



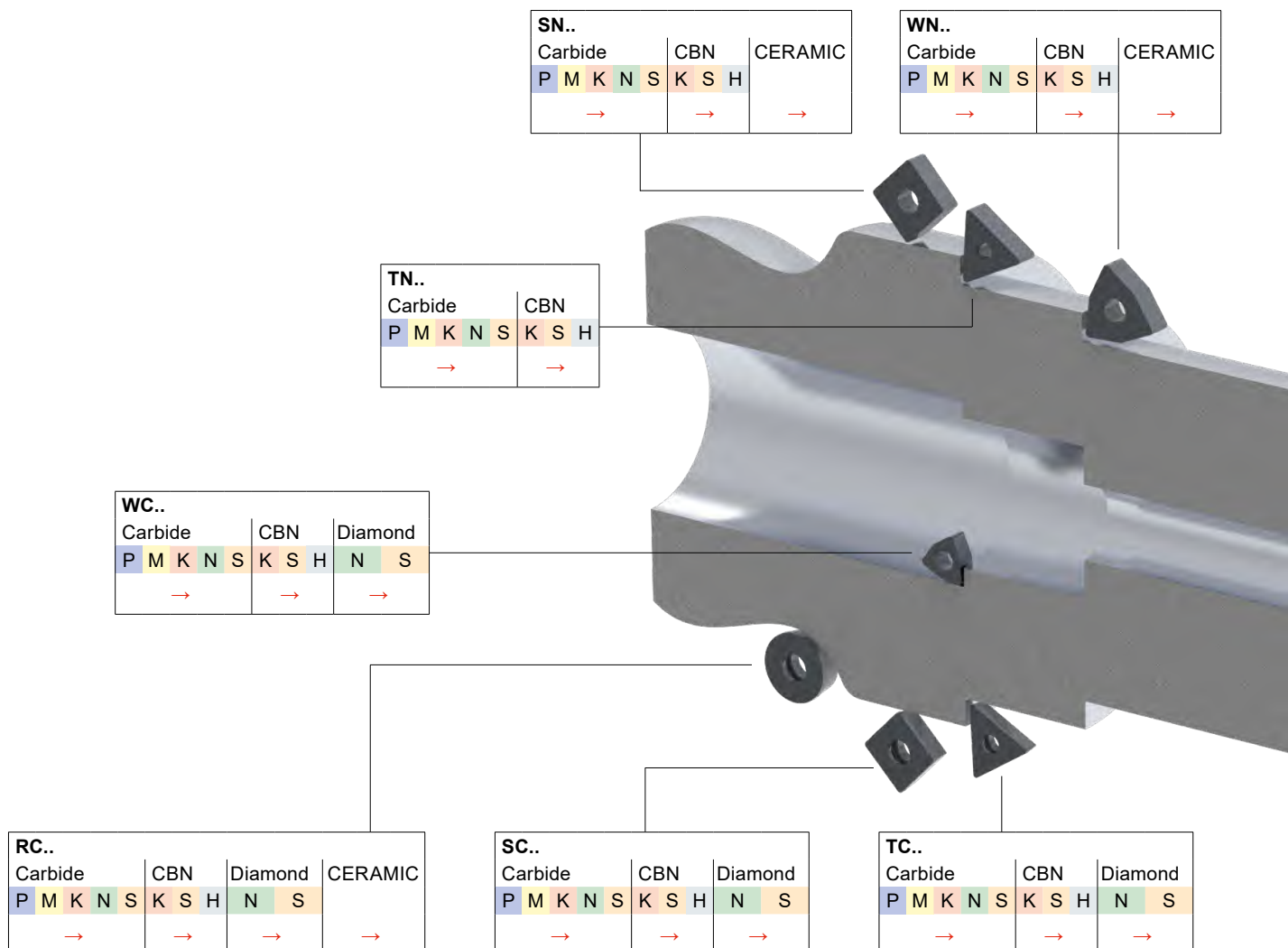
Indexable Turning



Contents

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 - Chip breakers overview / grade description
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 - Toolfinder – Holders
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- **Wheel set machining**
- **Bar peeling**
- **Heavy duty machining**
- **Technical information**

Toolfinder – Application



Explanation of symbols

CTCP125-P	Carbide grade					Smooth cut		Internal coolant supply
F	Fine machining					Irregular cut		DirectCooling
M	Medium machining					Interrupted cut		
R	Rough machining							



→ A detailed overview of grades can be found in the technical appendix.



Hard turning with PCBN indexable inserts



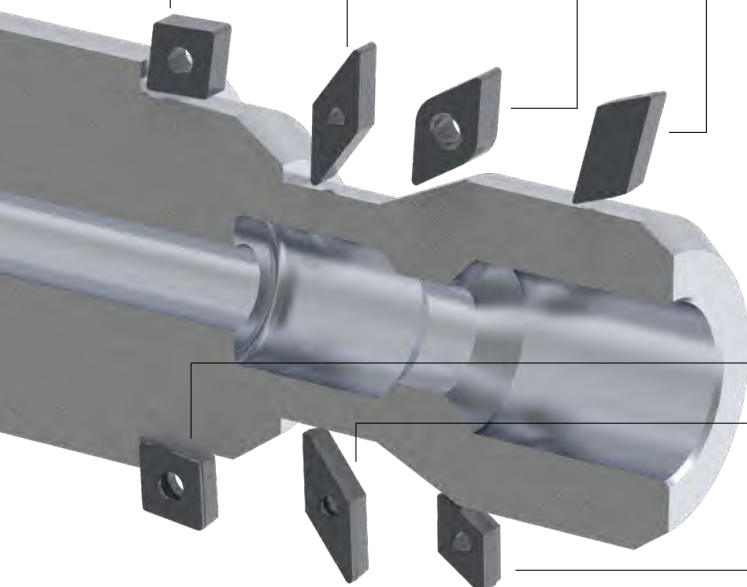
cts.ceratizit.com/en/us/pcbn-indexable-inserts

CN..											
Carbide						CBN			Diamond		
P	M	K	N	S		K	S	H	N	S	
→						→			→		

DN..											
Carbide						CBN			Diamond		
P	M	K	N	S		K	S	H	N	S	
→						→			→		

VN..											
Carbide						CBN			CERAMIC		
P	M	K	N	S		K	S	H			
→						→			→		

KN..					
Carbide					
P	M	K	N	S	
→					

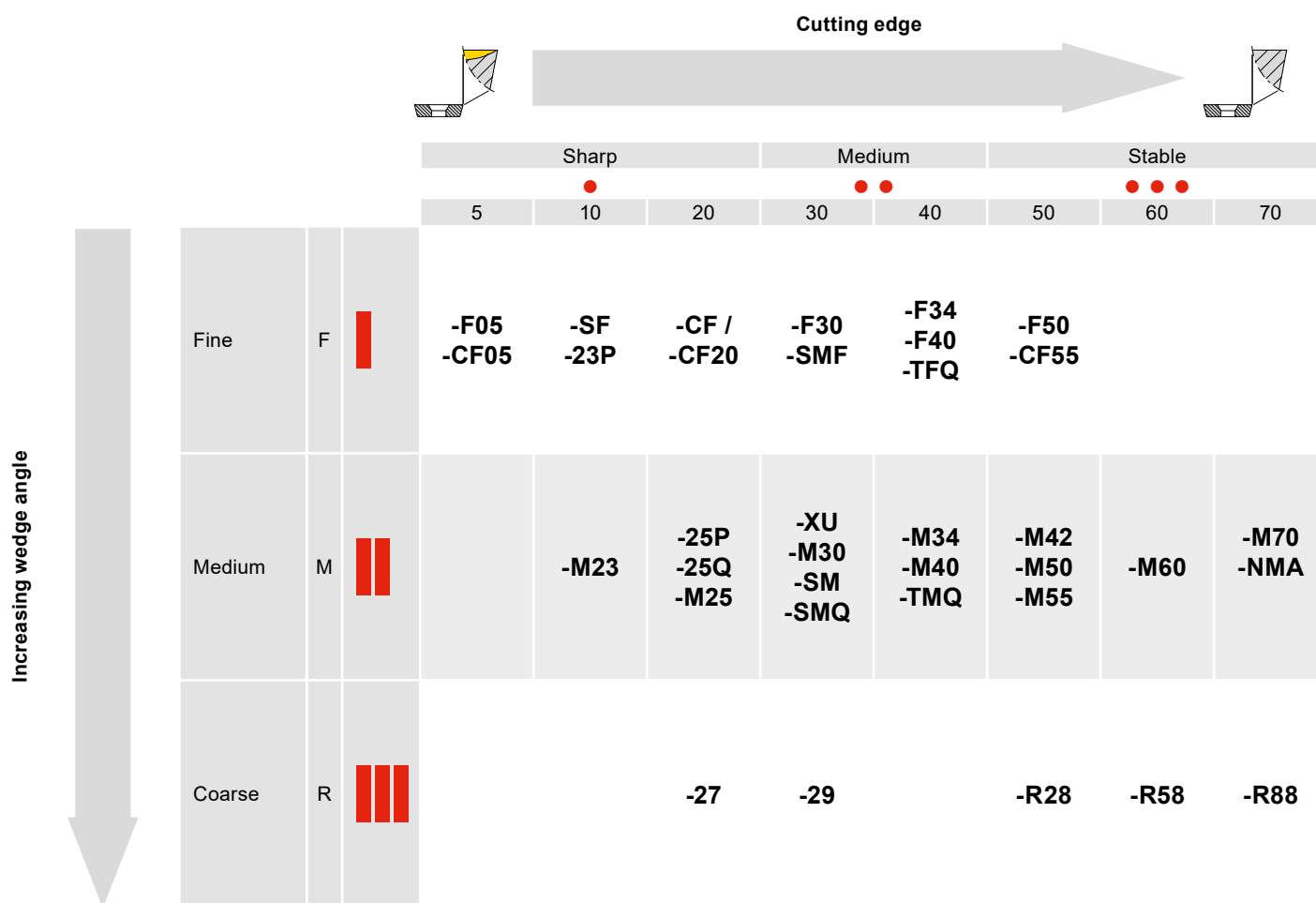


CC..											
Carbide						CBN			Diamond		
P	M	K	N	S		K	S	H	N	S	
→						→			→		

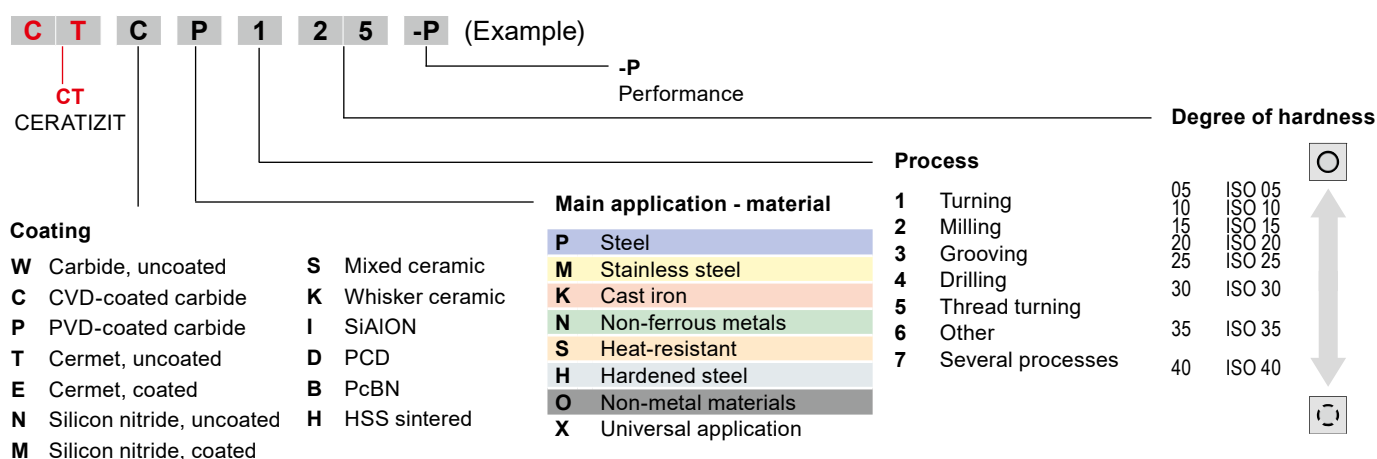
VC..											
Carbide						CBN			Diamond		
P	M	K	N	S		K	S	H	N	S	
→						→			→		

DC..											
Carbide						CBN			Diamond		
P	M	K	N	S		K	S	H	N	S	
→						→			→		

Chip breakers overview



Grade description



Toolfinder – Negative inserts



		Material							Geometry						
		Steel	Stainless steel	Cast iron	Non-ferrous metals	Heat-resistant	Hardened steel	Non-metal materials							
		P	M	K	N	S	H	O	CN..	DN..	KN..	SN..	TN..	VN..	WN..
Main application: Steel and cast iron	Fine	-CF / -CF20	●	○	○				→	→			→		→
		-F40	●		○										
		-F50	●		○				→	→		→	→	→	→
		-TFQ	●	○	○				→	→					→
	Medium	-XU	●		○				→	→				→	→
		-M40	●		○										
		-M50	●	○	○				→	→		→	→	→	→
		-TMQ	●		○				→	→					→
		-M70 -11, -12	●	○	○				→	→	→	→	→		→
	Rough	.NMA	●	○					→	→		→	→		→
		-R28	●	○	○				→	→		→	→		
		-R58	●	○	○				→	→		→	→		
		-R88	●	○	○				→			→			
Main application: Stainless	Fine	-F30	○	●		○			→	→		→	→	→	→
		-M30	○	●		○			→	→		→	→	→	→
	Medium	-42	○	●		○			→						
		-M42	○	●		●			→	→		→	→		→
		-M60	○	●		○			→	→		→	→		→
		-M70	○	●		○			→	→		→	→		→
Main application: Heat-resistant	Fine	-F32	●		○	●									
		-F34	○	●		○	●		→						→
	Medium	-M34	●	●		○	●		→	→		→	→	→	→
		-M42	●	●		○	●		→	→					
		-M52	●			○	●								
Main application: Non-ferrous metals	Diamond	FN , FL, FR			●		●		→	→					

[illegible]

Toolfinder – Holders

Tool holders and boring bars for negative inserts



Geometry	Tool holders	Boring bars	HSK-T	PSC
 CN..	→	→	→	→
 DN..	→	→	→	→
 SN..	→	→	→	
 TN..	→	→		
 VN..	→		→	→
 WN..	→	→	→	→

Tool holders and boring bars for positive inserts



Geometry	Tool holders	Boring bars	HSK-T	PSC
 CC..	→	→	→	→
 DC..	→	→	→	→
 RC..	→		→	
 SC..	→	→		
 TC..	→	→		
 VC..	→	→	→	→
 WC..		→		



→ Find the right coolant accessories here.

MaxiChange – Program overview

As the MaxiChange exchangeable head system is modular, it is extremely flexible and can be used for a variety of applications thanks to the wide selection of exchangeable heads. On top of these advantages, the MaxiChange GX also includes a grooving function for internal and external machining as well as axial and radial machining.

Exchangeable heads

For negative inserts

PCLN 95°



PDUN 93°



PDQN 107,5°



PWLN 95°



For positive inserts

SCLC 95°



SDUC 93°



SDQC 107,5°



SVPC 117,5°



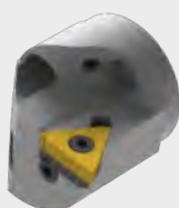
SVUC 93°



SVQC 107,5°



For internal threads



→ Grooving tools

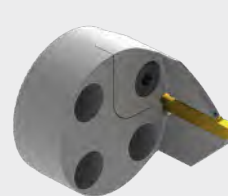
For radial grooving

GX 16



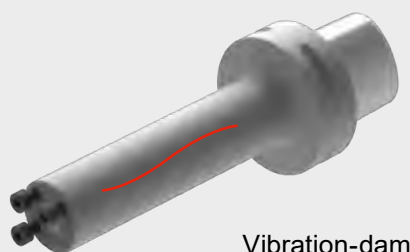
For axial grooving

GX 24

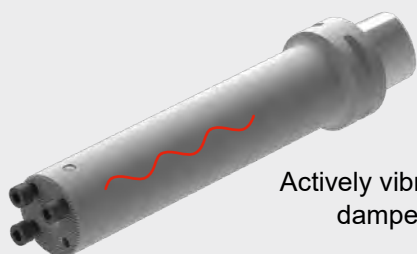


Holders

PSC

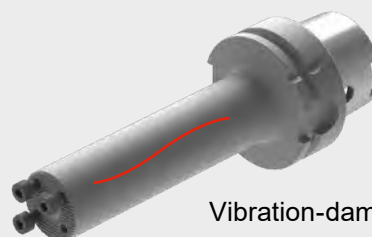


Vibration-damped

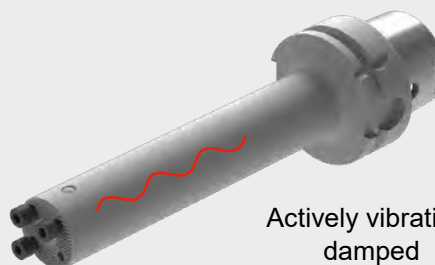


Actively vibration-damped

HSK-T

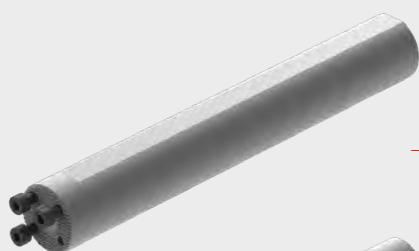
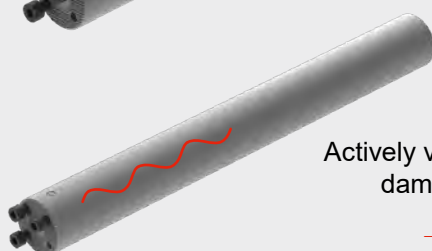


Vibration-damped

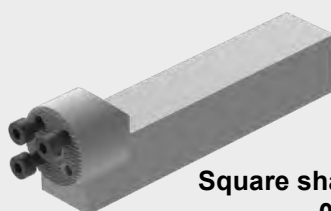
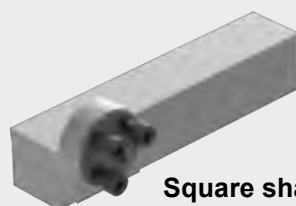


Actively vibration-damped

Cylindrical shank



Actively vibration-damped

Square shank holder
0°Square shank holder
90°

Toolfinder – Holders

Tool holders and boring bars for negative inserts

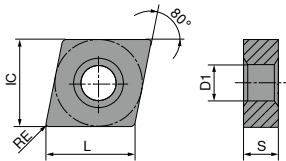
				
Geometry	Tool holders	Boring bars	HSK-T	PSC
 CN..	→	→	→	→
 DN..	→	→	→	→
 SN..	→	→	→	
 TN..	→	→		
 VN..	→		→	→
 WN..	→	→	→	→

Tool holders and boring bars for positive inserts

				
Geometry	Tool holders	Boring bars	HSK-T	PSC
 CC..	→	→	→	→
 DC..	→	→	→	→
 RC..	→		→	
 SC..	→	→		
 TC..	→	→		
 VC..	→	→	→	→
 WC..		→		

CNMG / CNMA / CNMM

Designation	L	S	D1	IC
	mm	mm	mm	mm
CNMG 0903..	9.7	3.18	3.81	9.52
CNM. 1204..	12.9	4.76	5.16	12.70
CNM. 1606..	16.1	6.35	6.35	15.87
CNM. 1906..	19.3	6.35	7.94	19.05
CNMM 2509..	25.8	9.52	9.12	25.40



CoreLine – Carbide turning indexable insert

CNMG

		-CF TCM10	-CF20 CTEP110-P	-TFQ CTEP110-P	-F50 CTCK110-P	-F50 CTCP115-P	-F50 CTCP125-P	-F50 CTCP135-P
		DRAGONSKIN						
		F CERMET CNMG	F CERMET CNMG	F CERMET CNMG	F CNMG	F CNMG	F CNMG	F CNMG
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	70 101 ...	76 101 ...	76 110 ...	70 307 ...	76 132 ...	76 132 ...	76 132 ...
090304EN	0.4					31601	51601	71601
090308EN	0.8					31801	51801	71801
120404EN	0.4	904	02801	02801	12801	32801	52801	72801
120408EN	0.8	908	03001	03001	13001	33001	53001	73001
120412EN	1.2			03201	13201	33201	53201	73201
P		●	●	●	○	●	●	●
M		○	○	○				○
K		○	○	○	●	○	○	
N								
S								
H								
O								

CoreLine – Carbide turning indexable insert

CNMG

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ISO	RE mm						
120404EN	0.4						
120408EN	0.8						
120412EN	1.2						
120416EN	1.6						
160608EN	0.8						
160612EN	1.2						
160616EN	1.6						
P		○	●	●	●	●	○
M						○	
K		●	○	○	○	○	●
N							
S							
H							
O							

CoreLine – Carbide turning indexable insert

CNMG

		<div><div><div><div><div>-M50</div><div>CTCK120-P</div></div><div>DRAGONSKIN</div><div></div><div><div>M</div><div>CNMG</div></div></div><div><div>-M50</div><div>CTCP115-P</div></div><div>DRAGONSKIN</div><div></div><div><div>M</div><div>CNMG</div></div></div><div><div>-M50</div><div>CTCP125-P</div></div><div>DRAGONSKIN</div><div></div><div><div>M</div><div>CNMG</div></div></div> <div><div>-M50</div><div>CTCP135-P</div></div> <div>DRAGONSKIN</div> <div></div> <div><div>M</div><div>CNMG</div></div>
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-TMQ

CTCK110-P

DRAGONSKIN



M

CNMG

-TMQ

CTCP115-P

DRAGONSKIN



M

CNMG

-TMQ

CTCP125-P

DRAGONSKIN

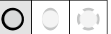
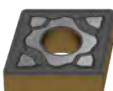


M

CNMG

CoreLine – Carbide turning indexable insert

CNMG / CNMA

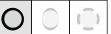
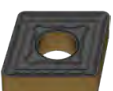
		-M70 CTCK110-P		-M70 CTCK120-P		-M70 CTCP115-P		-M70 CTCP125-P		-M70 CTCP135-P		CTCK110-P		CTCK120-P	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
															
		M CNMG		M CNMG		M CNMG		M CNMG		M CNMG		R CNMA		R CNMA	
		TR		TR		TR		TR		TR		TR		TR	
ISO	RE mm	70 119 ...		70 119 ...		76 119 ...		76 119 ...		76 119 ...		70 100 ...		70 100 ...	
120404EN	0.4											12801		52801	
120408EN	0.8	13001		53001		33001		53001		73001		13001		53001	
120412EN	1.2	13201		53201		32001		53201		73201		13201		53201	
120416EN	1.6	13401		53401		33401		53401		73401		13401		53401	
160608EN	0.8	14201		54201		34201		54201		74201		14201		54201	
160612EN	1.2	14401		54401		34401		54401		74401		14401		54401	
160616EN	1.6	14601		54601		34601		54601		74601		14601		54601	
160624EN	2.4	14801		54801		34801		54801		74801				54801	
190608EN	0.8	15401		55401		35401		55401		75401					
190612EN	1.2	15601		55601		35601		55601		75601		15601		55601	
190616EN	1.6	15801		55801		35801		55801		75801		15801		55801	
190624EN	2.4	16001		56001		36001		56001		76001					
P		○		○		●		●		●		○		○	
M										○					
K		●		●		○		○				●		●	
N															
S															
H															
O															

CNMM

		-R28 CTCP115-P	-R28 CTCP125-P	-R28 CTCP135-P	-R58 CTCP115-P	-R58 CTCP125-P	-R58 CTCP135-P	-R88 CTCP115-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		R CNMM	R CNMM	R CNMM	R CNMM	R CNMM	R CNMM	R CNMM
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	76 114 ...	76 114 ...	76 114 ...	76 115 ...	76 115 ...	76 115 ...	76 133 ...
120408EN	0.8	33001	53001		33001	53001	73001	
120412EN	1.2	33201	53201	73201	33201	53201	73201	
120416EN	1.6	33401	53401	73401	33401	53401	73401	
160612EN	1.2	34401	54401	74401	34401	54401	74401	
160616EN	1.6	34601	54601	74601	34601	54601	74601	
160624EN	2.4				34801	54801	74801	
160624SN	2.4							34801
190612EN	1.2	35601	55601	75601	35601	55601	75601	
190616EN	1.6	35801	55801	75801	35801	55801	75801	
190616SN	1.6							35801
190624EN	2.4	36001	56001	76001	36001	52401	76001	
190624SN	2.4							36001
250924EN	2.4	38401	58401	78401	38401	58401	78401	
250924SN	2.4							38401
P		●	●	●	●	●	●	●
M				○			○	
K		○	○		○	○		○
N								
S								
H								
O								

CoreLine – Carbide turning indexable insert

CNMM / CNMG

		-R88		-R88		-F30		-F30		-F30		-M30		-M30	
		CTCP125-P		CTCP135-P		CTCM120		CTPM125		CTCM130		CTCM120		CTPM125	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
															
		R		R		F		F		F		M		M	
		CNMM		CNMM		CNMG		CNMG		CNMG		CNMG		CNMG	
		TR		TR		TR		TR		TR		TR		TR	
ISO	RE mm	76 133 ...		76 133 ...		75 010 ...		75 010 ...		75 010 ...		75 011 ...		75 011 ...	
120404EN	0.4					12800		280		32800					
120408EN	0.8					13000		230		33000		13000		230	
120412EN	1.2											13200		232	
120416EN	1.6											13400		234	
160624SN	2.4	54801		74801											
190616SN	1.6	55801		75801											
190624SN	2.4	56001		76001											
250924SN	2.4	58401		78401											
P		●		●		○		○		○		○		○	
M				○		●		●		●		●		●	
K		○													
N															
S										○					
H															
O															

CoreLine – Carbide turning indexable insert

CNMG

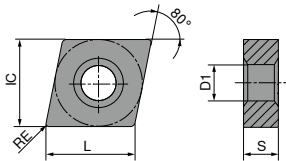
		-M30 CTCM130	-42 CTCM130	-M42 CTCM130	-M60 CTCM120	-M60 CTPM125	-M60 CTCM130	-M70 CTCM130
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		M CNMG	M CNMG	M CNMG	M CNMG	M CNMG	M CNMG	M CNMG
		TR 75 011 ...	TR 75 030 ...	TR 75 029 ...	TR 75 012 ...	TR 75 012 ...	TR 75 012 ...	TR 75 037 ...
ISO	RE mm							
120404EN	0.4			32800				
120408EN	0.8	33000	33000	33000	13000	230	33000	33000
120412EN	1.2	33200		33200	13200	232	33200	33200
120416EN	1.6	33400			13400	234	33400	
160612EN	1.2				14400	24400	34400	34400
190612EN	1.2							35600
190616EN	1.6							35800
P		○	○	○	○	○	○	○
M		●	●	●	●	●	●	●
K								
N								
S		○	○	○			○	○
H								
O								

CNMG

ISO	RE mm			
120404EN	0.4			
120408EN	0.8			
120412EN	1.2			
120416EN	1.6			
P				
M				
K				
N				
S				
H				
O				

CNGP / CNMG / CNMM

Designation	L	S	D1	IC
	mm	mm	mm	mm
CN.. 1204..	12.9	4.76	5.16	12.70
CNMM 1906..	19.3	6.35	7.94	19.05
CNMG 2509..	25.4	9.52	9.12	25.40



CoreLine – Carbide turning indexable insert

CNGP / CNMG

ISO	RE mm
120402FN	0.2
120404EN	0.4
120404FN	0.4
120408EN	0.8
120408FN	0.8

-F32 CTP2120	-M42 CTP2120	-M52 CTP2120	-42 TSM20
F CNGP	M CNMG	M CNMG	F CNMG
TR	TR	TR	TR
70 102 ...	70 130 ...	70 117 ...	70 103 ...
602			
604	604	604	
608	608	608	66000

P	
M	
K	●
N	●
S	●
H	
O	

CoreLine – Carbide turning indexable insert

CNMG / CNMM

ISO	RE mm			
120408EN	0.8			
190616SN	1.6			
250924EN	2.4			
P			●	●
M			○	
K				○
N				
S				
H				
O				

-42

CTCP135-P

DRAGONSKIN





M

CNMG

TR

76 103 ...

73001

-M70

CTCP125-P

DRAGONSKIN





M

CNMG

TR

76 167 ...

58401

-R80

CTCP125-P

DRAGONSKIN





R

CNMM

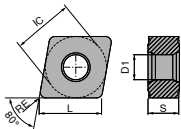
TR

76 178 ...

55801

CNMU

Designation	L	S	D1	IC
	mm	mm	mm	mm
CNMU 1206..	12.9	6.35	5.16	12.7



CoreLine – Carbide turning indexable insert

CNMU

-XU

CTCK110-P

DRAGONSKIN

M

CNMU

-M50

CTCK110-P

DRAGONSKIN

M

CNMU

-M50

CTCK120-P

DRAGONSKIN

M

CNMU

-M70

CTCK120-P

DRAGONSKIN

M

CNMU

ISO	RE mm
120608EN	0.8
120612EN	1.2
120616EN	1.6

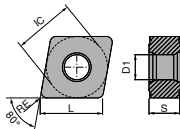
TR	TR	TR	TR
70 433 ...	70 411 ...	70 411 ...	70 422 ...
13001 ¹⁾	13001 ¹⁾		
13201 ¹⁾	13201 ¹⁾	53201 ¹⁾	53201 ¹⁾
	13401 ¹⁾		53401 ¹⁾

P				
M				
K				
N				
S				
H				
O				

1) Not in stock

CNMU

Designation	L	S	D1	IC
	mm	mm	mm	mm
CNMU 1204..	12.9	4.76	5.16	12.7
CNMU 1204..	12.9	6.35	5.16	12.7
CNMU 1206..	12.9	6.35	5.16	12.7



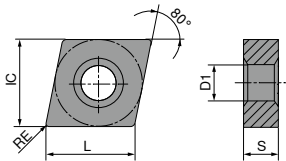
CoreLine – Carbide turning indexable insert

CNMU

		-XU CTCP115-P	-XU CTCP125-P	-M50 CTCP115-P	-M50 CTCP125-P	-M70 CTCP115-P	-M70 CTCP125-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M CNMU	M CNMU	M CNMU	M CNMU	M CNMU	M CNMU
		TR	TR	TR	TR	TR	TR
ISO	RE mm	76 429 ...	76 429 ...	76 410 ...	76 410 ...	76 417 ...	76 417 ...
120412EN	1.2					33201	
120608EN	0.8	33001	53001	33001	53001		
120612EN	1.2	33201	53201	33201	53201		53201
120616EN	1.6			33401	53401		53401
P		●	●	●	●	●	●
M							
K		○	○	○	○	○	○
N							
S							
H							
O							

CNMG

Designation	L	S	D1	IC
	mm	mm	mm	mm
CNMG 1204..	12.9	4.76	5.16	12.70
CNMG 1606..	16.1	6.35	6.35	15.87
CNMG 1906..	19.3	6.35	7.94	19.05



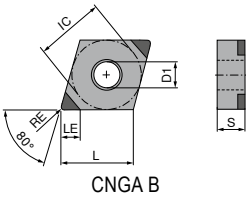
CoreLine – Carbide turning indexable insert

CNMG

		-FMS CT-P15	-FMS CT-P25	-MRS CT-P15	-MRS CT-P25	-MRS CT-P35
		F CNMG	F CNMG	M CNMG	M CNMG	M CNMG
		CX	CX	CX	CX	CX
ISO	RE mm	75 302 ...	75 302 ...	75 303 ...	75 303 ...	75 303 ...
120404EN	0.4	02809	12809			
120408EN	0.8	03009	13009	03009	13009	23009
120412EN	1.2	03209	13209	03209	13209	23209
120416EN	1.6			03409	13409	23409
160612EN	1.2			04409	14409	24409
160616EN	1.6			04609	14609	24609
190612EN	1.2			05609	15609	25609
190616EN	1.6			05809	15809	25809
P		●	●	●	●	●
M		○	○	○	○	○
K						
N						
S						
H						
O						

CNGA

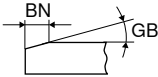
Designation	L	S	D1	IC
	mm	mm	mm	mm
CNGA 1204..	12.9	4.76	5.13	12.7



CoreLine – PcBN turning indexable insert

CNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners



CTBH1000C

F

PCBN

CNGA

CTBH2000C

F

PCBN

CNGA

CTBH3000C

F

PCBN

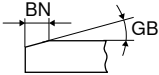
CNGA

ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	PC	71 003 ...
120404EN	0.4			B (2)	3.3		70002
120404SN	0.4	0.14	20°	B (2)	3.3		
120408EN	0.8			B (2)	3.3		70302
120408SN	0.8	0.14	20°	B (2)	3.3		
120412EN	1.2			B (2)	3.1		70602
120412SN	1.2	0.14	20°	B (2)	3.1		
P							
M							
K							
N							
S							
H							
O							

CoreLine – PcBN turning indexable insert

CNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners



CTBH1000C	CTBH2000C	CTBH3000C
M	M	M
PCBN	PCBN	PCBN
CNGA	CNGA	CNGA
PC	PC	PC
71 003 ...	71 003 ...	71 003 ...
70102	80102	90102
70402	80402	90402
70702	80702	90702

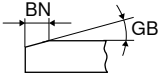
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
120404SN	0.4	0.09	15°	B (2)	3.3
120404SN	0.4	0.18	25°	B (2)	3.3
120408SN	0.8	0.09	15°	B (2)	3.3
120408SN	0.8	0.18	25°	B (2)	3.3
120412SN	1.2	0.09	15°	B (2)	3.1
120412SN	1.2	0.18	25°	B (2)	3.1

P			
M			
K			
N			
S			
H			
O			

CoreLine – PcBN turning indexable insert

CNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners



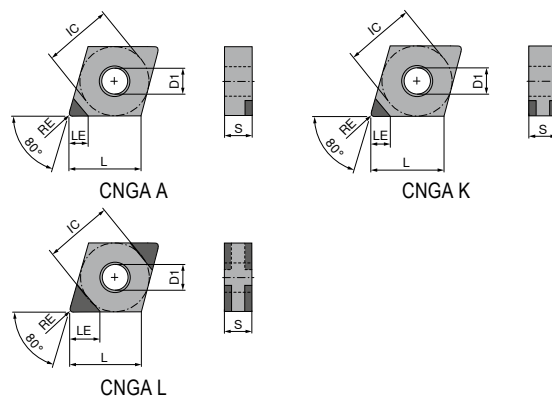
CTBH1000C	CTBH2000C	CTBH3000C
R	R	R
PCBN	PCBN	PCBN
CNGA	CNGA	CNGA
PC	PC	PC
71 003 ...	71 003 ...	71 003 ...
70202	80202	90202
70502	80502	90502
70802	80802	90802

ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
120404SN	0.4	0.14	20°	B (2)	3.3
120404SN	0.4	0.20	35°	B (2)	3.3
120408SN	0.8	0.14	20°	B (2)	3.3
120408SN	0.8	0.20	35°	B (2)	3.3
120412SN	1.2	0.14	20°	B (2)	3.1
120412SN	1.2	0.20	35°	B (2)	3.1

P			
M			
K			
N			
S			
H			
O			

CNGA

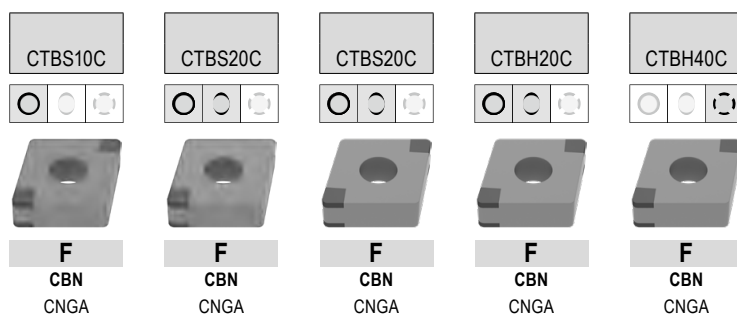
Designation	L mm	S mm	D1 mm	IC mm
CNGA 1204..	12.9	4.76	5.13	12.7



CoreLine – PcBN turning indexable insert

CNGA

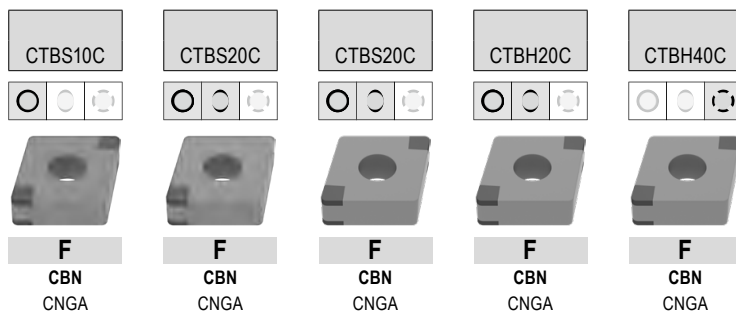
▲ TCE(NOI) = Design and number of equipped cutting edge corners



ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	PC	PC	PC	PC	PC
120404SN	0.4	0.09	10°	L (4)	2.8	71 408 ...	71 400 ...	71 401 ...	71 401 ...	71 401 ...
120404TN	0.4	0.09	15°	L (4)	2.8	80000		122		
120404SN	0.4	0.09	15°	L (4)	2.8			132		
120404SN	0.4	0.11	15°	L (4)	2.8			16200		
120404SN	0.4	0.11	15°	K (2)	2.8		142	152		332
120404SN	0.4	0.09	20°	L (4)	2.8				242	
120404SN	0.4	0.11	20°	L (4)	2.8		162		25200	
120404SN	0.4	0.14	20°	K (2)	2.8				262	352
120404TN	0.4	0.11	25°	L (4)	2.8					372
120404SN	0.4	0.11	25°	L (4)	2.8					
120404SN	0.4	0.13	25°	L (4)	2.8					
120404SN	0.4	0.14	30°	L (4)	2.8					
120404SN	0.4	0.18	30°	L (4)	2.8			182		
120408TN	0.8	0.09	10°	L (4)	2.5	80200				
120408SN	0.8	0.09	10°	L (4)	2.5			124		
120408TN	0.8	0.09	15°	L (4)	2.5	80300				
120408SN	0.8	0.09	15°	L (4)	2.5			134		31200
120408SN	0.8	0.11	15°	L (4)	2.5			16300		
120408SN	0.8	0.11	15°	K (2)	2.5		144			
120408SN	0.8	0.09	20°	L (4)	2.5			154		334
120408SN	0.8	0.11	20°	L (4)	2.5				244	
120408TN	0.8	0.11	20°	L (4)	2.5	80400				
120408SN	0.8	0.14	20°	L (4)	2.5			17200		

P					
M					
K		•	•	•	
N					
S		•	•	•	
H					•
O					•

CNGA

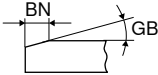
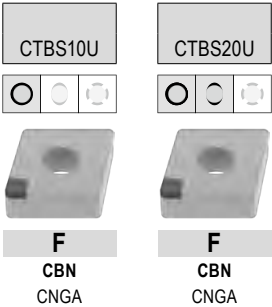


ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	PC 71 408 ...	PC 71 400 ...	PC 71 401 ...	PC 71 401 ...	PC 71 401 ...		
120408SN	0.8	0.14	20°	K (2)	2.5	80500	164					
120408TN	0.8	0.11	25°	L (4)	2.5			25300				
120408SN	0.8	0.11	25°	L (4)	2.5					354		
120408SN	0.8	0.13	25°	L (4)	2.5				264	364		
120408TN	0.8	0.15	25°	L (4)	2.5							
120408SN	0.8	0.16	25°	L (4)	2.5			18000				
120408SN	0.8	0.14	30°	L (4)	2.5				274	374		
120408SN	0.8	0.18	30°	L (4)	2.5			184				
120408SN	0.8	0.18	30°	K (2)	2.5							
120408SN	0.8	0.14	35°	L (4)	2.5					38100		
120412SN	1.2	0.11	15°	L (4)	2.2	80700		16400				
120412SN	1.2	0.11	15°	K (2)	2.2		146					
120412SN	1.2	0.09	20°	L (4)	2.2			156		336		
120412SN	1.2	0.14	20°	L (4)	2.2			17300				
120412SN	1.2	0.14	20°	K (2)	2.2		166					
120412SN	1.2	0.11	25°	L (4)	2.2					356		
120412SN	1.2	0.13	25°	L (4)	2.2				266	366		
120412TN	1.2	0.15	25°	L (4)	2.2							
120412SN	1.2	0.14	30°	L (4)	2.2					376		
120412SN	1.2	0.18	30°	L (4)	2.2				186			
P												
M												
K							●	●	●			
N												
S							●	●	●			
H											●	●
O												

CoreLine – PcBN turning indexable insert

CNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners



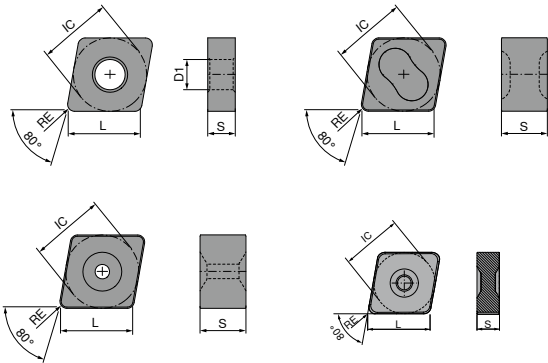
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
120402FN	0.2			A (1)	3.4
120404FN	0.4			A (1)	3.1
120404TN	0.4	0.09	15°	A (1)	3.1
120408FN	0.8			A (1)	2.8
120408TN	0.8	0.12	20°	A (1)	2.8
120412FN	1.2			A (1)	2.5

PC	PC
71 406 ...	71 406 ...
10000	
10200	
	20000
10400	
10500	
10600	

P		
M		
K	●	●
N		
S	●	●
H		
O		

CNGX-C / CNGX / CNGA / CNNX

Designation	L	S	D1	IC
	mm	mm	mm	mm
CN.X 1207..	12.9	7.94	-	12.7
CNGX 1204..	12.9	4.76	-	12.9
CNGX 1204..	12.9	4.76	-	12.7
CNGX 1207..	12.9	4.76	-	12.7
CNGA 1204..	12.9	4.76	5.13	12.7



CoreLine – PcBN turning indexable insert

CNGX-C

CTBK102

F

CBN

CNGX-C

CTBK103

F

CBN

CNGX-C

PC

71 466 ...

30002

PC

71 470 ...

40002

ISO	RE
	mm
120412TN	1.2
120416TN	1.6

P	
M	
K	● ●
N	
S	○ ○
H	○ ○
O	

CoreLine – CERAMIC turning indexable insert

CNGX-C

ISO

RE
mm

120712TN

1.2

120716TN

1.6

CTM3105





F

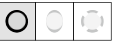
CERAMIC
CNGX-C

IC

71 460 ...

20002
20102

CTN3105





F

CERAMIC
CNGX-C

IC

71 442 ...

90001

P

M

K

N

S

H

O

CoreLine – CERAMIC turning indexable insert

CNGX

ISO

RE
mm

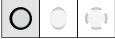
120712TN

1.2

120716TN

1.6

CTI3105





F

CERAMIC
CNGX

IC

71 446 ...

80001

CTM3105





F

CERAMIC
CNGX

IC

71 464 ...

20102

CTN3105





F

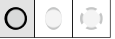
CERAMIC
CNGX

IC

71 451 ...

90101

CTN3110





F

CERAMIC
CNGX

IC

71 459 ...

10102

P

M

K

N

S

H

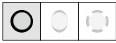
O

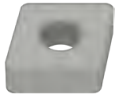
CoreLine – CERAMIC turning indexable insert

CNGA / CNNX

ISO	RE mm
120412SN	1.2
120716TN	1.6

CTN3110





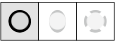
F

CERAMIC
CNGA

IC

71 458 ...
00002

CTN3105





F

CERAMIC
CNNX

IC

71 452 ...
90001

P

M

K

N

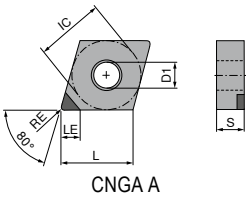
S

H

O

CNGA

Designation	L	S	D1	IC
	mm	mm	mm	mm
CNGA 1204..	12.9	4.76	5.13	12.7



CoreLine – PCD turning indexable insert

CNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners

CTDPD20

F

DIAMOND

CNGA

CTDPS30

F

DIAMOND

CNGA

ISO	RE mm	TCE (NOI)	LE mm
120404FN	0.4	A (1)	6.3
120408FN	0.8	A (1)	6.0
120412FN	1.2	A (1)	5.7

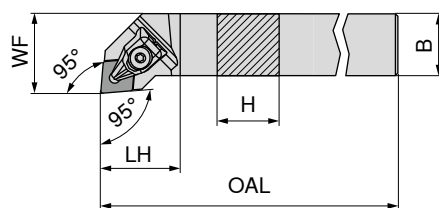
PC	PC
71 127 ...	71 127 ...
10001	20001
10101	20101
10201	20201

P		
M		
K		
N	•	•
S		
H		
O	•	•

CoreLine – DCLN 95° – Tool holder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Left

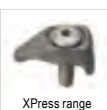
Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
DCLN R/L 1616 H09	16	16	100	23	20	2	CN.. 0903
DCLN R/L 2020 K09	20	20	125	24	25	2	CN.. 0903
DCLN R/L 2020 K12	20	20	125	32	25	4	CN.. 1204
DCLN R/L 2525 M12	25	25	150	32	32	4	CN.. 1204
DCLN R/L 3225 P12	32	25	170	32	32	4	CN.. 1204
DCLN R/L 2525 M16	25	25	150	38	32	6,5	CN.. 1606
DCLN R/L 3232 P16	32	32	170	36	40	6,5	CN.. 1606
DCLN R/L 3232 P19	32	32	170	42	40	6,5	CN.. 1906
DCLN R/L 4040 S19	40	40	250	42	50	6,5	CN.. 1906
DCLN R/L 4040 S25	40	40	250	60	50	6,5	CN.. 2509

TO	TO
70 509 ...	70 508 ...
516	516
520	520
620	620
625	625
632	632
725	725
732	732
832	832
940	940
440	440

Spare parts for article number

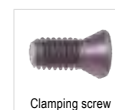
	AS 70 950 ...		AS 80 950 ...		AS 70 950 ...		AS 70 950 ...
70 508 516 / 70 509 516	823	T09 - IP	118	M3x7 - 09IP	819		848
70 508 520 / 70 509 520	823	T09 - IP	118	M3x7 - 09IP	819		848
70 508 620 / 70 509 620	824	T15 - IP	120	M4,5x12 - 15IP	820		810
70 508 625 / 70 509 625	824	T15 - IP	120	M4,5x12 - 15IP	820		810
70 508 632 / 70 509 632	824	T15 - IP	120	M4,5x12 - 15IP	820		810
70 508 725 / 70 509 725	825	T20 - IP	121	M5x14 - 20IP	821		814
70 508 732 / 70 509 732	825	T20 - IP	121	M5x14 - 20IP	821		814
70 508 832 / 70 509 832	826	T20 - IP	121	M5x14 - 20IP	821		816
70 508 940 / 70 509 940	826	T20 - IP	121	M5x14 - 20IP	821		816
70 508 440 / 70 509 440	827	T25 - IP	122	M6x16 - 25IP	822		625



XPress range



Screwdriver



Clamping screw

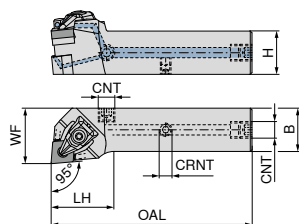


Carbide seat C

CoreLine – DCLN 95° DC – tool holder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Left

Right

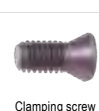
Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	Left TO 70 510 ...	Right TO 70 510 ...
DCLN R/L 2020 X09 DC	20	20	94	25	25	2	CN.. 0903	52000	52001
DCLN R/L 2020 X12 DC	20	20	101	32	25	4	CN.. 1204	62000	62001
DCLN R/L 2525 X12 DC	25	25	116	32	32	4	CN.. 1204	62500	62501
DCLN R/L 3225 X12 DC	32	25	132	32	32	4	CN.. 1204	63200	63201
DCLN R/L 2525 X16 DC	25	25	122	38	32	6,5	CN.. 1606	72500	72501
DCLN R/L 3232 X16 DC	32	32	142	42	40	6,5	CN.. 1606	73200	73201
DCLN R/L 3232 X19 DC	32	32	142	42	40	6,5	CN.. 1906	83200	83201
DCLN R/L 4040 X19 DC	40	40	167	42	50	6,5	CN.. 1906	94000	94001

Spare parts for article number

70 510 52001 / 70 510 52000	M3x7 - 09IP	819	848	M6x6	86700
70 510 62001 / 70 510 62000	M4,5x12 - 15IP	820	810	M6x6	86700
70 510 62501 / 70 510 62500	M4,5x12 - 15IP	820	810	M6x6	86700
70 510 63201 / 70 510 63200	M4,5x12 - 15IP	820	810	M6x6	86700
70 510 72501 / 70 510 72500	M5x14 - 20IP	821	814	M6x6	86700
70 510 73201 / 70 510 73200	M5x14 - 20IP	821	814	M6x6	86700
70 510 83201 / 70 510 83200	M5x14 - 20IP	821	816	M6x6	86700
70 510 94001 / 70 510 94000	M5x14 - 20IP	821	816	M6x6	86700

Spare parts for article number

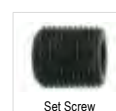
	AS 70 950 ...		AS 80 950 ...		AS 70 950 ...
70 510 52001 / 70 510 52000	823	T09 - IP	118	G 1/8"	294
70 510 62001 / 70 510 62000	824	T15 - IP	120	G 1/8"	294
70 510 62501 / 70 510 62500	824	T15 - IP	120	G 1/8"	294
70 510 63201 / 70 510 63200	824	T15 - IP	120	G 1/8"	294
70 510 72501 / 70 510 72500	825	T20 - IP	121	G 1/8"	294
70 510 73201 / 70 510 73200	825	T20 - IP	121	G 1/8"	294
70 510 83201 / 70 510 83200	826	T20 - IP	121	G 1/8"	294
70 510 94001 / 70 510 94000	826	T20 - IP	121	G 1/8"	294



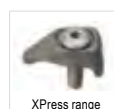
Clamping screw



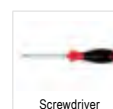
Carbide seat C



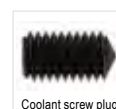
Set Screw



XPress range



Screwdriver

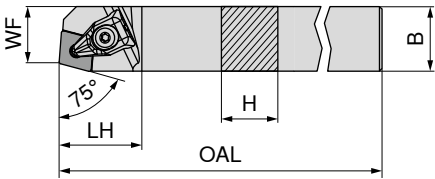


Coolant screw plug

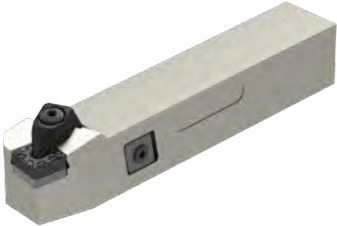
CoreLine – DCBN 75° – Tool holder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
DCBN R/L 2525 M12	25	25	150	32	22	4	CN.. 1204

Left	Right
TO	TO
70 501 ...	70 500 ...
825	825

Spare parts
for article number

70 500 825 / 70 501 825



XPress range

AS

70 950 ...

824



Screwdriver

AS

80 950 ...

120



Clamping screw

AS

70 950 ...

820



Carbide seat C

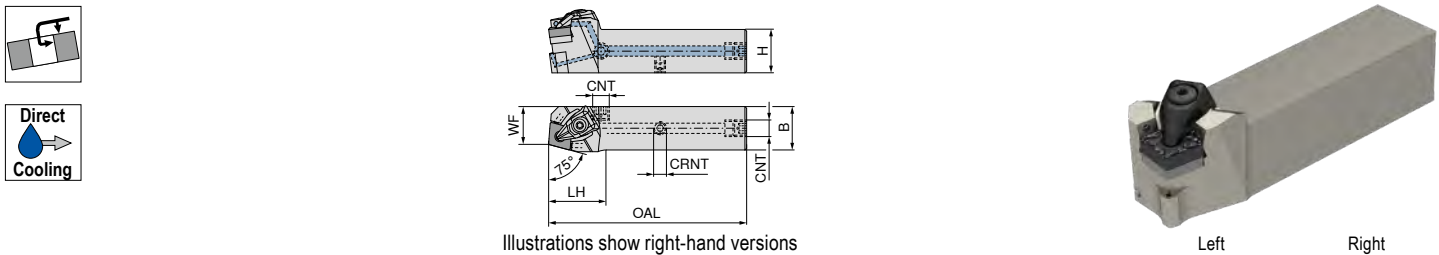
AS

70 950 ...

810

CoreLine – DCBN 75° DC – tool holder with top clamping

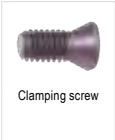
Scope of supply:
Tool holder with Torx key



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	Left TO 70 507 ... 82500 62500	Right TO 70 507 ... 82501 62501
DCBN R/L 2525 X12 DC	25	25	114	30	22	4	CN.. 1204		
DCBN R/L 2525 X16 DC	25	25	120	36	22	6,5	CN.. 1606		

Spare parts
for article number

70 507 82501 / 70 507 82500	M4,5x12 - 15IP	820	810	M6x6	86700
70 507 62501 / 70 507 62500	M5x14 - 20IP	821	814	M6x6	86700



Clamping screw

AS

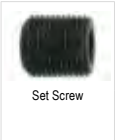
70 950 ...



Carbide seat C

AS

70 950 ...



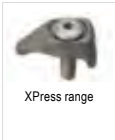
Set Screw

AS

70 950 ...

Spare parts
for article number

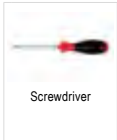
70 507 82501 / 70 507 82500	824	T15 - IP	120	G 1/8"	294
70 507 62501 / 70 507 62500	825	T20 - IP	121	G 1/8"	294



XPress range

AS

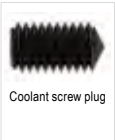
70 950 ...



Screwdriver

AS

80 950 ...



Coolant screw plug

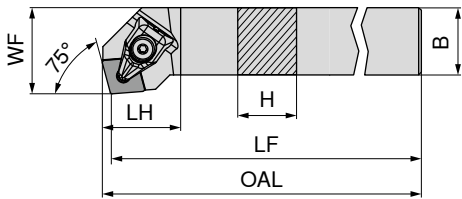
AS

70 950 ...

CoreLine – DCKN 75° – Tool holder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

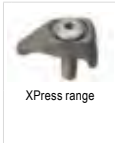
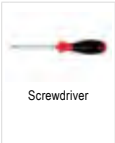
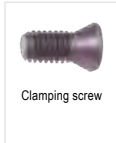


Designation	H mm	B mm	OAL mm	LF mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
DCKN R/L 2525 M12	25	25	152.9	150	28.9	32	4	CN.. 1204

Left	Right
TO	TO
70 505 ...	70 504 ...
825	825

Spare parts
for article number

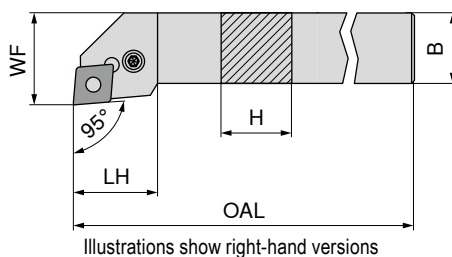
70 504 825 / 70 505 825

			
XPress range	Screwdriver	Clamping screw	Carbide seat C
AS	AS	AS	AS
70 950 ...	80 950 ...	70 950 ...	70 950 ...
824	120	820	810

CoreLine – PCLN 95° – Tool holder with lever clamping

Scope of supply:

Tool holder with Allen key



Left Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
PCLN R/L 1616 H12	16	16	100	26.2	20	4	CN.. 1204
PCLN R/L 2020 K12	20	20	125	27.5	25	4	CN.. 1204
PCLN R/L 2525 M12	25	25	150	28.1	32	4	CN.. 1204
PCLN R/L 3225 P12	32	25	170	28.1	32	4	CN.. 1204
PCLN R/L 2525 M16	25	25	150	32.7	32	4	CN.. 1606
PCLN R/L 3232 P16	32	32	170	32.6	40	4	CN.. 1606
PCLN R/L 3232 P19	32	32	170	38.0	40	8	CN.. 1906
PCLN R/L 4040 S19	40	40	250	38.0	50	8	CN.. 1906
PCLN R/L 4040 S25	40	40	250	50.0	50	8	CN.. 2509

TO	TO
70 509 ...	70 508 ...
016	016
020	020
025	025
032	032
125	125
132	132
232	232
54000	54000
340	340

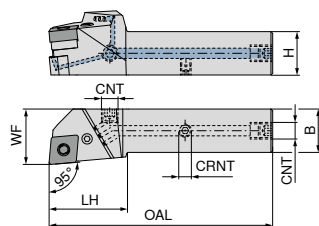
Spare parts for article number

70 508 016 / 70 509 016	SW3	176	198	192	187	209	233
70 508 020 / 70 509 020	SW3	176	198	192	187	209	233
70 508 025 / 70 509 025	SW3	176	198	192	187	209	233
70 508 032 / 70 509 032	SW3	176	198	192	187	209	233
70 508 125 / 70 509 125	SW3	176	391	394	385	388	380
70 508 132 / 70 509 132	SW3	176	391	394	385	388	380
70 508 232 / 70 509 232	SW4	396	392	395	386	389	381
70 508 54000 / 70 509 54000	SW4	396	392	395	386	389	381
70 508 340 / 70 509 340	SW5	265	621	623	620	622	624

CoreLine – PCLN 95° DC – Toolholder with lever clamping

Scope of supply:

Tool holder with Allen key



Illustrations show right-hand versions



Left

Right

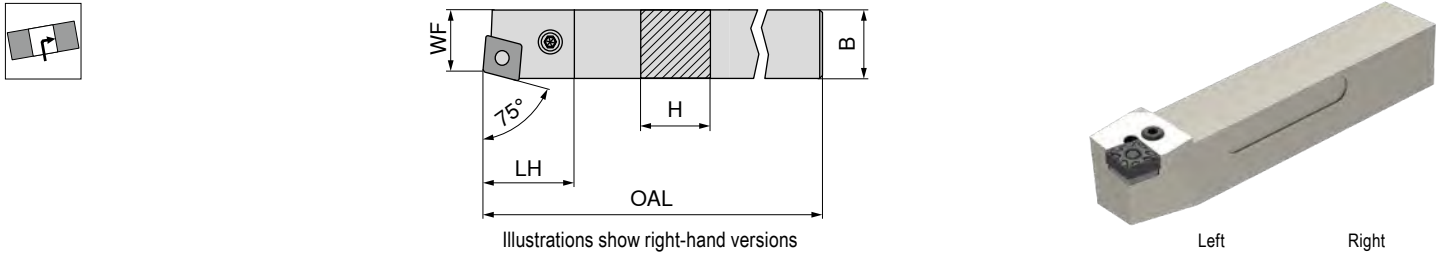
Designation	H mm	B mm	OAL mm	LH mm	WF mm	CNT	CRNT	Tightening torque Nm	Indexable insert	TO 70 592 ...	TO 70 592 ...
PCLN R/L 2020 X12-T DC	20	20	109	40	25	G1/8"	M6	4	CN.. 1204	02000	02001
PCLN R/L 2525 X12-T DC	25	25	124	40	32	G1/8"	M6	4	CN.. 1204	02500	02501
PCLN R/L 3225 X12-T DC	32	25	140	40	32	G1/8"	M6	4	CN.. 1204	03200	03201
PCLN R/L 2525 X16-T DC	25	25	129	45	32	G1/8"	M6	4	CN.. 1606	12500	12501
PCLN R/L 3232 X16-T DC	32	32	145	45	40	G1/8"	M6	4	CN.. 1606	13200	13201
PCLN R/L 3232 X19-T DC	32	32	150	50	40	G1/8"	M6	8	CN.. 1906	23200	23201
PCLN R/L 4040 X19-T DC	40	40	175	50	48	G1/8"	M6	8	CN.. 1906	04000	04001
PCLN R/L 4040 X25-T DC	40	40	185	60	48	G1/8"	M6	8	CN.. 2509	14000	14001

Spare parts for article number

	Key I	Shim	Assembly pin	Coolant screw plug	Toggle lever	Clamping screw	Carbide seat C	Set Screw
	AS	AS	AS	AS	AS	AS	AS	AS
70 592 02001 / 70 592 02000	176	198	192	294	187	209	233	86700
70 592 02501 / 70 592 02500	176	198	192	294	187	209	233	86700
70 592 03201 / 70 592 03200	176	198	192	294	187	209	233	86700
70 592 12501 / 70 592 12500	176	391	394	294	385	388	380	86700
70 592 13201 / 70 592 13200	176	391	394	294	385	388	380	86700
70 592 23201 / 70 592 23200	396	392	395	294	386	389	381	86700
70 592 04001 / 70 592 04000	396	392	395	294	386	389	381	86700
70 592 14001 / 70 592 14000	265	621	623	294	620	622	624	86700

CoreLine – PCBN 75° – Tool holder with lever clamping

Scope of supply:
Tool holder with Allen key



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
PCBN R/L 2525 M12	25	25	150	27.70	22	4	CN.. 1204
PCBN R/L 2525 M16	25	25	150	31.81	22	4	CN.. 1606
PCBN R/L 3232 P19	32	32	170	38.00	27	8	CN.. 1906

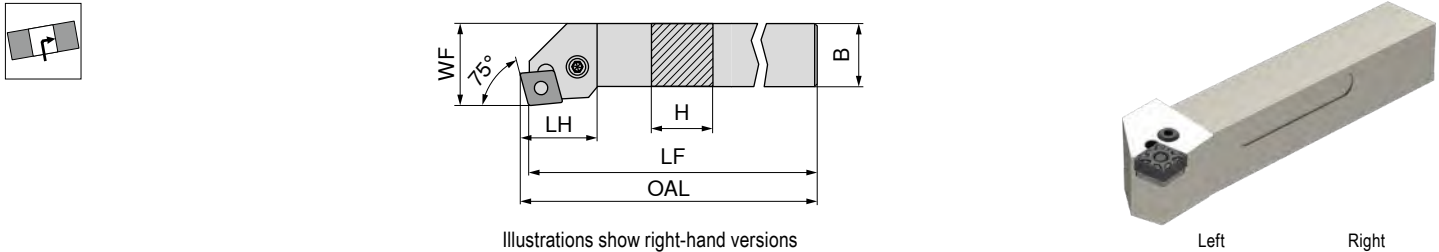
Left	Right
TO	TO
70 501 ...	70 500 ...
025	025
12500	125
032	032

Spare parts
for article number

70 500 025 / 70 501 025	SW3	176	198	192	187	209	233
70 500 125 / 70 501 12500	SW3	176	391	394	385	388	380
70 500 032 / 70 501 032	SW4	396	392	395	386	389	381

CoreLine – PCKN 75° – Tool holder with lever clamping

Scope of supply:
Tool holder with Allen key



Designation	H mm	B mm	OAL mm	LF mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
PCKN R/L 2525 M12	25	25	153.07	150	31.4	32	4	CN.. 1204

Left	Right
TO	TO
70 505 ...	70 504 ...
025	025

Spare parts
for article number

70 504 025 / 70 505 025	SW3	176	198	192	187	209	233
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Key I

AS

70 950 ...



Shim

AS

70 950 ...



Assembly pin

AS

70 950 ...



Toggle lever

AS

70 950 ...



Clamping screw

AS

70 950 ...



Carbide seat C

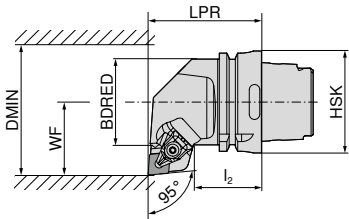
AS

70 950 ...

CoreLine – DCLN 95° – Tool holder with top clamping

Scope of supply:

Tool holder with Torx key



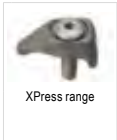
Illustrations show right-hand versions



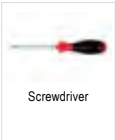
Designation	Adapter	LPR mm	l ₂ mm	BDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	Left	Right
									TO 74 504 ...	TO 74 503 ...
HSK T63 DCLN R/L 12	HSK-T 63	70	42	53	45	100	4	CN.. 1204	512	512
HSK T63 DCLN R/L 16	HSK-T 63	70	42	53	45	125	4	CN.. 1606	516	516
HSK T63 DCLN R/L 19	HSK-T 63	70	42	53	45	125	8	CN.. 1906	519	519
HSK T100 DCLN R/L 12	HSK-T 100	80	45	88	55	125	4	CN.. 1204	712	712

Spare parts
for article number

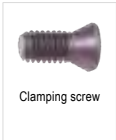
	AS 70 950 ...		AS 80 950 ...		AS 70 950 ...		AS 70 950 ...
74 503 512 / 74 504 512	824	T15 - IP	120	M4,5x12 - 15IP	820		810
74 503 516 / 74 504 516	825	T20 - IP	121	M5x14 - 20IP	821		814
74 503 519 / 74 504 519	826	T20 - IP	121	M5x14 - 20IP	821		816
74 503 712 / 74 504 712	824	T15 - IP	120	M4,5x12 - 15IP	820		810



XPress range



Screwdriver



Clamping screw

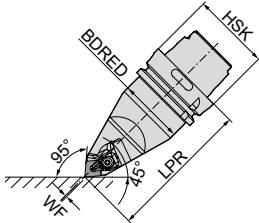


Carbide seat C

CoreLine – DCMN 95° – Tool holder with top clamping

Scope of supply:

Tool holder with Torx key



Neutral

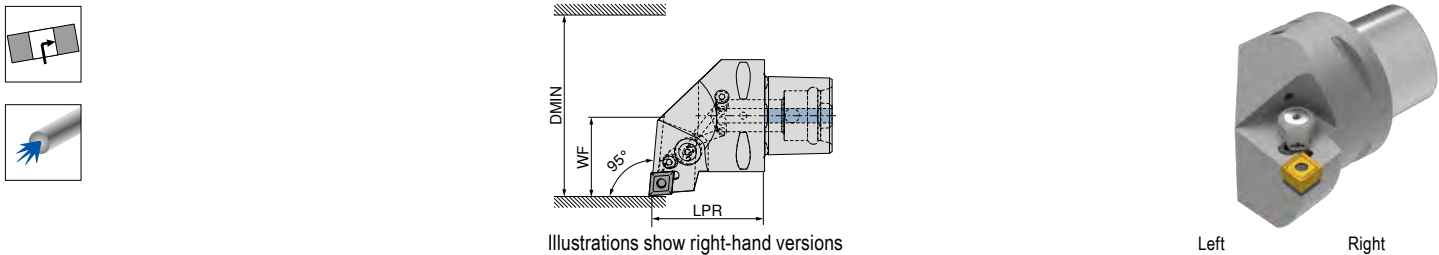
Designation	Adapter	LPR mm	BDRED mm	WF mm	Tightening torque Nm	Indexable insert	TO	
							74 506 ...	
HSK T63 DCMN N 12	HSK-T 63	115	53	0	4	CN.. 1204		512
HSK T100 DCMN N 12	HSK-T 100	150	88	0	4	CN.. 1204		712

Spare parts
for article number

	XPress range		Screwdriver		Clamping screw		Carbide seat C	
	AS	70 950 ...	AS	80 950 ...	AS	70 950 ...	AS	70 950 ...
74 506 512	824		T15 - IP	120	M4,5x12 - 15IP	820		810
74 506 712	824		T15 - IP	120	M4,5x12 - 15IP	820		810

CoreLine – PCLN 95° – Tool holder with lever clamping

Scope of supply:
Without high-performance coolant set



Designation	Adapter	LPR mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	Direct cooling compatible	TO 84 657 ...	TO 84 656 ...
PSC40 PCLN R/L 50050-12	PSC 40	50	27	50	5	CN.. 1204	DC	01295	01295
PSC50 PCLN R/L 65060-12	PSC 50	60	35	65	5	CN.. 1204	DC	01294	01294
PSC63 PCLN R/L 80065-12	PSC 63	65	45	80	5	CN.. 1204	DC	01293	01293



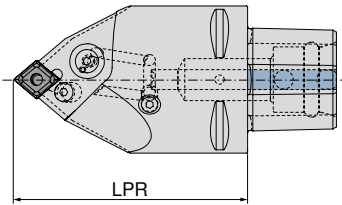
The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra.

Spare parts
for article number

	Shim		Toggle lever screw		Toggle lever		Carbide seat C
	AS		AS		AS		AS
	84 950 ...		84 950 ...		84 950 ...		84 950 ...
84 656 01295 / 84 657 01295	29200	M8X1/L17 SW3	28700		29000		27800
84 656 01294 / 84 657 01294	29200	M8X1/L17 SW3	28700		29000		27800
84 656 01293 / 84 657 01293	29200	M8X1/L17 SW3	28700		29000		27800

CoreLine – PCMN 50° – Tool holder with lever clamping

Scope of supply:
Without high-performance coolant set



Neutral

Designation	Adapter	LPR mm	Tightening torque Nm	Indexable insert	Direct cooling compatible		TO
							84 675 ...
PSC63 PCMN N 0100-12	PSC 63	100	5	CN.. 1204	DC		01293
PSC63 PCMN N 0130-12	PSC 63	130	5	CN.. 1204	DC		11293



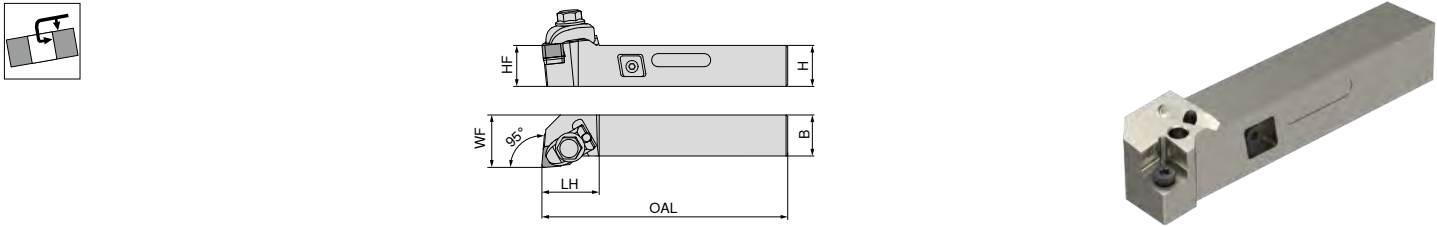
The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra.

Spare parts
for article number

	Shim		Toggle lever screw		Toggle lever		Carbide seat C	
	AS	84 950 ...	AS	84 950 ...	AS	84 950 ...	AS	84 950 ...
84 675 01293	29200	M8X1/L17 SW3	28700	29000	27800			
84 675 11293	29200	M8X1/L17 SW3	28700	29000	27800			

CoreLine – DCLN 95° – Tool holder with top clamping – C-Clamp

Scope of supply:
Tool holder **without** claw



Designation	H mm	B mm	OAL mm	LH mm	WF mm	HF mm	Indexable insert
DCLN R/L 2525 M12-C207	25	25	150	35	32	25	CN.X 12...

Left	Right
TO	TO
74 090 ...	74 090 ...
25000	25001

Spare parts
for article number

74 090 25001 / 74 090 25000

M6x13 - 20IP



Clamping screw

AS

70 950 ...

89700

X7



Carbide shim

AS

70 950 ...

88700



Carbide clamping claw

AS

70 950 ...

88400

Spare parts
for article number

74 090 25001 / 74 090 25000

M8 - 20 Nm



Clamping screw

AS

70 950 ...

89200

T20 - IP



Screwdriver

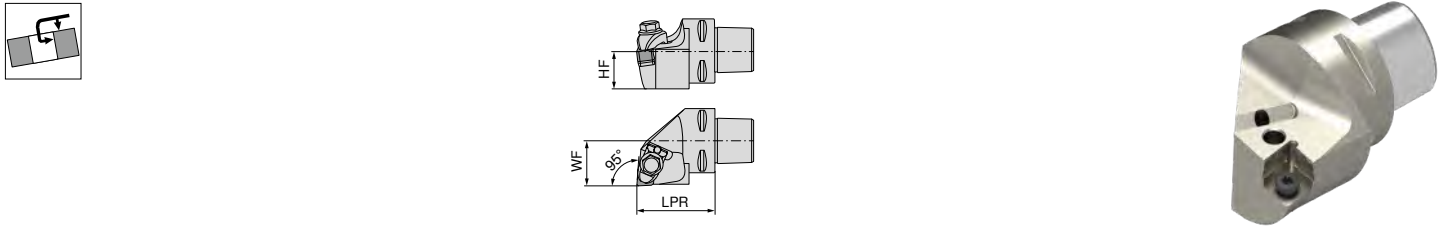
AS

80 950 ...

121

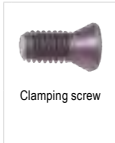
CoreLine – DCLN 95° – Tool holder with top clamping – C-Clamp

Scope of supply:
Tool holder **without** claw

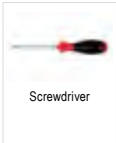


Designation	Adapter	LPR mm	WF mm	HF mm	Indexable insert	Left	Right
						TO 74 090 ... 28500	TO 74 090 ... 28501
PSC50 DCLN R 35060-12-C207	PSC 50	60	35	28.5	CN.X 12...		

Spare parts
for article number

74 090 28501 / 74 090 28500	M6x13 - 20IP	<div> AS 70 950 ... 89700</div>	X7	<div><div> AS 70 950 ... 88700</div><div> AS 70 950 ... 88400</div></div>
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Spare parts
for article number

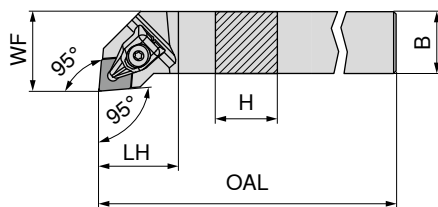
74 090 28501 / 74 090 28500	M8 - 20 Nm	<div> AS 70 950 ... 89200</div>	T20 - IP	<div> AS 80 950 ... 121</div>
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CoreLine – DCLN 95° – Toolholder with top clamping

- ▲ ...A-N = with thru coolant
▲ ...N = without thru coolant

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left

Right

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO 78 501 ...	TO 78 500 ...
DCLN R/L 12-4BA-N	0.750	0.750	4.500	1.250	1.000	CN..43..	01294	01294
DCLN R/L 12-4B-N	0.750	0.750	4.500	1.250	1.000	CN..43..	01293	01293
DCLN R/L 16-4D-N	1.000	1.000	6.000	1.250	1.250	CN..43..	01689	01689
DCLN R/L 16-4DA-N	1.000	1.000	6.000	1.250	1.250	CN..43..	01690	01690
DCLN R/L 20-4D-N	1.250	1.250	6.000	1.250	1.500	CN..43..	02089	02089
DCLN R/L 20-4DA-N	1.250	1.250	6.000	1.250	1.500	CN..43..	02090	02090
DCLN R/L 20-5D-N	1.250	1.250	6.000	1.380	1.500	CN..54..	02084	02084
DCLN L 20-5DA-N	1.250	1.250	6.000	1.380	1.500	CN..54..	02085 ¹⁾	02085 ¹⁾
DCLN R/L 24-5E-N	1.500	1.500	7.000	1.380	2.000	CN..54..	02482 ¹⁾	02482 ¹⁾
DCLN R/L 24-5EA-N	1.500	1.500	7.000	1.380	2.000	CN..54..	02483 ¹⁾	02483 ¹⁾
DCLN L 20-6D-N	1.250	1.250	6.000	1.650	1.500	CN..64..	02080	02080
DCLN R/L 20-6DA-N	1.250	1.250	6.000	1.650	1.500	CN..64..	02081 ¹⁾	02081 ¹⁾
DCLN R/L 24-6E-N	1.500	1.500	7.000	1.650	2.000	CN..64..	02477 ¹⁾	02477 ¹⁾
DCLN R/L 24-6EA-N	1.500	1.500	7.000	1.650	2.000	CN..64..	02478 ¹⁾	02478 ¹⁾

1) Not in stock

Spare parts for article number

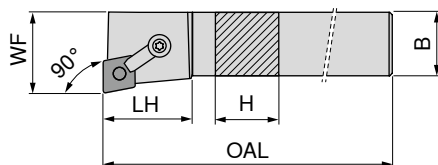
	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 500 01294 / 78 501 01294	07600	08100	08300		08500	04900
78 500 01293 / 78 501 01293	07600	08100	08300		08500	04900
78 500 01689 / 78 501 01689	07600	08100	08300		08500	04900
78 500 01690 / 78 501 01690	07600	08100	08300		08500	04900
78 500 02089 / 78 501 02089	07600	08100	08300		08500	04900
78 500 02090 / 78 501 02090	07600	08100	08300		08500	04900
78 500 02084 / 78 501 02084	07700	08100	08300	04100	08600	04900
78 500 02085 / 78 501 02085	07700	08100	08300	04100	08600	04900
78 500 02482 / 78 501 02482	07700	08100	08300	04100	08600	04900
78 500 02483 / 78 501 02483	07700	08100	08300	04100	08600	04900
78 500 02080 / 78 501 02080	07800	08100	08300	00900	08700	04900
78 500 02081 / 78 501 02081	07800	08100	08300	00900	08700	04900
78 500 02477 / 78 501 02477	07800	08100	08300	00900	08700	04900
78 500 02478 / 78 501 02478	07800	08100	08300	00900	08700	04900

					
Clamping claw	Key I	Clamping screw	Carbide seat C	Threaded bush	Spring

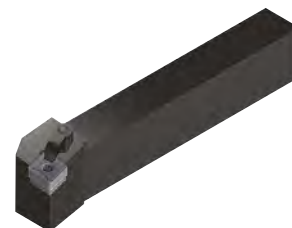
CoreLine – MCFN 90° – Toolholder with top clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left

Right

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO 78 517 ...	TO 78 516 ...
MCFN R/L 12-4B	0.750	0.750	4.500	1.120	1.000	CN..43..	01224 ¹⁾	01224 ¹⁾
MCFN R/L 16-4D	1.000	1.000	6.000	1.120	1.250	CN..43..	01644 ¹⁾	01644 ¹⁾
MCFN R/L 20-4D	1.250	1.250	6.000	1.120	1.500	CN..43..	02044 ¹⁾	02044 ¹⁾
MCFN R/L 85-4D	1.250	1.000	6.000	1.120	1.250	CN..43..	08544 ¹⁾	08544 ¹⁾
MCFN R/L 16-5D	1.000	1.000	6.000	1.250	1.250	CN..54..	01645 ¹⁾	01645 ¹⁾
MCFN R/L 20-5D	1.250	1.250	6.000	1.250	1.500	CN..54..	02045 ¹⁾	02045 ¹⁾
MCFN R/L 24-5D	1.500	1.500	6.000	1.250	2.000	CN..54..	02445 ¹⁾	02445 ¹⁾
MCFN R/L 16-6D	1.000	1.000	6.000	1.310	1.250	CN..64..	01646 ¹⁾	01646 ¹⁾
MCFN R/L 20-6D	1.250	1.250	6.000	1.310	1.500	CN..64..	02046 ¹⁾	02046 ¹⁾
MCFN R/L 24-6D	1.500	1.500	6.000	1.250	2.000	CN..64..	02446 ¹⁾	02446 ¹⁾

1) Not in stock

Spare parts

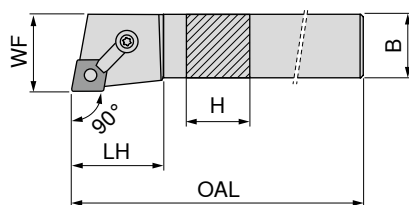
for article number

	Clamp	Key I	Dowel	Clamping screw	Carbide seat C
	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 516 01224 / 78 517 01224	00400	06900	03100	03800	00800
78 516 01644 / 78 517 01644	00400	06900	03100	03800	00800
78 516 02044 / 78 517 02044	00400	06900	03100	03800	00800
78 516 08544 / 78 517 08544	00400	06900	03100	03800	00800
78 516 01645 / 78 517 01645	00300	08100	03200	03900	04100
78 516 02045 / 78 517 02045	00300	08100	03200	03900	04100
78 516 02445 / 78 517 02445	00300	08100	03200	03900	04100
78 516 01646 / 78 517 01646	00300	08100	03300	03900	00900
78 516 02046 / 78 517 02046	00300	08100	03300	03900	00900
78 516 02446 / 78 517 02446	00300	08100	03300	03900	00900

CoreLine – MCGN 90° – Toolholder with top clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left

Right

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert
MCGN R/L 12-4B	0.750	0.750	4.500	1.120	1.000	CN..43..
MCGN R/L 16-4D	1.000	1.000	6.000	1.120	1.250	CN..43..
MCGN R/L 20-4D	1.250	1.250	6.000	1.120	1.500	CN..43..
MCGN R/L 24-4D	1.500	1.500	6.000	1.250	2.000	CN..43..
MCGN R/L 16-5D	1.000	1.000	6.000	1.500	1.250	CN..54..
MCGN R/L 20-5D	1.250	1.250	6.000	1.500	1.500	CN..54..
MCGN R/L 24-5D	1.500	1.500	6.000	1.500	2.000	CN..54..
MCGN R/L 20-6D	1.250	1.250	6.000	1.650	1.500	CN..64..
MCGN R/L 24-6D	1.500	1.500	6.000	1.650	2.000	CN..64..

TO	TO
78 519 ...	78 518 ...
01224 ¹⁾	01224 ¹⁾
01644 ¹⁾	01644 ¹⁾
02044 ¹⁾	02044 ¹⁾
02444 ¹⁾	02444 ¹⁾
01645 ¹⁾	01645 ¹⁾
02045 ¹⁾	02045 ¹⁾
02445 ¹⁾	02445 ¹⁾
02046 ¹⁾	02046 ¹⁾
02446 ¹⁾	02446 ¹⁾

¹⁾ Not in stock

Spare parts for article number

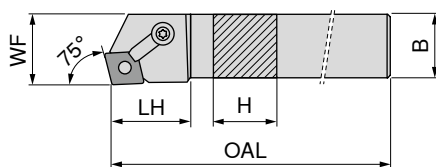
78 518 01224 / 78 519 01224
78 518 01644 / 78 519 01644
78 518 02044 / 78 519 02044
78 518 02444 / 78 519 02444
78 518 01645 / 78 519 01645
78 518 02045 / 78 519 02045
78 518 02445 / 78 519 02445
78 518 02046 / 78 519 02046
78 518 02446 / 78 519 02446

Clamp	Key I	Dowel	Clamping screw	Carbide seat C
AS	AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...
00400	06900	03100	03800	00800
00400	06900	03100	03800	00800
00400	06900	03100	03800	00800
00400	06900	03100	03800	00800
00300	08100	03200	03900	04100
00300	08100	03200	03900	04100
00300	08100	03200	03900	04100
00300	08100	03300	03900	00900
00300	08100	03300	03900	00900

CoreLine – MCKN 75° – Toolholder with top clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left

Right

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO 78 521 ...	TO 78 520 ...
MCKN R/L 12-4B	0.750	0.750	4.500	1.200	1.000	CN..43..	01224 ¹⁾	01224 ¹⁾
MCKN R/L 16-4D	1.000	1.000	6.000	1.200	1.250	CN..43..	01644 ¹⁾	01644 ¹⁾
MCKN R/L 20-4D	1.250	1.250	6.000	1.200	1.500	CN..43..	02044 ¹⁾	02044 ¹⁾
MCKN R/L 16-5D	1.000	1.000	6.000	1.350	1.250	CN..54..	01645 ¹⁾	01645 ¹⁾
MCKN R/L 20-5D	1.250	1.250	6.000	1.350	1.500	CN..54..	02045 ¹⁾	02045 ¹⁾
MCKN R/L 16-6D	1.000	1.000	6.000	1.470	1.250	CN..64..	01646 ¹⁾	01646 ¹⁾
MCKN R/L 20-6D	1.250	1.250	6.000	1.470	1.500	CN..64..	02046 ¹⁾	02046 ¹⁾
MCKN R/L 24-6D	1.500	1.500	6.000	1.470	2.000	CN..64..	02446 ¹⁾	02446 ¹⁾

¹⁾ Not in stock

Spare parts for article number

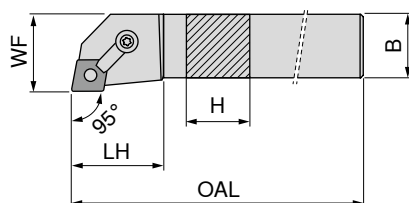
	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 520 01224 / 78 521 01224	00400	06900	03100	03800	00800
78 520 01644 / 78 521 01644	00400	06900	03100	03800	00800
78 520 02044 / 78 521 02044	00400	06900	03100	03800	00800
78 520 01645 / 78 521 01645	00300	08100	03200	03900	04100
78 520 02045 / 78 521 02045	00300	08100	03200	03900	04100
78 520 01646 / 78 521 01646	00300	08100	03300	03900	00900
78 520 02046 / 78 521 02046	00300	08100	03300	03900	00900
78 520 02446 / 78 521 02446	00300	08100	03300	03900	00900

Clamp	Key I	Dowel	Clamping screw	Carbide seat C
AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...

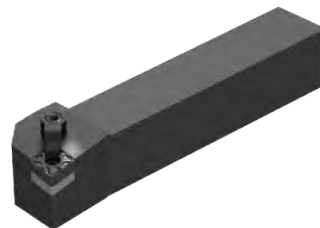
CoreLine – MCLN 95° – Toolholder with top clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left

Right

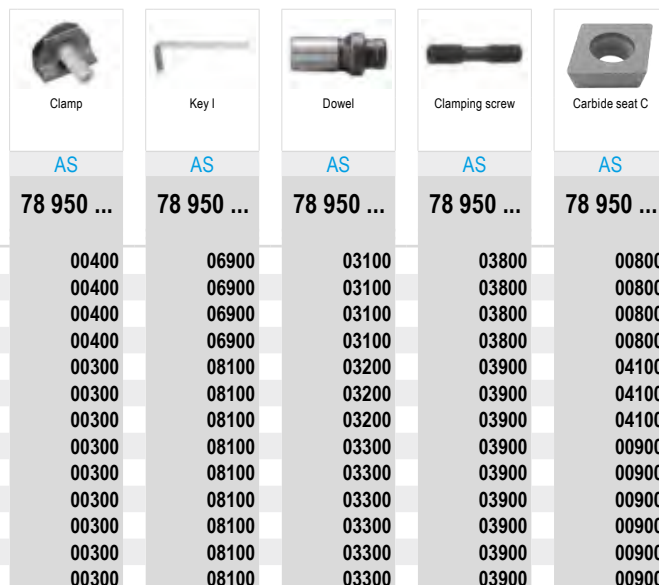
ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO 78 523 ...	TO 78 522 ...
MCLN R/L 12-4B	0.750	0.750	4.500	1.130	1.000	CN..43..	01224 ¹⁾	01224 ¹⁾
MCLN R/L 16-4D	1.000	1.000	6.000	1.130	1.250	CN..43..	01644 ¹⁾	01644 ¹⁾
MCLN R/L 85-4D	1.250	1.000	6.000	1.130	1.250	CN..43..	08544 ¹⁾	08544 ¹⁾
MCLN R/L 20-4D	1.250	1.250	6.000	1.130	1.500	CN..43..	02044 ¹⁾	02044 ¹⁾
MCLN R/L 16-5D	1.000	1.000	6.000	1.470	1.250	CN..54..	01645 ¹⁾	01645 ¹⁾
MCLN R/L 20-5D	1.250	1.250	6.000	1.470	1.500	CN..54..	02045 ¹⁾	02045 ¹⁾
MCLN R/L 24-5D	1.500	1.500	6.000	1.470	2.000	CN..54..	02445 ¹⁾	02445 ¹⁾
MCLN R/L 16-6D	1.000	1.000	6.000	1.510	1.250	CN..64..	01646 ¹⁾	01646 ¹⁾
MCLN R/L 20-6D	1.250	1.250	6.000	1.510	1.500	CN..64..	02046 ¹⁾	02046 ¹⁾
MCLN R/L 85-6D	1.250	1.000	6.000	1.510	1.250	CN..64..	08546 ¹⁾	08546 ¹⁾
MCLN R/L 24-6D	1.500	1.500	6.000	1.510	2.000	CN..64..	02446 ¹⁾	02446 ¹⁾
MCLN R/L 24-6E	1.500	1.500	7.000	1.500	2.000	CN..64..	02456 ¹⁾	02456 ¹⁾
MCLN R/L 86-6E	1.500	1.000	7.000	1.510	1.250	CN..64..	08656 ¹⁾	08656 ¹⁾

¹⁾ Not in stock

Spare parts

for article number

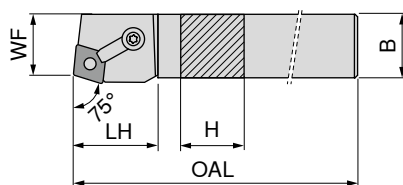
	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 522 01224 / 78 523 01224	00400	06900	03100	03800	00800
78 522 01644 / 78 523 01644	00400	06900	03100	03800	00800
78 522 08544 / 78 523 08544	00400	06900	03100	03800	00800
78 522 02044 / 78 523 02044	00400	06900	03100	03800	00800
78 522 01645 / 78 523 01645	00300	08100	03200	03900	04100
78 522 02045 / 78 523 02045	00300	08100	03200	03900	04100
78 522 02445 / 78 523 02445	00300	08100	03200	03900	04100
78 522 01646 / 78 523 01646	00300	08100	03300	03900	00900
78 522 02046 / 78 523 02046	00300	08100	03300	03900	00900
78 522 08546 / 78 523 08546	00300	08100	03300	03900	00900
78 522 02446 / 78 523 02446	00300	08100	03300	03900	00900
78 522 02456 / 78 523 02456	00300	08100	03300	03900	00900
78 522 08656 / 78 523 08656	00300	08100	03300	03900	00900



CoreLine – MCRN 75° – Toolholder with top clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left

Right

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert
MCRN R/L 12-4B	0.750	0.750	4.500	1.180	0.878	CN..43..
MCRN R/L 16-4D	1.000	1.000	6.000	1.180	1.128	CN..43..
MCRN R/L 20-4D	1.250	1.250	6.000	1.180	1.318	CN..43..
MCRN R/L 16-5D	1.000	1.000	6.000	1.100	1.101	CN..54..
MCRN R/L 20-5D	1.250	1.250	6.000	1.350	1.351	CN..54..
MCRN R/L 20-6D	1.250	1.250	6.000	1.318	1.318	CN..64..
MCRN R/L 24-6D	1.500	1.500	6.000	1.818	1.818	CN..64..

TO	TO
78 525 ...	78 524 ...
01224 ¹⁾	01224 ¹⁾
01644 ¹⁾	01644 ¹⁾
02044 ¹⁾	02044 ¹⁾
01645 ¹⁾	01645 ¹⁾
02045 ¹⁾	02045 ¹⁾
02046 ¹⁾	02046 ¹⁾
02446 ¹⁾	02446 ¹⁾

¹⁾ Not in stock

for article number

78 524 01224 / 78 525 01224
 78 524 01644 / 78 525 01644
 78 524 02044 / 78 525 02044
 78 524 01645 / 78 525 01645
 78 524 02045 / 78 525 02045
 78 524 02046 / 78 525 02046
 78 524 02446 / 78 525 02446

AS	AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...
00400	06900	03100	03800	00800
00400	06900	03100	03800	00800
00400	06900	03100	03800	00800
00300	08100	03200	03900	04100
00300	08100	03200	03900	04100
00300	08100	03300	03900	00900
00300	08100	03300	03900	00900



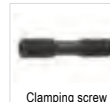
Clamp



Key I



Dowel



Clamping screw

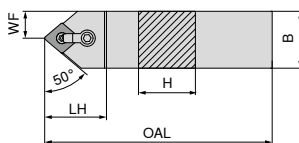


Carbide seat C

CoreLine – MCMN 50° – Toolholder with top clamping

Scope of supply:

Tool holder with allen key



Neutral

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO 78 575 ...
MCMN N 12-4B	0.750	0.750	4.500	1.280	0.375	CN..43..	01224 ¹⁾
MCMN N 16-4D	1.000	1.000	6.000	1.280	0.500	CN..43..	01644 ¹⁾
MCMN N 20-4D	1.250	1.250	6.000	1.390	0.625	CN..43..	02044 ¹⁾
MCMN N 85-4D	1.250	1.000	6.000	1.280	0.625	CN..43..	08544 ¹⁾
MCMN N 16-5C	1.000	1.000	6.000	1.750	0.500	CN..54..	01635 ¹⁾
MCMN N 20-5D	1.250	1.250	6.000	1.610	0.625	CN..54..	02045 ¹⁾
MCMN N 24-5D	1.500	1.500	6.000	1.610	0.750	CN..54..	02445 ¹⁾
MCMN N 24-6D	1.500	1.500	6.000	1.670	0.750	CN..64..	02446 ¹⁾

1) Not in stock

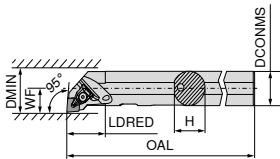
Spare parts for article number

	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 575 01224	00400	06900	03100	03800	00800
78 575 01644	00400	06900	03100	03800	00800
78 575 02044	00400	06900	03100	03800	00800
78 575 08544	00400	06900	03100	03800	00800
78 575 01635	00300	08100	03200	03900	04100
78 575 02045	00300	08100	03200	03900	04100
78 575 02445	00300	08100	03200	03900	04100
78 575 02446	00300	08100	03300	03900	00900

 Clamp	 Key I	 Dowel	 Clamping screw	 Carbide seat C
AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...

CoreLine – DCLN 95° – Boring bar with top clamping

Scope of supply:
Boring bar with Torx key

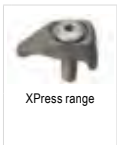


Illustrations show right-hand versions

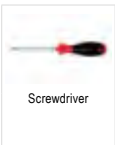
Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	Left	Right
									TO 70 557 ...	TO 70 556 ...
A20Q DCLN R/L 09	20	19	180	35	13	25	2	CN.. 0903	720	720
A25R DCLN R/L 12	25	24	200	36	17	32	4	CN.. 1204	825	825
A32S DCLN R/L 12	32	31	250	40	22	40	4	CN.. 1204	832	832
A40T DCLN R/L 12	40	39	300	45	27	50	4	CN.. 1204	840	840
A40U DCLN L 16	50	47	350	45	35	63	6,5	CN.. 1606	85000	

Spare parts
for article number

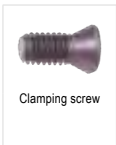
	AS 70 950 ...		AS 80 950 ...		AS 70 950 ...	AS 70 950 ...
70 556 720 / 70 557 720	823	T09 - IP	118	M3x7 - 09IP	819	848
70 556 825 / 70 557 825	824	T15 - IP	120	M4,5x12 - 15IP	820	
70 556 832 / 70 557 832	824	T15 - IP	120	M4,5x12 - 15IP	820	810
70 556 840 / 70 557 840	824	T15 - IP	120	M4,5x12 - 15IP	820	810
70 557 85000	825	T20 - IP	121	M5x14 - 20IP	821	814



XPress range



Screwdriver



Clamping screw



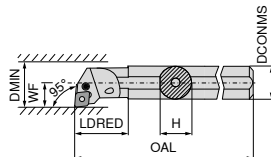
Carbide seat C

CoreLine – PCLN 95° – Boring bar with lever clamping

- ▲ A... = with coolant hole
▲ S... = without coolant hole

Scope of supply:

Boring bar with Allen key



Illustrations show right-hand versions

Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert
A25R PCLN R/L 12	25	23	200	36.0	17	32	4	CN.. 1204
S25T PCLN R/L 12	25	23	300	22.0	17	32	4	CN.. 1204
A32S PCLN R/L 12	32	30	250	50.0	22	40	4	CN.. 1204
S32U PCLN R/L 12	32	30	350	24.1	22	40	4	CN.. 1204
A40T PCLN R/L 12	40	38	300	60.0	27	50	4	CN.. 1204
S40V PCLN R/L 12	40	38	400	24.1	27	50	4	CN.. 1204
S50W PCLN R/L 16	50	47	450	31.0	35	63	4	CN.. 1606

Left

Right

TO	TO
70 557 ...	70 556 ...
225	225
025	025
232	232
032	032
240	240
040	04000 ¹⁾
050	050

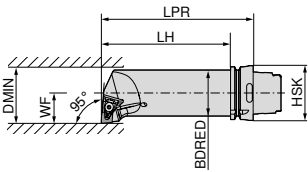
1) Nickel plated

	Key I	Shim	Assembly pin	Toggle lever	Clamping screw	Carbide seat C
	AS	AS	AS	AS	AS	AS
	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 556 225 / 70 557 225	SW3 176	198	192	187	205	233
70 556 025 / 70 557 025	SW3 176	198	192	187	205	233
70 556 232 / 70 557 232	SW3 176	198	192	187	205	233
70 556 032 / 70 557 032	SW3 176	198	192	187	205	233
70 556 240 / 70 557 240	SW3 176	198	192	187	209	233
70 556 04000 / 70 557 040	SW3 176	198	192	187	209	233
70 556 050 / 70 557 050	SW3 176	391	394	385	388	380

Spare parts
for article number

CoreLine – DCLN 95° – Boring bar with top clamping

Scope of supply:
Boring bar with Torx key



Illustrations show right-hand versions

Designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	Left TO 74 529 ... 512	Right TO 74 528 ... 512
HSK T63 50Q DCLN R/L 12	HSK-T 63	175	149	50	35	63	4	CN.. 1204		

Spare parts
for article number

74 528 512 / 74 529 512



XPress range

AS

70 950 ...

824



Screwdriver

AS

80 950 ...

120



Clamping screw

AS

70 950 ...

820



Carbide seat C

AS

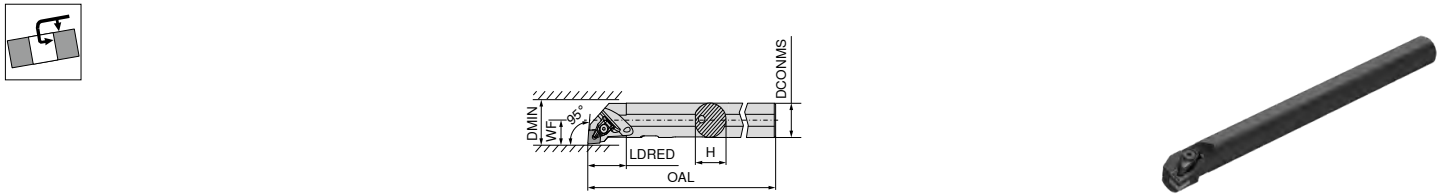
70 950 ...

810

CoreLine – DCLN 95° – Boring bar with top clamping

- ▲ A... = with thru coolant
- ▲ S... = without thru coolant

Scope of supply:
Tool holder with allen key



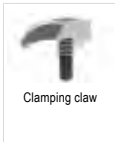
Illustrations show right-hand versions

ANSI designation	DCONMS inch	H inch	OAL inch	LDRED inch	WF inch	DMIN inch	Indexable insert	Left	Right
								TO 78 701 ...	TO 78 700 ...
S16T DCLN R/L 4N	1.000	0.900	12.000	1.575	0.640	1.280	CN..43..	41626 ¹⁾	41626 ¹⁾
S20U DCLN R/L 4N	1.250	1.180	14.000	1.771	0.765	1.530	CN..43..	42030 ¹⁾	42030 ¹⁾
S24U DCLN R/L 4N	1.500	1.370	14.000	1.968	0.890	1.780	CN..43..	42434 ¹⁾	42434 ¹⁾

1) Not in stock

Spare parts
for article number

	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 700 41626 / 78 701 41626	07600	08100	08300	07200	08500	04900
78 700 42030 / 78 701 42030	07600	08100	08300	07200	08500	04900
78 700 42434 / 78 701 42434	07600	08100	08300	07200	08500	04900



Clamping claw

AS
78 950 ...



Key I

AS
78 950 ...



Clamping screw

AS
78 950 ...



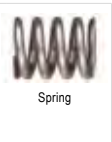
Carbide seat C

AS
78 950 ...



Threaded bush

AS
78 950 ...



Spring

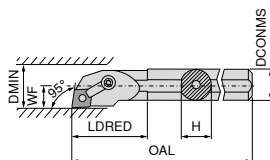
AS
78 950 ...

CoreLine – MCLN 95° – Boring bar with top clamping

- ▲ A... = with thru coolant
▲ S... = without thru coolant

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions

ANSI designation	DCONMS inch	H inch	OAL inch	LDRED inch	WF inch	DMIN inch	Indexable insert	Left TO 78 705 ...	Right TO 78 704 ...
A16T MCLN R/L 4	1.000	0.900	12.000	2.500	0.640	1.280	CN..32..	41616	41616
S16T MCLN R/L 4	1.000	0.900	12.000	2.500	0.640	1.280	CN..43..	41626 ¹⁾	41626 ¹⁾
S20U MCLN R/L 4	1.250	1.118	14.000	3.000	0.765	1.530	CN..43..	42030 ¹⁾	42030 ¹⁾
A20U MCLN R/L 4	1.250	1.118	14.000	3.000	0.765	1.530	CN..43..	42020 ¹⁾	42020 ¹⁾
S24U MCLN R/L 4	1.500	1.370	14.000	3.000	0.890	1.780	CN..43..	42434 ¹⁾	42434 ¹⁾
A24U MCLN R/L 4	1.500	1.370	14.000	3.000	0.890	1.780	CN..43..	42424	42424
S28U MCLN R/L 4	1.750	1.630	14.000	4.000	1.015	2.030	CN..43..	42838 ¹⁾	42838 ¹⁾
A28U MCLN R/L 4	1.750	1.630	14.000	4.000	1.015	2.030	CN..43..	42828 ¹⁾	42828 ¹⁾
S32V MCLN R/L 4	2.000	1.870	16.000	4.000	1.281	2.562	CN..43..	43242 ¹⁾	43242 ¹⁾
S40V MCLN R/L 4	2.500	2.380	16.000	4.000	1.531	3.062	CN..43..	44050 ¹⁾	44050 ¹⁾
S32V MCLN R/L 5	2.000	1.870	16.000	4.000	1.281	2.562	CN..54..	53242 ¹⁾	53242 ¹⁾
A32V MCLN R/L 5	2.000	1.870	16.000	4.000	1.281	2.562	CN..54..	53233 ¹⁾	53233 ¹⁾
S40V MCLN R/L 5	2.500	2.380	16.000	4.000	1.531	3.062	CN..54..	54050 ¹⁾	54050 ¹⁾
A32V MCLN R/L 6	2.000	1.870	16.000	4.000	1.281	2.562	CN..64..	63233 ¹⁾	63233 ¹⁾
S32V MCLN R/L 6	2.000	1.870	16.000	4.000	1.281	2.562	CN..64..	63242 ¹⁾	63242 ¹⁾
S40V MCLN R/L 6	2.500	2.380	16.000	4.000	1.531	3.062	CN..64..	64050 ¹⁾	64050 ¹⁾

1) Not in stock

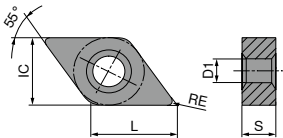
Spare parts

for article number

	Clamp	Key I	Dowel	Clamping screw	Carbide seat C
	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 704 41616 / 78 705 41616	00400	06900	03000	03700	
78 704 41626 / 78 705 41626	00400	06900	03000	03700	
78 704 42030 / 78 705 42030	00400	06900	03100	03800	00800
78 704 42020 / 78 705 42020	00400	06900	03100	03800	00800
78 704 42434 / 78 705 42434	00400	06900	03100	03800	00800
78 704 42424 / 78 705 42424	00400	06900	03100	03800	00800
78 704 42838 / 78 705 42838	00400	06900	03100	03800	00800
78 704 42828 / 78 705 42828	00400	06900	03100	03800	00800
78 704 43242 / 78 705 43242	00400	06900	03100	03800	00800
78 704 44050 / 78 705 44050	00400	06900	03100	03800	00800
78 704 53242 / 78 705 53242	00300	08100	03200	03900	04100
78 704 53233 / 78 705 53233	00300	08100	03200	03900	04100
78 704 54050 / 78 705 54050	00300	08100	03200	03900	04100
78 704 63233 / 78 705 63233	00300	08100	03300	03900	00900
78 704 63242 / 78 705 63242	00300	08100	03300	03900	00900
78 704 64050 / 78 705 64050	00300	08100	03300	03900	00900

DNMG / DNMA / DNMM

Designation	L	S	D1	IC
	mm	mm	mm	mm
DNMG 1104..	11.6	4.76	3.81	9.52
DNMG 1504..	15.5	4.76	5.16	12.70
DNM. 1506..	15.5	6.35	5.16	12.70



CoreLine – Carbide turning indexable insert

DNMG

		-CF20 CTEP110-P	-TFQ CTEP110-P	-F50 CTCK110-P	-F50 CTCP115-P	-F50 CTCP125-P	-F50 CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F	F	F	F	F	F
		CERMET DNMG	CERMET DNMG	DNMG	DNMG	DNMG	DNMG
		TR	TR	TR	TR	TR	TR
ISO	RE mm	76 102 ...	76 153 ...	70 317 ...	76 134 ...	76 134 ...	76 134 ...
110402EN	0.2			10201	30201	50201	70201
110404EN	0.4	00401		10401	30401	50401	70401
110408EN	0.8	00601		10601	30601	50601	70601
110412EN	1.2				30801	50801	70801
150404EN	0.4			11601	31601	51601	71601
150408EN	0.8			11801	31801	51801	71801
150412EN	1.2				32001	52001	72001
150604EN	0.4	02801	02801	12801	32801	52801	72801
150608EN	0.8	03001	03001	13001	33001	53001	73001
150612EN	1.2	03201		13201	33201	53201	73201
P		●	●	○	●	●	●
M		○	○				○
K		○	○	●	○	○	
N							
S							
H							
O							

DNMG

		-TFQ CTCP115-P	-TFQ CTCP125-P	-TFQ CTCP115-P	-TFQ CTCP125-P	-XU CTCP115-P	-XU CTCP125-P	-XU CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F DNMG	F DNMG	M DNMG	M DNMG	M DNMG	M DNMG	M DNMG
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	76 153 ...	76 153 ...	76 169 ...	76 169 ...	76 291 ...	76 291 ...	76 291 ...
110404EN	0.4					30401	50401	70401
110408EN	0.8					30601	50601	70601
150604EN	0.4	32801	52801			32801	52801	72801
150608EN	0.8	33001	53001			33001	53001	73001
150612EN	1.2			33201	53201	33201	53201	73201
P		●	●	●	●	●	●	●
M								○
K		○	○	○	○	○	○	
N								
S								
H								
O								

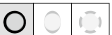
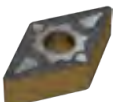
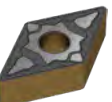
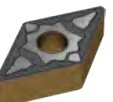
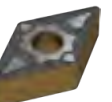
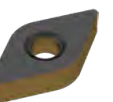
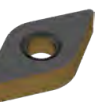
CoreLine – Carbide turning indexable insert

DNMG

		<div><div><div><div><div>-M50</div><div>CTCK110-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div><div></div><div></div><div></div></div></div><div>M</div><div>DNMG</div></div></div><div><div><div><div>-M50</div><div>CTCK120-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div><div></div><div></div><div></div></div></div><div>M</div><div>DNMG</div></div></div><div><div><div><div>-M50</div><div>CTCP115-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div><div></div><div></div><div></div></div></div><div>M</div><div>DNMG</div></div></div><div><div><div><div>-M50</div><div>CTCP125-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div><div></div><div></div><div></div></div></div><div>M</div><div>DNMG</div></div></div><div><div><div><div>-M50</div><div>CTCP135-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div><div></div><div></div><div></div></div></div><div>M</div><div>DNMG</div></div></div><div><div><div><div>-TMQ</div><div>CTCP125-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div><div></div><div></div><div></div></div></div><div>M</div><div>DNMG</div></div></div><div><div><div><div>-TMQ</div><div>CTCP125-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div><div></div><div></div><div></div></div></div><div>M</div><div>DNMG</div></div></div></div>						
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	70 133 ...	70 133 ...	76 136 ...	76 136 ...	76 136 ...	76 168 ...	76 197 ...
110404EN	0.4	10401	50401	30401	50401	70401		
110408EN	0.8	10601	50601	30601	50601	70601		
110412EN	1.2			30801	50801	70801		
150404EN	0.4	11601	51601	31601	51401	71601		
150408EN	0.8	11801	51801	31801	51801	71801		
150412EN	1.2			32001	51601	72001		
150416EN	1.6			32201	52201	72201		
150604EN	0.4	12801	52801	32801	52801	72801		
150608EN	0.8	13001	53001	33001	53001	73001	33001	53001
150612EN	1.2	13201	53201	33201	53201	73201	33201	53201
150616EN	1.6	13401	53401	33401	53401	73401		
P		○	○	●	●	●	●	●
M						○		
K		●	●	○	○		○	○
N								
S								
H								
O								

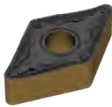
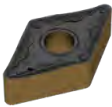
CoreLine – Carbide turning indexable insert

DNMG / DNMA

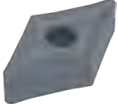
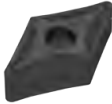
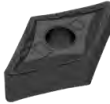
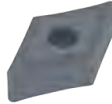
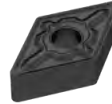
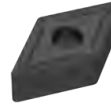
		<div>-M70 CTCK110-P</div>		<div>-M70 CTCK120-P</div>		<div>-M70 CTCP115-P</div>		<div>-M70 CTCP125-P</div>		<div>-M70 CTCP135-P</div>		<div>CTCK110-P</div>		<div>CTCK120-P</div>	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
															
		M DNMG		M DNMG		M DNMG		M DNMG		M DNMG		R DNMA		R DNMA	
		TR		TR		TR		TR		TR		TR		TR	
		70 263 ...		70 263 ...		76 263 ...		76 263 ...		76 263 ...		70 156 ...		70 156 ...	
ISO	RE mm	110408EN	0.8			30601		50601		70601					
		110412EN	1.2			30801		50801		70801					
ISO	RE mm	150408EN	0.8	11801	51801	31801	51801	71801							
		150412EN	1.2	12001	52001	32001	52001	72001							
		150416EN	1.6			32201	52201	72201							
ISO	RE mm	150608EN	0.8	13001	53001	33001	53001	73001				13001		53001	
		150612EN	1.2	13201	53201	33201	53201	73201				13201		53201	
		150616EN	1.6	13401	53401	33401	53401	73401							
P			○		○	●	●	●		○		○		○	
M										○					
K			●	●	○	○						●		●	
N															
S															
H															
O															

CoreLine – Carbide turning indexable insert

DNMM / DNMG

		<div><div>-R28</div><div>CTCP115-P</div></div>	<div><div>-R28</div><div>CTCP125-P</div></div>	<div><div>-R28</div><div>CTCP135-P</div></div>	<div><div>-R58</div><div>CTCP115-P</div></div>	<div><div>-R58</div><div>CTCP125-P</div></div>	<div><div>-R58</div><div>CTCP135-P</div></div>	<div><div>-F30</div><div>CTCM120</div></div>
		<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>
		<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>
		<div></div>	<div></div>	<div></div>	<div></div>	<div></div>	<div></div>	<div></div>
		<div>R</div> <div>DNMM</div>	<div>R</div> <div>DNMM</div>	<div>R</div> <div>DNMM</div>	<div>R</div> <div>DNMM</div>	<div>R</div> <div>DNMM</div>	<div>R</div> <div>DNMM</div>	<div>F</div> <div>DNMG</div>
		<div>TR</div>	<div>TR</div>	<div>TR</div>	<div>TR</div>	<div>TR</div>	<div>TR</div>	<div>TR</div>
ISO	RE mm	76 165 ...	76 165 ...	76 165 ...	76 166 ...	76 166 ...	76 166 ...	75 013 ...
110404EN	0.4							10400
110408EN	0.8							10600
150404EN	0.4							11600
150408EN	0.8							11800
150604EN	0.4							12800
150608EN	0.8							13000
150612EN	1.2	33201	53201	73201	33201	53201	73201	
150616EN	1.6	33401						
P		●	●	●	●	●	●	○
M				○			○	●
K		○	○		○	○		
N								
S								
H								
O								

DNMG

		-F30 CTPM125		-F30 CTCM130		-M30 CTCM120		-M30 CTPM125		-M30 CTCM130		-M42 CTCM130		-M60 CTCM120	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
															
		F DNMG		F DNMG		M DNMG		M DNMG		M DNMG		M DNMG		M DNMG	
		TR		TR		TR		TR		TR		TR		TR	
ISO	RE mm	75 013 ...		75 013 ...		75 014 ...		75 014 ...		75 014 ...		75 027 ...		75 015 ...	
110404EN	0.4	204		30400								30400			
110408EN	0.8	206		30600		10600		206		30600		30600			
110412EN	1.2					10800		208		30800					
150404EN	0.4			31600								31600			
150408EN	0.8			31800		11800				31800		31800		11800	
150412EN	1.2					12000				32000				12000	
150604EN	0.4	228		32800								32800			
150608EN	0.8	230		33000		13000		230		33000		33000		13000	
150612EN	1.2					13200		232		33200				13200	
P		○		○		○		○		○		○		○	
M		●		●		●		●		●		●		●	
K															
N															
S		○													
H															
O															

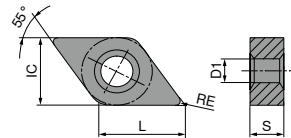
CoreLine – Carbide turning indexable insert

DNMG

		<div><div>-M60</div><div>CTPM125</div></div>	<div><div>-M60</div><div>CTCM130</div></div>	<div><div>-M70</div><div>CTCM130</div></div>	<div><div>-M34</div><div>CTPX710</div></div>	<div><div>-M42</div><div>CTPX710</div></div>
		<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>
		<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>
		<div><div></div></div>	<div><div></div></div>	<div><div></div></div>	<div><div></div></div>	<div><div></div></div>
		<div>M</div>	<div>M</div>	<div>M</div>	<div>M</div>	<div>M</div>
		<div>DNMG</div>	<div>DNMG</div>	<div>DNMG</div>	<div>DNMG</div>	<div>DNMG</div>
		<div>TR</div>	<div>TR</div>	<div>TR</div>	<div>TR</div>	<div>TR</div>
ISO	RE mm	75 015 ...	75 015 ...	75 038 ...	75 004 ...	75 027 ...
110408EN	0.8			30600		
150404EN	0.4				61600	
150408EN	0.8		31800		61800	
150412EN	1.2		32000		62000	
150608EN	0.8	230	33000		63000	63000
150612EN	1.2	232	33200		63200	
P		○	○	○	●	●
M		●	●	●	●	●
K						
N					○	○
S			○	○	●	●
H						
O						

DNGU

Designation	L	S	D1	IC
	mm	mm	mm	mm
DNGU 1104..	11.6	4.76	3.81	9.52



CoreLine – Carbide turning indexable insert

DNGU

-F32

WPU7620

F

DNGU

-F32

WUU7620

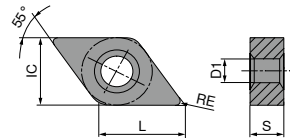
F

DNGU

ISO	RE mm		TR	72 494 ...	50800	51500	TR	72 401 ...	33800	34500
1104008FN	0.08									
1104015FN	0.15									
P				●				●		
M				○				○		
K				●				○		
N				○				○		
S				○				○		
H										
O				○				○		

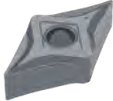
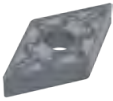
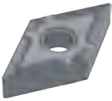
DNGP / DNMG

Designation	L	S	D1	IC
	mm	mm	mm	mm
DN.. 1506..	15.5	6.35	5.16	12.7
DN.. 1504..	15.5	4.76	5.16	12.7



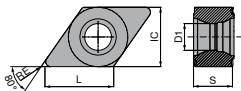
CoreLine – Carbide turning indexable insert

DNGP / DNMG

		<div><div>-F32</div><div>CTP2120</div><div><div></div><div></div><div></div></div><div></div><div><div>F</div><div>DNGP</div></div></div>	<div><div>-M42</div><div>CTP2120</div><div><div></div><div></div><div></div></div><div></div><div><div>M</div><div>DNMG</div></div></div>	<div><div>-M52</div><div>CTP2120</div><div><div></div><div></div><div></div></div><div></div><div><div>M</div><div>DNMG</div></div></div>
		TR	TR	TR
ISO	RE mm	70 118 ...	70 158 ...	70 119 ...
150402FN	0.2	602		
150404EN	0.4		604	
150404FN	0.4	604		
150408FN	0.8	608		
150602FN	0.2	610		
150604EN	0.4		610	612
150604FN	0.4	612		
150608EN	0.8		612	614
150608FN	0.8	614		
P				
M				
K				
N				
S				
H				
O				

DNMU

Designation	L	S	D1	IC
	mm	mm	mm	mm
DNMU 1106..	11.6	6.35	4.3	9.52

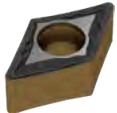


CoreLine – Carbide turning indexable insert

DNMU

-M30
CTCP115-P

DRAGONSKIN



M
DNMU

ISO	RE
	mm
110608EN	0.8

TR

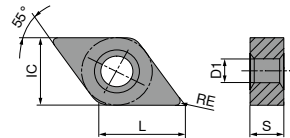
76 413 ...

30601

P	
M	
K	
N	
S	
H	
O	

DNMG

Designation	L	S	D1	IC
	mm	mm	mm	mm
DNMG 1504..	15.5	4.76	5.16	12.7
DNMG 1506..	15.5	6.35	5.16	12.7



CoreLine – Carbide turning indexable insert

DNMG

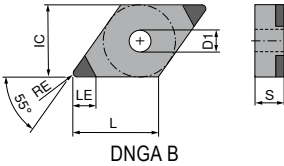
ISO	RE mm
150404EN	0.4
150408EN	0.8
150604EN	0.4
150608EN	0.8
150612EN	1.2
150616EN	1.6

-FMS CT-P15	-FMS CT-P25	-MRS CT-P15	-MRS CT-P25	-MRS CT-P35
F DNMG	F DNMG	M DNMG	M DNMG	M DNMG
CX	CX	CX	CX	CX
75 306 ...	75 306 ...	75 307 ...	75 307 ...	75 307 ...
01609	11609			
01809	11809	01809	11809	
02809	12809			
03009	13009	03009	13009	23009
03209	13209	03209	13209	23209
		03409	13409	23409

P	●	●	●	●	●
M	○	○	○	○	○
K					
N					
S					
H					
O					

DNGA

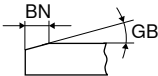
Designation	L	S	D1	IC
	mm	mm	mm	mm
DNGA 1506..	15.5	6.35	5.16	12.7



CoreLine – PcBN turning indexable insert

DNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners



CTBH1000C

F

PCBN

DNGA

CTBH2000C

F

PCBN

DNGA

CTBH3000C

F

PCBN

DNGA

ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
150604EN	0.4			B (2)	3.6
150604SN	0.4	0.14	20°	B (2)	3.6
150608EN	0.8			B (2)	3.3
150608SN	0.8	0.14	20°	B (2)	3.3
150612EN	1.2			B (2)	3.0
150612SN	1.2	0.14	20°	B (2)	3.0

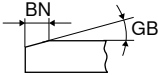
PC	PC	PC
71 017 ...	71 017 ...	71 017 ...
70002	80002	90002
70302	80302	90302
70602	80602	90602

P			
M			
K			
N			
S			
H			
O			

CoreLine – PcBN turning indexable insert

DNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners



CTBH1000C	CTBH2000C	CTBH3000C
M	M	M
PCBN	PCBN	PCBN
DNGA	DNGA	DNGA
PC	PC	PC
71 017 ...	71 017 ...	71 017 ...
70102	80102	90102
70402	80402	90402
70702	80702	90702

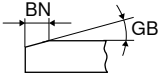
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
150604SN	0.4	0.09	15°	B (2)	3.6
150604SN	0.4	0.18	25°	B (2)	3.6
150608SN	0.8	0.09	15°	B (2)	3.3
150608SN	0.8	0.18	25°	B (2)	3.3
150612SN	1.2	0.09	15°	B (2)	3.0
150612SN	1.2	0.18	25°	B (2)	3.0

P			
M			
K			
N			
S			
H			
O			

CoreLine – PcBN turning indexable insert

DNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners



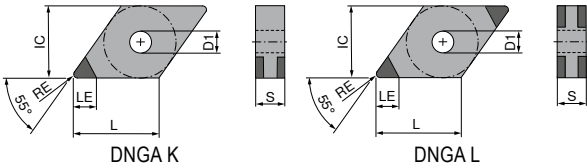
CTBH1000C	CTBH2000C	CTBH3000C
R	R	R
PCBN	PCBN	PCBN
DNGA	DNGA	DNGA
PC	PC	PC
71 017 ...	71 017 ...	71 017 ...
70202	80202	90202
70502	80502	90502
70802	80802	90802

ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
150604SN	0.4	0.14	20°	B (2)	3.6
150604SN	0.4	0.20	35°	B (2)	3.6
150608SN	0.8	0.14	20°	B (2)	3.3
150608SN	0.8	0.20	35°	B (2)	3.3
150612SN	1.2	0.14	20°	B (2)	3.0
150612SN	1.2	0.20	35°	B (2)	3.0

P			
M			
K			
N			
S			
H			
O			

DNGA

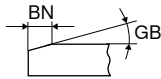
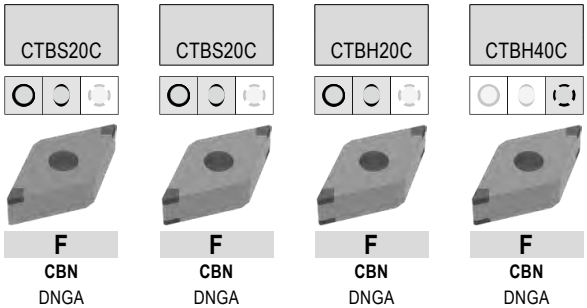
Designation	L	S	D1	IC
	mm	mm	mm	mm
DNGA 1504..	15.5	4.76	5.16	12.7
DNGA 1506..	15.5	6.35	5.16	12.7



CoreLine – PcBN turning indexable insert

DNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners



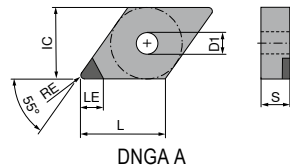
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
150604SN	0.4	0.09	10°	L (4)	2.8
150604SN	0.4	0.09	15°	L (4)	2.8
150404SN	0.4	0.09	20°	L (4)	2.8
150604SN	0.4	0.09	20°	L (4)	2.8
150604SN	0.4	0.09	20°	K (2)	2.8
150604SN	0.4	0.11	20°	L (4)	2.8
150404TN	0.4	0.11	25°	L (4)	2.8
150604SN	0.4	0.11	25°	L (4)	2.8
150604TN	0.4	0.11	25°	L (4)	2.8
150604SN	0.4	0.13	25°	L (4)	2.8
150604SN	0.4	0.14	30°	L (4)	2.8
150604SN	0.4	0.18	30°	L (4)	2.8
150604SN	0.4	0.14	35°	L (4)	2.8
150608SN	0.8	0.09	10°	L (4)	2.6
150608SN	0.8	0.09	15°	L (4)	2.6
150608SN	0.8	0.11	15°	K (2)	2.6
150408SN	0.8	0.09	20°	L (4)	2.6
150608SN	0.8	0.09	20°	L (4)	2.6
150608SN	0.8	0.11	20°	L (4)	2.6
150608SN	0.8	0.11	25°	L (4)	2.6
150608SN	0.8	0.13	25°	L (4)	2.6
150608SN	0.8	0.16	25°	K (2)	2.6
150408SN	0.8	0.14	30°	L (4)	2.6
150608SN	0.8	0.14	30°	L (4)	2.6
150608SN	0.8	0.18	30°	L (4)	2.6
150608SN	0.8	0.14	35°	L (4)	2.6

PC	PC	PC	PC
71 411 ...	71 403 ...	71 403 ...	71 403 ...
	122		
	132		
	10200		
	152		332
20000		242	
		20200	
			352
		24800	
		262	
	182		372
			37500
	124		
	134		
20100			
	10300		
	154		334
		244	
			354
20200		264	
			30700
		274	374
	184		
			37600

P				
M				
K				
N				
S				
H				
O				

DNGA

Designation	L	S	D1	IC
	mm	mm	mm	mm
DNGA 1504..	15.5	4.76	5.16	12.7
DNGA 1506..	15.5	6.35	5.16	12.7

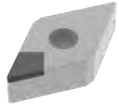


CoreLine – PCD turning indexable insert

DNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners

CTDPD20



F
DIAMOND
DNGA

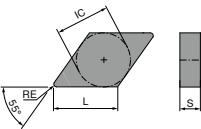
ISO	RE mm	TCE (NOI)	LE mm
150404FN	0.4	A (1)	6.4
150408FN	0.8	A (1)	6.0
150412FN	1.2	A (1)	5.6
150604FN	0.4	A (1)	6.4
150608FN	0.8	A (1)	6.0
150612FN	1.2	A (1)	5.6

PC
71 128 ...
10001
10101
10201
10301
10401
10501

P	
M	
K	
N	●
S	
H	
O	●

DNGN

Designation	L	S	IC
	mm	mm	mm
DNGN 1507..	15.5	7.94	12.7



CoreLine – CERAMIC turning indexable insert

DNGN

ISO	RE mm
150708TN	0.8
150712TN	1.2
150716TN	1.6

CTS3105

F

CERAMIC

DNGN

IC

74 205 ...

20200

20100

CTKX715

F

CERAMIC

DNGN

IC

74 205 ...

00100

00200

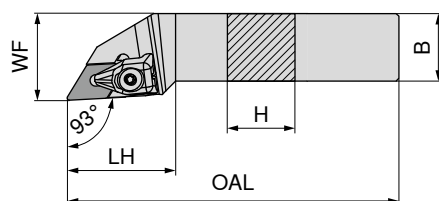
00300

P		
M		
K	●	○
N		
S		●
H	●	●
O		

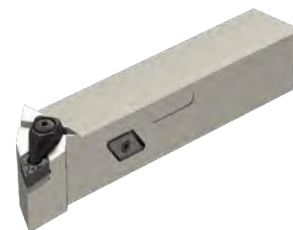
CoreLine – DDJN 93° – Tool holder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

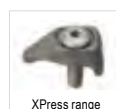


Left Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	Left TO 70 541 ...	Right TO 70 540 ...
DDJN R/L 1616 H11	16	16	100	33	20	2	DN.. 1104	816	816
DDJN R/L 2020 K11	20	20	125	33	25	2	DN.. 1104	820	820
DDJN R/L 2525 M11	25	25	150	33	32	2	DN.. 1104	825	825
DDJN R/L 2020 K15	20	20	125	40	25	4	DN.. 1504 / 1506	720	720
DDJN R/L 2525 M15	25	25	150	40	32	4	DN.. 1504 / 1506	725	725
DDJN R/L 3225 P15	32	25	170	40	32	4	DN.. 1504 / 1506	832	832



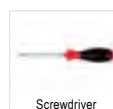
When working with DN.. 1504 indexable inserts, use insert seat with article no. **70 950 40000**.



XPress range

AS

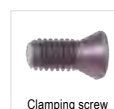
70 950 ...



Screwdriver

AS

80 950 ...



Clamping screw

AS

70 950 ...



Carbide seat D

AS

70 950 ...

Spare parts

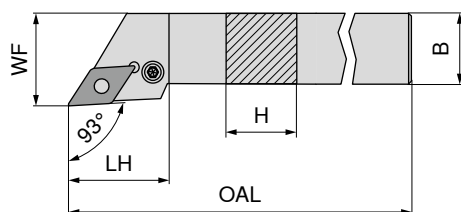
for article number

70 540 816 / 70 541 816	835	T09 - IP	118	M3x7 - 09IP	819	808
70 540 820 / 70 541 820	835	T09 - IP	118	M3x7 - 09IP	819	808
70 540 825 / 70 541 825	835	T09 - IP	118	M3x7 - 09IP	819	808
70 540 720 / 70 541 720	824	T15 - IP	120	M4,5x12 - 15IP	820	811
70 540 725 / 70 541 725	824	T15 - IP	120	M4,5x12 - 15IP	820	811
70 540 832 / 70 541 832	824	T15 - IP	120	M4,5x12 - 15IP	820	811

CoreLine – PDJN 93° – Tool holder with lever clamping

Scope of supply:

Tool holder with Allen key



Illustrations show right-hand versions



Left

Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
PDJN R/L 1616 H11	16	16	100	30.0	20	3	DN.. 1104
PDJN R/L 2020 K11	20	20	125	30.0	25	3	DN.. 1104
PDJN R/L 2525 M11	25	25	150	30.0	32	3	DN.. 1104
PDJN R/L 2020 K15	20	20	125	34.9	25	3,2	DN.. 1506
PDJN R/L 2525 M15	25	25	150	35.4	32	3,2	DN.. 1506
PDJN R/L 3225 P15	32	25	170	35.4	32	3,2	DN.. 1506
PDJN R/L 3232 P15	32	32	170	34.7	40	3,2	DN.. 1506

TO	TO
70 541 ...	70 540 ...
116	116
12000 ¹⁾	12000 ¹⁾
12500 ¹⁾	12500 ¹⁾
020	020
025	025
032	032
13200	13200

1) Nickel plated

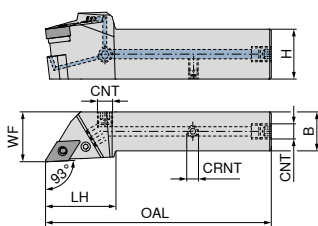
Spare parts for article number

70 540 116 / 70 541 116	SW2,5	175	122	191	121	208	120
70 540 12000 / 70 541 12000	SW2,5	175	122	191	121	208	120
70 540 12500 / 70 541 12500	SW2,5	175	122	191	121	208	120
70 540 020 / 70 541 020	SW3	176	198	192	188	388	236
70 540 025 / 70 541 025	SW3	176	198	192	188	388	236
70 540 032 / 70 541 032	SW3	176	198	192	188	388	236
70 540 13200 / 70 541 13200	SW3	176	198	192	188	388	236

CoreLine – PDJN 93° DC – Toolholder with lever clamping

Scope of supply:

Tool holder with Allen key



Illustrations show right-hand versions



Left

Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Tightening torque Nm	Indexable insert	TO 70 593 ...	TO 70 593 ...
PDJN R/L 2020 X11-T DC	20	20	104	35	25	M6	G1/8"	3	DN.. 1104	02000	02001
PDJN R/L 2525 X11-T DC	25	25	114	45	32	M6	G1/8"	3	DN.. 1104	02500	02501
PDJN R/L 2020 X15-T DC	20	20	114	45	25	M6	G1/8"	3,2	DN.. 1506	12000	12001
PDJN R/L 2525 X15-T DC	25	25	129	45	32	M6	G1/8"	3,2	DN.. 1506	12500	12501
PDJN R/L 3225 X15-T DC	32	25	145	45	32	M6	G1/8"	3,2	DN.. 1506	03200	03201
PDJN R/L 3232 X15-T DC	32	32	145	45	40	M6	G1/8"	3,2	DN.. 1506	13200	13201

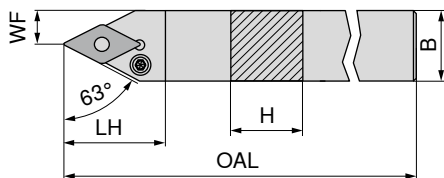
Spare parts

for article number

	Key I	Shim	Assembly pin	Coolant screw plug	Toggle lever	Clamping screw	Carbide seat D	Set Screw
	AS	AS	AS	AS	AS	AS	AS	AS
70 593 02001 / 70 593 02000	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 593 02501 / 70 593 02500	175	122	191	294	121	208	120	86700
70 593 12001 / 70 593 12000	175	122	191	294	121	208	120	86700
70 593 12501 / 70 593 12500	176	198	192	294	188	209	236	86700
70 593 03201 / 70 593 03200	176	198	192	294	188	209	236	86700
70 593 13201 / 70 593 13200	176	198	192	294	188	209	236	86700

Scope of supply:

Tool holder with Allen key



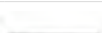
Illustrations show right-hand versions



Left

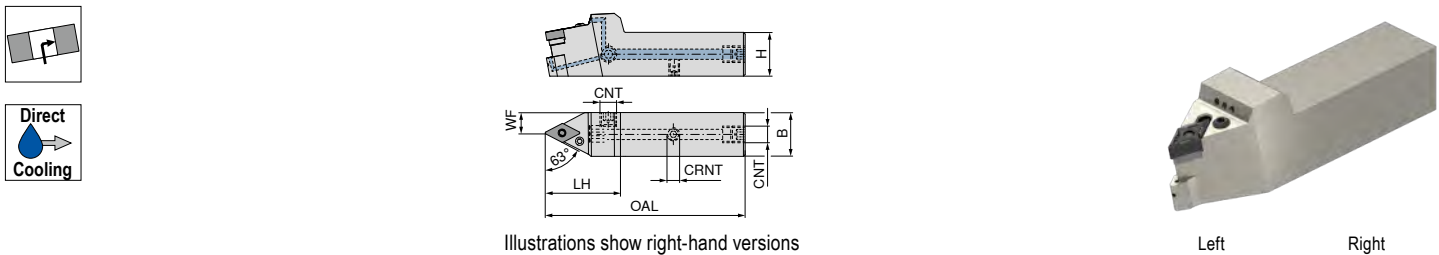
Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	TO	TO
								70 537 ...	70 536 ...
PDNN R/L 2525 M11	25	25	150	30.0	12.5	3	DN.. 1104	125	125
PDNN R/L 2525 M15	25	25	150	36.5	12.5	3.2	DN.. 1506	025	025

		 Key I	 Shim	 Assembly pin	 Toggle lever	 Clamping screw	 Carbide seat D
		AS	AS	AS	AS	AS	AS
Spare parts for article number		70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 536 125 / 70 537 125	SW2,5	175	122	191	121	208	120
70 536 025 / 70 537 025	SW3	176	198	192	188	388	236

CoreLine – PDNN 63° DC – Tool holder with lever clamping

Scope of supply:
Tool holder with Allen key



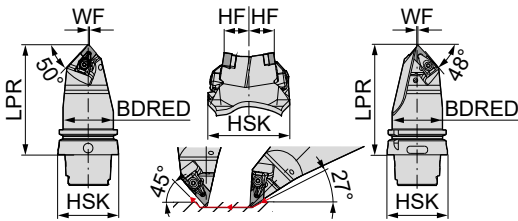
Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Tightening torque Nm	Indexable insert	Left	Right
										TO	TO
PDNN R/L 2525 X11-T DC	25	25	114	45	12.5	M6	G1/8"	3	DN.. 1104	70 594 ... 02500	70 594 ... 02501
PDNN R/L 2525 X15-T DC	25	25	119	50	12.5	M6	G1/8"	3,2	DN.. 1506	12500	12501

Spare parts for article number								
	AS	AS	AS	AS	AS	AS	AS	AS
	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 594 02501 / 70 594 02500	175	122	191	294	121	208	120	86700
70 594 12501 / 70 594 12500	176	198	192	294	188	209	236	86700

CoreLine – DCMN + DDMN – Tool holder with top clamping

Scope of supply:

Tool holder with Torx key



Neutral

Designation	Adapter	LPR mm	BDRED mm	WF mm	HF mm	Tightening torque Nm	Indexable insert
HSK T63 DCMN L 12 + DDMN L 15	HSK-T 63	115	53	0.5	20	4	CN.. 1204 / DN.. 1506

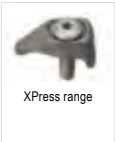
TO
74 600 ...
501



Face turning up to 78 mm

Spare parts
for article number

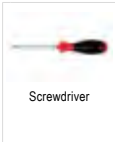
74 600 501	824	T15 - IP	120	M4,5x12 - 15IP	820	811	810
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XPress range

AS

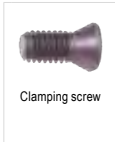
70 950 ...



Screwdriver

AS

80 950 ...



Clamping screw

AS

70 950 ...



Carbide seat D

AS

70 950 ...



Carbide seat C

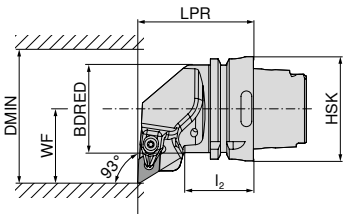
AS

70 950 ...

CoreLine – DDUN 93° – Tool holder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Designation	Adapter	LPR mm	l ₂ mm	BDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	Left	Right
									TO	TO
HSK T63 DDUN R/L 15	HSK-T 63	70	42	53	45	125	4	DN.. 1506	74 516 ...	74 515 ...
HSK T100 DDUN R/L 15	HSK-T 100	80	45	88	55	125	4	DN.. 1506	515	515
									715	715

Spare parts

for article number

74 515 515 / 74 516 515	824	T15 - IP	120	M4,5x12 - 15IP	820	811
74 515 715 / 74 516 715	824	T15 - IP	120	M4,5x12 - 15IP	820	811



XPress range

AS

70 950 ...



Screwdriver

AS

80 950 ...



Clamping screw

AS

70 950 ...



Carbide seat D

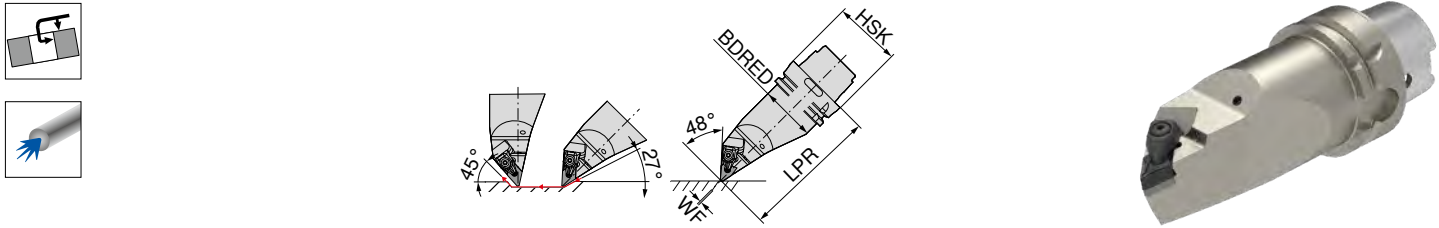
AS

70 950 ...

CoreLine – DDMN 48° – Tool holder with top clamping

Scope of supply:

Tool holder with Torx key



Designation	Adapter	LPR mm	BDRED mm	WF mm	Tightening torque Nm	Indexable insert	Left TO 74 519 ... 515 715
HSK T63 DDMN L 15	HSK-T 63	130	53	0	4	DN.. 1506	
HSK T100 DDMN L 15	HSK-T 100	160	88	0	4	DN.. 1506	

Spare parts
for article number

74 519 515	824	120	820	811
74 519 715	824	120	820	811



XPress range

AS

70 950 ...

824



Screwdriver

AS

80 950 ...

120



Clamping screw

AS

70 950 ...

820



Carbide seat D

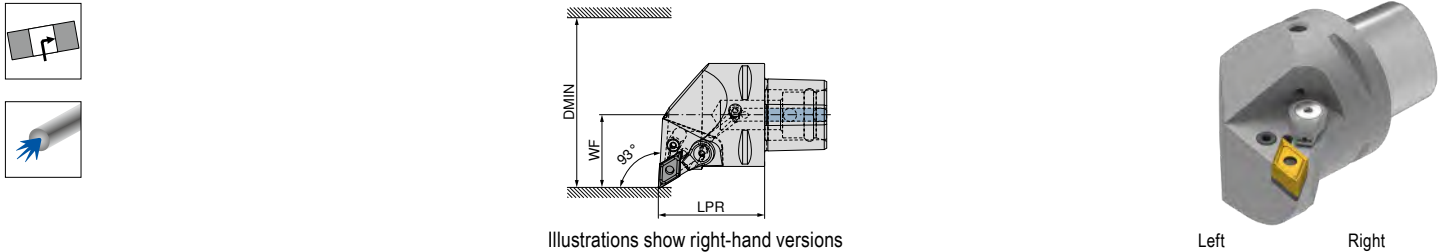
AS

70 950 ...

811

CoreLine – PDUN 93° – Tool holder with lever clamping

Scope of supply:
Without high-performance coolant set



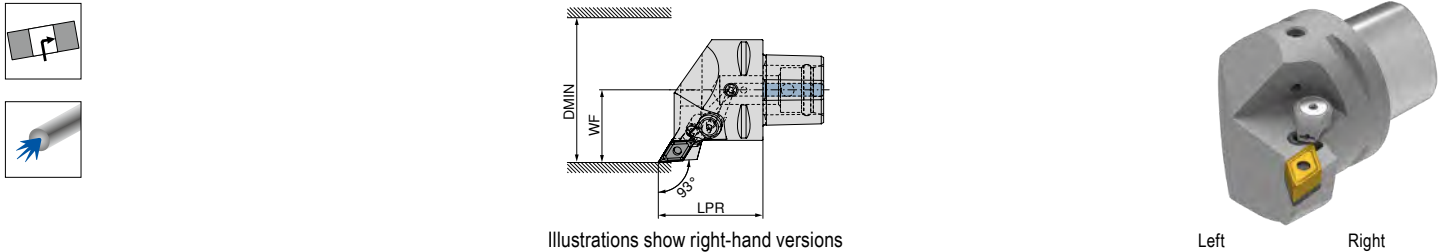
Designation	Adapter	LPR mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	Direct cooling compatible	Left TO 84 661 ...	Right TO 84 660 ...
PSC40 PDUN R/L 50050-15	PSC 40	50	27	50	5	DN.. 1504 / 1506	DC	01595	01595
PSC50 PDUN R/L 65060-15	PSC 50	60	35	65	5	DN.. 1504 / 1506	DC	01594	01594
PSC63 PDUN R/L 80065-15	PSC 63	65	45	80	5	DN.. 1504 / 1506	DC	01593	01593

Spare parts
Adapter

	Shim AS 84 950 ...		Toggle lever screw AS 84 950 ...		Toggle lever AS 84 950 ...		Carbide seat D AS 84 950 ...
PSC 40	29200	M8X1/L17 SW3	28700		28900		27900
PSC 50	29200	M8X1/L17 SW3	28700		28900		27900
PSC 63	29200	M8X1/L17 SW3	28700		28900		27900

CoreLine – PDJN 93° – Tool holder with lever clamping

Scope of supply:
Without high-performance coolant set



Designation	Adapter	LPR mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	Direct cooling compatible	Left TO 84 665 ...	Right TO 84 664 ...
PSC40 PDJN R/L 50050-15	PSC 40	50	27	50	5	DN.. 1504 / 1506	DC	01595	01595
PSC50 PDJN R/L 65060-15	PSC 50	60	35	65	5	DN.. 1504 / 1506	DC	01594	01594
PSC63 PDJN R/L 80065-15	PSC 63	65	45	80	5	DN.. 1504 / 1506	DC	01593	01593

Spare parts
Adapter

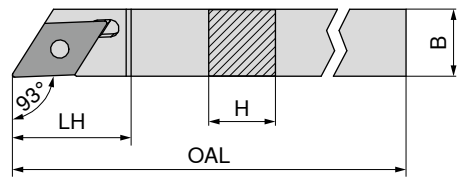
	Shim AS 84 950 ...	Toggle lever screw AS 84 950 ...	Toggle lever AS 84 950 ...	Carbide seat D AS 84 950 ...
PSC 40	29200	M8X1/L17 SW3 28700	28900	27900
PSC 50	29200	M8X1/L17 SW3 28700	28900	27900
PSC 63	29200	M8X1/L17 SW3 28700	28900	27900



The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra.

When working with DN1504.. use indexable insert shim article no. **84 950 28200**

CoreLine – SDJN 93° – Tool holder with screw clamping



Illustrations show right-hand versions



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
SDJN R/L 1012 H11	10	12	100	21.3	12	3,2	DNGU 1104
SDJN R/L 1212 H11	12	12	100	21.3	12	3,2	DNGU 1104
SDJN R/L 1616 K11	16	16	125	21.3	16	3,2	DNGU 1104
SDJN R/L 2020 K11	20	20	125	21.3	20	3,2	DNGU 1104
SDJN R/L 2525 M11	25	25	150	21.3	25	3,2	DNGU 1104

Left	Right
TO	TO
70 699 ...	70 698 ...
010	010
012	012
016	016
020	020
025	025

Spare parts

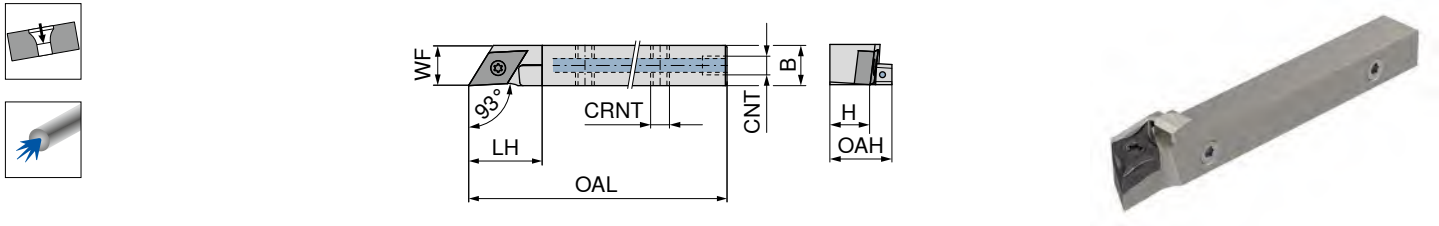
70 698 010 / 70 699 010
70 698 012 / 70 699 012
70 698 016 / 70 699 016
70 698 020 / 70 699 020
70 698 025 / 70 699 025

	
Screwdriver	Clamping screw
AS	AS
80 950 ...	72 950 ...
120	007
120	007
120	007
120	007
120	007

CoreLine – SDJN 93° – Tool holder with through coolant

▲ For sliding head lathes

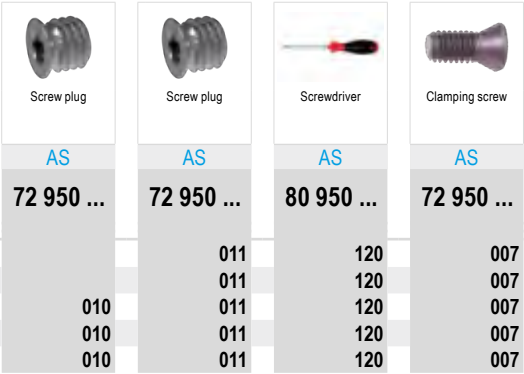
Scope of supply:
Holder without coolant connection



Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Indexable insert	Left	Right
									TO	TO
SDJN R/L 1012 H11 IC	10	12	100	22	12	M5	M5	DNGU 1104	72 359 ...	72 358 ...
SDJN R/L 1212 H11 IC	12	12	100	22	12	M5	M5	DNGU 1104	010	010
SDJN R/L 1616 K11 IC	16	16	125	22	16	M5	G1/8"	DNGU 1104	012	012
SDJN R/L 2020 K11 IC	20	20	125	22	20	M5	G1/8"	DNGU 1104	016	016
SDJN R/L 2525 K11 IC	25	25	125	22	25	M5	G1/8"	DNGU 1104	020	020
									025	025

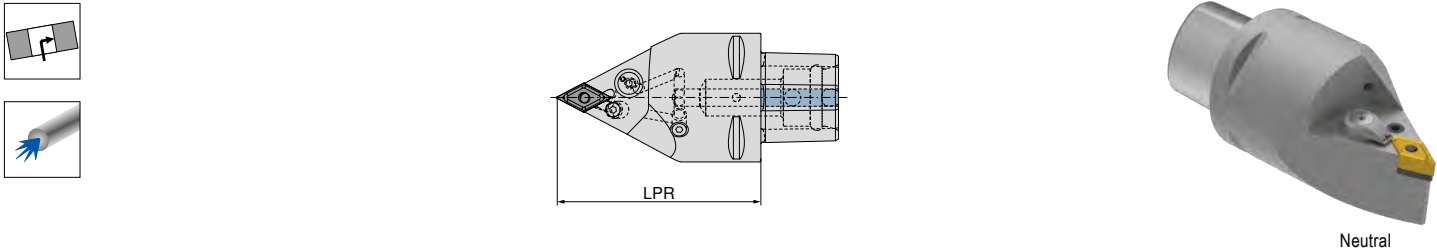
Spare parts

72 358 010 / 72 359 010	AS	72 950 ...	AS	72 950 ...	AS	80 950 ...	AS	72 950 ...
72 358 012 / 72 359 012								
72 358 016 / 72 359 016	010							
72 358 020 / 72 359 020	010							
72 358 025 / 72 359 025	010							



CoreLine – PDNN 62.5° – Tool holder with lever clamping

Scope of supply:
Without high-performance coolant set



Designation	Adapter	LPR mm	Tightening torque Nm	Indexable insert	Direct cooling compatible	TO 84 676 ...
PSC63 PDNN N 0100-15	PSC 63	100	5	DN.. 1504 / 1506	DC	01593
PSC63 PDNN N 0130-15	PSC 63	130	5	DN.. 1504 / 1506	DC	11593

Spare parts
for article number

84 676 01593	29200	28700	28900	27900
84 676 11593	29200	28700	28900	27900

			
Shim	Toggle lever screw	Toggle lever	Carbide seat D
AS	AS	AS	AS
84 950 ...	84 950 ...	84 950 ...	84 950 ...
29200	28700	28900	27900

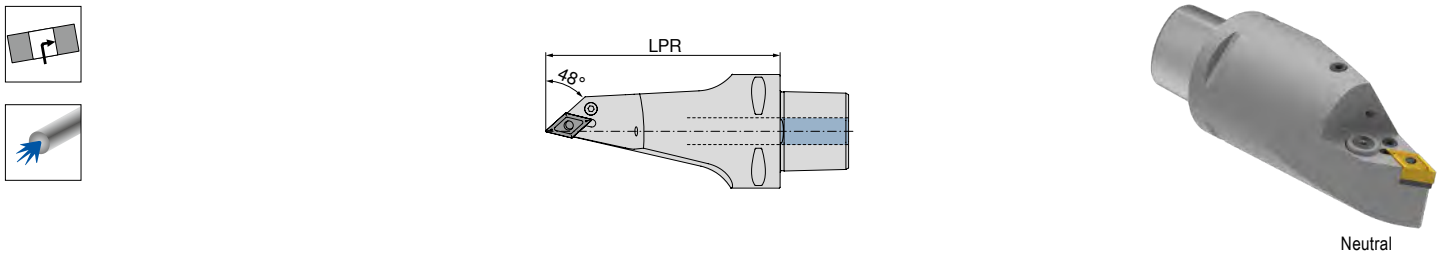


The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra.

When working with DN1504.. use indexable insert shim article no. **84 950 28200**

CoreLine – PDMN 48° – Tool holder with lever clamping

Scope of supply:
Without high-performance coolant set



Designation	Adapter	LPR mm	Tightening torque Nm	Indexable insert	Direct cooling compatible	TO 84 680 ... 11593
PSC63 PDMN L 0130-15	PSC 63	130	5	DN.. 1504 / 1506	DC	

Spare parts
for article number

84 680 11593

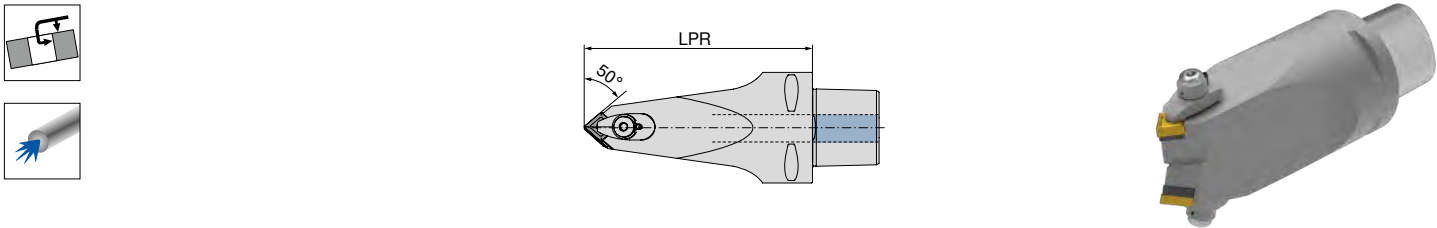
			
Shim	Toggle lever screw	Toggle lever	Carbide seat D
AS	AS	AS	AS
84 950 ...	84 950 ...	84 950 ...	84 950 ...
29200	28700	28900	27900



The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra.

When working with DN1504.. use indexable insert shim article no. **84 950 28200**

CoreLine – DCMN + DDMN 50°/48° – Tool holder with top clamping



Designation	Adapter	LPR mm	Tightening torque Nm	Indexable insert
PSC63 DCMN-DDMN L 0130-12/15	PSC 63	130	10	CN.. 1204 / DN.. 1506

Neutral
TO
84 683 ...
01293

Spare parts
for article number

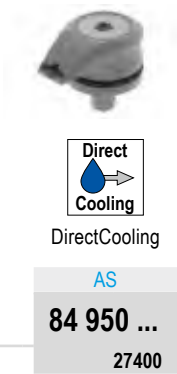
84 683 01293

 Clamping screw	 Clamping claw	 Ring-shaped nozzle	 Clamping screw	 Carbide seat D	 Carbide seat C
AS	AS	AS	AS	AS	AS
84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...
28300	28500	28400	27500	27900	27800

High-performance coolant set

- ▲ Using the DC kit blocks the other lubricant outlet so that all of the pressure is concentrated by the kit!
- ▲ Can be used up to 100 bar

Scope of supply:
Direct cooling nozzle and O ring



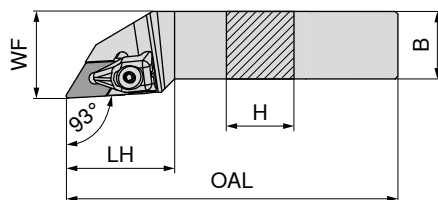
Coolant set

CoreLine – DDJN 93° – Toolholder with top clamping

- ▲ ...A-N = with thru coolant
▲ ...N = without thru coolant

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left

Right

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO 78 503 ...	TO 78 502 ...
DDJN R/L 12-4BA-N	0.750	0.750	4.500	1.535	1.000	DN..43..	01294	01294
DDJN R/L 12-4B-N	0.750	0.750	4.500	1.535	1.000	DN..43..	01293	01293
DDJN R/L 16-4D-N	1.000	1.000	6.000	1.535	1.250	DN..43..	01689	01689
DDJN R/L 16-4DA-N	1.000	1.000	6.000	1.535	1.250	DN..43..	01692	01692
DDJN R/L 20-4D-N	1.250	1.250	6.000	1.535	1.500	DN..43..	02089	02089
DDJN R/L 20-4DA-N	1.250	1.250	6.000	1.535	1.500	DN..43..	02092	02092
DDJN R/L 24-4E-N	1.500	1.500	7.000	1.535	2.000	DN..43..	02486 ¹⁾	02486 ¹⁾
DDJN R/L 24-4EA-N	1.500	1.500	7.000	1.535	2.000	DN..43..	02488 ¹⁾	02488 ¹⁾

1) Not in stock

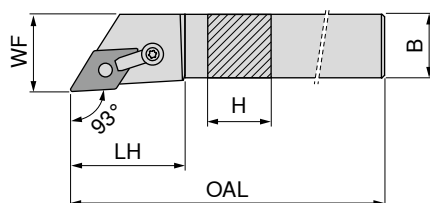
Spare parts for article number

	Clamping claw AS 78 950 ...	Key I AS 78 950 ...	Clamping screw AS 78 950 ...	Carbide seat D AS 78 950 ...	Threaded bush AS 78 950 ...	Spring AS 78 950 ...
78 502 01294 / 78 503 01294	07600	08100	08300	06700	08500	04900
78 502 01293 / 78 503 01293	07600	08100	08300	06700	08500	04900
78 502 01689 / 78 503 01689	07600	08100	08300	06700	08500	04900
78 502 01692 / 78 503 01692	07600	08100	08300	06700	08500	04900
78 502 02089 / 78 503 02089	07600	08100	08300	06700	08500	04900
78 502 02092 / 78 503 02092	07600	08100	08300	06700	08500	04900
78 502 02486 / 78 503 02486	07600	08100	08300	06700	08500	04900
78 502 02488 / 78 503 02488	07600	08100	08300	06700	08500	04900

CoreLine – MDJN 93° – Toolholder with top clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left

Right

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO 78 527 ...	TO 78 526 ...
MDJN R/L 08-3A	0.500	0.500	4.000	1.060	0.625	DN..33..	00813 ¹⁾	00813 ¹⁾
MDJN R/L 10-3B	0.625	0.625	4.500	1.250	0.875	DN..33..	01023 ¹⁾	01023 ¹⁾
MDJN R/L 12-4B	0.750	0.750	4.500	1.500	1.000	DN..43..	01224 ¹⁾	01224 ¹⁾
MDJN R/L 16-4D	1.000	1.000	6.000	1.500	1.250	DN..43..	01644 ¹⁾	01644 ¹⁾
MDJN R/L 20-4D	1.250	1.250	6.000	1.500	1.500	DN..43..	02044 ¹⁾	02044 ¹⁾
MDJN R/L 85-4D	1.250	1.000	6.000	1.500	1.250	DN..43..	08544 ¹⁾	08544 ¹⁾
MDJN R/L 24-4D	1.500	1.500	6.000	1.500	2.000	DN..43..	02444 ¹⁾	02444 ¹⁾

¹⁾ Not in stock

Spare parts

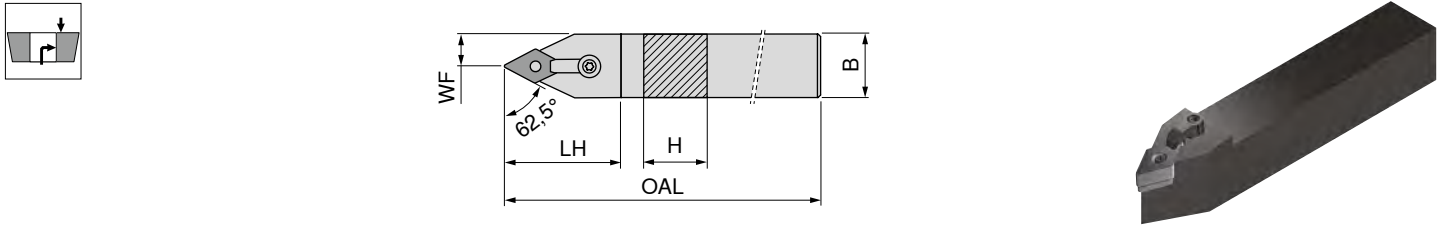
for article number

	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 526 00813 / 78 527 00813	00700	06800		03600	
78 526 01023 / 78 527 01023	00700	06800		03600	
78 526 01224 / 78 527 01224	00400	06900	03100	03800	04200
78 526 01644 / 78 527 01644	00400	06900	03100	03800	04200
78 526 02044 / 78 527 02044	00400	06900	03100	03800	04200
78 526 08544 / 78 527 08544	00400	06900	03100	03800	04200
78 526 02444 / 78 527 02444	00400	06900	03100	03800	04200

Clamp	Key I	Dowel	Clamping screw	Carbide seat D
AS	AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...

CoreLine – MDPN 62.5° – Toolholder with top clamping

Scope of supply:
Tool holder with allen key



ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert
MDPN N 12-4B	0.750	0.750	4.500	1.620	0.375	DN..43..
MDPN N 16-4D	1.000	1.000	6.000	1.620	0.500	DN..43..
MDPN N 20-4D	1.250	1.250	6.000	1.620	0.625	DN..43..

Neutral
TO
78 576 ...
01224 ¹⁾
01644 ¹⁾
02044 ¹⁾

1) Not in stock

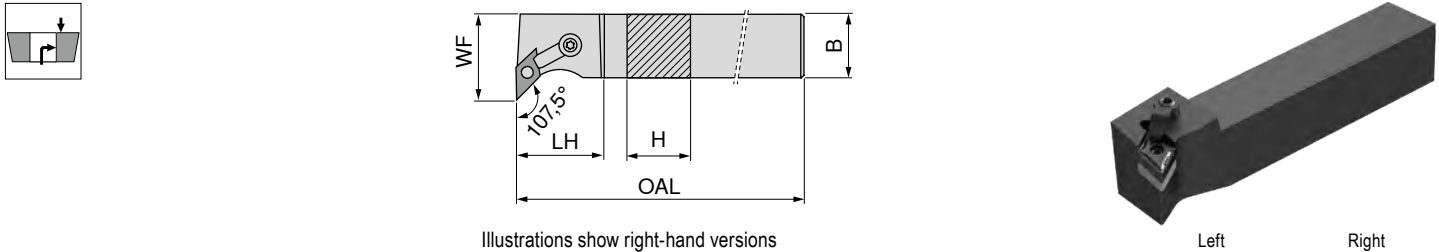
Spare parts
for article number

	AS	AS	AS	AS	AS
78 576 01224	09000	06900	03100	03800	04200
78 576 01644	09000	06900	03100	03800	04200
78 576 02044	09000	06900	03100	03800	04200

				
Clamp	Key I	Dowel	Clamping screw	Carbide seat D
AS	AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...

CoreLine – MDQN 107.5° – Toolholder with top clamping

Scope of supply:
Tool holder with allen key



ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	Left	Right
							TO 78 529 ...	TO 78 528 ...
MDQN R/L 12-4B	0.750	0.750	4.500	1.370	1.000	DN..43..	01293 ¹⁾	01293 ¹⁾
MDQN R/L 16-4D	1.000	1.000	6.000	1.370	1.250	DN..43..	01689 ¹⁾	01689 ¹⁾
MDQN R/L 20-4D	1.250	1.250	6.000	1.370	1.500	DN..43..	02089 ¹⁾	02089 ¹⁾
MDQN R/L 24-4E	1.500	1.500	7.000	1.370	2.000	DN..43..	02486 ¹⁾	02486 ¹⁾

1) Not in stock

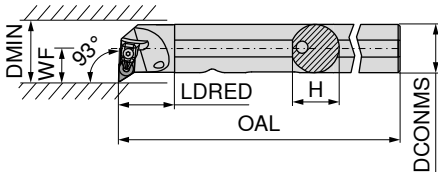
Spare parts
for article number

	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 528 01293 / 78 529 01293	00400	06900	03100	03800	04200
78 528 01689 / 78 529 01689	00400	06900	03100	03800	04200
78 528 02089 / 78 529 02089	00400	06900	03100	03800	04200
78 528 02486 / 78 529 02486	00400	06900	03100	03800	04200

				
Clamp	Key I	Dowel	Clamping screw	Carbide seat D
AS	AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...

CoreLine – DDUN 93° – Boring bar with top clamping

Scope of supply:
Boring bar with Torx key



Illustrations show right-hand versions

Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert
A25R DDUN R/L 11	25	24	200	30	17	32	2	DN.. 1104
A32S DDUN R/L 11	32	31	250	40	22	40	2	DN.. 1104
A40T DDUN R/L 15	40	39	300	45	27	50	4	DN.. 1506

Left	Right
TO	TO
70 569 ...	70 568 ...
725	725
732	732
840	840

Spare parts
for article number

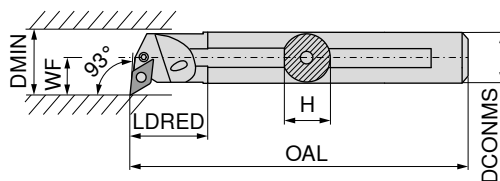
	XPress range	Screwdriver	Clamping screw	Carbide seat D
	AS	AS	AS	AS
	70 950 ...	80 950 ...	70 950 ...	70 950 ...
70 568 725 / 70 569 725	835	T09 - IP 118	M3x7 - 09IP 819	808
70 568 732 / 70 569 732	835	T09 - IP 118	M3x7 - 09IP 819	808
70 568 840 / 70 569 840	824	T15 - IP 120	M4,5x12 - 15IP 820	811

CoreLine – PDUN 93° – Boring bar with lever clamping

- ▲ A... = with coolant hole
 ▲ S... = without coolant hole

Scope of supply:

Boring bar with Allen key



Illustrations show right-hand versions



Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	Left	Right
									TO 70 569 ...	TO 70 568 ...
A20Q PDUN R/L 11	20	18.5	180	36	16.0	28	3	DN.. 1104	12000 ¹⁾	12000 ¹⁾
A25R PDUN R/L 11	25	23.0	200	36	18.5	32	3	DN.. 1104	125	12500 ¹⁾
A32S PDUN R/L 11	32	30.0	250	36	22.0	40	3	DN.. 1104	13200 ¹⁾	132
A32S PDUN R/L 15	32	30.0	250	50	22.0	40	3,2	DN.. 1506	232	232
A40T PDUN R/L 15	40	38.0	300	60	27.0	50	3,2	DN.. 1506	240	240
S50W PDUN R/L 15	50	47.0	450	31	35.0	63	3,2	DN.. 1506	050	050

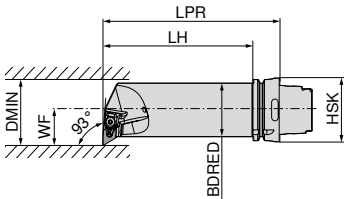
1) Nickel plated

Spare parts for article number

		Key I	Shim	Assembly pin	Toggle lever	Clamping screw	Carbide seat D
		AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 568 12000 / 70 569 12000	SW2,5	175			125	126	
70 568 12500 / 70 569 125	SW2,5	175	122	191	121	208	120
70 568 132 / 70 569 13200	SW2,5	175	122	191	121	208	120
70 568 232 / 70 569 232	SW3	176	198	192	188	209	236
70 568 240 / 70 569 240	SW3	176	198	192	188	209	236
70 568 050 / 70 569 050	SW3	176	198	192	188	388	236

CoreLine – DDUN 93° – Boring bar with top clamping

Scope of supply:
Boring bar with Torx key



Illustrations show right-hand versions



Designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	Left TO 74 533 ... 515	Right TO 74 532 ... 515
HSK T63 50Q DDUN R/L 15	HSK-T 63	175	149	50	35	63	4	DN.. 1506		

Spare parts
for article number

74 532 515 / 74 533 515



XPress range

AS

70 950 ...

824



Screwdriver

AS

80 950 ...

120



Clamping screw

AS

70 950 ...

820



Carbide seat D

AS

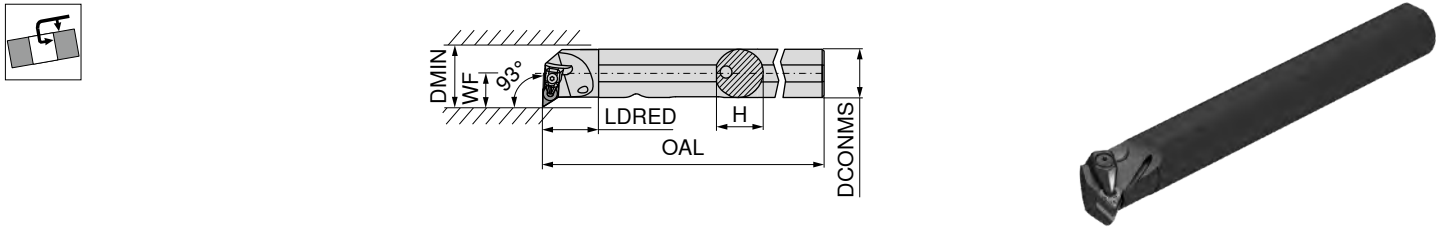
70 950 ...

811

CoreLine – DDUN 93° – Boring bar with top clamping

- ▲ A... = with thru coolant
- ▲ S... = without thru coolant

Scope of supply:
Tool holder with allen key



Illustrations show right-hand versions

ANSI designation	DCONMS inch	H inch	OAL inch	LDRED inch	WF inch	DMIN inch	Indexable insert	Left	Right
								TO 78 703 ...	TO 78 702 ...
S20U DDUN R/L 4N	1.250	1.118	14.000	1.771	0.765	1.530	DN..43..	42030 ¹⁾	42030 ¹⁾
S24U DDUN R/L 4N	1.500	1.370	14.000	1.968	0.890	1.780	DN..43..	42434 ¹⁾	42434 ¹⁾

1) Not in stock

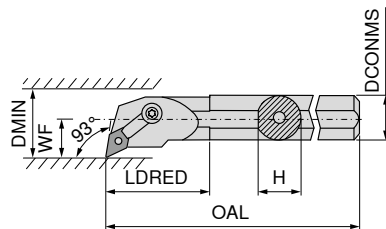
Spare parts for article number						
	Clamping claw	Key I	Clamping screw	Carbide seat D	Threaded bush	Spring
	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 702 42030 / 78 703 42030	07600	08100	08300	04200	08500	04900
78 702 42434 / 78 703 42434	07600	08100	08300	04200	08500	04900

CoreLine – MDUL 93° – Boring bar with top clamping

- ▲ A... = with thru coolant
▲ S... = without thru coolant

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left

Right

ANSI designation	DCONMS inch	H inch	OAL inch	LDRED inch	WF inch	DMIN inch	Indexable insert	TO 78 707 ...	TO 78 706 ...
S16T MDUN R/L 4	1.000	0.900	12.000	2.500	0.875	1.750	DN..43..	41626 ¹⁾	41626 ¹⁾
A16T MDUN R/L 4	1.000	0.900	12.000	2.500	0.875	1.750	DN..43..	41616	41616
S20U MDUN R/L 4	1.250	1.118	14.000	3.000	1.000	2.000	DN..43..	42030 ¹⁾	42030 ¹⁾
A20U MDUN R/L 4	1.250	1.118	14.000	3.000	1.000	2.000	DN..43..	42020 ¹⁾	42020 ¹⁾
S24U MDUN R/L 4	1.500	1.370	14.000	3.000	1.125	2.250	DN..43..	42434 ¹⁾	42434 ¹⁾
A24U MDUN R/L 4	1.500	1.370	14.000	3.000	1.125	2.250	DN..43..	42424	42424
S32V MDUN R/L 4	2.000	1.870	16.000	4.000	1.375	3.000	DN..43..	43242 ¹⁾	43242 ¹⁾
A32V MDUN R/L 4	2.000	1.870	16.000	4.000	1.375	3.000	DN..43..	43233 ¹⁾	43233 ¹⁾

1) Not in stock

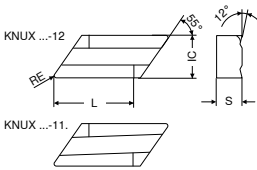
Spare parts for article number

	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 706 41626 / 78 707 41626	00400	06900	03000	03700	
78 706 41616 / 78 707 41616	00400	06900	03000	03700	
78 706 42030 / 78 707 42030	00400	06900	03100	03800	04200
78 706 42020 / 78 707 42020	00400	06900	03100	03800	04200
78 706 42434 / 78 707 42434	00400	06900	03100	03800	04200
78 706 42424 / 78 707 42424	00400	06900	03100	03800	04200
78 706 43242 / 78 707 43242	00400	06900	03100	03800	04200
78 706 43233 / 78 707 43233	00400	06900	03100	03800	04200

Clamp	Key I	Dowel	Clamping screw	Carbide seat D
AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...

KNUX

Designation	L	S	IC
	mm	mm	mm
KNUX 1604..	16	4.76	9.52



CoreLine – Carbide turning indexable insert

KNUX

-11

CTCK110-P

DRAGONSKIN

M

KNUX

-11

CTCK120-P

DRAGONSKIN

M

KNUX

ISO	RE		
	mm		
160405EL	0.5		
160405ER	0.5		
P			
M			
K			
N			
S			
H			
O			

TR

70 240 ...

10201

10001

TR

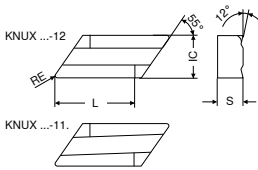
70 240 ...

55201

50001

KNUX

Designation	L	S	IC
	mm	mm	mm
KNUX 1604..	16	4.76	9.52



CoreLine – Carbide turning indexable insert

KNUX

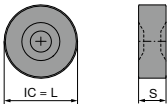
-11 CTCP125-P	-11 CTCP135-P	-12 CTCP135-P
DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
F KNUX	F KNUX	M KNUX
TR 76 240 ... 50001 50401	TR 76 240 ... 70201 70001	TR 76 242 ... 70001

ISO	RE mm
160405EL	0.5
160405ER	0.5
160410ER	1.0

P			
M			
K			
N			
S			
H			
O			

RNGX-C

Designation	L	S	IC
	mm	mm	mm
RNGX 1204..	12.7	4.76	12.7



CoreLine – PcBN turning indexable insert

RNGX-C

ISO

120400TN

P		
M		
K		●
N		
S		○
H		○
O		○

CTBK102

F

CBN

RNGX-C

PC

71 467 ...

30002

CTBK103

F

CBN

RNGX-C

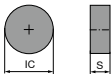
PC

71 471 ...

40002

RNGN

Designation	S	IC
	mm	mm
RNGN 0604..	4.76	6.35
RNGN 0903..	3.18	9.52
RNGN 0904..	4.76	9.52
RNGN 1204..	12.7	12.70
RNGN 1207..	7.94	12.70
RNGN 1507..	15.8	15.80
RNGN 1907..	7.94	19.00
RNGN 2507..	7.94	25.40
RNGN 2507..	25.4	25.40



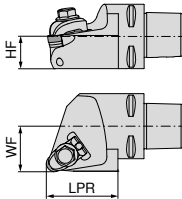
CoreLine – CERAMIC turning indexable insert

RNGN

		CTN3110	CTSH110	CTS3105	CTKX715
		M	M	M	M
		CERAMIC	CERAMIC	CERAMIC	CERAMIC
		RNGN	RNGN	RNGN	RNGN
		IC	IC	IC	IC
		74 202 ...	74 202 ...	74 202 ...	74 202 ...
ISO					
060400TN				20100	
090300TN					00100
090400TN				20200	
120400PN		40100			
120700PN			10100	20300	
120700SN					00200
120700TN				20400	00300
150700PN		40200			
190700PN			10200	20600	
190700TN					00400
250700PN		40300	10300		00500
P					
M					
K					○
N					
S					●
H					●
O					●

CoreLine – DRGN 90° – Tool holder with sold carbide claw – C-Clamp







Left

Right

Designation	Adapter	LPR mm	WF mm	HF mm	Indexable insert
PSC50 DRGN R/L 35075-12-C204	PSC 50	75	35	25	RNGX 12..

TO

74 091 ...
25100

TO

74 091 ...
25101

Spare parts
for article number

74 091 25101 / 74 091 25100



Clamping screw

AS

70 950 ...

M6x13 - 20IP

89700



Carbide shim

AS

70 950 ...

T3

89300



Carbide clamping claw

AS

70 950 ...

88400

Spare parts
for article number

74 091 25101 / 74 091 25100



Clamping screw

AS

70 950 ...

M8 - 20 Nm

89200



Screwdriver

AS

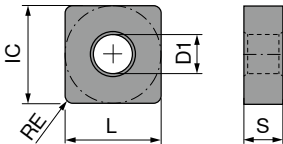
80 950 ...

T20 - IP

121

SNMG / SNMA / SNMM

Designation	L	S	D1	IC
	mm	mm	mm	mm
SNM. 1204..	12.70	4.76	5.16	12.70
SNM. 1506..	15.87	6.35	6.35	15.87
SNM. 1906..	19.05	6.35	7.94	19.05
SNMM 2507..	25.40	7.94	9.12	25.40
SNM. 2509..	25.40	9.52	9.12	25.40
SNMM 3109..	31.75	9.52	9.12	31.75



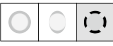
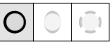
CoreLine – Carbide turning indexable insert

SNMG

		<div><div>-F50</div><div>CTCK110-P</div></div>	<div><div>-F50</div><div>CTCP115-P</div></div>	<div><div>-F50</div><div>CTCP125-P</div></div>	<div><div>-F50</div><div>CTCP135-P</div></div>	<div><div>-M50</div><div>CTCK110-P</div></div>	<div><div>-M50</div><div>CTCK120-P</div></div>	<div><div>-M50</div><div>CTCP115-P</div></div>
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F	F	F	F	M	M	M
		SNMG	SNMG	SNMG	SNMG	SNMG	SNMG	SNMG
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	70 319 ...	76 140 ...	76 140 ...	76 140 ...	70 323 ...	70 323 ...	76 137 ...
090308EN	0.8		30601	50601	70601			
120404EN	0.4	11601	31601	51601	71601			
120408EN	0.8	11801	31801	51801	71801	11801	51801	31801
120412EN	1.2	12001	32001	52001	72001	12001	52001	32001
120416EN	1.6							32201
150608EN	0.8							33001
150612EN	1.2							33201
150616EN	1.6							33401
P		○	●	●	●	○	○	●
M					○			
K		●	○	○	○	●	●	○
N								
S								
H								
O								

CoreLine – Carbide turning indexable insert

SNMG

		<div><div><div><div><div>-M50</div><div>CTCP125-P</div></div><div>DRAGONSkin</div><div></div><div><div>M</div><div>SNMG</div></div></div><div><div><div>-M50</div><div>CTCP135-P</div></div><div>DRAGONSkin</div><div></div><div><div>M</div><div>SNMG</div></div></div><div><div><div>-M70</div><div>CTCK110-P</div></div><div>DRAGONSkin</div><div></div><div><div>M</div><div>SNMG</div></div></div><div><div><div>-M70</div><div>CTCK120-P</div></div><div>DRAGONSkin</div><div></div><div><div>M</div><div>SNMG</div></div></div><div><div><div>-M70</div><div>CTCP115-P</div></div><div>DRAGONSkin</div><div></div><div><div>M</div><div>SNMG</div></div></div><div><div><div>-M70</div><div>CTCP125-P</div></div><div>DRAGONSkin</div><div></div><div><div>M</div><div>SNMG</div></div></div><div><div><div>-M70</div><div>CTCP135-P</div></div><div>DRAGONSkin</div><div></div><div><div>M</div><div>SNMG</div></div></div></div></div>						
		<div><div>TR</div><div>76 137 ...</div></div> <div><div>TR</div><div>76 137 ...</div></div> <div><div>TR</div><div>70 225 ...</div></div> <div><div>TR</div><div>70 225 ...</div></div> <div><div>TR</div><div>76 225 ...</div></div> <div><div>TR</div><div>76 225 ...</div></div> <div><div>TR</div><div>76 225 ...</div></div>						
ISO	RE mm	51801	71801	11801	51801	31801	51801	71801
120408EN	0.8	52001	72001	12001	52001	32001	52001	72001
120412EN	1.2	52201	72201	12201	52201	32201	52201	72201
120416EN	1.6							
150608EN	0.8	53001	73001					
150612EN	1.2	53201	73201	13201	53201	33201	53201	73201
150616EN	1.6	53401	73401	13401	53401	33401	53401	73401
190612EN	1.2			14401	54401	34401	54401	74401
190616EN	1.6			14601	54601	34601	54601	74601
190624EN	2.4					34801	54801	74801
P		●	●	○	○	●	●	●
M			○					○
K		○		●	●	○	○	
N								
S								
H								
O								

CoreLine – Carbide turning indexable insert

SNMG / SNMA / SNMM

		<div><div>-M70</div><div>CTCP125-P</div></div>	<div><div></div><div>CTCK110-P</div></div>	<div><div></div><div>CTCK120-P</div></div>	<div><div>-R28</div><div>CTCP115-P</div></div>	<div><div>-R28</div><div>CTCP125-P</div></div>	<div><div>-R28</div><div>CTCP135-P</div></div>	<div><div>-R58</div><div>CTCP115-P</div></div>
		<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>
		<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>
		<div></div>	<div></div>	<div></div>	<div></div>	<div></div>	<div></div>	<div></div>
		<div>R</div>	<div>R</div>	<div>R</div>	<div>R</div>	<div>R</div>	<div>R</div>	<div>R</div>
		SNMG	SNMA	SNMA	SNMM	SNMM	SNMM	SNMM
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	76 188 ...	70 114 ...	70 114 ...	76 128 ...	76 128 ...	76 128 ...	76 129 ...
120408EN	0.8		11801	51801				31801
120412EN	1.2		12001	52001				32001
120416EN	1.6		12201	52201				
150612EN	1.2				33201	53201	73201	33201
150616EN	1.6				33401	53401	73401	33401
190612EN	1.2		14401	54401				34401
190616EN	1.6		14601	54601	34601	54601	74601	34601
190624EN	2.4							34801
250724EN	2.4						76001	36001
250924EN	2.4	57001			37001	57001	77001	37001
P		●	○	○	●	●	●	●
M							○	
K		○	●	●	○	○		○
N								
S								
H								
O								

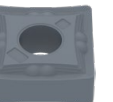
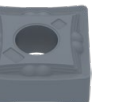
CoreLine – Carbide turning indexable insert

SNMM

		<div><div>-R58</div><div>CTCP125-P</div></div>	<div><div>-R58</div><div>CTCP135-P</div></div>	<div><div>-R88</div><div>CTCP115-P</div></div>	<div><div>-R88</div><div>CTCP115-P</div></div>	<div><div>-R88</div><div>CTCP125-P</div></div>	<div><div>-R88</div><div>CTCP125-P</div></div>	<div><div>-R88</div><div>CTCP135-P</div></div>
		<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>
		<div><div><div></div><div></div><div></div></div></div>	<div><div><div></div><div></div><div></div></div></div>	<div><div><div></div><div></div><div></div></div></div>	<div><div><div></div><div></div><div></div></div></div>	<div><div><div></div><div></div><div></div></div></div>	<div><div><div></div><div></div><div></div></div></div>	<div><div><div></div><div></div><div></div></div></div>
		<div><div><div></div></div></div>	<div><div><div></div></div></div>	<div><div><div></div></div></div>	<div><div><div></div></div></div>	<div><div><div></div></div></div>	<div><div><div></div></div></div>	<div><div><div></div></div></div>
		<div>R</div>	<div>R</div>	<div>R</div>	<div>R</div>	<div>R</div>	<div>R</div>	<div>R</div>
		<div>SNMM</div>	<div>SNMM</div>	<div>SNMM</div>	<div>SNMM</div>	<div>SNMM</div>	<div>SNMM</div>	<div>SNMM</div>
		<div>TR</div>	<div>TR</div>	<div>TR</div>	<div>TR</div>	<div>TR</div>	<div>TR</div>	<div>TR</div>
ISO	RE mm	76 129 ...	76 129 ...	76 130 ...	76 325 ...	76 130 ...	76 326 ...	76 130 ...
120408EN	0.8	51801	71801					
	3.2					58201		
120412EN	1.2	52001	72001					
150612EN	1.2	53201	73201					
150616EN	1.6	53401	73401					
190612EN	1.2	54401	74401					
190616EN	1.6	54601	74601					
190616SN	1.6			34601		54601		74601
190624EN	2.4	54801	74801					
190624SN	2.4			34801		54801		74801
250724EN	2.4	56001	76001					
250724SN	2.4			36001		56001		76001
250732SN	3.2				36101			
250924EN	2.4	57001	77001					
250924SN	2.4			37001		57001		77001
250932SN	3.2				37201		57201	
310932SN	3.2			38201				
P		●	●	●	●	●	●	●
M			○					○
K		○		○	○	○	○	
N								
S								
H								
O								

CoreLine – Carbide turning indexable insert

SNMM / SNMG

		<div><div>-R88</div><div>CTCP135-P</div></div>	<div><div>-F30</div><div>CTCM120</div></div>	<div><div>-F30</div><div>CTPM125</div></div>	<div><div>-F30</div><div>CTCM130</div></div>	<div><div>-M30</div><div>CTCM120</div></div>	<div><div>-M30</div><div>CTPM125</div></div>	<div><div>-M30</div><div>CTPM125</div></div>
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		R	F	F	F	M	M	M
		SNMM	SNMG	SNMG	SNMG	SNMG	SNMG	SNMG
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	76 327 ...	75 016 ...	75 016 ...	75 016 ...	75 017 ...	75 017 ...	75 016 ...
120404EN	0.4		11600	216	31600			
120408EN	0.8		11800	218	31800	11800	218	
120412EN	1.2					12000		220
250732SN	3.2	76101						
250932SN	3.2	77201						
P		●	○	○	○	○	○	○
M		○	●	●	●	●	●	●
K								
N								
S					○			
H								
O								

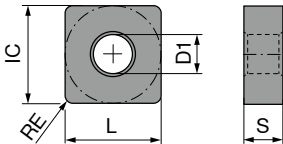
CoreLine – Carbide turning indexable insert

SNMG

		<div><div>-M30</div><div>CTCM130</div></div>	<div><div>-M42</div><div>CTCM130</div></div>	<div><div>-M60</div><div>CTCM120</div></div>	<div><div>-M60</div><div>CTPM125</div></div>	<div><div>-M60</div><div>CTCM130</div></div>	<div><div>-M70</div><div>CTCM130</div></div>	<div><div>-M34</div><div>CTPX710</div></div>
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		M	M	M	M	M	M	M
		SNMG	SNMG	SNMG	SNMG	SNMG	SNMG	SNMG
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	75 017 ...	75 034 ...	75 018 ...	75 018 ...	75 018 ...	75 039 ...	75 005 ...
120408EN	0.8	31800	31800	11800	218	31800	31800	61800
120412EN	1.2	32000	32000	12000	210	32000	32000	62000
120416EN	1.6			12200	220	32200		
190616EN	1.6						34600	
P		○	○	○	○	○	○	●
M		●	●	●	●	●	●	●
K								
N								○
S		○	○			○	○	●
H								
O								

SNMG

Designation	L	S	D1	IC
	mm	mm	mm	mm
SNMG 0903..	9.52	3.18	3.81	9.52
-	12.70	4.76	5.16	12.70
SNMG 1204..	12.70	4.76	5.16	12.70



CoreLine – Carbide turning indexable insert

SNMG

ISO	RE mm
	0.8
120408EN	0.8
090308EN	0.8

CTCP125

DRAGONSKIN



M
SNMG

TR

76 116 ...
50601

CTCP135-P

DRAGONSKIN



M
SNMG

TR

76 116 ...
70601

-M52
CTP2120



M
SNMG

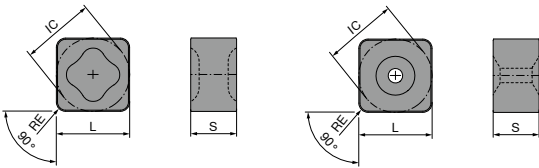
TR

70 129 ...
608

P	●	●
M		○
K	○	
N		
S		
H		
O		

SNGX-C / SNGA / SNNX / SNGX

Designation	L	S	D1	IC
	mm	mm	mm	mm
SNGA 1204..	12.7	4.76	5.16	12.7
SNGX 1204..	12.7	4.76	-	12.7
SN.X 1207..	12.7	7.94	-	12.7



CoreLine – PcBN turning indexable insert

SNGX-C

CTBK102

F

CBN

SNGX-C

PC

71 468 ...

30002

CTBK103

F

CBN

SNGX-C

PC

71 472 ...

40002

ISO	RE mm
120412TN	1.2

P	
M	
K	● ●
N	
S	○ ○
H	○ ○
O	

CoreLine – CERAMIC turning indexable insert

SNGX-C

CTM3105





F

CERAMIC

SNGX-C

IC

71 461 ...

20002

20102

ISO	RE mm
120712TN	1.2
120716TN	1.6

P

M

K

N

S

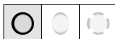
H

O

CoreLine – CERAMIC turning indexable insert

SNGA / SNNX / SNGX

CTN3105





F

CERAMIC

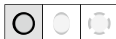
SNGA

IC

71 455 ...

90001

CTN3105





F

CERAMIC

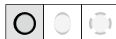
SNNX

IC

71 457 ...

90001

CTN3105





F

CERAMIC

SNGX

IC

71 456 ...

90101

CTI3105





F

CERAMIC

SNNX

IC

71 449 ...

80001

P

M

K

N

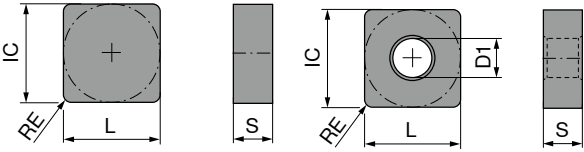
S

H

O

SNGN / SNGA

Designation	L	S	D1	IC
	mm	mm	mm	mm
SNGA 1204..	12.70	4.76	5.16	12.70
SNGA 1906..	19.05	6.35	5.16	19.05
SNGN 1207..	12.70	7.94	-	12.70
SNGN 1907..	19.00	7.94	-	19.00
SNGN 2507..	25.40	7.94	-	25.40
SNGN 2509..	25.40	9.52	-	25.40



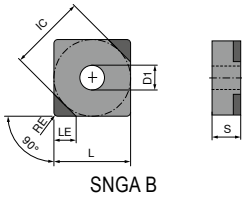
CoreLine – CERAMIC turning indexable insert

SNGN / SNGA

		CTS3105	CTM3110	CTN3110	CTSH110	CTX715	CTM3110	CTSH110
		F	F	F	F	F	F	F
		CERAMIC SNGN	CERAMIC SNGN	CERAMIC SNGN	CERAMIC SNGN	CERAMIC SNGN	CERAMIC SNGA	CERAMIC SNGA
		IC	IC	IC	IC	IC	IC	IC
ISO	RE mm	74 200 ...	74 200 ...	74 200 ...	74 200 ...	74 200 ...	74 201 ...	74 201 ...
120408SN	0.8						30100	
120704TN	0.4	20100						
120708TN	0.8					00100		
120716PN	1.6			40300	10100	00200		
120716TN	1.6							
190616PN	1.6							10100
190716PN	1.6			40400	10200			
250724PN	2.4	20200		40500	10300	00500		
250924PN	2.4		30100	40600	10400			
250924SN	2.4			40700				
P								
M								
K		•	•	•	•	○	•	•
N								
S						•		
H		•			•	•		•
O								

SNGA

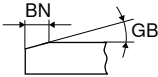
Designation	L	S	D1	IC
	mm	mm	mm	mm
SNGA 1204..	12.7	4.76	5.16	12.7



CoreLine – PcBN turning indexable insert

SNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners



CTBH1000C	CTBH2000C	CTBH3000C
F	F	F
PCBN	PCBN	PCBN
SNGA	SNGA	SNGA
PC	PC	PC
71 039 ...	71 039 ...	71 039 ...
70002	80002	90002
70302	80302	90302

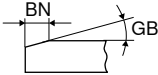
ISO	RE	BN	GB	TCE (NOI)	LE
	mm	mm			mm
120408EN	0.8			B (2)	3.8
120408SN	0.8	0.14	20°	B (2)	3.8
120412EN	1.2			B (2)	3.8
120412SN	1.2	0.14	20°	B (2)	3.8

P			
M			
K			
N			
S			
H			
O			

CoreLine – PcBN turning indexable insert

SNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners



CTBH1000C	CTBH2000C	CTBH3000C
M	M	M
PCBN	PCBN	PCBN
SNGA	SNGA	SNGA
PC	PC	PC
71 039 ...	71 039 ...	71 039 ...
70102	80102	90102
70402	80402	90402

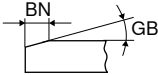
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
120408SN	0.8	0.09	15°	B (2)	3.8
120408SN	0.8	0.18	25°	B (2)	3.8
120412SN	1.2	0.09	15°	B (2)	3.8
120412SN	1.2	0.18	25°	B (2)	3.8

P			
M			
K			
N			
S			
H			
O			

CoreLine – PcBN turning indexable insert

SNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners



CTBH1000C	CTBH2000C	CTBH3000C
R	R	R
PCBN	PCBN	PCBN
SNGA	SNGA	SNGA
PC	PC	PC
71 039 ...	71 039 ...	71 039 ...
70202	80202	90202
70502	80502	90502

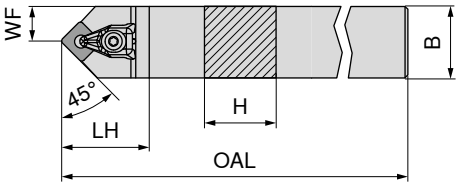
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
120408SN	0.8	0.14	20°	B (2)	3.8
120408SN	0.8	0.20	35°	B (2)	3.8
120412SN	1.2	0.14	20°	B (2)	3.8
120412SN	1.2	0.20	35°	B (2)	3.8

P			
M			
K			
N			
S			
H			
O			

CoreLine – DSDN 45° – Tool holder with top clamping

Scope of supply:

Tool holder with Torx key



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	Neutral TO 70 516 ... 620 625
DSDN N 2020 K12	20	20	125	38	10.3	4	SN.. 1204	
DSDN N 2525 M12	25	25	150	38	12.5	4	SN.. 1204	

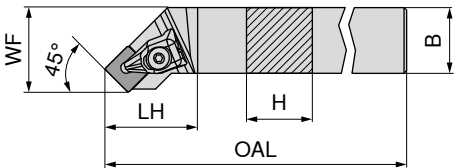
Spare parts
for article number

			
XPress range	Screwdriver	Clamping screw	Carbide seat S
AS	AS	AS	AS
70 950 ...	80 950 ...	70 950 ...	70 950 ...
824	T15 - IP	820	813
824	T15 - IP	820	813

CoreLine – DSSN 45° – Tool holder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

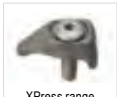


Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
DSSN R/L 2020 K12	20	20	125	35	25	4	SN.. 1204
DSSN R/L 2525 M12	25	25	150	35	32	4	SN.. 1204
DSSN R/L 3225 P12	32	25	170	35	32	4	SN.. 1204

Left	Right
TO	TO
70 513 ...	70 512 ...
620	620
625	625
632	632

Spare parts
for article number

	AS		AS		AS		AS
70 512 620 / 70 513 620	824	T15 - IP	120	M4,5x12 - 15IP	820		813
70 512 625 / 70 513 625	824	T15 - IP	120	M4,5x12 - 15IP	820		813
70 512 632 / 70 513 632	824	T15 - IP	120	M4,5x12 - 15IP	820		813



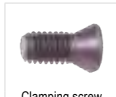
XPress range

AS
70 950 ...



Screwdriver

AS
80 950 ...



Clamping screw

AS
70 950 ...



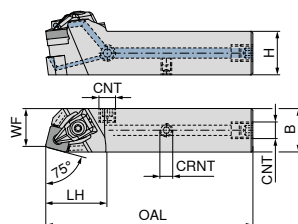
Carbide seat S

AS
70 950 ...

CoreLine – DSBN 75° DC – tool holder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	TO 70 522 ...
DSBN R 2020 X12 DC	20	20	104	35	17.2	4	SN.. 1204	62001
DSBN R 2525 X12 DC	25	25	119	35	22.2	4	SN.. 1204	62501
DSBN R 2525 X15 DC	25	25	127	33	22.3	6,5	SN.. 1506	72501
DSBN R 3232 X15 DC	32	32	142	42	26.1	6,5	SN.. 1506	73201
DSBN R 3232 X19 DC	32	32	148	48	27.3	6,5	SN.. 1906	83201
DSBN R 4040 X19 DC	40	40	173	48	35.3	6,5	SN.. 1906	84001

Spare parts for article number

	Clamping screw	Carbide seat S	Set Screw
70 522 62001	M4,5x12 - 15IP 820	813	M6x6 86700
70 522 62501	M4,5x12 - 15IP 820	813	M6x6 86700
70 522 72501	M5x14 - 20IP 821	833	M6x6 86700
70 522 73201	M5x14 - 20IP 821	833	M6x6 86700
70 522 83201	M5x14 - 20IP 821	817	M6x6 86700
70 522 84001	M5x14 - 20IP 821	817	M6x6 86700

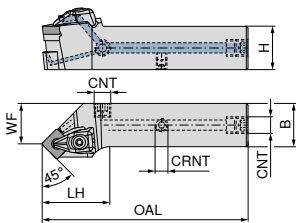
Spare parts for article number

	XPress range	Screwdriver	Coolant screw plug
70 522 62001	824	T15 - IP 120	G 1/8" 294
70 522 62501	824	T15 - IP 120	G 1/8" 294
70 522 72501	825	T20 - IP 121	G 1/8" 294
70 522 73201	825	T20 - IP 121	G 1/8" 294
70 522 83201	826	T20 - IP 121	G 1/8" 294
70 522 84001	826	T20 - IP 121	G 1/8" 294

CoreLine – DSSN 45° DC – tool holder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Left Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
DSSN R/L 2020 X12 DC	20	20	104	35	16.7	4	SN.. 1204
DSSN R/L 2525 X12 DC	25	25	119	35	24.2	4	SN.. 1204
DSSN R/L 3225 X12 DC	32	25	135	35	24.2	4	SN.. 1204

TO	TO
70 517 ...	70 517 ...
62000	62001
62500	62501
63200	63201

Spare parts
for article number

70 517 62001 / 70 517 62000	M4,5x12 - 15IP	820	813	M6x6	86700
70 517 62501 / 70 517 62500	M4,5x12 - 15IP	820	813	M6x6	86700
70 517 63201 / 70 517 63200	M4,5x12 - 15IP	820	813	M6x6	86700



Clamping screw

AS

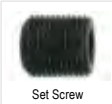
70 950 ...



Carbide seat S

AS

70 950 ...



Set Screw

AS

70 950 ...

Spare parts
for article number

70 517 62001 / 70 517 62000	824	T15 - IP	120	G 1/8"	294
70 517 62501 / 70 517 62500	824	T15 - IP	120	G 1/8"	294
70 517 63201 / 70 517 63200	824	T15 - IP	120	G 1/8"	294



XPress range

AS

70 950 ...



Screwdriver

AS

80 950 ...



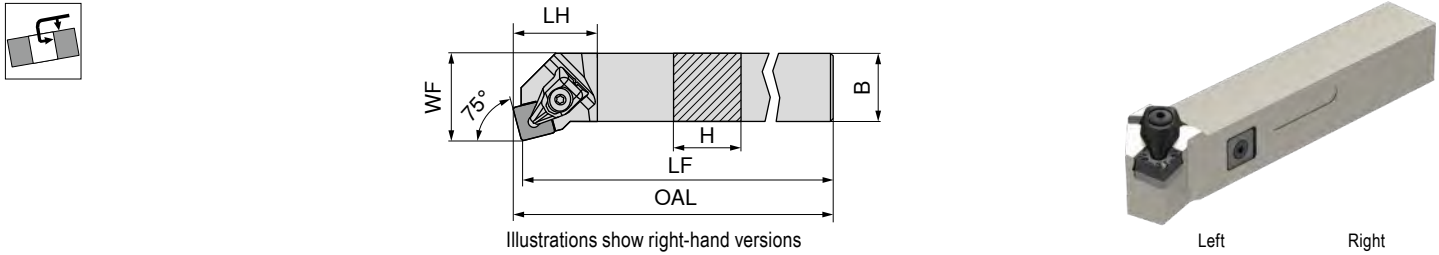
Coolant screw plug

AS

70 950 ...

CoreLine – DSKN 75° – Tool holder with top clamping

Scope of supply:
Tool holder with Torx key

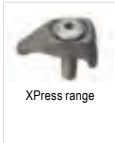
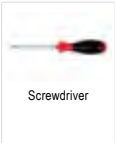
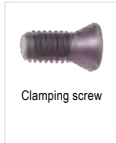


Designation	H mm	B mm	OAL mm	LF mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
DSKN R/L 2525 M12	25	25	153.3	150	28	32	4	SN.. 1204

Left	Right
TO	TO
70 525 ...	70 524 ...
625	625

Spare parts
for article number

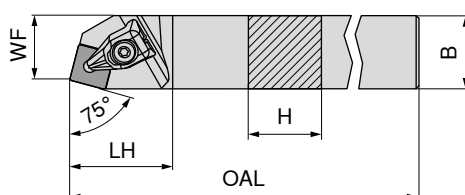
70 524 625 / 70 525 625

			
AS	AS	AS	AS
70 950 ...	80 950 ...	70 950 ...	70 950 ...
824	120	820	813

CoreLine – DSBN 75° – Tool holder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
DSBN R 2020 K12	20	20	125	35	17	4	SN.. 1204
DSBN R 2525 M12	25	25	150	35	22	4	SN.. 1204
DSBN R 2525 M15	25	25	150	42	22	6,5	SN.. 1506
DSBN R 3232 P15	32	32	170	42	27	6,5	SN.. 1506
DSBN R 3232 P19	32	32	170	48	27	6,5	SN.. 1906
DSBN R 4040 S19	40	40	250	48	35	6,5	SN.. 1906
DSBN R 4040 S25	40	40	250	57	35	6,5	SN.. 2507 / SN.. 2509

TO

70 520 ...

620

625

725

832

732

840

940



When working with SN.. 2509 use indexable insert shim article no. **70 950 40100**.

Spare parts for article number

	AS 70 950 ...		AS 80 950 ...		AS 70 950 ...	AS 70 950 ...
70 520 620	824	T15 - IP	120	M4,5x12 - 15IP	820	813
70 520 625	824	T15 - IP	120	M4,5x12 - 15IP	820	813
70 520 725	825	T20 - IP	121	M5x14 - 20IP	821	833
70 520 832	825	T20 - IP	121	M5x14 - 20IP	821	833
70 520 732	826	T20 - IP	121	M5x14 - 20IP	821	817
70 520 840	826	T20 - IP	121	M5x14 - 20IP	821	817
70 520 940	827	T25 - IP	122	M6x16 - 25IP	822	818



XPress range



Screwdriver



Clamping screw

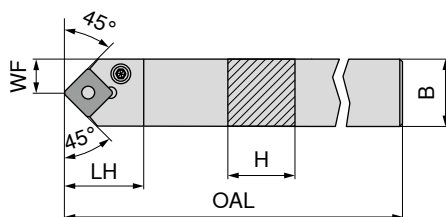


Carbide seat S

CoreLine – PSDN 45° – Tool holder with lever clamping

Scope of supply:

Tool holder with Allen key



Neutral

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
PSDN N 2020 K12	20	20	125	27.6	10.3	4	SNM. 1204
PSDN N 2525 M12	25	25	150	27.6	12.8	4	SNM. 1204
PSDN N 3225 P19	32	25	170	40.4	12.5	8	SNM. 1906
PSDN N 4040 S25	40	40	250	48.8	20.0	8	SNM. 2507 / 2509

TO

70 516 ...

020

025

03200

04000



When working with SN.. 2509 use indexable insert shim article no. **70 950 40200**.



Key I



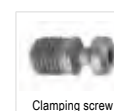
Shim



Assembly pin



Toggle lever



Clamping screw



Carbide seat S

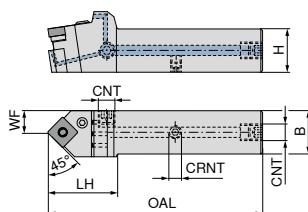
Spare parts for article number

		AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 516 020	SW3	176	198	192	187	209	230
70 516 025	SW3	176	198	192	187	209	230
70 516 03200	SW4	396	392	395	386	389	383
70 516 04000	SW5	265	621	623	620	622	27600

CoreLine – PSDN 45° DC – Tool holder with lever clamping

Scope of supply:

Tool holder with Allen key



Neutral

Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Tightening torque Nm	Indexable insert	TO 70 596 ...
PSDN N 2020 X12-T DC	20	20	109	40	11.5	M6	G1/8"	4	SNM. 1204	02000
PSDN N 2525 X12-T DC	25	25	124	40	13.3	M6	G1/8"	4	SNM. 1204	02500
PSDN N 2525 X15-T DC	25	25	134	50	13.7	M6	G1/8"	4	SNM. 1506	12500
PSDN N 3225 X15-T DC	32	25	150	50	13.7	M6	G1/8"	4	SNM. 1506	03200
PSDN N 3225 X19-T DC	32	25	152	52	13.7	M6	G1/8"	8	SNM. 1906	13200
PSDN N 4040 X25-T DC	40	40	190	65	22.4	M6	G1/8"	8	SNM. 2507 / 2509	04000



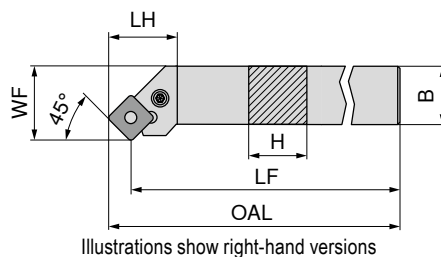
When working with SN.. 2509 use indexable insert shim article no. **70 950 40200**.

	Key I	Shim	Assembly pin	Coolant screw plug	Toggle lever	Clamping screw	Carbide seat S	Set Screw
	AS	AS	AS	AS	AS	AS	AS	AS
Spare parts for article number	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 596 02000	176	198	192	294	187	209	230	86700
70 596 02500	176	198	192	294	187	209	230	86700
70 596 12500	176	391	394	294	385	388	382	86700
70 596 03200	176	391	394	294	385	388	382	86700
70 596 13200	396	392	395	294	386	389	383	86700
70 596 04000	265	621	623	294	620	622	27600	86700

CoreLine – PSSN 45° – Tool holder with lever clamping

Scope of supply:

Tool holder with Allen key



Left

Right

Designation	H mm	B mm	OAL mm	LF mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
PSSN R/L 1616 H09	16	16	106.7	100	23.6	20	3	SNM. 0903
PSSN R/L 2020 K12	20	20	134.0	125	27.3	25	4	SNM. 1204
PSSN R/L 2525 M12	25	25	159.0	150	29.3	32	4	SNM. 1204
PSSN R/L 3225 P12	32	25	179.0	170	29.3	32	4	SNM. 1204
PSSN R 2525 M15	25	25	161.2	150	32.5	32	4	SNM. 1506
PSSN R 3232 P15	32	32	181.2	170	38.9	40	4	SNM. 1506
PSSN R 3232 P19	32	32	183.5	170	41.2	40	8	SNM. 1906
PSSN L 3232 P19	32	32	183.5	170	40.2	40	8	SNM. 1906
PSSN R 4040 S25	40	40	268.0	250	50.8	50	8	SNM. 2507 / 2509

TO	TO
70 513 ...	70 512 ...
016	01600 ¹⁾
020	020
025	025
032	032
	125
	132
	232
232	
	04000

1) Nickel plated



When working with SN.. 2509 use indexable insert shim article no. **70 950 40200**.

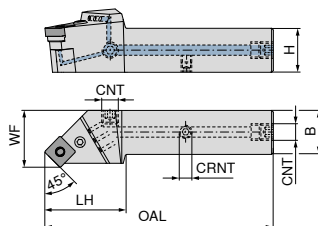
Spare parts for article number

		Key I	Shim	Assembly pin	Toggle lever	Clamping screw	Carbide seat S
		AS	AS	AS	AS	AS	AS
		70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 512 01600 / 70 513 016	SW2,5	175	197	191	185	208	229
70 512 020 / 70 513 020	SW3	176	198	192	187	209	230
70 512 025 / 70 513 025	SW3	176	198	192	187	209	230
70 512 032 / 70 513 032	SW3	176	198	192	187	209	230
70 512 125	SW3	176	391	394	385	388	382
70 512 132	SW3	176	391	394	385	388	382
70 512 232	SW4	396	392	395	386	389	383
70 513 232	SW4	396	392	395	386	389	383
70 512 04000	SW5	265	621	623	620	622	27600

CoreLine – PSSN 45° DC – Tool holder with lever clamping

Scope of supply:

Tool holder with Allen key



Illustrations show right-hand versions



Left

Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Tightening torque Nm	Indexable insert
PSSN R/L 2020 X12-T DC	20	20	111.9	42.9	25	M6	G1/8"	4	SNM. 1204
PSSN R/L 2525 X12-T DC	25	25	129.9	45.9	32	M6	G1/8"	4	SNM. 1204
PSSN R/L 3225 X12-T DC	32	25	145.9	45.9	32	M6	G1/8"	4	SNM. 1204
PSSN R 2525 X15-T DC	25	25	131.5	47.5	32	M6	G1/8"	4	SNM. 1506
PSSN R 3232 X15-T DC	32	32	145.9	45.9	40	M6	G1/8"	4	SNM. 1506
PSSN R/L 3232 X19-T DC	32	32	151.8	51.8	40	M6	G1/8"	8	SNM. 1906
PSSN R 4040 X25-T DC	40	40	189.6	64.6	50	M6	G1/8"	8	SNM. 2507 / 2509

TO	TO
70 597 ...	70 597 ...
02000	02001
02500	02501
03200	03201
	12501
	13201
13200	23201
	04001



When working with SN.. 2509 use indexable insert shim article no. **70 950 40200**.

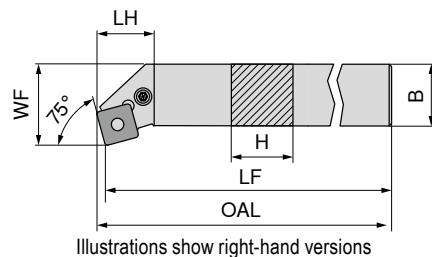
Spare parts for article number

	Key I	Shim	Assembly pin	Coolant screw plug	Toggle lever	Clamping screw	Carbide seat S	Set Screw
	AS	AS	AS	AS	AS	AS	AS	AS
	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 597 02001 / 70 597 02000	176	198	192	294	187	209	230	86700
70 597 02501 / 70 597 02500	176	198	192	294	187	209	230	86700
70 597 03201 / 70 597 03200	176	198	192	294	187	209	230	86700
70 597 12501	176	391	394	294	385	388	382	86700
70 597 13201	176	391	394	294	385	388	382	86700
70 597 23201 / 70 597 13200	396	392	395	294	386	389	383	86700
70 597 04001	265	621	623	294	620	622	27600	86700

CoreLine – PSKN 75° – Tool holder with lever clamping

Scope of supply:

Tool holder with Allen key



Left

Right

Designation	H mm	LF mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
PSKN R/L 1616 H09	16	100	16	102.5	18.7	20	3	SNM. 0903
PSKN R/L 2020 K12	20	125	20	128.3	24.1	25	4	SNM. 1204
PSKN R/L 2525 M12	25	150	25	153.3	24.1	32	4	SNM. 1204
PSKN R/L 3225 P12	32	170	25	173.1	24.1	32	4	SNM. 1204
PSKN R 4040 S19	40	250	40	254.6	38.3	50	8	SNM. 1906

TO	TO
70 525 ...	70 524 ...
016	016
020	020
025	025
03200	03200
	04000

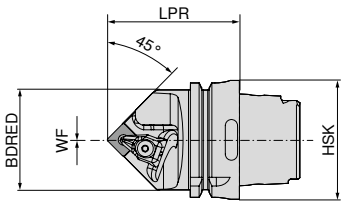
Spare parts for article number

70 524 016 / 70 525 016	SW2,5	175	197	191	185	208	229
70 524 020 / 70 525 020	SW3	176	198	192	187	209	230
70 524 025 / 70 525 025	SW3	176	198	192	187	209	230
70 524 03200 / 70 525 03200	SW3	176	198	192	187	209	230
70 524 04000	SW4	396	392	395	386	389	383

CoreLine – DSDN 45° – Tool holder with top clamping

Scope of supply:

Tool holder with Torx key



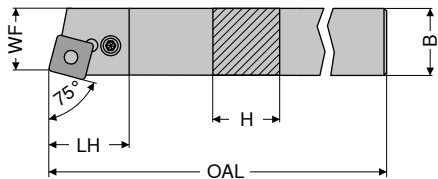
Neutral

Designation	Adapter	LPR mm	BDRED mm	WF mm	Tightening torque Nm	Indexable insert	TO
HSK T63 DSDN N 12	HSK-T 63	70	53	0	4	SN.. 1204	74 522 ...
HSK T100 DSDN N 12	HSK-T 100	80	88	0	4	SN.. 1204	512
							712

Spare parts
for article number

AS	AS	AS	AS
XPress range	Screwdriver	Clamping screw	Carbide seat S
70 950 ...	80 950 ...	70 950 ...	70 950 ...
74 522 512	824	T15 - IP	120
74 522 712	824	T15 - IP	120
		M4,5x12 - 15IP	820
		M4,5x12 - 15IP	820
			813
			813

CoreLine – PSBN 75° – Tool holder with lever clamping



Illustrations show right-hand versions



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	Left	Right
								TO 70 521 ... 232 14000	TO 70 520 ... 232 14000
PSBN R/L 3232 P19	32	32	170	39.2	27	8	SNM. 1906		
PSBN R/L 4040 S25	40	40	250	48.0	35	8	SNM. 2507 / 2509		

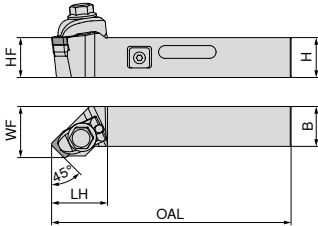
Spare parts
for article number

		Key I	Shim	Assembly pin	Toggle lever	Clamping screw	Carbide seat S
		AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 520 232 / 70 521 232	SW4	396	392	395	386	389	383
70 520 14000 / 70 521 14000	SW5	265	621	623	620	622	27600

CoreLine – DSSN 45° – Tool holder with top clamping – C-Clamp

Scope of supply:
Tool holder **without** claw







Designation	H mm	B mm	OAL mm	LH mm	WF mm	HF mm	Indexable insert
DSSN R/L 2525 M12-C207	25	25	150	35	32	25	SN.X 12..

Left

TO

74 091 ...

25000

Right

TO

74 091 ...

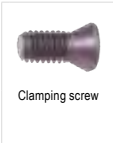
25001

Spare parts
for article number

74 091 25001 / 74 091 25000

M6x13 - 20IP

X7



Clamping screw

AS

70 950 ...

89700



Carbide shim

AS

70 950 ...

88500



Carbide clamping claw

AS

70 950 ...

88400

Spare parts
for article number

74 091 25001 / 74 091 25000

M8 - 20 Nm

T20 - IP

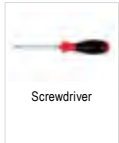


Clamping screw

AS

70 950 ...

89200



Screwdriver

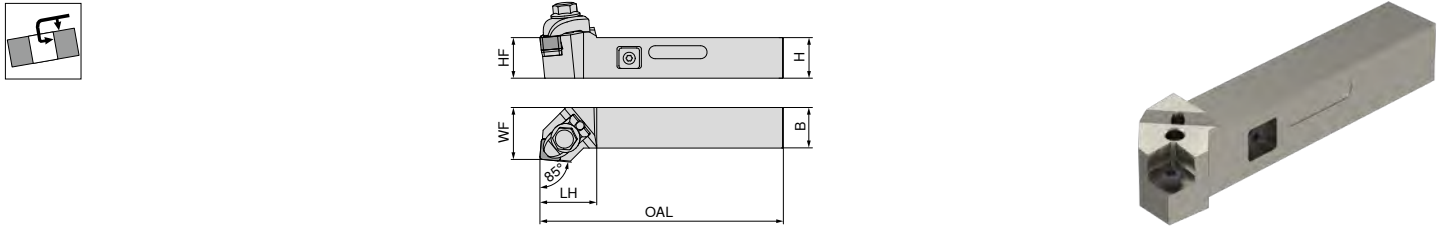
AS

80 950 ...

121

CoreLine – DSXN 85° – Tool holder with top clamping – C-Clamp

Scope of supply:
Tool holder **without** claw



Designation	H mm	B mm	OAL mm	LH mm	WF mm	HF mm	Indexable insert		
								Left	Right
DSXN R/L 2525 M12-C207	25	25	150	35	32	25	SN.X 12..	<div>TO</div> <div>74 092 ...</div> <div>25000</div>	<div>TO</div> <div>74 092 ...</div> <div>25001</div>

Spare parts
for article number

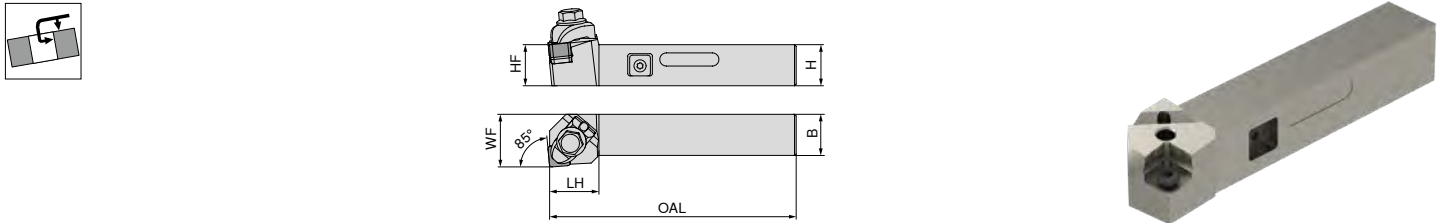
74 092 25001 / 74 092 25000	M6x13 - 20IP	<div>Clamping screw</div> <div>AS</div> <div>70 950 ...</div> <div>89700</div>	X7	<div>Carbide shim</div> <div>AS</div> <div>70 950 ...</div> <div>88500</div>	<div>Carbide clamping claw</div> <div>AS</div> <div>70 950 ...</div> <div>88400</div>
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Spare parts
for article number

74 092 25001 / 74 092 25000	M8 - 20 Nm	<div>Clamping screw</div> <div>AS</div> <div>70 950 ...</div> <div>89200</div>	T20 - IP	<div>Screwdriver</div> <div>AS</div> <div>80 950 ...</div> <div>121</div>
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CoreLine – DSYN 85° – Tool holder with top clamping – C-Clamp

Scope of supply:
Tool holder **without** claw



Designation	H mm	B mm	OAL mm	LH mm	WF mm	HF mm	Indexable insert
DSYN R/L 2525 M12-C207	25	25	150	36	32	25	SN.X 12..

Left	Right
TO	TO
74 093 ...	74 093 ...
25000	25001

Spare parts
for article number

74 093 25001 / 74 093 25000

M6x13 - 20IP



Clamping screw

AS

70 950 ...

89700

X7



Carbide shim

AS

70 950 ...

88500



Carbide clamping claw

AS

70 950 ...

88400

Spare parts
for article number

74 093 25001 / 74 093 25000

M8 - 20 Nm



Clamping screw

AS

70 950 ...

89200

T20 - IP



Screwdriver

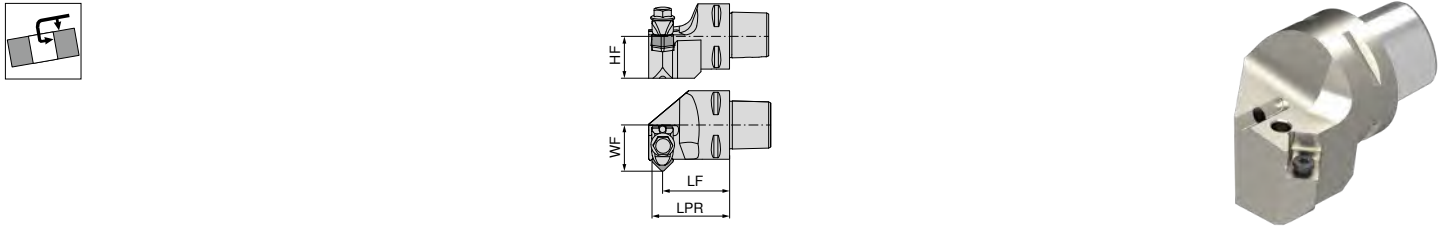
AS

80 950 ...

121

CoreLine – DSSN 45° – Tool holder with top clamping – C-Clamp

Scope of supply:
Tool holder **without** claw



Neutral

Designation	Adapter	LPR mm	WF mm	HF mm	Indexable insert	TO 74 092 ... 32002
PSC50 DSSN N 35050-12-C207	PSC 50	60	35	32	SN.X 12..	

Spare parts
for article number

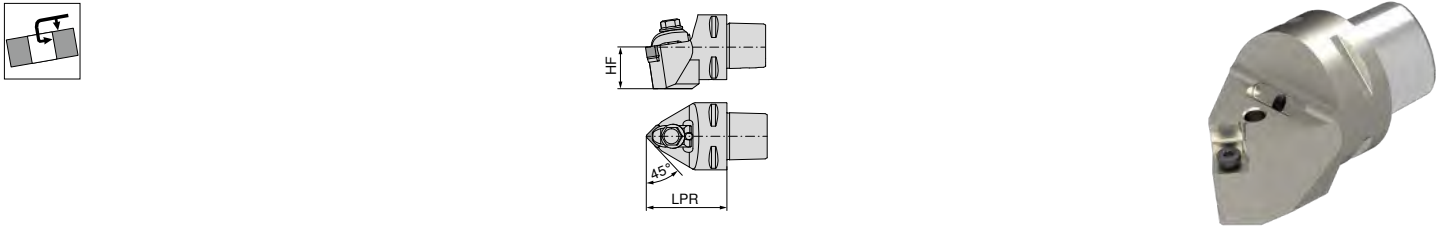
74 092 32002	M6x13 - 20IP	89700	X7	88500	88400
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Spare parts
for article number

74 092 32002	M8 - 20 Nm	89200	T20 - IP	121
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CoreLine – DSDN 45° – Tool holder with top clamping – C-Clamp

Scope of supply:
Tool holder **without** claw



Neutral

Designation	Adapter	LPR mm	WF mm	HF mm	Indexable insert	TO 74 092 ... 32502	
PSC50 DSDN N 00060-12-C207	PSC 50	60	0	32.5	SN.X 12..		

for article number

74 092 32502

M6x13 - 20IP



Clamping screw

AS

70 950 ...

89700

X7



Carbide shim

AS

70 950 ...

88500



Carbide clamping claw

AS

70 950 ...

88400

for article number

74 092 32502

M8 - 20 Nm



Clamping screw

AS

70 950 ...

89200

T20 - IP



Screwdriver

AS

80 950 ...

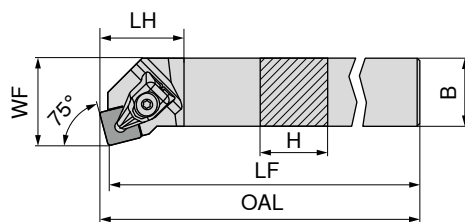
121

CoreLine – DSRN 75° – Toolholder with top clamping

- ▲ ...A-N = with thru coolant
 ▲ ...N = without thru coolant

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left

Right

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO 78 505 ...	TO 78 504 ...
DSRN R/L 16-4DA-N	1.000	1.000	6.000	1.380	1.130	SN..43..	01690 ¹⁾	01690 ¹⁾
DSRN R/L 12-4BA-N	0.750	0.750	4.500	1.380	0.880	SN..43..	01294 ¹⁾	01294 ¹⁾
DSRN R/L 20-5DA-N	1.250	1.250	6.000	1.380	1.353	SN..54..	02085 ¹⁾	02085 ¹⁾
DSRN R/L 20-6DA-N	1.250	1.250	6.000	1.380	1.321	SN..64..	02081 ¹⁾	02081 ¹⁾

1) Not in stock

Clamping claw	Key I	Clamping screw	Carbide seat S	Threaded bush	Spring
AS	AS	AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...
78 504 01690 / 78 505 01690	07600	08100	08300	08500	04900
78 504 01294 / 78 505 01294	07600	08100	08300	08500	04900
78 504 02085 / 78 505 02085	07700	08100	08300	01600 08600	04900
78 504 02081 / 78 505 02081	07800	08100	08300	01700 08700	04900

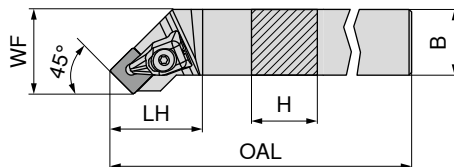
for article number

CoreLine – DSSN 45° – Toolholder with top clamping

- ▲ ...A-N = with thru coolant
 ▲ ...N = without thru coolant

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left

Right

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO 78 507 ...	TO 78 506 ...
DSSN R/L 20-4D-N	1.250	1.250	6.000	1.457	1.500	SN..43..	02089 ¹⁾	02089 ¹⁾
DSSN R/L 12-4B-N	0.750	0.750	4.500	1.457	1.000	SN..43..	01293 ¹⁾	01293 ¹⁾
DSSN R/L 16-4D-N	1.000	1.000	6.000	1.457	1.250	SN..43..	01689 ¹⁾	01689 ¹⁾
DSSN R/L 24-6E-N	1.500	1.500	7.000	1.772	2.000	SN..64..	02477 ¹⁾	02477 ¹⁾
DSSN R/L 20-6D-N	1.250	1.250	6.000	1.772	1.500	SN..64..	02080 ¹⁾	02080 ¹⁾

¹⁾ Not in stock

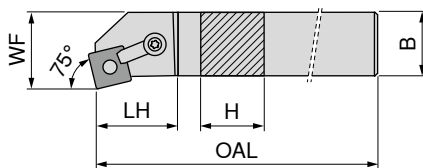
Spare parts for article number

	Clamping claw	Key I	Clamping screw	Carbide seat S	Threaded bush	Spring
	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 506 02089 / 78 507 02089	07600	08100	08300		08500	04900
78 506 01293 / 78 507 01293	07600	08100	08300		08500	04900
78 506 01689 / 78 507 01689	07600	08100	08300		08500	04900
78 506 02477 / 78 507 02477	07800	08100	08300	01700	08700	04900
78 506 02080 / 78 507 02080	07800	08100	08300	01700	08700	04900

CoreLine – MSKN 75° – Toolholder with top clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left

Right

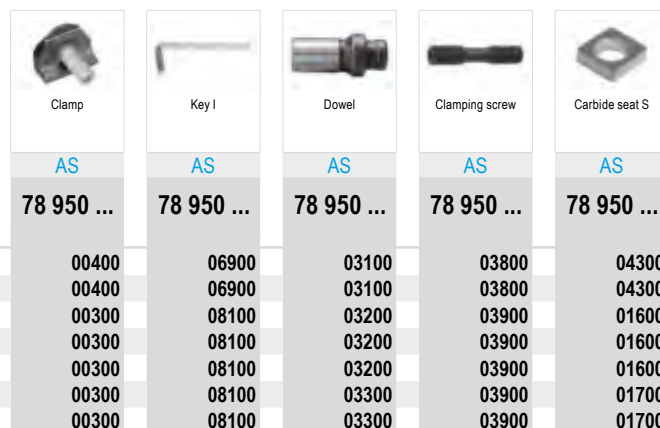
ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO 78 533 ...	TO 78 532 ...
MSKN R/L 16-4D	1.000	1.000	6.000	1.220	1.250	SN..43..	01644 ¹⁾	01644 ¹⁾
MSKN R/L 12-4B	0.750	0.750	4.500	1.220	1.000	SN..43..	01224 ¹⁾	01224 ¹⁾
MSKN R/L 16-5D	1.000	1.000	6.000	1.410	1.250	SN..54..	01645 ¹⁾	01645 ¹⁾
MSKN R/L 20-5D	1.250	1.250	6.000	1.410	1.500	SN..54..	02045 ¹⁾	02045 ¹⁾
MSKN R/L 85-5D	1.250	1.000	6.000	1.410	1.250	SN..54..	08545 ¹⁾	08545 ¹⁾
MSKN R/L 24-6E	1.500	1.500	7.000	1.500	2.000	SN..64..	02456 ¹⁾	02456 ¹⁾
MSKN R/L 20-6D	1.250	1.250	6.000	1.500	1.500	SN..64..	02046 ¹⁾	02046 ¹⁾

¹⁾ Not in stock

Spare parts

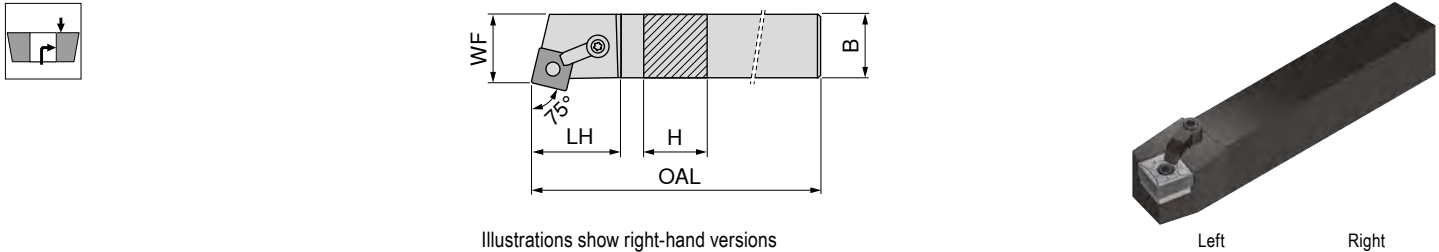
for article number

	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 532 01644 / 78 533 01644	00400	06900	03100	03800	04300
78 532 01224 / 78 533 01224	00400	06900	03100	03800	04300
78 532 01645 / 78 533 01645	00300	08100	03200	03900	01600
78 532 02045 / 78 533 02045	00300	08100	03200	03900	01600
78 532 08545 / 78 533 08545	00300	08100	03200	03900	01600
78 532 02456 / 78 533 02456	00300	08100	03300	03900	01700
78 532 02046 / 78 533 02046	00300	08100	03300	03900	01700



CoreLine – MSRN 75° – Toolholder with top clamping

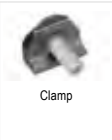
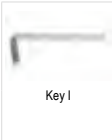
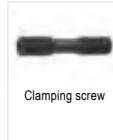
Scope of supply:
Tool holder with allen key



ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	Left	Right
							TO 78 535 ...	TO 78 534 ...
MSRN R/L 16-4D	1.000	1.000	6.000	1.250	1.130	SN..43..	01644 ¹⁾	01644 ¹⁾
MSRN R/L 12-4B	0.750	0.750	4.500	1.250	0.880	SN..43..	01224 ¹⁾	01224 ¹⁾
MSRN R/L 16-5D	1.000	1.000	6.000	1.500	1.103	SN..54..	01645 ¹⁾	01645 ¹⁾
MSRN R/L 20-5D	1.250	1.250	6.000	1.500	1.353	SN..54..	02045 ¹⁾	02045 ¹⁾
MSRN R/L 24-6E	1.500	1.500	7.000	1.590	1.821	SN..64..	02456 ¹⁾	02456 ¹⁾
MSRN R/L 20-6D	1.250	1.250	6.000	1.590	1.321	SN..64..	02046 ¹⁾	02046 ¹⁾

1) Not in stock

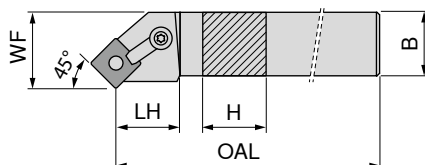
Spare parts
for article number

	 Clamp	 Key I	 Dowel	 Clamping screw	 Carbide seat S
	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 534 01644 / 78 535 01644	00400	06900	03100	03800	04300
78 534 01224 / 78 535 01224	00400	06900	03100	03800	04300
78 534 01645 / 78 535 01645	00300	08100	03200	03900	01600
78 534 02045 / 78 535 02045	00300	08100	03200	03900	01600
78 534 02456 / 78 535 02456	00300	08100	03300	03900	01700
78 534 02046 / 78 535 02046	00300	08100	03300	03900	01700

CoreLine – MSSN 45° – Toolholder with top clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left

Right

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO 78 537 ...	TO 78 536 ...
MSSN R/L 16-4D	1.000	1.000	6.000	1.230	0.925	SN..43..	01644 ¹⁾	01644 ¹⁾
MSSN R/L 12-4B	0.750	0.750	4.500	1.230	0.675	SN..43..	01224 ¹⁾	01224 ¹⁾
MSSN R/L 16-5D	1.000	1.000	6.000	1.380	0.847	SN..54..	01645 ¹⁾	01645 ¹⁾
MSSN R/L 20-5D	1.250	1.250	6.000	1.380	1.097	SN..54..	02045 ¹⁾	02045 ¹⁾
MSSN R/L 24-6E	1.500	1.500	7.000	1.470	1.511	SN..64..	02456 ¹⁾	02456 ¹⁾
MSSN R/L 20-6D	1.250	1.250	6.000	1.470	1.010	SN..64..	02046 ¹⁾	02046 ¹⁾
MSSN R/L 86-6E	1.500	1.000	7.000	1.470	0.761	SN..64..	08656 ¹⁾	08656 ¹⁾

¹⁾ Not in stock

Spare parts for article number

	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 536 01644 / 78 537 01644	00400	06900	03100	03800	04300
78 536 01224 / 78 537 01224	00400	06900	03100	03800	04300
78 536 01645 / 78 537 01645	00300	08100	03200	03900	01600
78 536 02045 / 78 537 02045	00300	08100	03200	03900	01600
78 536 02456 / 78 537 02456	00300	08100	03300	03900	01700
78 536 02046 / 78 537 02046	00300	08100	03300	03900	01700
78 536 08656 / 78 537 08656	00300	08100	03300	03900	01700

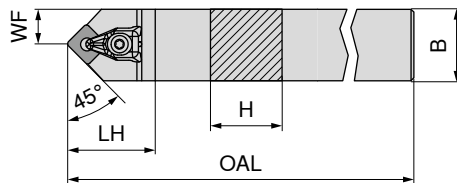
Clamp	Key I	Dowel	Clamping screw	Carbide seat S
AS	AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...

CoreLine – DSDN 45° – Toolholder with top clamping

- ▲ ...A-N = with thru coolant
 ▲ ...N = without thru' coolant

Scope of supply:

Tool holder with allen key



Neutral

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert
DSDN N 16-4DA-N	1.000	1.000	6.000	1.457	0.500	SN..43..
DSDN N 12-4BA-N	0.750	0.750	4.500	1.380	0.375	SN..43..
DSDN N 20-5DA-N	1.250	1.250	6.000	1.535	0.625	SN..54..
DSDN N 24-6EA-N	1.500	1.500	7.000	1.650	0.750	SN..64..
DSDN N 20-6DA-N	1.250	1.250	6.000	1.535	0.625	SN..64..

TO

78 574 ...

01690

01224 ¹⁾

02085

02479 ¹⁾

02081 ¹⁾

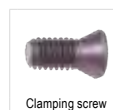
1) Not in stock



Clamping claw



Key I



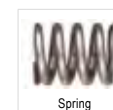
Clamping screw



Carbide seat S



Threaded bush



Spring

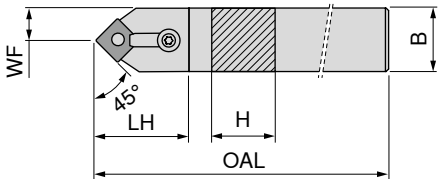
for article number

	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 574 01690	07600	08100	08300	08500	04900
78 574 01224	07600	08100	08300	08500	04900
78 574 02085	07700	08100	08300	01600	04900
78 574 02479	07800	08100	08300	01700	04900
78 574 02081	07800	08100	08300	01700	04900

CoreLine – MSDN 45° – Toolholder with top clamping

Scope of supply:

Tool holder with allen key



Neutral

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO	
							78 577 ...	
MSDN N 10-3B	0.625	0.625	4.500	1.000	0.313	SN..32..		01023 ¹⁾
MSDN N 08-3A	0.500	0.500	4.000	1.000	0.250	SN..32..		00813 ¹⁾
MSDN N 12-4B	0.750	0.750	4.500	1.300	0.375	SN..43..		01224 ¹⁾
MSDN N 85-4D	1.250	1.000	6.000	1.300	0.625	SN..43..		08544 ¹⁾
MSDN N 16-4D	1.000	1.000	6.000	1.300	0.500	SN..43..		01644 ¹⁾
MSDN N 20-5D	1.250	1.250	6.000	1.500	0.625	SN..54..		02045 ¹⁾
MSDN N 16-5D	1.000	1.000	6.000	1.500	0.500	SN..54..		01645 ¹⁾
MSDN N 85-5D	1.250	1.000	6.000	1.500	0.625	SN..54..		08545 ¹⁾
MSDN N 16-6D	1.000	1.000	6.000	1.730	0.500	SN..64..		01646 ¹⁾
MSDN N 20-6D	1.250	1.250	6.000	1.750	0.625	SN..64..		02046 ¹⁾
MSDN N 24-6E	1.500	1.500	7.000	1.750	0.750	SN..64..		02456 ¹⁾
MSDN N 85-6D	1.250	1.000	6.000	1.750	0.625	SN..64..		08546 ¹⁾

1) Not in stock

Spare parts
for article number

	AS				
	78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...
78 577 01023	00600	07000		03600	01500
78 577 00813	00600	07000		03600	01500
78 577 01224	00400	06900	03100	03800	04300
78 577 08544	00400	06900	03100	03800	04300
78 577 01644	00400	06900	03100	03800	04300
78 577 02045	00300	08100	03200	03900	01600
78 577 01645	00300	08100	03200	03900	01600
78 577 08545	00300	08100	03200	03900	01600
78 577 01646	00300	08100	03300	03900	01700
78 577 02046	00300	08100	03300	03900	01700
78 577 02456	00300	08100	03300	03900	01700
78 577 08546	00300	08100	03300	03900	01700

Clamp

Key I

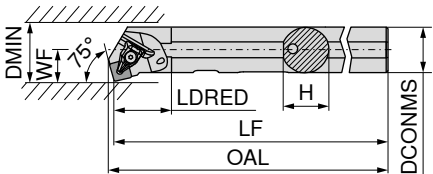
Dowel

Clamping screw

Carbide seat S

CoreLine – DSKN 75° – Boring bar with top clamping

Scope of supply:
Boring bar with Torx key



Illustrations show right-hand versions



Designation	DCONMS mm	H mm	LF mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert
A32S DSKN R/L 12	32	31	250	254.2	40	22	40	4	SN.. 1204

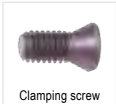
Left	Right
TO	TO
70 561 ...	70 560 ...
832	832

Spare parts
for article number

70 560 832 / 70 561 832



AS
70 950 ...
824



AS
70 950 ...
820

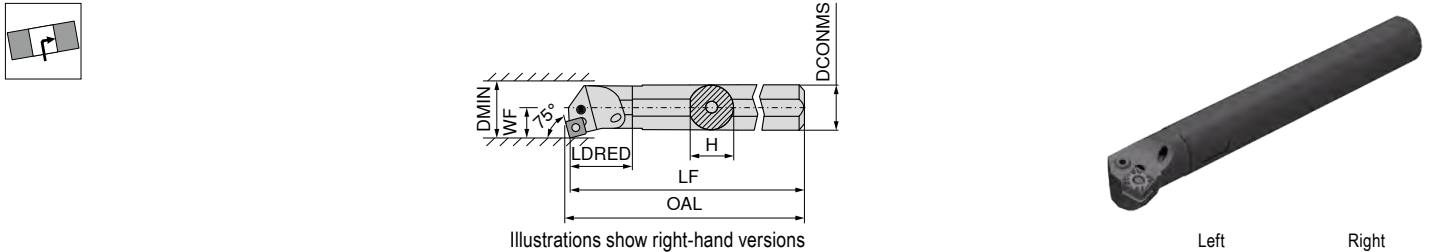


AS
70 950 ...
813

M4,5x12 - 15IP

CoreLine – PSKN 75° – Boring bar with lever clamping

Scope of supply:
Boring bar with Allen key



Designation	DCONMS mm	H mm	LF mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	TO 70 561 ...	TO 70 560 ...
A25R PSKN R/L 12	25	23	200	203	36	17	32	4	SNM. 1204	225	225
A32S PSKN R/L 12	32	30	250	253	50	22	40	4	SNM. 1204	232	232
A40T PSKN R/L 12	40	38	300	303	60	27	50	4	SNM. 1204	240	240

Spare parts
for article number

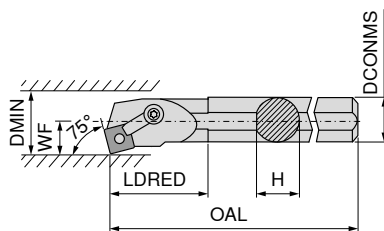
	Key I	Shim	Assembly pin	Toggle lever	Clamping screw	Carbide seat S
	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 560 225 / 70 561 225	SW3 176	198	192	187	205	230
70 560 232 / 70 561 232	SW3 176	198	192	187	205	230
70 560 240 / 70 561 240	SW3 176	198	192	187	209	230

CoreLine – MSKN 75° – Boring bar with top clamping

- ▲ A... = with thru coolant
▲ S... = without thru coolant

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



ANSI designation	DCONMS inch	H inch	OAL inch	LDRED inch	WF inch	DMIN inch	Indexable insert
S20U MSKN R/L 4	1.250	1.180	14.000	3.000	0.765	1.530	SN..43..
S24U MSKN R/L 4	1.500	1.370	14.000	3.000	0.890	1.780	SN..43..
S32V MSKN R/L 5	2.000	1.870	16.000	4.000	1.281	2.562	SN..54..
S32V MSKN R/L 6	2.000	1.870	16.000	4.000	1.281	2.562	SN..64..
S40V MSKN R/L 6	2.500	2.380	16.000	4.000	1.531	3.062	SN..64..

Left

Right

TO	TO
78 709 ...	78 708 ...
42030 ¹⁾	42030 ¹⁾
42434 ¹⁾	42434 ¹⁾
53242 ¹⁾	53242 ¹⁾
63242 ¹⁾	63242 ¹⁾
64050 ¹⁾	64050 ¹⁾

1) Not in stock

for article number

78 708 42030 / 78 709 42030
78 708 42434 / 78 709 42434
78 708 53242 / 78 709 53242
78 708 63242 / 78 709 63242
78 708 64050 / 78 709 64050

AS	AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...
00400	06900	03100	03800	04300
00400	06900	03100	03800	04300
00300	08100	03200	03900	01600
00300	08100	03300	03900	01700
00300	08100	03300	03900	01700



Clamp



Key I



Dowel



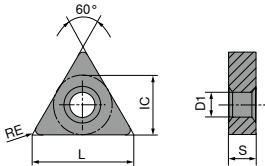
Clamping screw



Carbide seat S

TNMG / TNMA / TNMM

Designation	L	S	D1	IC
	mm	mm	mm	mm
TNM. 1604..	16.5	4.76	3.81	9.52
TNM. 2204..	22.0	4.76	5.16	12.70
TNMM 2706..	27.5	6.35	6.35	15.87



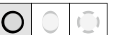
CoreLine – Carbide turning indexable insert

TNMG

		-CF20 CTEP110-P	-F50 CTCK110-P	-F50 CTCP115-P	-F50 CTCP125-P	-F50 CTCP135-P	-M50 CTCK110-P	-M50 CTCK120-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F	F	F	F	F	M	M
		CERMET						
		TNMG	TNMG	TNMG	TNMG	TNMG	TNMG	TNMG
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	76 149 ...	70 320 ...	76 146 ...	76 146 ...	76 146 ...	70 324 ...	70 324 ...
110304EN	0.4			30401	50401	70401		
110308EN	0.8			30601	50601	70601		
160404EN	0.4	01601	11601	31601	51601	71601	11601	51601
160408EN	0.8	01801	11801	31801	51801	71801	11801	51801
160412EN	1.2	02001	12001	32001	52001	72001	12001	52001
220408EN	0.8						13001	53001
220412EN	1.2						13201	53201
P		●	○	●	●	●	○	○
M		○				○		
K		○	●	○	○		●	●
N								
S								
H								
O								

CoreLine – Carbide turning indexable insert

TNMG

		<div><div>-M50</div><div>CTCP115-P</div><div>DRAGONSKIN</div><div></div><div></div><div>M</div><div>TNMG</div></div>	<div><div>-M50</div><div>CTCP125-P</div><div>DRAGONSKIN</div><div></div><div></div><div>M</div><div>TNMG</div></div>	<div><div>-M50</div><div>CTCP135-P</div><div>DRAGONSKIN</div><div></div><div></div><div>M</div><div>TNMG</div></div>	<div><div>-M70</div><div>CTCK110-P</div><div>DRAGONSKIN</div><div></div><div></div><div>M</div><div>TNMG</div></div>	<div><div>-M70</div><div>CTCK120-P</div><div>DRAGONSKIN</div><div></div><div></div><div>M</div><div>TNMG</div></div>	<div><div>-M70</div><div>CTCP115-P</div><div>DRAGONSKIN</div><div></div><div></div><div>M</div><div>TNMG</div></div>	<div><div>-M70</div><div>CTCP125-P</div><div>DRAGONSKIN</div><div></div><div></div><div>M</div><div>TNMG</div></div>
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	76 138 ...	76 138 ...	76 138 ...	70 155 ...	70 155 ...	76 155 ...	76 155 ...
160404EN	0.4	31601	51601	71601				
160408EN	0.8	31801	51801	71801	11801	51801	31801	51801
160412EN	1.2	32001	52001	72001	12001	52001	32001	52001
220404EN	0.4	32801	52801	72801			32801	52801
220408EN	0.8	33001	53001	73001	13001	53001	33001	53001
220412EN	1.2	33201	53201	73201	13201	53201	33201	53201
220416EN	1.6				13401	53401	33401	53401
P		●	●	●	○	○	●	●
M				○				
K		○	○		●	●	○	○
N								
S								
H								
O								

CoreLine – Carbide turning indexable insert

TNMG / TNMA / TNMM

		<div><div>-M70</div><div>CTCP135-P</div></div>	<div><div></div><div>CTCP125-P</div></div>	<div><div></div><div>CTCK110-P</div></div>	<div><div></div><div>CTCK120-P</div></div>	<div><div>-R28</div><div>CTCP115-P</div></div>	<div><div>-R28</div><div>CTCP125-P</div></div>
		<div>DRAGONS</div>	<div>DRAGONS</div>	<div>DRAGONS</div>	<div>DRAGONS</div>	<div>DRAGONS</div>	<div>DRAGONS</div>
		<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>
		<div></div>	<div></div>	<div></div>	<div></div>	<div></div>	<div></div>
		<div>M</div>	<div>M</div>	<div>R</div>	<div>R</div>	<div>R</div>	<div>R</div>
		TNMG	TNMG	TNMA	TNMA	TNMM	TNMM
		TR	TR	TR	TR	TR	TR
ISO	RE mm	76 155 ...	76 142 ...	70 134 ...	70 134 ...	76 154 ...	76 154 ...
160404ER	0.4		51601				
160408EL	0.8		51801				
160408EN	0.8	71801		11801	51801		
160408ER	0.8		51701				
160412EN	1.2	72001		12001	52001		
160416EN	1.6			12201	52201		
220404EN	0.4	72801					
220408EN	0.8	73001		13001	53001		
220412EN	1.2	73201		13201	53201		
220416EN	1.6	73401		13401	53401	33401	53401
P		●	●	○	○	●	●
M		○					
K			○	●	●	○	○
N							
S							
H							
O							

CoreLine – Carbide turning indexable insert

TNMM / TNMG

		<div><div>-R28</div><div>CTCP135-P</div><div>DRAGONSKIN</div><div></div><div><div>R</div><div>TNMM</div></div></div>	<div><div>-R58</div><div>CTCP115-P</div><div>DRAGONSKIN</div><div></div><div><div>R</div><div>TNMM</div></div></div>	<div><div>-R58</div><div>CTCP125-P</div><div>DRAGONSKIN</div><div></div><div><div>R</div><div>TNMM</div></div></div>	<div><div>-R58</div><div>CTCP135-P</div><div>DRAGONSKIN</div><div></div><div><div>R</div><div>TNMM</div></div></div>	<div><div>-F30</div><div>CTCM120</div><div>DRAGONSKIN</div><div></div><div><div>F</div><div>TNMG</div></div></div>	<div><div>-F30</div><div>CTPM125</div><div>DRAGONSKIN</div><div></div><div><div>F</div><div>TNMG</div></div></div>	<div><div>-F30</div><div>CTCM130</div><div>DRAGONSKIN</div><div></div><div><div>F</div><div>TNMG</div></div></div>
ISO	RE mm	TR 76 154 ...	TR 76 152 ...	TR 76 152 ...	TR 76 152 ...	TR 75 019 ...	TR 75 019 ...	TR 75 019 ...
160404EN	0.4					11600	216	31600
160408EN	0.8					11800	218	31800
220412EN	1.2		33201	53201	73201			
220416EN	1.6	73401						
270616EN	1.6			54601				
P		●	●	●	●	○	○	○
M		○			○	●	●	●
K			○	○				
N								
S								○
H								
O								

CoreLine – Carbide turning indexable insert

TNMG

		<div><div>-M30</div><div>CTCM120</div></div>	<div><div>-M30</div><div>CTPM125</div></div>	<div><div>-M30</div><div>CTCM130</div></div>	<div><div>-M42</div><div>CTCM130</div></div>	<div><div>-M60</div><div>CTCM120</div></div>	<div><div>-M60</div><div>CTPM125</div></div>	<div><div>-M60</div><div>CTCM130</div></div>
		<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>
		<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>
		<div></div>	<div></div>	<div></div>	<div></div>	<div></div>	<div></div>	<div></div>
		<div><div>M</div><div>TNMG</div></div>	<div><div>M</div><div>TNMG</div></div>	<div><div>M</div><div>TNMG</div></div>	<div><div>M</div><div>TNMG</div></div>	<div><div>M</div><div>TNMG</div></div>	<div><div>M</div><div>TNMG</div></div>	<div><div>M</div><div>TNMG</div></div>
		<div>TR</div>	<div>TR</div>	<div>TR</div>	<div>TR</div>	<div>TR</div>	<div>TR</div>	<div>TR</div>
ISO	RE mm	<div>75 020 ...</div>	<div>75 020 ...</div>	<div>75 020 ...</div>	<div>75 035 ...</div>	<div>75 021 ...</div>	<div>75 021 ...</div>	<div>75 021 ...</div>
160404EN	0.4				<div>31600</div>			
160408EN	0.8	<div>11800</div>	<div>218</div>	<div>31800</div>	<div>31800</div>	<div>11800</div>	<div>218</div>	<div>31800</div>
160412EN	1.2	<div>12000</div>	<div>220</div>	<div>32000</div>		<div>12000</div>	<div>220</div>	<div>32000</div>
						<div>13000</div>		<div>33000</div>
220408EN	0.8							
P		<div></div>	<div></div>	<div></div>	<div></div>	<div></div>	<div></div>	<div></div>
M		<div></div>	<div></div>	<div></div>	<div></div>	<div></div>	<div></div>	<div></div>
K								
N								
S				<div></div>	<div></div>			<div></div>
H								
O								

CoreLine – Carbide turning indexable insert

TNMG

ISO	RE mm		
160408EN	0.8		
160412EN	1.2		
220404EN	0.4		
220408EN	0.8		
220412EN	1.2		
220416EN	1.6		
P			○ ●
M			● ●
K			
N			○
S			○ ●
H			
O			

-M70
CTCM130

DRAGONSKIN

M
TNMG

TR

75 040 ...

31800

32000

33200

-M34
CTPX710

DRAGONSKIN

M
TNMG

TR

75 006 ...

61800

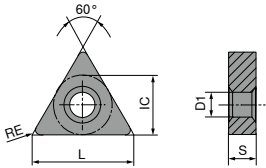
62800

63000

63400

TNMG

Designation	L	S	D1	IC
	mm	mm	mm	mm
TNMG 1604..	16.5	4.76	3.81	9.52



CoreLine – Carbide turning indexable insert

TNMG

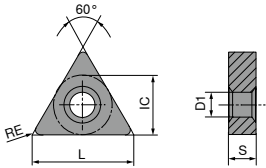
-F30 CTPX710	-M42 CTP2120	-M52 CTP2120
DRAGONSKIN		
F TNMG	M TNMG	M TNMG
TR	TR	TR
75 028 ... 62000	70 148 ... 608	70 152 ... 604 608

ISO	RE mm
160404EN	0.4
160408EN	0.8
160412EN	1.2

P	●
M	●
K	
N	○
S	●
H	
O	

TNMU

Designation	L	S	D1	IC
	mm	mm	mm	mm
TNMU 1604..	16.5	4.76	4.7	9.52



CoreLine – Carbide turning indexable insert

TNMU

-M50
CTCP125-P

DRAGONSKIN



M
TNMU

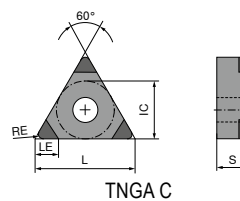
TR
76 282 ...
52001

ISO	RE
	mm
160412EN	1.2

P	
M	
K	
N	
S	
H	
O	

CoreLine – PcBN turning indexable insert

▲ TCE(NOI) = Design and number of equipped cutting edge corners



CTBH1000C	CTBH2000C	CTBH3000C
F PCBN TNGA	F PCBN TNGA	F PCBN TNGA
PC 71 040 ... 70002	PC 71 040 ... 80002	PC 71 040 ... 90002
70302	80302	90302
70602	80602	90602

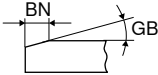
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
160404EN	0.4			C (3)	3.6
160404SN	0.4	0.14	20°	C (3)	3.6
160408EN	0.8			C (3)	3.3
160408SN	0.8	0.14	20°	C (3)	3.3
160412EN	1.2			C (3)	3.0
160412SN	1.2	0.14	20°	C (3)	3.0

Month	Days
P	31
M	31
K	31
N	31
S	31
H	31
O	31

CoreLine – PcBN turning indexable insert

TNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners



CTBH1000C	CTBH2000C	CTBH3000C
M	M	M
PCBN	PCBN	PCBN
TNGA	TNGA	TNGA
PC	PC	PC
71 040 ...	71 040 ...	71 040 ...
70102	80102	90102
70402	80402	90402
70702	80702	90702

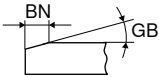
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
160404SN	0.4	0.09	15°	C (3)	3.6
160404SN	0.4	0.18	25°	C (3)	3.6
160408SN	0.8	0.09	15°	C (3)	3.3
160408SN	0.8	0.18	25°	C (3)	3.3
160412SN	1.2	0.09	15°	C (3)	3.0
160412SN	1.2	0.18	25°	C (3)	3.0

P			
M			
K			
N			
S			
H			
O			

CoreLine – PcBN turning indexable insert

TNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners



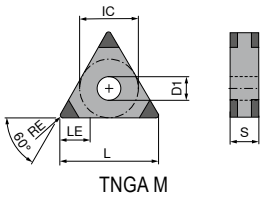
CTBH1000C	CTBH2000C	CTBH3000C
R	R	R
PCBN	PCBN	PCBN
TNGA	TNGA	TNGA
PC	PC	PC
71 040 ...	71 040 ...	71 040 ...
70202	80202	90202
70502	80502	90502
70802	80802	90802

ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
160404SN	0.4	0.14	20°	C (3)	3.6
160404SN	0.4	0.20	35°	C (3)	3.6
160408SN	0.8	0.14	20°	C (3)	3.3
160408SN	0.8	0.20	35°	C (3)	3.3
160412SN	1.2	0.14	20°	C (3)	3.0
160412SN	1.2	0.20	35°	C (3)	3.0

P			
M			
K			
N			
S			
H			
O			

TNGA

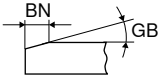
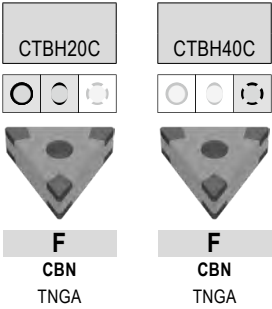
Designation	L	S	D1	IC
	mm	mm	mm	mm
TNGA 1604..	16.5	4.76	3.81	9.52



CoreLine – PcBN turning indexable insert

TNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners

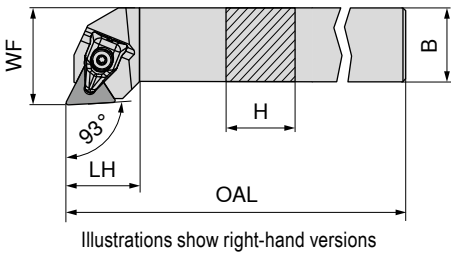


ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	PC	PC
160404SN	0.4	0.09	20°	M (6)	2.8	71 404 ...	71 404 ...
160404SN	0.4	0.14	30°	M (6)	2.8		332 372
160408SN	0.8	0.09	20°	M (6)	2.5		334
160408SN	0.8	0.11	20°	M (6)	2.5	244	364
160408SN	0.8	0.13	25°	M (6)	2.5		366
160412SN	1.2	0.13	25°	M (6)	2.2		
P							
M							
K							
N							
S							
H							
O							

CoreLine – DTJN 93° – Tool holder with top clamping

Scope of supply:

Tool holder with Torx key



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
DTJN R/L 2020 K16	20	20	125	23	25	2	TNM. 1604
DTJN R/L 2525 M16	25	25	150	24	32	2	TNM. 1604

Left	Right
TO	TO
70 591 ...	70 590 ...
820	820
825	825

Spare parts
for article number

70 590 820 / 70 591 820	823	T09 - IP	118	M3x7 - 09IP	819	847
70 590 825 / 70 591 825	823	T09 - IP	118	M3x7 - 09IP	819	847



XPress range

AS

70 950 ...



Screwdriver

AS

80 950 ...



Clamping screw

AS

70 950 ...



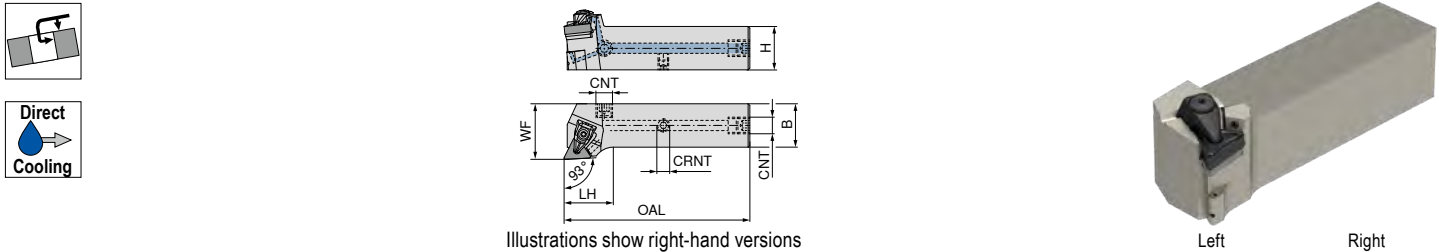
Carbide seat T

AS

70 950 ...

CoreLine – DTJN 93° DC – tool holder with top clamping

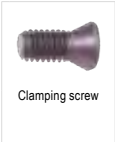
Scope of supply:
Tool holder with Torx key



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	TO 70 601 ...	TO 70 601 ...
DTJN R/L 2020 X16 DC	20	20	92	23	25	2	TNM. 1604	82000	82001
DTJN R/L 2525 X16 DC	25	25	107	23	32	2	TNM. 1604	82500	82501

Spare parts
for article number

70 601 82001 / 70 601 82000	M3x7 - 09IP	819	847	M6x6	86700
70 601 82501 / 70 601 82500	M3x7 - 09IP	819	847	M6x6	86700



Clamping screw

AS

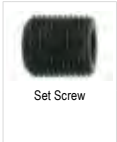
70 950 ...



Carbide seat T

AS

70 950 ...



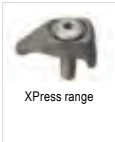
Set Screw

AS

70 950 ...

Spare parts
for article number

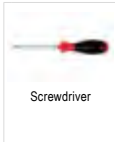
70 601 82001 / 70 601 82000	823	T09 - IP	118	G 1/8"	294
70 601 82501 / 70 601 82500	823	T09 - IP	118	G 1/8"	294



XPress range

AS

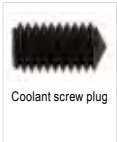
70 950 ...



Screwdriver

AS

80 950 ...



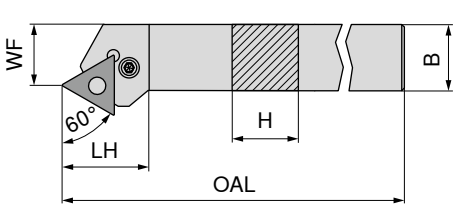
Coolant screw plug

AS

70 950 ...

CoreLine – PTTN 60° – Tool holder with lever clamping

Scope of supply:
Tool holder with Allen key



Illustrations show right-hand versions



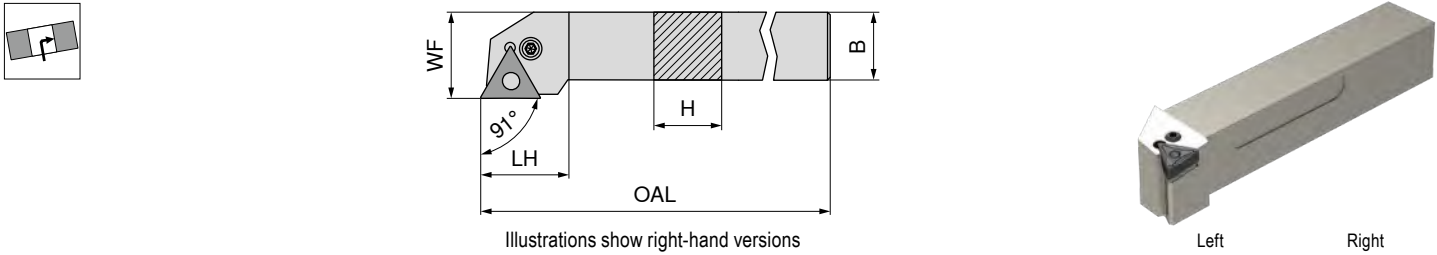
Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	Left	Right
								TO 70 529 ...	TO 70 528 ...
PTTN R/L 2020 K16	20	20	125	25.9	17	3	TNM. 1604	020	020
PTTN R/L 2525 M22	25	25	150	32.7	22	4	TNM. 2204	025	025

Spare parts
for article number

	Key I	Shim	Assembly pin	Toggle lever	Clamping screw	Carbide seat T
	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 528 020 / 70 529 020	SW2,5 175	197	191	185	208	225
70 528 025 / 70 529 025	SW3 176	198	192	187	209	226

CoreLine – PTGN 91° – Tool holder with lever clamping

Scope of supply:
Tool holder with Allen key



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
PTGN R/L 1616 H16	16	16	100	20	20	3	TNM. 1604
PTGN R/L 2020 K16	20	20	125	20	25	3	TNM. 1604
PTGN R/L 2525 M16	25	25	150	22	32	3	TNM. 1604
PTGN R/L 3225 P16	32	25	170	22	32	3	TNM. 1604
PTGN R/L 2525 M22	25	25	150	29	32	4	TNM. 2204
PTGN R/L 3232 P22	32	32	170	29	40	4	TNM. 2204

Left	Right
TO	TO
70 533 ...	70 532 ...
016	016
020	020
025	025
032	032
125	125
132	132

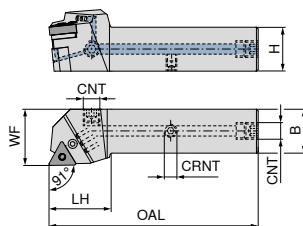
Spare parts
for article number

	Key I	Shim	Assembly pin	Toggle lever	Clamping screw	Carbide seat T
	AS	AS	AS	AS	AS	AS
70 532 016 / 70 533 016	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 532 020 / 70 533 020	175	197	191	185	208	225
70 532 025 / 70 533 025	175	197	191	185	208	225
70 532 032 / 70 533 032	175	197	191	185	208	225
70 532 125 / 70 533 125	176	198	192	187	209	226
70 532 132 / 70 533 132	176	198	192	187	209	226

CoreLine – PTGN 91° DC – Tool holder with lever clamping

Scope of supply:

Tool holder with Allen key



Illustrations show right-hand versions



Left

Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Tightening torque Nm	Indexable insert
PTGN R/L 2020 X16-T DC	20	20	101	32	25	M6	G1/8"	3	TNM. 1604
PTGN R/L 2525 X16-T DC	25	25	119	35	32	M6	G1/8"	3	TNM. 1604
PTGN R/L 3225 X16-T DC	32	25	136	36	32	M6	G1/8"	3	TNM. 1604
PTGN R/L 2525 X22-T DC	25	25	122	38	32	M6	G1/8"	4	TNM. 2204
PTGN R/L 3232 X22-T DC	32	32	138	38	40	M6	G1/8"	4	TNM. 2204

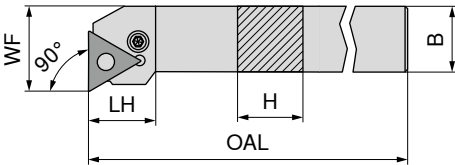
TO	TO
70 598 ...	70 598 ...
02000	02001
02500	02501
03200	03201
12500	12501
13200	13201

Spare parts for article number

	Key I	Shim	Assembly pin	Coolant screw plug	Toggle lever	Clamping screw	Carbide seat T	Set Screw
	AS	AS	AS	AS	AS	AS	AS	AS
70 598 02001 / 70 598 02000	175	197	191	294	185	208	225	86700
70 598 02501 / 70 598 02500	175	197	191	294	185	208	225	86700
70 598 03201 / 70 598 03200	175	197	191	294	185	208	225	86700
70 598 12501 / 70 598 12500	176	198	192	294	187	209	226	86700
70 598 13201 / 70 598 13200	176	198	192	294	187	209	226	86700

CoreLine – PTFN 90° – Tool holder with lever clamping

Scope of supply:
Tool holder with Allen key



Illustrations show right-hand versions



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
PTFN R/L 1616 H16	16	16	100	19.7	20	3	TNM. 1604
PTFN R/L 2020 K16	20	20	125	20.2	25	3	TNM. 1604
PTFN R/L 2525 M16	25	25	150	20.2	32	3	TNM. 1604
PTFN R/L 2525 M22	25	25	150	25.2	32	4	TNM. 2204
PTFN R/L 3225 P22	32	25	170	25.2	32	4	TNM. 2204

Left	Right
TO	TO
70 535 ...	70 534 ...
016	016
020	020
025	025
125	125
132	132

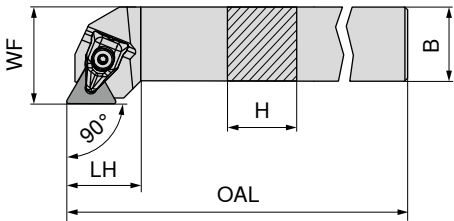
Spare parts
for article number

	Key I	Shim	Assembly pin	Toggle lever	Clamping screw	Carbide seat T
	AS	AS	AS	AS	AS	AS
	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 534 016 / 70 535 016	SW2,5	175	191	185	208	225
70 534 020 / 70 535 020	SW2,5	175	191	185	208	225
70 534 025 / 70 535 025	SW2,5	175	191	185	208	225
70 534 125 / 70 535 125	SW3	176	192	187	209	226
70 534 132 / 70 535 132	SW3	176	192	187	209	226

CoreLine – DTGN 90° – Toolholder with top clamping

- ▲ ...A-N = with thru coolant
- ▲ ...N = without thru' coolant

Scope of supply:
Tool holder with allen key



Illustrations show right-hand versions

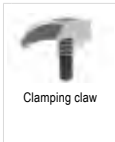


Left Right

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO	
							78 509 ...	78 508 ...
DTGN R/L 12-3B-N	0.750	0.750	4.500	1.100	1.000	TN..33..	01299	01299
DTGN R/L 16-3D-N	1.000	1.000	6.000	1.100	1.250	TN..33..	01697	01697
DTGN R/L 16-4D-N	1.000	1.000	6.000	1.338	1.250	TN..43..	01689	01689
DTGN R/L 20-4D-N	1.250	1.250	6.000	1.338	1.500	TN..43..	02089	02089

for article number

	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 508 01299 / 78 509 01299	07500	08100	07900	07400	08400	08000
78 508 01697 / 78 509 01697	07500	08100	07900	07400	08400	08000
78 508 01689 / 78 509 01689	07600	08100	08300	01900	08500	04900
78 508 02089 / 78 509 02089	07600	08100	08300	01900	08500	04900



Clamping claw

AS

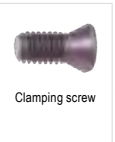
78 950 ...



Key I

AS

78 950 ...



Clamping screw

AS

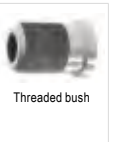
78 950 ...



Carbide seat T

AS

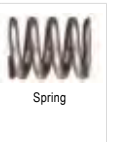
78 950 ...



Threaded bush

AS

78 950 ...



Spring

AS

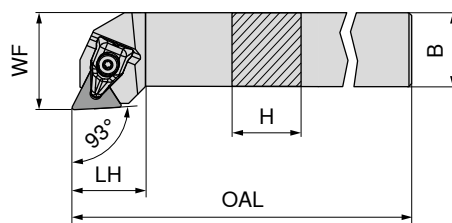
78 950 ...

CoreLine – DTJN 93° – Toolholder with top clamping

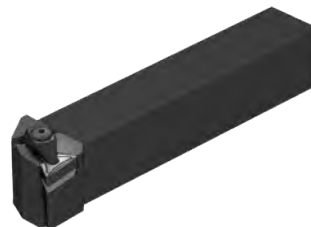
- ▲ ...A-N = with thru coolant
 ▲ ...N = without thru' coolant

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left

Right

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO 78 511 ...	TO 78 510 ...
DTJN R/L 12-3BA-N	0.750	0.750	4.500	1.250	1.000	TN..33..	01276	01276
DTJN R/L 16-3DA-N	1.000	1.000	6.000	1.250	1.250	TN..33..	01698 ¹⁾	01698 ¹⁾
DTJN R/L 16-4DA-N	1.000	1.000	6.000	1.380	1.250	TN..43..	01690 ¹⁾	01690 ¹⁾
DTJN R/L 20-4DA-N	1.250	1.250	6.000	1.250	1.500	TN..43..	02090	02090
DTJN R/L 24-4EA-N	1.500	1.500	7.000	1.380	2.000	TN..43..	02487 ¹⁾	02487 ¹⁾

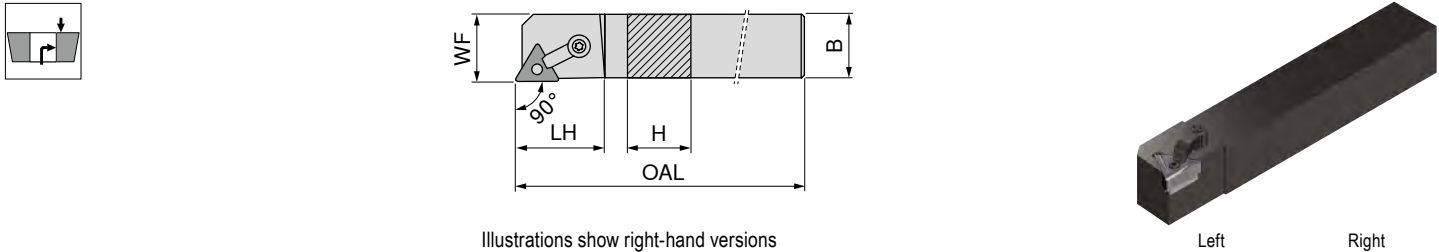
1) Not in stock

Clamping claw	Key I	Clamping screw	Carbide seat T	Threaded bush	Spring
AS	AS	AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...
78 510 01276 / 78 511 01276	07500	08100	07900	07400	08400
78 510 01698 / 78 511 01698	07500	08100	07900	07400	08400
78 510 01690 / 78 511 01690	07600	08100	08300	01900	08500
78 510 02090 / 78 511 02090	07600	08100	08300	01900	08500
78 510 02487 / 78 511 02487	07600	08100	08300	01900	08500

for article number

CoreLine – MTAN 90° – Toolholder with top clamping

Scope of supply:
Tool holder with allen key



ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	Left		Right	
							TO		TO	
MTAN R/L 08-2A	0.500	0.500	4.000	0.875	0.500	TN..22..	78 539 ...	00812 ¹⁾	78 538 ...	00812 ¹⁾
MTAN R/L 12-3B	0.750	0.750	4.500	1.060	0.750	TN..33..	01223 ¹⁾		01223 ¹⁾	
MTAN R/L 16-3D	1.000	1.000	6.000	1.060	1.000	TN..33..	01643 ¹⁾		01643 ¹⁾	
MTAN R/L 16-4D	1.000	1.000	6.000	1.220	1.000	TN..43..	01644 ¹⁾		01644 ¹⁾	

1) Not in stock

Spare parts
for article number

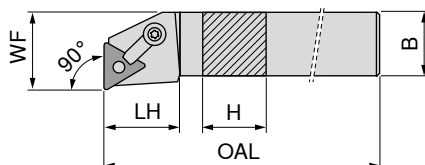
	AS	AS	AS	AS	AS
78 538 00812 / 78 539 00812	00700	07000		05000	
78 538 01223 / 78 539 01223	00400	06900	02900	03800	01800
78 538 01643 / 78 539 01643	00400	06900	02900	03800	01800
78 538 01644 / 78 539 01644	00400	06900	03100	03800	01900

				
Clamp	Key I	Dowel	Clamping screw	Carbide seat T
AS	AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...

CoreLine – MTFN 90° – Toolholder with top clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left

Right

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO 78 541 ...	TO 78 540 ...
MTFN R/L 12-3B	0.750	0.750	4.500	1.000	1.000	TN..33..	01223 ¹⁾	01223 ¹⁾
MTFN R/L 16-3D	1.000	1.000	6.000	1.250	1.250	TN..33..	01643 ¹⁾	01643 ¹⁾
MTFN R/L 16-4D	1.000	1.000	6.000	1.250	1.250	TN..43..	01644 ¹⁾	01644 ¹⁾
MTFN R/L 20-4D	1.250	1.250	6.000	1.500	1.500	TN..43..	02044 ¹⁾	02044 ¹⁾
MTFN R/L 85-4D	1.250	1.000	6.000	1.250	1.250	TN..43..	08544 ¹⁾	08544 ¹⁾
MTFN R/L 86-4D	1.500	1.000	6.000	1.250	1.250	TN..43..	08644 ¹⁾	08644 ¹⁾

¹⁾ Not in stock

Spare parts

for article number

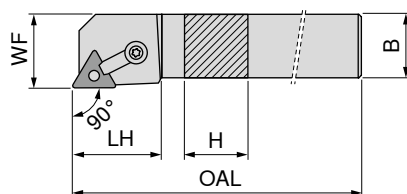
	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 540 01223 / 78 541 01223	00400	06800	02900	03800	01800
78 540 01643 / 78 541 01643	00400	06800	02900	03800	01800
78 540 01644 / 78 541 01644	00400	07000	03100	03800	01900
78 540 02044 / 78 541 02044	00400	07000	03100	03800	01900
78 540 08544 / 78 541 08544	00400	07000	03100	03800	01900
78 540 08644 / 78 541 08644	00400	07000	03100	03800	01900

Clamp	Key I	Dowel	Clamping screw	Carbide seat T
AS	AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...

CoreLine – MTGN 90° – Toolholder with top clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left

Right

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO 78 543 ...	TO 78 542 ...
MTGN R/L 08-2A	0.500	0.500	4.000	0.875	0.625	TN..22..	00812 ¹⁾	00812 ¹⁾
MTGN R/L 10-3B	0.625	0.625	4.500	1.000	0.875	TN..33..	01023 ¹⁾	01023 ¹⁾
MTGN R/L 12-3B	0.750	0.750	4.500	1.060	1.000	TN..33..	01223 ¹⁾	01223 ¹⁾
MTGN R/L 16-3D	1.000	1.000	6.000	1.060	1.250	TN..33..	01643 ¹⁾	01643 ¹⁾
MTGN R/L 16-4D	1.000	1.000	6.000	1.220	1.250	TN..43..	01644 ¹⁾	01644 ¹⁾
MTGN R/L 20-4D	1.250	1.250	6.000	1.220	1.500	TN..43..	02044 ¹⁾	02044 ¹⁾
MTGN R/L 85-4D	1.250	1.000	6.000	1.220	1.250	TN..43..	08544 ¹⁾	08544 ¹⁾
MTGN R/L 86-4D	1.500	1.000	6.000	1.220	1.250	TN..43..	08644 ¹⁾	08644 ¹⁾

1) Not in stock

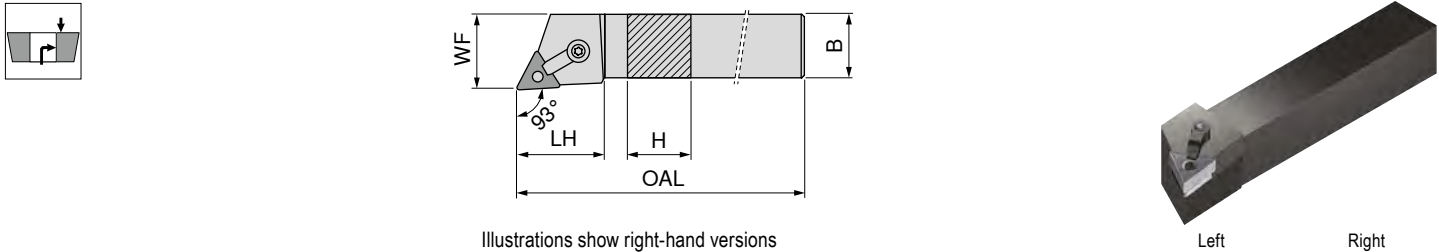
Spare parts for article number

	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 542 00812 / 78 543 00812	00700	07000		05000	
78 542 01023 / 78 543 01023	00400	06800	02900	03800	01800
78 542 01223 / 78 543 01223	00400	06800	02900	03800	01800
78 542 01643 / 78 543 01643	00400	06800	02900	03800	01800
78 542 01644 / 78 543 01644	00400	07000	03100	03800	01900
78 542 02044 / 78 543 02044	00400	07000	03100	03800	01900
78 542 08544 / 78 543 08544	00400	07000	03100	03800	01900
78 542 08644 / 78 543 08644	00400	07000	03100	03800	01900

 Clamp	 Key I	 Dowel	 Clamping screw	 Carbide seat T
AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
00700	07000		05000	
00400	06800	02900	03800	01800
00400	06800	02900	03800	01800
00400	06800	02900	03800	01800
00400	07000	03100	03800	01900
00400	07000	03100	03800	01900
00400	07000	03100	03800	01900
00400	07000	03100	03800	01900

CoreLine – MTJN 93° – Toolholder with top clamping

Scope of supply:
Tool holder with allen key



Illustrations show right-hand versions

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	Left TO 78 545 ...	Right TO 78 544 ...
MTJN R/L 12-3B	0.750	0.750	4.500	1.030	1.000	TN..33..	01223 ¹⁾	01223 ¹⁾
MTJN R/L 16-3D	1.000	1.000	6.000	1.030	1.250	TN..33..	01643 ¹⁾	01643 ¹⁾
MTJN R/L 16-4D	1.000	1.000	6.000	1.250	1.250	TN..43..	01644 ¹⁾	01644 ¹⁾
MTJN R/L 20-4D	1.250	1.250	6.000	1.250	1.500	TN..43..	02044 ¹⁾	02044 ¹⁾

1) Not in stock

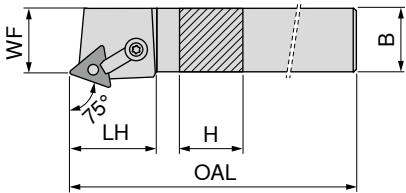
Spare parts
for article number

	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 544 01223 / 78 545 01223	00400	06800	02900	03800	01800
78 544 01643 / 78 545 01643	00400	06800	02900	03800	01800
78 544 01644 / 78 545 01644	00400	07000	03100	03800	01900
78 544 02044 / 78 545 02044	00400	07000	03100	03800	01900

Clamp	Key I	Dowel	Clamping screw	Carbide seat T
AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
00400	06800	02900	03800	01800
00400	06800	02900	03800	01800
00400	07000	03100	03800	01900
00400	07000	03100	03800	01900

CoreLine – MTRN 75° – Toolholder with top clamping

Scope of supply:
Tool holder with allen key



Illustrations show right-hand versions



Left Right

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO	
							78 547 ...	78 546 ...
MTRN R/L 12-3B	0.750	0.750	4.500	1.160	0.855	TN..33..	01223 ¹⁾	01223 ¹⁾
MTRN R/L 16-3D	1.000	1.000	6.000	1.160	1.105	TN..33..	01643 ¹⁾	01643 ¹⁾
MTRN R/L 16-4D	1.000	1.000	6.000	1.380	1.048	TN..43..	01644 ¹⁾	01644 ¹⁾
MTRN R/L 20-4D	1.250	1.250	6.000	1.380	1.298	TN..43..	02044 ¹⁾	02044 ¹⁾

1) Not in stock

Spare parts
for article number

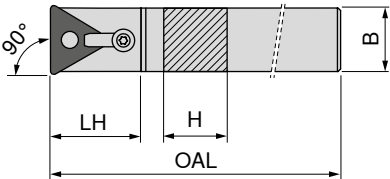
	AS	AS	AS	AS	AS
78 546 01223 / 78 547 01223	00400	06800	02900	03800	01800
78 546 01643 / 78 547 01643	00400	06800	02900	03800	01800
78 546 01644 / 78 547 01644	00400	07000	03100	03800	01900
78 546 02044 / 78 547 02044	00400	07000	03100	03800	01900

Clamp	Key I	Dowel	Clamping screw	Carbide seat T
AS	AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...

CoreLine – MTCN 90° – Toolholder with top clamping

Scope of supply:

Tool holder with allen key



ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	Neutral	
							TO	
MTCN N 44-3F	1.000	0.500	8.000	1.000	0.325	TN..33..	78 578 ...	04463 ¹⁾
MTCN N 12-4B	0.750	0.750	4.500	1.380	0.433	TN..43..		01224 ¹⁾
MTCN N 64-4F	1.000	0.750	8.000	1.380	0.433	TN..43..		06464 ¹⁾
MTCN N 66-4F	1.500	0.750	8.000	1.380	0.433	TN..43..		06664 ¹⁾

1) Not in stock

Spare parts
for article number

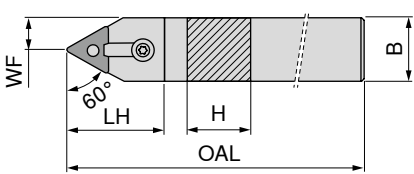
	AS	AS	AS	AS	AS
78 578 04463	00400	06800	02900	04000	01800
78 578 01224	00400	07000	03100	03800	01900
78 578 06464	00300	07000	03100	03900	01900
78 578 06664	00300	07000	03100	03900	01900

Clamp	Key I	Dowel	Clamping screw	Carbide seat T
AS	AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...

CoreLine – MTEN 60° – Toolholder with top clamping

Scope of supply:

Tool holder with allen key



Neutral

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert
MTEN NS 08-2A	0.500	0.500	4.000	1.000	0.250	TN..22..
MTEN NS 10-3B	0.625	0.625	4.500	1.130	0.313	TN..33..
MTEN NS 12-3B	0.750	0.750	4.500	1.300	0.375	TN..33..
MTEN NS 16-3D	1.000	1.000	6.000	1.300	0.500	TN..33..
MTEN NS 16-4D	1.000	1.000	6.000	1.500	0.500	TN..43..

TO
78 580 ...
00812 ¹⁾
01023 ¹⁾
01223 ¹⁾
01643 ¹⁾
01644 ¹⁾

1) Not in stock

**Spare parts
for article number**

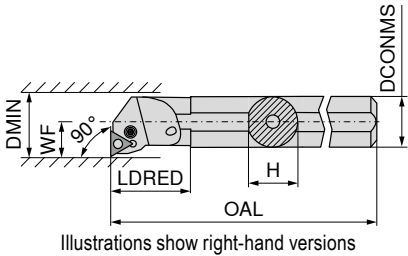
	AS	AS	AS	AS	AS
78 580 00812	00700	07000		05000	
78 580 01023	00600	06800	02900	03600	01800
78 580 01223	00400	06800	02900	03800	01800
78 580 01643	00400	06800	02900	03800	01800
78 580 01644	00400	07000	03100	03800	01900

 Clamp	 Key I	 Dowel	 Clamping screw	 Carbide seat T
AS	AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...

CoreLine – PTFN 90° – Boring bar with lever clamping

- ▲ A... = with coolant hole
- ▲ S... = without coolant hole

Scope of supply:
Boring bar with Allen key



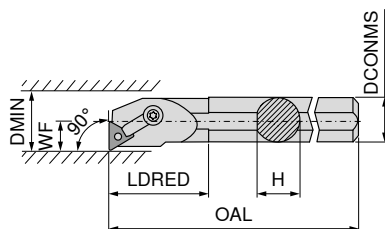
Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	Left	Right
									TO 70 565 ...	TO 70 564 ...
S25T PTFN R 16	25	23	300	36	17	32	3	TNM. 1604		02500
A25R PTFN R/L 16	25	23	200	36	17	32	3	TNM. 1604	225	225
A32S PTFN R/L 16	32	30	250	50	22	40	3	TNM. 1604	232	232
A40T PTFN R/L 22	40	38	300	60	27	50	4	TNM. 2204	240	240
S50W PTFN R 22	50	47	450	35	35	63	4	TNM. 2204		050

Spare parts
for article number

	Key I	Shim	Assembly pin	Toggle lever	Clamping screw	Carbide seat T
	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 564 02500	175	197	191	185	208	225
70 564 225 / 70 565 225	175	197	191	185	208	225
70 564 232 / 70 565 232	175	197	191	185	208	225
70 564 240 / 70 565 240	176	198	192	187	209	226
70 564 050	176	198	192	187	209	226

- ▲ A... = with thru coolant
- ▲ S... = without thru coolant

Tool holder with allen key



Illustrations show right-hand versions



Right

ANSI designation	DCONMS inch	H inch	OAL inch	LDRED inch	WF inch	DMIN inch	Indexable insert		78 711 ...	78 710 ...
A16T MTFN R/L 3	1.000	0.900	12.000	2.500	0.640	1.280	TN..33..		31616	31616
S16T MTFN R/L 3	1.000	0.900	12.000	2.500	0.640	1.280	TN..33..		31626 ¹⁾	31626 ¹⁾
A20U MTFN R/L 3	1.250	1.180	14.000	3.000	0.765	1.530	TN..33..		32020 ¹⁾	32020 ¹⁾
S20U MTFN R/L 3	1.250	1.180	14.000	3.000	0.765	1.530	TN..33..		32030 ¹⁾	32030 ¹⁾
S24U MTFN R/L 3	1.500	1.370	14.000	3.000	0.890	1.780	TN..33..		32434 ¹⁾	32434 ¹⁾
S20U MTFN R/L 4	1.250	1.180	14.000	3.000	0.765	1.530	TN..43..		42030 ¹⁾	42030 ¹⁾
S24U MTFN R/L 4	1.500	1.370	14.000	3.000	0.890	1.780	TN..43..		42434 ¹⁾	42434 ¹⁾
A24U MTFN R/L 4	1.500	1.370	14.000	3.000	0.890	1.780	TN..43..		42424 ¹⁾	42424 ¹⁾
S28U MTFN R/L 4	1.750	1.630	14.000	4.000	1.015	2.030	TN..43..		42838 ¹⁾	42838 ¹⁾
A28U MTFN R/L 4	1.750	1.630	14.000	4.000	1.015	2.030	TN..43..		42828 ¹⁾	42828 ¹⁾
A32V MTFN L 4	2.000	1.870	16.000	4.000	1.281	2.562	TN..43..		43233 ¹⁾	
S32V MTFN R/L 4	2.000	1.870	16.000	4.000	1.281	2.562	TN..43..		43242 ¹⁾	43242 ¹⁾
S40V MTFN R/L 4	2.500	2.380	16.000	4.000	1.531	3.062	TN..43..		44050 ¹⁾	44050 ¹⁾

1) Not in stock

**Spare parts
for article number**

78 710 31616 / 78 711 31616	00400	06800		03700	
78 710 31626 / 78 711 31626	00400	06800		03700	
78 710 32020 / 78 711 32020	00400	06800	02900	03800	01800
78 710 32030 / 78 711 32030	00400	06800	02900	03800	01800
78 710 32434 / 78 711 32434	00400	06800	02900	03800	01800
78 710 42030 / 78 711 42030	00400	06900	03100	03800	01900
78 710 42434 / 78 711 42434	00400	06900	03100	03800	01900
78 710 42424 / 78 711 42424	00400	06900	03100	03800	01900
78 710 42838 / 78 711 42838	00400	06900	03100	03800	01900
78 710 42828 / 78 711 42828	00400	06900	03100	03800	01900
78 711 43233	00400	06900	03100	03800	01900
78 710 43242 / 78 711 43242	00400	06900	03100	03800	01900
78 710 44050 / 78 711 44050	00400	06900	03100	03800	01900



Clamp



Key I



Dowe



Clamping screw

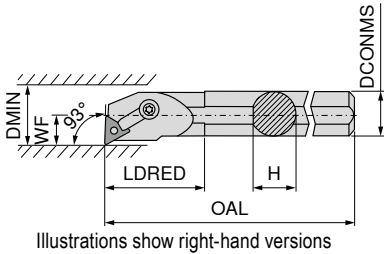


Carbide seat T

CoreLine – MTUN 93° – Boring bar with top clamping

- ▲ A... = with thru coolant
- ▲ S... = without thru coolant

Scope of supply:
Tool holder with allen key



Illustrations show right-hand versions



ANSI designation	DCONMS inch	H inch	OAL inch	LDRED inch	WF inch	DMIN inch	Indexable insert	Left	Right
								TO 78 713 ...	TO 78 712 ...
S16T MTUN R/L 3	1.000	0.900	12.000	2.500	0.640	1.280	TN..33..	31626 ¹⁾	31626 ¹⁾
S24U MTUN R/L 4	1.500	1.370	14.000	3.000	0.890	1.780	TN..43..	42434 ¹⁾	42434 ¹⁾

1) Not in stock

Spare parts
for article number

78 712 31626 / 78 713 31626	00400	06800		03700
78 712 42434 / 78 713 42434	00400	06900	03100	03800

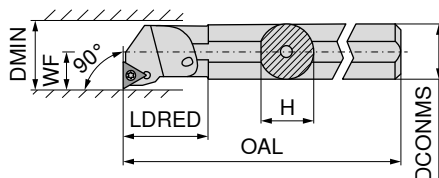
 Clamp	 Key I	 Dowel	 Clamping screw
AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...

CoreLine – STFC 90° – Boring bar with screw clamping

- ▲ A... = with thru coolant
▲ S... = without thru coolant

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



ANSI designation	DCONMS inch	H inch	OAL inch	LDRED inch	WF inch	DMIN inch	Indexable insert
S06M STFC R/L 2	0.375	0.340	6.000	0.850	0.250	0.500	TC..21.5..
A06M STFC R/L	0.375	0.340	6.000	0.850	0.250	0.500	TC..21.5..
S08M STFC R/L 2	0.500	0.460	6.000	0.800	0.312	0.625	TC..21.5..
A08M STFC R/L	0.500	0.460	6.000	0.800	0.312	0.625	TC..21.5..
S10R STFC R/L 2	0.625	0.580	8.000	0.960	0.406	0.812	TC..21.5..
A10R STFC R/L	0.625	0.580	8.000	0.960	0.406	0.812	TC..21.5..
S12S STFC R/L 2	0.750	0.710	10.000	1.420	0.500	1.000	TC..21.5..
A12S STFC R/L	0.750	0.710	10.000	1.420	0.500	1.000	TC..21.5..
S16T STFC R/L 3	1.000	0.900	12.000	1.930	0.640	1.280	TC..32.5..
S20U STFC R/L 3	1.250	1.180	14.000	1.970	0.765	1.530	TC..32.5..
S24V STFC R/L 3	1.500	1.370	16.000	2.360	0.890	1.780	TC..32.5..

Left

Right

TO	TO
78 725 ...	78 724 ...
20617 ¹⁾	20617 ¹⁾
20606	20606
20818 ¹⁾	20818 ¹⁾
20808 ¹⁾	20808 ¹⁾
21021 ¹⁾	21021 ¹⁾
21010	21010
21222 ¹⁾	21222 ¹⁾
21212 ¹⁾	21212 ¹⁾
31626 ¹⁾	31626 ¹⁾
32030 ¹⁾	32030 ¹⁾
32435 ¹⁾	32435 ¹⁾

1) Not in stock

Spare parts

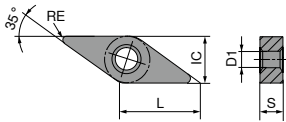
for article number

78 724 20617 / 78 725 20617
78 724 20606 / 78 725 20606
78 724 20818 / 78 725 20818
78 724 20808 / 78 725 20808
78 724 21021 / 78 725 21021
78 724 21010 / 78 725 21010
78 724 21222 / 78 725 21222
78 724 21212 / 78 725 21212
78 724 31626 / 78 725 31626
78 724 32030 / 78 725 32030
78 724 32435 / 78 725 32435

			
Clamping screw	Carbide seat T	Threaded bush	Key I - TORX®
AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...
05200			06400
05200			06400
05200			06400
06200			06400
06200			06400
06200			06400
06200			06400
06200			06400
05600			05700
05100	06100	05300	05400
05100	06100	05300	05400

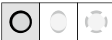
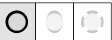
VNMG

Designation	L	S	D1	IC
	mm	mm	mm	mm
VNMG 1604..	16.6	4.76	3.81	9.52



CoreLine – Carbide turning indexable insert

VNMG

		-F50 CTCK110-P	-F40 CTCP115-P	-F40 CTCP125-P	-F50 CTCP115-P	-F50 CTCP125-P	-F50 CTCP135-P	-XU CTCP115-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		F VNMG	F VNMG	F VNMG	F VNMG	F VNMG	F VNMG	M VNMG
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	70 321 ...	76 000 ...	76 000 ...	76 156 ...	76 156 ...	76 156 ...	76 294 ...
160404EN	0.4	12801	31601	51601	31601	51601	71601	31601
160408EN	0.8	13001	31801	51801	31801	51801	71801	31801
P		○	●	●	●	●	●	●
M							○	
K		●	○	○	○	○		○
N								
S								
H								
O								

CoreLine – VNMG

VNMG

		-XU CTCP125-P	-XU CTCP135-P	-M50 CTCK110-P	-M50 CTCK120-P	-M40 CTCP115-P	-M40 CTCP125-P	-M40 CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M VNMG	M VNMG	M VNMG	M VNMG	M VNMG	M VNMG	M VNMG
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	76 294 ...	76 294 ...	70 131 ...	70 131 ...	76 001 ...	76 001 ...	76 001 ...
160404EN	0.4	51601	71601	11601	51601	31601	51601	71601
160408EN	0.8	51801	71801	11801	51801	31801	51801	71801
160412EN	1.2			12001	52001			
P		●	●	○	○	●	●	●
M			○					○
K		○		●	●	○	○	
N								
S								
H								
O								

CoreLine – Carbide turning indexable insert

VNMG

		-M50 CTCP115-P	-M50 CTCP125-P	-M50 CTCP135-P	-F30 CTCM120	-F30 CTPM125	-F30 CTCM130	-M30 CTCM120
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M VNMG	M VNMG	M VNMG	F VNMG	F VNMG	F VNMG	M VNMG
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	76 131 ...	76 131 ...	76 131 ...	75 022 ...	75 022 ...	75 022 ...	75 023 ...
160404EN	0.4	31601	51601	71601	11600	216	31600	
160408EN	0.8	31801	51801	71801	11800	218	31800	
160412EN	1.2	32001	52001	72001				11800
P		●	●	●	○	○	○	○
M				○	●	●	●	●
K		○	○					
N								
S							○	
H								
O								

CoreLine – Carbide turning indexable insert

VNMG

ISO	RE mm
160404EN	0.4
160408EN	0.8
160412EN	1.2

TR
75 023 ...
218

TR
75 023 ...
31800

TR
75 009 ...
61600
61800
62000

-M30
CTPM125

DRAGONSKIN

M
VNMG

-M30
CTCM130

DRAGONSKIN

M
VNMG

-M34
CTPX710

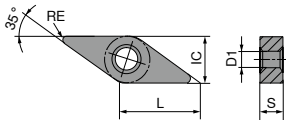
DRAGONSKIN

M
VNMG

P	○	○	●
M	●	●	●
K			
N			○
S		○	●
H			
O			

VNMG

Designation	L	S	D1	IC
	mm	mm	mm	mm
VNMG 1604..	16.6	4.76	3.81	9.52



CoreLine – Carbide turning indexable insert

VNMG

ISO	RE mm
160404EN	0.4
160408EN	0.8

-FMS
CT-P15



F
VNMG

-FMS
CT-P25



F
VNMG

CX

75 310 ...

01609

01809

CX

75 310 ...

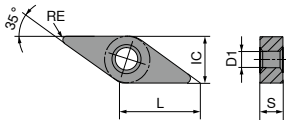
11609

11809

P		●	●
M		○	○
K			
N			
S			
H			
O			

VNGP

Designation	L	S	D1	IC
	mm	mm	mm	mm
VNGP 1604..	16.6	4.76	3.81	9.52



CoreLine – Carbide turning indexable insert

VNGP

-F32
CTP2120



F
VNGP

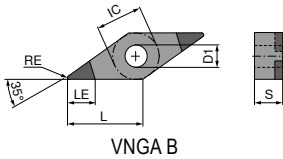
ISO	RE mm
160402FN	0.2
160404FN	0.4

TR
70 167 ...
602
604

P	
M	
K	
N	
S	
H	
O	

VNGA

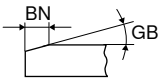
Designation	L	S	D1	IC
	mm	mm	mm	mm
VNGA 1604..	16.6	4.76	3.81	9.52



CoreLine – PcBN turning indexable insert

VNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners



CTBH1000C	CTBH2000C	CTBH3000C
F	F	F
PCBN	PCBN	PCBN
VNGA	VNGA	VNGA
PC	PC	PC
71 042 ...	71 042 ...	71 042 ...
70002	80002	90002
70302	80302	90302

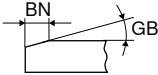
ISO	RE	BN	GB	TCE (NOI)	LE
	mm	mm			mm
160404EN	0.4			B (2)	5.1
160404SN	0.4	0.14	20°	B (2)	5.1
160408EN	0.8			B (2)	4.2
160408SN	0.8	0.14	20°	B (2)	4.2

P			
M			
K			
N			
S			
H			
O			

CoreLine – PcBN turning indexable insert

VNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners



CTBH1000C	CTBH2000C	CTBH3000C
M	M	M
PCBN	PCBN	PCBN
VNGA	VNGA	VNGA
PC	PC	PC
71 042 ...	71 042 ...	71 042 ...
70102	80102	90102
70402	80402	90402

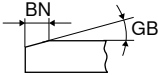
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
160404SN	0.4	0.09	15°	B (2)	5.1
160404SN	0.4	0.18	25°	B (2)	5.1
160408SN	0.8	0.09	15°	B (2)	4.2
160408SN	0.8	0.18	25°	B (2)	4.2

P			
M			
K			
N			
S			
H			
O			

CoreLine – PcBN turning indexable insert

VNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners



CTBH1000C

R

PCBN

VNGA

PC

71 042 ...

70202

70502

CTBH2000C

R

PCBN

VNGA

PC

71 042 ...

80202

80502

CTBH3000C

R

PCBN

VNGA

PC

71 042 ...

90202

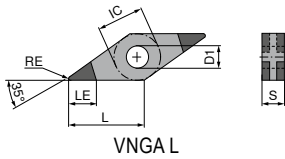
90502

ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
160404SN	0.4	0.14	20°	B (2)	5.1
160404SN	0.4	0.20	35°	B (2)	5.1
160408SN	0.8	0.14	20°	B (2)	4.2
160408SN	0.8	0.20	35°	B (2)	4.2

P			
M			
K			
N			
S			
H			
O			

VNGA

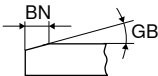
Designation	L	S	D1	IC
VNGA 1604..	mm 16.6	mm 4.76	mm 3.81	mm 9.52



CoreLine – PcBN turning indexable insert

VNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners



CTBH20C	CTBH40C



F	F
CBN	CBN
VNGA	VNGA

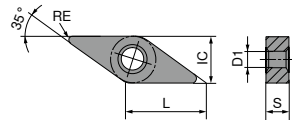
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
160404TN	0.4	0.11	25°	L (4)	2.8
160404SN	0.4	0.13	25°	L (4)	2.8
160408SN	0.8	0.11	20°	L (4)	2.2
160408SN	0.8	0.11	25°	L (4)	2.2

PC	PC
71 413 ...	71 413 ...
30200	60200
30400	60700

P	
M	
K	
N	
S	
H	• •
O	

VNGA

Designation	L	S	D1	IC
VNGA 1604..	mm 16.6	mm 4.76	mm 3.81	mm 9.52



CoreLine – CERAMIC turning indexable insert

VNGA

CTSH110



F
CERAMIC
VNGA

ISO	RE
160408TN	mm 0.8

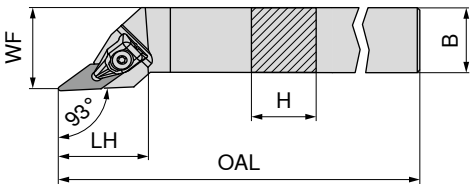
IC
71 459 ...
10002

P	
M	
K	○
N	
S	
H	●
O	

CoreLine – DVJN 93° – Tool holder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
DVJN R/L 2020 K16	20	20	125	39	25	2	VN.. 1604
DVJN R/L 2525 M16	25	25	150	39	32	2	VN.. 1604

Left	Right
TO	TO
70 503 ...	70 502 ...
620	620
725	725

Spare parts
for article number

70 502 620 / 70 503 620	835	T09 - IP	118	M3x7 - 09IP	819	806
70 502 725 / 70 503 725	835	T09 - IP	118	M3x7 - 09IP	819	806



XPress range

AS

70 950 ...



Screwdriver

AS

80 950 ...



Clamping screw

AS

70 950 ...



Carbide seat V

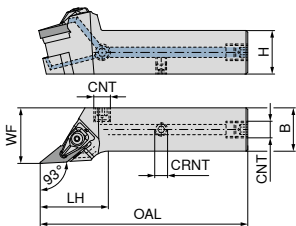
AS

70 950 ...

CoreLine – DVJN 93° DC – tool holder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Left Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	TO 70 511 ...	TO 70 511 ...
DVJN R/L 2020 X16 DC	20	20	104	35	25	2	VN.. 1604	62000	62001
DVJN R/L 2525 X16 DC	25	25	119	35	32	2	VN.. 1604	62500	62501

Spare parts
for article number

70 511 62001 / 70 511 62000	M3x7 - 09IP	819	806	M6x6	86700
70 511 62501 / 70 511 62500	M3x7 - 09IP	819	806	M6x6	86700



Clamping screw

AS

70 950 ...



Carbide seat V

AS

70 950 ...



Set Screw

AS

70 950 ...

Spare parts
for article number

70 511 62001 / 70 511 62000	835	T09 - IP	118	G 1/8"	294
70 511 62501 / 70 511 62500	835	T09 - IP	118	G 1/8"	294



XPress range

AS

70 950 ...



Screwdriver

AS

80 950 ...



Coolant screw plug

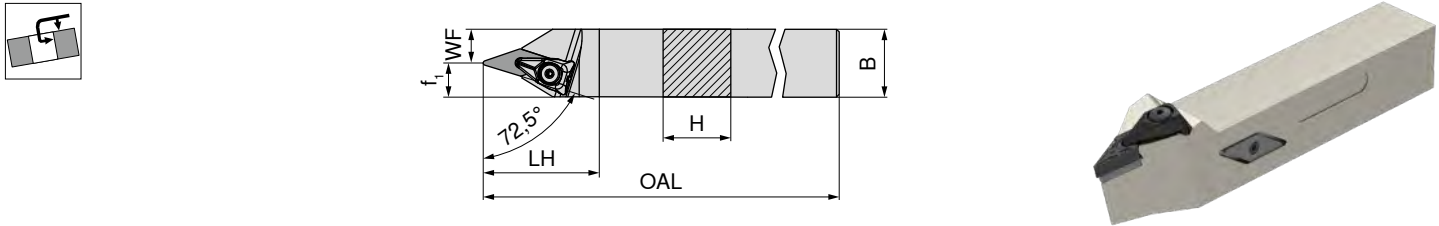
AS

70 950 ...

CoreLine – DVVN 72.5° – Tool holder with top clamping

Scope of supply:

Tool holder with Torx key



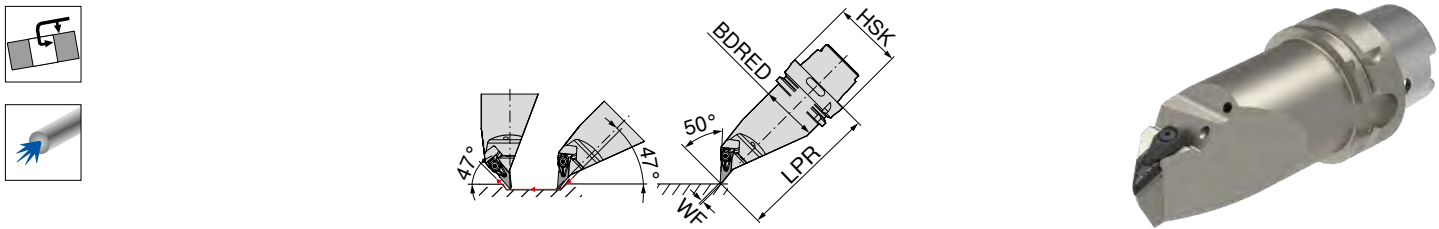
Designation	H mm	B mm	OAL mm	LH mm	WF mm	f ₁ mm	Tightening torque Nm	Indexable insert	Neutral	
									TO	
DVVN N 2020 K16	20	20	125	43	7.5	12.5	2	VN.. 1604	70 506 ...	620
DVVN N 2525 M16	25	25	150	43	12.5	12.5	2	VN.. 1604		625

Spare parts
for article number

70 506 620	835	T09 - IP	118	M3x7 - 09IP	819	806
70 506 625	835	T09 - IP	118	M3x7 - 09IP	819	806

CoreLine – DVMN 50° – Tool holder with top clamping

Scope of supply:
Tool holder with Torx key



Designation	Adapter	LPR mm	BDRED mm	WF mm	Tightening torque Nm	Indexable insert
HSK T63 DVMN L 16	HSK-T 63	130	53	0	2	VN.. 1604

Left

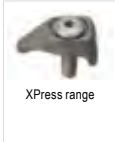
TO

74 525 ...

516

Spare parts
for article number

74 525 516	835	T09 - IP	118	M3x7 - 09IP	819	806
------------	-----	----------	-----	-------------	-----	-----

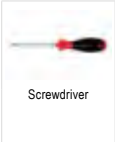


XPress range

AS

70 950 ...

835

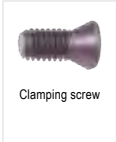


Screwdriver

AS

80 950 ...

118

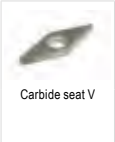


Clamping screw

AS

70 950 ...

819



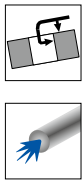
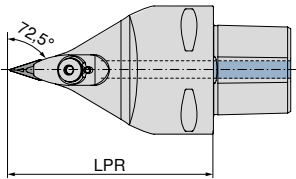
Carbide seat V

AS

70 950 ...

806

CoreLine – DVVN 72.5° – Tool holder with top clamping



Neutral

Designation	Adapter	LPR mm	Tightening torque Nm	Indexable insert
PSC63 DVVN N 0100-16	PSC 63	100	10	VN.. 1604
PSC63 DVVN N 0130-16	PSC 63	130	10	VN.. 1604

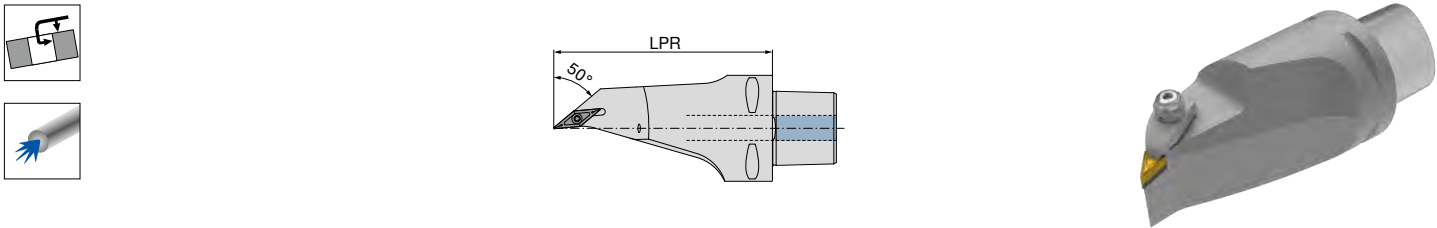
TO
84 679 ...
01693
11693

Spare parts
for article number

84 679 01693	M6X28 SW4	28300	28500	28400	27600	28000
84 679 11693	M6X28 SW4	28300	28500	28400	27600	28000

				
Clamping screw	Clamping claw	Ring-shaped nozzle	Clamping screw	Carbide seat V
AS	AS	AS	AS	AS
84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...

CoreLine – DVMN 50° – Tool holder with top clamping



Designation	Adapter	LPR mm	Tightening torque Nm	Indexable insert
PSC63 DVMN L 0130-16	PSC 63	130	10	VN.. 1604

Neutral
TO
84 682 ...
01693

Spare parts
for article number

84 682 01693

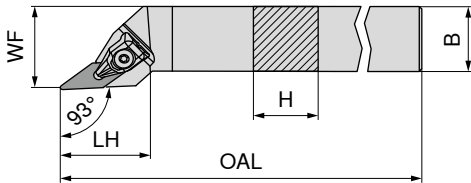
M6X28 SW4

				
Clamping screw	Clamping claw	Ring-shaped nozzle	Clamping screw	Carbide seat V
AS	AS	AS	AS	AS
84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...
28300	28600	28400	27600	28000

CoreLine – DVJN 93° – Toolholder with top clamping

- ▲ ...A-N = with thru coolant
- ▲ ...N = without thru' coolant

Scope of supply:
Tool holder with allen key



Illustrations show right-hand versions



Left Right

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO 78 513 ...	TO 78 512 ...
DVJN R/L 12-3BA-N	0.750	0.750	4.500	1.750	1.000	VN..33..	01276	01276
DVJN R/L 16-3DA-N	1.000	1.000	6.000	1.750	1.250	VN..33..	01698	01698
DVJN R/L 20-3DA-N	1.250	1.250	6.000	1.750	1.500	VN..33..	02098	02098
DVJN R/L 24-3EA-N	1.500	1.500	7.000	1.750	2.000	VN..33..	02495 ¹⁾	02495 ¹⁾

1) Not in stock

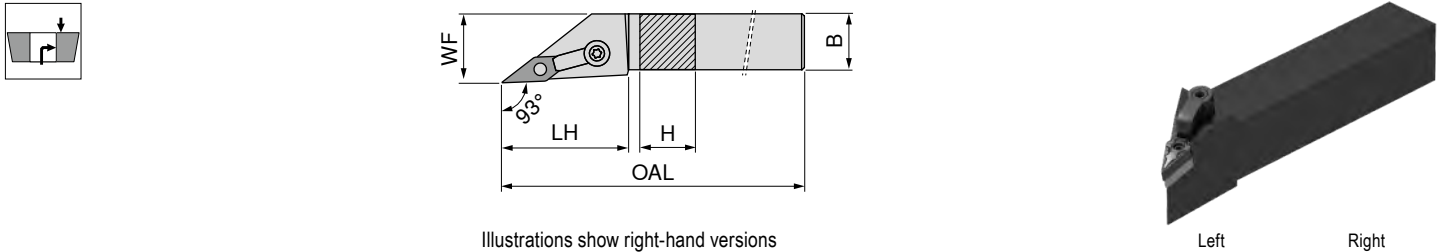
for article number

78 512 01276 / 78 513 01276	07500	08100	07900	02200	08400	08000
78 512 01698 / 78 513 01698	07500	08100	07900	02200	08400	08000
78 512 02098 / 78 513 02098	07500	08100	07900	02200	08400	08000
78 512 02495 / 78 513 02495	07500	08100	07900	02200	08400	08000

 Clamping claw	 Key I	 Clamping screw	 Carbide seat V	 Threaded bush	 Spring
AS	AS	AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...

CoreLine – MVJN 93° – Toolholder with top clamping

Scope of supply:
Tool holder with allen key



Illustrations show right-hand versions

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	Left TO	Right TO
MVJN R/L 12-3B	0.750	0.750	4.500	1.620	1.000	VN..33..	78 549 ...	78 548 ...
MVJN R/L 16-3D	1.000	1.000	6.000	1.620	1.250	VN..33..	01223 ¹⁾	01223 ¹⁾
MVJN R/L 20-3D	1.250	1.250	6.000	1.620	1.500	VN..33..	01643 ¹⁾	01643 ¹⁾
							02043 ¹⁾	02043 ¹⁾

1) Not in stock

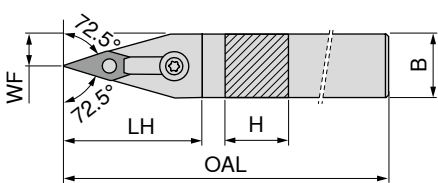
Spare parts
for article number

	Clamp	Key I	Dowel	Clamping screw	Carbide seat V
78 548 01223 / 78 549 01223	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 548 01643 / 78 549 01643	09000	06800	02900	03800	02200
78 548 02043 / 78 549 02043	09000	06800	02900	03800	02200

CoreLine – MVVN 72.5° – Toolholder with top clamping

Scope of supply:

Tool holder with allen key



Neutral

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO	
							78 581 ...	
MVVN N 12-3B	0.750	0.750	4.500	1.620	0.375	VN..33..		01223 ¹⁾
MVVN N 16-3B	1.000	1.000	4.500	1.620	0.500	VN..33..		01623 ¹⁾
MVVN N 20-3D	1.250	1.250	6.000	1.620	0.625	VN..33..		02043 ¹⁾
MVVN N 24-3E	1.500	1.500	7.000	1.620	0.750	VN..33..		02453 ¹⁾

1) Not in stock

Spare parts
for article number

	AS	AS	AS	AS	AS
78 581 01223	09000	06800	02900	03800	02200
78 581 01623	09000	06800	02900	03800	02200
78 581 02043	09000	06800	02900	03800	02200
78 581 02453	09000	06800	02900	03800	02200



Clamp

AS

78 950 ...



Key I

AS

78 950 ...



Dowel

AS

78 950 ...



Clamping screw

AS

78 950 ...



Carbide seat V

AS

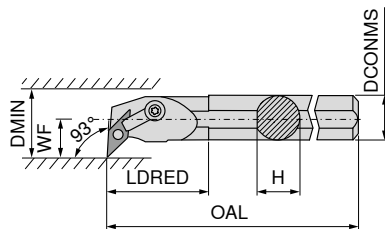
78 950 ...

CoreLine – MVUN 93° – Boring bar with top clamping

- ▲ A... = with thru coolant
▲ S... = without thru coolant

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left

Right

ANSI designation	DCONMS inch	H inch	OAL inch	LDRED inch	WF inch	DMIN inch	Indexable insert	TO 78 715 ...	TO 78 714 ...
A16T MVUN R/L 3	1.000	0.900	12.000	2.500	1.000	2.000	VN..33..	31616	31616
S16T MVUN R/L 3	1.000	0.900	12.000	2.500	1.000	2.000	VN..33..	31626 ¹⁾	31626 ¹⁾
A20U MVUN R/L 3	1.250	1.180	14.000	3.000	1.125	2.250	VN..33..	32020 ¹⁾	32020 ¹⁾
S20U MVUN R/L 3	1.250	1.180	14.000	3.000	1.125	2.250	VN..33..	32030 ¹⁾	32030 ¹⁾
S24U MVUN R/L 3	1.500	1.370	14.000	3.000	1.250	2.500	VN..33..	32434 ¹⁾	32434 ¹⁾
A24U MVUN R/L 3	1.500	1.370	14.000	3.000	1.250	2.500	VN..33..	32424 ¹⁾	32424 ¹⁾

¹⁾ Not in stock

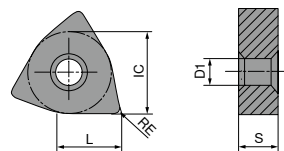
Spare parts

for article number

	Clamp	Key I	Dowel	Clamping screw	Carbide seat V
	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 714 31616 / 78 715 31616	09000	06800	02900	03700	02200
78 714 31626 / 78 715 31626	09000	06800	02900	03700	02200
78 714 32020 / 78 715 32020	09000	06800	02900	03800	02200
78 714 32030 / 78 715 32030	09000	06800	02900	03800	02200
78 714 32434 / 78 715 32434	09000	06800	02900	03800	02200
78 714 32424 / 78 715 32424	09000	06800	02900	03800	02200

WNMG / WNMA

Designation	L	S	D1	IC
	mm	mm	mm	mm
WNMG 0604..	6.5	4.76	3.81	9.52
WNM. 0804..	8.6	4.76	5.16	12.70



CoreLine – Carbide turning indexable insert

WNMG

		-CF20 CTEP110-P	-TFQ CTEP110-P	-F50 CTCK110-P	-F50 CTCP115-P	-F50 CTCP125-P	-F50 CTCP135-P	-TFQ CTCK110-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F	F	F	F	F	F	F
		CERMET	CERMET	WNMG	WNMG	WNMG	WNMG	WNMG
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	76 171 ...	76 177 ...	70 322 ...	76 157 ...	76 157 ...	76 157 ...	70 314 ...
060404EN	0.4	00401		10401	30401	50401	70401	10401
060408EN	0.8	00601	00601	10601	30601	50601	70601	
060408EN	0.4							10601
080404EN	0.4		01601	11601	31601	51601	71601	
080408EN	0.8	01801	01801	11801	31801	51801	71801	11801
080412EN	1.2				32001	52001	72001	12001
P		●	●	○	●	●	●	○
M		○	○				○	
K		○	○	●	○	○		●
N								
S								
H								
O								

CoreLine – Carbide turning indexable insert

WNMG

		-TFQ CTCP115-P		-TFQ CTCP125-P		-XU CTCP115-P		-XU CTCP125-P		-XU CTCP135-P		-M50 CTCK110-P		-M50 CTCK120-P	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
		F WNMG		F WNMG		M WNMG		M WNMG		M WNMG		M WNMG		M WNMG	
		TR 76 177 ...		TR 76 177 ...		TR 76 295 ...		TR 76 295 ...		TR 76 295 ...		TR 70 139 ...		TR 70 139 ...	
ISO	RE mm	30401 30601		51401 50601								10401 10601 10801		50401 50601 50801	
060404EN	0.4														
060408EN	0.8														
060412EN	1.2														
080404EN	0.4					31601		51601		71601		11601		51601	
080408EN	0.8	31801		51801		31801		51801		71801		11801		51801	
080412EN	1.2	32001		52001		32001		52001		72001		12001		52001	
080416EN	1.6											12201		52201	
P		●		●		●		●		●		○		○	
M										○					
K		○		○		○		○				●		●	
N															
S															
H															
O															

CoreLine – Carbide turning indexable insert

WNMG

		<div><div><div><div>-M50</div><div>CTCP115-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div></div><div><div>M</div><div>WNMG</div></div></div></div>	<div><div><div><div>-M50</div><div>CTCP125-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div></div><div><div>M</div><div>WNMG</div></div></div></div>	<div><div><div><div>-M50</div><div>CTCP135-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div></div><div><div>M</div><div>WNMG</div></div></div></div>	<div><div><div><div>-TMQ</div><div>CTCK110-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div></div><div><div>M</div><div>WNMG</div></div></div></div>	<div><div><div><div>-TMQ</div><div>CTCP115-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div></div><div><div>M</div><div>WNMG</div></div></div></div>	<div><div><div><div>-TMQ</div><div>CTCP125-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div></div><div><div>M</div><div>WNMG</div></div></div></div>	<div><div><div><div>-M70</div><div>CTCK110-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div></div><div><div>M</div><div>WNMG</div></div></div></div>
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	76 139 ...	76 139 ...	76 139 ...	70 318 ...	76 198 ...	76 198 ...	70 273 ...
060404EN	0.4	30401	50401	70401				
060408EN	0.8	30601	50601	70601				
060412EN	1.2	30801	50801	70801				
080404EN	0.4	31601	51601	71601				
080408EN	0.8	31801	51801	71801	11801	31801	51801	11801
080412EN	1.2	32001	52001	72001	12001	32001	52001	12001
080416EN	1.6	32201	52201	72201				12201
P		●	●	●	○	●	●	○
M				○				
K		○	○		●	○	○	●
N								
S								
H								
O								

CoreLine – Carbide turning indexable insert

WNMG / WNMA

		<div><div><div><div>-M70</div><div>CTCK120-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div></div><div><div>M</div><div>WNMG</div></div></div></div>	<div><div><div><div>-M70</div><div>CTCP115-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div></div><div><div>M</div><div>WNMG</div></div></div></div>	<div><div><div><div>-M70</div><div>CTCP125-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div></div><div><div>M</div><div>WNMG</div></div></div></div>	<div><div><div><div>-M70</div><div>CTCP135-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div></div><div><div>M</div><div>WNMG</div></div></div></div>	<div><div><div><div>CTCK110-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div></div><div><div>R</div><div>WNMA</div></div></div></div>	<div><div><div><div>CTCK120-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div></div><div><div>R</div><div>WNMA</div></div></div></div>	<div><div><div><div>-F30</div><div>CTCM120</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div></div><div><div>F</div><div>WNMG</div></div></div></div>
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	70 273 ...	76 273 ...	76 273 ...	76 273 ...	70 169 ...	70 169 ...	75 024 ...
060404EN	0.4							10400
060408EN	0.8		30601	50601	70601			10600
060412EN	1.2		30801	50801	70801			
080404EN	0.4							11600
080408EN	0.8	51801	31801	51801	71801	11801	51801	11800
080412EN	1.2	52001	32001	52001	72001	12001	52001	
080416EN	1.6	52201	32201	52201	72201	12201	52201	
P		○	●	●	●	○	○	○
M					○			●
K		●	○	○		●	●	
N								
S								
H								
O								

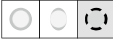
CoreLine – Carbide turning indexable insert

WNMG

		<div><div>-F30</div><div>CTPM125</div></div>		<div><div>-F30</div><div>CTCM130</div></div>		<div><div>-M30</div><div>CTCM120</div></div>		<div><div>-M30</div><div>CTPM125</div></div>		<div><div>-M30</div><div>CTCM130</div></div>		<div><div>-M42</div><div>CTCM130</div></div>		<div><div>-M60</div><div>CTCM120</div></div>	
		<div>DRAGONSKIN</div>		<div>DRAGONSKIN</div>		<div>DRAGONSKIN</div>		<div>DRAGONSKIN</div>		<div>DRAGONSKIN</div>		<div>DRAGONSKIN</div>		<div>DRAGONSKIN</div>	
															
		<div><div>F</div><div>WNMG</div></div>		<div><div>F</div><div>WNMG</div></div>		<div><div>M</div><div>WNMG</div></div>		<div><div>M</div><div>WNMG</div></div>		<div><div>M</div><div>WNMG</div></div>		<div><div>M</div><div>WNMG</div></div>		<div><div>M</div><div>WNMG</div></div>	
		<div>TR</div>		<div>TR</div>		<div>TR</div>		<div>TR</div>		<div>TR</div>		<div>TR</div>		<div>TR</div>	
		75 024 ...		75 024 ...		75 025 ...		75 025 ...		75 025 ...		75 036 ...		75 026 ...	
		204		30400								30400			
		206		30600		10600		206		30600		30600		10600	
						10800		208		30800				10800	
		216		31600								31600			
		218		31800		11800		218		31800		31800		11800	
						12000		220		32000		32000		12000	
ISO		RE													
		mm													
060404EN		0.4													
060408EN		0.8													
060412EN		1.2													
080404EN		0.4													
080408EN		0.8													
080412EN		1.2													
P		○		○		○		○		○		○		○	
M		●		●		●		●		●		●		●	
K															
N															
S															
H															
O															

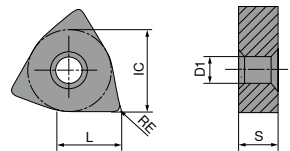
CoreLine – Carbide turning indexable insert

WNMG

		-M60 CTPM125		-M60 CTCM130		-M70 CTCM130		-F34 CTPX710		-M34 CTPX710	
		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin	
											
											
		M WNMG		M WNMG		M WNMG		F WNMG		M WNMG	
		TR		TR		TR		TR		TR	
		75 026 ...		75 026 ...		75 041 ...		75 313 ...		75 008 ...	
		206		30600		30600					
		208		30800							
		218		31800		31800		61800		61800	
		220		32000		32000				62000	
		P		○		○		○		●	
		M		●		●		●		●	
		K									
		N						○		○	
		S				○		○		●	
		H									
		O									

WNMG

Designation	L	S	D1	IC
	mm	mm	mm	mm
WNMG 0604..	6.5	4.76	3.81	9.52
WNMG 0804..	8.6	4.76	5.16	12.70



CoreLine – Carbide turning indexable insert

WNMG

ISO	RE mm
060404EN	0.4
060408EN	0.8
080404EN	0.4
080408EN	0.8

-M42

CTP2120

M

WNMG

TR

70 178 ...

608

-M52

CTP2120

M

WNMG

TR

70 179 ...

604

608

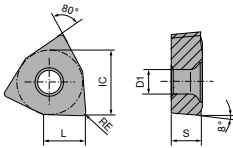
612

614

P
M
K
N
S
H
O

WNMU

Designation	L	S	D1	IC
	mm	mm	mm	mm
WNMU 0806..	8.6	6.35	4.4	12.7



CoreLine – Carbide turning indexable insert

WNMU

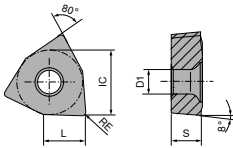
-XU CTCK110-P	-M50 CTCK110-P	-M50 CTCK120-P
DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
M WNMU	M WNMU	M WNMU
TR	TR	TR
70 423 ... 11801 ¹⁾	70 432 ... 11801 ¹⁾	70 432 ... 52001 ¹⁾

ISO	RE mm	70 423 ...	70 432 ...	70 432 ...
080608EN	0.8	11801 ¹⁾	11801 ¹⁾	
080612EN	1.2			52001 ¹⁾
P		○	○	○
M				
K		●	●	●
N				
S				
H				
O				

1) Not in stock

WNMU

Designation	L	S	D1	IC
	mm	mm	mm	mm
WNMU 0804..	8.6	4.76	4.7	12.7
WNMU 0806..	8.6	6.35	4.4	12.7



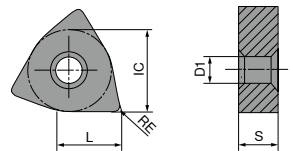
CoreLine – Carbide turning indexable insert

WNMU

		<div><div>-XU</div><div>CTCP115-P</div></div>	<div><div>-XU</div><div>CTCP125-P</div></div>	<div><div>-M30</div><div>CTCP115-P</div></div>	<div><div>-M50</div><div>CTCP115-P</div></div>	<div><div>-M50</div><div>CTCP125-P</div></div>	<div><div>-TMQ</div><div>CTCP115-P</div></div>
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M	M	M	M	M	M
		WNMU	WNMU	WNMU	WNMU	WNMU	WNMU
		TR	TR	TR	TR	TR	TR
ISO	RE	76 421 ...	76 421 ...	76 283 ...	76 431 ...	76 431 ...	76 286 ...
	mm						
080412EN	1.2						
080608EN	0.8	31801	51801	31801	31801 32001	51801 52001	32001
080612EN	1.2						
P		●	●	●	●	●	●
M							
K		○	○	○	○	○	○
N							
S							
H							
O							

WNMG

Designation	L	S	D1	IC
	mm	mm	mm	mm
WNMG 0804..	8.6	4.76	5.16	12.7



CoreLine – Carbide turning indexable insert

WNMG

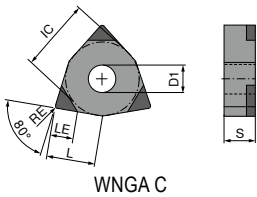
ISO	RE mm
080404EN	0.4
080408EN	0.8
080412EN	1.2

-FMS CT-P15	-FMS CT-P25	-MRS CT-P15	-MRS CT-P25	-MRS CT-P35
F WNMG	F WNMG	M WNMG	M WNMG	M WNMG
CX 75 311 ... 01609 01809 02009	CX 75 311 ... 11609 11809 12009	CX 75 312 ... 01809 02009	CX 75 312 ... 11809 12009	CX 75 312 ... 21809 22009

P	●	●	●	●	●
M	○	○	○	○	○
K					
N					
S					
H					
O					

WNGA

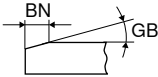
Designation	L	S	D1	IC
	mm	mm	mm	mm
WNGA 0804...	8.5	4.76	5.13	12.7



CoreLine – PcBN turning indexable insert

WNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners



CTBH1000C	CTBH2000C	CTBH3000C
F	F	F
PCBN	PCBN	PCBN
WNGA	WNGA	WNGA
PC	PC	PC
71 044 ...	71 044 ...	71 044 ...
70002	80002	90002
70302	80302	90302

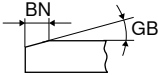
ISO	RE	BN	GB	TCE	LE
	mm	mm		(NOI)	mm
080408EN	0.8			C (3)	3.3
080408SN	0.8	0.14	20°	C (3)	3.3
080412EN	1.2			C (3)	3.1
080412SN	1.2	0.14	20°	C (3)	3.1

P			
M			
K			
N			
S			
H			
O			

CoreLine – PcBN turning indexable insert

WNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners



CTBH1000C	CTBH2000C	CTBH3000C
M	M	M
PCBN	PCBN	PCBN
WNGA	WNGA	WNGA
PC	PC	PC
71 044 ...	71 044 ...	71 044 ...
70102	80102	90102
70402	80402	90402

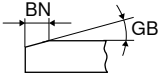
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
080408SN	0.8	0.09	15°	C (3)	3.3
080408SN	0.8	0.18	25°	C (3)	3.3
080412SN	1.2	0.09	15°	C (3)	3.1
080412SN	1.2	0.18	25°	C (3)	3.1

P			
M			
K			
N			
S			
H			
O			

CoreLine – PcBN turning indexable insert

WNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners



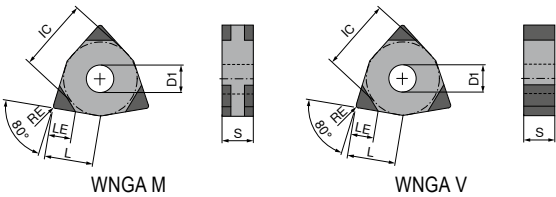
CTBH1000C	CTBH2000C	CTBH3000C
R	R	R
PCBN	PCBN	PCBN
WNGA	WNGA	WNGA
PC	PC	PC
71 044 ...	71 044 ...	71 044 ...
70202	80202	90202
70502	80502	90502

ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
080408SN	0.8	0.14	20°	C (3)	3.3
080408SN	0.8	0.20	35°	C (3)	3.3
080412SN	1.2	0.14	20°	C (3)	3.1
080412SN	1.2	0.20	35°	C (3)	3.1

P			
M			
K			
N			
S			
H			
O			

WNGA

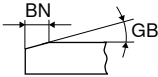
Designation	L	S	D1	IC
	mm	mm	mm	mm
WNGA 0804...	8.5	4.76	5.13	12.7



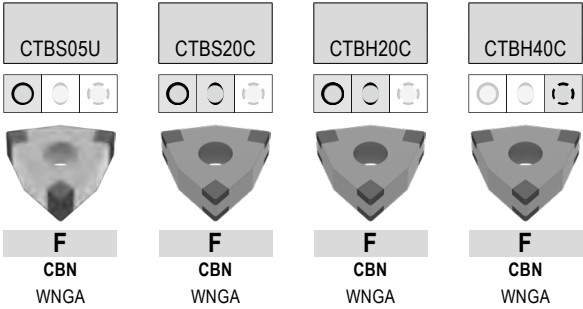
CoreLine – PcBN turning indexable insert

WNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners



ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
080404SN	0.4	0.09	15°	M (6)	2.8
080404SN	0.4	0.09	20°	M (6)	2.8
080404TN	0.4	0.20	30°	V (3)	4.5
080408SN	0.8	0.09	10°	M (6)	2.5
080408SN	0.8	0.09	15°	M (6)	2.5
080408SN	0.8	0.09	20°	M (6)	2.5
080408SN	0.8	0.11	20°	M (6)	2.5
080408SN	0.8	0.11	25°	M (6)	2.5
080408SN	0.8	0.13	25°	M (6)	2.5
080408SN	0.8	0.16	25°	M (6)	2.5
080408SN	0.8	0.14	30°	M (6)	2.5
080408TN	0.8	0.20	30°	V (3)	4.2
080412TN	1.2	0.20	30°	V (3)	4.0

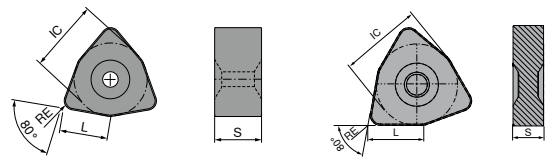


PC	PC	PC	PC
71 415 ...	71 405 ...	71 405 ...	71 405 ...
00200	132 152		
	124 134 154	244	334
	174		354 364
00400			376
00600			

P				
M				
K				
N				
S				
H				
O				

WNGX-C / WNNX-C

Designation	L	S	IC
	mm	mm	mm
WN.X 0807..	8.69	7.94	12.7
WNGX 0804..	8.69	4.76	12.7



CoreLine – PcBN turning indexable insert

WNGX-C

CTBK102

F

CBN

WNGX-C

PC

71 469 ...

30002

CTBK103

F

CBN

WNGX-C

PC

71 473 ...

40002

ISO	RE
	mm
080416TN	1.6

P	
M	
K	● ●
N	
S	○ ○
H	○ ○
O	

CoreLine – CERAMIC turning indexable insert

WNGX-C / WNNX-C

ISO	RE mm
080408TN	0.8
080712TN	1.2
080716TN	1.6

P
M
K
N
S
H
O

CTN3105

F

CERAMIC

WNGX-C

IC

71 444 ...

90201

90001

90101

CTN3105

F

CERAMIC

WNNX-C

IC

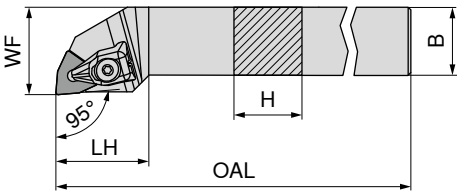
71 445 ...

90001

CoreLine – DWLN 95° – Tool holder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

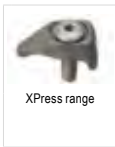


Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
DWLN R/L 1616 H06	16	16	100	25	20	2	WN.. 0604
DWLN R/L 2020 K06	20	20	125	27	25	2	WN.. 0604
DWLN R/L 2525 M06	25	25	150	27	32	2	WN.. 0604
DWLN R/L 2020 K08	20	20	125	34	25	4	WN.. 0804
DWLN R/L 2525 M08	25	25	150	34	32	4	WN.. 0804

Left	Right
TO	TO
70 543 ...	70 542 ...
716	716
720	720
725	725
620	620
625	625

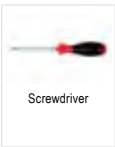
Spare parts
for article number

70 542 716 / 70 543 716	823	T09 - IP	118	M3x7 - 09IP	819	807
70 542 720 / 70 543 720	823	T09 - IP	118	M3x7 - 09IP	819	807
70 542 725 / 70 543 725	823	T09 - IP	118	M3x7 - 09IP	819	807
70 542 620 / 70 543 620	824	T15 - IP	120	M4,5x12 - 15IP	820	812
70 542 625 / 70 543 625	824	T15 - IP	120	M4,5x12 - 15IP	820	812



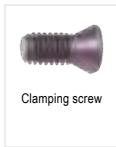
AS

70 950 ...



AS

80 950 ...



AS

70 950 ...

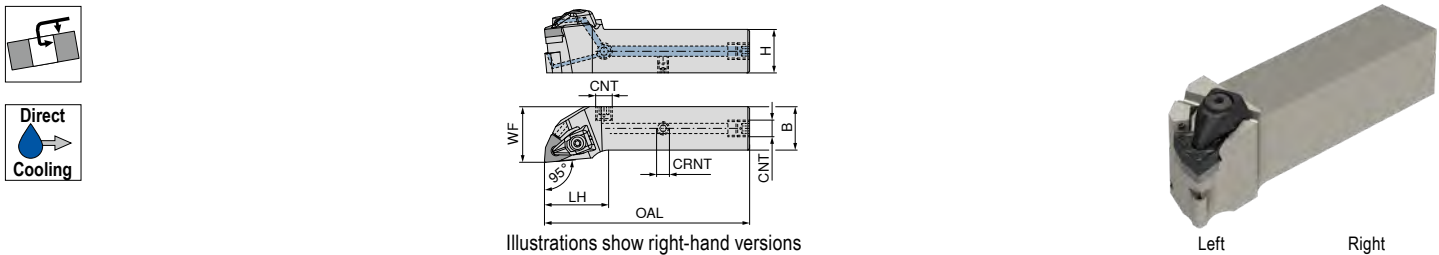


AS

70 950 ...

CoreLine – DWLN 95° DC – tool holder with top clamping

Scope of supply:
Tool holder with Torx key



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	Left	Right
								TO 70 547 ...	TO 70 547 ...
DWLN R/L 2020 X06 DC	20	20	94	25	25	2	WN.. 0604	62000	62001
DWLN R/L 2525 X06 DC	25	25	109	25	32	2	WN.. 0604	62500	62501
DWLN R/L 2020 X08 DC	20	20	100	31	25	4	WN.. 0804	72000	72001
DWLN R/L 2525 X08 DC	25	25	118	34	32	4	WN.. 0804	72500	72501

Spare parts
for article number

		Clamping screw	Carbide seat W	Set Screw
		AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 547 62001 / 70 547 62000	M3x7 - 09IP	819	807	M6x6 86700
70 547 62501 / 70 547 62500	M3x7 - 09IP	819	807	M6x6 86700
70 547 72001 / 70 547 72000	M4,5x12 - 15IP	820	812	M6x6 86700
70 547 72501 / 70 547 72500	M4,5x12 - 15IP	820	812	M6x6 86700

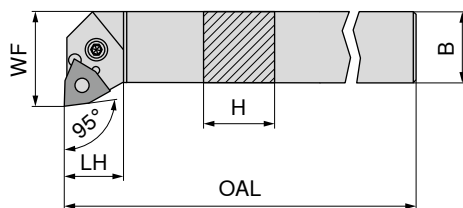
Spare parts
for article number

		XPress range	Screwdriver	Coolant screw plug
		AS 70 950 ...	AS 80 950 ...	AS 70 950 ...
70 547 62001 / 70 547 62000	T09 - IP	823	118	G 1/8" 294
70 547 62501 / 70 547 62500	T09 - IP	823	118	G 1/8" 294
70 547 72001 / 70 547 72000	T15 - IP	824	120	G 1/8" 294
70 547 72501 / 70 547 72500	T15 - IP	824	120	G 1/8" 294

CoreLine – PWLN 95° – Tool holder with lever clamping

Scope of supply:

Tool holder with Allen key



Illustrations show right-hand versions



Left Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	Left TO 70 543 ...	Right TO 70 542 ...
PWLN L 1616 H06	16	16	100	14.5	22.5	3	WNMG 0604	116	11600 ¹⁾
PWLN R 1616 H06	16	16	100	20.0	22.5	3	WNMG 0604	12000 ¹⁾	12000 ¹⁾
PWLN R/L 2020 K06	20	20	125	26.0	25.0	3	WNMG 0604	125	12500 ¹⁾
PWLN R/L 2525 M06	25	25	150	19.0	32.0	3	WNMG 0604	020	020
PWLN R/L 2020 K08	20	20	125	22.0	25.0	4	WNMG 0804	025	025
PWLN R/L 2525 M08	25	25	150	22.0	32.0	4	WNMG 0804	032	032
PWLN R/L 3225 P08	32	25	170	22.0	32.0	4	WNMG 0804		

1) Nickel plated

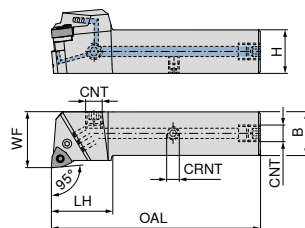
Spare parts for article number

	Key I	Shim	Assembly pin	Toggle lever	Clamping screw	Carbide seat W
	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 542 11600 / 70 543 116	SW2,5 175	122	191	185	208	127
70 542 12000 / 70 543 12000	SW2,5 175	122	191	185	208	127
70 542 12500 / 70 543 125	SW2,5 175	122	191	185	208	127
70 542 020 / 70 543 020	SW3 176	198	192	187	209	235
70 542 025 / 70 543 025	SW3 176	198	192	187	209	235
70 542 032 / 70 543 032	SW3 176	198	192	187	209	235

CoreLine – PWLN 95° DC – Tool holder with lever clamping

Scope of supply:

Tool holder with Allen key



Illustrations show right-hand versions



Left

Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Tightening torque Nm	Indexable insert
PWLN R/L 2020 X06-T DC	20	20	104	35	25	M6	G1/8"	3	WNMG 0604
PWLN R/L 2525 X06-T DC	25	25	120	35	32	M6	G1/8"	3	WNMG 0604
PWLN R/L 2020 X08-T DC	20	20	104	35	25	M6	G1/8"	4	WNMG 0804
PWLN R/L 2525 X08-T DC	25	25	120	35	32	M6	G1/8"	4	WNMG 0804
PWLN R/L 3225 X08-T DC	32	25	135	35	32	M6	G1/8"	4	WNMG 0804

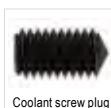
TO	TO
70 599 ...	70 599 ...
02000	02001
02500	02501
12000	12001
12500	12501
03200	03201

Spare parts for article number

		AS	AS	AS	AS		AS
		70 950 ...	70 950 ...	70 950 ...	70 950 ...		70 950 ...
70 599 02001 / 70 599 02000	G 1/8"	294	185	208	127	M6x6	86700
70 599 02501 / 70 599 02500	G 1/8"	294	185	208	127	M6x6	86700
70 599 12001 / 70 599 12000	G 1/8"	294	187	209	235	M6x6	86700
70 599 12501 / 70 599 12500	G 1/8"	294	187	209	235	M6x6	86700
70 599 03201 / 70 599 03200	G 1/8"	294	187	209	235	M6x6	86700

Spare parts for article number

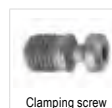
		AS	AS	AS
		70 950 ...	70 950 ...	70 950 ...
70 599 02001 / 70 599 02000	SW2,5	175	122	191
70 599 02501 / 70 599 02500	SW2,5	175	122	191
70 599 12001 / 70 599 12000	SW3	176	198	192
70 599 12501 / 70 599 12500	SW3	176	198	192
70 599 03201 / 70 599 03200	SW3	176	198	192



Coolant screw plug



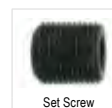
Toggle lever



Clamping screw



Carbide seat W



Set Screw



Key I



Shim

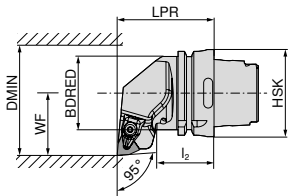


Assembly pin

CoreLine – DWLN 95° – Tool holder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Designation	Adapter	LPR mm	I ₂ mm	BDRED mm	WF mm	DMIN mm	Indexable insert	Left TO 74 529 ... 508	Right TO 74 528 ... 508
HSK T63 DWLN R/L 08	HSK-T 63	70	42	52.6	45	125	WN.. 0804		

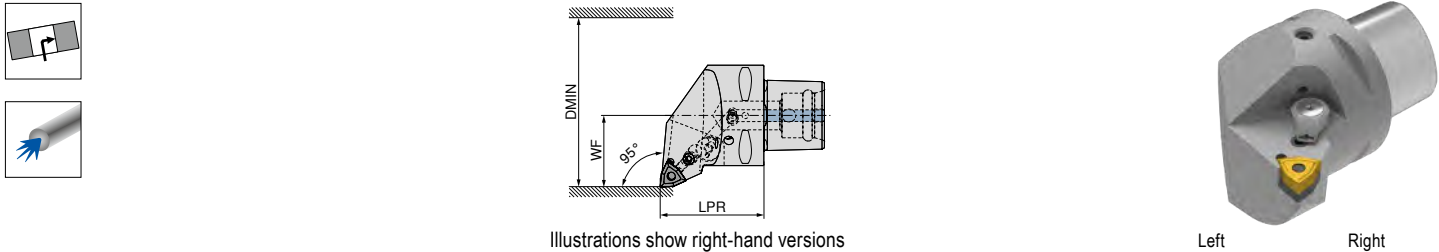
Spare parts
for article number

74 528 508 / 74 529 508

			
XPress range	Screwdriver	Clamping screw	Carbide seat W
AS	AS	AS	AS
70 950 ...	80 950 ...	70 950 ...	70 950 ...
824	120	820	812
	T15 - IP	M4,5x12 - 15IP	

CoreLine – PWLN 95° – Tool holder with lever clamping

Scope of supply:
Without high-performance coolant set



Designation	Adapter	LPR mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	Direct cooling compatible	TO 84 653 ...	TO 84 652 ...
PSC40 PWLN R/L 50050-08	PSC 40	50	27	50	5	WN.. 0804	DC	00895	00895
PSC50 PWLN R/L 65060-08	PSC 50	60	35	65	5	WN.. 0804	DC	00894	00894
PSC63 PWLN R/L 80065-08	PSC 63	65	45	80	5	WN.. 0804	DC	00893	00893



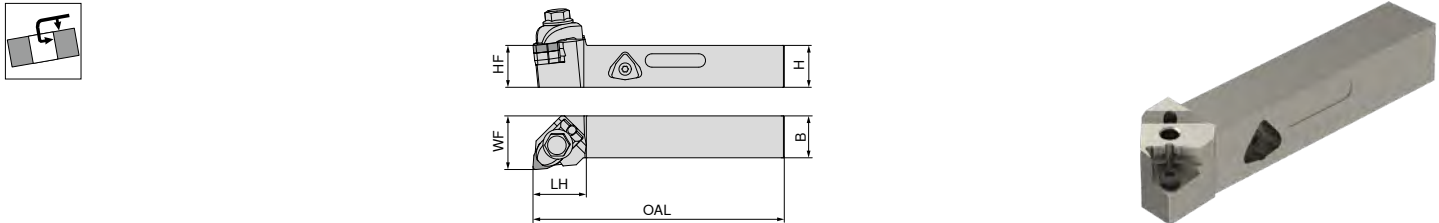
The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra.

Spare parts
for article number

	Shim		Toggle lever screw		Toggle lever		Carbide seat W
	AS		AS		AS		AS
	84 950 ...		84 950 ...		84 950 ...		84 950 ...
84 652 00895 / 84 653 00895	29200	M8X1/L17 SW3	28700		28900		27700
84 652 00894 / 84 653 00894	29200	M8X1/L17 SW3	28700		28900		27700
84 652 00893 / 84 653 00893	29200	M8X1/L17 SW3	28700		28900		27700

CoreLine – DWLN 95° – Tool holder with top clamping – C-Clamp

Scope of supply:
Tool holder **without** claw



Designation	H mm	B mm	OAL mm	LH mm	WF mm	HF mm	Indexable insert	Left		Right	
								TO	TO	TO	TO
DWLN R/L 2525 M08-C207	25	25	150	32	32	25	WN.X 08..	74 094 ... 25000	74 094 ... 25001	74 094 ... 25000	74 094 ... 25001

Spare parts
for article number

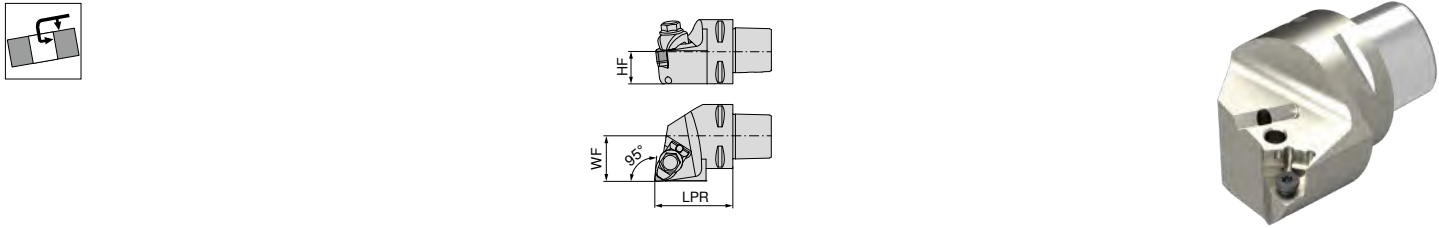
74 094 25001 / 74 094 25000	M6x13 - 20IP	89700	X7	88900	88400
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Spare parts
for article number

74 094 25001 / 74 094 25000	M8 - 20 Nm	89200	T20 - IP	121
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CoreLine – DWLN 95° – Tool holder with top clamping – C-Clamp

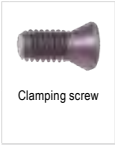
Scope of supply:
Tool holder **without** claw



Designation	Adapter	LPR mm	WF mm	HF mm	Indexable insert	Left	Right
						TO 74 093 ... 25100	TO 74 093 ... 25101
PSC50 DWLN L 35060-08-C207	PSC 50	60	35	25	WN.X 08..		
PSC50 DCLN R 35060-12-C207	PSC 50	60	35	25	WN.X 08..		

Spare parts
for article number

74 093 25100	M6x13 - 20IP	89700	X7	88900	88400
74 093 25101	M6x13 - 20IP	89700	X7	88900	88400



Clamping screw

AS

70 950 ...



Carbide shim

AS

70 950 ...



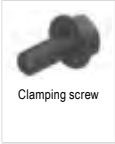
Carbide clamping claw

AS

70 950 ...

Spare parts
for article number

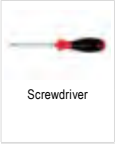
74 093 25100	M8 - 20 Nm	89200	T20 - IP	121
74 093 25101	M8 - 20 Nm	89200	T20 - IP	121



Clamping screw

AS

70 950 ...



Screwdriver

AS

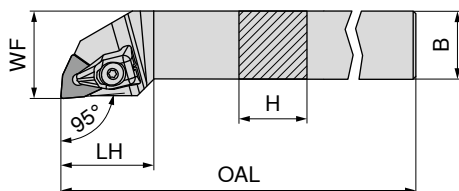
80 950 ...

CoreLine – DWLN 95° – Toolholder with top clamping

- ▲ ...A-N = with thru coolant
 ▲ ...N = without thru coolant

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left

Right

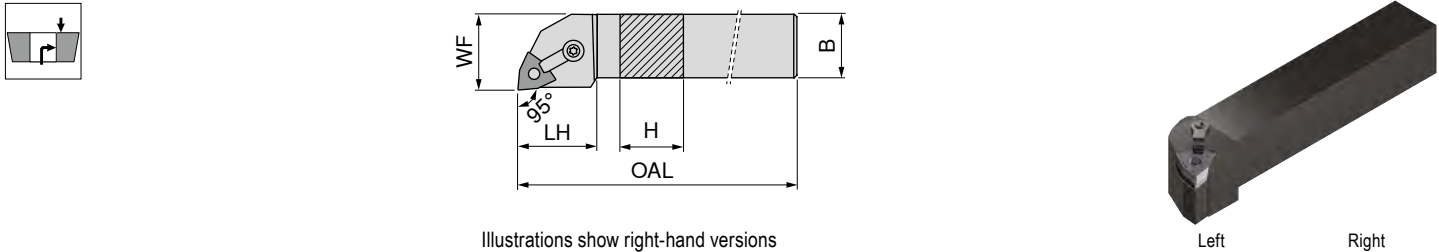
ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO 78 515 ...	TO 78 514 ...
DWLN R 12-4BA-N	0.750	0.750	4.500	1.250	1.000	WN..43..		01294
DWLN R/L 12-4B-N	0.750	0.750	4.500	1.250	1.000	WN..43..	01293	01293
DWLN L 12-4BA-N	0.750	0.750		1.250	1.000	WN..43..	01294	
DWLN R/L 16-4DA-N	1.000	1.000	6.000	1.250	1.250	WN..43..	01690	01690
DWLN R/L 16-4D-N	1.000	1.000	6.000	1.250	1.250	WN..43..	01689	01689
DWLN R/L 20-4DA-N	1.250	1.250	6.000	1.250	1.500	WN..43..	02092	02091
DWLN R/L 20-4D-N	1.250	1.250	6.000	1.250	1.500	WN..43..	02089	02089
DWLN R/L 24-4E-N	1.500	1.500	7.000	1.250	2.000	WN..43..	02486 ¹⁾	02486 ¹⁾
DWLN R/L 24-4EA-N	1.500	1.500	7.000	1.250	2.000	WN..43..	02488 ¹⁾	02488 ¹⁾

1) Not in stock

	Clamping claw	Key I	Clamping screw	Carbide seat W	Threaded bush	Spring
	AS	AS	AS	AS	AS	AS
for article number	78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...
78 514 01294	07600	08100	08300	02400	08500	04900
78 514 01293 / 78 515 01293	07600	08100	08300	02400	08500	04900
78 515 01294	07600	08100	08300	02400	08500	04900
78 514 01690 / 78 515 01690	07600	08100	08300	02400	08500	04900
78 514 01689 / 78 515 01689	07600	08100	08300	02400	08500	04900
78 514 02091 / 78 515 02092	07600	08100	08300	02400	08500	04900
78 514 02089 / 78 515 02089	07600	08100	08300	02400	08500	04900
78 514 02486 / 78 515 02486	07600	08100	08300	02400	08500	04900
78 514 02488 / 78 515 02488	07600	08100	08300	02400	08500	04900

CoreLine – MWLN 95° – Toolholder with top clamping

Scope of supply:
Tool holder with allen key



ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO	
							78 551 ...	78 550 ...
MWLN L 12-3B	0.750	0.750	4.500	1.000	1.000	WN..33..	01223 ¹⁾	01223 ¹⁾
MWLN R/L 16-3D	1.000	1.000	6.000	1.000	1.250	WN..33..	01643 ¹⁾	01643 ¹⁾
MWLN R/L 12-4B	0.750	0.750	4.500	1.070	1.000	WN..43..	01224 ¹⁾	01224 ¹⁾
MWLN R/L 16-4D	1.000	1.000	6.000	1.070	1.250	WN..43..	01644 ¹⁾	01644 ¹⁾
MWLN R/L 20-4D	1.250	1.250	6.000	1.070	1.500	WN..43..	02044 ¹⁾	02044 ¹⁾
MWLN R/L 24-4E	1.500	1.500	7.000	1.070	2.000	WN..43..	02454 ¹⁾	02454 ¹⁾

1) Not in stock

Spare parts
for article number

	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...	AS 78 950 ...
78 551 01223	00600	06800	02900	03600		02200
78 550 01643 / 78 551 01643	00600	06800	02900	03600		02200
78 550 01224 / 78 551 01224	00400	07000	03100	03800		
78 550 01644	00400	07000	03100	03800	02400	
78 551 01644	00400	07000	03100	03800		
78 550 02044 / 78 551 02044	00400	07000	03100	03800		
78 550 02454 / 78 551 02454	00400	07000	03100	03800		



Clamp

AS

78 950 ...



Key I

AS

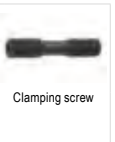
78 950 ...



Dowel

AS

78 950 ...



Clamping screw

AS

78 950 ...



Carbide seat W

AS

78 950 ...



Carbide seat V

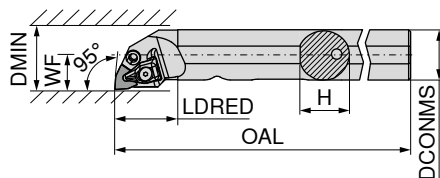
AS

78 950 ...

CoreLine – DWLN 95° – Boring bar with top clamping

Scope of supply:

Boring bar with Torx key



Illustrations show right-hand versions

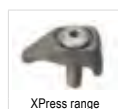
Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert
A25R DWLN R/L 06	25	24	200	32	17	32	2	WN.. 0604
A32S DWLN R/L 08	32	31	250	40	22	44	4	WN.. 0804
A40T DWLN R/L 08	40	39	300	45	27	50	4	WN.. 0804

Left

Right

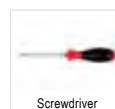
TO	TO
70 573 ...	70 572 ...
725	725
732	732
64000	640

Spare parts for article number



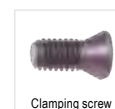
XPress range

AS

70 950 ...

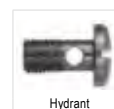
Screwdriver

AS

80 950 ...

Clamping screw

AS

70 950 ...

Hydrant

AS

70 950 ...

Carbide seat W

AS

70 950 ...

70 572 725 / 70 573 725

70 572 732 / 70 573 732

70 572 640 / 70 573 64000

T09 - IP

T15 - IP

T15 - IP

M3x7 - 09IP

M4,5x12 - 15IP

M4,5x12 - 15IP

819

820

820

834

834

834

807

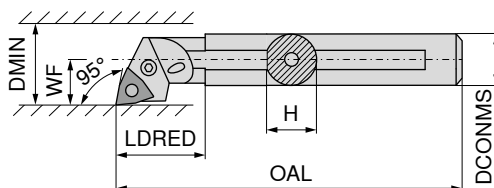
812

812

CoreLine – PWLN 95° – Boring bar with lever clamping

Scope of supply:

Boring bar with Allen key



Illustrations show right-hand versions



Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert
A16M PWLN R/L 06	16	15	150	20	11	20	3	WNMG 0604
A20Q PWLN R/L 06-1	20	19	180	30	13	25	3	WNMG 0604
A25R PWLN R/L 06	25	23	200	25	17	32	3	WNMG 0604
A32S PWLN R/L 06	32	30	250	50	22	40	3	WNMG 0604
A25R PWLN R/L 08	25	23	200	40	17	31	4	WNMG 0804
A32S PWLN R/L 08	32	30	250	50	22	40	4	WNMG 0804
A40T PWLN R/L 08	40	39	300	60	27	50	4	WNMG 0804

Left	Right
TO	TO
70 573 ...	70 572 ...
11600 ¹⁾	11600 ¹⁾
12100 ¹⁾	12100 ¹⁾
12500 ¹⁾	12500 ¹⁾
132	132
225	225
032	032
040	040

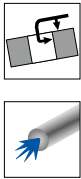
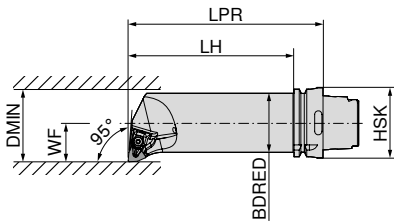
1) Nickel plated

Spare parts for article number

	Key I	Shim	Assembly pin	Toggle lever	Clamping screw	Carbide seat W
	AS	AS	AS	AS	AS	AS
	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 572 11600 / 70 573 11600	SW2	177		129	217	
70 572 12100 / 70 573 12100	SW2	177		129	217	
70 572 12500 / 70 573 12500	SW2,5	175	122	185	208	127
70 572 132 / 70 573 132	SW2,5	175	122	185	208	127
70 572 225 / 70 573 225	SW3	176		187	205	
70 572 032 / 70 573 032	SW3	176	198	187	209	235
70 572 040 / 70 573 040	SW3	176	198	187	209	235

CoreLine – DWLN 95° – Boring bar with top clamping

Scope of supply:
Boring bar with Torx key



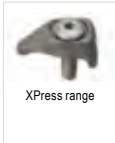
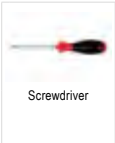
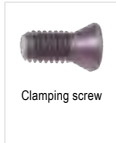
Illustrations show right-hand versions



Designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	Left TO 74 537 ... 508	Right TO 74 536 ... 508
HSK T63 50Q DWLN R/L 08	HSK-T 63	175	149	50	35	63	4	WN.. 0804		

Spare parts
for article number

74 536 508 / 74 537 508

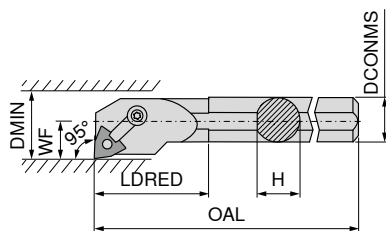
 XPress range AS 70 950 ... 824	 Screwdriver AS 80 950 ... 120	 Clamping screw AS 70 950 ... 820	 Carbide seat W AS 70 950 ... 812
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CoreLine – MWLN 95° – Boring bar with top clamping

- ▲ A... = with thru coolant
▲ S... = without thru coolant

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left

Right

ANSI designation	DCONMS inch	H inch	OAL inch	LDRED inch	WF inch	DMIN inch	Indexable insert	TO 78 717 ...	TO 78 716 ...
S16T MWLN R/L 4	1.000	0.900	12.000	2.500	0.640	1.280	WN..43..	41626 ¹⁾	41626 ¹⁾
A16T MWLN R/L 4	1.000	0.900	12.000	2.500	0.640	1.280	WN..43..	41616	41616
S20U MWLN R/L 4	1.250	1.180	14.000	3.000	0.765	1.530	WN..43..	42030 ¹⁾	42030 ¹⁾
A20U MWLN R/L 4	1.250	1.180	14.000	3.000	0.765	1.530	WN..43..	42020 ¹⁾	42020 ¹⁾
S24U MWLN R/L 4	1.500	1.370	14.000	3.000	0.890	1.780	WN..43..	42434 ¹⁾	42434 ¹⁾
A24U MWLN R/L 4	1.500	1.370	14.000	3.000	0.890	1.780	WN..43..	42424 ¹⁾	42424 ¹⁾

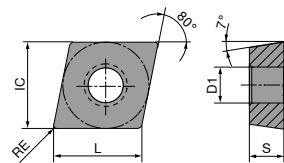
1) Not in stock

for article number

	Clamp	Key I	Dowel	Clamping screw	Carbide seat W
	AS	AS	AS	AS	AS
78 716 41626 / 78 717 41626	78 950 ...	78 950 ...	78 950 ...	78 950 ...	78 950 ...
	00400	06900	03000	03700	
78 716 41616 / 78 717 41616	00400	06900	03000	03700	
78 716 42030 / 78 717 42030	00400	06900	03100	03800	02400
78 716 42020 / 78 717 42020	00400	06900	03100	03800	02400
78 716 42434 / 78 717 42434	00400	06900	03100	03800	02400
78 716 42424 / 78 717 42424	00400	06900	03100	03800	02400

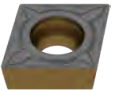
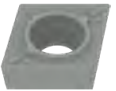
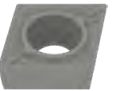
CCGT / CCMT / CCET

Designation	L	S	D1	IC
	mm	mm	mm	mm
CC.T 0602..	6.4	2.38	2.8	6.35
CC.T 09T3..	9.7	3.97	4.4	9.52
CC.T 1204..	12.9	4.76	5.5	12.70



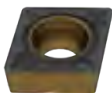
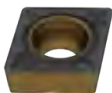
CoreLine – Carbide turning indexable insert

CCGT / CCMT

		-CF05 CTEP110-P	-CF55 CTEP110-P	-SF TCM407	-SF TCM10	-SMF TCM10	-SF CTCP115-P	-SF CTCP125-P
		DRAGONSKIN	DRAGONSKIN				DRAGONSKIN	DRAGONSKIN
								
		F	F	F	F	F	F	F
		CERMET	CERMET	CERMET	CERMET	CERMET		
		CCGT	CCMT	CCGT	CCGT	CCMT	CCGT	CCGT
		TR	TR	TR	TR	TR	TR	TR
		76 247 ...	76 248 ...	70 251 ...	70 251 ...	70 249 ...	76 251 ...	76 251 ...
		00201		850	900		30201	50201
		00401	00401	852	902	900		
		01401		854	904			
		01601	01601		906	904		
		01801	01801		908	906		
		02001	02801		910			
		P	●	●	●	●	●	●
		M	○	○	○	○	○	○
		K	○	○	○	○	○	○
		N						
		S						
		H						
		O						

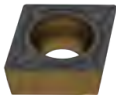
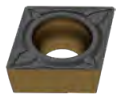
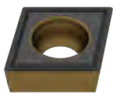
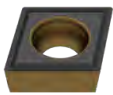
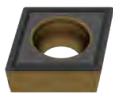
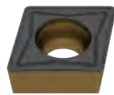
CoreLine – Carbide turning indexable insert

CCGT / CCMT

		<div><div><div>-SF</div><div>CTCP125-P</div></div><div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div></div><div>F</div><div>CCGT</div></div></div><div><div><div>-SF</div><div>CTCP135-P</div></div><div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div></div><div>F</div><div>CCGT</div></div></div><div><div><div>-SF</div><div>CTCK110-P</div></div><div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div></div><div>F</div><div>CCMT</div></div></div><div><div><div>-SF</div><div>CTCP115-P</div></div><div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div></div><div>F</div><div>CCMT</div></div></div><div><div><div>-SF</div><div>CTCP125-P</div></div><div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div></div><div>F</div><div>CCMT</div></div></div><div><div><div>-SF</div><div>CTCP135-P</div></div><div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div></div><div>F</div><div>CCMT</div></div></div><div><div><div>-SMF</div><div>CTCP115-P</div></div><div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div></div><div>F</div><div>CCMT</div></div></div></div></div></div></div></div></div></div>
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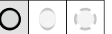
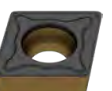
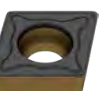
CoreLine – Carbide turning indexable insert

CCMT / CCGT

		<div>-SMF</div> <div>CTCP125-P</div>	<div>-SMF</div> <div>CTCP135-P</div>	<div>-SM</div> <div>CTCP115-P</div>	<div>-SM</div> <div>CTCP125-P</div>	<div>-SM</div> <div>CTCP135-P</div>	<div>-SM</div> <div>CTCK110-P</div>	<div>-SM</div> <div>CTCK120-P</div>
		<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>
								
		<div>F</div> <div>CCMT</div>	<div>F</div> <div>CCMT</div>	<div>M</div> <div>CCGT</div>	<div>M</div> <div>CCGT</div>	<div>M</div> <div>CCGT</div>	<div>M</div> <div>CCMT</div>	<div>M</div> <div>CCMT</div>
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	76 249 ...	76 249 ...	76 250 ...	76 250 ...	76 250 ...	70 252 ...	70 252 ...
060202EN	0.2			30201	50201	70201		
060204EN	0.4	50401	70401				10401	50401
060208EN	0.8	50601	70601				10601	50601
09T304EN	0.4	51601	71601				11601	51601
09T308EN	0.8	51801	71801				11801	51801
09T312EN	1.2						12001	52001
120404EN	0.4	52801	72801				12801	52801
120408EN	0.8	53001	73001				13001	53001
P		●	●	●	●	●	○	○
M			○			○		
K		○		○	○		●	●
N								
S								
H								
O								

CoreLine – Carbide turning indexable insert

CCMT

		-SM CTCP115-P		-SM CTCP125-P		-SM CTCP135-P		-SMQ CTCP115-P		-SMQ CTCP125-P		-M25 CTCM120		-SF CTPM125	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
															
		M CCMT		M CCMT		M CCMT		F CCMT		F CCMT		F CCMT		F CCMT	
		TR		TR		TR		TR		TR		TR		TR	
ISO	RE mm	76 252 ...		76 252 ...		76 252 ...		76 194 ...		76 194 ...		75 210 ...		75 042 ...	
060204EN	0.4	30401		50401		70401						10400		20400	
060208EN	0.8	30601		50601		70601									
09T304EN	0.4	31601		51601		71601		31601		51601		11600		21600	
09T308EN	0.8	31801		51801		71801		31801		51801		11800			
09T312EN	1.2	32001		52001		72001									
120404EN	0.4	32801		52801		72801		32801		52801					
120408EN	0.8	33001		53001		73001		33001		53001					
120412EN	1.2	33201		53201		73201									
P		●		●		●		●		●		○		○	
M						○						●		●	
K		○		○				○		○					
N															
S															
H															
O															

CoreLine – Carbide turning indexable insert

CCMT

		<div><div>-M25</div><div>CTPM125</div></div>	<div><div>-F43</div><div>CTCM130</div></div>	<div><div>-M25</div><div>CTCM130</div></div>	<div><div>-SM</div><div>CTCM130</div></div>	<div><div>-M25</div><div>CTPX710</div></div>	<div><div>-M55</div><div>CTCM120</div></div>	<div><div>-M55</div><div>CTPM125</div></div>
		DRAGONS	DRAGONS	DRAGONS	DRAGONS	DRAGONS	DRAGONS	DRAGONS
		F	F	F	M	M	M	M
		CCMT	CCMT	CCMT	CCMT	CCMT	CCMT	CCMT
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	75 210 ...	75 031 ...	75 210 ...	75 047 ...	75 210 ...	75 211 ...	75 211 ...
060202EN	0.2					60200		
060204EN	0.4	204		30400	30400	60400	10400	204
09T304EN	0.4	216	31600	31600	31600	61600	11600	216
09T308EN	0.8	218	31800	31800	31800	61800	11800	218
120404EN	0.4				32800		12800	228
120408EN	0.8				33000		13000	230
P		○	○	○	○	●	○	○
M		●	●	●	●	●	●	●
K								
N						○		
S			○	○	○	●		
H								
O								

CoreLine – Carbide turning indexable insert

CCMT / CCGT

		<div><div>-M55</div><div>CTCM130</div></div>		<div><div>-M55</div><div>CTPX710</div></div>		<div><div>-23P</div><div>H216T</div></div>		<div><div>-25P</div><div>H210T</div></div>		<div><div>-25P</div><div>CTPX710</div></div>		<div><div>-25Q</div><div>H210T</div></div>		<div><div>-25Q</div><div>H216T</div></div>	
		<div>DRAGONSKIN</div>		<div>DRAGONSKIN</div>						<div>DRAGONSKIN</div>					
															
															
		<div>M</div> <div>CCMT</div>		<div>M</div> <div>CCMT</div>		<div>F</div> <div>CCGT</div>		<div>F</div> <div>CCGT</div>		<div>M</div> <div>CCGT</div>		<div>M</div> <div>CCGT</div>		<div>M</div> <div>CCGT</div>	
		TR		TR		TR		TR		TR		TR		TR	
ISO	RE mm	75 211 ...		75 211 ...		70 255 ...		70 248 ...		70 248 ...		70 248 ...		70 248 ...	
060202FN	0.2					652		636		70200					
060204EN	0.4	30400		60400				638		70400		678			
060204FN	0.4					654		639		71400					
09T302FN	0.2							640		71600		680			
09T304EN	0.4	31600		61600		656		641		71800		681			
09T304FN	0.4					658		643							
09T308EN	0.8	31800		61800				642		72800		682			
09T308FN	0.8							644		73000		686		69500	
120402FN	0.2														
120404EN	0.4	32800		62800											
120404FN	0.4														
120408EN	0.8	33000		63000											
120408FN	0.8														
120412EN	1.2			63200											
P		○		●						●					
M		●		●						●					
K						○		○				○		○	
N				○		●		●		●		●		●	
S		○		●				○		●		○			
H															
O						○		○				○		○	

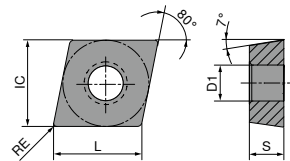
MaxiTurn – Carbide turning indexable insert

CCGT / CCMT / CCET

		<div><div>-25Q</div><div>CTPX710</div></div>	<div><div>-27</div><div>H10T</div></div>	<div><div>-27</div><div>CTPX715</div></div>	<div><div>-29</div><div>H216T</div></div>	<div><div>-29</div><div>CTPX715</div></div>	<div><div>-F05</div><div>CTPX710</div></div>
		<div>DRAGONS</div> <div><div></div><div></div><div></div></div>	<div>DRAGONS</div> <div><div></div><div></div><div></div></div>	<div>DRAGONS</div> <div><div></div><div></div><div></div></div>	<div>DRAGONS</div> <div><div></div><div></div><div></div></div>	<div>DRAGONS</div> <div><div></div><div></div><div></div></div>	<div>DRAGONS</div> <div><div></div><div></div><div></div></div>
		<div><div></div></div>	<div><div></div></div>	<div><div></div></div>	<div><div></div></div>	<div><div></div></div>	<div><div></div></div>
		<div>M</div> <div>CCGT</div>	<div>M</div> <div>CCGT</div>	<div>M</div> <div>CCGT</div>	<div>M</div> <div>CCMT</div>	<div>M</div> <div>CCMT</div>	<div>F</div> <div>CCET</div>
		TR	TR	TR	TR	TR	IA
ISO	RE mm	70 248 ...	70 254 ...	70 254 ...	70 245 ...	70 245 ...	76 243 ...
060201FN	0.1						10100
060202FN	0.2		600	80200			10200
060204EN	0.4				60400	70400	
060204FN	0.4	75400	602	80400			10400
09T302FN	0.2		604	81400			
09T304EN	0.4				61600	71600	
09T304FN	0.4	76600	606	81600			
09T308EN	0.8				61800	71800	
09T308FN	0.8	76800	608	81800			
09T316FN	1.6			72200			
120402FN	0.2		610	82600			
120404FN	0.4	77800	612	82800			
120408FN	0.8	78000	614	83000			
P		●		●		●	●
M		●		●		●	●
K			○	○	○	○	
N		●	●	●	●	●	●
S		●		●		●	●
H							
O			○	○	○	○	

CCGT / CCXT

Designation	L	S	D1	IC
	mm	mm	mm	mm
CC.T 0602..	6.4	2.38	2.8	6.35
CC.T 09T3..	9.7	3.97	4.4	9.52



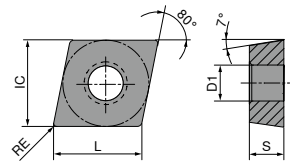
CoreLine – Carbide turning indexable insert

CCGT / CCXT

		<div>-F23 CTP2120</div>	<div>-SF CTCK110-P</div>	<div>-M81 CWN2120</div>
		<div>DRAGONSKIN</div>		
		<div></div>	<div></div>	<div></div>
		<div></div>	<div></div>	<div></div>
		<div>F CCGT</div>	<div>F CCGT</div>	<div>M CCXT</div>
		TR	TR	TR
		70 191 ...	70 325 ...	70 254 ...
		600		
		602		
			10201	100
				102
		604		
		606		
				104
				106
				108
P			○	
M				●
K			●	
N				○
S				
H				
O				

CCMT

Designation	L	S	D1	IC
	mm	mm	mm	mm
CCMT 09T3..	9.7	3.97	4.4	9.52
CCMT 1204..	12.9	4.76	5.5	12.70



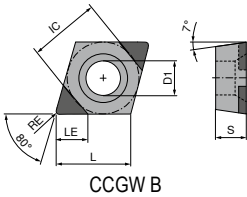
CoreLine – Carbide turning indexable insert

CCMT

		-FMS CT-P15	-FMS CT-P25	-MRS CT-P15	-MRS CT-P25
		F CCMT	F CCMT	M CCMT	M CCMT
		CX	CX	CX	CX
ISO	RE mm	75 300 ...	75 300 ...	75 301 ...	75 301 ...
09T304EN	0.4	01609	11609	01609	11609
09T308EN	0.8	01809	11809	01809	11809
120404EN	0.4	02809	12809	02809	12809
120408EN	0.8	03009	13009	03009	13009
120412EN	1.2			03209	13209
P		●	●	●	●
M		○	○	○	○
K					
N					
S					
H					
O					

CCGW

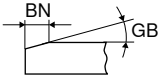
Designation	L	S	D1	IC
	mm	mm	mm	mm
CCGW 0602..	6.45	2.38	2.8	6.35
CCGW 09T3..	9.70	3.97	4.4	9.52



CoreLine – PcBN turning indexable insert

CCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners



CTBH1000C

F

PCBN

CCGW

CTBH2000C

F

PCBN

CCGW

CTBH3000C

F

PCBN

CCGW

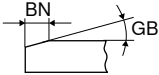
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	PC 71 000 ...	PC 71 000 ...	PC 71 000 ...
060202EN	0.2			B (2)	2.9	70002	80002	
060202SN	0.2	0.14	20°	B (2)	2.9			90002
060204EN	0.4			B (2)	2.9	70302	80302	
060204SN	0.4	0.14	20°	B (2)	2.9			90302
09T302EN	0.2			B (2)	3.3	70602	80602	
09T302SN	0.2	0.14	20°	B (2)	3.3			90602
09T304EN	0.4			B (2)	3.3	70902	80902	
09T304SN	0.4	0.14	20°	B (2)	3.3			90902
09T308EN	0.8			B (2)	3.3	71202	81202	
09T308SN	0.8	0.14	20°	B (2)	3.3			91202

P			
M			
K			
N			
S			
H			
O			

CoreLine – PcBN turning indexable insert

CCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners



ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
060202SN	0.2	0.09	15°	B (2)	2.9
060202SN	0.2	0.18	25°	B (2)	2.9
060204SN	0.4	0.09	15°	B (2)	2.9
060204SN	0.4	0.18	25°	B (2)	2.9
09T302SN	0.2	0.09	15°	B (2)	3.3
09T302SN	0.2	0.18	25°	B (2)	3.3
09T304SN	0.4	0.09	15°	B (2)	3.3
09T304SN	0.4	0.18	25°	B (2)	3.3
09T308SN	0.8	0.09	15°	B (2)	3.3
09T308SN	0.8	0.18	25°	B (2)	3.3

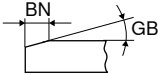
P			
M			
K			
N			
S			
H			
O			

CTBH1000C	CTBH2000C	CTBH3000C
M	M	M
PCBN	PCBN	PCBN
CCGW	CCGW	CCGW
PC	PC	PC
71 000 ...	71 000 ...	71 000 ...
70102	80102	90102
70402	80402	90402
70702	80702	90702
71002	81002	91002
71302	81302	91302

CoreLine – PcBN turning indexable insert

CCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners



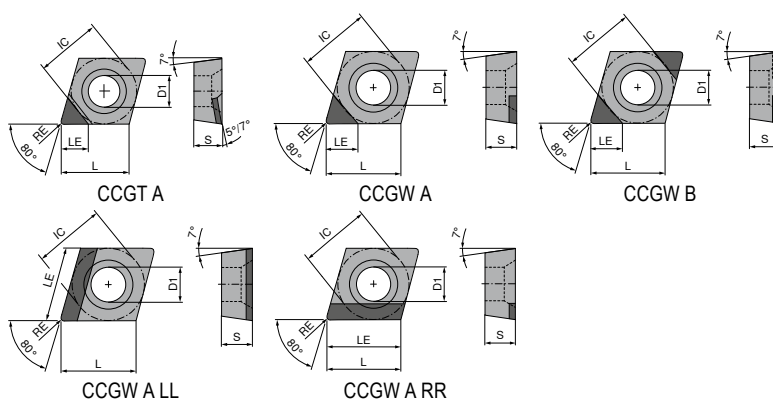
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
060202SN	0.2	0.14	20°	B (2)	2.9
060202SN	0.2	0.20	35°	B (2)	2.9
060204SN	0.4	0.14	20°	B (2)	2.9
060204SN	0.4	0.20	35°	B (2)	2.9
09T302SN	0.2	0.14	20°	B (2)	3.3
09T302SN	0.2	0.20	35°	B (2)	3.3
09T304SN	0.4	0.14	20°	B (2)	3.3
09T304SN	0.4	0.20	35°	B (2)	3.3
09T308SN	0.8	0.14	20°	B (2)	3.3
09T308SN	0.8	0.20	35°	B (2)	3.3

P			
M			
K			
N			
S			
H			
O			

CTBH1000C	CTBH2000C	CTBH3000C
R	R	R
PCBN	PCBN	PCBN
CCGW	CCGW	CCGW
PC	PC	PC
71 000 ...	71 000 ...	71 000 ...
70202	80202	90202
70502	80502	90502
70802	80802	90802
71102	81102	91102
71402	81402	91402

CCGW / CCGT

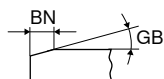
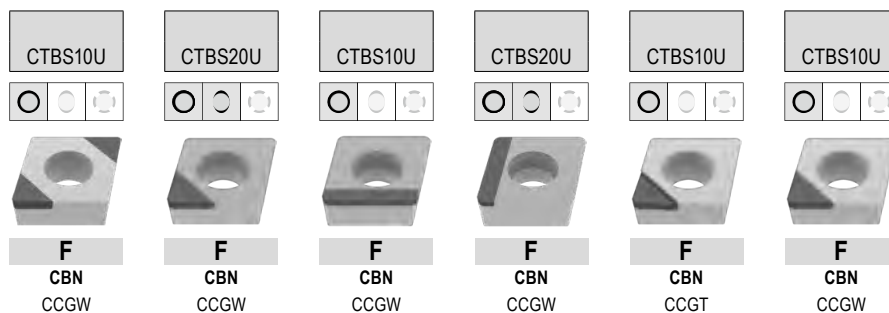
Designation	L	S	D1	IC
	mm	mm	mm	mm
CCG. 0602..	6.40	2.38	2.8	6.35
CCG. 09T3..	9.70	3.97	4.4	9.52
CCGW 0602..	6.45	2.38	2.8	6.35
CCGW 1204..	12.90	4.76	5.5	12.70



CoreLine – PcBN turning indexable insert

CCGW / CCGT

▲ TCE(NOI) = Design and number of equipped cutting edge corners



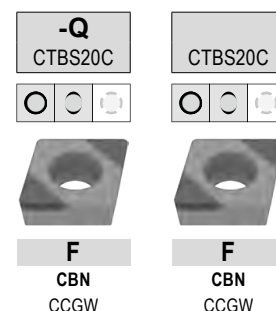
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	PC	PC	PC	PC	PC	PC
060202TN	0.2	0.12	20°	A (1)	3.4	71 419 ...	71 418 ...	71 420 ...	71 420 ...	71 124 ...	71 120 ...
060202FN	0.2			A (1)	3.4					200	300
060204TN	0.4	0.12	20°	A (1)	3.1					202	302
060204FN	0.4			A (1)	3.1						202
060208TN	0.8	0.12	20°	A (1)	2.8						30300
09T304TN	0.4	0.12	15°	A (1)	2.8		20400				204
09T304FN	0.4			A (1)	2.8						
09T304FN	0.4			A (1)	3.1						
09T304FN	0.4			B (2)	3.1	10000				25200	
09T304TN	0.4	0.12	20°	B (2)	3.1	10100					304
09T304TN	0.4	0.12	20°	A (1)	2.8						
09T308TLL	0.8	0.12	15°	A (1)	9.7				20000		
09T308TN	0.8	0.12	20°	A (1)	2.5						306
09T308FN	0.8			A (1)	2.5		20500				206
09T308TRR	0.8	0.12	20°	A (1)	9.7			10300			
120404TN	0.4	0.12	20°	A (1)	3.1						308
120404FN	0.4			A (1)	3.1						208
120408TN	0.8	0.12	15°	A (1)	2.8		20900				
120408TN	0.8	0.12	20°	A (1)	2.8						310
120408FN	0.8			A (1)	2.8						210

P						
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CoreLine – PcBN turning indexable insert

CCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners



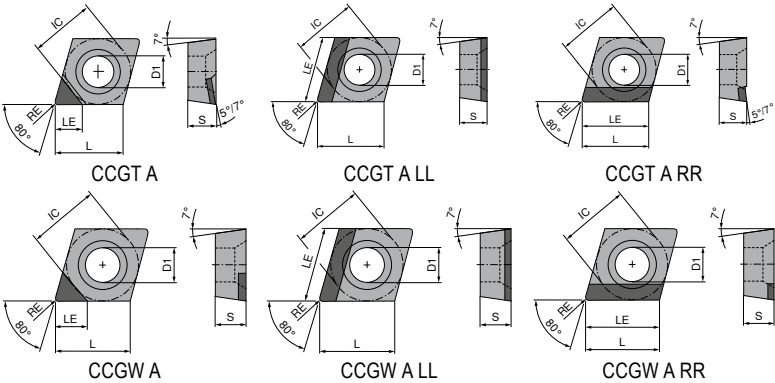
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
060202SN	0.2	0.09	10°	B (2)	3.4
060202SN	0.2	0.11	15°	B (2)	3.4
060202SN	0.2	0.16	20°	B (2)	3.4
060202EN	0.2			B (2)	3.4
060204SN	0.4	0.09	10°	B (2)	3.1
060204SN	0.4	0.11	15°	B (2)	3.1
060204TN	0.4	0.15	20°	B (2)	3.1
060204SN	0.4	0.16	20°	B (2)	3.1
060204SN	0.4	0.18	25°	B (2)	3.1
060208TN	0.8	0.15	20°	B (2)	2.8
060208TN	0.8	0.17	25°	B (2)	2.8
060208SN	0.8	0.18	25°	B (2)	2.8
09T302SN	0.2	0.09	10°	B (2)	3.4
09T302TN	0.2	0.17	25°	B (2)	3.4
09T302EN	0.2			B (2)	3.4
09T304SN	0.4	0.09	10°	B (2)	3.1
09T304SN	0.4	0.11	15°	B (2)	3.1
09T304TN	0.4	0.15	20°	B (2)	3.1
09T304SN	0.4	0.16	20°	B (2)	3.1
09T304EN	0.4			B (2)	3.1
09T304TN	0.4	0.17	25°	B (2)	3.1
09T304SN	0.4	0.18	25°	B (2)	3.1
09T304SN	0.4	0.18	30°	B (2)	3.1
09T308SN	0.8	0.09	10°	B (2)	2.8
09T308SN	0.8	0.11	15°	B (2)	2.8
09T308TN	0.8	0.15	20°	B (2)	2.8
09T308SN	0.8	0.16	20°	B (2)	2.8
09T308TN	0.8	0.17	25°	B (2)	2.8
09T308SN	0.8	0.18	25°	B (2)	2.8
09T308EN	0.8			B (2)	2.8

PC	PC
71 162 ...	71 161 ...
120	
130	
	150
	110
121	121
131	131
141	141
151	151
171	
	142
	162
	172
	123
	163
	113
	124
	134
144	144
	154
	114
	164
174	174
	184
125	125
135	
	145
155	155
165	165
	175
115	

P		
M		
K	•	•
N		
S	•	•
H		
O		

CCGW / CCGT

Designation	L	S	D1	IC
	mm	mm	mm	mm
CCG. 0602..	6.4	2.38	2.8	6.35
CCG. 09T3..	9.7	3.97	4.4	9.52
CCG. 1204..	12.9	4.76	5.5	12.70



CoreLine – PCD turning indexable insert

CCGW / CCGT

▲ TCE(NOI) = Design and number of equipped cutting edge corners

ISO	RE mm	TCE (NOI)	LE mm
060201FN	0.1	A (1)	3.4
060201FN	0.1	A (1)	3.5
060202FN	0.2	A (1)	2.5
060202FN	0.2	A (1)	3.3
060202FN	0.2	A (1)	3.4
060204FN	0.4	A (1)	2.5
060204FN	0.4	A (1)	3.1
060204FN	0.4	A (1)	3.2
060208FN	0.8	A (1)	2.5
060208FN	0.8	A (1)	3.0
09T301FN	0.1	A (1)	4.5
09T302FN	0.2	A (1)	4.4
09T302FN	0.2	A (1)	4.5
09T304FN	0.4	A (1)	2.5
09T304FN	0.4	A (1)	4.2
09T304FN	0.4	A (1)	4.3
09T308FN	0.8	A (1)	2.5
09T308FN	0.8	A (1)	4.1
120402FN	0.2	A (1)	4.4
120404FN	0.4	A (1)	4.2
120404FN	0.4	A (1)	4.3
120408FN	0.8	A (1)	4.1

P					
M					
K					
N	•	•	•	•	•
S					
H					
O	•	•	•	•	•

CTDMD05	CTDPD20	CTDPD20	-Q CTDPD20	-Q CTDPD20
F DIAMOND CCGW	F DIAMOND CCGW	F DIAMOND CCGT	F DIAMOND CCGW	F DIAMOND CCGT
PC	PC	PC	PC	PC
71 120 ...	71 120 ...	71 124 ...	71 125 ...	71 126 ...
		10100		101
050			102	102
	100	100		104
052			104	
	102	102		
05300	10300	10300		
			111	111
	10500	10500	112	112
054			114	114
	104	104		
056	106	106		
			122	122
	108	108	124	124
	110	110		

CoreLine – PCD turning indexable insert

CCGW / CCGT

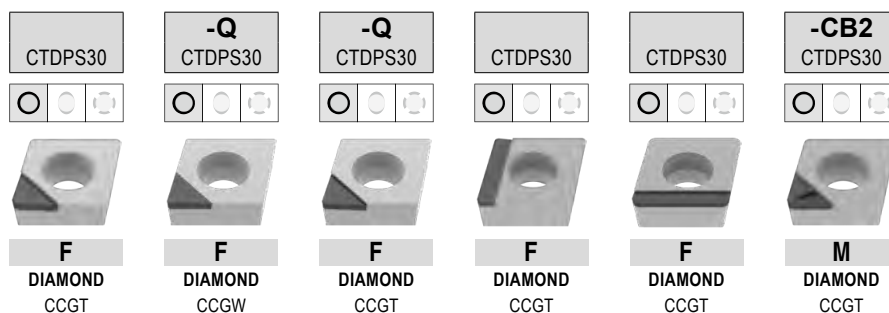
▲ TCE(NOI) = Design and number of equipped cutting edge corners

				CTDPD20	CTDPD20	-CB1 CTDPD20	-CB2 CTDPD20	-CB1 CTDPD20	-Q-CB2 CTDPD20
				F	F	F	M	F	M
				DIAMOND	DIAMOND	DIAMOND	DIAMOND	DIAMOND	DIAMOND
				CCGW	CCGW	CCGT	CCGT	CCGT	CCGT
				PC	PC	PC	PC	PC	PC
ISO	RE mm	TCE (NOI)	LE mm	71 172 ...	71 172 ...	71 300 ...	71 168 ...	71 305 ...	71 169 ...
060202FN	0.2	A (1)	3.40						
060204FN	0.4	A (1)	3.10			102		104	
060204FN	0.4	A (1)	3.20			104	10001		
060204FRR	0.4	A (1)	6.45		10101				
060204FLL	0.4	A (1)	6.45	10001					
060208FN	0.8	A (1)	3.00			10600			
09T302FN	0.2	A (1)	4.40						10001
09T302FN	0.2	A (1)	4.50			112			
09T304FN	0.4	A (1)	4.20					114	10101
09T304FN	0.4	A (1)	4.30			114			
09T308FN	0.8	A (1)	4.10			118			
09T308FRR	0.8	A (1)	9.70		10301				
09T308FLL	0.8	A (1)	9.70	10201					
09T312FLL	1.2	A (1)	9.70	10401					
120404FN	0.4	A (1)	4.20					124	10201
120404FN	0.4	A (1)	4.30			124			
120408FN	0.8	A (1)	4.10			128			
120412FRR	1.2	A (1)	12.90		10601				
120412FLL	1.2	A (1)	12.90	10501					
P									
M									
K									
N				•	•	•	•	•	•
S									
H									
O				•	•	•	•	•	•

CoreLine – PCD turning indexable insert

CCGT / CCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners



ISO	RE mm	TCE (NOI)	LE mm	PC	PC	PC	PC	PC	PC
				71 166 ...	71 125 ...	71 126 ...	71 170 ...	71 170 ...	71 301 ...
060201FN	0.1	A (1)	3.50	20001					
060202FN	0.2	A (1)	3.30		152	152			
060202FN	0.2	A (1)	3.40	20101					202
060204FN	0.4	A (1)	3.20						204
060204FRR	0.4	A (1)	6.45					20101	
060204FLL	0.4	A (1)	6.45				20001		
060208FN	0.8	A (1)	3.00						208
060208FRR	0.8	A (1)	6.45				20201	20301	
060208FLL	0.8	A (1)	6.45						
09T301FN	0.1	A (1)	4.50		16300				
09T302FN	0.2	A (1)	4.40		162	162			
09T302FN	0.2	A (1)	4.50	20201					212
09T304FN	0.4	A (1)	4.30						214
09T308FN	0.8	A (1)	4.10						218
09T308FRR	0.8	A (1)	9.70					20501	
09T308FLL	0.8	A (1)	9.70				20401		
120402FN	0.2	A (1)	4.40			172			
120404FN	0.4	A (1)	4.20			174			
120404FN	0.4	A (1)	4.30	20301					224
120408FN	0.8	A (1)	4.10						228
120412FRR	1.2	A (1)	12.90					20701	
120412FLL	1.2	A (1)	12.90				20601		
P									
M									
K									
N				•	•	•	•	•	•
S									
H									
O				•	•	•	•	•	•

CoreLine – PCD turning indexable insert

CCGT / CCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners

ISO	RE mm	TCE (NOI)	LE mm
060201FN	0.1	A (1)	3.5
060202FN	0.2	A (1)	3.3
060202FN	0.2	A (1)	3.4
060204FN	0.4	A (1)	3.1
060204FN	0.4	A (1)	3.2
09T302FN	0.2	A (1)	4.4
09T302FN	0.2	A (1)	4.5
09T304FN	0.4	A (1)	4.2
09T304FN	0.4	A (1)	4.3
09T308FN	0.8	A (1)	4.1
120402FN	0.2	A (1)	4.4
120404FN	0.4	A (1)	4.2
120404FN	0.4	A (1)	4.3

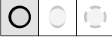
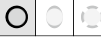
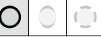
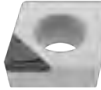
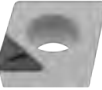
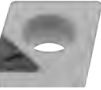
P				
M				
K				
N		•	•	•
S				
H				
O		•	•	•

-Q-CB2 CTDPS30	CTDPU20	-CB3 CTDPU20	CTDPS30
M DIAMOND CCGT	F DIAMOND CCGW	R DIAMOND CCGT	F DIAMOND CCGW
PC	PC	PC	PC
71 306 ...	71 171 ...	71 302 ...	71 171 ...
202			20001
204			20101
212		204	20201
214			20301
	30001 30101	214 218	20401
222 224			
			20501

CoreLine – PCD turning indexable insert

CCGW / CCGT

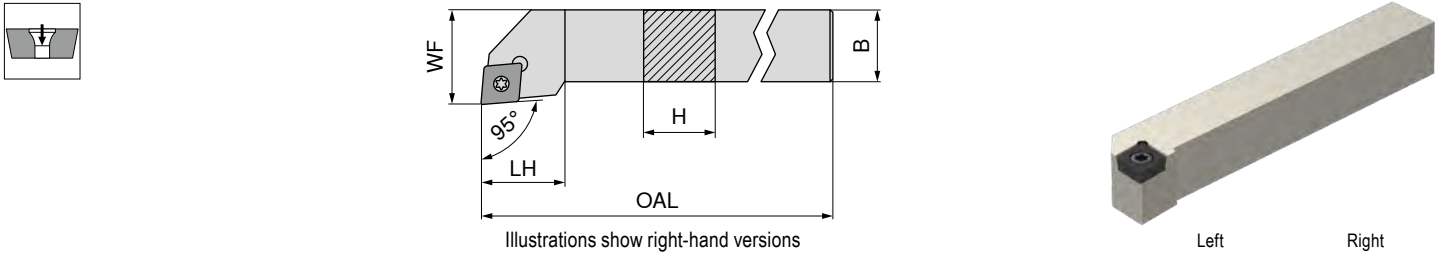
▲ TCE(NOI) = Design and number of equipped cutting edge corners

				CTDCD10	-CB1 CTDCD10	-Q-CB1 CTDCD10	-CB2 CTDCD10	-Q-CB2 CTDCD10
								
								
				F DIAMOND CCGW	F DIAMOND CCGT	F DIAMOND CCGT	M DIAMOND CCGT	M DIAMOND CCGT
				PC	PC	PC	PC	PC
ISO	RE mm	TCE (NOI)	LE mm	71 171 ...	71 300 ...	71 167 ...	71 301 ...	71 306 ...
060202FN	0.2	A (1)	2.3			40001		
060202FN	0.2	A (1)	2.4	40001	302		30200	
060204FN	0.4	A (1)	2.1			40101		304
060204FN	0.4	A (1)	2.2	40101	304		304	
060208FN	0.8	A (1)	2.0		30600			
09T302FN	0.2	A (1)	2.3					31200
09T302FN	0.2	A (1)	2.4	40201			31200	
09T304FN	0.4	A (1)	2.1			40201		314
09T304FN	0.4	A (1)	2.2	40301	314		314	
09T308FN	0.8	A (1)	2.0	40401			31600	
120404FN	0.4	A (1)	2.1			40301		324
120404FN	0.4	A (1)	2.2				32600	
120408FN	0.8	A (1)	2.0	40501				
120408FN	0.8	A (1)	2.1				328	
P								
M								
K								
N				•	•	•	•	•
S								
H								
O				•	•	•	•	•

CoreLine – SCLC 95° – Tool holder with screw clamping

Scope of supply:

Tool holder with Torx key



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
SCLC R/L 0808 D06	8	8	60	9	10	1,2	CC.. 0602
SCLC R/L 1010 E06	10	10	70	9	12	1,2	CC.. 0602
SCLC R/L 1212 F09	12	12	80	15	16	3,2	CC.. 09T3
SCLC R/L 1616 H09	16	16	100	17	20	3,2	CC.. 09T3
SCLC R/L 2020 K09	20	20	125	17	25	3,2	CC.. 09T3
SCLC R/L 1616 H12	16	16	100	20	20	5	CC.. 1204
SCLC R/L 2020 K12	20	20	125	20	25	5	CC.. 1204
SCLC R/L 2525 M12	25	25	150	20	32	5	CC.. 1204
SCLC R/L 3225 P12	32	25	170	20	32	5	CC.. 1204

Left	Right
TO	TO
70 636 ...	70 636 ...
00800	00801
01000	01001
01200	01201
01600	01601
02000	02001
11600	11601
12000	12001
12500	12501
13200	13201

Spare parts
for article number

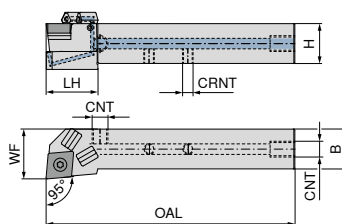
70 636 00801 / 70 636 00800
70 636 01001 / 70 636 01000
70 636 01201 / 70 636 01200
70 636 01601 / 70 636 01600
70 636 02001 / 70 636 02000
70 636 11601 / 70 636 11600
70 636 12001 / 70 636 12000
70 636 12501 / 70 636 12500
70 636 13201 / 70 636 13200

			
Screwdriver	Clamping screw	Carbide seat C	Threaded bush
AS	AS	AS	AS
80 950 ...	70 950 ...	70 950 ...	70 950 ...
039	857		
039	857		
120	87900		
120	87900		
120	87900		
120	820	166	170
120	820	166	170
120	820	166	170
120	820	166	170

CoreLine – SCLC 95° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions



Left

Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Tightening torque Nm	Indexable insert	TO 70 770 ...	TO 70 770 ...
SCLC R/L 1010 E06 DC	10	10	70	14	12	M6	M6	1,2	CC.. 0602	01001	01000
SCLC R/L 1212 F09 DC	12	12	80	19	16	M6	M6	3,2	CC.. 09T3	01201	01200
SCLC R/L 1616 H09 DC	16	16	100	26	20	M6	G1/8"	3,2	CC.. 09T3	11601	01600
SCLC R/L 2020 K09 DC	20	20	125	28	25	M6	G1/8"	3,2	CC.. 09T3	12001	02000
SCLC R/L 1616 H12 DC	16	16	100	28	20	M6	G1/8"	5	CC.. 1204	01601	11600
SCLC R/L 2020 K12 DC	20	20	125	26	25	M6	G1/8"	5	CC.. 1204	02001	12000
SCLC R/L 2525 M12 DC	25	25	150	28	30	M6	G1/8"	5	CC.. 1204	02501	02500
SCLC R/L 3225 P12 DC	32	25	170	26	32	G1/8"	G1/8"	5	CC.. 1204	03201	03200

Spare parts for article number

	Clamping screw	Carbide seat C	Set Screw	Set Screw	Threaded bush
70 770 01000 / 70 770 01001	857			86700	
70 770 01200 / 70 770 01201	859			86700	
70 770 01600 / 70 770 11601	87900	165	88000	86700	171
70 770 02000 / 70 770 12001	87900	165	88000	86700	171
70 770 11600 / 70 770 01601	820	166	88000	86700	170
70 770 12000 / 70 770 02001	820	166	88000	86700	170
70 770 02500 / 70 770 02501	820	166	88000	86700	170
70 770 03200 / 70 770 03201	820	166	88000		170

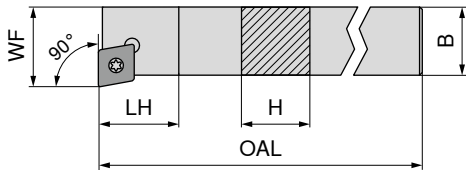
Spare parts for article number

	Sealing plugs DC	Screwdriver	O ring	Coolant nozzle DC	Coolant screw plug
70 770 01000 / 70 770 01001		039			
70 770 01200 / 70 770 01201		120			
70 770 01600 / 70 770 11601	87600	120	88100	87700	294
70 770 02000 / 70 770 12001	87600	120	88100	87700	294
70 770 11600 / 70 770 01601	87600	120	88100	87700	294
70 770 12000 / 70 770 02001	87600	120	88100	87700	294
70 770 02500 / 70 770 02501	87600	120	88100	87700	294
70 770 03200 / 70 770 03201	87600	120	88100	87700	294

CoreLine – SCFC 90° – Tool holder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
SCFC R 0808 D06	8	8	60	10	10	1,2	CC.. 0602
SCFC R 1010 E06	10	10	70	10	12	1,2	CC.. 0602
SCFC R 1212 F09	12	12	80	13	16	3,2	CC.. 09T3
SCFC R 1616 H09	16	16	100	13	20	3,2	CC.. 09T3
SCFC R/L 2020 K12	20	20	125	17	25	5	CC.. 1204

Left	Right
TO	TO
70 761 ...	70 760 ...
	008
	010
	012
	016
02000 ¹⁾	020

1) Nickel plated

Spare parts
for article number

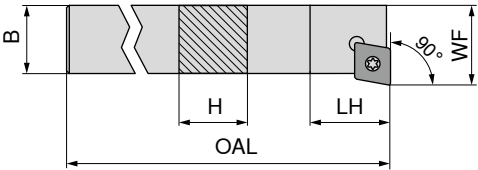
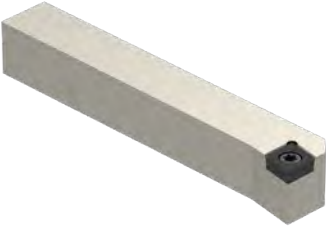
70 760 008
70 760 010
70 760 012
70 760 016
70 760 020 / 70 761 02000

Screwdriver	Combi key	Clamping screw	Carbide seat C	Threaded bush
AS	AS	AS	AS	AS
80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
110		13800		
110		13800		
113		113		
	398	113	165	171
	398	114	166	170

CoreLine – SCFC 90° – Tool holder with screw clamping

Scope of supply:

Tool holder with Torx key



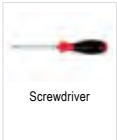
Left

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
SCFC L 0808 D06	8	8	60	10	10	1,2	CC.. 0602
SCFC L 1010 E06	10	10	70	10	12	1,2	CC.. 0602
SCFC L 1212 F09	12	12	80	13	16	3,2	CC.. 09T3
SCFC L 1616 H09	16	16	100	13	20	3,2	CC.. 09T3

TO
70 635 ...
00800
01000
01200
01600

Spare parts
for article number

70 635 00800
70 635 01000
70 635 01200
70 635 01600



Screwdriver



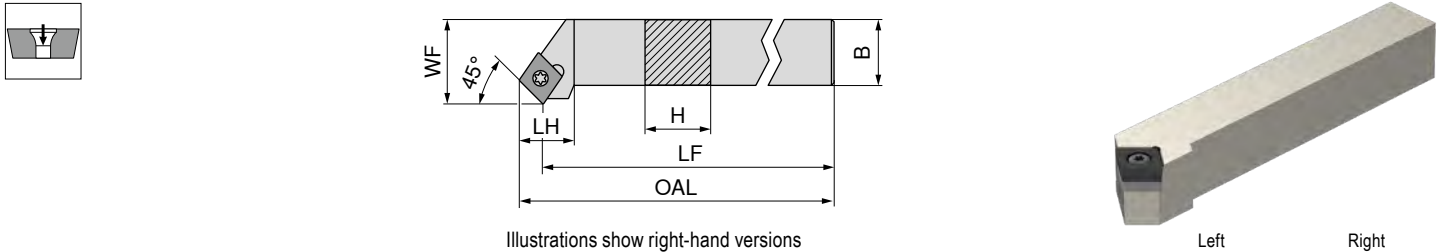
Clamping screw

AS
80 950 ...
039
039
120
120

AS
70 950 ...
857
857
87900
87900

CoreLine – SCSC 45° – Tool holder with screw clamping

Scope of supply:
Tool holder with Torx key



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
SCSC R 1616 H12	16	16	108.45	20	20	5	CC.. 1204
SCSC R/L 2020 K12	20	20	133.45	20	25	5	CC.. 1204
SCSC R/L 2525 M12	25	25	158.45	20	32	5	CC.. 1204

Left	Right
TO	TO
70 638 ...	70 638 ...
02000	01601
02500	02001
	02501

Spare parts
for article number

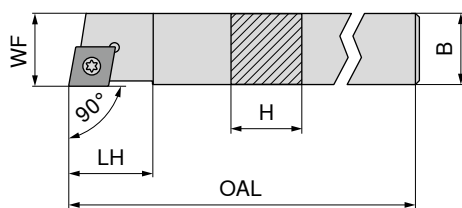
	 Screwdriver	 Clamping screw	 Carbide seat C	 Threaded bush
	AS	AS	AS	AS
	80 950 ...	70 950 ...	70 950 ...	70 950 ...
70 638 01601	T15 - IP120	M4,5x12 - 15IP820	166	M4,5170
70 638 02001 / 70 638 02000	T15 - IP120	M4,5x12 - 15IP820	166	M4,5170
70 638 02501 / 70 638 02500	T15 - IP120	M4,5x12 - 15IP820	166	M4,5170

CoreLine – SCAC 90° – Tool holder with screw clamping

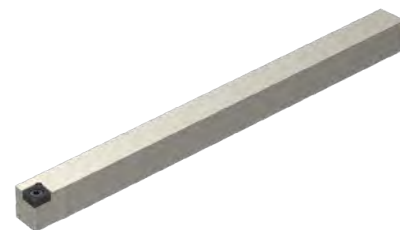
▲ For sliding head lathes

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

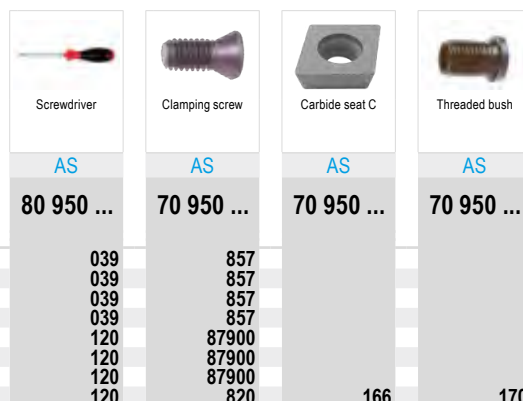


Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	Left	Right
								TO 70 633 ...	TO 70 633 ...
SCAC R/L 0808 K06	8	8	125	9	8	1,2	CC.. 0602	10800	10801
SCAC R/L 0808 D06	8	8	60	9	8	1,2	CC.. 0602	00800	00801
SCAC R/L 1010 E06	10	10	70	9	10	1,2	CC.. 0602	01000	01001
SCAC R/L 1010 M06	10	10	150	9	10	1,2	CC.. 0602	11000	11001
SCAC R/L 1212 F09	12	12	80	13	12	3,2	CC.. 09T3	01200	01201
SCAC R/L 1212 M09	12	12	150	13	12	3,2	CC.. 09T3	11200	11201
SCAC R/L 1616 H09	16	16	100	13	16	3,2	CC.. 09T3	11600	11601
SCAC R/L 2020 K12	20	20	125	17	20	5	CC.. 1204	12000	12001

Spare parts

for article number

	AS 80 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 633 10801 / 70 633 10800	039	857		
70 633 00801 / 70 633 00800	039	857		
70 633 01001 / 70 633 01000	039	857		
70 633 11001 / 70 633 11000	039	857		
70 633 01201 / 70 633 01200	120	87900		
70 633 11201 / 70 633 11200	120	87900		
70 633 11601 / 70 633 11600	120	87900		
70 633 12001 / 70 633 12000	120	820	166	170

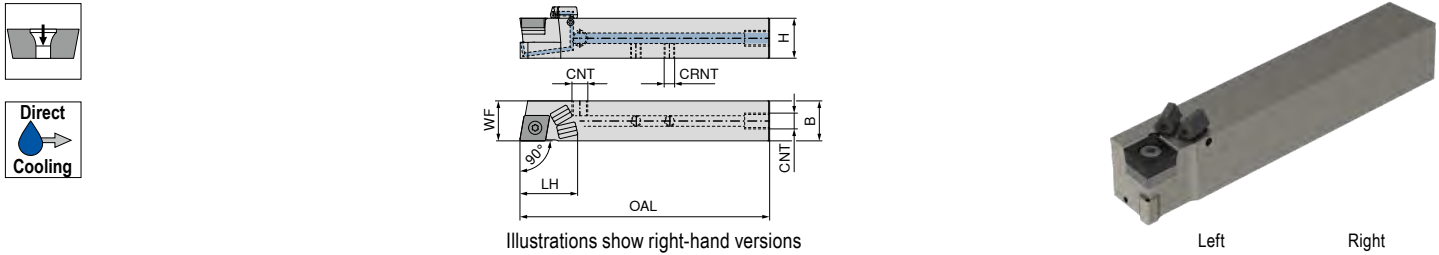


CoreLine – SCAC 90° DC – Tool holder with screw clamping

▲ For sliding head lathes

Scope of supply:

Tool holder with blind plug and Torx key



Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Tightening torque Nm	Indexable insert	Left TO 70 766 ...	Right TO 70 766 ...
SCAC R/L 1212 M09 DC	12	12	150	21	12	M6	M6	3,2	CC.. 09T3	11201	11200
SCAC R/L 1212 F09 DC	12	12	80	22	12	M6	M6	3,2	CC.. 09T3	01201	01200
SCAC R/L 1616 H09 DC	16	16	100	30	16	M6	G1/8"	3,2	CC.. 09T3	01601	01600
SCAC R/L 2020 K12 DC	20	20	125	30	20	M6	G1/8"	5	CC.. 1204	02001	02000

Spare parts
for article number

70 766 11200 / 70 766 11201	859				
70 766 01200 / 70 766 01201	859				
70 766 01600 / 70 766 01601	87900	165	88000	86700	171
70 766 02000 / 70 766 02001	820	166	88000	86700	170

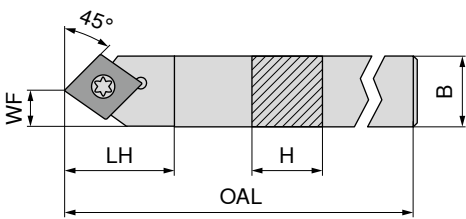
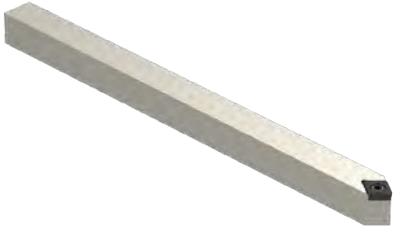
Spare parts
for article number

70 766 11200 / 70 766 11201		120			
70 766 01200 / 70 766 01201		120			
70 766 01600 / 70 766 01601	87600	120	88100	87700	294
70 766 02000 / 70 766 02001	87600	120	88100	87700	294

CoreLine – SCDC 45° – Tool holder with screw clamping

Scope of supply:

Tool holder with Torx key

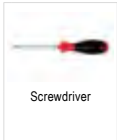


Left

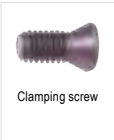
Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	TO	
								70 634 ...	
SCDC L 0808 K06	8	8	125	13	4	1,2	CC.. 0602		00800
SCDC L 1010 M06	10	10	150	13	5	1,2	CC.. 0602		01000
SCDC L 1212 M09	12	12	150	18	6	3,2	CC.. 09T3		01200
SCDC L 1414 M09	14	14	150	18	7	3,2	CC.. 09T3		01400

Spare parts
for article number

			AS			AS	
			80 950 ...			70 950 ...	
70 634 00800	T08 - IP	039		M2,5x6 - 08IP		857	
70 634 01000	T08 - IP	039		M2,5x6 - 08IP		857	
70 634 01200	T15 - IP	120		M3,5x11		87900	
70 634 01400	T15 - IP	120		M3,5x11		87900	



Screwdriver

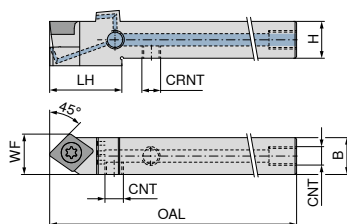


Clamping screw

CoreLine – SCDC 45° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Left

Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Tightening torque Nm	Indexable insert	TO 70 767 ...
SCDC L 0808 K06 DC	8	8	125	17	8.5	M5	M5	1,2	CC.. 0602	00801
SCDC L 1010 M06 DC	10	10	150	17	10.0	M6	M6	1,2	CC.. 0602	01001
SCDC L 1212 M09 DC	12	12	150	23	13.0	M6	M6	3,2	CC.. 09T3	01201
SCDC L 1414 M09 DC	14	14	150	25	14.0	M6	G1/8"	3,2	CC.. 09T3	01401

Spare parts for article number

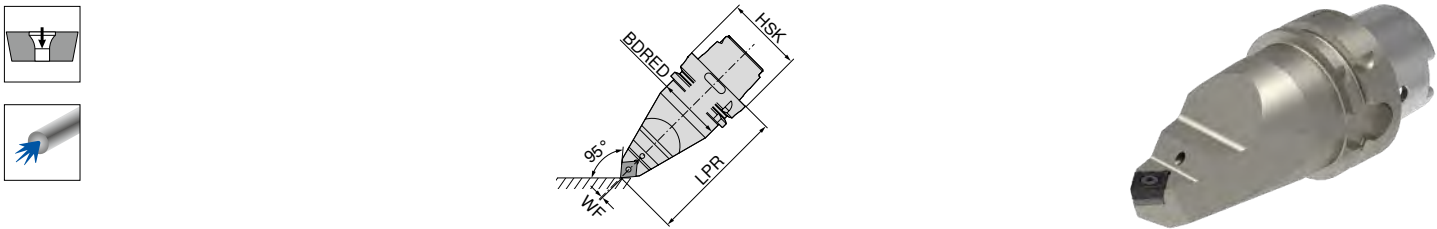
	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 767 00801		M2,5x6 - T08 13800	
70 767 01001		M2,5x6 - T08 13800	M6x6 86700
70 767 01201		M3,5x11 113	M6x6 86700
70 767 01401	G 1/8" 294	M3,5x11 113	M6x6 86700

Spare parts for article number

	CT 83 950 ...	AS 80 950 ...
70 767 00801	M5x5 - SW2,5 157	T08 - IP 039
70 767 01001		T08 - IP 039
70 767 01201		T15 - IP 120
70 767 01401		T15 - IP 120

CoreLine – SCMC 50° – Tool holder with screw clamping

Scope of supply:
Tool holder with Torx key



Designation	Adapter	LPR mm	BDRED mm	WF mm	Tightening torque Nm	Indexable insert	Neutral TO 74 542 ... 512
HSK T63 SCMC N 12	HSK-T 63	115	53	0	5	CC.. 1204	

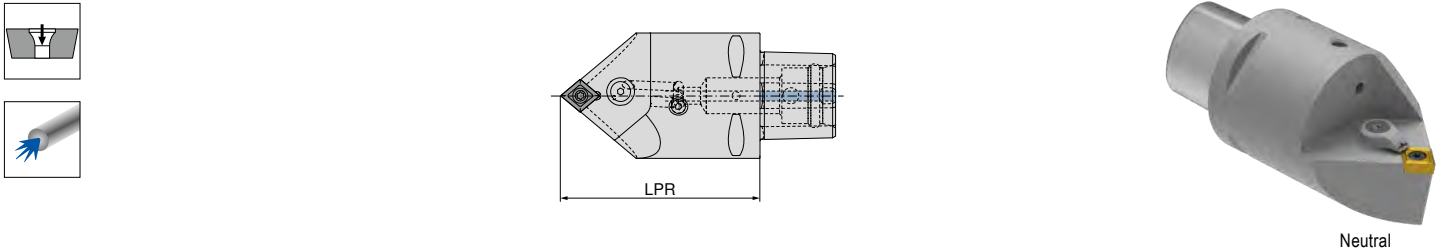


The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra.

Spare parts for article number				
	Combi key	Clamping screw	Carbide seat C	Threaded bush
	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
74 542 512	T15/SW 398	M4,5x12 114	166	M4,5 170

CoreLine – SCMC 50° – Tool holder with screw clamping

Scope of supply:
Without high-performance coolant set



Designation	Adapter	LPR mm	Tightening torque Nm	Indexable insert	Direct cooling compatible	TO 84 674 ... 01293 11293
PSC63 SCMC N 0100-12	PSC 63	100	5	CC.. 1204	DC	
PSC63 SCMC N 0130-12	PSC 63	130	5	CC.. 1204	DC	

 The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra.


Clamping screw

AS
84 950 ...
27500
27500

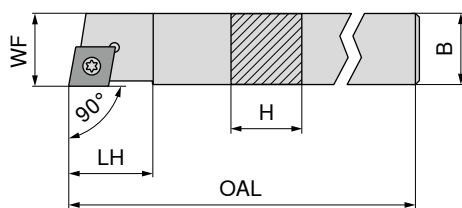
Spare parts for article number
84 674 01293
84 674 11293

CoreLine – SCAC 90° – Tool holder with screw clamping

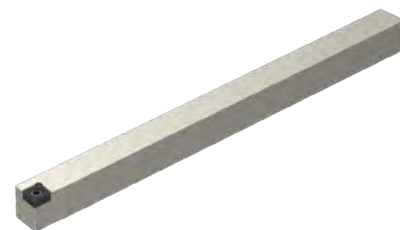
▲ For sliding head lathes

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

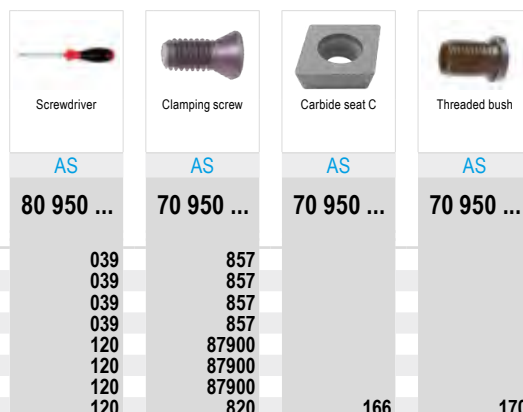


Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	Left	Right
								TO 70 633 ...	TO 70 633 ...
SCAC R/L 0808 D06	8	8	60	9	8	1,2	CC.. 0602	00800	00801
SCAC R/L 1010 E06	10	10	70	9	10	1,2	CC.. 0602	01000	01001
SCAC R/L 0808 K06	8	8	125	9	8	1,2	CC.. 0602	10800	10801
SCAC R/L 1010 M06	10	10	150	9	10	1,2	CC.. 0602	11000	11001
SCAC R/L 1212 F09	12	12	80	13	12	3,2	CC.. 09T3	01200	01201
SCAC R/L 1616 H09	16	16	100	13	16	3,2	CC.. 09T3	11600	11601
SCAC R/L 1212 M09	12	12	150	13	12	3,2	CC.. 09T3	11200	11201
SCAC R/L 2020 K12	20	20	125	17	20	5	CC.. 1204	12000	12001

Spare parts

for article number

	AS 80 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 633 00801 / 70 633 00800	039	857		
70 633 01001 / 70 633 01000	039	857		
70 633 10801 / 70 633 10800	039	857		
70 633 11001 / 70 633 11000	039	857		
70 633 01201 / 70 633 01200	120	87900		
70 633 11601 / 70 633 11600	120	87900		
70 633 11201 / 70 633 11200	120	87900		
70 633 12001 / 70 633 12000	120	820	166	170

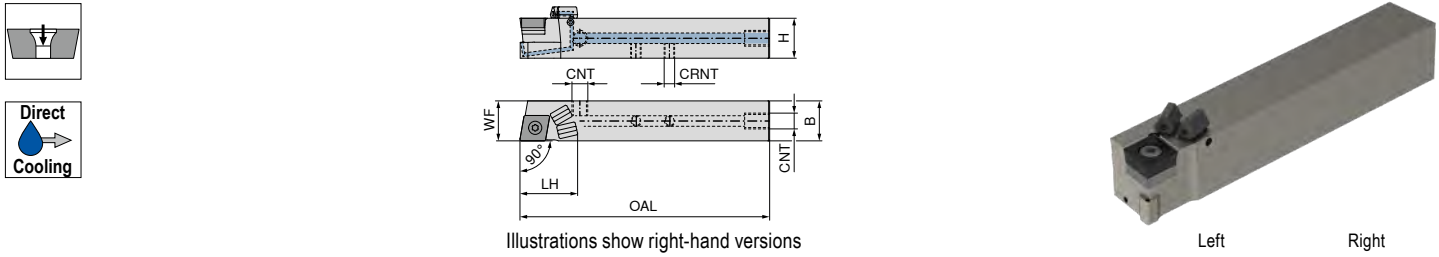


CoreLine – SCAC 90° DC – Tool holder with screw clamping

▲ For sliding head lathes

Scope of supply:

Tool holder with blind plug and Torx key



Designation	H mm	B mm	OAL mm	LH mm	WF mm	CNT	CRNT	Tightening torque Nm	Indexable insert	Left TO 70 766 ...	Right TO 70 766 ...
SCAC R/L 1212 F09 DC	12	12	80	22	12	M6	M6	3,2	CC.. 09T3	01201	01200
SCAC R/L 1212 M09 DC	12	12	150	21	12	M6	M6	3,2	CC.. 09T3	11201	11200
SCAC R/L 1616 H09 DC	16	16	100	30	16	G1/8"	M6	3,2	CC.. 09T3	01601	01600
SCAC R/L 2020 K12 DC	20	20	125	30	20	G1/8"	M6	5	CC.. 1204	02001	02000

Spare parts
for article number

	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 766 01200 / 70 766 01201	859			86700	
70 766 11200 / 70 766 11201	859			86700	
70 766 01600 / 70 766 01601	87900	165	88000	86700	171
70 766 02000 / 70 766 02001	820	166	88000	86700	170

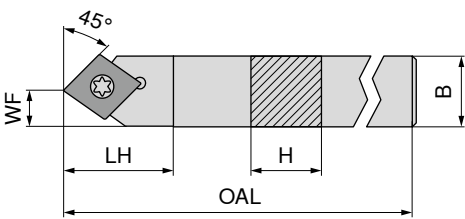
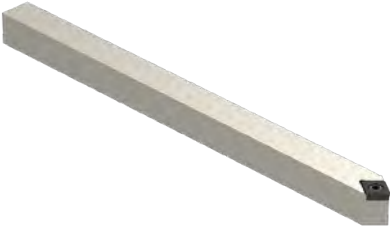
Spare parts
for article number

	AS 70 950 ...	AS 80 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 766 01200 / 70 766 01201		120			
70 766 11200 / 70 766 11201		120			
70 766 01600 / 70 766 01601	87600	120	88100	87700	294
70 766 02000 / 70 766 02001	87600	120	88100	87700	294

CoreLine – SCDC 45° – Tool holder with screw clamping

Scope of supply:

Tool holder with Torx key

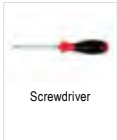


Left

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	TO
SCDC L 0808 K06	8	8	125	13	4	1,2	CC.. 0602	70 634 ... 00800
SCDC L 1010 M06	10	10	150	13	5	1,2	CC.. 0602	01000
SCDC L 1212 M09	12	12	150	18	6	3,2	CC.. 09T3	01200
SCDC L 1414 M09	14	14	150	18	7	3,2	CC.. 09T3	01400

Spare parts
for article number

70 634 00800	T08 - IP	039	M2,5x6 - 08IP	857
70 634 01000	T08 - IP	039	M2,5x6 - 08IP	857
70 634 01200	T15 - IP	120	M3,5x11	87900
70 634 01400	T15 - IP	120	M3,5x11	87900



Screwdriver

AS

80 950 ...



Clamping screw

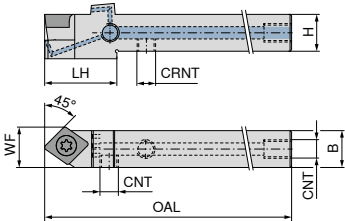
AS

70 950 ...

CoreLine – SCDC 45° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Designation	H mm	B mm	OAL mm	LH mm	WF mm	CNT	CRNT	Tightening torque Nm	Indexable insert	Left TO 70 767 ...
SCDC L 0808 K06 DC	8	8	125	17	8.5	M5	M5	1,2	CC.. 0602	00801
SCDC L 1010 M06 DC	10	10	150	17	10.0	M6	M6	1,2	CC.. 0602	01001
SCDC L 1212 M09 DC	12	12	150	23	13.0	M6	M6	3,2	CC.. 09T3	01201
SCDC L 1414 M09 DC	14	14	150	25	14.0	G1/8"	M6	3,2	CC.. 09T3	01401

Spare parts
for article number

	CT 83 950 ...	AS 80 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 767 00801	157	039		13800	
70 767 01001		039		13800	86700
70 767 01201		120		113	86700
70 767 01401		120	294	113	86700



Cylindrical screw

CT

83 950 ...



Screwdriver

AS

80 950 ...



Coolant screw plug

AS

70 950 ...



Clamping screw

AS

70 950 ...



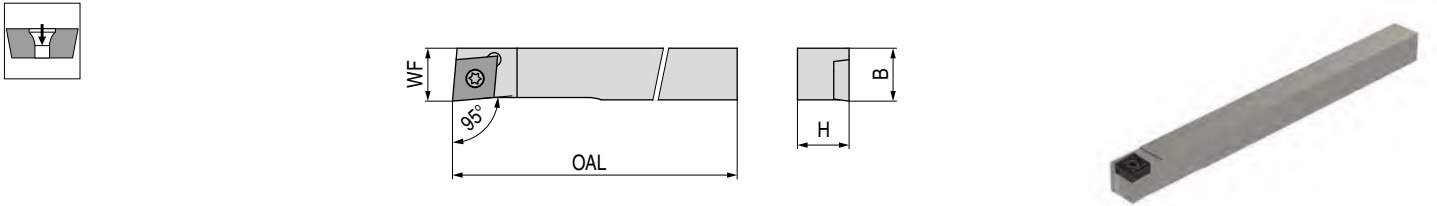
Set Screw

AS

70 950 ...

CoreLine – SCLC 95° – Tool holder with screw clamping

▲ For sliding head lathes



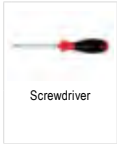
Illustrations show right-hand versions

Designation	H mm	B mm	OAL mm	WF mm	Indexable insert
SCLC R/L 0808 H06	8	8	100	8	CC.. 0602
SCLC R/L 1010 H06	10	10	100	10	CC.. 0602
SCLC R/L 1212 H09	12	12	100	12	CC.. 09T3

Left	Right
TO	TO
72 353 ...	72 352 ...
008	008
010	010
012	012

Spare parts
for article number

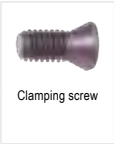
72 352 008 / 72 353 008	T08	110	M2,5x6 - T08	13800
72 352 010 / 72 353 010	T08	110	M2,5x6 - T08	13800
72 352 012 / 72 353 012	T15	113	M3,5x11	113



Screwdriver

AS

80 950 ...



Clamping screw

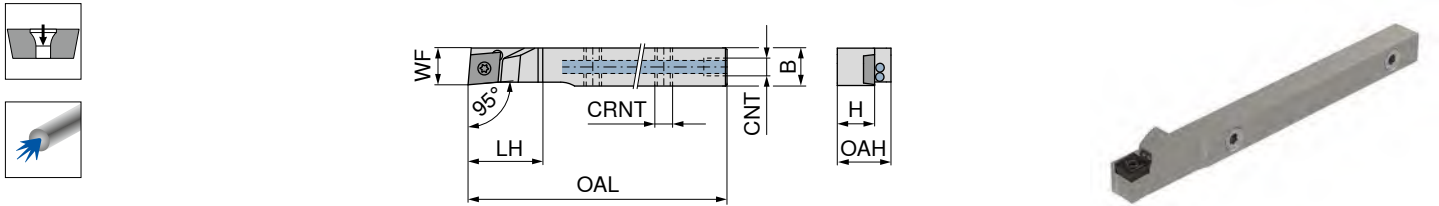
AS

70 950 ...

CoreLine – SCLC 95° – Tool holder with through coolant

▲ For sliding head lathes

Scope of supply:
Holder without coolant connection



Illustrations show right-hand versions

Designation	H mm	B mm	OAL mm	LH mm	WF mm	CNT	CRNT	Indexable insert
SCLC R/L 0808 H06 IC	8	8	100	16	8	M5	M5	CC.. 0602
SCLC R/L 1010 H06 IC	10	10	100	16	10	M5	M5	CC.. 0602
SCLC R/L 1212 H09 IC	12	12	100	19	12	M5	M5	CC.. 09T3
SCLC R/L 1616 K09 IC	16	16	125	19	16	M5	M5	CC.. 09T3

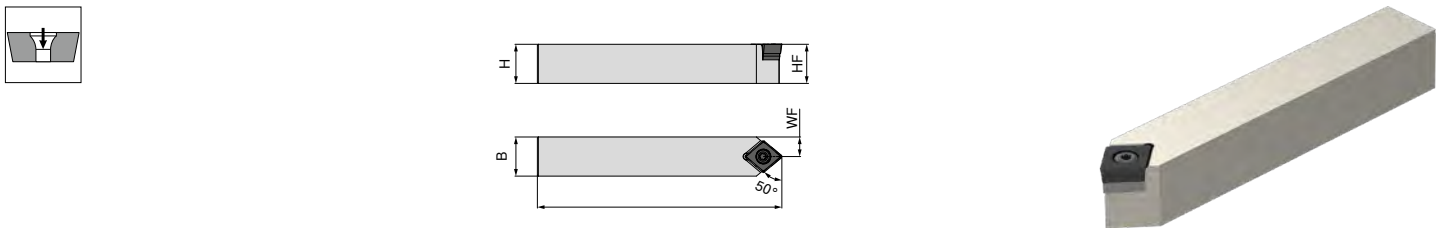
Left	Right
TO	TO
72 351 ...	72 350 ...
008	008
010	010
012	012
016	016

Spare parts
for article number

72 350 008 / 72 351 008
72 350 010 / 72 351 010
72 350 012 / 72 351 012
72 350 016 / 72 351 016

 Screw plug	 Screwdriver	 Clamping screw
AS	AS	AS
72 950 ...	80 950 ...	70 950 ...
011	110	13800
011	110	13800
011	113	113
011	113	113

CoreLine – SCMC 50° – Tool holder with screw clamping



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	Neutral	
SCMC N 2020 K12	20	20	125	25	10.0	5	CC.. 1204	TO	70 637 ...
SCMC N 2525 M12	25	25	150	25	12.5	5	CC.. 1204		02000
									02500

Spare parts
for article number

70 637 02000	120	820	166	170
70 637 02500	120	820	166	170

			
Screwdriver	Clamping screw	Carbide seat C	Threaded bush
AS	AS	AS	AS
80 950 ...	70 950 ...	70 950 ...	70 950 ...
120	820	166	170
120	820	166	170

Technical drawing of a 1/2" x 1" x 16" 303 stainless steel angle bracket. The drawing includes a top view showing a 75-degree angle and dimensions WF, LH, H, OAL, and B. A 3D perspective view shows the bracket with a "Left" label.

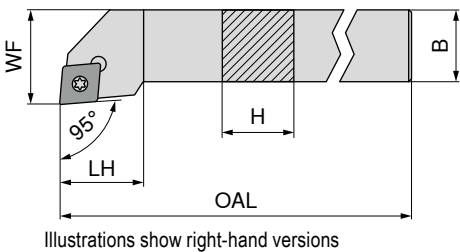
Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	70 649 ...
SCRC L 1212 F09	12	12	80	16	13	3,2	CC..09T3	01200 ¹⁾
SCRC L 2020 K09	20	20	125	17	22	3,2	CC..09T3	02000 ¹⁾

				
Screwdriver	Combi key	Clamping screw	Carbide seat C	Threaded bush
AS	AS	AS	AS	AS
80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
113		113		
	398	113	165	171

CoreLine – SCLC 95° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Left Right

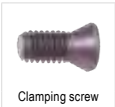
ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert
SCLC R/L 06-2	0.375	0.375	2.500	0.472	0.500	CC..21.5..
SCLC R/L 08-3	0.500	0.500	3.500	0.587	0.625	CC..32.5..
SCLC R/L 10-3	0.625	0.625	4.000	0.614	0.750	CC..32.5..
SCLC R/L 12-3B	0.750	0.750	4.500	0.563	1.000	CC..32.5..
SCLC R/L 16-3D	1.000	1.000	6.000	1.079	1.250	CC..32.5..
SCLC R/L 12-4B	0.750	0.750	4.500	0.839	1.000	CC..43..
SCLC R/L 16-4D	1.000	1.000	6.000	0.843	1.250	CC..43..
SCLC R/L 20-4D	1.250	1.250	6.000	1.079	1.500	CC..43..

TO	TO
78 553 ...	78 552 ...
00602 ¹⁾	00602 ¹⁾
00803	00803
01003 ¹⁾	01003 ¹⁾
01223	01223
01643	01643
01224 ¹⁾	01224 ¹⁾
01644 ¹⁾	01644 ¹⁾
02044 ¹⁾	02044 ¹⁾

1) Not in stock

Spare parts

78 552 01644 / 78 553 02044
78 552 01223 / 78 553 01003
78 552 00602 / 78 553 00602

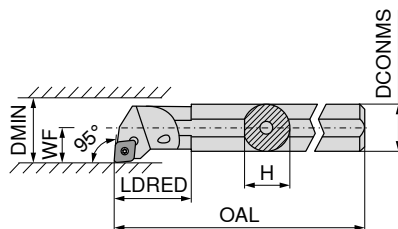
 Clamping screw	 Carbide seat C	 Threaded bush	 Key I - TORX®
AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...
	04500	04800	04700
05600			05700
06200			06400

CoreLine – SCLC 95° – Boring bar with screw clamping

- ▲ A... = with coolant hole
 ▲ S... = without coolant hole

Scope of supply:

Boring bar with Torx key



Illustrations show right-hand versions



Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert
S08H SCLC R/L 06	8	7.2	100	11.0	5	11	1,2	CC.. 0602
A08F SCLC R/L 06	8	7.6	80	17.0	5	11	1,2	CC.. 0602
S10K SCLC R/L 06	10	9.0	125	15.0	7	13	1,2	CC.. 0602
A10H SCLC R/L 06	10	9.5	100	19.0	7	13	1,2	CC.. 0602
S12Q SCLC R/L 06	12	11.0	180	18.8	9	16	1,2	CC.. 0602
A12K SCLC R/L 06	12	11.5	125	22.0	9	16	1,2	CC.. 0602
A16M SCLC R/L 06	16	14.0	150	50.0	9	18	1,2	CC.. 0602
S16R SCLC R/L 09	16	14.5	200	25.0	11	20	3,2	CC.. 09T3
A16M SCLC R/L 09	16	15.0	150	29.0	11	20	3,2	CC.. 09T3
S20S SCLC R/L 09	20	18.0	250	25.0	13	25	3,2	CC.. 09T3
A20Q SCLC R/L 09	20	18.5	180	32.0	13	25	3,2	CC.. 09T3
S25T SCLC R/L 09	25	23.0	300	20.0	17	32	3,2	CC.. 09T3
A25R SCLC R/L 09	25	23.0	200	36.0	17	32	3,2	CC.. 09T3
A32S SCLC R/L 12	32	30.0	250	50.0	22	40	5	CC.. 1204
A40T SCLC R/L 12	40	38.0	300	60.0	27	50	5	CC.. 1204

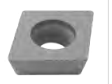
Left

Right

TO	TO
70 717 ...	70 716 ...
008	008
208	208
010	010
210	210
012	012
212	212
116	116
016	016
216	216
020	020
220	220
025	025
225	225
232	232
240	240

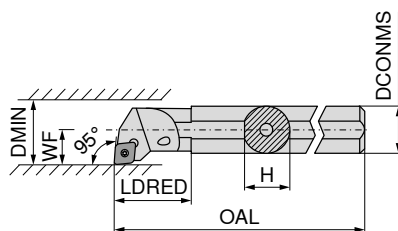
Spare parts for article number

70 716 008 / 70 717 008
70 716 208 / 70 717 208
70 716 010 / 70 717 010
70 716 210 / 70 717 210
70 716 012 / 70 717 012
70 716 212 / 70 717 212
70 716 116 / 70 717 116
70 716 016 / 70 717 016
70 716 216 / 70 717 216
70 716 020 / 70 717 020
70 716 220 / 70 717 220
70 716 025 / 70 717 025
70 716 225 / 70 717 225
70 716 232 / 70 717 232
70 716 240 / 70 717 240

				
Screwdriver	Combi key	Clamping screw	Carbide seat C	Threaded bush
AS	AS	AS	AS	AS
80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
110		116		
110		116		
110		116		
110		116		
110		116		
110		116		
110		116		
113		110		
113		110		
113		110		
113		304		
113		113		
113		304		
	398	114	166	170
	398	114	166	170

CoreLine – SCLC 95° – Boring bar with screw clamping

▲ With carbide core



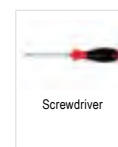
Illustrations show right-hand versions



Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	Left	Right
									TO 70 719 ...	TO 70 718 ...
E-A08F SCLC R/L 06	8	7.5	80	20.60	6	12	1,2	CC.. 0602	208	208
E-A10H SCLC R/L 06	10	9.0	100	31.75	7	14	1,2	CC.. 0602	210	210
E-A12K SCLC R/L 06	12	11.0	125	20.00	9	18	1,2	CC.. 0602	212	212
E-A16M SCLC R/L 09	16	15.0	150	45.30	11	22	3,2	CC.. 09T3	216	216
E-A20Q SCLC R/L 09	20	18.0	180	38.00	13	26	3,2	CC.. 09T3	220	220
E-A25R SCLC R/L 09	25	23.0	200	40.25	17	34	3,2	CC.. 09T3	225	225

Spare parts for article number

70 718 208 / 70 719 208	T08	110	M2,5x5	116
70 718 210 / 70 719 210	T08	110	M2,5x5	116
70 718 212 / 70 719 212	T08	110	M2,5x5	116
70 718 216 / 70 719 216	T15	113	M4x9,5	449
70 718 220 / 70 719 220	T15	113	M4x9,5	449
70 718 225 / 70 719 225	T15	113	M4x9,5	449



Screwdriver

AS

80 950 ...



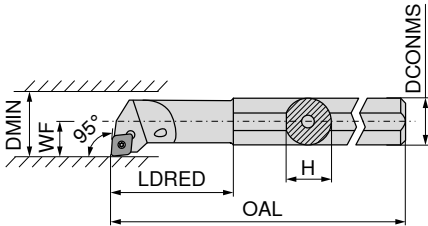
Clamping screw

AS

70 950 ...

CoreLine – SCLC 95° – Boring bar with screw clamping

▲ With carbide core



Illustrations show right-hand versions

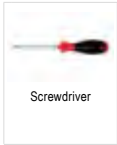


Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert
E-A0608F SCLC R/L 06	8	7.5	100	25	4	8	1,2	CC.. 0602
E-A0810H SCLC R/L 06	10	9.0	110	32	6	12	1,2	CC.. 0602
E-A1012K SCLC R/L 06	12	11.0	125	38	7	14	1,2	CC.. 0602
E-A1216M SCLC R/L 06	16	15.0	150	50	9	18	1,2	CC.. 0602

Left	Right
TO	TO
70 719 ...	70 718 ...
308	308
310	310
312	312
316	316

Spare parts
for article number

70 718 308 / 70 719 308	T08	110	M2,5x5	116
70 718 310 / 70 719 310	T08	110	M2,5x5	116
70 718 312 / 70 719 312	T08	110	M2,5x5	116
70 718 316 / 70 719 316	T08	110	M2,5x5	116



Screwdriver

AS

80 950 ...



Clamping screw

AS

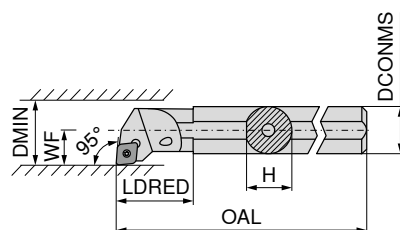
70 950 ...

CoreLine – SCLC 95° – Boring bar with screw clamping

▲ Finish: Carbide

Scope of supply:

Boring bar with Torx key



Illustrations show right-hand versions



Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert
E08H SCLC R/L 06	8	7.6	100	20	6	11	1,2	CC.. 0602
E10K SCLC R/L 06	10	9.0	125	22	7	13	1,2	CC.. 0602
E12Q SCLC R/L 06	12	11.5	180	26	9	16	1,2	CC.. 0602
E16R SCLC R/L 09	16	15.0	200	34	11	20	3,2	CC.. 09T3
E20S SCLC R/L 09	20	18.5	250	38	13	25	3,2	CC.. 09T3
E25T SCLC R/L 09	25	23.0	300	43	17	32	3,2	CC.. 09T3

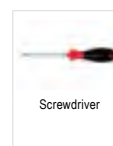
Left

Right

TO	TO
70 719 ...	70 718 ...
008	008
010	010
012	012
016	016
020	020
025	025

Spare parts for article number

70 718 008 / 70 719 008	T08	110	M2,5x5	116
70 718 010 / 70 719 010	T08	110	M2,5x5	116
70 718 012 / 70 719 012	T08	110	M2,5x5	116
70 718 016 / 70 719 016	T15	113	M3,5x7,2	110
70 718 020 / 70 719 020	T15	113	M3,5x8,6	304
70 718 025 / 70 719 025	T15	113	M3,5x11	113



Screwdriver

AS

80 950 ...



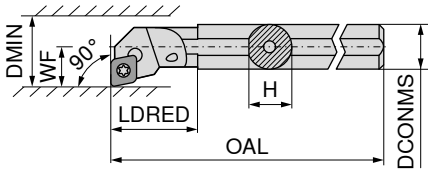
Clamping screw

AS

70 950 ...

CoreLine – SCFC 90° – Boring bar with screw clamping

Scope of supply:
Boring bar with Torx key



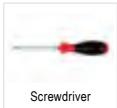
Illustrations show right-hand versions

Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert
A08F SCFC R/L 06	8	7.6	80	17	5	11	1,2	CC.. 0602
A10H SCFC R/L 06	10	9.5	100	19	7	13	1,2	CC.. 0602
A12K SCFC R/L 06	12	11.5	125	22	9	16	1,2	CC.. 0602

Left	Right
TO	TO
70 793 ...	70 792 ...
208	208
210	210
212	212

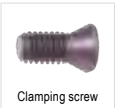
Spare parts
for article number

70 792 208 / 70 793 208	T08	110
70 792 210 / 70 793 210	T08	110
70 792 212 / 70 793 212	T08	110



Screwdriver

AS
80 950 ...



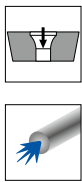
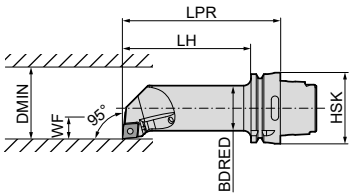
Clamping screw

AS
70 950 ...

M2,5x5	116
M2,5x5	116
M2,5x5	116

CoreLine – SCLC 95° – Boring bar with screw clamping

Scope of supply:
Boring bar with Torx key



Illustrations show right-hand versions



Designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	Left TO 74 564 ... 512	Right TO 74 563 ... 512
HSK T63 40L SCLC R/L 12	HSK-T 63	140	114	40	27	50	5	CC.. 1204		

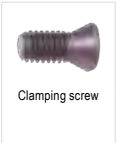
Spare parts
for article number

74 563 512 / 74 564 512



Combi key

AS
70 950 ...
398



Clamping screw

AS
70 950 ...
114



Carbide seat C

AS
70 950 ...
166



Threaded bush

AS
70 950 ...
170

T15/SW

M4,5x12

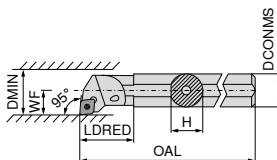
M4,5

CoreLine – SCLC 95° – Boring bar with screw clamping

- ▲ A... = with thru coolant
▲ S... = without thru coolant

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



ANSI designation	DCONMS inch	H inch	OAL inch	LDRED inch	WF inch	DMIN inch	Indexable insert
S06M SCLC R/L 2	0.375	0.340	6.000	0.830	0.250	0.500	CC..21.5..
A06M SCLC R/L 2	0.375	0.340	6.000	0.830	0.250	0.500	CC..21.5..
S08M SCLC R/L 2	0.500	0.460	6.000	0.910	0.312	0.625	CC..21.5..
A08M SCLC R/L 2	0.500	0.460	6.000	0.910	0.312	0.625	CC..21.5..
S10R SCLC R/L 2	0.625	0.580	8.000	1.060	0.406	0.812	CC..21.5..
A10R SCLC R/L 2	0.625	0.580	8.000	1.060	0.406	0.812	CC..21.5..
S10R SCLC R/L 3	0.625	0.580	8.000	1.060	0.406	0.812	CC..32.5..
A10R SCLC R/L 3	0.625	0.580	8.000	1.060	0.406	0.812	CC..32.5..
S12S SCLC R/L 3M	0.750	0.710	10.000	1.580	0.500	1.000	CC..32.5..
A12S SCLC R/L 3M	0.750	0.710	10.000	1.580	0.500	1.000	CC..32.5..
S16T SCLC R/L 3M	1.000	0.900	12.000	1.810	0.640	1.280	CC..32.5..
S16T SCLC R/L 4	1.000	0.900	12.000	3.000	0.640	1.280	CC..43..
S20U SCLC R/L 4	1.250	1.180	14.000	3.000	0.765	1.530	CC..43..
S24V SCLC R/L 4	1.500	1.370	16.000	3.000	0.890	1.780	CC..43..

Left

Right

TO 78 719 ...	TO 78 718 ...
20617 ¹⁾	20617 ¹⁾
20606	20606
20818 ¹⁾	20818 ¹⁾
20808 ¹⁾	20808 ¹⁾
21021 ¹⁾	21021 ¹⁾
21010	21010 ¹⁾
31021 ¹⁾	31021 ¹⁾
31010	31010
91222 ¹⁾	91222 ¹⁾
91212	91212
91626 ¹⁾	91626 ¹⁾
41626 ¹⁾	41626 ¹⁾
42030 ¹⁾	42030 ¹⁾
42435 ¹⁾	42435 ¹⁾

¹⁾ Not in stock

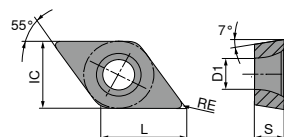
Spare parts

78 718 42030 / 78 719 42435
78 718 20606 / 78 719 31021
78 718 31010 / 78 719 91626
78 718 41626 / 78 719 41626

			
Clamping screw	Carbide seat C	Threaded bush	Key I - TORX®
AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...
04600	04500	04800	04700
05200			06400
05800			05700
06500			06600

DCGT / DCMT / DCET

Designation	L	S	D1	IC
	mm	mm	mm	mm
DC.T 0702..	7.75	2.38	2.8	6.35
DC.T 11T3..	11.60	3.97	4.4	9.52
DCMT 0702..	11.60	3.97	4.4	9.52



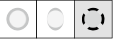
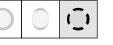
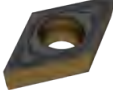
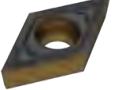
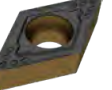
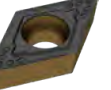
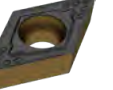
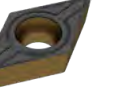
CoreLine – Carbide turning indexable insert

DCGT / DCMT

		-CF05 CTEP110-P	-CF55 CTEP110-P	-SF TCM407	-SF TCM10	-SMF TCM10	-SF CTCK110-P	-SF CTCP115-P
		DRAGONSKIN	DRAGONSKIN				DRAGONSKIN	DRAGONSKIN
		F	F	F	F	F	F	F
		CERMET	CERMET	CERMET	CERMET	CERMET	DCGT	DCGT
		DCGT	DCMT	DCGT	DCGT	DCMT	DCGT	DCGT
		TR	TR	TR	TR	TR	TR	TR
		76 245 ...	76 246 ...	70 257 ...	70 257 ...	70 265 ...	70 326 ...	76 257 ...
ISO	RE mm	00101			898			
070201EN	0.1				900			
070202EN	0.2	00201	00201		902	898	10201	30201
070204EN	0.4	00401	00401	852		900		
11T302EN	0.2	01401		854	904			
11T304EN	0.4	01601	01601	856	906	904		
11T308EN	0.8	01801	01801	858	908	906		
P		●	●	●	●	●	○	●
M		○	○	○	○	○		
K		○	○	○	○	○	●	○
N								
S								
H								
O								

CoreLine – Carbide turning indexable insert

DCGT / DCMT

		-SF CTCP125-P		-SF CTCP135-P		-SF CTCK110-P		-SF CTCP115-P		-SF CTCP125-P		-SF CTCP135-P		-SMF CTCP115-P	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
															
		F DCGT		F DCGT		F DCMT		F DCMT		F DCMT		F DCMT		F DCMT	
		TR		TR		TR		TR		TR		TR		TR	
ISO	RE mm	76 257 ... 50201		76 257 ... 70201		70 309 ... 10401		76 259 ... 30401		76 259 ... 50401		76 259 ... 70401		76 265 ... 30401 30601	
070202EN	0.2														
070204EN	0.4														
070208EN	0.8														
11T304EN	0.4														
11T308EN	0.8														
P		●		●		○		●		●		●		●	
M				○								○			
K		○				●		○		○				○	
N															
S															
H															
O															

CoreLine – Carbide turning indexable insert

DCMT / DCGT

		-SMF		-SMF		-SM		-SM		-SM		-SM		-SM	
		CTCP125-P		CTCP135-P		CTCP115-P		CTCP125-P		CTCP135-P		CTCK110-P		CTCK120-P	
		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin	
		F		F		M		M		M		M		M	
		DCMT		DCMT		DCGT		DCGT		DCGT		DCMT		DCMT	
		TR		TR		TR		TR		TR		TR		TR	
		76 265 ...		76 265 ...		76 256 ...		76 256 ...		76 256 ...		70 258 ...		70 258 ...	
						30201		50201		70201					
		50401		70401								10401		50401	
		50601		70601								10601		50601	
		51601		71601								11601		51601	
		51801		71801								11801		51801	
												12001		52001	
		P		●		●		●		●		○		○	
		M		○		○		○		○		○		○	
		K		○		○		○		○		●		●	
		N													
		S													
		H													
		O													

CoreLine – Carbide turning indexable insert

DCMT

		<div><div>-SM</div><div>CTCP115-P</div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div></div><div></div><div></div></div><div>M</div><div>DCMT</div></div>	<div><div>-SM</div><div>CTCP115-P</div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div></div><div></div><div></div></div><div>M</div><div>DCMT</div></div>	<div><div>-SM</div><div>CTCP125-P</div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div></div><div></div><div></div></div><div>M</div><div>DCMT</div></div>	<div><div>-SM</div><div>CTCP135-P</div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div></div><div></div><div></div></div><div>M</div><div>DCMT</div></div>	<div><div>-SMQ</div><div>CTCP115-P</div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div></div><div></div><div></div></div><div>M</div><div>DCMT</div></div>	<div><div>-SMQ</div><div>CTCP125-P</div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div></div><div></div><div></div></div><div>M</div><div>DCMT</div></div>	<div><div>-SF</div><div>CTPM125</div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div></div><div></div><div></div></div><div>F</div><div>DCMT</div></div>
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	76 183 ...	76 258 ...	76 258 ...	76 258 ...	76 195 ...	76 195 ...	75 044 ...
070204EN	0.4		30401	50401	70401	30401	50401	20400
070208EN	0.8		30601	50601	70601			
11T304EL	0.4					31601	51601	
11T304EN	0.4		31601	51601	71601	31501	51501	21600
11T304ER	0.4					31701	51701	
11T308EN	0.8		31801	51801	71801	31801	51801	21800
11T312EN	1.2	32001		52001	72001			
P		●	●	●	●	●	●	○
M					○			●
K		○	○	○		○	○	
N								
S								
H								
O								

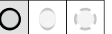
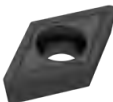
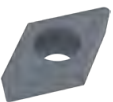
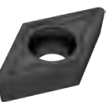
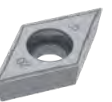
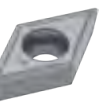
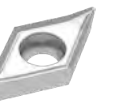
CoreLine – Carbide turning indexable insert

DCGT / DCMT

		<div><div>-SF</div><div>CTPM125</div></div>	<div><div>-F43</div><div>CTCM130</div></div>	<div><div>-M25</div><div>CTCM120</div></div>	<div><div>-M25</div><div>CTPM125</div></div>	<div><div>-M25</div><div>CTCM130</div></div>	<div><div>-M55</div><div>CTCM120</div></div>	<div><div>-M55</div><div>CTPM125</div></div>
		<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>
		<div>F</div> <div>DCGT</div>	<div>F</div> <div>DCMT</div>	<div>F</div> <div>DCMT</div>	<div>F</div> <div>DCMT</div>	<div>F</div> <div>DCMT</div>	<div>M</div> <div>DCMT</div>	<div>M</div> <div>DCMT</div>
		<div>TR</div> <div>75 043 ...</div>	<div>TR</div> <div>75 032 ...</div>	<div>TR</div> <div>75 213 ...</div>	<div>TR</div> <div>75 213 ...</div>	<div>TR</div> <div>75 213 ...</div>	<div>TR</div> <div>75 214 ...</div>	<div>TR</div> <div>75 214 ...</div>
ISO	RE mm							
070202EN	0.2	20200	30200	10200	202	30200		
070204EN	0.4		30400	10400	204	30400	10400	204
070208EN	0.8						10600	206
11T302EN	0.2		31400	11400	214	31400		
11T304EN	0.4		31600	11600	216	31600	11600	216
11T308EN	0.8		31800	11800	218	31800	11800	218
P		○	○	○	○	○	○	○
M		●	●	●	●	●	●	●
K								
N								
S			○			○		
H								
O								

CoreLine – Carbide turning indexable insert

DCMT / DCGT

		-M55 CTCM130		-SM CTPM125		-SM CTCM130		-M25 CTPX710		-M55 CTPX710		-23P H216T		-25P H210T	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN					
															
															
		M		M		M		M		M		F		F	
		DCMT		DCMT		DCMT		DCMT		DCMT		DCGT		DCGT	
		TR		TR		TR		TR		TR		TR		TR	
ISO	RE mm	75 214 ...		75 048 ...		75 048 ...		75 213 ...		75 214 ...		70 261 ...		70 263 ...	
070202EN	0.2							60200							
070202FN	0.2													632	
070204EN	0.4	30400				30400		60400		60400				634	
070204FN	0.4											654			
070208EN	0.8	30600				30600				60800					
11T302EN	0.2							61400						635	
11T302FN	0.2														
11T304EN	0.4	31600				31600		61600		61600				636	
11T304FN	0.4											664		638	
11T308EN	0.8	31800		21800		31800		61800		61800					
11T308FN	0.8											666			
11T312EN	1.2							62000		62000					
P		○		○		○		●		●					
M		●		●		●		●		●					
K												○		○	
N								○		○		●		●	
S		○				○		●		●				○	
H															
O												○		○	

CoreLine – Carbide turning indexable insert

DCGT / DCMT

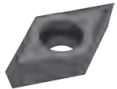
		-25P CTPX710		-25Q H210T		-25Q CTPX710		-27 H10T		-27 CTPX715		-29 H216T		-29 CTPX715	
		DRAGONSKIN				DRAGONSKIN				DRAGONSKIN				DRAGONSKIN	
		M DCGT		M DCGT		M DCGT		M DCGT		M DCGT		M DCMT		M DCMT	
		TR		TR		TR		TR		TR		TR		TR	
ISO	RE mm	70 263 ...		70 263 ...		70 263 ...		70 260 ...		70 260 ...		70 246 ...		70 246 ...	
070202FN	0.2	70200						600		80200					
070204FN	0.4	70400						602		80400					
070204EN	0.4											60400		70400	
11T302FN	0.2	71400						604		81400					
11T304FN	0.4	71600		660		75600		606		81600					
11T304EN	0.4											61600		71600	
11T304FL	0.4			670		75700									
11T304FR	0.4			680		75800									
11T308FL	0.8			672											
11T308EN	0.8											61800		71800	
11T308FN	0.8	71800		662		76000		608		81800					
11T308FR	0.8			682											
P		●		●		●		●		●		●		●	
M		●		●		●		●		●		●		●	
K				○				○		○		○		○	
N		●		●		●		●		●		●		●	
S		●		○		●		●		●		●		●	
H															
O				○				○		○		○		○	

MaxiTurn – Carbide turning indexable insert

DCET

-F05
CTPX710

DRAGONSKIN



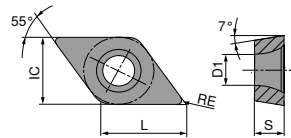
F
DCET

ISO	RE		
	mm		
0702005FN	0.05		
070201FN	0.10		
0702015FN	0.15		
070202FN	0.20		
11T3005FN	0.05		
11T301FN	0.10		
11T3015FN	0.15		
11T302FN	0.20		
11T304FN	0.40		
P			●
M			●
K			
N			●
S			●
H			
O			

IA
76 254 ...
10200
10400
10600
10800
11400
11600
11800
12000
12200

DCGT / DCXT

Designation	L	S	D1	IC
	mm	mm	mm	mm
DC.T 0702..	7.75	2.38	2.8	6.35
DC.T 11T3..	11.60	3.97	4.4	9.52



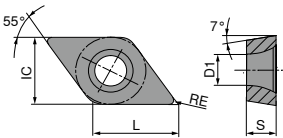
CoreLine – Carbide turning indexable insert

DCGT / DCXT

		<div><div><div>-F23</div><div>CTP2120</div><div><div></div><div></div><div></div></div><div></div><div><div>F</div><div>DCGT</div></div></div><div><div>-M81</div><div>CWN2120</div><div><div></div><div></div><div></div></div><div></div><div><div>M</div><div>DCXT</div></div></div></div>	
		<div>TR</div> <div>70 192 ...</div> <div>600</div> <div>602</div> <div>604</div> <div>606</div>	<div>TR</div> <div>70 260 ...</div> <div>100</div> <div>102</div> <div>104</div> <div>106</div> <div>108</div>
ISO	RE mm		
070200FN	0.0		
070201FN	0.1		
070202EN	0.2		
070204EN	0.4		
11T300FN	0.0		
11T301FN	0.1		
11T302EN	0.2		
11T304EN	0.4		
11T308EN	0.8		
P			
M			
K			
N			
S			
H			
O			

DCMT

Designation	L	S	D1	IC
	mm	mm	mm	mm
DCMT 0702..	7.75	2.38	2.8	6.35
DCMT 11T3..	11.60	3.97	4.4	9.52



CoreLine – Carbide turning indexable insert

DCMT

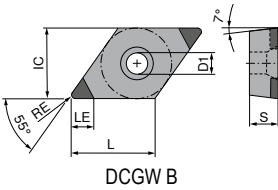
ISO	RE mm
070204EN	0.4
070208EN	0.8
11T304EN	0.4
11T308EN	0.8

-FMS CT-P15	-FMS CT-P25	-MRS CT-P15	-MRS CT-P25
F DCMT	F DCMT	M DCMT	M DCMT
CX	CX	CX	CX
75 304 ...	75 304 ...	75 305 ...	75 305 ...
00409	10409	00409	10409
00609	10609	00609	10609
01609	11609	01609	11609
01809	11809	01809	11809

P	●	●	●	●
M	○	○	○	○
K				
N				
S				
H				
O				

DCGW

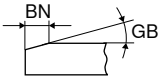
Designation	L	S	D1	IC
	mm	mm	mm	mm
DCGW 0702..	7.75	2.38	2.38	6.35
DCGW 11T3..	11.60	3.97	4.40	9.52



CoreLine – PcBN turning indexable insert

DCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners



ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
070202EN	0.2			B (2)	3.7
070202SN	0.2	0.14	20°	B (2)	3.7
070204EN	0.4			B (2)	3.6
070204SN	0.4	0.14	20°	B (2)	3.6
070208EN	0.8			B (2)	3.3
070208SN	0.8	0.14	20°	B (2)	3.3
11T302EN	0.2			B (2)	3.7
11T302SN	0.2	0.14	20°	B (2)	3.7
11T304EN	0.4			B (2)	3.6
11T304SN	0.4	0.14	20°	B (2)	3.6
11T308EN	0.8			B (2)	3.3
11T308SN	0.8	0.14	20°	B (2)	3.3

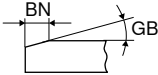
CTBH1000C	CTBH2000C	CTBH3000C
F PCBN DCGW	F PCBN DCGW	F PCBN DCGW
PC	PC	PC
71 007 ...	71 007 ...	71 007 ...
70002	80002	90002
70302	80302	90302
71202	81202	91202
70602	80602	90602
70902	80902	90902
71302	81302	91302

P			
M			
K			
N			
S			
H			
O			

CoreLine – PcBN turning indexable insert

DCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners



ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
070202SN	0.2	0.09	15°	B (2)	3.7
070202SN	0.2	0.18	25°	B (2)	3.7
070204SN	0.4	0.09	15°	B (2)	3.6
070204SN	0.4	0.18	25°	B (2)	3.6
070208SN	0.8	0.09	15°	B (2)	3.3
070208SN	0.8	0.18	25°	B (2)	3.3
11T302SN	0.2	0.09	15°	B (2)	3.7
11T302SN	0.2	0.18	25°	B (2)	3.7
11T304SN	0.4	0.09	15°	B (2)	3.6
11T304SN	0.4	0.18	25°	B (2)	3.6
11T308SN	0.8	0.09	15°	B (2)	3.3
11T308SN	0.8	0.18	25°	B (2)	3.3

P			
M			
K			
N			
S			
H			
O			

CTBH1000C

M

PCBN

DCGW

CTBH2000C

M

PCBN

DCGW

CTBH3000C

M

PCBN

DCGW

PC

71 007 ...

70102

70402

71402

70702

71002

71502

PC

71 007 ...

80102

80402

81402

80702

81002

81502

PC

71 007 ...

90102

90402

91402

90702

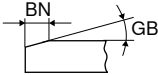
91002

91502

CoreLine – PcBN turning indexable insert

DCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners



ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
070202SN	0.2	0.14	20°	B (2)	3.7
070202SN	0.2	0.20	35°	B (2)	3.7
070204SN	0.4	0.14	20°	B (2)	3.6
070204SN	0.4	0.20	35°	B (2)	3.6
070208SN	0.8	0.14	20°	B (2)	3.3
070208SN	0.8	0.20	35°	B (2)	3.3
11T302SN	0.2	0.14	20°	B (2)	3.7
11T302SN	0.2	0.20	35°	B (2)	3.7
11T304SN	0.4	0.14	20°	B (2)	3.6
11T304SN	0.4	0.20	35°	B (2)	3.6
11T308SN	0.8	0.14	20°	B (2)	3.3
11T308SN	0.8	0.20	35°	B (2)	3.3

P			
M			
K			
N			
S			
H			
O			

CTBH1000C

R

PCBN

DCGW

CTBH2000C

R

PCBN

DCGW

CTBH3000C

R

PCBN

DCGW

PC

71 007 ...

PC

71 007 ...

PC

71 007 ...

70202

80202

90202

70502

80502

90502

71602

81602

91602

70802

80802

90802

71102

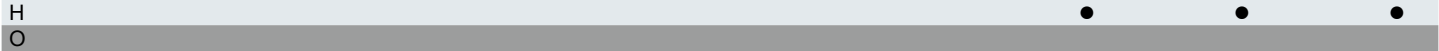
81102

91102

71702

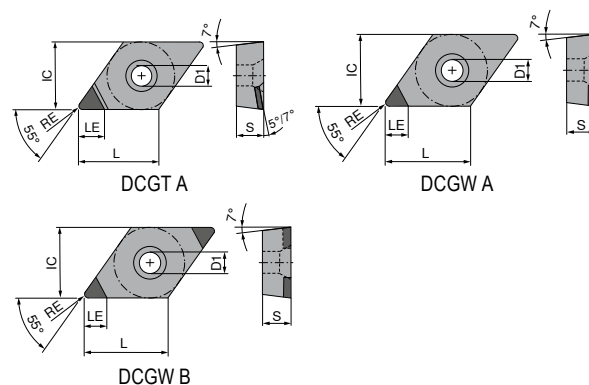
81702

91702



DCGT / DCGW

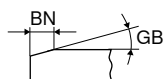
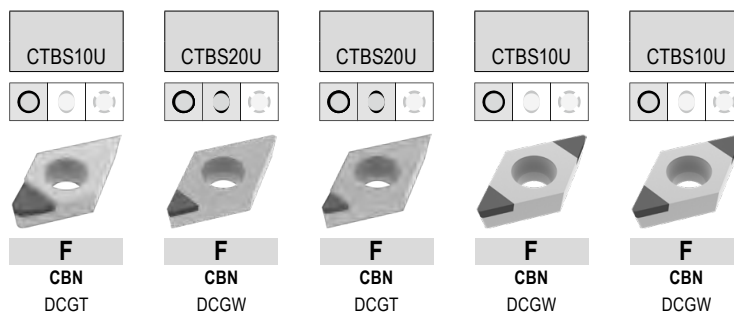
Designation	L	S	D1	IC
	mm	mm	mm	mm
DCG. 0702..	7.75	2.38	2.8	6.35
DCG. 11T3..	11.60	3.97	4.4	9.52



CoreLine – PcBN turning indexable insert

DCGT / DCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners



ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
070204FN	0.4			A (1)	3.5
070204TN	0.4	0.12	15°	A (1)	3.5
070208FN	0.8			A (1)	3.0
11T302FN	0.2			A (1)	3.9
11T302FN	0.2			B (2)	3.9
11T302TN	0.2	0.12	20°	B (2)	3.9
11T304FN	0.4			A (1)	3.5
11T304FN	0.4			B (2)	3.5
11T304TN	0.4	0.12	20°	B (2)	3.5
11T304TN	0.4	0.12	15°	A (1)	3.5
11T308TN	0.8	0.12	20°	B (2)	3.0
11T308FN	0.8			B (2)	3.0
11T308FN	0.8			A (1)	3.0

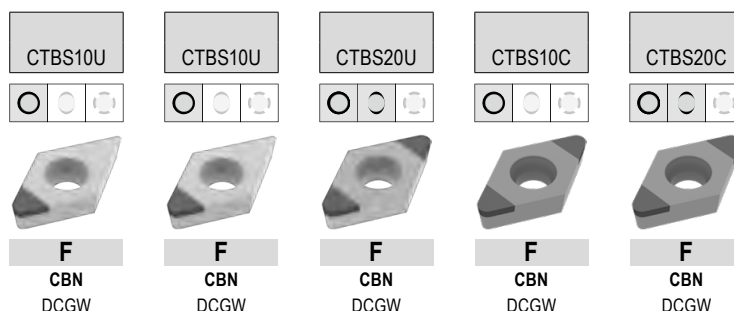
PC	PC	PC	PC	PC
71 134 ...	71 422 ...	71 421 ...	71 131 ...	71 131 ...
202	20200			
204				
206	20300			200
208		20000	300	
	20500		302	202
			304	204
210				

P					
M					
K	•	•	•	•	•
N					
S	•	•	•	•	•
H					
O					

CoreLine – PcBN turning indexable insert

DCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners

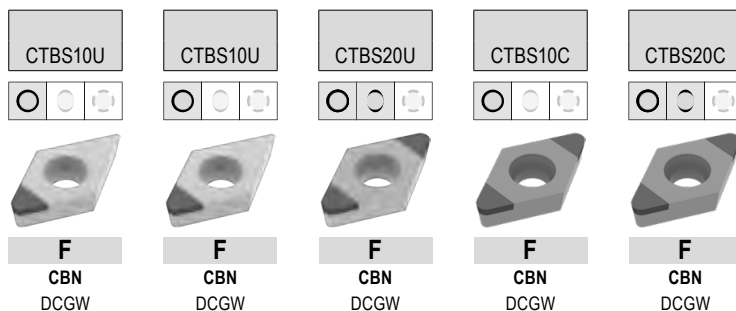


ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
070202SN	0.2	0.09	10°	B (2)	3.9
070202TN	0.2	0.12	20°	A (1)	3.9
070202SN	0.2	0.16	20°	B (2)	3.9
070202FN	0.2			A (1)	3.9
070204SN	0.4	0.09	10°	B (2)	3.5
070204SN	0.4	0.11	15°	B (2)	3.5
070204SN	0.4	0.14	15°	B (2)	3.5
070204TN	0.4	0.12	20°	A (1)	3.5
070204TN	0.4	0.15	20°	B (2)	3.5
070204SN	0.4	0.16	20°	B (2)	3.5
070204TN	0.4	0.17	25°	B (2)	3.5
070204SN	0.4	0.18	30°	B (2)	3.5
070204FN	0.4			A (1)	3.5
070208FN	0.8			A (1)	3.0
070208SN	0.8	0.11	15°	B (2)	3.0
070208TN	0.8	0.15	20°	B (2)	3.0
070208TN	0.8	0.12	20°	A (1)	3.0
11T302SN	0.2	0.11	15°	B (2)	3.9
11T302TN	0.2	0.12	20°	A (1)	3.9
11T302TN	0.2	0.15	20°	B (2)	3.9
11T302FN	0.2			A (1)	3.9
11T304SN	0.4	0.09	10°	B (2)	3.5
11T304TN	0.4	0.12	15°	B (2)	3.5
11T304SN	0.4	0.14	15°	B (2)	3.5
11T304TN	0.4	0.12	20°	A (1)	3.5
11T304SN	0.4	0.14	20°	B (2)	3.5
11T304TN	0.4	0.15	20°	B (2)	3.5
11T304SN	0.4	0.16	20°	B (2)	3.5
11T304TN	0.4	0.17	25°	B (2)	3.5
11T304SN	0.4	0.18	25°	B (2)	3.5
11T304SN	0.4	0.18	30°	B (2)	3.5
11T304FN	0.4			A (2)	3.5
11T304FN	0.4			A (1)	3.5
11T308SN	0.8	0.09	10°	B (2)	3.0
11T308SN	0.8	0.11	15°	B (2)	3.0
11T308TN	0.8	0.12	20°	A (1)	3.0
11T308SN	0.8	0.14	20°	B (2)	3.0
11T308TN	0.8	0.15	20°	B (2)	3.0
11T308SN	0.8	0.16	20°	B (2)	3.0

PC	PC	PC	PC	PC
71 130 ...	71 130 ...	71 163 ...	71 424 ...	71 163 ...
300			80100	120
	200			150
				121
			80400	131
302				141
				151
				161
	202			181
	204			
304				132
				142
				133
306				143
	206			
				124
		13400		
308			80700	
			80800	144
				154
				164
				174
				184
			80500	
	208			
			81000	135
310			81300	
				145
				155

P					
M					
K	•	•	•	•	•
N					
S	•	•	•	•	•
H					
O					

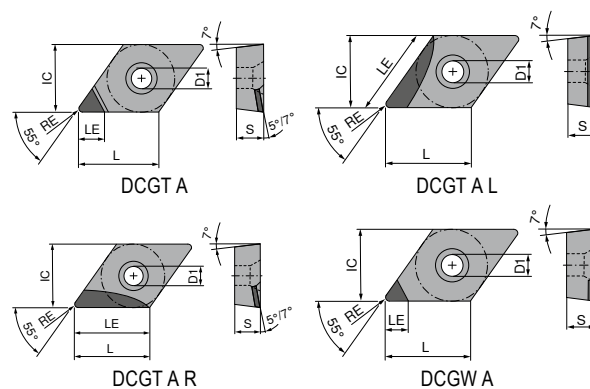
DCGW



ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	PC 71 130 ...	PC 71 130 ...	PC 71 163 ...	PC 71 424 ...	PC 71 163 ...
11T308TN	0.8	0.17	25°	B (2)	3.0					165
11T308SN	0.8	0.18	30°	B (2)	3.0					185
11T308EN	0.8			B (2)	3.0					115
11T308FN	0.8			A (1)	3.0		210			
P										
M										
K										
N										
S										
H										
O										

DCGW / DCGT

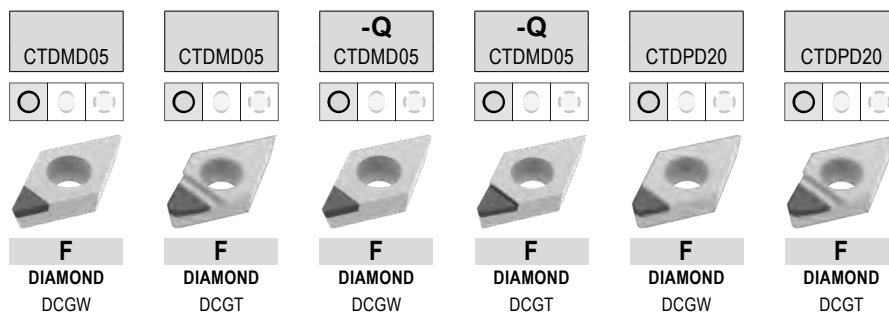
Designation	L	S	D1	IC
	mm	mm	mm	mm
DCG. 0702..	7.75	2.38	2.8	6.35
DCG. 11T3..	11.60	3.97	4.4	9.52



CoreLine – PCD turning indexable insert

DCGW / DCGT

▲ TCE(NOI) = Design and number of equipped cutting edge corners



ISO	RE mm	TCE (NOI)	LE mm	PC	PC	PC	PC	PC	PC
070202FN	0.2	A (1)	2.5	71 130 ...	71 134 ...	71 178 ...	71 176 ...	71 130 ...	71 134 ...
070202FN	0.2	A (1)	3.7	00200	050				
070204FN	0.4	A (1)	2.5	00400	052			100	100
070204FR	0.4	A (1)	2.5				50001		
070204FN	0.4	A (1)	3.4					102	102
070208FN	0.8	A (1)	2.5	00600	054			104	104
070208FN	0.8	A (1)	3.0						
11T302FN	0.2	A (1)	2.5		056				
11T302FN	0.2	A (1)	3.0	056					
11T302FN	0.2	A (1)	4.7					106	106
11T304FN	0.4	A (1)	2.5						
11T304FL	0.4	A (1)	3.0						
11T304FN	0.4	A (1)	3.0	058		50001			
11T304FN	0.4	A (1)	4.3					108	108
11T308FN	0.8	A (1)	2.5		060				
11T308FN	0.8	A (1)	4.0					110	110
11T312FN	1.2	A (1)	3.5						11200
11T312FN	1.2	A (1)	3.6					11200	
P									
M									
K									
N				•	•	•	•	•	•
S									
H									
O				•	•	•	•	•	•

CoreLine – PCD turning indexable insert

DCGW / DCGT

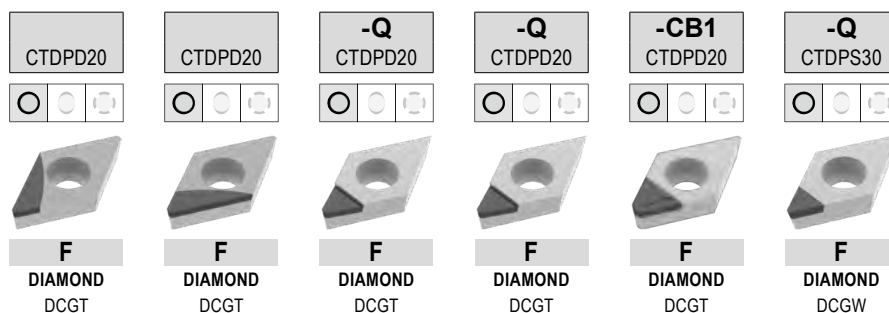
▲ TCE(NOI) = Design and number of equipped cutting edge corners

				CTDPS30	CTDPS30	CTDPS30	CTDPS30	-CB1 CTDPU20	-CB2 CTDPU20
				F	F	F	F	F	M
				DIAMOND	DIAMOND	DIAMOND	DIAMOND	DIAMOND	DIAMOND
				DCGW	DCGT	DCGT	DCGT	DCGT	DCGT
				PC	PC	PC	PC	PC	PC
ISO	RE mm	TCE (NOI)	LE mm	71 177 ...	71 173 ...	71 173 ...	71 173 ...	71 174 ...	71 175 ...
070201FN	0.1	A (1)	3.8	20001		20001			
070202FN	0.2	A (1)	3.7	20101		20101		30001	
070204FN	0.4	A (1)	3.4	20201				30101	30001
070204FL	0.4	A (1)	5.5		20201				
070208FN	0.8	A (1)	3.0	20301					
11T301FN	0.1	A (1)	4.8	20401		20301			
11T302FN	0.2	A (1)	4.7	20501		20401			
11T304FN	0.4	A (1)	4.3	20601				30201	30101
11T304FL	0.4	A (1)	7.5		20501				
11T308FN	0.8	A (1)	4.0	20701				30301	
11T308FL	0.8	A (1)	7.0		20601				
11T308FR	0.8	A (1)	7.0				20701		
11T312FN	1.2	A (1)	3.6	20801					
11T312FL	1.2	A (1)	6.5		20801				
11T312FR	1.2	A (1)	6.5				20901		
P									
M									
K									
N				•	•	•	•	•	•
S									
H									
O				•	•	•	•	•	•

CoreLine – PCD turning indexable insert

DCGT / DCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners

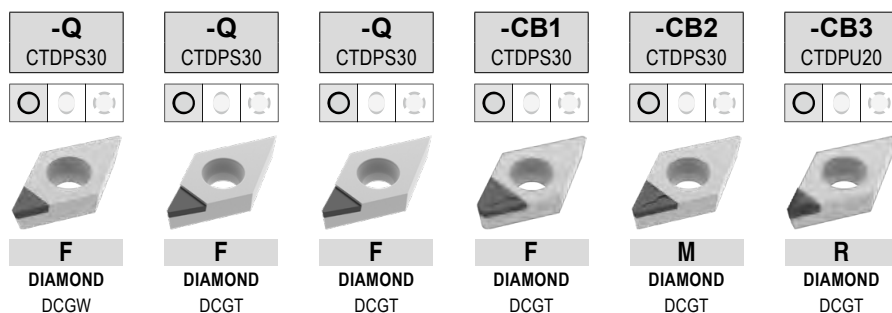


ISO	RE mm	TCE (NOI)	LE mm	PC	PC	PC	PC	PC	PC
070201FN	0.1	A (1)	3.8	71 136 ...	71 135 ...	71 144 ...	71 145 ...	71 310 ...	71 138 ...
070202FN	0.2	A (1)	3.7					10100	
070204FL	0.4	A (1)	3.0				104	102	
070204FR	0.4	A (1)	3.0			104			
070204FN	0.4	A (1)	3.4					104	
070204FRR	0.4	A (1)	5.5		102				
070204FLL	0.4	A (1)	5.5	102					
070208FN	0.8	A (1)	3.0		104			108	
070208FRR	0.8	A (1)	5.0						
070208FLL	0.8	A (1)	5.0	104					
11T301FN	0.1	A (1)	4.8					11100	
11T302FR	0.2	A (1)	4.0						162
11T302FN	0.2	A (1)	4.7					112	
11T304FL	0.4	A (1)	4.0				114		
11T304FR	0.4	A (1)	4.0			114			164
11T304FN	0.4	A (1)	4.3					114	
11T304FRR	0.4	A (1)	7.5		108				
11T304FLL	0.4	A (1)	7.5	108					
11T308FN	0.8	A (1)	4.0		110			118	
11T308FRR	0.8	A (1)	7.0						
11T308FLL	0.8	A (1)	7.0	110					
P									
M									
K									
N				•	•	•	•	•	•
S									
H									
O				•	•	•	•	•	•

CoreLine – PCD turning indexable insert

DCGW / DCGT

▲ TCE(NOI) = Design and number of equipped cutting edge corners



ISO	RE mm	TCE (NOI)	LE mm	PC	PC	PC	PC	PC	PC
070201FL	0.1	A (1)	3.0	71 139 ...	71 144 ...	71 145 ...	71 310 ...	71 311 ...	71 312 ...
070201FR	0.1	A (1)	3.0		15000	151			
070201FN	0.1	A (1)	3.8				20100		
070202FL	0.2	A (1)	3.0			152			
070202FR	0.2	A (1)	3.0		152				
070202FN	0.2	A (1)	3.7				202 204	202 204 208	
070204FN	0.4	A (1)	3.4						204
070208FN	0.8	A (1)	3.0						
11T301FR	0.1	A (1)	4.0		161				
11T301FL	0.1	A (1)	4.0			161			
11T301FN	0.1	A (1)	4.8				21100	21100	
11T302FL	0.2	A (1)	4.0			162			
11T302FR	0.2	A (1)	4.0		162				
11T302FN	0.2	A (1)	4.7				212	212	
11T304FL	0.4	A (1)	4.0	164			214 218	214 218	214 218
11T304FN	0.4	A (1)	4.3						
11T308FN	0.8	A (1)	4.0						
P									
M									
K									
N				•	•	•	•	•	•
S									
H									
O				•	•	•	•	•	•

CoreLine – PCD turning indexable insert

DCGW / DCGT

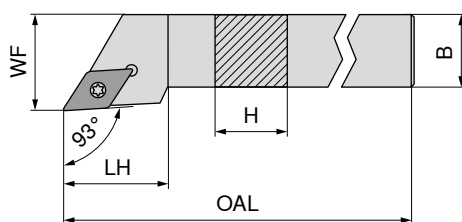
▲ TCE(NOI) = Design and number of equipped cutting edge corners

				CTDPU20	CTDCD10	-CB1 CTDCD10	-CB2 CTDCD10
				F DIAMOND DCGW	F DIAMOND DCGW	F DIAMOND DCGT	M DIAMOND DCGT
ISO	RE mm	TCE (NOI)	LE mm	PC 71 177 ...	PC 71 177 ...	PC 71 310 ...	PC 71 311 ...
070202FN	0.2	A (1)	2.6		40001	302	30200
070204FN	0.4	A (1)	2.3		40101	304	304
070204FN	0.4	A (1)	3.4	30001			
070208FN	0.8	A (1)	2.0		40201		308
070208FN	0.8	A (1)	3.0	30101			
11T302FN	0.2	A (1)	2.6		40301	31200	31200
11T304FN	0.4	A (1)	2.3		40401	314	314
11T304FN	0.4	A (1)	4.3	30201			
11T308FN	0.8	A (1)	2.0		40501	318	318
11T308FN	0.8	A (1)	4.0	30301			
P							
M							
K							
N							
S							
H							
O							

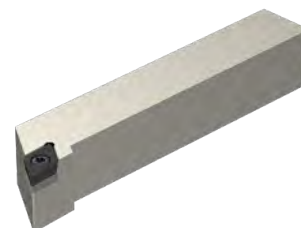
CoreLine – SDJC 93° – Tool holder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Left

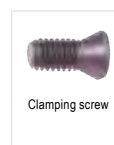
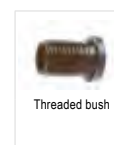
Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
SDJC R/L 0808 D07	8	8	60	13.0	10	1,2	DC.. 0702
SDJC R/L 1010 E07	10	10	70	13.0	12	1,2	DC.. 0702
SDJC R/L 1212 F07	12	12	80	14.3	16	1,2	DC.. 0702
SDJC R/L 1616 H11	16	16	100	19.3	20	3,2	DC.. 11T3
SDJC R/L 2020 K11	20	20	125	19.9	25	3,2	DC.. 11T3
SDJC R/L 2525 M11	25	25	150	21.2	32	3,2	DC.. 11T3
SDJC R/L 3225 P11	32	25	170	21.2	32	3,2	DC.. 11T3

TO	TO
70 643 ...	70 643 ...
00800	00801
01000	01001
01200	01201
01600	01601
02000	02001
02500	02501
03200	03201

Spare parts for article number

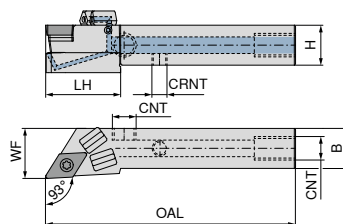
		AS		AS		AS		AS
		80 950 ...		70 950 ...		70 950 ...		70 950 ...
70 643 00801 / 70 643 00800	T08 - IP	039	M2,5x6 - 08IP	857				
70 643 01001 / 70 643 01000	T08 - IP	039	M2,5x6 - 08IP	857				
70 643 01201 / 70 643 01200	T08 - IP	039	M2,5x6 - 08IP	857				
70 643 01601 / 70 643 01600	T15 - IP	120	M3,5x11	87900	106	M3,5	171	
70 643 02001 / 70 643 02000	T15 - IP	120	M3,5x11	87900	106	M3,5	171	
70 643 02501 / 70 643 02500	T15 - IP	120	M3,5x11	87900	106	M3,5	171	
70 643 03201 / 70 643 03200	T15 - IP	120	M3,5x11	87900	106	M3,5	171	



CoreLine – SDJC 93° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions



Left

Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Tightening torque Nm	Indexable insert
SDJC R/L 1010 E07 DC	10	10	70	20	12	M6	M6	1,2	DC.. 0702
SDJC R/L 1212 F07 DC	12	12	80	21	16	M6	M6	1,2	DC.. 0702
SDJC R/L 1616 H11 DC	16	16	100	30	20	M6	G1/8"	3,2	DC.. 11T3
SDJC R/L 2020 K11 DC	20	20	125	30	25	M6	G1/8"	3,2	DC.. 11T3
SDJC R/L 2525 M11 DC	25	25	150	35	32	M6	G1/8"	3,2	DC.. 11T3

TO	TO
70 773 ...	70 773 ...
01001	01000
01201	01200
01601	01600
02001	02000
02501	02500

Spare parts for article number

70 773 01000 / 70 773 01001
70 773 01200 / 70 773 01201
70 773 01600 / 70 773 01601
70 773 02000 / 70 773 02001
70 773 02500 / 70 773 02501

AS	AS	AS	AS	AS
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
857			86700	
857			86700	
87900	106	88000	86700	171
87900	106	88000	86700	171
87900	106	88000	86700	171

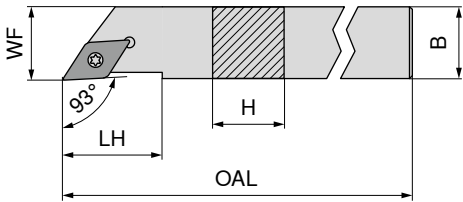
Spare parts for article number

70 773 01000 / 70 773 01001
70 773 01200 / 70 773 01201
70 773 01600 / 70 773 01601
70 773 02000 / 70 773 02001
70 773 02500 / 70 773 02501

AS	AS	AS	AS	AS
70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...
	039			
	039			
87600	120	88100	87700	294
87600	120	88100	87700	294
87600	120	88100	87700	294

CoreLine – SDJC 93° – Tool holder with screw clamping

▲ For sliding head lathes



Illustrations show right-hand versions

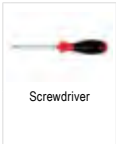


Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
SDJC R/L 0808 H07	8	8	100	13.0	8	1,2	DC.. 0702
SDJC R/L 1010 H07	10	10	100	13.0	10	1,2	DC.. 0702
SDJC R/L 1212 H07	12	12	100	14.5	12	1,2	DC.. 0702
SDJC R/L 1616 K07	16	16	125	33.0	16	1,2	DC.. 0702
SDJC R/L 1212 H11	12	12	100	22.0	12	3,2	DC.. 11T3
SDJC R/L 1616 K11	16	16	125	33.0	16	3,2	DC.. 11T3
SDJC R/L 2020 K11	20	20	125		20		DC.. 11T3

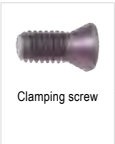
Left	Right
TO	TO
70 685 ...	70 684 ...
108	108
110	110
112	112
116	116
212	212
216	216
220	220

Spare parts
Indexable insert

DC.. 0702	T08	110	002
DC.. 11T3	T15	113	006



Screwdriver



Clamping screw

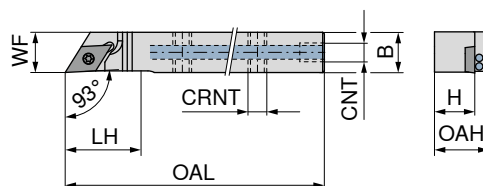
AS	AS
80 950 ...	72 950 ...
110	002
113	006

CoreLine – SDJC 93° – Tool holder with through coolant

▲ For sliding head lathes

Scope of supply:

Holder without coolant connection



Illustrations show right-hand versions



Designation	H mm	B mm	OAL mm	LH mm	WF mm	CNT	CRNT	Indexable insert
SDJC L 0808 H07 IC	8	8	100	17	8	M5	M5	DC.. 0702
SDJC R/L 1010 H07 IC	10	10	100	17	10	M5	M5	DC.. 0702
SDJC R/L 1212 H07 IC	12	12	100	17	12	M5	M5	DC.. 0702
SDJC R/L 1616 K07 IC	16	16	125	17	16	G1/8"	M5	DC.. 0702
SDJC R/L 1010 H11 IC	10	10	100	22	10	M5	M5	DC.. 11T3
SDJC R/L 1212 H11 IC	12	12	100	22	12	M5	M5	DC.. 11T3
SDJC R/L 1616 K11 IC	16	16	125	22	16	G1/8"	M5	DC.. 11T3
SDJC R/L 2020 K11 IC	20	20	125	22	20	G1/8"	M5	DC.. 11T3

Left

Right

TO	TO
72 357 ...	72 356 ...
008	
010	010
012	012
016	016
110	110
112	112
116	116
120	120

Spare parts

Indexable insert CNT

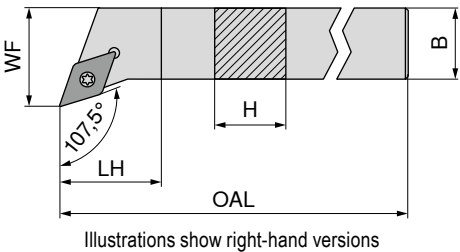
DC.. 0702	M5
DC.. 0702	G1/8"
DC.. 11T3	M5
DC.. 11T3	G1/8"

			
Screw plug	Screw plug	Screwdriver	Clamping screw
AS	AS	AS	AS
72 950 ...	72 950 ...	80 950 ...	72 950 ...
	011	110	002
010	011	110	002
	011	113	006
010	011	113	006

CoreLine – SDHC 107.5° – Tool holder with screw clamping

Scope of supply:

Tool holder with Torx key

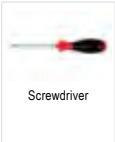
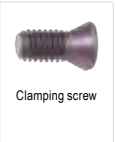
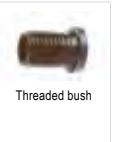


Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
SDHC R/L 1010 E07	10	10	70	7.6	12	1,2	DC.. 0702
SDHC R/L 1212 F07	12	12	80	12.2	16	1,2	DC.. 0702
SDHC R/L 1616 H11	16	16	100	11.6	20	3,2	DC.. 11T3
SDHC R/L 2020 K11	20	20	125	14.1	25	3,2	DC.. 11T3
SDHC R/L 2525 M11	25	25	150	20.5	32	3,2	DC.. 11T3

Left	Right
TO	TO
70 642 ...	70 642 ...
01000	01001
01200	01201
01600	01601
02000	02001
02500	02501

Spare parts
for article number

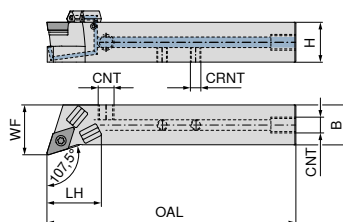
70 642 01001 / 70 642 01000
70 642 01201 / 70 642 01200
70 642 01601 / 70 642 01600
70 642 02001 / 70 642 02000
70 642 02501 / 70 642 02500

			
Screwdriver	Clamping screw	Carbide seat D	Threaded bush
AS	AS	AS	AS
80 950 ...	70 950 ...	70 950 ...	70 950 ...
039	857		
039	857		
120	87900	106	171
120	87900	106	171
120	87900	106	171

CoreLine – SDHC 107.5° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions



Left

Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Tightening torque Nm	Indexable insert	TO 70 772 ...	TO 70 772 ...
SDHC R/L 1212 F07 DC	12	12	80	20	16	M6	M6	1,2	DC.. 0702	01201	01200
SDHC R/L 1616 H11 DC	16	16	100	25	20	M6	G1/8"	3,2	DC.. 11T3	01601	01600
SDHC R/L 2020 K11 DC	20	20	125	28	25	M6	G1/8"	3,2	DC.. 11T3	02001	02000
SDHC R/L 2525 M11 DC	25	25	150	27	32	M6	G1/8"	3,2	DC.. 11T3	02501	02500

Spare parts for article number

	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 772 01200 / 70 772 01201	857			86700	
70 772 01600 / 70 772 01601	87900	106	88000	86700	171
70 772 02000 / 70 772 02001	87900	106	88000	86700	171
70 772 02500 / 70 772 02501	87900	106	88000	86700	171

Spare parts for article number

	AS 70 950 ...	AS 80 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 772 01200 / 70 772 01201		039			
70 772 01600 / 70 772 01601	87600	120	88100	87700	294
70 772 02000 / 70 772 02001	87600	120	88100	87700	294
70 772 02500 / 70 772 02501	87600	120	88100	87700	294

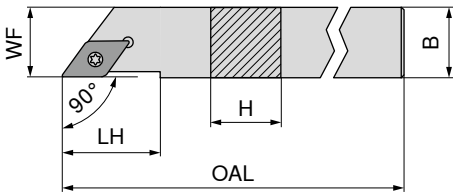
Clamping screw	Carbide seat D	Set Screw	Set Screw	Threaded bush
AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
Sealing plugs DC	Screwdriver	O ring	Coolant nozzle DC	Coolant screw plug
AS 70 950 ...	AS 80 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...

CoreLine – SDAC 90° – Tool holder with screw clamping

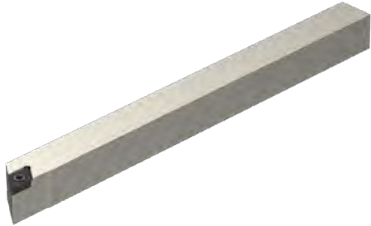
▲ For sliding head lathes

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

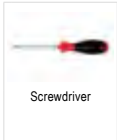


Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
SDAC R/L 0808 K07	8	8	125	14	8	1,2	DC.. 0702
SDAC R/L 1010 M07	10	10	150	14	10	1,2	DC.. 0702
SDAC R/L 1212 M07	12	12	150	14	12	1,2	DC.. 0702
SDAC R/L 1212 M11	12	12	150	21	12	3,2	DC.. 11T3
SDAC R/L 1414 M11	14	14	150	21	14	3,2	DC.. 11T3

Left	Right
TO	TO
70 639 ...	70 639 ...
00800	00801
01000	01001
01200	01201
11200	11201
01400	01401

Spare parts
for article number

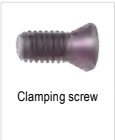
70 639 00801 / 70 639 00800	T08 - IP	039	M2,5x6 - 08IP	857
70 639 01001 / 70 639 01000	T08 - IP	039	M2,5x6 - 08IP	857
70 639 01201 / 70 639 01200	T08 - IP	039	M2,5x6 - 08IP	857
70 639 11201 / 70 639 11200	T15 - IP	120	M3,5x11	87900
70 639 01401 / 70 639 01400	T15 - IP	120	M3,5x11	87900



Screwdriver

AS

80 950 ...



Clamping screw

AS

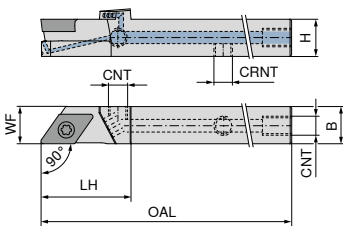
70 950 ...

CoreLine – SDAC 90° DC – Tool holder with screw clamping

▲ For sliding head lathes

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions



Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Tightening torque Nm	Indexable insert	Left	Right
										TO 70 771 ...	TO 70 771 ...
SDAC R/L 0808 K07 DC	8	8	125	21	8	M5	M5	1,2	DC.. 0702	00801	00800
SDAC R/L 1010 M07 DC	10	10	150	21	10	M6	M6	1,2	DC.. 0702	01001	01000
SDAC R/L 1212 M07 DC	12	12	150	21	12	M6	M6	1,2	DC.. 0702	01201	01200
SDAC R/L 1212 M11 DC	12	12	150	29	12	M6	M6	3,2	DC.. 11T3	11201	11200

Spare parts
for article number

70 771 00800 / 70 771 00801	CT	AS	AS	AS
70 771 01000 / 70 771 01001	83 950 ...	80 950 ...	70 950 ...	70 950 ...
70 771 01200 / 70 771 01201	157	039	13800	86700
70 771 11200 / 70 771 11201		039	13800	86700
		120	113	86700



Cylindrical screw

CT

83 950 ...



Screwdriver

AS

80 950 ...



Clamping screw

AS

70 950 ...



Set Screw

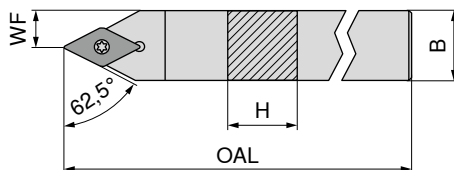
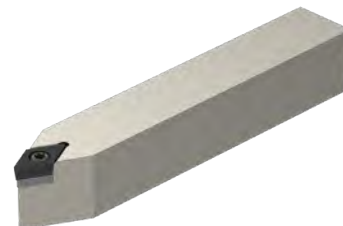
AS

70 950 ...

CoreLine – SDNC 62.5° – Tool holder with screw clamping

Scope of supply:

Tool holder with Torx key



Neutral

Designation	H mm	B mm	OAL mm	WF mm	Tightening torque Nm	Indexable insert
SDNC N 0808 K07	8	8	125	4.0	1,2	DC.. 0702
SDNC N 1010 M07	10	10	150	5.0	1,2	DC.. 0702
SDNC N 1010 E07	10	10	70	5.0	1,2	DC.. 0702
SDNC N 1212 F07	12	12	80	6.0	1,2	DC.. 0702
SDNC N 1212 M07	12	12	150	6.0	1,2	DC.. 0702
SDNC N 1212 M11	12	12	150	6.0	3,2	DC.. 11T3
SDNC N 1616 H11	16	16	100	8.0	3,2	DC.. 11T3
SDNC N 2020 K11	20	20	125	10.0	3,2	DC.. 11T3
SDNC N 2525 M11	25	25	150	12.5	3,2	DC.. 11T3

TO

70 645 ...

00800

11000

01000

01200

11200

21200

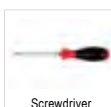
01600

02000

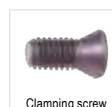
02500

Spare parts for article number

		AS		AS		AS		AS
70 645 00800	T08 - IP	039	M2,5x6 - 08IP	857				
70 645 11000	T08 - IP	039	M2,5x6 - 08IP	857				
70 645 01000	T08 - IP	039	M2,5x6 - 08IP	857				
70 645 01200	T08 - IP	039	M2,5x6 - 08IP	857				
70 645 11200	T08 - IP	039	M2,5x6 - 08IP	857				
70 645 21200	T15 - IP	120	M3,5x11	87900				
70 645 01600	T15 - IP	120	M3,5x11	87900	106	M3,5	171	
70 645 02000	T15 - IP	120	M3,5x11	87900	106	M3,5	171	
70 645 02500	T15 - IP	120	M3,5x11	87900	106	M3,5	171	



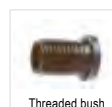
Screwdriver



Clamping screw



Carbide seat D

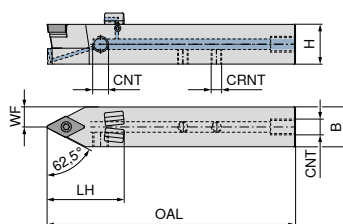


Threaded bush

CoreLine – SDNC 62.5° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Neutral

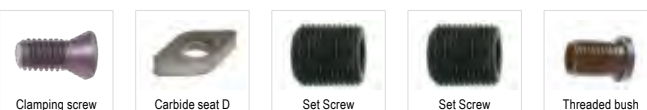
Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Tightening torque Nm	Indexable insert	TO 70 774 ...
SDNC N 1212 M07 DC	12	12	150	24	6.0	M6	M6	1,2	DC.. 0702	11200
SDNC N 1212 F07 DC	12	12	80	24	6.0	M6	M6	1,2	DC.. 0702	01200
SDNC N 1212 M11 DC	12	12	150	31	6.0	M6	M6	3,2	DC.. 11T3	21200
SDNC N 1616 H11 DC	16	16	100	30	8.0	M6	G1/8"	3,2	DC.. 11T3	01600
SDNC N 2020 K11 DC	20	20	125	39	10.0	M6	G1/8"	3,2	DC.. 11T3	02000
SDNC N 2525 M11 DC	25	25	150	30	12.5	M6	G1/8"	3,2	DC.. 11T3	02500

Spare parts for article number

	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 774 11200	857			86700	
70 774 01200	857			86700	
70 774 21200	859			86700	
70 774 01600	87900	106	88000	86700	171
70 774 02000	87900	106	88000	86700	171
70 774 02500	87900	106	88000	86700	171

Spare parts for article number

	AS 70 950 ...	AS 80 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 774 11200		039			
70 774 01200		039			
70 774 21200		120			
70 774 01600	87600	120	88100	87700	294
70 774 02000	87600	120	88100	87700	294
70 774 02500	87600	120	88100	87700	294



AS
70 950 ...

857
857
859
87900
87900
87900



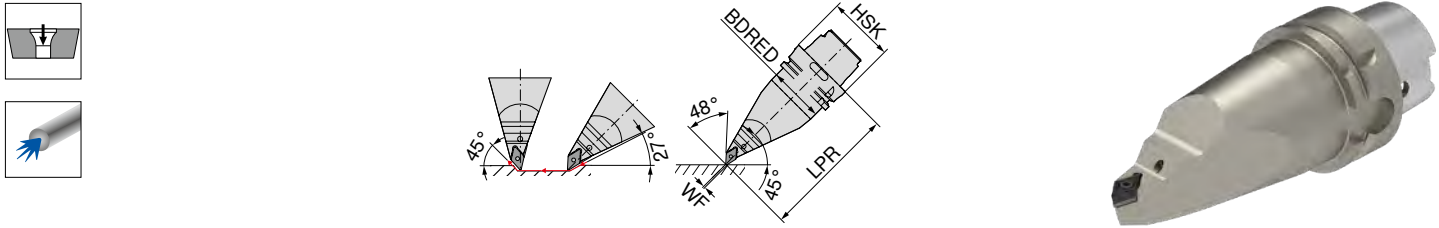
AS
70 950 ...

039
039
120
87600
87600
87600

CoreLine – SDMC 48° – Tool holder with screw clamping

Scope of supply:

Tool holder with Torx key



Designation	Adapter	LPR mm	BDRED mm	WF mm	Tightening torque Nm	Indexable insert
HSK T63 SDMC L 11	HSK-T 63	130	53	0	3.2	DC.. 11T3

Left
TO
74 546 ...
511

Spare parts
for article number

74 546 511	T15/SW	398	M3,5x11	113	106	M3,5	171
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Combi key

AS

70 950 ...



Clamping screw

AS

70 950 ...



Carbide seat D

AS

70 950 ...



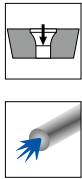
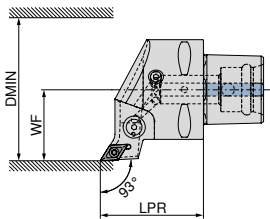
Threaded bush

AS

70 950 ...

CoreLine – SDJC 93° – Tool holder with screw clamping

Scope of supply:
Without high-performance coolant set



Illustrations show right-hand versions



Designation	Adapter	LPR mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	Direct cooling compatible
PSC40 SDJC R/L 50050-11	PSC 40	50	27	50	3	DC.. 11T3	DC
PSC50 SDJC R/L 65060-11	PSC 50	60	35	65	3	DC.. 11T3	DC
PSC63 SDJC R/L 80065-11	PSC 63	65	45	80	3	DC.. 11T3	DC

Left	Right
TO	TO
84 663 ...	84 662 ...
01195	01195
01194	01194
01193	01193



The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra.

Spare parts
for article number

84 662 01195 / 84 663 01195
84 662 01194 / 84 663 01194
84 662 01193 / 84 663 01193



Clamping screw

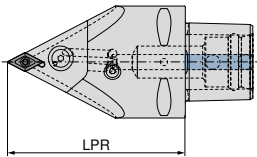
AS

84 950 ...

27600
27600
27600

CoreLine – SDNC 62.5° – Tool holder with screw clamping

Scope of supply:
Without high-performance coolant set



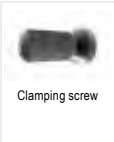
Neutral

Designation	Adapter	LPR mm	Tightening torque Nm	Indexable insert	Direct cooling compatible
PSC63 SDNC N 0100-11	PSC 63	100	3	DC.. 11T3	DC
PSC63 SDNC N 0130-11	PSC 63	130	3	DC.. 11T3	DC

TO
84 677 ...
01193
11193



The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra.



Clamping screw

Spare parts
for article number

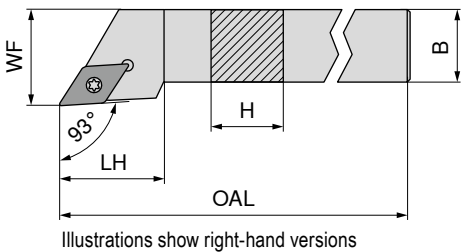
84 677 01193
84 677 11193

AS
84 950 ...
27600
27600

CoreLine – SDJC 93° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



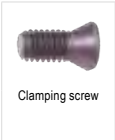
Left Right

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	TO	
							78 555 ...	78 554 ...
SDJC R/L 06-2	0.375	0.375	2.500	0.590	0.500	DC..21.5..	00602 ¹⁾	00602 ¹⁾
SDJC R/L 08-2	0.500	0.500	3.500	0.670	0.625	DC..21.5..	00802	00802
SDJC R/L 10-2	0.625	0.625	4.000	0.670	0.750	DC..21.5..	01002 ¹⁾	01002 ¹⁾
SDJC R/L 12-2B	0.750	0.750	4.500	0.708	1.000	DC..21.5..	01222 ¹⁾	01222 ¹⁾
SDJC R/L 12-3B	0.750	0.750	4.500	1.000	1.000	DC..32.5..	01223	01223
SDJC R/L 16-3D	1.000	1.000	6.000	1.100	1.250	DC..32.5..	01643	01643

1) Not in stock

Spare parts

78 554 01222 / 78 555 01002	06200			06400
78 554 01223 / 78 555 01643	05100	06000	05300	05400



Clamping screw

AS

78 950 ...

06200
05100



Carbide seat D

AS

78 950 ...

06000

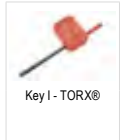


Threaded bush

AS

78 950 ...

05300



Key 1 - TORX®

AS

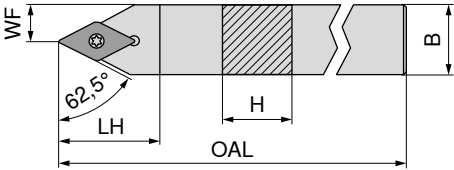
78 950 ...

06400
05400

CoreLine – SDPC 62.5° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Neutral

ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert
SDPC N 06-2	0.375	0.375	2.500	0.370	0.197	DC..21.5..
SDPC N 08-2	0.500	0.500	3.500	0.492	0.260	DC..21.5..
SDPC N 10-3	0.625	0.625	4.000	0.630	0.232	DC..32.5..
SDPC N 12-3B	0.750	0.750	4.500	0.744	0.382	DC..32.5..
SDPC N 16-3D	1.000	1.000	6.000	0.984	0.520	DC..32.5..

TO
78 582 ...
00602 ¹⁾
00802 ¹⁾
01003 ¹⁾
01223 ¹⁾
01643 ¹⁾

1) Not in stock

Spare parts

78 582 00602 / 78 582 00802
78 582 01223 / 78 582 01003

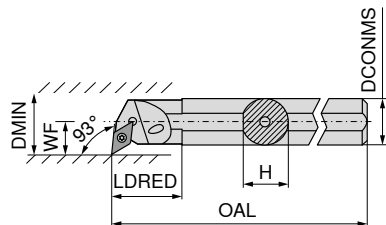
			
Clamping screw	Carbide seat D	Threaded bush	Key I - TORX®
AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...
06200			06400
05100	06000	05300	05400

CoreLine – SDUC 93° – Boring bar with screw clamping

- ▲ A... = with coolant hole
▲ S... = without coolant hole

Scope of supply:

Boring bar with Torx key



Illustrations show right-hand versions



Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert
S12Q SDUC R/L 07	12	11.0	180	12.5	9	17	1,2	DC.. 0702
A12K SDUC R/L 07	12	11.5	125	22.0	9	16	1,2	DC.. 0702
S16R SDUC R/L 07	16	15.0	200	13.0	11	21	1,2	DC.. 0702
A16M SDUC R/L 07	16	15.0	150	29.0	11	20	1,2	DC.. 0702
S20S SDUC R 07	20	18.0	250	20.0	13	25	1,2	DC.. 0702
A20Q SDUC R/L 07	20	18.5	180	32.0	13	25	1,2	DC.. 0702
S20S SDUC R 11	20	18.0	250	20.0	13	25	3,2	DC.. 11T3
A20Q SDUC R/L 11	20	19.0	180	32.0	13	25	3,2	DC.. 11T3
S25T SDUC R/L 11	25	23.0	300		17	32	3,2	DC.. 11T3
A25R SDUC R/L 11	25	24.0	200	36.0	17	32	3,2	DC.. 11T3
S32U SDUC R 11	32	30.0	350		22	40	3,2	DC.. 11T3
A32S SDUC R/L 11	32	31.0	250	50.0	22	40	3,2	DC.. 11T3
A40T SDUC R/L 11	40	39.0	300	60.0	27	50	3,2	DC.. 11T3

Left

Right

TO	TO
70 737 ...	70 736 ...
012	012
212	212
016	016
216	216
	020
220	220
	120
320	320
125	125
325	325
	132
332	332
340	340

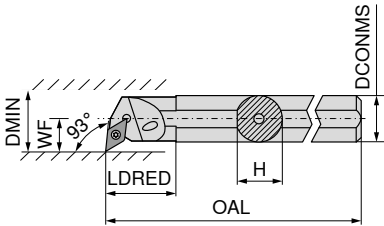
Spare parts for article number

70 736 012 / 70 737 012
70 736 212 / 70 737 212
70 736 016 / 70 737 016
70 736 216 / 70 737 216
70 736 020
70 736 220 / 70 737 220
70 736 120
70 736 320 / 70 737 320
70 736 125 / 70 737 125
70 736 325 / 70 737 325
70 736 132
70 736 332 / 70 737 332
70 736 340 / 70 737 340

Screwdriver	Combi key	Clamping screw	Carbide seat D	Threaded bush
AS	AS	AS	AS	AS
80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
110		13800		
110		13800		
110		13800		
110		13800		
110		13800		
110		13800		
113		110		
113		110		
	398	113	106	171
113		113		
	398	113	106	171
	398	113	106	171
	398	113	106	171

CoreLine – SDUC 93° – Boring bar with screw clamping

▲ With carbide core



Illustrations show right-hand versions



Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert
E-A10H SDUC R/L 07	10	9	100	28	8	13	1,2	DC.. 0702
E-A12K SDUC R/L 07	12	11	125	18	9	18	1,2	DC.. 0702
E-A16M SDUC R/L 07	16	15	150	30	11	22	1,2	DC.. 0702
E-A20Q SDUC R/L 11	20	18	180	38	13	26	3,2	DC.. 11T3
E-A25R SDUC R/L 11	25	23	200	40	17	34	3,2	DC.. 11T3

Left	Right
TO	TO
70 739 ...	70 738 ...
210	210
212	212
216	216
320	320
225	225

Spare parts
for article number

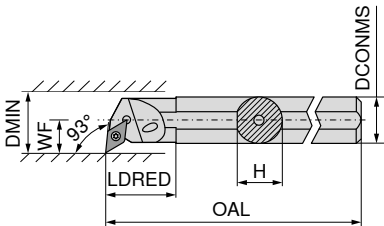
70 738 210 / 70 739 210
70 738 212 / 70 739 212
70 738 216 / 70 739 216
70 738 320 / 70 739 320
70 738 225 / 70 739 225

	
Screwdriver	Clamping screw
AS	AS
80 950 ...	70 950 ...
110	13800
110	13800
110	13800
113	449
113	449

CoreLine – SDUC 93° – Boring bar with screw clamping

▲ Finish: Carbide

Scope of supply:
Boring bar with Torx key



Illustrations show right-hand versions

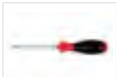


Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert
E12Q SDUC R/L 07	12	11.5	180	26	9	16	1,2	DC.. 0702
E16R SDUC R/L 07	16	15.0	200	34	11	20	1,2	DC.. 0702
E20S SDUC R/L 11	20	18.5	250	38	13	25	3,2	DC.. 11T3
E25T SDUC R/L 11	25	23.0	300	43	17	32	3,2	DC.. 11T3

Left	Right
TO	TO
70 739 ...	70 738 ...
012	012
016	016
120	120
125	125

Spare parts
for article number

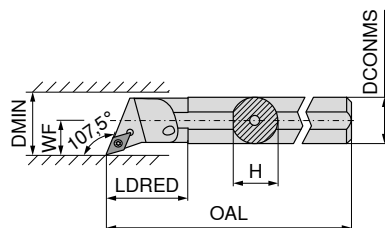
70 738 012 / 70 739 012
70 738 016 / 70 739 016
70 738 120 / 70 739 120
70 738 125 / 70 739 125

	
Screwdriver	Clamping screw
AS	AS
80 950 ...	70 950 ...
110	13800
110	13800
113	304
113	113

CoreLine – SDQC 107.5° – Boring bar with screw clamping

Scope of supply:

Boring bar with Torx key



Illustrations show right-hand versions



Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert
A10H SDQC R/L 07	10	9.0	100	22	7	12.5	1,2	DC.. 0702
A12K SDQC R/L 07	12	11.5	125	22	9	16.0	1,2	DC.. 0702
A16M SDQC R/L 07	16	15.0	150	29	11	20.0	1,2	DC.. 0702
A20Q SDQC R/L 07	20	18.5	180	32	13	25.0	1,2	DC.. 0702
A25R SDQC R/L 11	25	23.0	200	36	17	32.0	3,2	DC.. 11T3
A32S SDQC R/L 11	32	30.0	250	50	22	40.0	3,2	DC.. 11T3
A40T SDQC R/L 11	40	38.0	300	60	27	50.0	3,2	DC.. 11T3

Left

Right

TO	TO
70 741 ...	70 740 ...
210	210
212	212
216	216
220	220
225	225
232	232
240	240

Spare parts

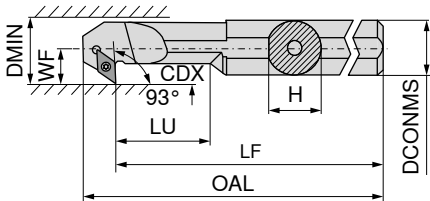
for article number

70 740 210 / 70 741 210
70 740 212 / 70 741 212
70 740 216 / 70 741 216
70 740 220 / 70 741 220
70 740 225 / 70 741 225
70 740 232 / 70 741 232
70 740 240 / 70 741 240

				
Screwdriver	Combi key	Clamping screw	Carbide seat D	Threaded bush
AS	AS	AS	AS	AS
80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
110		13800		
110		13800		
110		13800		
110		13800		
	398	113		
	398	113	106	171
	398	113	106	171

CoreLine – SDXC 93° – Boring bar with screw clamping

Scope of supply:
Boring bar with Torx key



Illustrations show right-hand versions

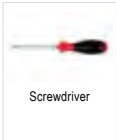
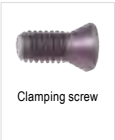


Designation	DCONMS mm	H mm	LF mm	OAL mm	LU mm	WF mm	DMIN mm	CDX mm	Tightening torque Nm	Indexable insert
A12K SDXC R/L 07	12	11.5	125	137.0	24	9	16	4.5	1,2	DC.. 0702
A16M SDXC R/L 07	16	15.0	150	162.0	36	11	20	4.5	1,2	DC.. 0702
A20Q SDXC R/L 11	20	18.5	180	196.5	40	13	25	6.5	3,2	DC.. 11T3
A25R SDXC R/L 11	25	23.0	200	216.8	50	17	32	9.5	3,2	DC.. 11T3

Left	Right
TO	TO
70 733 ...	70 732 ...
212	212
216	216
220	220
225	225

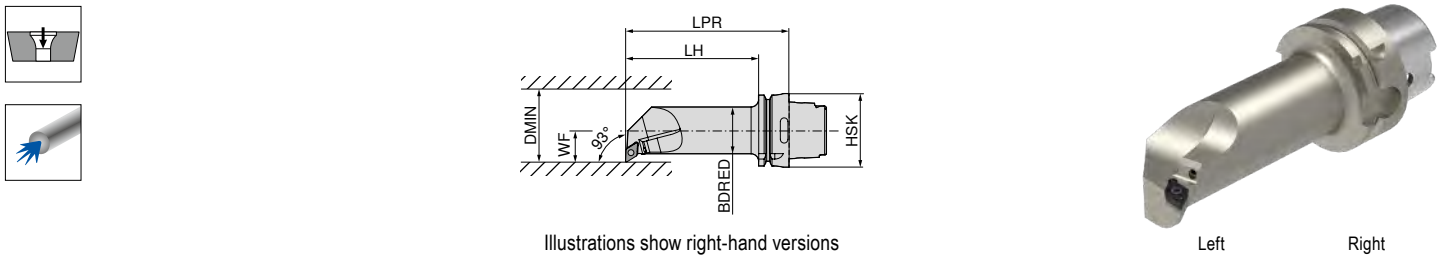
Spare parts
for article number

70 732 212 / 70 733 212
70 732 216 / 70 733 216
70 732 220 / 70 733 220
70 732 225 / 70 733 225

 Screwdriver	 Clamping screw
AS	AS
80 950 ...	70 950 ...
110	13800
110	13800
113	304
113	304

CoreLine – SDUC 93° – Boring bar with screw clamping

Scope of supply:
Boring bar with Torx key



Designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	TO 74 566 ... 511	TO 74 565 ... 511
HSK T63 40L SDUC R/L 11	HSK-T 63	140	114	40	27	50	3.2	DC.. 11T3		

Spare parts
for article number

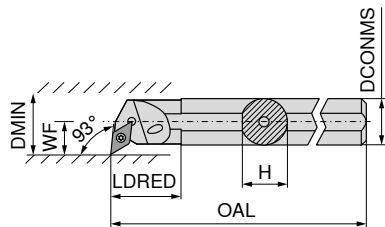
74 565 511 / 74 566 511	T15/SW	398	M3,5x11	113	106	M3,5	171
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CoreLine – SDUC 93° – Boring bar with screw clamping

- ▲ A... = with thru coolant
▲ S... = without thru coolant

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



ANSI designation	DCONMS inch	H inch	OAL inch	LDRED inch	WF inch	DMIN inch	Indexable insert
S06M SDUC R/L 2	0.375	0.340	6.000	0.830	0.375	0.750	DC..21.5..
A06M SDUC R/L 2	0.375	0.340	6.000	0.830	0.375	0.750	DC..21.5..
S08M SDUC R/L 2	0.500	0.460	6.000	0.910	0.438	0.875	DC..21.5..
A08M SDUC R/L 2	0.500	0.460	6.000	0.910	0.438	0.875	DC..21.5..
S10R SDUC R/L 2	0.625	0.580	8.000	1.060	0.500	1.000	DC..21.5..
A10R SDUC R/L 2	0.625	0.580	8.000	1.060	0.500	1.000	DC..21.5..
S12S SDUC R/L 2EX	0.750	0.710	10.000	0.760	0.625	1.250	DC..21.5..
S16T SDUC R/L 2DX	1.000	0.900	12.000	1.000	0.750	1.500	DC..21.5..
S12S SDUC R/L 3M	0.750	0.710	10.000	1.580	0.625	1.250	DC..32.5..
A12S SDUC R/L 3M	0.750	0.710	10.000	1.580	0.625	1.250	DC..32.5..
S16T SDUC R/L 3M	1.000	0.910	12.000	1.810	0.750	1.500	DC..32.5..
S20U SDUC R/L 3M	1.250	1.180	14.000	1.890	0.875	1.750	DC..32.5..
S20U SDUC R/L 3X	1.250	1.180	14.000	1.270	0.765	1.750	DC..32.5..

Left

Right

TO	TO
78 721 ...	78 720 ...
20617 ¹⁾	20617 ¹⁾
20606	20606
20818 ¹⁾	20818 ¹⁾
20808 ¹⁾	20808 ¹⁾
21021 ¹⁾	21021 ¹⁾
21010	21010
21222 ¹⁾	21222 ¹⁾
21626 ¹⁾	21626 ¹⁾
91222 ¹⁾	91222 ¹⁾
91212 ¹⁾	91212 ¹⁾
91626 ¹⁾	91626 ¹⁾
92030 ¹⁾	92030 ¹⁾
32030 ¹⁾	32030 ¹⁾

1) Not in stock

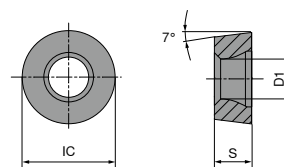
Spare parts

78 720 20808 / 78 721 21222
78 720 32030 / 78 721 32030
78 720 20606 / 78 721 20818
78 720 91212 / 78 721 91626

			
Clamping screw	Carbide seat D	Threaded bush	Key I - TORX®
AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...
06200			06400
05100	06000	05300	05400
05200			06400
05600			05700

RCGT / RCMT / RCMX

Designation	S	D1	IC
	mm	mm	mm
RCGT 0602..	2.38	2.8	6
RC.T 0803..	3.18	3.4	8
RC.T 1003..	3.18	4.0	10
RCMT 10T3..	3.97	4.4	10
RC.T 1204..	4.76	4.9	12
RCMT 1606..	6.35	5.3	16
RCMT 2006..	6.35	6.5	20
RCMT 2507..	7.94	7.2	25
RCMX 2507..	7.94	10.5	25



CoreLine – Carbide turning indexable insert

RCGT / RCMT

		<div>-SM</div> <div>CTCP115-P</div> <div>DRAGONSKIN</div> <div></div> <div></div> <div>M</div> <div>RCGT</div>	<div>-SM</div> <div>CTCP125-P</div> <div>DRAGONSKIN</div> <div></div> <div></div> <div>M</div> <div>RCGT</div>	<div>-SM</div> <div>CTCP135-P</div> <div>DRAGONSKIN</div> <div></div> <div></div> <div>M</div> <div>RCGT</div>	<div>-SM</div> <div>CTCP115-P</div> <div>DRAGONSKIN</div> <div></div> <div></div> <div>M</div> <div>RCMT</div>	<div>-SM</div> <div>CTCP115-P</div> <div>DRAGONSKIN</div> <div></div> <div></div> <div>M</div> <div>RCMT</div>	<div>-SM</div> <div>CTCP125-P</div> <div>DRAGONSKIN</div> <div></div> <div></div> <div>M</div> <div>RCMT</div>	<div>-SM</div> <div>CTCP135-P</div> <div>DRAGONSKIN</div> <div></div> <div></div> <div>M</div> <div>RCMT</div>
ISO	RE mm	TR 76 185 ...	TR 76 262 ...	TR 76 262 ...	TR 76 186 ...	TR 76 264 ...	TR 76 264 ...	TR 76 264 ...
0602M0EN	3.0	30201	50201	70201				
0803M0EN	4.0	30401	51201	71201				
1003M0SN	5.0					31401	51401	71401
1204M0SN	6.0					32801	52601	72601
1606M0SN	8.0					34001	53801	73801
2006M0SN	10.0				35001		55001	75001
2507M0SN	12.5					36201	56201	76201
P		●	●	●	●	●	●	●
M				○				○
K		○	○		○	○	○	
N								
S								
H								
O								

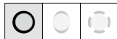
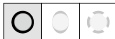
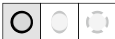
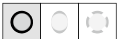
CoreLine – Carbide turning indexable insert

RCMT / RCMX

		<div><div><div><div><div>-M23</div><div>CTCP115-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div><div></div><div></div><div></div></div></div><div>M</div><div>RCMT</div></div></div><div><div><div><div>-M23</div><div>CTCP115-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div><div></div><div></div><div></div></div></div><div>M</div><div>RCMT</div></div></div><div><div><div><div>-M23</div><div>CTCP125-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div><div></div><div></div><div></div></div></div><div>M</div><div>RCMT</div></div></div><div><div><div><div>-M23</div><div>CTCP135-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div><div></div><div></div><div></div></div></div><div>M</div><div>RCMT</div></div></div><div><div><div><div>-M23</div><div>CTCP115-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div><div></div><div></div><div></div></div></div><div>M</div><div>RCMX</div></div></div><div><div><div><div>-M23</div><div>CTCP125-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div><div></div><div></div><div></div></div></div><div>M</div><div>RCMX</div></div></div><div><div><div><div>-M23</div><div>CTCP135-P</div></div><div>DRAGONSKIN</div><div><div><div></div><div></div><div></div></div></div><div><div><div></div><div></div><div></div></div></div><div>M</div><div>RCMX</div></div></div></div>						
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	74 117 ...	74 121 ...	74 121 ...	74 121 ...	74 117 ...	74 117 ...	74 117 ...
0803M0SN	4.0		21300	20600				
10T3M0SN	5.0		21400	61400	71401			
1204M0SN	6.0		22600	62600	72601			
1606M0SN	8.0		23800	63800	73801			
2006M0SN	10.0	25000		65000	76501			
2507M0SN	12.5					25400	66200	76201
P		●	●	●	●	●	●	●
M					○			
K		○	○	○		○	○	○
N								
S								
H								
O								

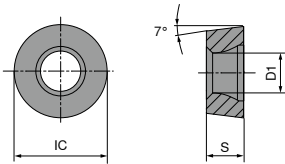
CoreLine – Carbide turning indexable insert

RCMT / RCGT

		<div><div>-SM</div><div>CTCM120</div><div>DRAGONSKIN</div><div></div><div></div><div>M</div><div>RCMT</div></div>	<div><div>-SM</div><div>CTPM125</div><div>DRAGONSKIN</div><div></div><div></div><div>M</div><div>RCMT</div></div>	<div><div>-SM</div><div>CTPX710</div><div>DRAGONSKIN</div><div></div><div></div><div>M</div><div>RCMT</div></div>	<div><div>-25P</div><div>H210T</div><div></div><div></div><div>F</div><div>RCGT</div></div>	<div><div>-27</div><div>H10T</div><div></div><div></div><div>M</div><div>RCGT</div></div>	<div><div>-27</div><div>CTPX715</div><div>DRAGONSKIN</div><div></div><div></div><div>M</div><div>RCGT</div></div>
		TR	TR	TR	TR	TR	TR
ISO	RE mm	75 221 ...	75 221 ...	75 221 ...	70 241 ...	70 266 ...	70 266 ...
0602M0FN	3.0					600	70200
0803M0FN	4.0				60200	602	80200
1003M0FN	5.0					604	80400
1003M0SN	5.0	11400	21600	61400			
1204M0FN	6.0						72800
2006M0SN	10.0		25000				
2507M0SN	12.5		26200				
P		○	○	●			●
M		●	●	●			●
K					○	○	○
N				○	●	●	●
S				●	○		●
H							
O					○	○	○

RCMX

Designation	S	D1	IC
	mm	mm	mm
RCMX 2507..	7.94	7.20	25
RCMX 2507..	7.94	10.50	25
RCMX 3009..	9.52	10.15	30
RCMX 3209..	9.52	10.50	32



MaxiTurn – Carbide turning indexable insert

RCMX

ISO	RE mm
2507M0SN	12.5
3009M0SN	15.0
3209M0SN	16.0
P	
M	
K	
N	
S	
H	
O	

-M23 CTC10RW1	-M23 CTC25RW1	-M63 CTC10RW1
M RCMX	M RCMX	M RCMX
TR	IA	IA
74 117 ... 35200	74 117 ...	74 118 ... 36200
37400	47600	

MaxiTurn – Carbide turning indexable insert

RCMX

ISO	RE mm
2507M0SN	12.5
3209M0SN	16.0

-R33 CTCP115-P	-R33 CTC10RW1	-R33 CTC15RW1	-R33 CTC25RW1
R RCMX	R RCMX	R RCMX	R RCMX
TR	TR	TR	IA
74 119 ... 25800	74 119 ... 35600	74 119 ... 56000	74 119 ... 48200
28400	37800	58000	48200

P				
M				
K				
N				
S				
H				
O				

MaxiTurn – Carbide turning indexable insert

RCMX

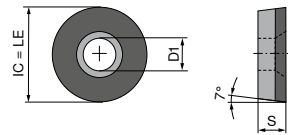
ISO	RE mm
2507M0SN	12.5
3209M0SN	16.0

-R63 CTCP115-P	-R63 CTC10RW1	-R63 CTC15RW1	-R63 CTC25RW1
R RCMX	R RCMX	R RCMX	R RCMX
TR	TR	TR	IA
74 120 ... 26600	74 120 ... 36400	74 120 ... 56800	74 120 ... 47200
37000			

P				
M				
K				
N				
S				
H				
O				

RCGW

Designation		S	D1	IC
	mm	mm	mm	mm
RCGW 1204..	-	4.76	4.4	12

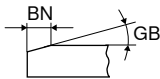


RCGW F

CoreLine – PcBN turning indexable insert

RCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners



CTBS10U



F
CBN
RCGW

ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
1204M0TN	6	0.12	20°	F	12

PC

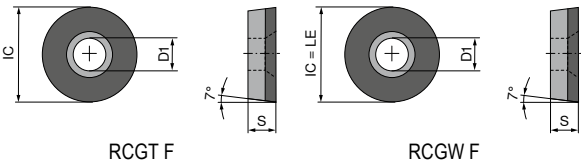
71 425 ...

10000

P	
M	
K	●
N	
S	●
H	
O	

RCGW / RCGT

Designation	S	D1	IC
	mm	mm	mm
RCG. 0602..	2.38	2.8	6
RCGW 0803..	3.18	3.4	8
RCGW 1003..	3.18	4.4	10
RCGT 10T3..	3.97	4.4	10
RCGW 1204..	4.76	4.4	12



CoreLine – PCD turning indexable insert

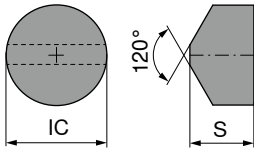
RCGW / RCGT

▲ TCE(NOI) = Design and number of equipped cutting edge corners

				CTDPD20	-CB1 CTDPD20	CTDPS30	-CB1 CTDPS30	-CB2 CTDPS30
				F DIAMOND RCGW	F DIAMOND RCGT	F DIAMOND RCGW	F DIAMOND RCGT	M DIAMOND RCGT
ISO	RE mm	TCE (NOI)	LE mm	PC 71 179 ...	PC 71 315 ...	PC 71 179 ...	PC 71 315 ...	PC 71 316 ...
0602M0FN	3	F	6	10001	102	20001	202	202
0803M0FN	4	F	8	10101		20101		
1003M0FN	6	F	10	10201				
10T3M0FN	5	F	10		104		204	204
1204M0FN	6	F	12	10301				
P								
M								
K								
N				•	•	•	•	•
S								
H								
O				•	•	•	•	•

RCGX

Designation	S	IC
	mm	mm
RCGX 0606..	6.2	6.35
RCGX 0707..	7.7	9.52
RCGX 0907..	7.7	9.52
RCGX 1207..	7.7	12.70
RCGX 1510..	10.0	15.80
RCGX 1512..	12.0	25.40
RCGX 1910..	10.0	19.05
RCGX 2512..	12.0	25.40



CoreLine – CERAMIC turning indexable insert

RCGX

CTS3105

DRAGONSKIN

M

CERAMIC

RCGX

CTN3110

DRAGONSKIN

M

CERAMIC

RCGX

CTSH110

DRAGONSKIN

M

CERAMIC

RCGX

CTKX715

DRAGONSKIN

M

CERAMIC

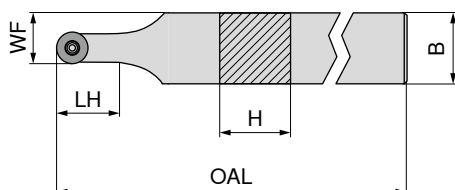
RCGX

ISO	IC	IC	IC	IC
	74 203 ...	74 203 ...	74 203 ...	74 203 ...
060600TN	20100		10100	00100
090700SN	20200			
090700TN	20300			
090700TN				00200
120700PN	20400		10200	
120700TN	20500		10300	00300
151000PN	20600		10400	
151000SN	20700			
151200PN	21000			
191000PN	20800	40200		
191000SN	20900			
191000TN			10700	
251200PN			10800	00500
P				
M				
K				○
N				
S				●
H				●
O				

CoreLine – SRDC 0° – Tool holder with screw clamping

Scope of supply:

Tool holder with Torx key



Neutral

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	TO 70 646 ...
SRDC N 1212 F06	12	12	80	12.0	9.0	1,2	RC.. 0602	01200
SRDC N 1616 H06	16	16	100	12.0	11.0	1,2	RC.. 0602	01600
SRDC N 2020 K06	20	20	125	12.0	13.0	1,2	RC.. 0602	02000
SRDC N 2525 M06	25	25	150	12.4	15.5	1,2	RC.. 0602	02500
SRDC N 1616 H08	16	16	100	16.0	12.0	1,8	RC.. 0803	11600
SRDC N 2020 K08	20	20	125	16.5	14.0	1,8	RC.. 0803	12000
SRDC N 2525 M08	25	25	150	16.5	16.5	1,8	RC.. 0803	12500
SRDC N 1616 H10	16	16	100	20.9	13.0	3,2	RC.. 1003 / RC.. 10T3	21600
SRDC N 2020 K10	20	20	125	20.0	15.0	3,2	RC.. 1003 / RC.. 10T3	22000
SRDC N 2525 M10	25	25	150	20.9	17.5	3,2	RC.. 1003 / RC.. 10T3	22500



When working with WSP RC.. 10T3 use indexable insert shim article no. **70 950 92100**.

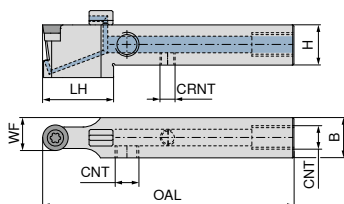
Spare parts for article number

	Screwdriver	Clamping screw	Carbide seat R	Threaded bush
	AS	AS	AS	AS
70 646 01200	80 950 ...	70 950 ...	70 950 ...	70 950 ...
70 646 01600	039	857		
70 646 02000	039	857		
70 646 02500	039	857		
70 646 11600	118	819		
70 646 12000	118	819		
70 646 12500	118	819		
70 646 21600	120	87900	117	171
70 646 22000	120	87900	117	171
70 646 22500	120	87900	117	171

CoreLine – SRDC 0° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Neutral

Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Tightening torque Nm	Indexable insert	TO 70 775 ...
SRDC N 1212 F06 DC	12	12	80	26	9.0	M6	M6	1,2	RC.. 0602	01200
SRDC N 1616 H06 DC	16	16	100	30	11.0	M6	G1/8"	1,2	RC.. 0602	01600
SRDC N 2020 K06 DC	20	20	125	30	13.0	M6	G1/8"	1,2	RC.. 0602	02000
SRDC N 2525 M06 DC	25	25	150	30	15.5	M6	G1/8"	1,2	RC.. 0602	02500
SRDC N 1616 H08 DC	16	16	100	30	12.0	M6	G1/8"	1,8	RC.. 0803	11600
SRDC N 2020 K08 DC	20	20	125	30	14.0	M6	G1/8"	1,8	RC.. 0803	12000
SRDC N 2525 M08 DC	25	25	150	31	16.5	M6	G1/8"	1,8	RC.. 0803	12500
SRDC N 1616 H10 DC	16	16	100	30	13.0	M6	G1/8"	3,2	RC.. 1003 / RC.. 10T3	21600
SRDC N 2020 K10 DC	20	20	125	30	15.0	M6	G1/8"	3,2	RC.. 1003 / RC.. 10T3	22000
SRDC N 2525 M10 DC	25	25	150	36	17.5	M6	G1/8"	3,2	RC.. 1003 / RC.. 10T3	22500



When working with WSP RC.. 10T3 use indexable insert shim article no. **70 950 92100**.

Spare parts for article number

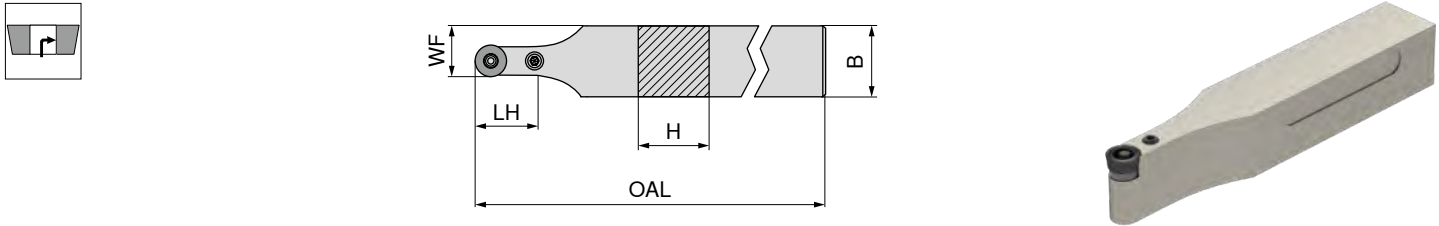
	Clamping screw	Carbide seat R	Set Screw	Set Screw	Threaded bush
	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 775 01200	857			86700	
70 775 01600	857		88000	86700	
70 775 02000	857		88000	86700	
70 775 02500	857		88000	86700	
70 775 11600	819		88000	86700	
70 775 12000	819		88000	86700	
70 775 12500	819		88000	86700	
70 775 21600	87900	117	88000	86700	171
70 775 22000	87900	117	88000	86700	171
70 775 22500	87900	117	88000	86700	171

Spare parts for article number

	Sealing plugs DC	Screwdriver	O ring	Coolant nozzle DC	Coolant screw plug
	AS 70 950 ...	AS 80 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 775 01200		039			
70 775 01600	87600	039	88100	87700	294
70 775 02000	87600	039	88100	87700	294
70 775 02500	87600	039	88100	87700	294
70 775 11600	87600	118	88100	87700	294
70 775 12000	87600	118	88100	87700	294
70 775 12500	87600	118	88100	87700	294
70 775 21600	87600	120	88100	87700	294
70 775 22000	87600	120	88100	87700	294
70 775 22500	87600	120	88100	87700	294

CoreLine – PRDC 0° – Tool holder with lever clamping

Scope of supply:
Tool holder with Allen key



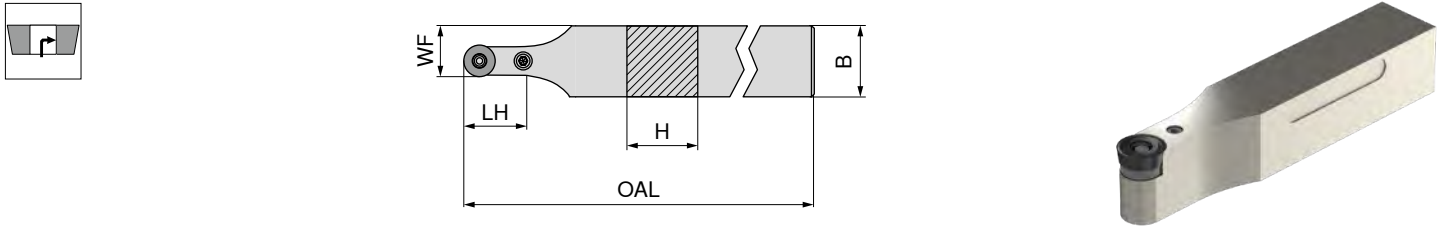
Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	Neutral TO 70 544 ...	
PRDC N 2525 M12	25	25	150	24	18.5	3	RC.. 1204	025	
PRDC N 3225 P12	32	25	170	24	18.5	3	RC.. 1204	032	
PRDC N 3225 P16	32	25	170	28	20.5	4	RC.. 1606	132	

Spare parts
for article number

		Key I	Shim	Assembly pin	Toggle lever	Clamping screw	Carbide seat R
		AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 544 025	SW2,5	175	197	191	178	208	215
70 544 032	SW2,5	175	197	191	178	208	215
70 544 132	SW3	176	196	192	387	390	384

CoreLine – PRDC 0° – Tool holder with lever clamping

Scope of supply:
Tool holder with Allen key



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	Neutral TO 70 545 ...
PRDC N 3232 P20	32	32	170	32	26.0	5	RC.. 2006	23200
PRDC N 4040 S25	40	40	250	42	32.5	6	RCMT 2507 / RCMX 2507	40400

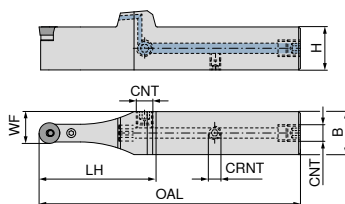
Spare parts
for article number

	Key I	Shim	Assembly pin	Toggle lever	Clamping screw	Carbide seat R
	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 545 23200	176	391	394	28100	28500	27400
70 545 40400	396	392	395	28400	28600	27500

CoreLine – PRDC 0° DC – Tool holder with lever clamping

Scope of supply:

Tool holder with Allen key



Neutral

Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Tightening torque Nm	Indexable insert	TO 70 595 ...
PRDC N 2020 X12-T DC	20	20	132	63	16.0	M6	G1/8"	3	RC.. 1204	02000
PRDC N 2525 X12-T DC	25	25	152	68	18.5	M6	G1/8"	3	RC.. 1204	02500
PRDC N 3225 X12-T DC	32	25	168	68	18.5	M6	G1/8"	3	RC.. 1204	03200
PRDC N 3225 X16-T DC	32	25	172	72	20.5	M6	G1/8"	4	RC.. 1606	13200
PRDC N 3232 X20-T DC	32	32	176	76	26.0	M6	G1/8"	5	RC.. 2006	23200
PRDC N 4040 X25-T DC	40	40	216	91	32.5	M6	G1/8"	6	RCMT 2507 / RCMX 2507	04000

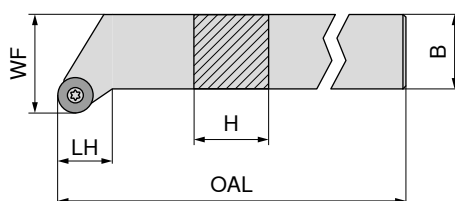
Spare parts for article number

	Key I	Shim	Assembly pin	Coolant screw plug	Toggle lever	Clamping screw	Carbide seat R	Set Screw
	AS	AS	AS	AS	AS	AS	AS	AS
70 595 02000	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 595 02500								
70 595 03200								
70 595 13200								
70 595 23200								
70 595 04000								

CoreLine – SRGC – Tool holder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



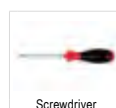
Left Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
SRGC R/L 1212 F06	12	12	80	12.5	16	1,2	RC.. 0602
SRGC R 1616 H06	16	16	100	12.5	20	1,2	RC.. 0602
SRGC R/L 2020 K06	20	20	125	15.0	25	1,2	RC.. 0602
SRGC R/L 2525 M06	25	25	150	18.5	32	1,2	RC.. 0602
SRGC R/L 1616 H08	16	16	100	13.6	20	1,8	RC.. 0803
SRGC R 2020 K08	20	20	125	16.1	25	1,8	RC.. 0803
SRGC R/L 2525 M08	25	25	150	19.6	32	1,8	RC.. 0803
SRGC R/L 2020 K10	20	20	125	16.1	25	3,2	RC.. 1003 / RC.. 10T3
SRGC R/L 2525 M10	25	25	150	19.6	32	3,2	RC.. 1003 / RC.. 10T3

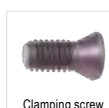
TO	TO
70 647 ...	70 647 ...
01200	01201
	01601
02000	02001
02500	02501
11600	11601
	12001
12500	12501
22000	22001
22500	22501



When working with WSP RC.. 10T3 use indexable insert shim article no. **70 950 92100**.



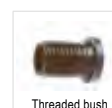
Screwdriver



Clamping screw



Carbide seat R



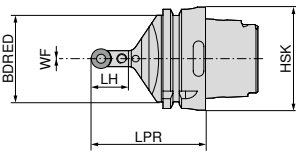
Threaded bush

Spare parts for article number

		AS		AS		AS		AS
70 647 01201 / 70 647 01200	T08 - IP	039	M2,5x6 - 08IP	857				
70 647 01601	T08 - IP	039	M2,5x6 - 08IP	857				
70 647 02001 / 70 647 02000	T08 - IP	039	M2,5x6 - 08IP	857				
70 647 02501 / 70 647 02500	T08 - IP	039	M2,5x6 - 08IP	857				
70 647 11601 / 70 647 11600	T09 - IP	118	M3x7 - 09IP	819				
70 647 12001	T09 - IP	118	M3x7 - 09IP	819				
70 647 12501 / 70 647 12500	T09 - IP	118	M3x7 - 09IP	819				
70 647 22001 / 70 647 22000	T15 - IP	120	M3,5x11	87900	117	M3,5	171	
70 647 22501 / 70 647 22500	T15 - IP	120	M3,5x11	87900	117	M3,5	171	

CoreLine – PRDC 0° – Tool holder with lever clamping

Scope of supply:
Tool holder with Allen key



Neutral

TO

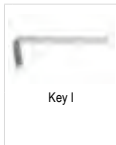
74 548 ...

512

Designation	Adapter	LPR mm	BORED mm	WF mm	Tightening torque Nm	Indexable insert
HSK T63 PRDC N 12	HSK-T 63	70	53	0	3	RC.. 1204 M0

Spare parts
for article number

74 548 512	SW2,5	175	197	191	178	208	215
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Key I

AS

70 950 ...



Shim

AS

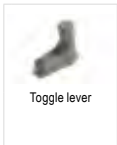
70 950 ...



Assembly pin

AS

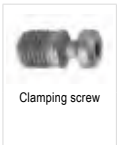
70 950 ...



Toggle lever

AS

70 950 ...



Clamping screw

AS

70 950 ...

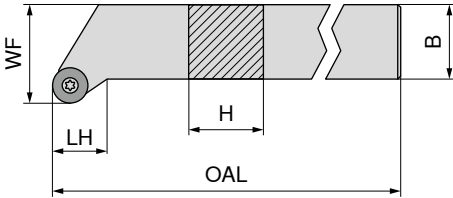


Carbide seat R

AS

70 950 ...

CoreLine – SRGC – Tool holder with screw clamping



Illustrations show right-hand versions

Left

TO

70 713 ...

216

Right

TO

70 712 ...

216

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
SRGC R/L 1616 H10	16	16	100	12	20	3,2	RC.. 1003 M0

Spare parts
for article number

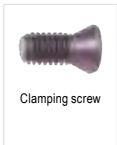
70 712 216 / 70 713 216	398	113	117	171
-------------------------	-----	-----	-----	-----



Combi key

AS

70 950 ...



Clamping screw

AS

70 950 ...



Carbide seat R

AS

70 950 ...



Threaded bush

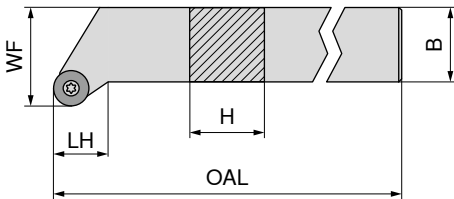
AS

70 950 ...

CoreLine – SRGC – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



ANSI designation	OAL inch	H inch	B inch	WF inch	Indexable insert
SRGC R/L 12-3B	4.500	0.750	0.750	1.000	RC..10T3M0
SRGC R/L 16-3D	6.000	1.000	1.000	1.250	RC..10T3M0
SRGC R/L 20-4D	6.000	1.250	1.250	1.500	RC..1204M0
SRGC R/L 16-4D	6.000	1.000	1.000	1.250	RC..1204M0
SRGC R/L 85-4D	6.000	1.250	1.000	1.250	RC..1204M0

Left	Right
TO	TO
78 557 ...	78 556 ...
01223	01223
01643 ¹⁾	01643 ¹⁾
02044 ¹⁾	02044 ¹⁾
01644	01644
08544 ¹⁾	08544 ¹⁾

1) Not in stock

Spare parts

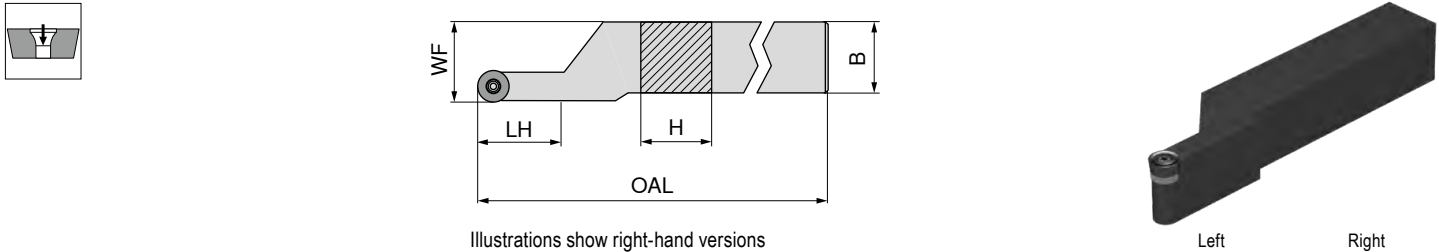
78 556 01644 / 78 557 02044	05100	06300	05300	05400
78 556 01643 / 78 557 01643	05100	05900	05300	05400

 Clamping screw	 Carbide seat R	 Threaded bush	 Key I - TORX®
AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...

CoreLine – SRSC 45° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



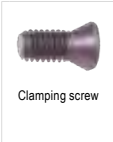
ANSI designation	OAL inch	H inch	B inch	WF inch	Indexable insert
SRSC R/L 12-4B	4.500	0.750	0.750	1.000	RC..1204M0
SRSC R/L 20-3D	6.000	1.250	1.250	1.500	RC..10T3M0
SRSC R/L 16-3D	6.000	1.000	1.000	1.250	RC..10T3M0
SRSC R/L 16-4D	6.000	1.000	1.000	1.250	RC..1204M0
SRSC R/L 20-4D	6.000	1.250	1.250	1.500	RC..1204M0

TO	TO
78 559 ...	78 558 ...
01224 ¹⁾	01224 ¹⁾
02043 ¹⁾	02043 ¹⁾
01643 ¹⁾	01643 ¹⁾
01644 ¹⁾	01644 ¹⁾
02044 ¹⁾	02044 ¹⁾

1) Not in stock

Spare parts

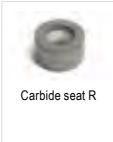
78 558 01224 / 78 559 01224	05100	06300	05300	05400
78 558 01643 / 78 559 01643	05100	05900	05300	05400



Clamping screw

AS

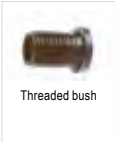
78 950 ...



Carbide seat R

AS

78 950 ...



Threaded bush

AS

78 950 ...



Key I - TORX®

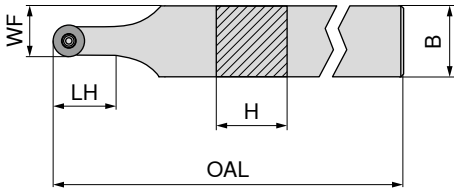
AS

78 950 ...

CoreLine – SRDC 0° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



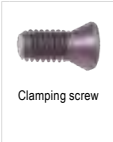
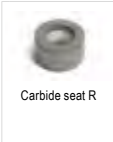
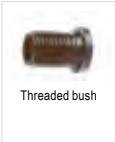
ANSI designation	OAL inch	H inch	B inch	WF inch	Indexable insert
SRDC N 08-2	3.500	0.500	0.500	0.407	RC..0803M0
SRDC N 10-3	4.000	0.625	0.625	0.510	RC..10T3M0
SRDC N 12-3B	4.500	0.750	0.750	0.570	RC..10T3M0
SRDC N 20-4D	6.000	1.250	1.250	0.861	RC..1204M0
SRDC N 16-4D	6.000	1.000	1.000	0.756	RC..1204M0

Neutral
TO
78 583 ...
00802 ¹⁾
01003 ¹⁾
01223
02044
01644

1) Not in stock

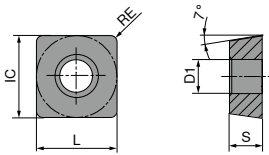
Spare parts

78 583 01003 / 78 583 01223
78 583 00802
78 583 01644 / 78 583 02044

			
Clamping screw	Carbide seat R	Threaded bush	Key I - TORX®
AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...
05100	05900	05300	05400
00200			00100
05100	06300	05300	05400

SCGT / SCMT

Designation	L	S	D1	IC
	mm	mm	mm	mm
SC.T 09T3..	9.52	3.97	4.4	9.52
SC.T 1204..	12.70	4.76	5.5	12.70



CoreLine – Carbide turning indexable insert

SCGT / SCMT

		-CF05 CTEP110-P	-CF55 CTEP110-P	-SF TCM10	-SF CTCK110-P	-SF CTCP115-P	-SF CTCP125-P	-SF CTCP135-P
		DRAGONSKIN	DRAGONSKIN		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		F CERMET SCGT	F CERMET SCMT	F CERMET SCGT	F SCMT	F SCMT	F SCMT	F SCMT
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	76 261 ...	76 260 ...	70 271 ...	70 310 ...	76 187 ...	76 269 ...	76 269 ...
09T304EN	0.4	00401	00401	902	10401	30401	50401	70401
09T308EN	0.8	00601	00601	904	10601	30601	50601	70601
120408EN	0.8				11801	31801	51801	71801
P		●	●	●	○	●	●	●
M		○	○	○				○
K		○	○	○	●	○	○	
N								
S								
H								
O								

CoreLine – Carbide turning indexable insert

SCMT

		-SMF CTCP135-P	-SMF CTCP125-P	-SMF CTCP115-P	-SM CTCK110-P	-SM CTCK120-P	-SM CTCP115-P	-SM CTCP125-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		F SCMT	F SCMT	F SCMT	M SCMT	M SCMT	M SCMT	M SCMT
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	76 267 ...	76 267 ...	76 267 ...	70 268 ...	70 268 ...	76 268 ...	76 268 ...
09T304EN	0.4	70401	50401	30401	10401	50401	30401	50401
09T308EN	0.8	70601	50601	30601	10601	50601	30601	50601
120408EN	0.8	71801	51801	31801	11801	51801	31801	51801
120412EN	1.2				12001	52001	32001	52001
P		●	●	●	○	○	●	●
M		○						
K			○	○	●	●	○	○
N								
S								
H								
O								

CoreLine – Carbide turning indexable insert

SCMT

		-SM CTCP135-P	-SM CTPM125	-M25 CTPM125	-M55 CTCM120	-M55 CTPM125	-M55 CTCM130	-M55 CTPX710
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		M SCMT	M SCMT	F SCMT	M SCMT	M SCMT	M SCMT	M SCMT
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	76 268 ...	75 049 ...	75 222 ...	75 216 ...	75 216 ...	75 216 ...	75 216 ...
09T304EN	0.4	70401		70400				
09T308EN	0.8	70601	20600		10600	206	30600	60600
120408EN	0.8	71801	21800		11800	218	31800	61800
120412EN	1.2	72001						
P		●	○	○	○	○	○	●
M		○	●	●	●	●	●	●
K								
N								○
S							○	●
H								
O								

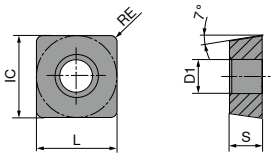
CoreLine – Carbide turning indexable insert

SCGT

			<div><div>-25P</div><div>H210T</div></div>	<div><div>-25P</div><div>CTPX710</div></div>	<div><div>-27</div><div>H10T</div></div>	<div><div>-27</div><div>CTPX715</div></div>
			<div><div></div><div></div><div></div></div>	<div><div>DRAGONSKIN</div><div></div><div></div><div></div></div>	<div><div></div><div></div><div></div></div>	<div><div>DRAGONSKIN</div><div></div><div></div><div></div></div>
						
			<div><div>F</div><div>SCGT</div></div>	<div><div>M</div><div>SCGT</div></div>	<div><div>M</div><div>SCGT</div></div>	<div><div>M</div><div>SCGT</div></div>
ISO	RE mm		<div>TR</div> <div>70 283 ...</div>	<div>TR</div> <div>70 283 ...</div>	<div>TR</div> <div>70 270 ...</div>	<div>TR</div> <div>70 270 ...</div>
09T304FN	0.4				600	80400
09T308FN	0.8				602	80600
120408FN	0.8		634	71600	604	71800
P				●		●
M				●		●
K			○		○	○
N			●	●	●	●
S			○	●		●
H						
O			○		○	○

SCMX / SCGT

Designation	L	S	D1	IC
	mm	mm	mm	mm
SCGT 09T3..	9.52	3.97	4.4	9.52
SCMX 1204..	12.70	4.76	5.5	12.70



CoreLine – Carbide turning indexable insert

SCMX / SCGT

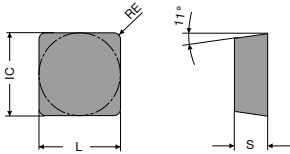
CTCP125-P	CTCP135-P	-27P CTPX715	-27P H10T
DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	
M SCMX	M SCMX	M SCGT	M SCGT
TR	TR	TR	TR
76 190 ...	76 182 ...	70 270 ...	70 243 ...
		70600	60600
51801	71801		

ISO	RE mm
09T308FN	0.8
120408EN	0.8

P	●	●	●
M		○	●
K	○	○	○
N		●	●
S		●	
H			
O		○	○

SPUN / SPMR

Designation	L	S	IC
	mm	mm	mm
SP.. 1203..	12.7	3.18	12.7



CoreLine – Carbide turning indexable insert

SPUN / SPMR

ISO	RE mm
120304EN	0.4
120308EN	0.8

CTCP135-P

DRAGONSKIN

M
SPUN

TR

76 206 ...
71801

CTCP135-P

DRAGONSKIN

M
SPMR

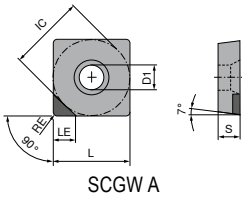
TR

76 208 ...
71601
71801

P		●	●
M		○	○
K			
N			
S			
H			
O			

SCGW

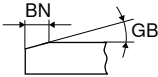
Designation	L	S	D1	IC
	mm	mm	mm	mm
SCGW 09T3..	9.52	3.97	4.4	9.52
SCGW 1204..	12.70	4.76	5.5	12.70



CoreLine – PcBN turning indexable insert

SCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners



CTBS10U



F
CBN
SCGW

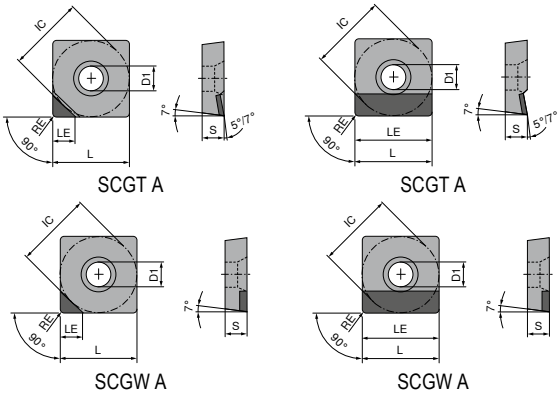
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
09T304TN	0.4	0.12	20°	A (1)	3.5
09T304FN	0.4			A (1)	3.5
09T308TN	0.8	0.12	20°	A (1)	3.4
120404FN	0.4			A (1)	3.5
120404TN	0.4	0.12	20°	A (1)	3.5
120408TN	0.8	0.12	20°	A (1)	3.4

PC
71 426 ...
10100
10000
10300
10400
10500
10700

P	
M	
K	●
N	
S	●
H	
O	

SCGW / SCGT

Designation	L	S	D1	IC
	mm	mm	mm	mm
SCG. 09T3..	9.52	3.97	4.4	9.52
SCG. 1204..	12.70	4.76	5.5	12.70



CoreLine – PCD turning indexable insert

SCGW / SCGT

▲ TCE(NOI) = Design and number of equipped cutting edge corners

ISO	RE mm	TCE (NOI)	LE mm
09T304FN	0.4	A (1)	9.52
09T304FN	0.4	A (1)	4.40
09T308FN	0.8	A (1)	9.52
09T308FN	0.8	A (1)	4.30
09T312FN	1.2	A (1)	4.20
120404FN	0.4	A (1)	12.70
120404FN	0.4	A (1)	4.40
120408FN	0.8	A (1)	4.30
120408FN	0.8	A (1)	12.70
120412FN	1.2	A (1)	4.20
120412FN	1.2	A (1)	12.70

	CTDPD20	CTDPD20	-CB1 CTDPD20	CTDPS30	CTDPS30
	F	F	F	F	F
	DIAMOND SCGW	DIAMOND SCGW	DIAMOND SCGT	DIAMOND SCGW	DIAMOND SCGT
PC	71 182 ...	71 183 ...	71 320 ...	71 182 ...	71 180 ...
	10001	10001	114	20601	20001
	10101	10101	118		20101
	10201				20201
	10301	10201			
	10401	10301			
	10501	10401			
P					
M					
K					
N	•	•	•	•	•
S					
H					
O	•	•	•	•	•

CoreLine – PCD turning indexable insert

SCGT

▲ TCE(NOI) = Design and number of equipped cutting edge corners

ISO	RE mm	TCE (NOI)	LE mm
09T304FN	0.4	A (1)	4.4
09T308FN	0.8	A (1)	9.5
09T308FN	0.8	A (1)	4.3
120408FN	0.8	A (1)	12.7
120412FN	1.2	A (1)	12.0

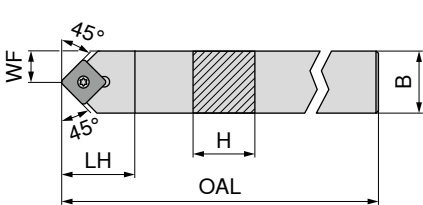
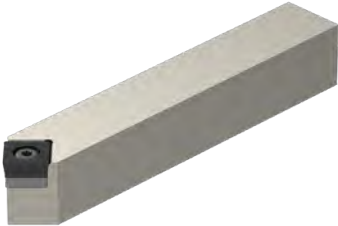
CTDPS30	-CB2 CTDPS30	-CB3 CTDPU20
F DIAMOND SCGT	M DIAMOND SCGT	R DIAMOND SCGT
PC	PC	PC
71 181 ...	71 321 ...	71 322 ...
	214	214
20001		
	218	218
20101		
20201		

P			
M			
K			
N	•	•	•
S			
H			
O	•	•	•

CoreLine – SSDC 45° – Tool holder with screw clamping

Scope of supply:

Tool holder with Torx key



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	Neutral	
								TO	
SSDC N 1212 F09	12	12	80	16	6.0	3,2	SC.. 09T3..	70 651 ...	01200
SSDC N 1616 H09	16	16	100	20	8.0	3,2	SC.. 09T3..		01600
SSDC N 2020 K09	20	20	125	20	10.0	3,2	SC.. 09T3..		02000
SSDC N 1616 H12	16	16	100	25	8.0	5	SC.. 1204..		11600
SSDC N 2020 K12	20	20	125	25	10.0	5	SC.. 1204..		12000
SSDC N 2525 M12	25	25	150	25	12.5	5	SC.. 1204..		12500

Spare parts
for article number

	AS	AS	AS	AS
70 651 01200	120	87900		
70 651 01600	120	87900		
70 651 02000	120	87900	167	171
70 651 11600	120	820	168	170
70 651 12000	120	820	168	170
70 651 12500	120	820	168	170

Screwdriver

AS

80 950 ...

Clamping screw

AS

70 950 ...

Carbide seat S

AS

70 950 ...

Threaded bush

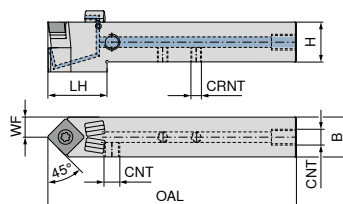
AS

70 950 ...

CoreLine – SSDC 45° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Neutral

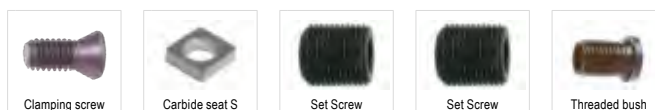
Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Tightening torque Nm	Indexable insert	TO 70 776 ...
SSDC N 1212 F09 DC	12	12	80	25	12.8	M6	M6	3,2	SC.. 09T3..	01200
SSDC N 1616 H09 DC	16	16	100	30	16.0	M6	G1/8"	3,2	SC.. 09T3..	01600
SSDC N 2020 K09 DC	20	20	125	30	20.0	M6	G1/8"	3,2	SC.. 09T3..	02000
SSDC N 1616 H12 DC	16	16	100	29	17.3	M6	G1/8"	5	SC.. 1204..	11600
SSDC N 2020 K12 DC	20	20	125	30	20.0	M6	G1/8"	5	SC.. 1204..	12000
SSDC N 2525 M12 DC	25	25	150	30	25.0	M6	G1/8"	5	SC.. 1204..	02500

Spare parts for article number

	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 776 01200	87900			86700	
70 776 01600	87900	167	88000	86700	171
70 776 02000	87900	167	88000	86700	171
70 776 11600	820	168	88000	86700	170
70 776 12000	820	168	88000	86700	170
70 776 02500	820	168	88000	86700	170

Spare parts for article number

	AS 70 950 ...	AS 80 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 776 01200		120			
70 776 01600	87600	120	88100	87700	294
70 776 02000	87600	120	88100	87700	294
70 776 11600	87600	120	88100	87700	294
70 776 12000	87600	120	88100	87700	294
70 776 02500	87600	120	88100	87700	294



AS 70 950 ... AS 70 950 ... AS 70 950 ... AS 70 950 ... AS 70 950 ...

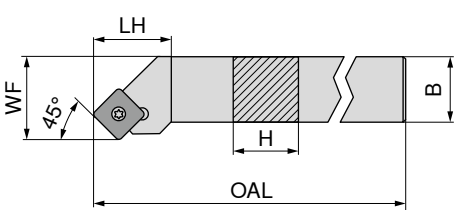


AS 70 950 ... AS 80 950 ... AS 70 950 ... AS 70 950 ... AS 70 950 ...

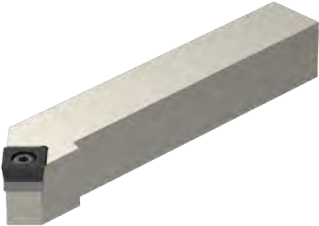
CoreLine – SSSC 45° – Tool holder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
SSSC R/L 1212 F09	12	12	86.40	18	16	3,2	SC.. 09T3..
SSSC R/L 1616 H09	16	16	106.40	20	20	3,2	SC.. 09T3..
SSSC R/L 2020 K09	20	20	131.40	20	25	3,2	SC.. 09T3..
SSSC R/L 1616 H12	16	16	108.63	25	20	5	SC.. 1204..
SSSC R/L 2020 K12	20	20	133.63	25	25	5	SC.. 1204..
SSSC R/L 2525 M12	25	25	158.63	25	32	5	SC.. 1204..
SSSC R 3225 P12	32	25	178.63	25	32	5	SC.. 1204..

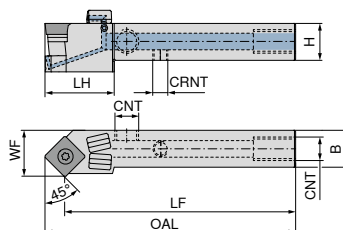
Left	Right
TO	TO
70 654 ...	70 654 ...
01200	01201
01600	01601
02000	02001
11600	11601
12000	12001
12500	12501
	13201

Spare parts
for article number

70 654 01201 / 70 654 01200	120	87900		171
70 654 01601 / 70 654 01600	120	87900	167	171
70 654 02001 / 70 654 02000	120	87900	167	171
70 654 11601 / 70 654 11600	120	820	168	170
70 654 12001 / 70 654 12000	120	820	168	170
70 654 12501 / 70 654 12500	120	820	168	170
70 654 13201	120	820	168	170

Screwdriver	Clamping screw	Carbide seat S	Threaded bush
AS	AS	AS	AS
80 950 ...	70 950 ...	70 950 ...	70 950 ...
120	87900		
120	87900	167	171
120	87900	167	171
120	820	168	170
120	820	168	170
120	820	168	170
120	820	168	170

Tool holder with blind plug and Torx key



Illustrations show right-hand versions



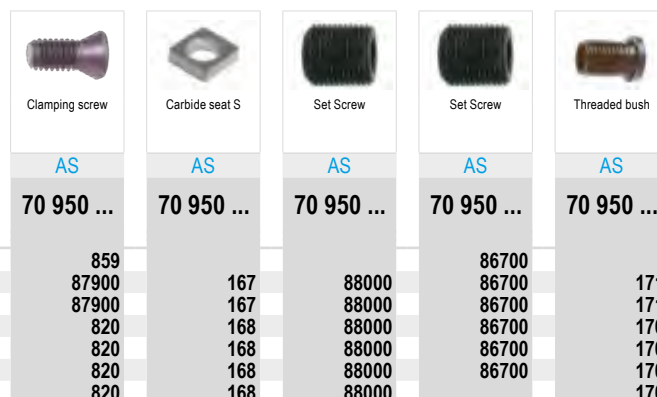
Left

Right

TO	TO
70 777 ...	70 777 ...
01201	01200
01601	01600
02001	02000
11601	11600
12001	12000
02501	02500
03201	

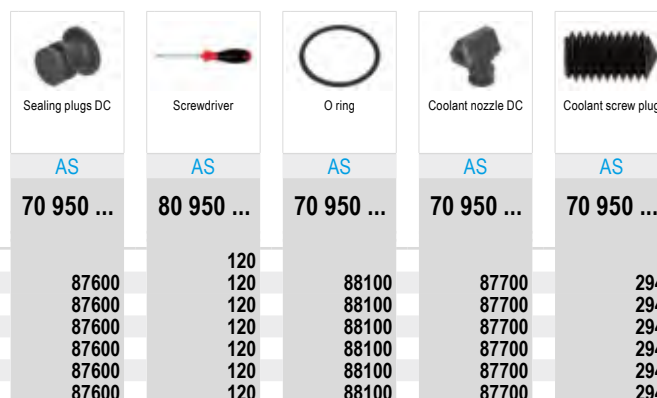
for article number

70 777 01200 / 70 777 01201
70 777 01600 / 70 777 01601
70 777 02000 / 70 777 02001
70 777 11600 / 70 777 11601
70 777 12000 / 70 777 12001
70 777 02500 / 70 777 02501
70 777 03201



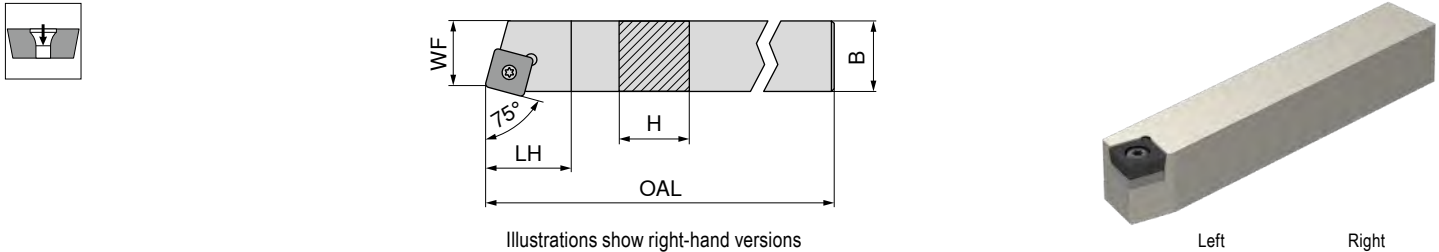
for article number

70 777 01200 / 70 777 01201
70 777 01600 / 70 777 01601
70 777 02000 / 70 777 02001
70 777 11600 / 70 777 11601
70 777 12000 / 70 777 12001
70 777 02500 / 70 777 02501
70 777 03201



CoreLine – SSBC 75° – Tool holder with screw clamping

Scope of supply:
Tool holder with blind plug and Torx key



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
SSBC R/L 2020 K12	20	20	125	20	17	5	SC.. 1204..
SSBC R/L 2525 M12	25	25	150	20	22	5	SC.. 1204..

Left	Right
TO	TO
70 650 ...	70 650 ...
12000	12001
12500	12501

Spare parts
for article number

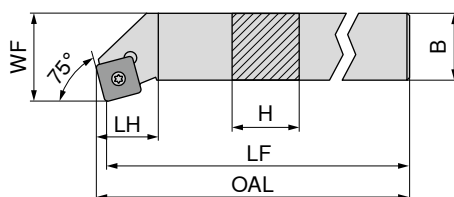
70 650 12001 / 70 650 12000
70 650 12501 / 70 650 12500

			
Screwdriver	Clamping screw	Carbide seat S	Threaded bush
AS	AS	AS	AS
80 950 ...	70 950 ...	70 950 ...	70 950 ...
120	820	168	170
120	820	168	170

CoreLine – SSKC 75° – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions



Left

Right

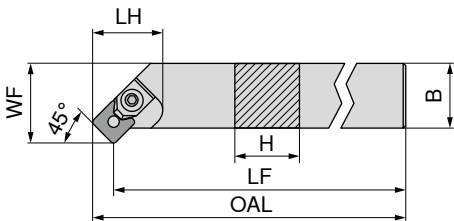
Designation	H mm	B mm	LF mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	TO 70 669 ...	TO 70 668 ...
SSKC R/L 1616 H09	16	16	100	102.3	22	20	3,2	SC.. 09T3..	016	016
SSKC R/L 2020 K09	20	20	125	127.3	22	25	3,2	SC.. 09T3..	020	020
SSKC R 2020 K12	20	20	125	127.3	23	25	5	SC.. 1204..		120
SSKC R 2525 M12	25	25	150	153.3	23	32	5	SC.. 1204..		125

Spare parts for article number

	AS 80 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 668 016 / 70 669 016	113	398	113	167	171
70 668 020 / 70 669 020	113	398	113	167	171
70 668 120	113	398	114	168	170
70 668 125	113	398	114	168	170

Screwdriver	Combi key	Clamping screw	Carbide seat S	Threaded bush
AS 80 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
113	398	113	167	171
113	398	113	167	171
113	398	114	168	170
113	398	114	168	170

CoreLine – MSSC 45° – Tool holder with top clamping



Illustrations show right-hand versions



Designation	H mm	B mm	LF mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
MSSC R/L 2020 K12	20	20	125	133.65	32	25	5	SCMX 1204
MSSC R/L 2525 M12	25	25	150	158.65	28	32	5	SCMX 1204
MSSC R/L 3225 P12	32	25	170	178.65	28	32	5	SCMX 1204

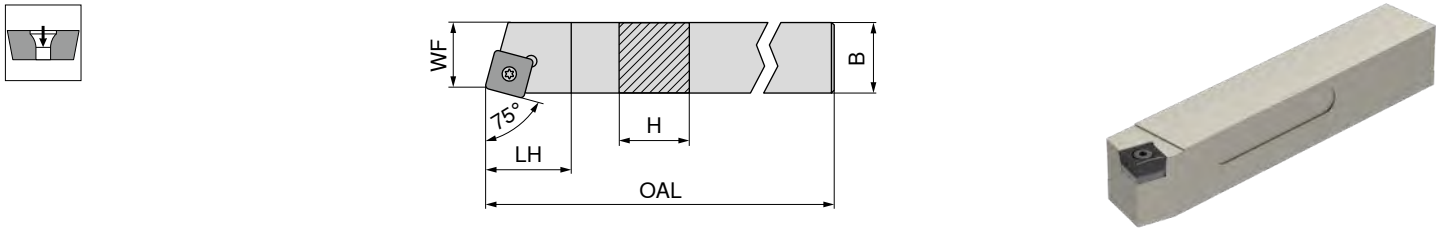
Left	Right
TO	TO
70 589 ...	70 588 ...
020	020
025	025
032	032

Spare parts
for article number

70 588 020 / 70 589 020
70 588 025 / 70 589 025
70 588 032 / 70 589 032

Screwdriver	Dowel	Clamping element	Wedge	Carbide seat S
AS	AS	AS	AS	AS
80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
114	153	159	150	140
114	153	159	150	140
114	153	159	150	140

CoreLine – SSBC 75° – Tool holder with screw clamping

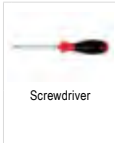


Illustrations show right-hand versions

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	TO	
								Left	Right
SSBC R/L 1616 H09	16	16	100	20	13	3,2	SC.. 09T3..	70 665 ...	70 664 ...
								016	016
SSBC R 2020 K09	20	20	125	20	17	3,2	SC.. 09T3..		020
SSBC R/L 4040 S25	40	40	250	40	35	8	SC.. 2509..	04000	04000
SSBC R/L 5050 T38	50	50	300	53	43	8	SC.. 3809..	05000	05000

Spare parts
for article number

	AS	AS	AS	AS	AS	AS
70 664 016 / 70 665 016	113	398	113		167	171
70 664 020	113	398	113		167	171
70 664 04000 / 70 665 04000			74900	77100		
70 664 05000 / 70 665 05000			74900	75300		



Screwdriver

AS

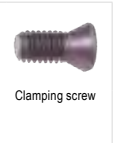
80 950 ...



Combi key

AS

70 950 ...



Clamping screw

AS

70 950 ...



Carbide shim

AS

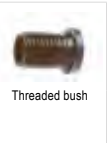
70 950 ...



Carbide seat S

AS

70 950 ...



Threaded bush

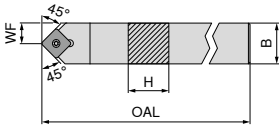
AS

70 950 ...

CoreLine – SSDC 45° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Neutral

ANSI designation	H inch	B inch	OAL inch	WF inch	Indexable insert
SSDC N 10-3	0.625	0.625	4.000	0.325	SC..32.5..
SSDC N 08-3	0.500	0.500	3.500	0.263	SC..32.5..
SSDC N 12-4B	0.750	0.750	4.500	0.388	SC..43..

TO
78 584 ...
01003 ¹⁾
00803 ¹⁾
01224 ¹⁾

1) Not in stock

Spare parts

78 584 01224
78 584 00803 / 78 584 01003

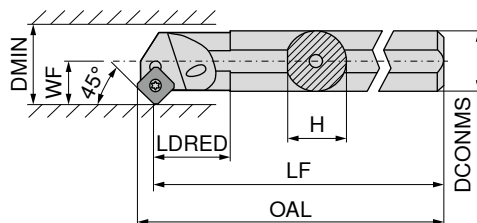
 Clamping screw	 Carbide seat S	 Threaded bush	 Key 1 - TORX®
AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...
04600 05600	04400	04800	04700 05700

CoreLine – SSSC 45° – Boring bar with screw clamping

- ▲ A... = with coolant hole
 ▲ S... = without coolant hole

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Designation	DCONMS mm	H mm	LF mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	Left	Right
										TO 70 721 ...	TO 70 720 ...
S16R SSSC R 09	16	15.00	200	206.0	13.97	11	20	3,2	SC.. 09T3..		016
A16M SSSC R/L 09	16	15.25	150	156.0	29.00	11	20	3,2	SC.. 09T3..	216	216
A20Q SSSC R/L 09	20	19.00	180	186.0	32.00	13	25	3,2	SC.. 09T3..	220	220
A25R SSSC R/L 09	25	24.50	200	206.0	36.00	17	32	3,2	SC.. 09T3..	225	225
A32S SSSC R/L 12	32	31.00	250	258.3	50.00	22	40	5	SC.. 1204..	232	232
A40T SSSC R/L 12	40	39.00	300	308.1	60.00	27	50	5	SC.. 1204..	240	240

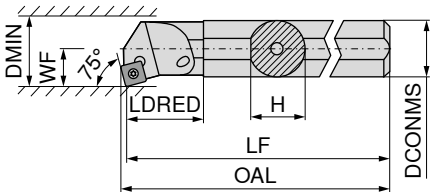
Spare parts for article number

	Screwdriver	Combi key	Clamping screw	Carbide seat S	Threaded bush
70 720 016	AS	AS	AS	AS	AS
70 720 216 / 70 721 216	80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 720 220 / 70 721 220	113		110		
70 720 225 / 70 721 225	113		110		
70 720 232 / 70 721 232	113		304		
70 720 240 / 70 721 240		398	114	168	170
		398	114	168	170

CoreLine – SSKC 75° – Boring bar with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

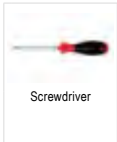


Designation	DCONMS mm	H mm	LF mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert
A16M SSKC R/L 09	16	15.0	150	152.4	29	11	20	3,2	SC.. 09T3..
A20Q SSKC R/L 09	20	18.5	180	182.4	32	13	25	3,2	SC.. 09T3..
A25R SSKC R/L 09	25	23.0	200	202.4	36	17	32	3,2	SC.. 09T3..

Left	Right
TO	TO
70 725 ...	70 724 ...
216	216
220	220
225	225

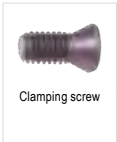
Spare parts
for article number

70 724 216 / 70 725 216
70 724 220 / 70 725 220
70 724 225 / 70 725 225



Screwdriver

AS
80 950 ...



Clamping screw

AS
70 950 ...

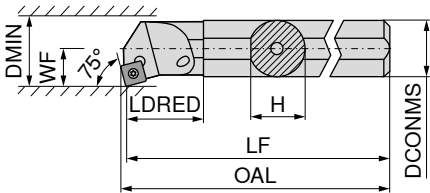
T15	113	M3,5x7,2	110
T15	113	M3,5x8,6	304
T15	113	M3,5x8,6	304

CoreLine – SSKC 75° – Boring bar with screw clamping

- ▲ A... = with thru coolant
- ▲ S... = without thru coolant

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



ANSI designation	DCONMS inch	H inch	OAL inch	LDRED inch	WF inch	DMIN inch	Indexable insert
S10R SSKC R/L 3	0.625	0.580	8.000	1.060	0.406	0.812	SC..32.5..
S12S SSKC R/L 3	0.750	0.710	10.000	1.580	0.500	1.000	SC..32.5..
S16T SSKC R/L 3	1.000	0.900	12.000	1.810	0.640	1.280	SC..32.5..

Left	Right
TO	TO
78 723 ...	78 722 ...
31021 ¹⁾	31021 ¹⁾
31222 ¹⁾	31222 ¹⁾
31626 ¹⁾	31626 ¹⁾

1) Not in stock

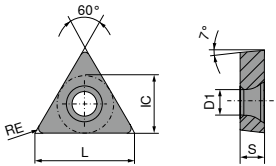
Spare parts

78 722 31021 / 78 723 31021
78 722 31222 / 78 723 31626

	
Clamping screw	Key 1 - TORX®
AS	AS
78 950 ...	78 950 ...
05800	05700
05600	05700

TCGT / TCMT

Designation	L	S	D1	IC
	mm	mm	mm	mm
TCMT 0902..	9.6	2.38	2.50	5.56
TC.T 1102..	11.0	2.38	2.80	6.35
TC.T 16T3..	16.5	3.97	4.40	9.52
TCMT 2204..	22.0	4.76	5.16	12.70



CoreLine – Carbide turning indexable insert

TCGT / TCMT

		-CF05 CTEP110-P	-CF55 CTEP110-P	-SF TCM10	-SMF TCM10	-SF CTCP115-P	-SF CTCP125-P	-SF CTCP135-P
		DRAGONSKIN	DRAGONSKIN			DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F	F	F	F	F	F	F
		CERMET	CERMET	CERMET	CERMET			
		TCGT	TCMT	TCGT	TCMT	TCGT	TCGT	TCGT
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	76 272 ...	76 266 ...	70 273 ...	70 284 ...	76 271 ...	76 271 ...	76 271 ...
110202EN	0.2	01401		900		31401		
110204EN	0.4	01601	01601	902	902		51401	
110208EN	0.8	01801						71401
16T304EN	0.4	02801		906				
16T308EN	0.8		03001					
P		●	●	●	●	●	●	●
M		○	○	○	○			○
K		○	○	○	○	○	○	
N								
S								
H								
O								

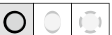
CoreLine – Carbide turning indexable insert

TCMT

		<div><div>-SF</div><div>CTCK110-P</div><div>DRAGONSKIN</div><div></div><div></div><div>F</div><div>TCMT</div></div>	<div><div>-SF</div><div>CTCP115-P</div><div>DRAGONSKIN</div><div></div><div></div><div>F</div><div>TCMT</div></div>	<div><div>-SF</div><div>CTCP125-P</div><div>DRAGONSKIN</div><div></div><div></div><div>F</div><div>TCMT</div></div>	<div><div>-SF</div><div>CTCP135-P</div><div>DRAGONSKIN</div><div></div><div></div><div>F</div><div>TCMT</div></div>	<div><div>-SMF</div><div>CTCP115-P</div><div>DRAGONSKIN</div><div></div><div></div><div>F</div><div>TCMT</div></div>	<div><div>-SMF</div><div>CTCP125-P</div><div>DRAGONSKIN</div><div></div><div></div><div>F</div><div>TCMT</div></div>	<div><div>-SMF</div><div>CTCP135-P</div><div>DRAGONSKIN</div><div></div><div></div><div>F</div><div>TCMT</div></div>
		TR	TR	TR	TR	TR	TR	TR
ISO	RE	70 311 ...	76 275 ...	76 275 ...	76 275 ...	76 284 ...	76 284 ...	76 284 ...
	mm							
110204EN	0.4	11601	31601	51601	71601			
110208EN	0.8	11801	31801	51801	71801	31801	51801	71801
16T304EN	0.4	12801	32801	52801	72801	32801	52801	72801
16T308EN	0.8	13001	33001	53001	73001	33001	53001	73001
P		○	●	●	●	●	●	●
M					○			○
K		●	○	○		○	○	
N								
S								
H								
O								

CoreLine – Carbide turning indexable insert

TCMT / TCGT

		<div><div><div><div>-SM</div><div>CTCK110-P</div><div>DRAGONSKIN</div><div></div><div>M</div><div>TCMT</div></div><div><div>-SM</div><div>CTCK120-P</div><div>DRAGONSKIN</div><div></div><div>M</div><div>TCMT</div></div><div><div>-SM</div><div>CTCP115-P</div><div>DRAGONSKIN</div><div></div><div>M</div><div>TCGT</div></div><div><div>-SM</div><div>CTCP125-P</div><div>DRAGONSKIN</div><div></div><div>M</div><div>TCGT</div></div><div><div>-SM</div><div>CTCP135-P</div><div>DRAGONSKIN</div><div></div><div>M</div><div>TCGT</div></div><div><div>-SM</div><div>CTCP115-P</div><div>DRAGONSKIN</div><div></div><div>M</div><div>TCMT</div></div><div><div>-SM</div><div>CTCP115-P</div><div>DRAGONSKIN</div><div></div><div>M</div><div>TCMT</div></div></div></div>						
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	70 274 ...	70 274 ...	76 270 ...	76 270 ...	76 270 ...	76 189 ...	76 274 ...
090204EN	0.4							30201
110202EN	0.2			31401	51401	71401		
110204EN	0.4	11601	51601					31601
110208EN	0.8	11801	51801					31801
16T304EN	0.4	12801	52801					32801
16T308EN	0.8	13001	53001					33001
16T312EN	1.2	13201	53201					33201
220408EN	0.8	14201	54201				34201	
P		○	○	●	●	●	●	●
M						○		
K		●	●	○	○		○	○
N								
S								
H								
O								

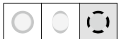
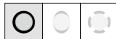
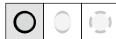
CoreLine – Carbide turning indexable insert

TCMT

		<div><div>-SM</div><div>CTCP125-P</div></div>		<div><div>-SM</div><div>CTCP135-P</div></div>		<div><div>-F43</div><div>CTCM130</div></div>		<div><div>-M25</div><div>CTCM120</div></div>		<div><div>-M25</div><div>CTPM125</div></div>		<div><div>-M25</div><div>CTCM130</div></div>		<div><div>-M55</div><div>CTCM120</div></div>	
		<div>DRAGONSkin</div>		<div>DRAGONSkin</div>		<div>DRAGONSkin</div>		<div>DRAGONSkin</div>		<div>DRAGONSkin</div>		<div>DRAGONSkin</div>		<div>DRAGONSkin</div>	
		<div><div>M</div><div>TCMT</div></div>		<div><div>M</div><div>TCMT</div></div>		<div><div>F</div><div>TCMT</div></div>		<div><div>F</div><div>TCMT</div></div>		<div><div>F</div><div>TCMT</div></div>		<div><div>F</div><div>TCMT</div></div>		<div><div>F</div><div>TCMT</div></div>	
		<div>TR</div>		<div>TR</div>		<div>TR</div>		<div>TR</div>		<div>TR</div>		<div>TR</div>		<div>TR</div>	
ISO	RE mm	76 274 ...		76 274 ...		75 033 ...		75 217 ...		75 217 ...		75 217 ...		75 218 ...	
090204EN	0.4	50401		70401						20400				10400	
110204EN	0.4	51601		71601		31600		11600		216		31600		11600	
110208EN	0.8	51801		71801											
16T304EN	0.4	52801		72801		32800		12800		228		32800			
16T308EN	0.8	53001		73001		33000		13000		230		33000		13000	
16T312EN	1.2	53201		73201											
220408EN	0.8	54201		74201											
P		●		●		○		○		○		○		○	
M				○		●		●		●		●		●	
K		○													
N															
S						○						○			
H															
O															

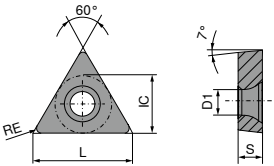
CoreLine – Carbide turning indexable insert

TCMT / TCGT

		<div><div>-M55</div><div>CTPM125</div></div>	<div><div>-M55</div><div>CTCM130</div></div>	<div><div>-SM</div><div>CTPM125</div></div>	<div><div>-M25</div><div>CTPX710</div></div>	<div><div>-M55</div><div>CTPX710</div></div>	<div><div>-27</div><div>H10T</div></div>	<div><div>-27</div><div>CTPX715</div></div>
		<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>		<div>DRAGONSKIN</div>
								
								
		<div>M</div> <div>TCMT</div>	<div>M</div> <div>TCMT</div>	<div>M</div> <div>TCMT</div>	<div>M</div> <div>TCMT</div>	<div>M</div> <div>TCMT</div>	<div>M</div> <div>TCGT</div>	<div>M</div> <div>TCGT</div>
		<div>TR</div>	<div>TR</div>	<div>TR</div>	<div>TR</div>	<div>TR</div>	<div>TR</div>	<div>TR</div>
ISO	RE mm	75 218 ... 204	75 218 ... 30400	75 050 ... 20400	75 217 ...	75 218 ...	70 276 ...	70 276 ...
090204EN	0.4							
110202FN	0.2						600	71400
110204EN	0.4	216	31600	21600	61600	61600		
110204FN	0.4						602	81600
16T302FN	0.2						604	72600
16T304EN	0.4			22800	62800			
16T304FN	0.4						606	72800
16T308EN	0.8	230	33000	23000	63000	63000		
16T308FN	0.8						608	83000
220408EN	0.8			24200				
220412EN	1.2			24400				
P		○	○	○	●	●		●
M		●	●	●	●	●		●
K							○	○
N					○	○	●	●
S			○		●	●		●
H								
O							○	○

TCMX

Designation	L	S	D1	IC
	mm	mm	mm	mm
TCMX 1604..	16.5	4.76	3.81	9.52



CoreLine – Carbide turning indexable insert

TCMX

CTCP135-P

DRAGONSKIN



M
TCMX

ISO	RE mm
160404EN	0.4
160408EN	0.8

TR

76 191 ...

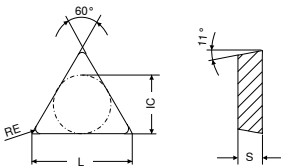
72801

73001

P	●
M	○
K	
N	
S	
H	
O	

TPMR / TPUN

Designation	L	S	IC
	mm	mm	mm
TPMR 1103..	11.0	3.18	6.35
TPMR 1603..	16.5	3.18	9.52
TPUN 2204..	22.0	4.76	12.70



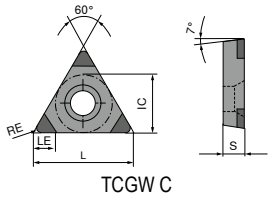
CoreLine – Carbide turning indexable insert

TPMR / TPUN

		<div>CTCP135-P</div> <div>DRAGONSKIN</div> <div></div> <div></div> <div>M</div> <div>TPMR</div>	<div>CTCP125-P</div> <div>DRAGONSKIN</div> <div></div> <div></div> <div>M</div> <div>TPMR</div>	<div>CTCP135-P</div> <div>DRAGONSKIN</div> <div></div> <div></div> <div>M</div> <div>TPMR</div>	<div>CTCP135-P</div> <div>DRAGONSKIN</div> <div></div> <div></div> <div>M</div> <div>TPUN</div>
		TR	TR	TR	TR
		76 232 ...	76 192 ...	76 228 ...	76 212 ...
			50201	70201	
		71401	50601	70601	72001
		71201			
		71801	50801	70801	
		71601			
					74201
					74401
P		●	●	●	●
M		○		○	○
K			○		
N					
S					
H					
O					

TCGW

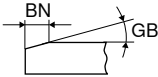
Designation	L	S	D1	IC
	mm	mm	mm	mm
TCGW 1102..	11.0	2.38	2.8	6.35
TCGW 16T3..	16.5	3.97	4.4	9.52



CoreLine – PcBN turning indexable insert

TCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners



CTBH1000C	CTBH2000C	CTBH3000C
F	F	F
PCBN	PCBN	PCBN
TCGW	TCGW	TCGW
PC	PC	PC
71 034 ...	71 034 ...	71 034 ...
70002	80002	90002
70302	80302	90302
70602	80602	90602
70902	80902	90902

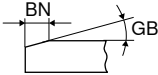
ISO	RE	BN	GB	TCE (NOI)	LE
	mm	mm			mm
110204EN	0.4			C (3)	3.6
110204SN	0.4	0.14	20°	C (3)	3.6
110208EN	0.8			C (3)	3.3
110208SN	0.8	0.14	20°	C (3)	3.3
16T304EN	0.4			C (3)	3.6
16T304SN	0.4	0.14	20°	C (3)	3.6
16T308EN	0.8			C (3)	3.3
16T308SN	0.8	0.14	20°	C (3)	3.3

P			
M			
K			
N			
S			
H			
O			

CoreLine – PcBN turning indexable insert

TCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners



ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
110204SN	0.4	0.09	15°	C (3)	3.6
110204SN	0.4	0.18	25°	C (3)	3.6
110208SN	0.8	0.09	15°	C (3)	3.3
110208SN	0.8	0.18	25°	C (3)	3.3
16T304SN	0.4	0.09	15°	C (3)	3.6
16T304SN	0.4	0.18	25°	C (3)	3.6
16T308SN	0.8	0.09	15°	C (3)	3.3
16T308SN	0.8	0.18	25°	C (3)	3.3

P			
M			
K			
N			
S			
H			
O			

CTBH1000C

M

PCBN

TCGW

CTBH2000C

M

PCBN

TCGW

CTBH3000C

M

PCBN

TCGW

PC

71 034 ...

70102

70402

70702

71002

PC

71 034 ...

80102

80402

80702

81002

PC

71 034 ...

90102

90402

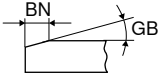
90702

91002

CoreLine – PcBN turning indexable insert

TCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners



ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
110204SN	0.4	0.14	20°	C (3)	3.6
110204SN	0.4	0.20	35°	C (3)	3.6
110208SN	0.8	0.14	20°	C (3)	3.3
110208SN	0.8	0.20	35°	C (3)	3.3
16T304SN	0.4	0.14	20°	C (3)	3.6
16T304SN	0.4	0.20	35°	C (3)	3.6
16T308SN	0.8	0.14	20°	C (3)	3.3
16T308SN	0.8	0.20	35°	C (3)	3.3

P			
M			
K			
N			
S			
H			
O			

CTBH1000C

R

PCBN

TCGW

CTBH2000C

R

PCBN

TCGW

CTBH3000C

R

PCBN

TCGW

PC

71 034 ...

70202

70502

70802

71102

PC

71 034 ...

80202

80502

80802

81102

PC

71 034 ...

90202

90502

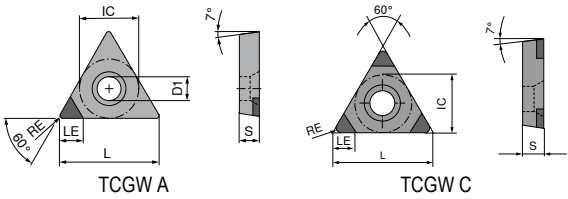
90802

91102



TCGW

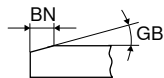
Designation	L	S	D1	IC
	mm	mm	mm	mm
TCGW 0902..	9.6	2.38	2.5	5.56
TCGW 1102..	11.0	2.38	2.8	6.35
TCGW 16T3..	16.5	3.97	4.4	9.52



CoreLine – PcBN turning indexable insert

TCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners



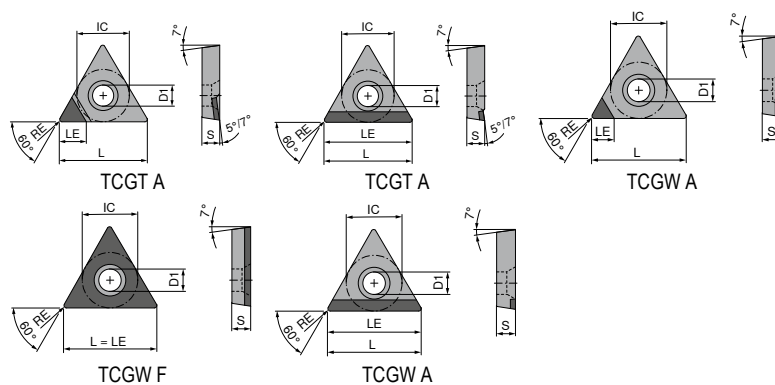
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
090202SN	0.2	0.11	15°	C (3)	2.6
090202TN	0.2	0.12	20°	A (1)	3.8
090204SN	0.4	0.09	10°	C (3)	2.2
090204SN	0.4	0.11	15°	C (3)	2.2
090204TN	0.4	0.12	15°	A (1)	3.5
090204TN	0.4	0.12	20°	A (1)	3.5
090204TN	0.4	0.17	25°	C (3)	2.2
090204FN	0.4			A (1)	3.5
110202SN	0.2	0.11	15°	C (3)	2.9
110202FN	0.2			A (1)	3.8
110202TN	0.2	0.12	20°	A (1)	3.8
110204SN	0.4	0.09	10°	C (3)	2.5
110204SN	0.4	0.11	15°	C (3)	2.5
110204TN	0.4	0.12	20°	A (1)	3.5
110204TN	0.4	0.15	20°	C (3)	2.5
110204SN	0.4	0.16	20°	C (3)	2.5
110204TN	0.4	0.17	25°	C (3)	2.5
110204EN	0.4			C (3)	2.5
110204FN	0.4			A (1)	3.5
110208SN	0.8	0.09	10°	C (3)	2.1
110208TN	0.8	0.12	20°	A (1)	3.0
110208TN	0.8	0.15	20°	C (3)	2.1
110208TN	0.8	0.17	25°	C (3)	2.1
110208FN	0.8			A (1)	3.0
16T304SN	0.4	0.09	10°	C (3)	3.2
16T304SN	0.4	0.11	15°	C (3)	3.2
16T308SN	0.8	0.09	10°	C (3)	2.7
16T308SN	0.8	0.11	15°	C (3)	2.7
16T308SN	0.8	0.16	20°	C (3)	2.7
16T308EN	0.8			C (3)	2.7
16T308TN	0.8	0.17	25°	C (3)	2.7

CTBS10U	CTBS20U	CTBS20C
F CBN TCGW	F CBN TCGW	F CBN TCGW
PC 71 140 ...	PC 71 427 ...	PC 71 164 ...
300		130
		121
	20000	131
302		
202		161
		133
206		
306		124
		134
308		144
		154
		164
		114
208		
		125
310		145
		165
210		
		126
		136
		127
		137
		157
		117
		167

P			
M			
K	•	•	•
N			
S	•	•	•
H			
O			

TCGW / TCGT

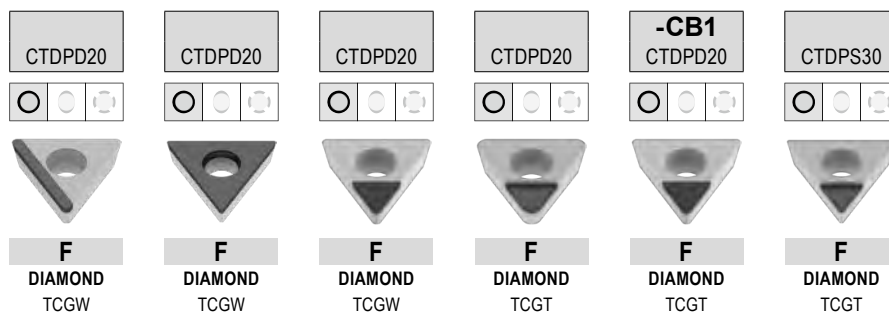
Designation	L	S	D1	IC
	mm	mm	mm	mm
TCGW 0902..	8.46	2.38	2.5	5.56
TCGT 0902..	9.04	2.38	2.5	5.56
TCG. 0902..	9.60	2.38	2.5	5.56
TCG. 1102..	9.83	2.38	2.8	6.35
TCG. 1102..	10.41	2.38	2.8	6.35
TCGW 1102..	10.71	2.38	2.8	6.35
TCG. 1102..	11.00	2.38	2.8	6.35
TCG. 16T3..	15.32	3.97	4.4	9.52
TCG. 16T3..	15.90	3.97	4.4	9.52
TCG. 16T3..	16.50	3.97	4.4	9.52



CoreLine – PCD turning indexable insert

TCGW / TCGT

▲ TCE(NOI) = Design and number of equipped cutting edge corners



ISO	RE mm	TCE (NOI)	LE mm
090202FN	0.2	A (1)	3.70
090204FN	0.4	A (1)	3.40
090208FN	0.8	A (1)	3.00
090208FN	0.8	A (1)	8.46
110202FN	0.2	A (1)	3.70
110202FN	0.2	F	10.71
110204FN	0.4	A (1)	3.40
110204FN	0.4	F	10.41
110204FN	0.4	A (1)	10.41
110208FN	0.8	A (1)	3.00
110208FN	0.8	A (1)	9.83
16T304FN	0.4	A (1)	4.60
16T304FN	0.4	A (1)	15.90
16T308FN	0.8	A (1)	4.20
16T308FN	0.8	A (1)	15.32
16T312FN	1.2	A (1)	3.80

PC	PC	PC	PC	PC	PC
71 188 ...	71 187 ...	71 140 ...	71 184 ...	71 325 ...	71 184 ...
		100		112	20001
		102		114	20101
		104	10001		
10001					
		106	10101	122	
	10001				
		108	10201	124	20201
	10101				
		110	10301		
10201					
		112	10401	134	20301
10301					
		114	10501	13600	
10401					
		11600			

P					
M					
K					
N	•	•	•	•	•
S					
H					
O	•	•	•	•	•

CoreLine – PCD turning indexable insert

TCGW / TCGT

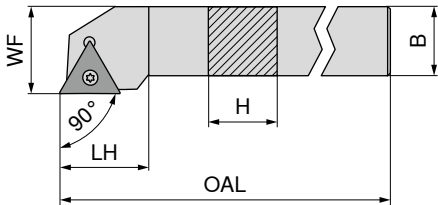
▲ TCE(NOI) = Design and number of equipped cutting edge corners

				CTDPS30	CTDPS30	-CB2 CTDPS30	CTDPU20	-CB3 CTDPU20	CTDCD10
				F DIAMOND TCGW	F DIAMOND TCGT	M DIAMOND TCGT	F DIAMOND TCGW	R DIAMOND TCGT	F DIAMOND TCGW
				PC	PC	PC	PC	PC	PC
ISO	RE mm	TCE (NOI)	LE mm	71 186 ...	71 185 ...	71 326 ...	71 188 ...	71 327 ...	71 186 ...
090202FN	0.2	A (1)	3.70	20001	20001	212	30001	224	40001
090204FN	0.4	A (1)	3.40			214			
090204FN	0.4	A (1)	9.04						
110202FN	0.2	A (1)	2.60	20101	20101	222	30001	224	40101
110202FN	0.2	A (1)	3.70						
110204FN	0.4	A (1)	2.30			224			
110204FN	0.4	A (1)	3.40	20201	20101	234	30001	224	40201
110204FN	0.4	A (1)	10.41						
110208FN	0.8	A (1)	2.00						
110208FN	0.8	A (1)	9.83	20301	20201	234	30001	238	40301
16T304FN	0.4	A (1)	2.30						
16T304FN	0.4	A (1)	4.60						
16T304FN	0.4	A (1)	15.90	20401	20301	234	30001	238	40401
16T308FN	0.8	A (1)	2.00						
16T308FN	0.8	A (1)	4.20						
16T308FN	0.8	A (1)	15.32	20401	20401	234	30001	238	40401
16T308FN	0.8	A (1)	15.32						
16T308FN	0.8	A (1)	15.32						
P									
M									
K									
N									
S									
H									
O									

CoreLine – STGC 90° – Tool holder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
STGC R/L 1212 F11	12	12	80	15	16	1,2	TC.. 1102
STGC R/L 1616 H16	16	16	100	22	20	3,2	TC.. 16T3
STGC R/L 2020 K16	20	20	125	22	25	3,2	TC.. 16T3
STGC R/L 2525 M16	25	25	150	22	32	3,2	TC.. 16T3

Left	Right
TO	TO
70 659 ...	70 659 ...
01200	01201
01600	01601
02000	02001
02500	02501

Spare parts
for article number

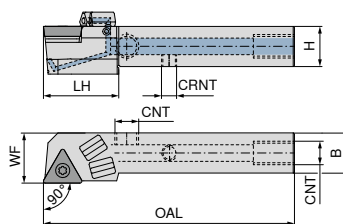
70 659 01201 / 70 659 01200
70 659 01601 / 70 659 01600
70 659 02001 / 70 659 02000
70 659 02501 / 70 659 02500

Screwdriver	Clamping screw	Carbide seat T	Threaded bush
AS	AS	AS	AS
80 950 ...	70 950 ...	70 950 ...	70 950 ...
039	857		
120	87900	169	171
120	87900	169	171
120	87900	169	171

CoreLine – STGC 90° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions



Left

Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Tightening torque Nm	Indexable insert	TO 70 778 ...	TO 70 778 ...
STGC R/L 1212 F11 DC	12	12	80	17.1	16	M6	M6	1,2	TC.. 1102	01201	01200
STGC R/L 1616 H16 DC	16	16	100	30.0	20	M6	G1/8"	3,2	TC.. 16T3	01601	01600
STGC R/L 2020 K16 DC	20	20	125	28.0	25	M6	G1/8"	3,2	TC.. 16T3	02001	02000
STGC R/L 2525 M16 DC	25	25	150	30.0	32	M6	G1/8"	3,2	TC.. 16T3	02501	02500

Spare parts for article number

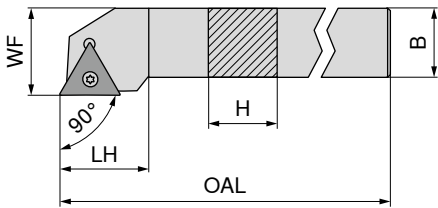
	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 778 01200 / 70 778 01201	857			86700	
70 778 01600 / 70 778 01601	87900	169	88000	86700	171
70 778 02000 / 70 778 02001	87900	169	88000	86700	171
70 778 02500 / 70 778 02501	87900	169	88000	86700	171

Spare parts for article number

	AS 70 950 ...	AS 80 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 778 01200 / 70 778 01201		039			
70 778 01600 / 70 778 01601	87600	120	88100	87700	294
70 778 02000 / 70 778 02001	87600	120	88100	87700	294
70 778 02500 / 70 778 02501	87600	120	88100	87700	294

				
Clamping screw	Carbide seat T	Set Screw	Set Screw	Threaded bush
AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
				
Sealing plugs DC	Screwdriver	O ring	Coolant nozzle DC	Coolant screw plug
AS 70 950 ...	AS 80 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...

CoreLine – STGC 90° – Tool holder with screw clamping



Illustrations show right-hand versions

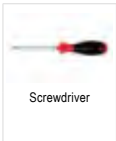


Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
STGC R/L 1010 E09	10	10	70	12	12	1	TC.. 0902

Left	Right
TO 70 677 ... 010	TO 70 676 ... 010

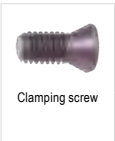
Spare parts
for article number

70 676 010 / 70 677 010



Screwdriver

AS 80 950 ... 109



Clamping screw

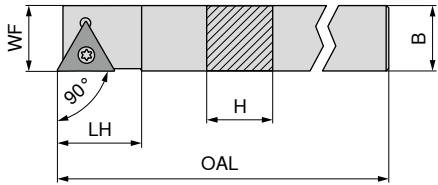
AS 70 950 ... 111

CoreLine – STAC 90° – Tool holder with screw clamping

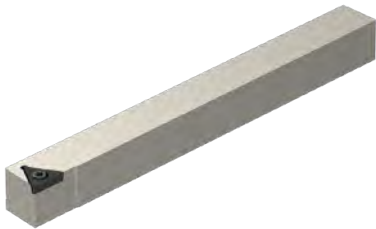
▲ For sliding head lathes

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

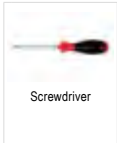


Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
STAC R/L 1212 K11	12	12	125	15	12	1,2	TC.. 1102

Left	Right
TO	TO
70 655 ...	70 655 ...
01200	01201

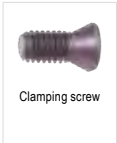
Spare parts
for article number

70 655 01201 / 70 655 01200



Screwdriver

AS
80 950 ...
T08 - IP
039

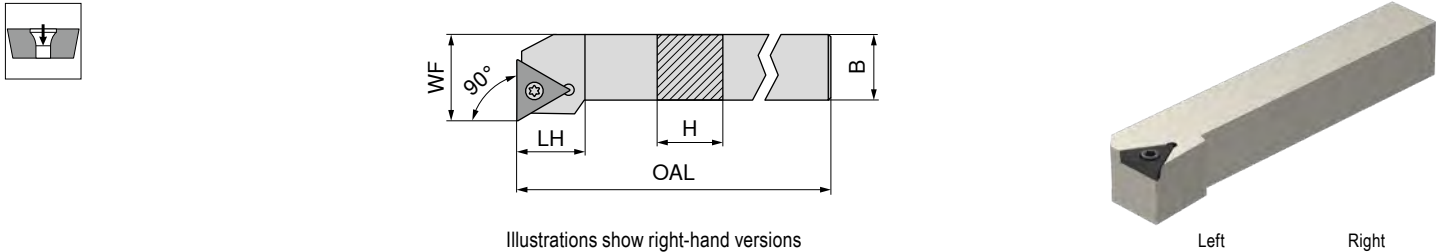


Clamping screw

AS
70 950 ...
M2,5x6 - 08IP
857

CoreLine – STFC 90° – Tool holder with screw clamping

Scope of supply:
Tool holder with Torx key



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert	Left	Right
								TO	TO
STFC R/L 1212 F11	12	12	80	15	16	1,2	TC.. 1102	70 658 ... 01200	70 658 ... 01201
STFC R/L 1616 H16	16	16	100	20	20	3,2	TC.. 16T3	01600	01601
STFC R/L 2020 K16	20	20	125	20	25	3,2	TC.. 16T3	02000	02001
STFC R/L 2525 M16	25	25	150	20	32	3,2	TC.. 16T3	02500	02501

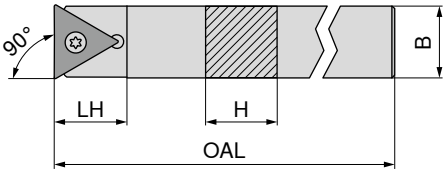
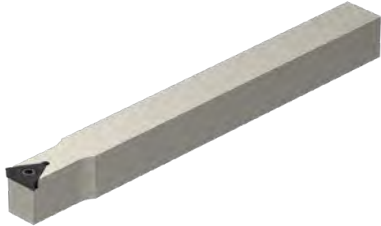
Spare parts
for article number

	Screwdriver	Clamping screw	Carbide seat T	Threaded bush
	AS	AS	AS	AS
70 658 01201 / 70 658 01200	80 950 ... 039	70 950 ... 857	70 950 ...	70 950 ...
70 658 01601 / 70 658 01600	120	87900	169	171
70 658 02001 / 70 658 02000	120	87900	169	171
70 658 02501 / 70 658 02500	120	87900	169	171

CoreLine – STCC 90° – Tool holder with screw clamping

Scope of supply:

Tool holder with Torx key

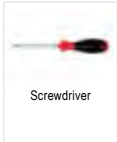


Designation	H mm	B mm	OAL mm	LH mm	Tightening torque Nm	Indexable insert
STCC N 0808 K09	8	8	125	11	1	TC.. 0902
STCC N 1010 K11	10	10	125	15	1,2	TC.. 1102
STCC N 1212 K11	12	12	125	15	1,2	TC.. 1102
STCC N 1414 K11	14	14	125	21	1,2	TC.. 1102
STCC N 1616 K11	16	16	125	24	1,2	TC.. 1102

Neutral
TO
70 657 ...
00800
01000
01200
01400
01600

Spare parts
for article number

70 657 00800	T07 - IP	117	M2,2x5 - 07IP	856
70 657 01000	T08 - IP	039	M2,5x6 - 08IP	857
70 657 01200	T08 - IP	039	M2,5x6 - 08IP	857
70 657 01400	T08 - IP	039	M2,5x6 - 08IP	857
70 657 01600	T08 - IP	039	M2,5x6 - 08IP	857



Screwdriver

AS

80 950 ...



Clamping screw

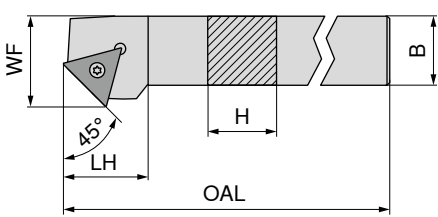
AS

70 950 ...

CoreLine – STDC 45° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Left Right

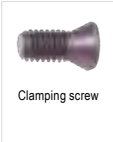
ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert
STDC R/L 06-2	0.375	0.375	2.500	0.410	0.433	TC..21.5..
STDC R/L 08-2	0.500	0.500	3.500	0.570	0.512	TC..21.5..
STDC R/L 10-3	0.625	0.625	4.000	1.000	0.669	TC..32.5..
STDC R/L 12-3B	0.750	0.750	4.500	1.000	0.866	TC..32.5..
STDC R/L 16-3D	1.000	1.000	6.000	1.000	1.063	TC..32.5..

TO	TO
78 561 ...	78 560 ...
00602 ¹⁾	00602 ¹⁾
00802 ¹⁾	00802 ¹⁾
01003 ¹⁾	01003 ¹⁾
01223 ¹⁾	01223 ¹⁾
01643 ¹⁾	01643 ¹⁾

1) Not in stock

Spare parts

78 560 01003 / 78 561 01643	05100	06100	05300	05400
78 560 00602 / 78 561 00802	06200			06400



Clamping screw

AS

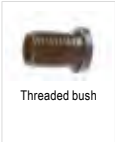
78 950 ...



Carbide seat T

AS

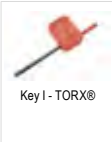
78 950 ...



Threaded bush

AS

78 950 ...



Key I - TORX®

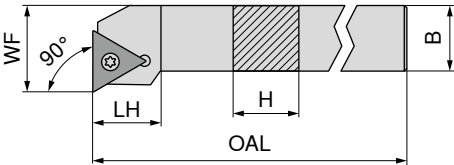
AS

78 950 ...

CoreLine – STFC 90° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



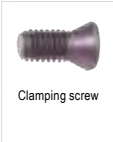
ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert
STFC R/L 06-2	0.375	0.375	2.500	0.400	0.500	TC..21.5..
STFC R/L 08-2	0.500	0.500	3.500	0.689	0.625	TC..21.5..
STFC R/L 10-3	0.625	0.625	4.000	1.000	0.750	TC..32.5..
STFC R/L 12-3B	0.750	0.750	4.500	1.000	1.000	TC..32.5..
STFC R/L 16-3D	1.000	1.000	6.000	1.000	1.250	TC..32.5..

Left	Right
TO	TO
78 563 ...	78 562 ...
00602 ¹⁾	00602 ¹⁾
00802 ¹⁾	00802 ¹⁾
01003 ¹⁾	01003 ¹⁾
01223 ¹⁾	01223 ¹⁾
01643 ¹⁾	01643 ¹⁾

1) Not in stock

Spare parts

78 562 00602 / 78 563 00802	06200			06400
78 562 01643 / 78 563 01643	05100	06100	05300	05400



Clamping screw

AS

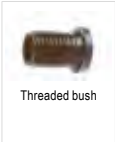
78 950 ...



Carbide seat T

AS

78 950 ...



Threaded bush

AS

78 950 ...



Key I - TORX®

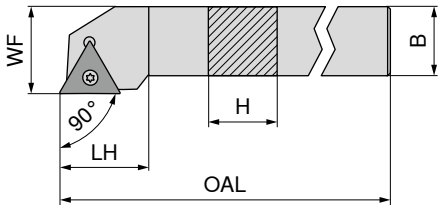
AS

78 950 ...

CoreLine – STGC 90° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



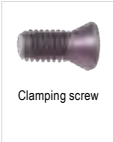
ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert
STGC R/L 06-2	0.375	0.375	2.500	0.500	0.500	TC..21.5..
STGC R/L 08-2	0.500	0.500	3.500	0.560	0.625	TC..21.5..
STGC R/L 10-3	0.625	0.625	4.000	1.000	0.750	TC..32.5..
STGC R/L 12-3B	0.750	0.750	4.500	1.000	1.000	TC..32.5..
STGC R/L 16-3D	1.000	1.000	6.000	1.000	1.250	TC..32.5..

Left	Right
TO	TO
78 565 ...	78 564 ...
00602 ¹⁾	00602 ¹⁾
00802 ¹⁾	00802 ¹⁾
01003 ¹⁾	01003 ¹⁾
01223 ¹⁾	01223 ¹⁾
01643 ¹⁾	01643 ¹⁾

1) Not in stock

Spare parts

78 564 00802 / 78 565 00802	06200			06400
78 564 01223 / 78 565 01223	05100	06100	05300	05400



Clamping screw

AS

78 950 ...



Carbide seat T

AS

78 950 ...



Threaded bush

AS

78 950 ...



Key I - TORX®

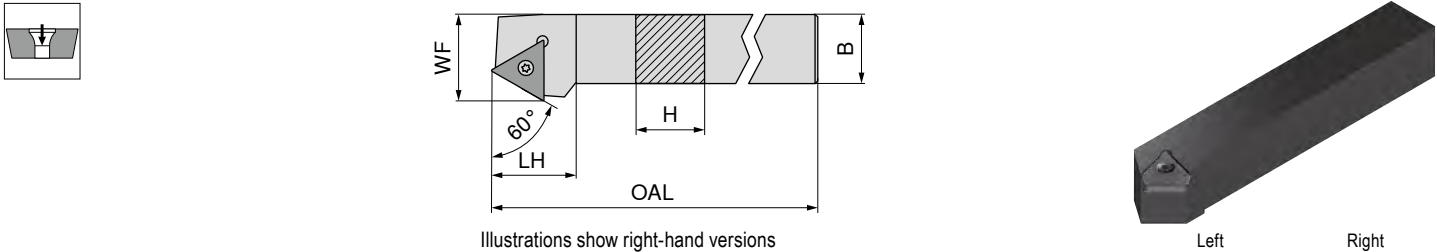
AS

78 950 ...

CoreLine – STTC 60° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	Left TO 78 567 ...	Right TO 78 566 ...
STTC R/L 12-3B	0.750	0.750	4.500	1.000	0.718	TC..32.5..	01223 ¹⁾	01223 ¹⁾
STTC R/L 16-3D	1.000	1.000	6.000	1.000	0.860	TC..32.5..	01643 ¹⁾	01643 ¹⁾

1) Not in stock

Spare parts

78 566 01223 / 78 567 01223

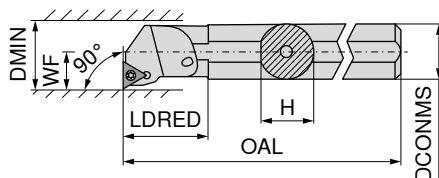
 Clamping screw	 Carbide seat T	 Threaded bush	 Key I - TORX®
AS 78 950 ... 05100	AS 78 950 ... 06100	AS 78 950 ... 05300	AS 78 950 ... 05400

CoreLine – STFC 90° – Boring bar with screw clamping

- ▲ A... = with coolant hole
▲ S... = without coolant hole

Scope of supply:

Boring bar with Torx key



Illustrations show right-hand versions



Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert
A10H STFC R/L 09	10	9.5	100	19	7	13	1	TC.. 0902
A12K STFC R/L 11	12	11.5	125	22	9	16	1,2	TC.. 1102
A16M STFC R/L 11	16	15.0	150	29	11	20	1,2	TC.. 1102
S16R STFC R 11	16	15.0	200	21	11	21	1,2	TC.. 1102
S20S STFC R 11	20	18.0	250	15	13	25	1,2	TC.. 1102
A20Q STFC R/L 11	20	18.5	180	32	13	25	1,2	TC.. 1102
A25R STFC R/L 16	25	24.0	200	36	17	32	3,2	TC.. 16T3
A32S STFC R/L 16	32	31.0	250	50	22	40	3,2	TC.. 16T3
A40T STFC R/L 16	40	39.0	300	60	27	50	3,2	TC.. 16T3

Left	Right
TO	TO
70 729 ...	70 728 ...
210	210
212	212
216	216
	016
	020
220	220
225	225
232	232
240	240

Spare parts for article number

	Clamping screw	Carbide seat T	Threaded bush
	AS	AS	AS
	70 950 ...	70 950 ...	70 950 ...
70 728 210 / 70 729 210	M2,2x5	111	
70 728 212 / 70 729 212	M2,5x6 - T08	13800	
70 728 216 / 70 729 216	M2,5x6 - T08	13800	
70 728 016	M2,5x6 - T08	13800	
70 728 020	M2,5x6 - T08	13800	
70 728 220 / 70 729 220	M2,5x6 - T08	13800	
70 728 225 / 70 729 225	M3,5x11	113	169
70 728 232 / 70 729 232	M3,5x11	113	169
70 728 240 / 70 729 240	M3,5x11	113	169

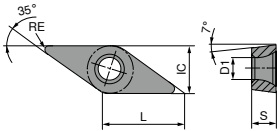
Spare parts for article number

	Screwdriver	Combi key
	AS	AS
	80 950 ...	70 950 ...
70 728 210 / 70 729 210	T07	109
70 728 212 / 70 729 212	T08	110
70 728 216 / 70 729 216	T08	110
70 728 016	T08	110
70 728 020	T08	110
70 728 220 / 70 729 220	T08	110
70 728 225 / 70 729 225		T15/SW
70 728 232 / 70 729 232		T15/SW
70 728 240 / 70 729 240		T15/SW

398
398
398

VCGT / VCMT / VCET

Designation	L	S	D1	IC
	mm	mm	mm	mm
VC.T 1103..	11.1	3.18	2.9	6.35
VC.T 1604..	16.6	4.76	4.4	9.52
VCGT 2205..	22.1	5.56	5.5	12.70



CoreLine – Carbide turning indexable insert

VCGT / VCMT

		-CF05 CTEP110-P	-CF55 CTEP110-P	-SF TCM407	-SF TCM10	-SMF TCM10	-SF CTCK110-P	-SF CTCP115-P
		DRAGONSKIN	DRAGONSKIN				DRAGONSKIN	DRAGONSKIN
		F CERMET VCGT	F CERMET VCMT	F CERMET VCGT	F CERMET VCGT	F CERMET VCMT	F CERMET VCGT	F CERMET VCGT
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	76 276 ...	76 292 ...	70 277 ...	70 277 ...	70 288 ...	70 329 ...	76 277 ...
110301EN	0.1	01201			892			
110302EN	0.2	01401		844	894		11401	31401
110304EN	0.4	01601	01601	846	896	896	11601	31601
110308EN	0.8						11801	31801
160402EN	0.2							32601
160404EN	0.4	02801	02801	850	900	900		
160408EN	0.8	03001	03001		902	902		
P		●	●	●	●	●	○	●
M		○	○	○	○	○		
K		○	○	○	○	○	●	○
N								
S								
H								
O								

CoreLine – Carbide turning indexable insert

VCGT / VCMT

		-SF CTCP125-P	-SF CTCP135-P	-SF CTCK110-P	-SF CTCP115-P	-SF CTCP125-P	-SF CTCP135-P	-SMF CTCP115-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F VCGT	F VCGT	F VCMT	F VCMT	F VCMT	F VCMT	F VCGT
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	76 277 ... 51401 51601 51801	76 277 ... 71401 71601 71801	70 312 ...	76 279 ... 32801 33001	76 279 ... 52801 53001	76 279 ... 72801 73001	76 285 ... 31401
110302EN	0.2							
110304EN	0.4							
110308EN	0.8							
160402EN	0.2	52601	72601					
160404EN	0.4			12801 13001				
160408EN	0.8							
P		●	●	○	●	●	●	●
M			○				○	
K		○		●	○	○		○
N								
S								
H								
O								

CoreLine – Carbide turning indexable insert

VCGT / VCMT

		-SMF CTCP125-P	-SMF CTCP135-P	-SMF CTCP115-P	-SMF CTCP125-P	-SMF CTCP135-P	-SM CTCK110-P	-SM CTCK120-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F VCGT	F VCGT	F VCMT	F VCMT	F VCMT	M VCMT	M VCMT
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	76 285 ... 51401	76 285 ... 71401	76 288 ... 31601 32801 33001	76 288 ... 51601 52801 53001	76 288 ... 71601 72801 73001	70 278 ... 12801 13001 13201	70 278 ... 52801 53001 53201
110302EN	0.2							
110304EN	0.4							
160404EN	0.4							
160408EN	0.8							
160412EN	1.2							
P		●	●	●	●	●	○	○
M			○			○		
K		○		○	○		●	●
N								
S								
H								
O								

CoreLine – Carbide turning indexable insert

VCMT / VCGT

		-SM	-SM	-SM	-SF	-SF	-M25	-M25
		CTCP115-P	CTCP125-P	CTCP135-P	CTPM125	CTPM125	CTCM120	CTPM125
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M	M	M	F	F	F	F
		VCMT	VCMT	VCMT	VCGT	VCMT	VCMT	VCMT
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	76 278 ...	76 278 ...	76 278 ...	75 045 ...	75 046 ...	75 219 ...	75 219 ...
110302EN	0.2				21400			
110304EN	0.4				21600			
160404EN	0.4	32801	52801	72801		22800	12800	228
160406EN	0.6	32901	52901					
160408EN	0.8	33001	53001	73001		23000	13000	23000
160412EN	1.2	33201	53201	73201				
P		●	●	●	○	○	○	○
M				○	●	●	●	●
K		○	○					
N								
S								
H								
O								

CoreLine – Carbide turning indexable insert

VCMT

		<div><div>-M25</div><div>CTCM130</div></div>	<div><div>-M55</div><div>CTCM120</div></div>	<div><div>-M55</div><div>CTPM125</div></div>	<div><div>-M55</div><div>CTCM130</div></div>	<div><div>-SM</div><div>CTPM125</div></div>	<div><div>-M25</div><div>CTPX710</div></div>	<div><div>-M55</div><div>CTPX710</div></div>
		<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>
		<div>F</div> <div>VCMT</div>	<div>M</div> <div>VCMT</div>	<div>M</div> <div>VCMT</div>	<div>M</div> <div>VCMT</div>	<div>M</div> <div>VCMT</div>	<div>M</div> <div>VCMT</div>	<div>M</div> <div>VCMT</div>
		<div>TR</div> <div>75 219 ...</div>	<div>TR</div> <div>75 220 ...</div>	<div>TR</div> <div>75 220 ...</div>	<div>TR</div> <div>75 220 ...</div>	<div>TR</div> <div>75 051 ...</div>	<div>TR</div> <div>75 219 ...</div>	<div>TR</div> <div>75 220 ...</div>
ISO	RE mm							
110302EN	0.2							
110304EN	0.4						61400	
110308EN	0.8						61600	61600
								61800
160402EN	0.2						62600	
160404EN	0.4	32800	12800	228	32800	22800	62800	62800
160408EN	0.8	33000	13000	230	33000	23000	63000	63000
P		○	○	○	○	○	●	●
M		●	●	●	●	●	●	●
K								
N							○	○
S		○			○		●	●
H								
O								

CoreLine – Carbide turning indexable insert

VCGT / VCMT

		<div><div>-25P</div><div>H210T</div></div>	<div><div>-25P</div><div>CTPX710</div></div>	<div><div>-25Q</div><div>H210T</div></div>	<div><div>-25Q</div><div>CTPX710</div></div>	<div><div>-27</div><div>H10T</div></div>	<div><div>-27</div><div>CTPX715</div></div>	<div><div>-29</div><div>H216T</div></div>
		<div><div>F</div><div>VCGT</div></div>	<div><div>M</div><div>VCGT</div></div>	<div><div>M</div><div>VCGT</div></div>	<div><div>M</div><div>VCGT</div></div>	<div><div>M</div><div>VCGT</div></div>	<div><div>M</div><div>VCGT</div></div>	<div><div>M</div><div>VCMT</div></div>
		TR	TR	TR	TR	TR	TR	TR
ISO	RE mm	70 282 ...	70 282 ...	70 282 ...	70 282 ...	70 280 ...	70 280 ...	70 247 ...
110302FN	0.2	638	71400			606	81400	
110304FL	0.4			670	81600			
110304FN	0.4	640	71600			608	81600	
110304FR	0.4			680	81700			
110308FN	0.8					610	71800	
160402FN	0.2		72600				72600	
160404EN	0.4							62800
160404FN	0.4	642	72800			612	82800	
160408EN	0.8							63000
160408FN	0.8	644	73000			614	83000	
160412EN	1.2							63200
160412FN	1.2	646	73200			616	73200	
220530FN	3.0	648	75000			618		
P			●		●		●	
M			●		●		●	
K		○		○		○	○	○
N		●	●	●	●	●	●	●
S		○	●	○	●		●	
H								
O		○		○		○	○	○

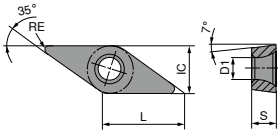
MaxiTurn – Carbide turning indexable insert

VCMT / VCET

		-29 CTPX715		-F05 CTPX710	
		DRAGONSKIN		DRAGONSKIN	
		M VCMT		F VCET	
		TR		IA	
		70 247 ...		76 255 ...	
				11400	
				11600	
				11800	
				12000	
				12200	
		72800			
		73000			
		73200			
ISO	RE mm				
1103005FN	0.05				
110301FN	0.10				
1103015FN	0.15				
110302FN	0.20				
110304FN	0.40				
160404EN	0.40				
160408EN	0.80				
160412EN	1.20				
P		●		●	
M		●		●	
K		○			
N		●		●	
S		●		●	
H					
O		○			

VCGT / VCXT

Designation	L	S	D1	IC
	mm	mm	mm	mm
VCGT 1103..	11.1	3.18	2.9	6.35
VC.T 1604..	16.6	4.76	4.4	9.52



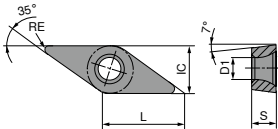
CoreLine – Carbide turning indexable insert

VCGT / VCXT

		<div><div>-F23</div><div>CTP2120</div><div><div></div><div></div><div></div></div><div></div><div><div>F</div><div>VCGT</div></div></div>	<div><div>-M81</div><div>CWN2120</div><div><div></div><div></div><div></div></div><div></div><div><div>M</div><div>VCXT</div></div></div>
		<div>TR</div> <div>70 193 ...</div> <div>600</div> <div>602</div> <div>606</div>	<div>TR</div> <div>70 280 ...</div> <div></div> <div></div> <div></div> <div>112</div> <div>114</div>
ISO	RE mm		
110300FN	0.0		
110301FN	0.1		
160401FN	0.1		
160404FN	0.4		
160408FN	0.8		
P			
M			
K			
N			
S			
H			
O			

VCGT

Designation	L	S	D1	IC
	mm	mm	mm	mm
VCGT 1604..	16.6	4.76	4.4	9.52
VCGT 2205..	22.1	5.56	5.5	12.70



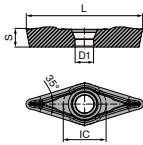
CoreLine – Carbide turning indexable insert

VCGT

		-24P H210T	-24P H216T	-28P H216T
		F VCGT	F VCGT	F VCGT
ISO	RE mm	TR 70 219 ... 53000 53200	TR 70 219 ... 55000	TR 70 220 ... 53200 54700
160408FN	0.8			
160412FN	1.2			
220520FN	2.0			
220530FN	3.0			
P				
M				
K		○	○	○
N		●	●	●
S		○		
H				
O		○	○	○

VPGT / VPGX

Designation	L	S	D1	IC
	mm	mm	mm	mm
VPGX 2206..	22.1	6.35	5.16	12.9
VPGT 2205..	22.1	5.56	5.50	12.7



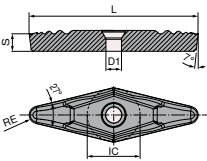
CoreLine – Carbide turning indexable insert

VPGT / VPGX

		<div><div>-24P</div><div>H216T</div><div></div><div></div><div>F</div><div>VPGT</div></div>	<div><div>-25P</div><div>H210T</div><div></div><div></div><div>F</div><div>VPGT</div></div>	<div><div>-25P</div><div>H216T</div><div></div><div></div><div>F</div><div>VPGX</div></div>	<div><div>-25</div><div>H10T</div><div></div><div></div><div>F</div><div>VPGT</div></div>	<div><div>-28P</div><div>H216T</div><div></div><div></div><div>F</div><div>VPGT</div></div>
		TR	TR	TR	TR	TR
		70 221 ...	70 222 ...	70 222 ...	70 223 ...	70 224 ...
		61000	51000	60800	41000	61000
ISO	RE					
	mm					
220612FN	1.2					
220516FN	1.6					
P						
M						
K			○	○	○	○
N		●	●	●	●	●
S			○			
H						
O		○	○	○	○	○

XCGT

Designation	L	S	D1	IC
	mm	mm	mm	mm
XCGT 4006..	45.9	7.5	5.6	19.66



CoreLine – Carbide turning indexable insert

XCGT

ISO	RE
	mm
400632FN	3.2

-25
H216T



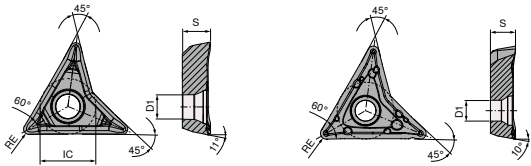
F
XCGT

TR
70 226 ...
61400

P	
M	
K	○
N	●
S	
H	
O	○

HUB

Designation	S	D1	IC
	mm	mm	mm
HUB 12061..	6.35	5.5	12.70
HUB 15071..	7.0	5.8	15.88



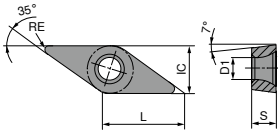
MaxiTurn – Carbide turning indexable insert

HUB

		<div><div>-27</div><div>H216T</div><div><div></div><div></div><div></div></div><div></div><div>F</div><div>HUB</div></div>	<div><div>-27</div><div>H216T</div><div><div></div><div></div><div></div></div><div></div><div>F</div><div>HUB</div></div>
		<div>IA</div> <div>70 218 ...</div> <div>62200</div>	<div>IA</div> <div>70 218 ...</div> <div>60800</div>
ISO			
HUB 120612N			
HUB 150716L			
P			
M			
K			
N			
S			
H			
O			

VCMT

Designation	L	S	D1	IC
	mm	mm	mm	mm
VCMT 1103..	11.1	3.18	2.9	6.35
VCMT 1604..	16.6	4.76	4.4	9.52



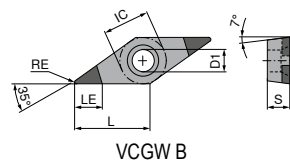
CoreLine – Carbide turning indexable insert

VCMT

		-FMS CT-P15	-FMS CT-P25	-MRS CT-P15	-MRS CT-P25
		F VCMT	F VCMT	M VCMT	M VCMT
		CX	CX	CX	CX
ISO	RE mm	75 308 ... 01609	75 308 ... 11609	75 309 ... 02809 03009	75 309 ... 12809 13009
110304EN	0.4				
160404EN	0.4	02809	12809	02809	12809
160408EN	0.8	03009	13009	03009	13009
P		●	●	●	●
M		○	○	○	○
K					
N					
S					
H					
O					

VCGW

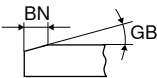
Designation	L	S	D1	IC
	mm	mm	mm	mm
VCGW 1103..	11.1	3.18	2.9	6.35
VCGW 1604..	16.6	4.76	4.4	9.52



CoreLine – PcBN turning indexable insert

VCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners



CTBH1000C

F

PCBN

VCGW

CTBH2000C

F

PCBN

VCGW

CTBH3000C

F

PCBN

VCGW

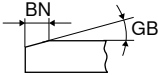
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	PC 71 041 ...
110302EN	0.2			B (2)	5.5	70002
110302SN	0.2	0.14	20°	B (2)	5.5	80002
						90002
110304EN	0.4			B (2)	5.1	70302
110304SN	0.4	0.14	20°	B (2)	5.1	80302
						90302
160402EN	0.2			B (2)	5.5	70602
160402SN	0.2	0.14	20°	B (2)	5.5	80602
						90602
160404EN	0.4			B (2)	5.1	70902
160404SN	0.4	0.14	20°	B (2)	5.1	80902
						90902
160408EN	0.8			B (2)	4.2	71202
160408SN	0.8	0.14	20°	B (2)	4.2	81202
						91202

P			
M			
K			
N			
S			
H			
O			

CoreLine – PcBN turning indexable insert

VCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners



ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
110302SN	0.2	0.09	15°	B (2)	5.5
110302SN	0.2	0.18	25°	B (2)	5.5
110304SN	0.4	0.09	15°	B (2)	5.1
110304SN	0.4	0.18	25°	B (2)	5.1
160402SN	0.2	0.09	15°	B (2)	5.5
160402SN	0.2	0.18	25°	B (2)	5.5
160404SN	0.4	0.09	15°	B (2)	5.1
160404SN	0.4	0.18	25°	B (2)	5.1
160408SN	0.8	0.09	15°	B (2)	4.2
160408SN	0.8	0.18	25°	B (2)	4.2

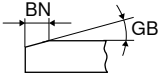
P			
M			
K			
N			
S			
H			
O			

CTBH1000C	CTBH2000C	CTBH3000C
M	M	M
PCBN	PCBN	PCBN
VCGW	VCGW	VCGW
PC	PC	PC
71 041 ...	71 041 ...	71 041 ...
70102	80102	90102
70402	80402	90402
70702	80702	90702
71002	81002	91002
71302	81302	91302

CoreLine – PcBN turning indexable insert

VCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners



ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
110302SN	0.2	0.14	20°	B (2)	5.5
110302SN	0.2	0.20	35°	B (2)	5.5
110304SN	0.4	0.14	20°	B (2)	5.1
110304SN	0.4	0.20	35°	B (2)	5.1
160402SN	0.2	0.14	20°	B (2)	5.5
160402SN	0.2	0.20	35°	B (2)	5.5
160404SN	0.4	0.14	20°	B (2)	5.1
160404SN	0.4	0.20	35°	B (2)	5.1
160408SN	0.8	0.14	20°	B (2)	4.2
160408SN	0.8	0.20	35°	B (2)	4.2

P			
M			
K			
N			
S			
H			
O			

CTBH1000C

R

PCBN

VCGW

CTBH2000C

R

PCBN

VCGW

CTBH3000C

R

PCBN

VCGW

PC

71 041 ...

70202

70502

70802

71102

71402

PC

71 041 ...

80202

80502

80802

81102

81402

PC

71 041 ...

90202

90502

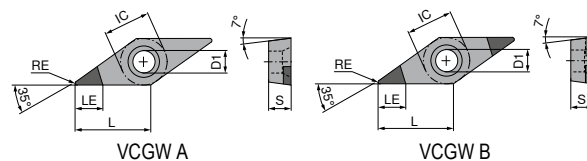
90802

91102

91402

VCGW

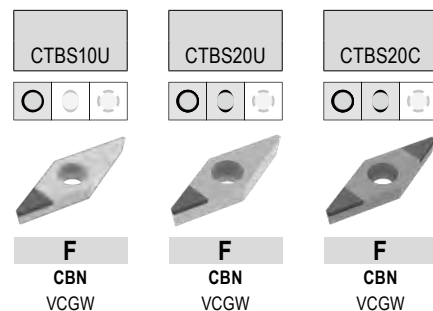
Designation	L	S	D1	IC
	mm	mm	mm	mm
VCGW 1103..	11.1	3.18	2.9	6.35
VCGW 1604..	16.6	4.76	4.4	9.52



CoreLine – PcBN turning indexable insert

VCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners

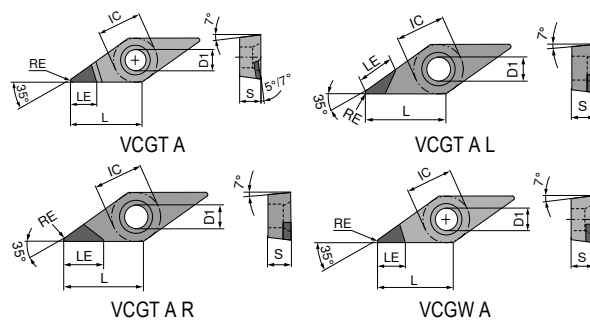


ISO	RE	BN	GB	TCE (NOI)	LE	PC	71 160 ...	71 429 ...	71 165 ...
110302TN	0.2	0.12	15°	A (1)	4.7				
110302FN	0.2			A (1)	4.7		200	20000	
110302TN	0.2	0.12	20°	A (1)	4.7		300		
110304SN	0.4	0.09	10°	B (2)	3.1				121
110304SN	0.4	0.11	15°	B (2)	3.1				131
110304TN	0.4	0.15	20°	B (2)	3.1				141
110304SN	0.4	0.16	20°	B (2)	3.1				151
110304FN	0.4			A (1)	4.5		202		
110308SN	0.8	0.16	20°	B (2)	2.5				152
110308EN	0.8			B (2)	2.5				112
110308FN	0.8			A (1)	4.2		204		
160402FN	0.2			A (1)	5.3		205		
160402TN	0.2	0.12	20°	A (1)	5.3		305		
160404SN	0.4	0.09	10°	B (2)	3.1				125
160404SN	0.4	0.11	15°	B (2)	3.1				135
160404TN	0.4	0.12	15°	A (1)	5.0			20100	
160404TN	0.4	0.12	20°	A (1)	5.0		306		
160404TN	0.4	0.15	20°	B (2)	3.1				145
160404SN	0.4	0.16	20°	B (2)	3.1				155
160404FN	0.4			A (1)	5.0		206		
160408SN	0.8	0.09	10°	B (2)	2.5				126
160408SN	0.8	0.11	15°	B (2)	2.5				136
160408TN	0.8	0.12	15°	A (1)	4.4			20200	
160408TN	0.8	0.12	20°	A (1)	4.4		308		
160408SN	0.8	0.16	20°	B (2)	2.5				156
160408TN	0.8	0.17	25°	B (2)	2.5				166
160408EN	0.8			B (2)	2.5				116
160408FN	0.8			A (1)	4.4		208		
160408SN	0.8	0.18	25°	B (2)	2.5				176

P			
M			
K			
N			
S			
H			
O			

VCGT / VCGW

Designation	L	S	D1	IC
	mm	mm	mm	mm
VCG. 0702..	6.9	2.38	2.2	3.97
VCG. 1103..	11.1	3.18	2.9	6.35
VCG. 1303..	13.3	3.18	3.4	7.94
VCG. 1604..	16.6	4.76	4.4	9.52



CoreLine – PCD turning indexable insert

VCGT / VCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners

				CTDMD05	CTDMD05	CTDPD20	CTDPD20	CTDPD20	CTDPD20
				F	F	F	F	F	F
				DIAMOND	DIAMOND	DIAMOND	DIAMOND	DIAMOND	DIAMOND
				VCGT	VCGW	VCGW	VCGT	VCGT	VCGT
				PC	PC	PC	PC	PC	PC
ISO	RE mm	TCE (NOI)	LE mm	71 189 ...	71 160 ...	71 160 ...	71 062 ...	71 063 ...	71 064 ...
070202FN	0.2	A (1)		50001					
070204FN	0.4	A (1)		50101					
110301FN	0.1	A (1)	5.4				10100		
110302FN	0.2	A (1)	3.0		050				
110302FN	0.2	A (1)	4.6	50201		100	100		
110304FN	0.4	A (1)	3.0		052				
110304FN	0.4	A (1)	3.9	50301		102	102		
110304FR	0.4	A (1)	6.5					102	
110304FL	0.4	A (1)	6.5						102
110308FN	0.8	A (1)	3.3			104	104		
110308FR	0.8	A (1)	6.0					104	
110308FL	0.8	A (1)	6.0						104
160401FN	0.1	A (1)	6.0				10700		
160402FN	0.2	A (1)	5.9			105	105		
160402FN	0.2	A (1)		50401					
160404FN	0.4	A (1)	5.5			106	106		
160404FN	0.4	A (1)		50501					
160404FR	0.4	A (1)	7.5					106	
160404FL	0.4	A (1)	7.5						106
160408FN	0.8	A (1)	5.0		07800	108	108		
160408FR	0.8	A (1)	7.0					108	
160408FL	0.8	A (1)	7.0						108
160408FN	0.8	A (1)		50601					
160412FN	1.2	A (1)	4.5			110	110		
160412FR	1.2	A (1)	7.0					110	
160412FL	1.2	A (1)	7.0						110
P									
M									
K									
N				•	•	•	•	•	•
S									
H									
O				•	•	•	•	•	•

CoreLine – PCD turning indexable insert

VC GT / VC GW

▲ TCE(NOI) = Design and number of equipped cutting edge corners

				-CB1 CTDPD20	CTDPS30	CTDPS30	-CB1 CTDPS30	-CB2 CTDPS30	CTDPU20
				F DIAMOND VCGT	F DIAMOND VCGW	F DIAMOND VCGT	F DIAMOND VCGT	M DIAMOND VCGT	F DIAMOND VCGW
ISO	RE mm	TCE (NOI)	LE mm	PC 71 330 ...	PC 71 191 ...	PC 71 189 ...	PC 71 330 ...	PC 71 331 ...	PC 71 191 ...
070201FN	0.1	A (1)	3.8	71 330 ...	71 191 ...	71 189 ...	71 330 ...	71 331 ...	71 191 ...
070202FN	0.2	A (1)	3.6						
070204FN	0.4	A (1)	3.2						
110301FN	0.1	A (1)	5.4	11000	20201	20101			
110302FN	0.2	A (1)	4.6	112	20301	20201	21200	212	
110304FN	0.4	A (1)	3.9	114	20401	20301	214	214	
110308FN	0.8	A (1)	3.3					21800	
130302FN	0.2	A (1)	5.9		20501	20401			
160401FN	0.1	A (1)	6.0		20601	20501			
160402FN	0.2	A (1)	5.9	13200		20601		23200	
160404FN	0.4	A (1)	5.5	134	20701	20701	234	234	30001
160408FN	0.8	A (1)	5.0	138	20801		238	238	
160412FN	1.2	A (1)	4.5	14000	20901		24000	242	
P									
M									
K									
N									
S									
H									
O									

CoreLine – PCD turning indexable insert

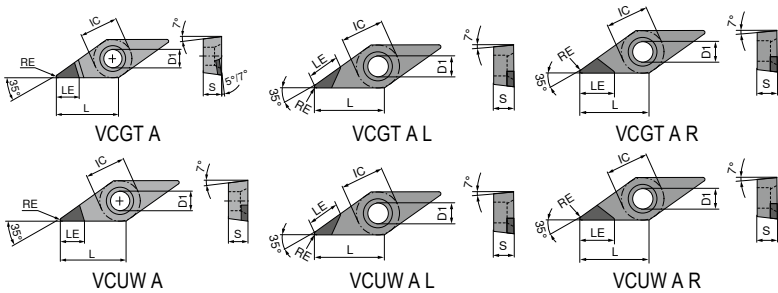
VC GT / VC GW

▲ TCE(NOI) = Design and number of equipped cutting edge corners

				<div>-CB2 CTDPU20</div> <div></div> <div>M DIAMOND VCGT</div>	<div>-CB3 CTDPU20</div> <div></div> <div>R DIAMOND VCGT</div>	<div>CTDCD10</div> <div></div> <div>F DIAMOND VCGW</div>	<div>-CB1 CTDCD10</div> <div></div> <div>F DIAMOND VCGT</div>	<div>-CB2 CTDCD10</div> <div></div> <div>M DIAMOND VCGT</div>
ISO	RE mm	TCE (NOI)	LE mm	PC 71 190 ...	PC 71 332 ...	PC 71 191 ...	PC 71 330 ...	PC 71 331 ...
110301FN	0.1	A (1)	3.0				31000	
110302FN	0.2	A (1)	3.0			40001	312	312
110304FN	0.4	A (1)	3.0			40101	314	314
110304FN	0.4	A (1)	3.9					
110308FN	0.8	A (1)	3.0			40201		
160402FN	0.2	A (1)	3.0	30001	234	40301	32200	33200
160404FN	0.4	A (1)	3.0			40401	32400	334
160404FN	0.4	A (1)	5.5					
160408FN	0.8	A (1)	3.0			40501	32600	338
160412FN	1.2	A (1)	3.0				32800	34000
P								
M								
K								
N								
S								
H								
O								

VCUW / VCUT

Designation	L	S	D1	IC
	mm	mm	mm	mm
VCU. 1604..	16.6	4.76	4.4	9.52
VCU. 2205..	22.1	5.56	5.5	12.70



CoreLine – PCD turning indexable insert

VCUW

▲ TCE(NOI) = Design and number of equipped cutting edge corners

-F4 CTD4110	-F4 CTD4110	-F4 CTD4110
F DIAMOND VCUW	F DIAMOND VCUW	F DIAMOND VCUW
PC	PC	PC
71 143 ...	71 143 ...	71 143 ...
60002	60102	60202
60302	60402	60502
61002	61102	61202
61402	61502	61602
62002	62102	62202
62302	62402	62502

ISO	RE mm	TCE (NOI)
160408FL	0.8	A (1)
160408FN	0.8	A (1)
160408FR	0.8	A (1)
160408TL	0.8	A (1)
160408TN	0.8	A (1)
160408TR	0.8	A (1)
160412FL	1.2	A (1)
160412FN	1.2	A (1)
160412FR	1.2	A (1)
160412SN	1.2	A (1)
160412TL	1.2	A (1)
160412TN	1.2	A (1)
160412TR	1.2	A (1)
220530FL	3.0	A (1)
220530FN	3.0	A (1)
220530FR	3.0	A (1)
220530TL	3.0	A (1)
220530TN	3.0	A (1)
220530TR	3.0	A (1)

P			
M			
K			
N			
S			
H			
O			

CoreLine – PCD turning indexable insert

VCUW

▲ TCE(NOI) = Design and number of equipped cutting edge corners

-G
CTDPD20



F
DIAMOND
VCUW

ISO	RE mm	TCE (NOI)	PC 71 141 ...
160408EN	0.8	A (1)	10001
160408FN	0.8	A (1)	10101
160408SN	0.8	A (1)	10501
160408SN	0.8	A (1)	10601
160408SN	0.8	A (1)	10701
160408SN	0.8	A (1)	10801
160408SN	0.8	A (1)	10901
160408TN	0.8	A (1)	11501
160408TN	0.8	A (1)	11601
160408TN	0.8	A (1)	11701
160408TN	0.8	A (1)	11801
160408TN	0.8	A (1)	11901
160412EN	1.2	A (1)	12001
160412FN	1.2	A (1)	12101
160412SN	1.2	A (1)	12501
160412SN	1.2	A (1)	12601
160412SN	1.2	A (1)	12701
160412SN	1.2	A (1)	12801
160412SN	1.2	A (1)	12901
160412TN	1.2	A (1)	13501
160412TN	1.2	A (1)	13601
160412TN	1.2	A (1)	13701
160412TN	1.2	A (1)	13801
160412TN	1.2	A (1)	13901
P			
M			
K			
N			●
S			
H			
O			●

CoreLine – PCD turning indexable insert

VCUT

▲ TCE(NOI) = Design and number of equipped cutting edge corners

			<div><div>-F41</div><div>CTD4110</div><div><div><div></div><div></div><div></div></div></div></div> <div></div> <div><div>F</div><div>DIAMOND</div><div>VCUT</div></div>	<div><div>-F41</div><div>CTD4110</div><div><div><div></div><div></div><div></div></div></div></div> <div></div> <div><div>F</div><div>DIAMOND</div><div>VCUT</div></div>	<div><div>-F41</div><div>CTD4110</div><div><div><div></div><div></div><div></div></div></div></div> <div></div> <div><div>F</div><div>DIAMOND</div><div>VCUT</div></div>
ISO	RE mm	TCE (NOI)	PC 71 147 ...	PC 71 147 ...	PC 71 147 ...
160408FL	0.8	A (1)	60102		
160408FN	0.8	A (1)		60002	
160408FR	0.8	A (1)			60202
160408SN	0.8	A (1)		60602	
160408TL	0.8	A (1)	60402		
160408TN	0.8	A (1)		60302	
160408TR	0.8	A (1)			60502
160412FL	1.2	A (1)	61102		
160412FN	1.2	A (1)		61002	
160412FR	1.2	A (1)			61202
160412SN	1.2	A (1)		61602	
160412TL	1.2	A (1)	61402		
160412TN	1.2	A (1)		61302	
160412TR	1.2	A (1)			61502
220530FL	3.0	A (1)	62102		
220530FN	3.0	A (1)		62002	
220530FR	3.0	A (1)			62202
220530TL	3.0	A (1)	62402		
220530TN	3.0	A (1)		62302	
220530TR	3.0	A (1)			62502
P					
M					
K					
N					
S					
H					
O					

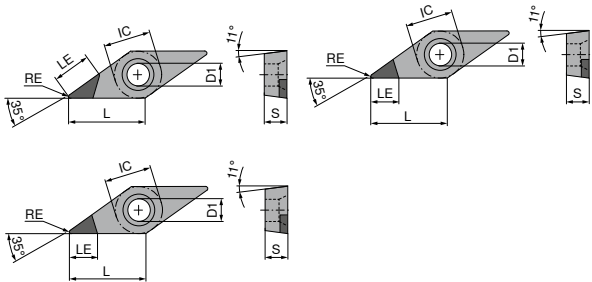
VCUT

▲ TCE(NOI) = Design and number of equipped cutting edge corners

			-M41 CTD4110	-M41 CTD4110	-M41 CTD4110	-R41 CTD4110	-R41 CTD4110	-R41 CTD4110
			M DIAMOND VCUT	M DIAMOND VCUT	M DIAMOND VCUT	R DIAMOND VCUT	R DIAMOND VCUT	R DIAMOND VCUT
			PC	PC	PC	PC	PC	PC
ISO	RE mm	TCE (NOI)	71 148 ...	71 148 ...	71 148 ...	71 149 ...	71 149 ...	71 149 ...
160408FL	0.8	A (1)	60202			60202		
160408FN	0.8	A (1)		60002			60102	
160408FR	0.8	A (1)			60302			60302
160408SN	0.8	A (1)		60602				
160408TL	0.8	A (1)	60402			60402		
160408TN	0.8	A (1)		60102			60002	
160408TR	0.8	A (1)			60502			60502
160412FL	1.2	A (1)	61202			61302		
160412FN	1.2	A (1)		61002			61202	
160412FR	1.2	A (1)			61302			61402
160412SN	1.2	A (1)		61602				
160412TL	1.2	A (1)	61402			61102		
160412TN	1.2	A (1)		61102			61002	
160412TR	1.2	A (1)			61502			61502
220530EN	3.0	A (1)					62702	
220530FL	3.0	A (1)	62202			62202		
220530FN	3.0	A (1)		62102			62102	
220530FR	3.0	A (1)			62302			62302
220530SR	3.0	A (1)						62602
220530TL	3.0	A (1)	62402			62002		
220530TN	3.0	A (1)		62002			62402	
220530TR	3.0	A (1)			62502			62502
P								
M								
K								
N	.	.	.	.	.	.	.	.
S								
H								
O								

VPUW / VPUT

Designation	L	S	D1	IC
	mm	mm	mm	mm
VPU. 2205..	22.1	5.56	5.5	12.7



CoreLine – PCD turning indexable insert

VPUW

▲ TCE(NOI) = Design and number of equipped cutting edge corners

-F4 CTD4110	-F4 CTD4110	-F4 CTD4110
F DIAMOND VPUW	F DIAMOND VPUW	F DIAMOND VPUW
PC 71 146 ... 60102	PC 71 146 ... 60002 60402 60302	PC 71 146 ... 60202 60502

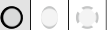
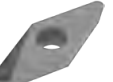
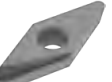
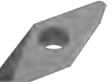
ISO	RE mm	TCE (NOI)			
220516FL	1.6	A (1)			
220516FN	1.6	A (1)			
220516FR	1.6	A (1)			
220516TL	1.6	A (1)			
220516TN	1.6	A (1)			
220516TR	1.6	A (1)			
P					
M					
K					
N				•	•
S					
H					
O					

VPUT

▲ TCE(NOI) = Design and number of equipped cutting edge corners

ISO	RE mm	TCE (NOI)			
220516FL	1.6	A (1)			
220516FN	1.6	A (1)			
220516FR	1.6	A (1)			
220516TL	1.6	A (1)			
220516TN	1.6	A (1)			
220516TR	1.6	A (1)			
P					
M					
K					
N					
S					
H					
O					

VPUT

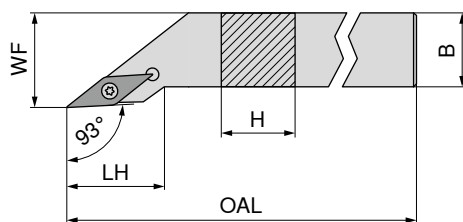
-M41 CTD4110	-M41 CTD4110	-M41 CTD4110	-R41 CTD4110	-R41 CTD4110	-R41 CTD4110
					
					
M DIAMOND VPUT	M DIAMOND VPUT	M DIAMOND VPUT	R DIAMOND VPUT	R DIAMOND VPUT	R DIAMOND VPUT

ISO	RE mm	TCE (NOI)	PC 71 157 ... 60002	PC 71 157 ... 60102	PC 71 157 ... 60202	PC 71 158 ... 60302	PC 71 158 ... 60402	PC 71 158 ... 60502
220516FL	1.6	A (1)						
220516FN	1.6	A (1)						
220516FR	1.6	A (1)						
220516TL	1.6	A (1)						
220516TN	1.6	A (1)						
220516TR	1.6	A (1)						
P								
M								
K								
N								
S								
H								
O								

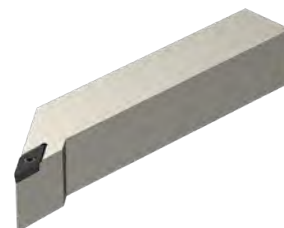
CoreLine – SVJC 93° – Tool holder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Left

Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
SVJC R/L 1212 F11	12	12	80	21.6	16	1,2	VC.. 1103
SVJC R/L 1616 H11	16	16	100	21.6	20	1,2	VC.. 1103
SVJC R/L 2020 K11	20	20	125	23.0	25	1,2	VC.. 1103
SVJC R/L 2525 M11	25	25	150	25.5	32	1,2	VC.. 1103
SVJC R/L 2020 K16	20	20	125	29.4	25	3,2	VC.. 1604
SVJC R/L 2525 M16	25	25	150	32.5	32	3,2	VC.. 1604
SVJC R/L 3225 P16	32	25	170	32.5	32	3,2	VC.. 1604

TO	TO
70 663 ...	70 663 ...
01200	01201
01600	01601
02000	02001
02500	02501
12000	12001
12500	12501
13200	13201

Spare parts

for article number

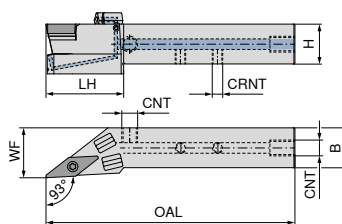
70 663 01201 / 70 663 01200
 70 663 01601 / 70 663 01600
 70 663 02001 / 70 663 02000
 70 663 02501 / 70 663 02500
 70 663 12001 / 70 663 12000
 70 663 12501 / 70 663 12500
 70 663 13201 / 70 663 13200

			
Screwdriver	Clamping screw	Carbide seat V	Threaded bush
AS	AS	AS	AS
80 950 ...	70 950 ...	70 950 ...	70 950 ...
039	857		
039	857		
039	857		
039	857		
120	87900	107	171
120	87900	107	171
120	87900	107	171

CoreLine – SVJC 93° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions



Left

Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Tightening torque Nm	Indexable insert
SVJC R/L 1212 F11 DC	12	12	80	30	16	M6	M6	1,2	VC.. 1103
SVJC R/L 1616 H11 DC	16	16	100	27	20	M6	G1/8"	1,2	VC.. 1103
SVJC R/L 2020 K11 DC	20	20	125	39	25	M6	G1/8"	1,2	VC.. 1103
SVJC R/L 2525 M11 DC	25	25	150	41	32	M6	G1/8"	1,2	VC.. 1103
SVJC R/L 2020 K16 DC	20	20	125	39	25	M6	G1/8"	3,2	VC.. 1604
SVJC R/L 2525 M16 DC	25	25	150	41	32	M6	G1/8"	3,2	VC.. 1604
SVJC R/L 3225 P16 DC	32	25	170	41	32	G1/8"	G1/8"	3,2	VC.. 1604

TO	TO
70 780 ...	70 780 ...
01201	01200
01601	01600
02001	02000
02501	02500
12001	12000
12501	12500
03201	03200

Spare parts

for article number

70 780 01200 / 70 780 01201
70 780 01600 / 70 780 01601
70 780 02000 / 70 780 02001
70 780 02500 / 70 780 02501
70 780 12000 / 70 780 12001
70 780 12500 / 70 780 12501
70 780 03200 / 70 780 03201

AS	AS	AS	AS	AS
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
857			86700	
857		88000	86700	
857		88000	86700	
857		88000	86700	
87900	107	88000	86700	171
87900	107	88000	86700	171
87900	107	88000		171

Spare parts

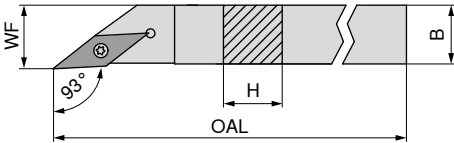
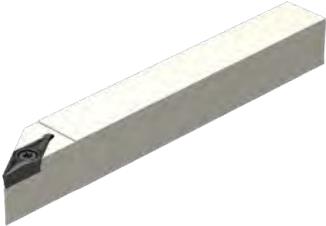
for article number

70 780 01200 / 70 780 01201
70 780 01600 / 70 780 01601
70 780 02000 / 70 780 02001
70 780 02500 / 70 780 02501
70 780 12000 / 70 780 12001
70 780 12500 / 70 780 12501
70 780 03200 / 70 780 03201

AS	AS	AS	AS	AS
70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...
	039			
87600	039	88100	87700	294
87600	039	88100	87700	294
87600	039	88100	87700	294
87600	120	88100	87700	294
87600	120	88100	87700	294
87600	120	88100	87700	294

CoreLine – SVJC 93° – Tool holder with screw clamping

▲ For sliding head lathes



Illustrations show right-hand versions

Designation	H mm	B mm	OAL mm	WF mm	Tightening torque Nm	Indexable insert
SVJC R/L 0808 H11	8	8	100	8	1,2	VC.. 1103
SVJC R/L 1010 H11	10	10	100	10	1,2	VC.. 1103
SVJC R/L 1212 H11	12	12	100	12	1,2	VC.. 1103
SVJC R/L 1616 K11	16	16	125	16	1,2	VC.. 1103

Left	Right
TO	TO
70 697 ...	70 696 ...
008	008
010	010
112	112
116	116

Spare parts
Indexable insert

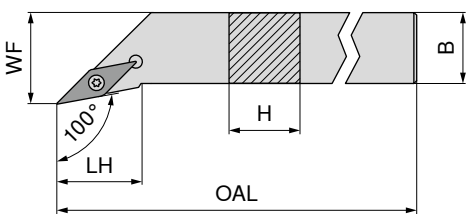
VC.. 1103

	
Screwdriver	Clamping screw
AS	AS
80 950 ...	70 950 ...
110	13800

CoreLine – SVZC 100° – Tool holder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

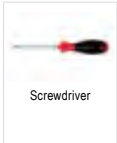


Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
SVZC R/L 2525 M16	25	25	150	27.3	32	3,2	VC.. 1604

Left	Right
TO	TO
70 667 ...	70 667 ...
02500	02501

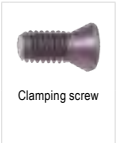
Spare parts
for article number

70 667 02501 / 70 667 02500



Screwdriver

AS
80 950 ...
T15 - IP
120



Clamping screw

AS
70 950 ...
M3,5x11
87900



Carbide seat V

AS
70 950 ...
107

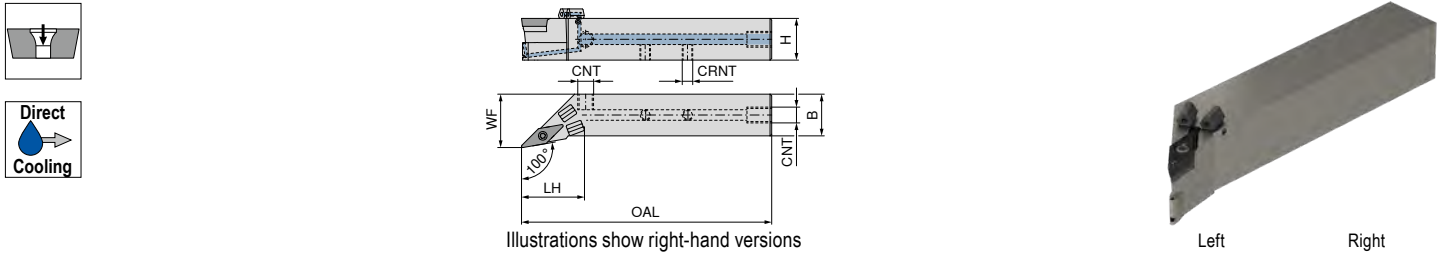


Threaded bush

AS
70 950 ...
M3,5
171

CoreLine – SVZC 100° DC – Tool holder with screw clamping

Scope of supply:
Tool holder with blind plug and Torx key



Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Tightening torque Nm	Indexable insert
SVZC R/L 2525 M16 DC	25	25	150	38	32	M6	G1/8"	3,2	VC.. 1604

Left	Right
TO 70 783 ... 02501	TO 70 783 ... 02500

Spare parts
for article number

70 783 02500 / 70 783 02501

 Clamping screw AS 70 950 ... 87900	 Carbide seat V AS 70 950 ... 107	 Set Screw AS 70 950 ... 88000	 Set Screw AS 70 950 ... 86700	 Threaded bush AS 70 950 ... 171
 Sealing plugs DC AS 70 950 ... 87600	 Screwdriver AS 80 950 ... 120	 O ring AS 70 950 ... 88100	 Coolant nozzle DC AS 70 950 ... 87700	 Coolant screw plug AS 70 950 ... 294

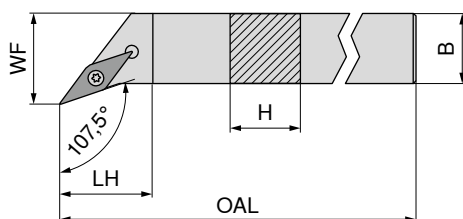
Spare parts
for article number

70 783 02500 / 70 783 02501

CoreLine – SVHC 107.5° – Tool holder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Left

Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
SVHC R/L 1212 F11	12	12	80	11.9	16	1,2	VC.. 1103
SVHC R/L 1616 H11	16	16	100	11.9	20	1,2	VC.. 1103
SVHC R/L 2020 K11	20	20	125	14.7	25	1,2	VC.. 1103
SVHC R/L 2525 M11	25	25	150	20.1	32	1,2	VC.. 1103
SVHC R/L 2020 K16	20	20	125	13.7	25	3,2	VC.. 1604
SVHC R/L 2525 M16	25	25	150	20.0	32	3,2	VC.. 1604
SVHC R/L 3225 P16	32	25	170	20.0	32	3,2	VC.. 1604
SVHC R/L 2525 M22	25	25	150	21.9	32	5	VC.. 2205

TO	TO
70 662 ...	70 662 ...
01200	01201
01600	01601
02000	02001
02500	02501
12000	12001
12500	12501
13200	13201
22500	22501

Spare parts

for article number

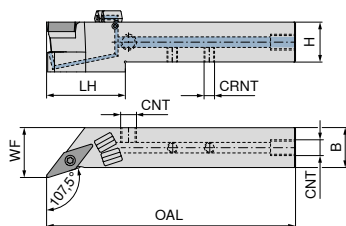
70 662 01201 / 70 662 01200
70 662 01601 / 70 662 01600
70 662 02001 / 70 662 02000
70 662 02501 / 70 662 02500
70 662 12001 / 70 662 12000
70 662 12501 / 70 662 12500
70 662 13201 / 70 662 13200
70 662 22501 / 70 662 22500

			
Screwdriver	Clamping screw	Carbide seat V	Threaded bush
AS	AS	AS	AS
80 950 ...	70 950 ...	70 950 ...	70 950 ...
039	857		
039	857		
039	857		
039	857		
120	87900	107	171
120	87900	107	171
120	87900	107	171
120	820	109	170

CoreLine – SVHC 107.5° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions



Left

Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Tightening torque Nm	Indexable insert	TO 70 779 ...	TO 70 779 ...
SVHC R/L 1212 F11 DC	12	12	80	28	16	M6	M6	1,2	VC.. 1103	01201	01200
SVHC R/L 1616 H11 DC	16	16	100	27	20	M6	G1/8"	1,2	VC.. 1103	01601	01600
SVHC R/L 2020 K11 DC	20	20	125	37	27	M6	G1/8"	1,2	VC.. 1103	02001	02000
SVHC R/L 2525 M11 DC	25	25	150	38	32	M6	G1/8"	1,2	VC.. 1103	02501	02500
SVHC R/L 2020 K16 DC	20	20	125	38	25	M6	G1/8"	3,2	VC.. 1604	12001	12000
SVHC R/L 2525 M16 DC	25	25	150	38	32	M6	G1/8"	3,2	VC.. 1604	12501	12500
SVHC R/L 3225 P16 DC	32	25	170	38	32	M6	G1/8"	3,2	VC.. 1604	03201	03200
SVHC R/L 2525 M22 DC	25	25	150	41	32	M6	G1/8"	5	VC.. 2205	22501	22500

Spare parts for article number

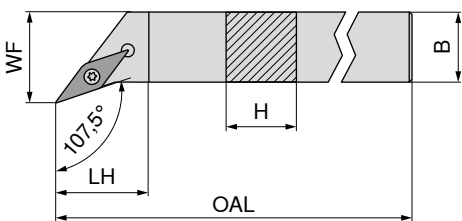
	Clamping screw	Carbide seat V	Set Screw	Set Screw	Threaded bush
70 779 01200 / 70 779 01201	857			86700	
70 779 01600 / 70 779 01601	857		88000	86700	
70 779 02000 / 70 779 02001	857		88000	86700	
70 779 02500 / 70 779 02501	857		88000	86700	
70 779 12000 / 70 779 12001	87900	107	88000	86700	171
70 779 12500 / 70 779 12501	87900	107	88000	86700	171
70 779 03200 / 70 779 03201	87900	107	88000	86700	171
70 779 22500 / 70 779 22501	820	109	88000	86700	170

Spare parts for article number

	Sealing plugs DC	Screwdriver	O ring	Coolant nozzle DC	Coolant screw plug
70 779 01200 / 70 779 01201		039			
70 779 01600 / 70 779 01601	87600	039	88100	87700	294
70 779 02000 / 70 779 02001	87600	039	88100	87700	294
70 779 02500 / 70 779 02501	87600	039	88100	87700	294
70 779 12000 / 70 779 12001	87600	120	88100	87700	294
70 779 12500 / 70 779 12501	87600	120	88100	87700	294
70 779 03200 / 70 779 03201	87600	120	88100	87700	294
70 779 22500 / 70 779 22501	87600	120	88100	87700	294

CoreLine – SVHC 107.5° – Tool holder with screw clamping





Illustrations show right-hand versions



Left Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
SVHC R/L 3225 P22	32	25	170	19.6	32	5	VC.. 2205

TO
70 705 ...
232

TO
70 704 ...
232

Spare parts
for article number

70 704 232 / 70 705 232



Combi key

AS
70 950 ...
398



Clamping screw

AS
70 950 ...
114



Carbide seat V

AS
70 950 ...
109



Threaded bush

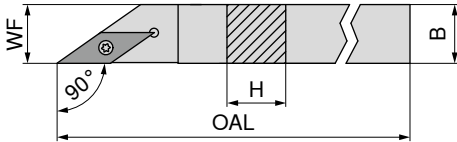
AS
70 950 ...
170

CoreLine – SVAC 90° – Tool holder with screw clamping

▲ For sliding head lathes

Scope of supply:

Tool holder with Torx key



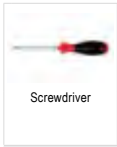
Illustrations show right-hand versions

Designation	H mm	B mm	OAL mm	WF mm	Tightening torque Nm	Indexable insert
SVAC R/L 0808 H11	8	8	100	8	1,2	VC.. 1103
SVAC R/L 1010 H11	10	10	100	10	1,2	VC.. 1103
SVAC R/L 1212 H11	12	12	100	12	1,2	VC.. 1103

Left	Right
TO	TO
70 695 ...	70 694 ...
008	008
010	010
012	012

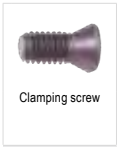
Spare parts
for article number

70 694 008 / 70 695 008	T08	110	M2,5x6 - T08	13800
70 694 010 / 70 695 010	T08	110	M2,5x6 - T08	13800
70 694 012 / 70 695 012	T08	110	M2,5x6 - T08	13800



Screwdriver

AS
80 950 ...



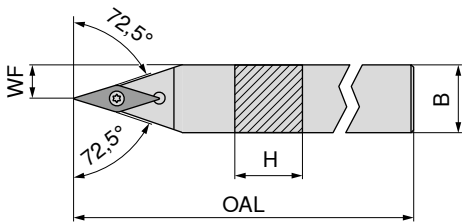
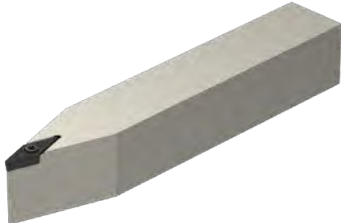
Clamping screw

AS
70 950 ...

CoreLine – SVVC 72.5° – Tool holder with screw clamping

Scope of supply:

Tool holder with Torx key



Neutral

Designation	H mm	B mm	OAL mm	WF mm	Tightening torque Nm	Indexable insert
SVVC N 1212 F11	12	12	80	6.0	1,2	VC.. 1103
SVVC N 1616 H11	16	16	100	8.0	1,2	VC.. 1103
SVVC N 2020 K11	20	20	125	10.0	1,2	VC.. 1103
SVVC N 2525 M11	25	25	150	12.5	1,2	VC.. 1103
SVVC N 2020 K16	20	20	125	10.0	3,2	VC.. 1604
SVVC N 2525 M16	25	25	150	12.5	3,2	VC.. 1604
SVVC N 3225 P16	32	25	170	12.5	3,2	VC.. 1604

TO
70 666 ...
01200
01600
02000
02500
12000
12500
13200

Spare parts
for article number

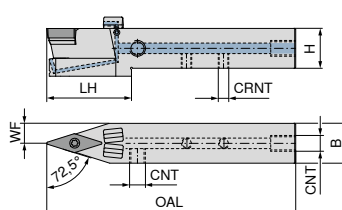
70 666 01200
70 666 01600
70 666 02000
70 666 02500
70 666 12000
70 666 12500
70 666 13200

Screwdriver	Clamping screw	Carbide seat V	Threaded bush
AS	AS	AS	AS
80 950 ...	70 950 ...	70 950 ...	70 950 ...
039	857		
039	857		
039	857		
039	857		
120	87900	107	171
120	87900	107	171
120	87900	107	171

CoreLine – SVVC 72.5° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Neutral

Designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Tightening torque Nm	Indexable insert
SVVC N 1212 F11 DC	12	12	80	29.0	6.0	M6	M6	1,2	VC.. 1103
SVVC N 1616 H11 DC	16	16	100	29.5	8.0	M6	G1/8"	1,2	VC.. 1103
SVVC N 2020 K11 DC	20	20	125	43.0	10.0	M6	G1/8"	1,2	VC.. 1103
SVVC N 2525 M11 DC	25	25	150	43.0	12.5	M6	G1/8"	1,2	VC.. 1103
SVVC N 2020 K16 DC	20	20	125	43.0	10.0	M6	G1/8"	3,2	VC.. 1604
SVVC N 2525 M16 DC	25	25	150	43.0	12.5	M6	G1/8"	3,2	VC.. 1604
SVVC N 3225 P16 DC	32	25	170	44.0	12.5	G1/8"	G1/8"	3,2	VC.. 1604

TO
70 781 ...
01200
01600
02000
02500
12000
12500
03200

Spare parts for article number

70 781 01200
70 781 01600
70 781 02000
70 781 02500
70 781 12000
70 781 12500
70 781 03200

Clamping screw	Carbide seat V	Set Screw	Set Screw	Threaded bush
AS	AS	AS	AS	AS
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
857			86700	
857		88000	86700	
857		88000	86700	
857		88000	86700	
87900	107	88000	86700	171
87900	107	88000	86700	171
87900	107	88000		171

Spare parts for article number

70 781 01200
70 781 01600
70 781 02000
70 781 02500
70 781 12000
70 781 12500
70 781 03200

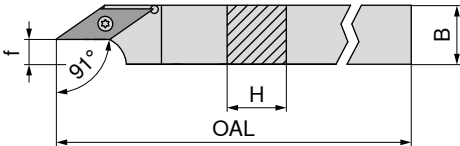
Sealing plugs DC	Screwdriver	O ring	Coolant nozzle DC	Coolant screw plug
AS	AS	AS	AS	AS
70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...
	039			
87600	039	88100	87700	294
87600	039	88100	87800	294
87600	039	88100	87700	294
87600	120	88100	87800	294
87600	120	88100	87800	294
87600	120	88100	87700	294

CoreLine – SVXC 91° – Tool holder with screw clamping

▲ For sliding head lathes

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

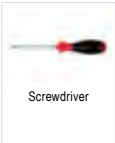


Designation	H mm	B mm	OAL mm	f mm	Tightening torque Nm	Indexable insert
SVXC R/L 1010 H11	10	10	100	2.5	1,2	VC.. 1103
SVXC R/L 1212 H11	12	12	100	4.5	1,2	VC.. 1103
SVXC R/L 1616 K11	16	16	125	8.5	1,2	VC.. 1103
SVXC R/L 2020 K16	20	20	125	8.5	3,2	VC.. 1604

Left	Right
TO	TO
70 691 ...	70 690 ...
010	010
012	012
016	016
020	020

Spare parts
for article number

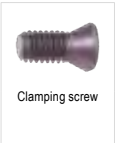
70 690 010 / 70 691 010	T08	110	M2,5x6 - T08	13800
70 690 012 / 70 691 012	T08	110	M2,5x6 - T08	13800
70 690 016 / 70 691 016	T08	110	M2,5x6 - T08	13800
70 690 020 / 70 691 020	T15	113	M3,5x11	113



Screwdriver

AS

80 950 ...



Clamping screw

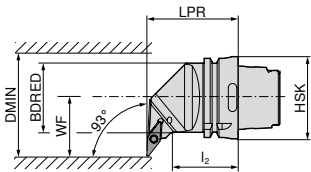
AS

70 950 ...

CoreLine – SVUC 93° – Tool holder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Left Right

Designation	Adapter	LPR mm	I ₂ mm	BDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	TO 74 557 ... 516	TO 74 558 ... 516
HSK T63 SVUC R/L 16	HSK-T 63	70	42	53	45	100	3.2	VC.. 1604		

Spare parts
for article number

74 558 516 / 74 557 516



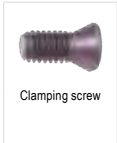
Combi key

AS

70 950 ...

T15/SW

398



Clamping screw

AS

70 950 ...

M3,5x11

113



Carbide seat V

AS

70 950 ...

107



Threaded bush

AS

70 950 ...

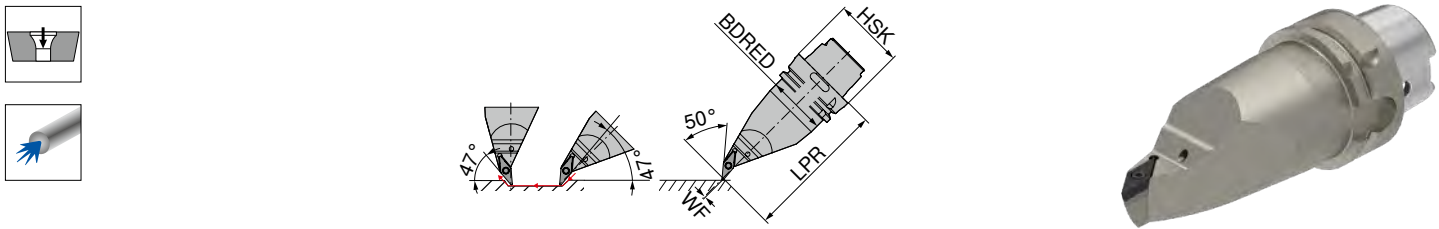
M3,5

171

CoreLine – SVMC 50° – Tool holder with screw clamping

Scope of supply:

Tool holder with Torx key



Designation	Adapter	LPR mm	BDRED mm	WF mm	Tightening torque Nm	Indexable insert
HSK T63 SVMC L 16	HSK-T 63	130	53	0	3.2	VC.. 1604

Left
TO
74 560 ...
516



The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra.

Spare parts
for article number

74 560 516	T15/SW	398	M3,5x11	113	107	M3,5	171
------------	--------	-----	---------	-----	-----	------	-----


Combi key

AS

70 950 ...


Clamping screw

AS

70 950 ...


Carbide seat V

AS

70 950 ...

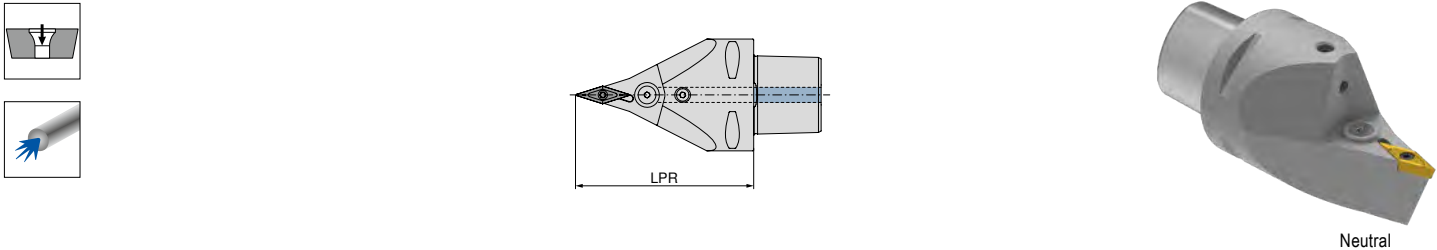

Threaded bush

AS

70 950 ...

CoreLine – SVVC 72.5° – Tool holder with screw clamping

Scope of supply:
Without high-performance coolant set



Designation	Adapter	LPR mm	Tightening torque Nm	Indexable insert	Direct cooling compatible	TO 84 678 ... 01693 11693
PSC63 SVVC N 0100-16	PSC 63	100	3	VC.. 1604	DC	
PSC63 SVVC N 0130-16	PSC 63	130	3	VC.. 1604	DC	

 The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra.



Clamping screw

AS

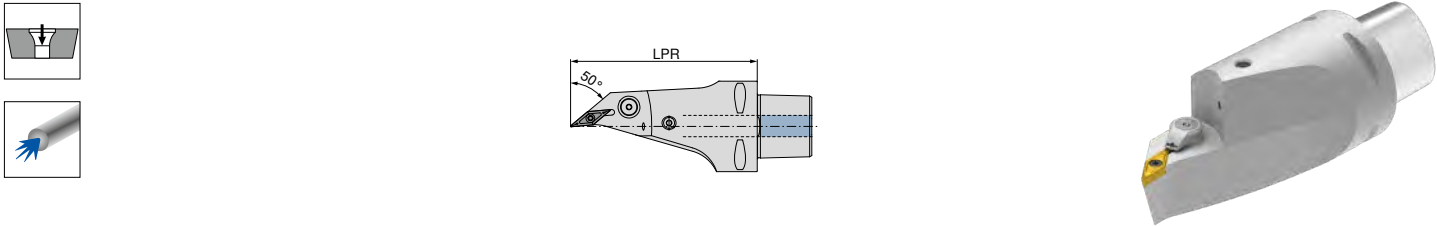
84 950 ...

27600
27600

Spare parts for article number
84 678 01693
84 678 11693

CoreLine – SVMC 50° – Tool holder with screw clamping

Scope of supply:
Without high-performance coolant set



Designation	Adapter	LPR mm	Tightening torque Nm	Indexable insert	Direct cooling compatible
PSC63 SVMC L 0130-16	PSC 63	130	3	VC.. 1604	DC

Neutral

TO

84 681 ...

11693



The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra.

Spare parts
for article number

84 681 11693



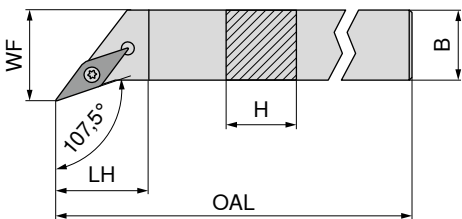
Clamping screw

AS

84 950 ...

27600

CoreLine – SVHC 107.5° – Tool holder with screw clamping



Illustrations show right-hand versions



Left Right

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Tightening torque Nm	Indexable insert
SVHC R/L 3225 P22	32	25	170	19.6	32	5	VC.. 2205

TO	TO
70 705 ...	70 704 ...
232	232

Spare parts
for article number

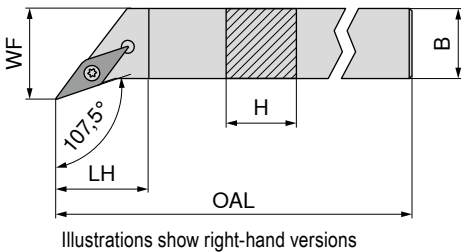
70 704 232 / 70 705 232

			
Combi key	Clamping screw	Carbide seat V	Threaded bush
AS	AS	AS	AS
70 950 ...	70 950 ...	70 950 ...	70 950 ...
398	114	109	170

CoreLine – SVHC 107.5° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	Left	Right
							TO 78 569 ... 01223 01643	TO 78 568 ... 01223 01643
SVHC R/L 12-3B	0.750	0.750	4.500	0.744	1.000	VC..33..		
SVHC R/L 16-3D	1.000	1.000	6.000	0.756	1.250	VC..33..		

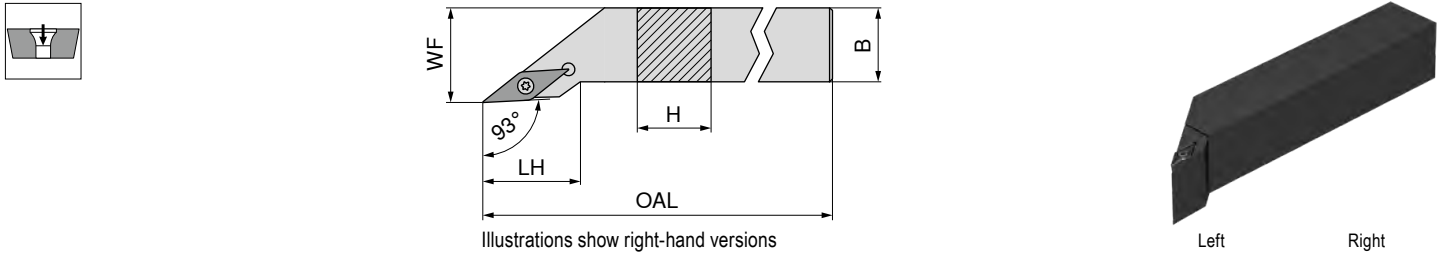
Spare parts

78 568 01223 / 78 569 01223

			
Clamping screw	Carbide seat V	Threaded bush	Key I - TORX®
AS 78 950 ... 05100	AS 78 950 ... 05500	AS 78 950 ... 05300	AS 78 950 ... 05400

CoreLine – SVJC 93° – Toolholder with screw clamping

Scope of supply:
Tool holder with Torx key

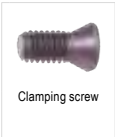


ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert	Left TO 78 571 ...	Right TO 78 570 ...
SVJC R/L 12-3B	0.750	0.750	4.500	1.610	1.000	VC..33..	01223	01223
SVJC R/L 16-3D	1.000	1.000	6.000	1.610	1.250	VC..33..	01643	01643
SVJC R/L 20-3D	1.250	1.250	6.000	1.610	1.500	VC..33..	02043 ¹⁾	02043 ¹⁾

1) Not in stock

Spare parts

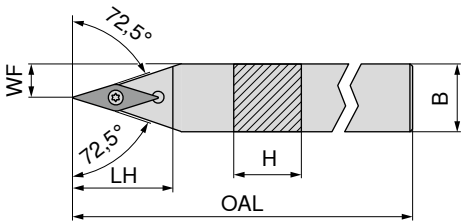
78 570 01223 / 78 571 02043

 Clamping screw	 Carbide seat V	 Threaded bush	 Key 1 - TORX®
AS 78 950 ... 05100	AS 78 950 ... 05500	AS 78 950 ... 05300	AS 78 950 ... 05400

CoreLine – SVVC 72.5° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



ANSI designation	H inch	B inch	OAL inch	LH inch	WF inch	Indexable insert
SVVC N 12-3B	0.750	0.750	4.500	1.212	0.398	VC..33..
SVVC N 16-3D	1.000	1.000	6.000	1.610	0.523	VC..33..
SVVC N 20-3D	1.250	1.250	6.000	2.008	0.648	VC..33..

Neutral
TO
78 585 ...
01223
01643
02043 ¹⁾

1) Not in stock

Spare parts

78 585 01223 / 78 585 02043

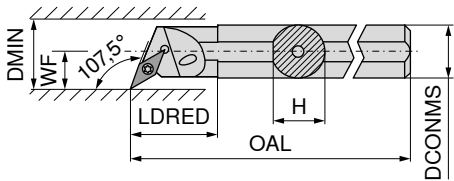
			
Clamping screw	Carbide seat V	Threaded bush	Key 1 - TORX®
AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...
05100	05500	05300	05400

CoreLine – SVQC 107.5° – Boring bar with screw clamping

- ▲ A... = with thru coolant
- ▲ S... = without thru coolant

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



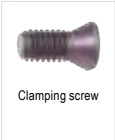
ANSI designation	DCONMS inch	H inch	OAL inch	LDRED inch	WF inch	DMIN inch	Indexable insert
S16T SVQC R/L 3	1.000	0.900	12.000	0.910	0.750	1.375	VC..33..
S20U SVQC R/L 3	1.250	1.180	14.000	1.060	0.875	1.625	VC..33..
S24V SVQC R/L 3	1.500	1.370	16.000	1.370	1.063	2.000	VC..33..

Left	Right
TO	TO
78 727 ...	78 726 ...
31626 ¹⁾	31626 ¹⁾
32030 ¹⁾	32030 ¹⁾
32435 ¹⁾	32435 ¹⁾

1) Not in stock

Spare parts

78 726 32030 / 78 727 32435	05100	05500	05300	05400
78 726 31626 / 78 727 31626	05600			05700

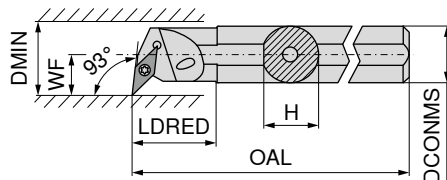
 Clamping screw	 Carbide seat V	 Threaded bush	 Key 1 - TORX®
AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...

CoreLine – SVUC 93° – Boring bar with screw clamping

- ▲ A... = with thru coolant
 ▲ S... = without thru coolant

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



ANSI designation	DCONMS inch	H inch	OAL inch	LDRED inch	WF inch	DMIN inch	Indexable insert
S10R SVUC R/L 2E	0.625	0.580	8.000	1.060	0.500	0.867	VC..22..
S12S SVUC R/L 2E	0.750	0.710	10.000	1.580	0.625	1.060	VC..22..
S16T SVUC R/L 2D	1.000	0.900	12.000	1.810	0.750	1.300	VC..22..
S20U SVUC R/L 3	1.250	1.180	14.000	3.000	1.000	2.000	VC..33..
S24V SVUC R/L 3	1.500	1.370	16.000	3.000	1.250	2.250	VC..33..
S32W SVUC R/L 3	2.000	1.870	18.000	4.000	1.375	2.750	VC..33..

Left

Right

TO	TO
78 729 ...	78 728 ...
21021 ¹⁾	21021 ¹⁾
21222 ¹⁾	21222 ¹⁾
21626 ¹⁾	21626 ¹⁾
32030 ¹⁾	32030 ¹⁾
32435 ¹⁾	32435 ¹⁾
33243 ¹⁾	33243 ¹⁾

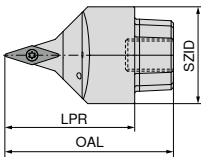
1) Not in stock

Spare parts

78 728 32030 / 78 729 33243
 78 728 21021 / 78 729 21626

			
Clamping screw	Carbide seat V	Threaded bush	Key 1 - TORX®
AS	AS	AS	AS
78 950 ...	78 950 ...	78 950 ...	78 950 ...
05100 06200	05500	05300	05400 06400

MaxiTurn – SVXC 0° – Tool head for axial clamping – OvalFlex



Neutral

Designation	LPR mm	OAL mm	WF mm	SZID	Indexable insert
OC50 SVXC N 16	67	89	0	50	VC.. 160408

TO

74 598 ...

00002

Spare parts
for article number

74 598 00002



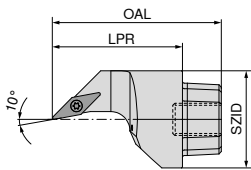
Clamping screw

AS

70 950 ...

M3,5x11113

MaxiTurn – SVXC 10° – Tool head for axial clamping – OvalFlex



Illustrations show right-hand versions



Left

Right

Designation	LPR mm	OAL mm	WF mm	SZID	Indexable insert
OC50 SVXC L 16	67	89	0	50	VC.. 160408
OC50 SVXC R 16	67	89	0	50	VC.. 160408

TO
74 598 ...
01001

TO
74 598 ...
01000

Spare parts
for article number

74 598 01001	M3,5x11
74 598 01000	M3,5x11

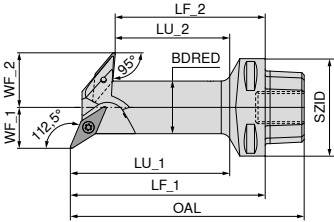


Clamping screw

AS
70 950 ...
113
113

MaxiTurn – Hub tool 112.5° for axial clamping – OvalFlex







Right

TO

74 595 ...

11200

Designation	LPR mm	OAL mm	BDRED mm	LF_1 mm	LF_2 mm	WF_1 mm	WF_2 mm	SZID	Indexable insert
OC50 D50 R 112.5H	100	120	27	100	77	21	28	50	VC.. 160408

Spare parts
for article number

74 595 11200



Combi key

AS

70 950 ...

T15/SW398



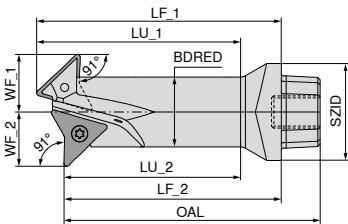
Clamping screw

AS

70 950 ...

M3,5x11113

MaxiTurn – Hub tool for axial clamping – HubStar



Right

Designation	LPR mm	OAL mm	BDRED mm	LF_1 mm	LF_2 mm	WF_1 mm	WF_2 mm	SZID	Indexable insert	<div>TO</div> <div>74 594 ...</div> <div>04800</div> <div>05600</div> <div>06000</div> <div>06500</div>
OC50 HUB48 R 12K	125	145	34	125	112	24.0	22.5	50	HUB 1206..	
OC50 HUB56 R 15K	125	145	36	125	112	28.0	26.5	50	HUB 1507..	
OC50 HUB60 R 15K	125	145	36	125	112	30.0	27.5	50	HUB 1507..	
OC50 HUB65 R 15K	125	145	41	125	112	32.5	30.0	50	HUB 1507..	

Spare parts
for article number

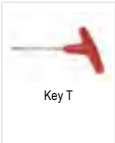
74 594 04800	T15	738			M4,5x12	114
74 594 05600			T20-IP	90800	M5x10,8 - 20IP	010
74 594 06000			T20-IP	90800	M5x10,8 - 20IP	010
74 594 06500			T20-IP	90800	M5x10,8 - 20IP	010



Key T

AS

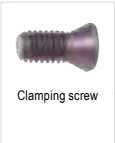
70 950 ...



Key T

AS

70 950 ...



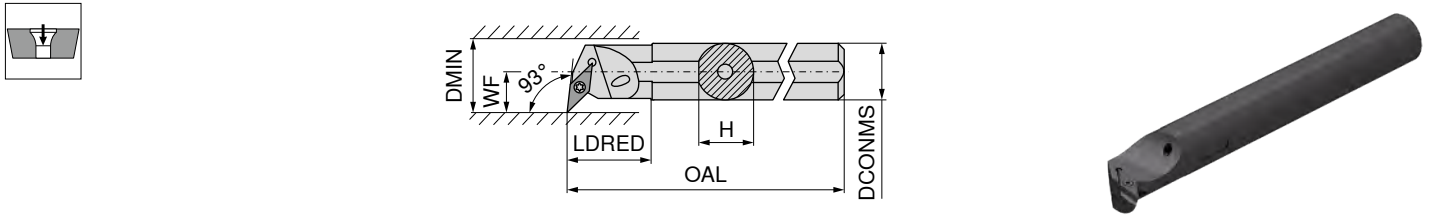
Clamping screw

AS

70 950 ...

CoreLine – SVUC 93° – Boring bar with screw clamping

Scope of supply:
Boring bar with Torx key



Illustrations show right-hand versions

Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	Left	Right
									TO 70 745 ...	TO 70 744 ...
A16M SVUC R/L 11	16	15	150	29	11	20	1,2	VC.. 1103	216	216
A20Q SVUC R/L 11	20	19	180	43	13	25	1,2	VC.. 1103	220	220
A25R SVUC R/L 11	25	24	200	38	17	32	1,2	VC.. 1103	225	225
A32S SVUC R/L 16	32	31	250	50	22	40	3,2	VC.. 1604	232	232
A40T SVUC R/L 16	40	39	300	60	27	50	3,2	VC.. 1604	240	240

Spare parts
for article number

	AS 80 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
70 744 216 / 70 745 216	110		13800		
70 744 220 / 70 745 220	110		13800		
70 744 225 / 70 745 225	110		13800		
70 744 232 / 70 745 232		398	113	107	171
70 744 240 / 70 745 240		398	113	107	171



Screwdriver

AS

80 950 ...



Combi key

AS

70 950 ...



Clamping screw

AS

70 950 ...



Carbide seat V

AS

70 950 ...



Threaded bush

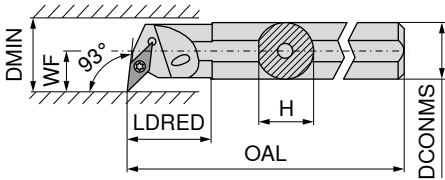
AS

70 950 ...

CoreLine – SVUC 93° – Boring bar with screw clamping

▲ Finish: Carbide

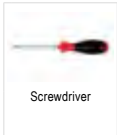
Scope of supply:
Boring bar with Torx key



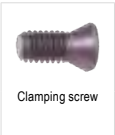
Illustrations show right-hand versions

Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	Left	Right
									TO 70 747 ...	TO 70 746 ...
E16R SVUC L 11	16	15.0	200	34	11	20	1,2	VC.. 1103	016	
E16R SVUC R 11	16	15.5	200	34	11	20	1,2	VC.. 1103		016
E20S SVUC L 11	20	18.5	250	38	13	25	1,2	VC.. 1103	020	
E20S SVUC R 11	20	19.0	250	38	13	25	1,2	VC.. 1103		020

Spare parts
for article number



Screwdriver

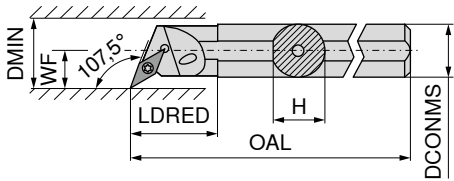


Clamping screw

				AS 80 950 ...	AS 70 950 ...
70 747 016	T08	110	M2,5x6 - T08		13800
70 746 016	T08	110	M2,5x6 - T08		13800
70 747 020	T08	110	M2,5x6 - T08		13800
70 746 020	T08	110	M2,5x6 - T08		13800

CoreLine – SVQC 107.5° – Boring bar with screw clamping

Scope of supply:
Boring bar with Torx key



Illustrations show right-hand versions

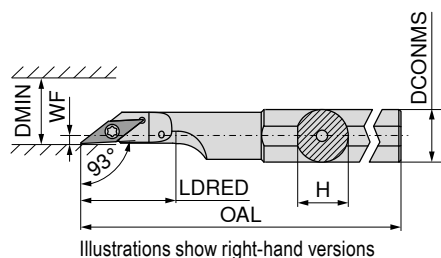
Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	Left	Right
									TO 70 749 ...	TO 70 748 ...
A16M SVQC R/L 11	16	15.0	150	29	11	20	1,2	VC.. 1103	216	216
A20Q SVQC R/L 11	20	18.5	180	32	13	25	1,2	VC.. 1103	220	220
A25R SVQC R/L 11	25	23.0	200	36	17	32	1,2	VC.. 1103	225	225
A32S SVQC R/L 16	32	30.0	250	50	22	40	3,2	VC.. 1604	232	232
A40T SVQC R/L 16	40	38.0	300	60	27	50	3,2	VC.. 1604	240	240

Spare parts
for article number

70 748 216 / 70 749 216
70 748 220 / 70 749 220
70 748 225 / 70 749 225
70 748 232 / 70 749 232
70 748 240 / 70 749 240

				
Screwdriver	Combi key	Clamping screw	Carbide seat V	Threaded bush
AS	AS	AS	AS	AS
80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
110		13800		
110		13800		
110		13800		
	398	113	107	171
	398	113	107	171

CoreLine – SVJC 93° – Boring bar with screw clamping



Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert
A16M SVJC R/L 11	16	15	150	50.0	2	22	1,2	VC.. 1103
A20M SVJC R/L 11	20	19	150	55.5	2	25	1,2	VC.. 1103
A25M SVJC R/L 16	25	24	150	58.0	5	28	3,2	VC.. 1604

Left Right

TO	TO
70 727 ...	70 726 ...
216	216
220	220
225	225

Spare parts for article number

70 726 216 / 70 727 216

70 726 220 / 70 727 220

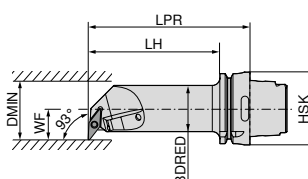
70 726 225 / 70 727 225

	
Screwdriver	Clamping screw
AS	AS
80 950 ...	70 950 ...
110	13800
110	13800
113	174

CoreLine – SVUC 93° – Boring bar with screw clamping

Scope of supply:

Boring bar with Torx key



Illustrations show right-hand versions



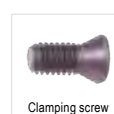
Left Right

Designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert
HSK T63 40L SVUC R/L 16	HSK-T 63	140	114	40	27	50	3.2	VC.. 1604

TO	TO
74 568 ...	74 567 ...
516	516

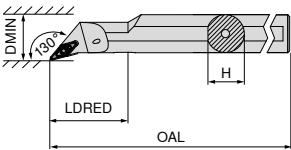
Spare parts for article number

74 567 516 / 74 568 516



AS	AS	AS	AS
70 950 ...	70 950 ...	70 950 ...	70 950 ...
T15/SW	M3,5x11	107	M3,5
398	113		171

CoreLine – SVXC 130° – Boring bar with screw clamping



Designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert
A40S SVXC R 22	40	37	250	80	27	45	5	VCG. 2205..

Right

TO

70 726 ...
24000

Spare parts
for article number

70 726 24000



Clamping screw

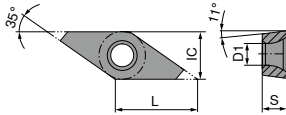
AS

70 950 ...

114

VPGT / VPET / VPXT

Designation	L	S	D1	IC
	mm	mm	mm	mm
VP.T 1003..	10	3.18	4.4	6.35



CoreLine – Carbide turning indexable insert

VPGT

		-FL WPU7610	-FR WPU7610	-FL TiAIN+	-FR TiAIN+	-FL WUU7620	-FR WUU7620
		F VPGT	F VPGT	F VPGT	F VPGT	F VPGT	F VPGT
		TR	TR	TR	TR	TR	TR
ISO	RE mm	72 405 ...	72 404 ...	72 493 ...	72 492 ...	72 493 ...	72 492 ...
1003ZZ	0.00	760 ²⁾	760 ¹⁾	500 ²⁾	500 ¹⁾	70000 ²⁾	70000 ¹⁾
1003008	0.08	728 ²⁾	728 ¹⁾	508 ²⁾	508 ¹⁾	70800 ²⁾	70800 ¹⁾
1003015	0.15	735 ²⁾	735 ¹⁾	515 ²⁾	515 ¹⁾	71500 ²⁾	71500 ¹⁾
P		●	●	●	●	●	●
M		●	●	●	●	●	●
K		○	○	○	○	○	○
N		●	●	○	○	○	○
S		●	●	●	●	○	○
H							
O		○	○	○	○	○	○

1) Note! Right-hand insert for right-hand holder

2) Note! Left-hand insert for left-hand holder

CoreLine – Carbide turning indexable insert

VPET

ISO	RE mm	-FL WUU7610		-FR WUU7610		-FL WPU7610		-FR WPU7610		-FL WPU7620		-FR WPU7620	
		F VPET		F VPET		F VPET		F VPET		F VPET		F VPET	
		TR		TR		TR		TR		TR		TR	
		72 403 ...		72 402 ...		72 403 ...		72 402 ...		72 403 ...		72 402 ...	
1003ZZ	0.00	060 ²⁾		060 ¹⁾		760 ²⁾		760 ¹⁾		560 ²⁾		560 ¹⁾	
1003008	0.08	028 ²⁾		028 ¹⁾		728 ²⁾		728 ¹⁾		528 ²⁾		528 ¹⁾	
1003015	0.15	035 ²⁾		035 ¹⁾		735 ²⁾		735 ¹⁾		535 ²⁾		535 ¹⁾	
P		○		○		●		●		●		●	
M		●		●		●		●		●		●	
K		○		○		○		○		○		○	
N		●		●		●		●		○		○	
S		○		○		●		●		●		●	
H													
O		●		●		○		○		○		○	

1) Note! Right-hand insert for right-hand holder
2) Note! Left-hand insert for left-hand holder

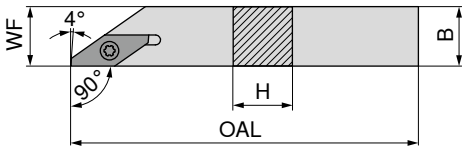
CoreLine – Carbide turning indexable insert

VPXT

ISO	RE mm	-EL TiAlN+		-ER TiAlN+	
		F VPXT		F VPXT	
		TR		TR	
		72 493 ...		72 492 ...	
1003015	0.15	615 ²⁾		615 ¹⁾	
1003035	0.35	635 ²⁾		635 ¹⁾	
P		●		●	
M		●		●	
K		○		○	
N		○		○	
S		●		●	
H					
O		○		○	

1) Note! Right-hand insert for right-hand holder
2) Note! Left-hand insert for left-hand holder

CoreLine – SVAP 90° – Tool holder with screw clamping – TriClamp



Illustrations show right-hand versions

Designation	H mm	B mm	OAL mm	WF mm	Indexable insert
SVAP R/L 0808 H10	8	8	100	8	VP.. 1003
SVAP R/L 1010 H10	10	10	100	10	VP.. 1003
SVAP R/L 1212 H10	12	12	100	12	VP.. 1003

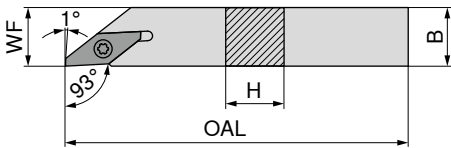
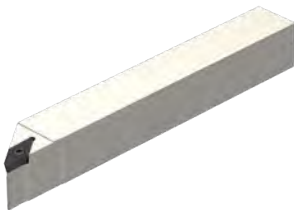
Left	Right
TO	TO
72 382 ...	72 380 ...
008	008
010	010
012	012

Spare parts
Indexable insert

VP.. 1003

	
Screwdriver	Clamping screw
AS	AS
80 950 ...	72 950 ...
T08 110	002

CoreLine – SVJP 93° – Tool holder with screw clamping – TriClamp



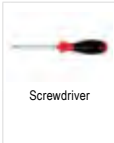
Illustrations show right-hand versions

Designation	H mm	B mm	OAL mm	WF mm	Indexable insert
SVJP R/L 0808 H10	8	8	100	8	VP.. 1003
SVJP R/L 1010 H10	10	10	100	10	VP.. 1003
SVJP R/L 1212 H10	12	12	100	12	VP.. 1003
SVJP R/L 1616 K10	16	16	125	16	VP.. 1003

Left	Right
TO	TO
72 386 ...	72 384 ...
008	008
010	010
012	012
016	016

Spare parts
Indexable insert

VP.. 1003



Screwdriver

AS

80 950 ...

T08 110



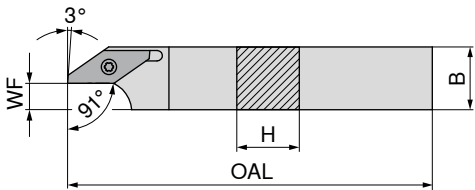
Clamping screw

AS

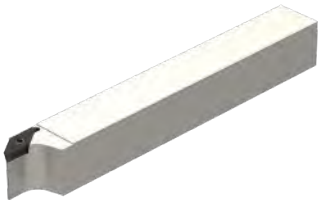
72 950 ...

002

CoreLine – SVXP 91° – Tool holder with screw clamping – TriClamp



Illustrations show right-hand versions



Designation	B mm	H mm	OAL mm
SVXP R/L 0808 H10	8	8	100
SVXP R/L 1010 H10	10	10	100
SVXP R/L 1212 H10	12	12	100
SVXP R/L 1616 K10	16	16	125

Indexable insert
VP.. 1003

Left	Right
TO	TO
72 390 ...	72 388 ...
008	008
010	010
012	012
016	016

Spare parts
Indexable insert

VP.. 1003



Screwdriver

AS

80 950 ...

T08 110



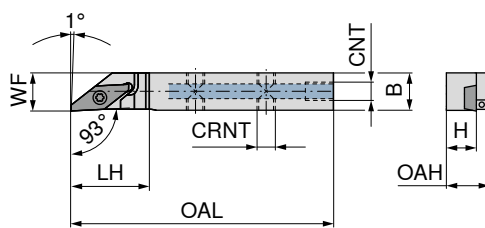
Clamping screw

AS

72 950 ...

002

Holder without coolant connection



Illustrations show right-hand versions



Left	Right
TO	TO
72 361 ...	72 360 ...
008	008
010	010
012	012
016	016
020	020

Screw plug

Screw plug

AS

72 950 ...



Screw plug

AS

72 950 ...



Screwdriver

AS

80 950 ...



Clamping screw

AS

72 950 ...

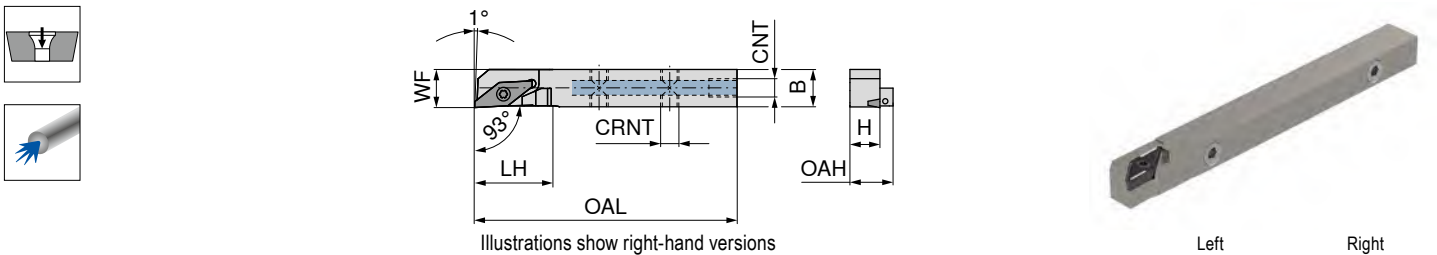
72 360 008 / 72 361 008			M5x4	011	T08	110	002
72 360 010 / 72 361 010			M5x4	011	T08	110	002
72 360 012 / 72 361 012			M5x4	011	T08	110	002
72 360 016 / 72 361 016	G1/8"	010	M5x4	011	T08	110	002
72 360 020 / 72 361 020	G1/8"	010	M5x4	011	T08	110	002



→ Find the right accessories here

CoreLine – SVJP 93°-VIC – Reinforced tool holder with screw clamping and through coolant – TriClamp

Scope of supply:
Holder without coolant connection



Designation	H mm	B mm	LH mm	WF mm	OAL mm	OAH mm	CRNT	CNT	Indexable insert
SVJP R/L 0810 H10 VIC	8	10	21	10	100	11.5	M5	M5	VP.. 1003
SVJP R/L 1010 H10 VIC	10	10	21	10	100	13.5	M5	M5	VP.. 1003
SVJP R/L 1212 H10 VIC	12	12	21	12	100	15.5	M5	M5	VP.. 1003

Left	Right
TO	TO
72 363 ...	72 362 ...
008	008
010	010
012	012

Spare parts
Indexable insert

VP.. 1003	M5x4	011	T08	110	002
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Screw plug

AS

72 950 ...



Screwdriver

AS

80 950 ...



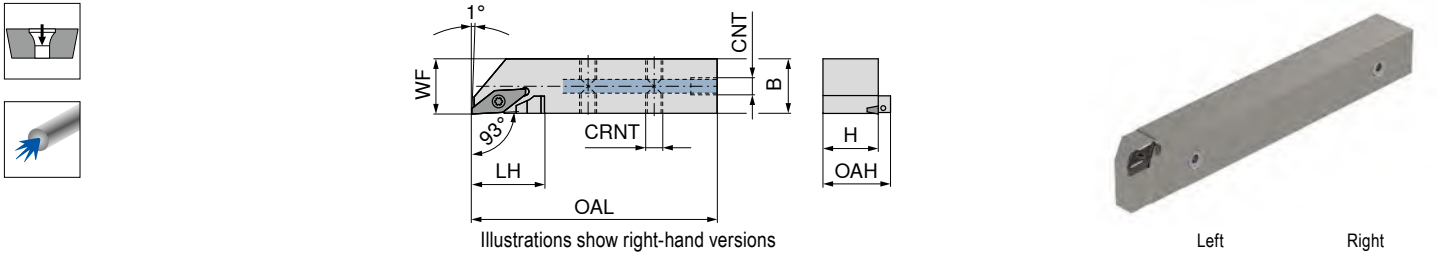
Clamping screw

AS

72 950 ...

CoreLine – SVJP 93°-VIC – Reinforced tool holder with screw clamping and through coolant – TriClamp

Scope of supply:
Holder without coolant connection



Designation	H mm	B mm	LH mm	WF mm	OAL mm	OAH mm	CRNT	CNT	Indexable insert	Left	Right
										TO	TO
SVJP R/L 1616 K10 VIC	16	16	21	16	125	19.5	M5	G1/8"	VP.. 1003	72 365 ...	72 364 ...
SVJP R/L 2020 K10 VIC	20	20	21	20	125	23.5	M5	G1/8"	VP.. 1003	016 020	016 020

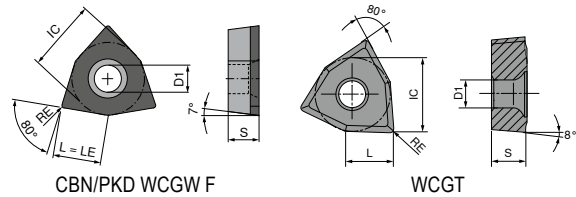
Spare parts
Indexable insert

VP.. 1003	G1/8"	010	M5x4	011	T08	110	002
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→ Find the right accessories here

WCGT / WCGW

Designation	L	S	D1	IC
	mm	mm	mm	mm
WCGW 0201..	2.70	1.58	2.3	3.97
WCGT 0201..	2.71	1.59	2.1	3.97



CoreLine – Carbide turning indexable insert

WCGT

		<div>-SF TCM10</div>			<div>-SF CTPP430</div>			<div>-SF H216T</div>								
		<div>DRAGONSKIN</div>														
		<div>○ ○ □</div>			<div>○ ○ □</div>			<div>○ ○ □</div>								
		<div></div>			<div></div>			<div></div>								
		<div>F</div>			<div>F</div>			<div>F</div>								
		<div>CERMET</div>			<div>WCGT</div>			<div>WCGT</div>								
		<div>WCGT</div>			<div>WCGT</div>			<div>WCGT</div>								
		<div>TR</div>			<div>TR</div>			<div>TR</div>								
		<div>70 287 ...</div>			<div>70 287 ...</div>			<div>70 287 ...</div>								
		<div>900</div>			<div>450</div>			<div>600</div>								
		<div>902</div>			<div>452</div>			<div>602</div>								
ISO	RE															
	mm															
020102EN	0.2															
020104EN	0.4															
P																
M																
K																
N																
S																
H																
O																

CoreLine – PCD turning indexable insert

WCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners

CTDPD20



F

DIAMOND

WCGW

PC

71 154 ...

100

102

ISO	RE mm	TCE (NOI)	LE mm
020102FN	0.2	F	2.7
020104FN	0.4	F	2.7

P

M

K

N

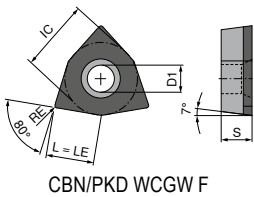
S

H

O

WCGW

Designation	L	S	D1	IC
	mm	mm	mm	mm
WCGW 0201..	2.7	1.58	2.3	3.97

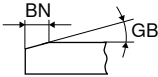


CBN/PKD WCGW F

CoreLine – PcBN turning indexable insert

WCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners



CTBS10U



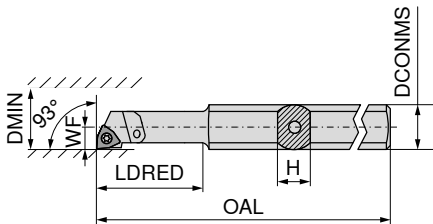
F
CBN
WCGW

ISO	RE	TCE (NOI)	LE
	mm		mm
020102FN	0.2	F	2.7

PC
71 154 ...
200

P	
M	
K	●
N	
S	●
H	
O	

CoreLine – SWUC 93° – Boring bar with screw clamping



Illustrations show right-hand versions

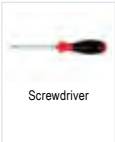


Designation	H mm	OAL mm	LDRED mm	WF mm	DCONMS mm	DMIN mm	Tightening torque Nm	Indexable insert
A0508H SWUC R/L 02	7	100	24	2.9	8	5.8	0,4	WC.. 0201..
A0608H SWUC R/L 02	7	100	24	3.9	8	7.8	0,4	WC.. 0201..

Left	Right
TO	TO
70 731 ...	70 730 ...
005	005
006	006

Spare parts
for article number

70 730 005 / 70 731 005	T06	108	M1,8x3,4	334
70 730 006 / 70 731 006	T06	108	M1,8x3,4	334



Screwdriver

AS
80 950 ...

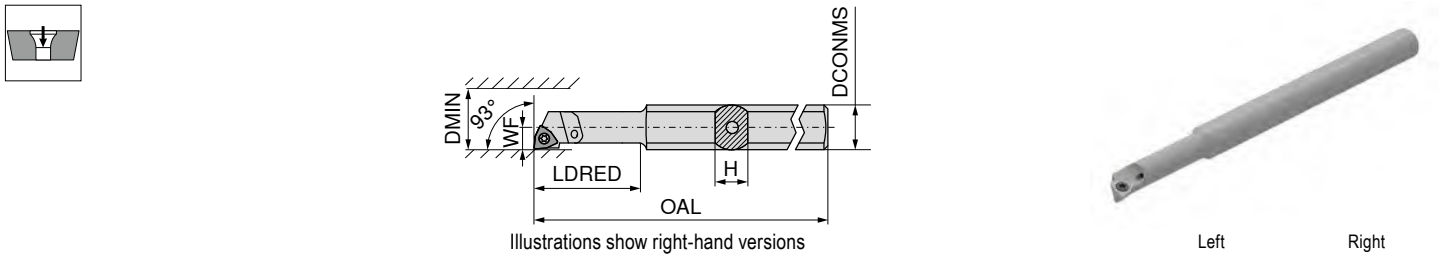


Clamping screw

AS
70 950 ...

CoreLine – SWUC 93° – Boring bar with screw clamping

▲ With carbide core



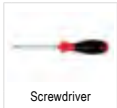
Designation	H mm	OAL mm	LDRED mm	WF mm	DCONMS mm	DMIN mm	Tightening torque Nm	Indexable insert	Left	Right
									TO	TO
E-A0508H SWUC R/L 02	7	100	24	2.9	8	5.8	0,4	WC.. 0201..	70 743 ... 005	70 742 ... 005
E-A0608H SWUC R/L 02	7	100	24	3.9	8	7.8	0,4	WC.. 0201..	006	006



Set contains boring bar **70 743 005** and **70 743 006** or **70 742 005** and **70 742 006**

Spare parts
for article number

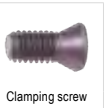
70 742 005 / 70 743 005	T06	108	M1,8x3,4	334
70 742 006 / 70 743 006	T06	108	M1,8x3,4	334



Screwdriver

AS

80 950 ...



Clamping screw

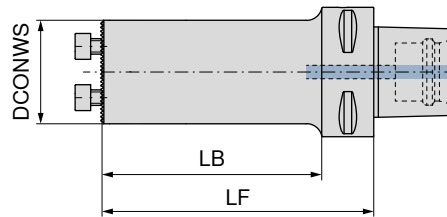
AS

70 950 ...

CoreLine – Base holders for the exchangeable head system – MaxiChange

Scope of supply:

Includes clamping screws



Adapter	LF mm	LB mm	DCONWS mm
PSC 40	40	20	16
PSC 40	50	30	20
PSC 40	55	35	25
PSC 40	75	55	32
PSC 40	80		40
PSC 50	40	20	16
PSC 50	50	30	20
PSC 50	55	35	25
PSC 50	75	55	32
PSC 50	100	80	40
PSC 63	40	18	16
PSC 63	50	28	20
PSC 63	65	43	25
PSC 63	90	68	32
PSC 63	125	103	32
PSC 63	100	78	40
PSC 63	140	118	40

TO

84 192 ...

01695
02095
02595
03295
04095

01694
02094
02594
03294
04094

01693
02093
02593
03293
13293
04093
14093

Spare parts for article number

84 192 01695	M3x10	44800
84 192 02095	M3,5x12	44900
84 192 02595	M4x12 (SW3)	30000
84 192 03295	M5x14 (SW4)	29900
84 192 04095	M6x16 (SW5)	29800
84 192 01694	M3x10	44800
84 192 02094	M3,5x12	44900
84 192 02594	M4x12 (SW3)	30000
84 192 03294	M5x14 (SW4)	29900
84 192 04094	M6x16 (SW5)	29800
84 192 01693	M3x10	44800
84 192 02093	M3,5x12	44900
84 192 02593	M4x12 (SW3)	30000
84 192 03293	M5x14 (SW4)	29900
84 192 13293	M5x14 (SW4)	29900
84 192 04093	M6x16 (SW5)	29800
84 192 14093	M6x16 (SW5)	29800



Clamping screw

AS

84 950 ...

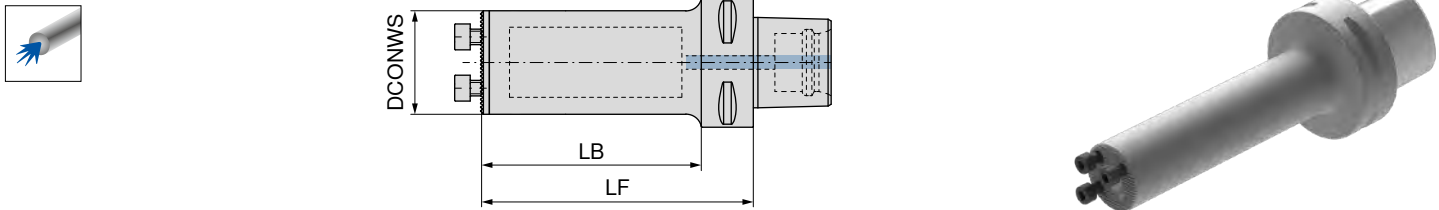
CoreLine

– Base holders for the exchangeable head system – Vibration-

damped – MaxiChange

▲ Heavy metal core reduces vibrations

Scope of supply:
Includes clamping screws

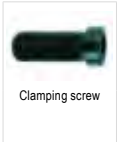


Adapter	LF mm	LB mm	DCONWS mm
PSC 63	115	93	25
PSC 63	150	128	32
PSC 63	185	163	40

TO
84 195 ...
02593
03293
04093

Spare parts
for article number

84 195 02593	M4X12 (SW3)
84 195 03293	M5X14 (SW4)
84 195 04093	M6X16 (SW5)



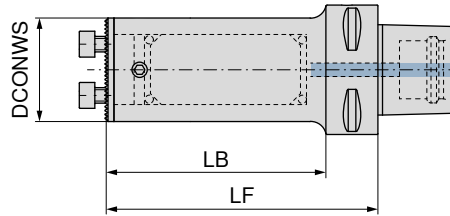
AS
84 950 ...
30000
29900
29800

MaxiTurn – Base holders for the exchangeable head system – Actively vibration-damped – MaxiChange

- ▲ Reduction in vibrations due to actively mounted dampers
- ▲ Improved surface quality and chip removal

Scope of supply:

Includes clamping screws



Adapter	LF mm	LB mm	DCONWS mm
PSC 40	88	68	16
PSC 40	107	87	20
PSC 40	132	112	25
PSC 40	154	134	32
PSC 40	173		40
PSC 50	85	65	16
PSC 50	109	89	20
PSC 50	133	113	25
PSC 50	180	160	25
PSC 50	154	134	32
PSC 50	224	204	32
PSC 50	194	174	40
PSC 50	288	268	40
PSC 63	90	68	16
PSC 63	110	88	20
PSC 63	132	110	25
PSC 63	180	158	25
PSC 63	230	208	25
PSC 63	159	137	32
PSC 63	224	202	32
PSC 63	288	266	32
PSC 63	198	176	40
PSC 63	288	266	40
PSC 63	368	346	40

TO

84 198 ...

31695
32095
42595
43295
44095

31694
32094
32594
42594
33294
43294
34094
44094

31693
32093
32593
42593
52593
33293
43293
53293
34093
44093
54093

Spare parts

DCONWS

16	M3x10	44800
20	M3,5x12	44900
25	M4x12 (SW3)	30000
32	M5x14 (SW4)	29900
40	M6x16 (SW5)	29800



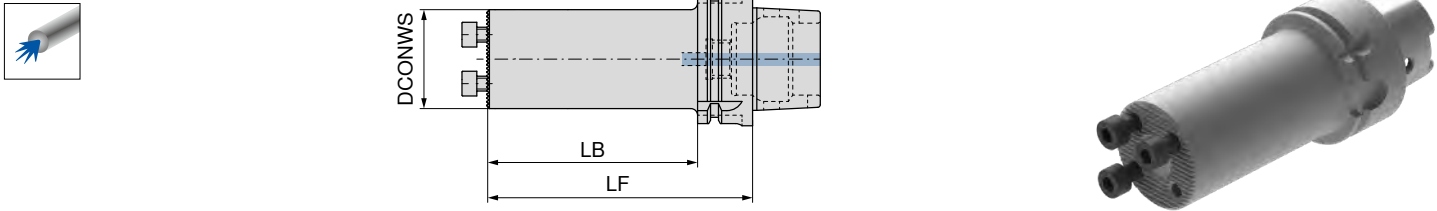
Clamping screw

AS

84 950 ...

CoreLine – Base holders for the exchangeable head system – MaxiChange

Scope of supply:
Includes clamping screws



Adapter	TO		
	LF mm	LB mm	DCONWS mm
HSK-T 40	55	35	25
HSK-T 40	75	55	25
HSK-T 40	80	60	32
HSK-T 40	80		40
HSK-T 63	56	30	16
HSK-T 63	80	54	20
HSK-T 63	80	44	25
HSK-T 63	90	64	32
HSK-T 63	100	74	40
HSK-T 63	125	99	32
HSK-T 63	140	114	40
HSK-T 100	140	111	40

84 193 ...

02539

12539

03239

04039

01637

02037

02537

03237

04037

13237

14037

04035

Spare parts
for article number

AS	
84 950 ...	
84 193 02539	M4X12 (SW3) 30000
84 193 12539	M4X12 (SW3) 30000
84 193 03239	M5X14 (SW4) 29900
84 193 04039	M6X16 (SW5) 29800
84 193 01637	M3x10 44800
84 193 02037	M3,5X12 44900
84 193 02537	M4X12 (SW3) 30000
84 193 03237	M5X14 (SW4) 29900
84 193 04037	M6X16 (SW5) 29800
84 193 13237	M5X14 (SW4) 29900
84 193 14037	M6X16 (SW5) 29800
84 193 04035	M6X16 (SW5) 29800

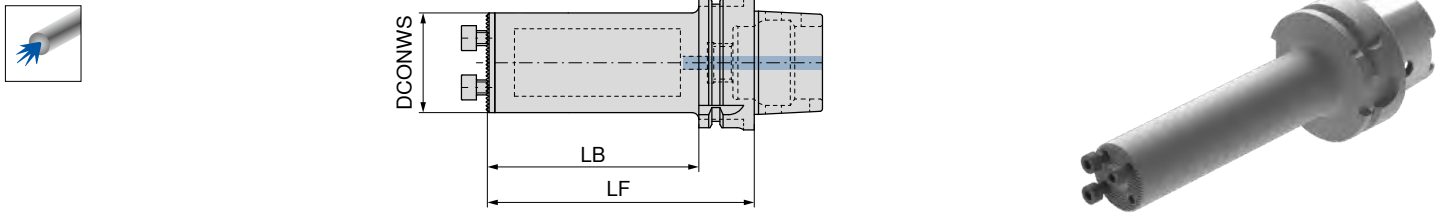
Clamping screw

CoreLine

– Base holders for the exchangeable head system – Vibration-damped – MaxiChange

▲ Heavy metal core reduces vibrations

Scope of supply:
Includes clamping screws

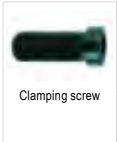


Adapter	LF mm	LB mm	DCONWS mm
HSK-T 63	115	89	25
HSK-T 63	150	124	32
HSK-T 63	185	159	40

TO
84 195 ...
02537
03237
04037

Spare parts
for article number

84 195 02537	M4X12 (SW3)
84 195 03237	M4X12 (SW3)
84 195 04037	M4X12 (SW3)

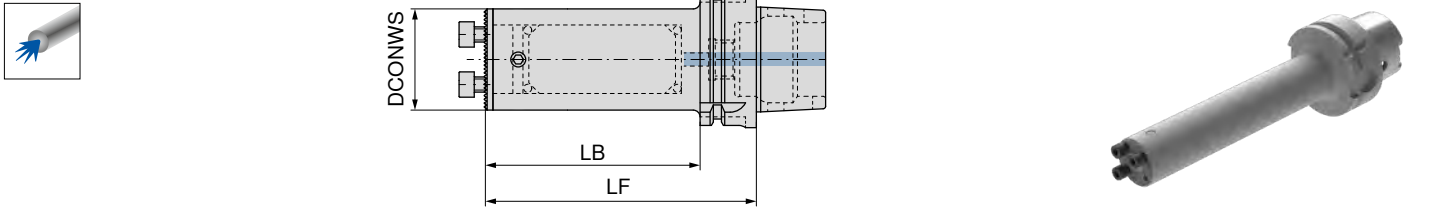


AS
84 950 ...
30000
30000
30000

MaxiTurn – Base holders for the exchangeable head system – Actively vibration-damped – MaxiChange

- ▲ Reduction in vibrations due to actively mounted dampers
- ▲ Improved surface quality and chip removal

Scope of supply:
Includes clamping screws

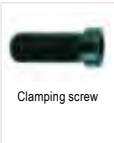


Adapter	LF mm	LB mm	DCONWS mm
HSK-T 63	90	64	16
HSK-T 63	106	80	20
HSK-T 63	126	100	25
HSK-T 63	151	125	25
HSK-T 63	154	128	32
HSK-T 63	186	160	32
HSK-T 63	186	160	40
HSK-T 63	226	200	40

TO
84 198 ...
31637
32037
32537
42537
33237
43237
34037
44037

Spare parts
for article number

84 198 31637	M3x10
84 198 32037	M3,5x12
84 198 32537	M4x12 (SW3)
84 198 42537	M4x12 (SW3)
84 198 33237	M5x14 (SW4)
84 198 43237	M5x14 (SW4)
84 198 34037	M6x16 (SW5)
84 198 44037	M6x16 (SW5)



Clamping screw

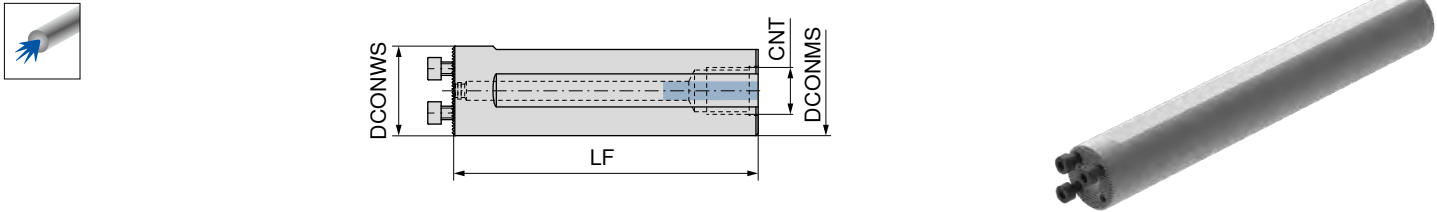
AS
84 950 ...
44800
44900
30000
30000
29900
29900
29800
29800

CoreLine

– Base holders for the exchangeable head system – Cylindrical – MaxiChange

- ▲ Connection thread for through coolant
- ▲ 3 clamping flats

Scope of supply:
Includes clamping screws



DCONWS	LF	DCONMS	CNT	TO	
mm	mm	mm		84 194 ...	
25	100	25	M8 x 1		12599
32	120	32	M8 x 1		13299
40	120	40	M8 x 1		14099
25	200	25	1/4		02599
32	218	32	3/8		03299
40	283	40	1/2		04099

Spare parts
for article number

84 194 12599	M4X12 (SW3)	30000
84 194 13299	M5X14 (SW4)	29900
84 194 14099	M6X16 (SW5)	29800
84 194 02599	M4X12 (SW3)	30000
84 194 03299	M5X14 (SW4)	29900
84 194 04099	M6X16 (SW5)	29800



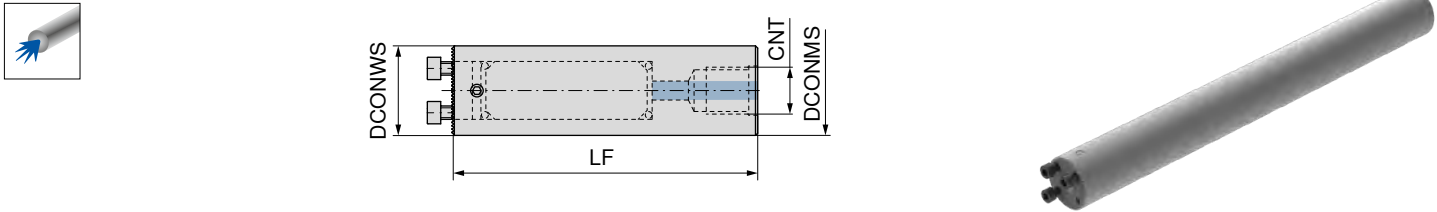
Clamping screw

AS
84 950 ...

MaxiTurn – Base holders for the exchangeable head system – Actively vibration-damped – MaxiChange

- ▲ Reduction in vibrations due to actively mounted dampers
- ▲ Improved surface quality and chip removal

Scope of supply:
Includes clamping screws

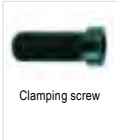


DCONWS	LF	DCONMS	CNT
mm	mm	mm	
16	170	16	1/4
20	200	20	1/4
25	255	25	1/4
32	320	32	1/2
40	408	40	1/2

TO
84 198 ...
31699
32099
32599
33299
34099

Spare parts
for article number

84 198 31699	M3x10
84 198 32099	M3,5x12
84 198 32599	M4x12 (SW3)
84 198 33299	M5x14 (SW4)
84 198 34099	M6x16 (SW5)



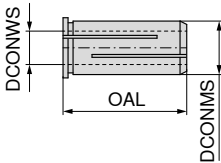
Clamping screw

AS
84 950 ...
44800
44900
30000
29900
29800

CoreLine – Cylindrical reduction sleeve for positioning

- ▲ Specially designed for MaxiChange cylindrical base holders with active vibration damping
- ▲ Simple tool clamping for correct center height

Scope of supply:
Reduction sleeve including locking device

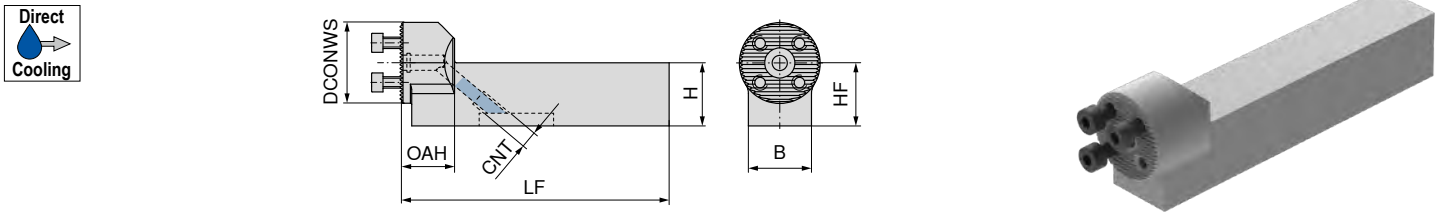


DCONWS ₁₇	DCONMS ₁₆	OAL
mm	mm	mm
16	20	55
20	25	61
25	32	65
32	40	75
40	50	95

AS
84 199 ...
01600
02000
02500
03200
04000

CoreLine – 0° base holders for the exchangeable head system – MaxiChange

Scope of supply:
Includes clamping screws



DCONWS	H	B	HF	OAH	LF	CNT	TO	
mm	mm	mm	mm	mm	mm		84 185 ...	
25	20	20	20	21	106	M8x1	02500	
32	20	20	20	21	106	M8x1	03200	
32	25	25	25	21	106	M8x1	13200	
40	25	25	25	21	106	M8x1	14000	

Spare parts
for article number

84 185 02500	M4X12 (SW3)	30000
84 185 03200	M5X14 (SW4)	29900
84 185 13200	M5X14 (SW4)	29900
84 185 14000	M6X16 (SW5)	29800

i

→ Adapters and accessories

Here you will find suitable base adapters.

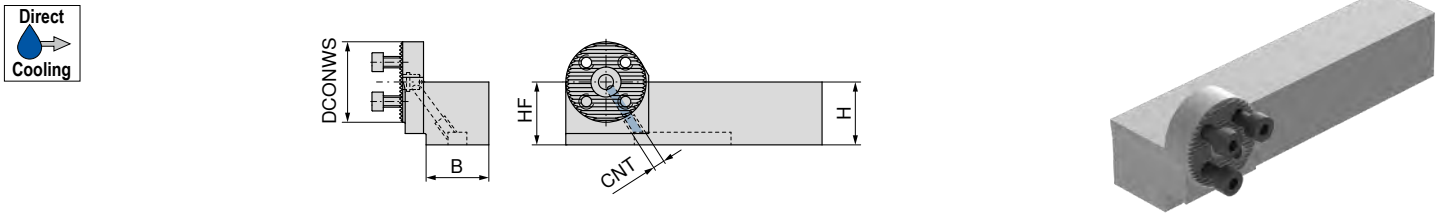


AS

84 950 ...

CoreLine – 90° base holders for the exchangeable head system – MaxiChange

Scope of supply:
Includes clamping screws



DCONWS	H	B	HF	CNT	TO
mm	mm	mm	mm		84 184 ...
25	20	20	20	M8x1	02500
32	20	20	20	M8x1	03200
32	25	25	25	M8x1	13200
40	25	25	25	M8x1	14000

Spare parts
for article number

84 184 02500	30000
84 184 03200	30000
84 184 13200	30000
84 184 14000	29800

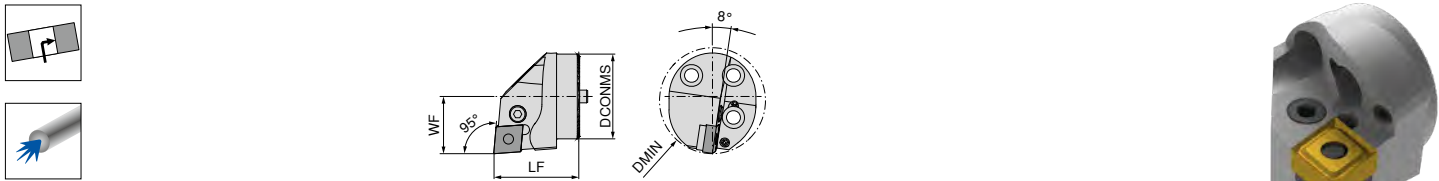
→ **Adapters and accessories**
Here you will find suitable base adapters.



AS

84 950 ...

CoreLine – PCLN 95° – Exchangeable cutting head with lever clamping – MaxiChange



Illustrations show right-hand versions

DCONMS mm	LF mm	DMIN mm	WF mm	Tightening torque Nm	Indexable insert
25	35	32	17	5	CN.. 1204
32	35	40	22	5	CN.. 1204
40	40	50	27	5	CN.. 1204

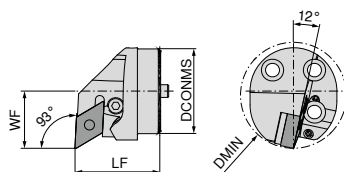
Left	Right
TO	TO
84 159 ...	84 160 ...
02500	02500
03200	03200
04000	04000

Spare parts
for article number

84 160 02500 / 84 159 02500	29200	M8X1/L17 SW3	28700	29000	27800
84 160 03200 / 84 159 03200	29200	M8X1/L17 SW3	28700	29000	27800
84 160 04000 / 84 159 04000	29200	M8X1/L17 SW3	28700	29000	27800

			
Shim	Toggle lever screw	Toggle lever	Carbide seat C
AS	AS	AS	AS
84 950 ...	84 950 ...	84 950 ...	84 950 ...

CoreLine – PDUN 93° – Exchangeable cutting head with lever clamping – MaxiChange



Illustrations show right-hand versions



Left

Right

DCONMS mm	LF mm	DMIN mm	WF mm	Tightening torque Nm	Indexable insert
25	35	32	17	5	DN.. 1104
32	35	40	22	5	DN.. 1104
32	35	40	22	5	DN.. 1504 / 1506
40	40	50	27	5	DN.. 1104
40	40	50	27	5	DN.. 1504 / 1506

TO	TO
84 161 ...	84 162 ...
02500	02500
03200	03200
13200	13200
04000	04000
14000	14000



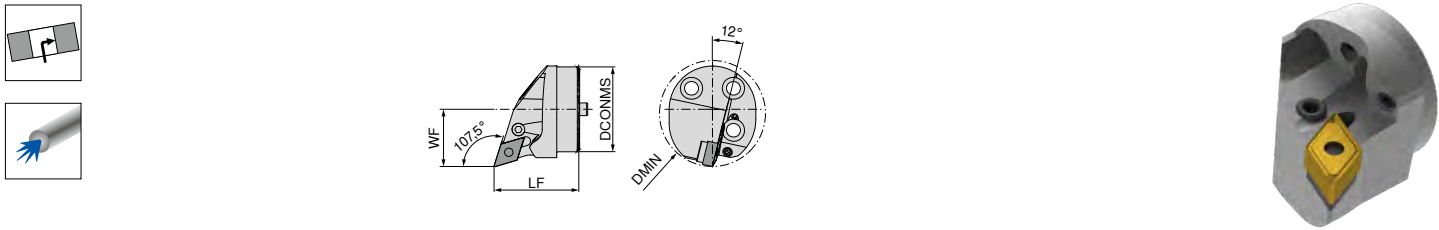
When working with DN.. 1504 use indexable insert shim article no. **84 950 28200**.

Spare parts for article number

84 162 02500 / 84 161 02500
84 162 03200 / 84 161 03200
84 162 13200 / 84 161 13200
84 162 04000 / 84 161 04000
84 162 14000 / 84 161 14000

Shim	Toggle lever screw	Toggle lever	Carbide seat D
AS	AS	AS	AS
84 950 ...	84 950 ...	84 950 ...	84 950 ...
29300	28800	29100	28100
29300	28800	29100	28100
29200	28700	28900	27900
29300	28800	29100	28100
29200	28700	28900	27900

CoreLine – PDQN 107.5° – Exchangeable cutting head with lever clamping – MaxiChange



Illustrations show right-hand versions

DCONMS mm	LF mm	DMIN mm	WF mm	Tightening torque Nm	Indexable insert
25	35	32	17	5	DN.. 1104
32	35	40	22	5	DN.. 1104
40	40	50	27	5	DN.. 1104

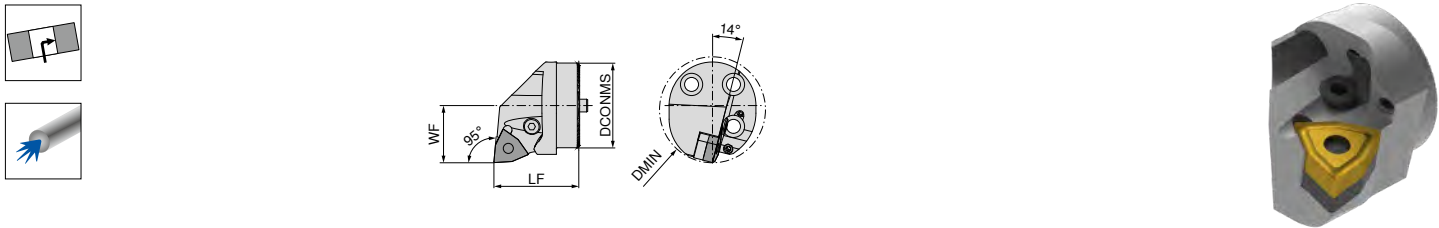
Left	Right
TO	TO
84 163 ...	84 164 ...
02500	02500
03200	03200
04000	04000

Spare parts
for article number

84 164 02500 / 84 163 02500
84 164 03200 / 84 163 03200
84 164 04000 / 84 163 04000

			
Shim	Toggle lever screw	Toggle lever	Carbide seat D
AS	AS	AS	AS
84 950 ...	84 950 ...	84 950 ...	84 950 ...
29300	28800	29100	28100
29300	28800	29100	28100
29300	28800	29100	28100

CoreLine – PWLN 95° – Exchangeable cutting head with lever clamping – MaxiChange



Illustrations show right-hand versions

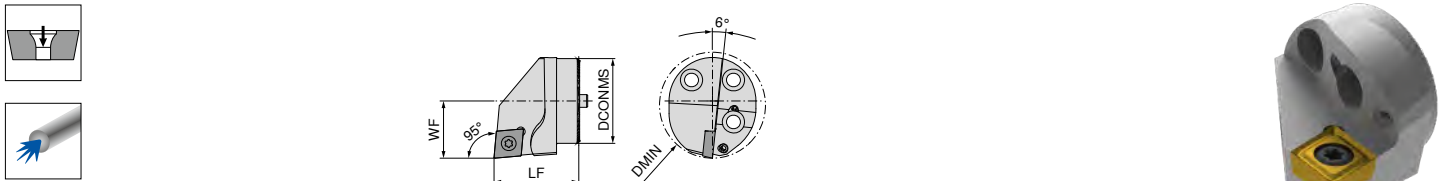
DCONMS mm	LF mm	DMIN mm	WF mm	Tightening torque Nm	Indexable insert	Left		Right	
						TO	TO	TO	TO
32	35	40	22	5	WN.. 0804	84 165 ...	84 166 ...	03200	03200
40	40	50	27	5	WN.. 0804	04000	04000	04000	04000

Spare parts
for article number

84 166 03200 / 84 165 03200	29200	M8X1/L17 SW3	28700	28900	27700
84 166 04000 / 84 165 04000	29200	M8X1/L17 SW3	28700	28900	27700

			
Shim	Toggle lever screw	Toggle lever	Carbide seat W
AS	AS	AS	AS
84 950 ...	84 950 ...	84 950 ...	84 950 ...

CoreLine – SCLC 95° – Exchangeable cutting head with screw clamping – MaxiChange



Illustrations show right-hand versions

DCONMS mm	LF mm	DMIN mm	WF mm	Tightening torque Nm	Indexable insert
16	20	20	11	0.9	CC.. 0602
20	20	25	13	3	CC.. 09T3
25	35	32	17	5	CC.. 1204
32	35	40	22	5	CC.. 1204
40	40	50	27	5	CC.. 1204

Left	Right
TO	TO
84 147 ...	84 148 ...
01600	01600
02000	02000
02500	02500
03200	03200
04000	04000

Spare parts
for article number

84 148 01600 / 84 147 01600
84 148 02000 / 84 147 02000
84 148 02500 / 84 147 02500
84 148 03200 / 84 147 03200
84 148 04000 / 84 147 04000



Clamping screw

AS

84 950 ...

44700

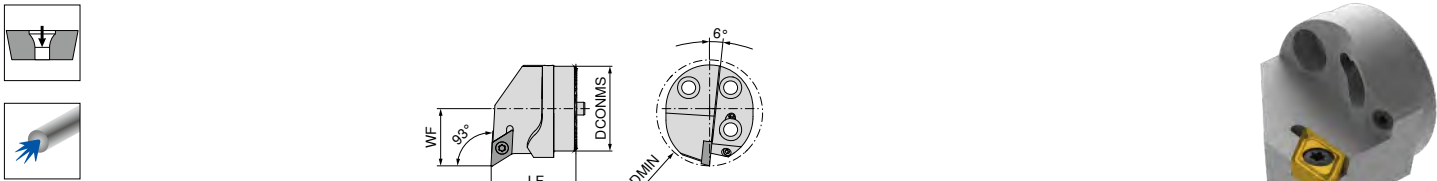
27600

27500

27500

27500

CoreLine – SDUC 93° – Exchangeable cutting head with screw clamping – MaxiChange



Illustrations show right-hand versions

DCONMS mm	LF mm	DMIN mm	WF mm	Tightening torque Nm	Indexable insert
16	20	20	11	0,9	DC.. 0702
20	20	25	13	3	DC.. 11T3
25	35	32	17	3	DC.. 11T3
32	35	40	22	3	DC.. 11T3
40	40	50	27	3	DC.. 11T3

Left	Right
TO	TO
84 143 ...	84 144 ...
01600	01600
02000	02000
02500	02500
03200	03200
04000	04000

Spare parts
for article number

84 144 01600 / 84 143 01600
84 144 02000 / 84 143 02000
84 144 02500 / 84 143 02500
84 144 03200 / 84 143 03200
84 144 04000 / 84 143 04000



Clamping screw

AS

84 950 ...

44700

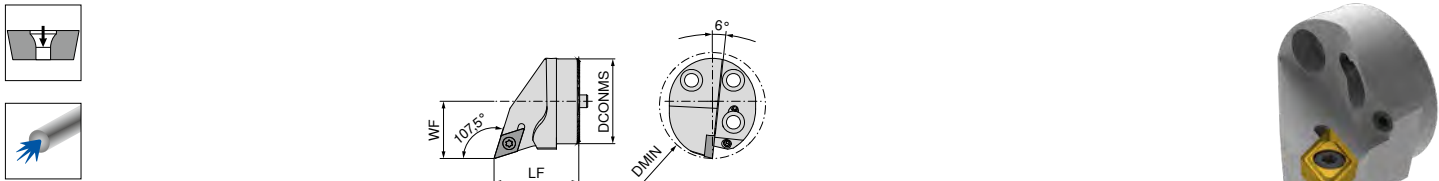
27600

27600

27600

27600

CoreLine – SDQC 107.5° – Exchangeable cutting head with screw clamping – MaxiChange



Illustrations show right-hand versions

DCONMS mm	LF mm	DMIN mm	WF mm	Tightening torque Nm	Indexable insert	Left	Right
						TO 84 145 ...	TO 84 146 ...
20	20	25	13	3	DC.. 11T3	02000	02000
25	35	32	17	3	DC.. 11T3	02500	02500
32	35	40	22	3	DC.. 11T3	03200	03200
40	40	50	27	3	DC.. 11T3	04000	04000

Spare parts
for article number

84 146 02000 / 84 145 02000	27600
84 146 02500 / 84 145 02500	27600
84 146 03200 / 84 145 03200	27600
84 146 04000 / 84 145 04000	27600



Clamping screw

AS

84 950 ...

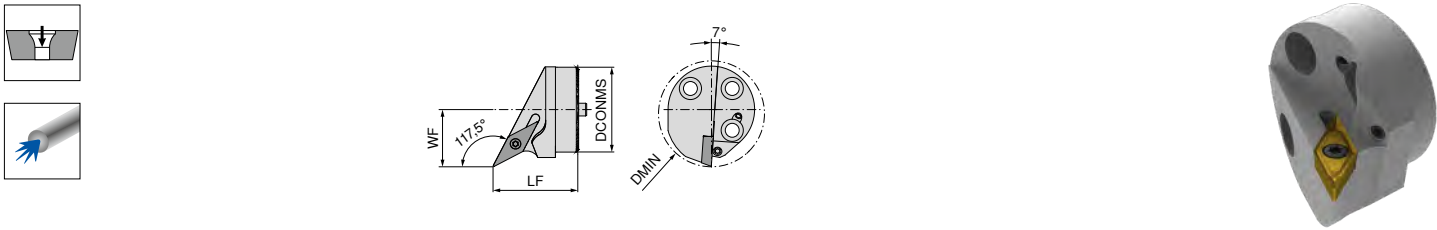
27600

27600

27600

27600

CoreLine – SVPC 117.5° – Exchangeable cutting head with screw clamping – MaxiChange



Illustrations show right-hand versions

DCONMS mm	LF mm	DMIN mm	WF mm	Tightening torque Nm	Indexable insert
25	35	32	17	3	VC.. 1103
32	35	40	22	3	VC.. 1604
40	40	50	27	3	VC.. 1604

Left	Right
TO	TO
84 176 ...	84 176 ...
12500	02500
13200	03200
14000	04000

Spare parts
for article number

84 176 02500 / 84 176 12500
84 176 03200 / 84 176 13200
84 176 04000 / 84 176 14000



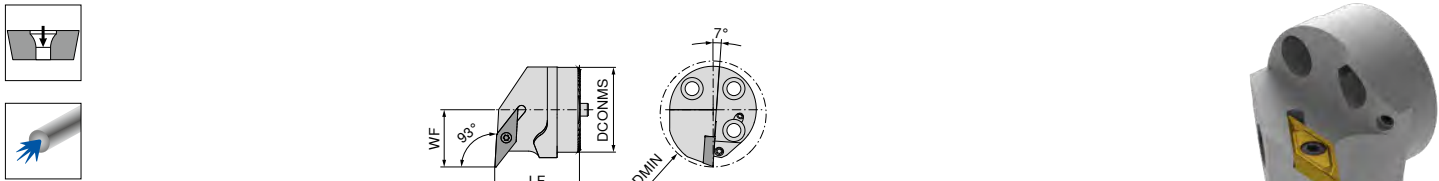
Clamping screw

AS

84 950 ...

44700
27600
27600

CoreLine – SVUC 93° – Exchangeable cutting head with screw clamping – MaxiChange



Illustrations show right-hand versions

DCONMS mm	LF mm	DMIN mm	WF mm	Tightening torque Nm	Indexable insert	Left	Right
						TO 84 177 ...	TO 84 177 ...
20	20	25	13	3	VC.. 1103	12000	02000
25	35	32	17	3	VC.. 1103	12500	02500
32	35	40	22	3	VC.. 1604	13200	03200
40	40	50	27	3	VC.. 1604	14000	04000

Spare parts
for article number

84 177 02000 / 84 177 12000	44700
84 177 02500 / 84 177 12500	44700
84 177 03200 / 84 177 13200	27600
84 177 04000 / 84 177 14000	27600

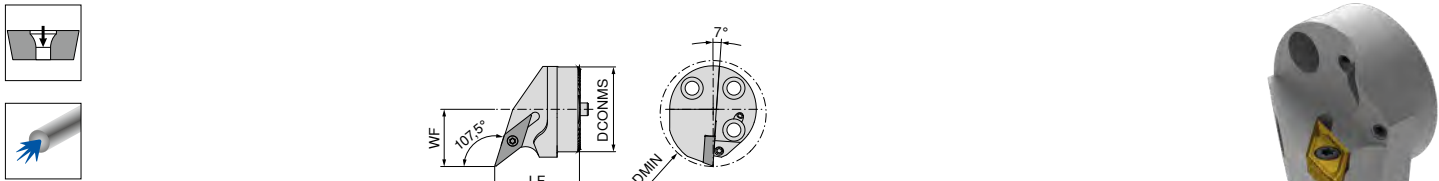


Clamping screw

AS

84 950 ...

CoreLine – SVQC 107.5° – Exchangeable cutting head with screw clamping – MaxiChange



Illustrations show right-hand versions

DCONMS mm	LF mm	DMIN mm	WF mm	Tightening torque Nm	Indexable insert
20	20	25	13	3	VC.. 1103
25	35	32	17	3	VC.. 1103
32	35	40	22	3	VC.. 1604
40	40	50	27	3	VC.. 1604

Left	Right
TO	TO
84 178 ...	84 178 ...
12000	02000
12500	02500
13200	03200
14000	04000

Spare parts
for article number

84 178 02000 / 84 178 12000	44700
84 178 02500 / 84 178 12500	44700
84 178 03200 / 84 178 13200	27600
84 178 04000 / 84 178 14000	27600

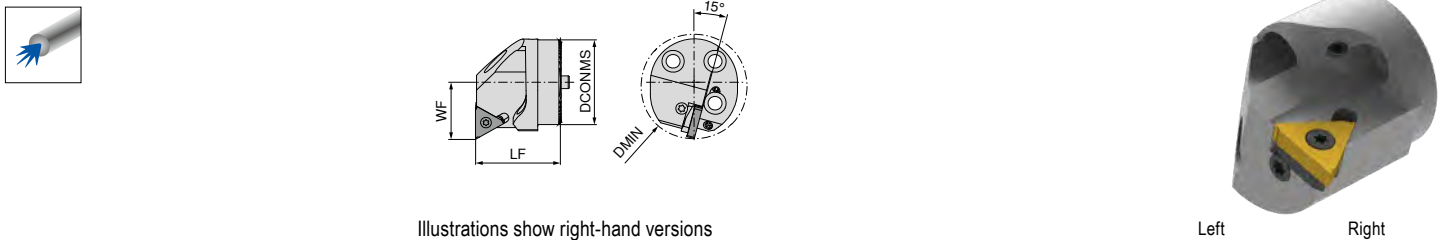


Clamping screw

AS

84 950 ...

CoreLine – Exchangeable cutting head for internal thread – MaxiChange



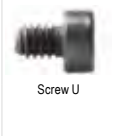
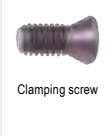
Illustrations show right-hand versions

DCONMS mm	LF mm	DMIN mm	WF mm	Tightening torque Nm	Indexable insert
25	35	32	17	2	16 ..
32	35	40	22	2	16 ..
40	40	50	27	2	16 ..

Left	Right
TO	TO
84 167 ...	84 168 ...
02500	02500
03200	03200
04000	04000

Spare parts
for article number

84 168 02500	29500	UNC5x7,3	29700	29400
84 167 02500	29600	UNC5x7,3	29700	29400
84 168 03200	29500	UNC5x7,3	29700	29400
84 167 03200	29600	UNC5x7,3	29700	29400
84 168 04000	29500	UNC5x7,3	29700	29400
84 167 04000	29600	UNC5x7,3	29700	29400

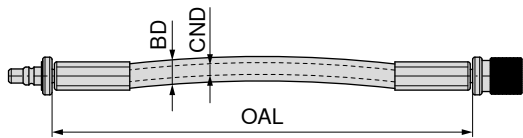
		
Shim	Screw U	Clamping screw
AS	AS	AS
84 950 ...	84 950 ...	84 950 ...



Suitable internal thread inserts can be found in the **Thread turning tools chapter**.

Flexible coolant hoses

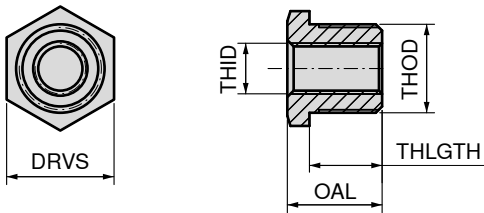
- ▲ Incl. prefitted quick-coupler and coupler connector
- ▲ Extremely flexible
- ▲ Pressure-resistant up to 300 bar



Designation	BD mm	CND mm	OAL mm
MU.KSS-DN3-150	6.0	3	150
MU.KSS-DN3-250	6.0	3	250
MU.KSS-DN5-200	9.5	5	200
MU.KSS-DN5-300	9.5	5	300
MU.KSS-DN5-400	9.5	5	400
MU.KSS-DN5-500	9.5	5	500

AS
72 990 ...
11005
11006
11001
11002
11003
11004

Threaded adapter

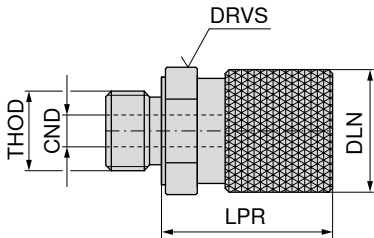


THID	THOD	THLGTH mm	DRVS mm	OAL mm
G1/8"	G1/4"	11.5	17	15.0
G1/8"	M8x1	11.5	14	15.0
G1/8"	M12x1	11.5	14	15.0
G1/8"	M14x1	11.5	17	15.0
M8x1	G1/4"	11.5	17	15.0
M8x1	M12x1	11.5	14	15.0
M8x1	M14x1	11.5	17	15.0
M8x1	G1/8"	11.5	14	23.5

AS
72 988 ...
01005
01006
01007
01008
01003
01001
01002
01004

Quick-coupler

- ▲ Pressure-resistant up to at least 400 bar
- ▲ Rapid change of coolant distribution without screws thanks to click system



THOD	BD	DLN	LPR	CND	DRVS
	mm	mm	mm	mm	mm
G1/8"	16	15.5	21.5	4	14

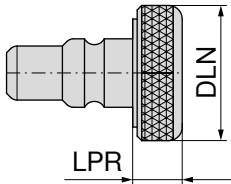
AS

72 993 ...

15001

Sealing plug

- ▲ For closing off the quick-coupler to protect against contamination



Designation	LPR	DLN
	mm	mm
MU.KSVS	5.5	15.5

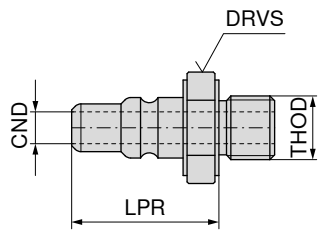
AS

72 994 ...

17001

Coupler connector

▲ Pressure-resistant up to at least 400 bar



Designation	LPR mm	CND mm	DRVS mm	OAL mm
MU.KSKS-M8x1	18.5	4	12	19

AS

72 992 ...

13001

G1/8" screw plug

▲ Maximum 200 bar/2900 psi
▲ No sealing ring required



Designation	THSZMS
VS.G1/8	G1/8"

AS

72 950 ...

010

Angled coolant connection for distributor



Designation	THOD	THID
MU.KS-KA-KSV	G1/8"	G1/8"

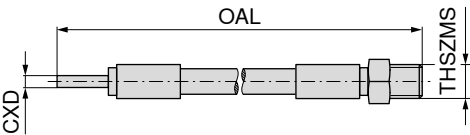
AS

72 987 ...

18003

Hose (connector/thread)

- ▲ Maximum 200 bar/2900 psi
- ▲ No sealing ring required

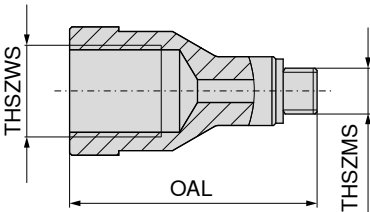


Designation	THSZMS	CXD mm	OAL mm
HDKS.150.M5-4	M5	4	150
HDKS.200.M5-4	M5	4	200
HDKS.300.M5-4	M5	4	300
HDKS.500.M5-4	M5	4	500

AS
72 305 ...
010
021
033
045

Reduction fitting

- ▲ Maximum 200 bar/2900 psi
- ▲ Including sealing ring

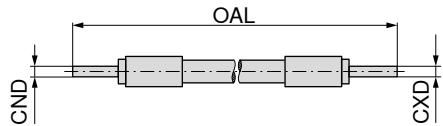


Designation	THSZWS	THSZMS	OAL mm
RV.100.M5-M6	M6	M5	15
RV.100.M5-M8x1	M8x1	M5	23
RV.100.M5-M10x1	M10x1	M5	27
RV.100.M5-G1/8	G1/8"	M5	27

AS
72 301 ...
001
003
005
004

Hose (connector/connector)

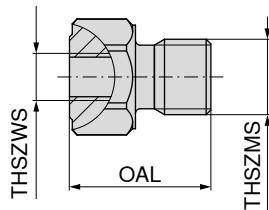
▲ Maximum 200 bar/2900 psi



Designation	CND mm	CXD mm	OAL mm	AS
HDKS.150.4-4	4	4	150	72 305 ...
HDKS.200.4-4	4	4	200	003
HDKS.300.4-4	4	4	300	014
HDKS.500.4-4	4	4	500	025
				037

Reduction fitting

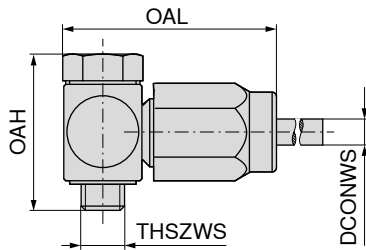
▲ Maximum 200 bar/2900 psi
▲ No sealing ring required



Designation	THSZWS	THSZMS	OAL mm	AS
RV.100.M6-M5	M5	M6	18	72 301 ...
RV.100.M8x1-M5	M5	M8x1	15	002
RV.100.M10x1-M5	M5	M10x1	15	008
RV.100.G1/8-M5	M5	G1/8"	15	007
				006

Swivel fitting

▲ Maximum 200 bar/2900 psi

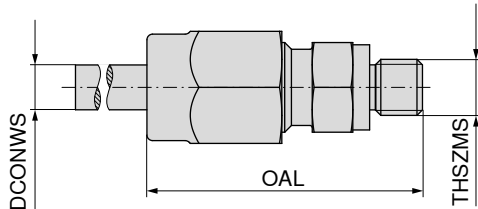


Designation	DCONWS mm	OAH mm	THSZMS	OAL mm
KA.SV.M5-4	4	21	M5	28
KA.SV.G1/8-4	4	30	G1/8"	37

AS
72 307 ...
017
012

Straight fitting

▲ Maximum 200 bar/2900 psi

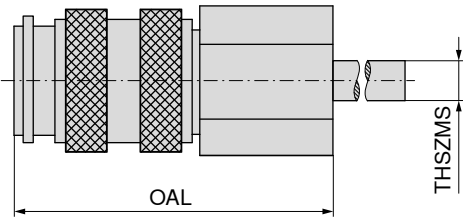


Designation	DCONWS mm	THSZMS	OAL mm
KA. M5-4	4	M5	27
KA. G1/8-4	4	G1/8"	32

AS
72 307 ...
009
003

Quick connection (coupling)

▲ Maximum 200 bar/2900 psi

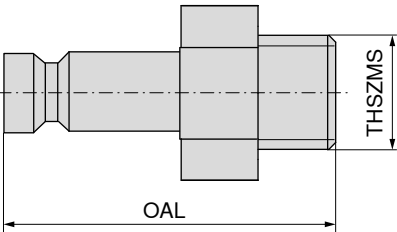


Designation	THSZMS	OAL mm
KIG.M5	M5	26

AS
72 319 ...
001

Quick connection (plug-in)

- ▲ Maximum 200 bar/2900 psi
- ▲ No sealing ring required



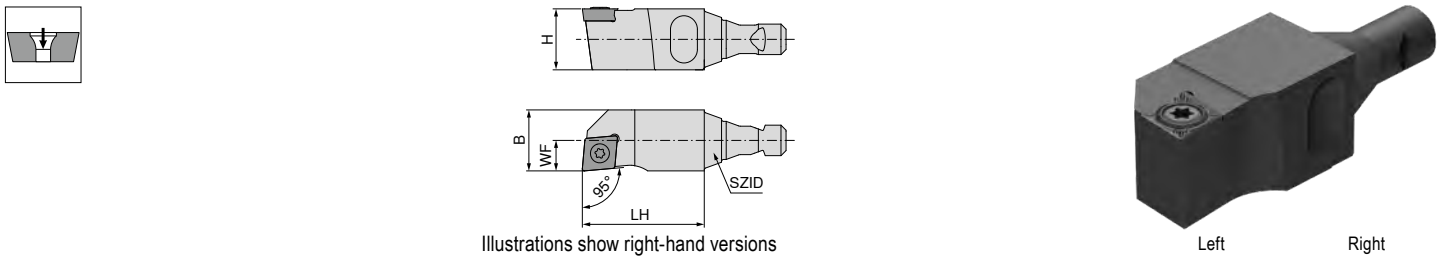
Designation	THSZMS	OAL mm
SAG.M5	M5	20

AS
72 320 ...
001



Sliding head tooling

CoreLine – Turning exchangeable head SCLC 95° – XheadClamp



Designation	SZID	H mm	B mm	LH mm	WF mm	Indexable insert	TO 72 809 ...	TO 72 808 ...
SCLC R/L 06 BH12	12	12	12	24	6	CC.. 0602	221	221
SCLC R/L 09 BH12	12	12	12	24	6	CC.. 09T3	222	222
SCLC R/L 06 BH16	16	16	16	28	8	CC.. 0602	621	621
SCLC R/L 09 BH16	16	16	16	28	8	CC.. 09T3	622	622

Spare parts
Indexable insert

CC.. 0602	T08	AS 80 950 ...	110			M2,5x6 - T08	13800
CC.. 09T3				T15/SW	398	M4x11	174
CC.. 09T3				T15/SW	398	M3,5x11	113



Screwdriver

AS

80 950 ...



Combi key

AS

70 950 ...

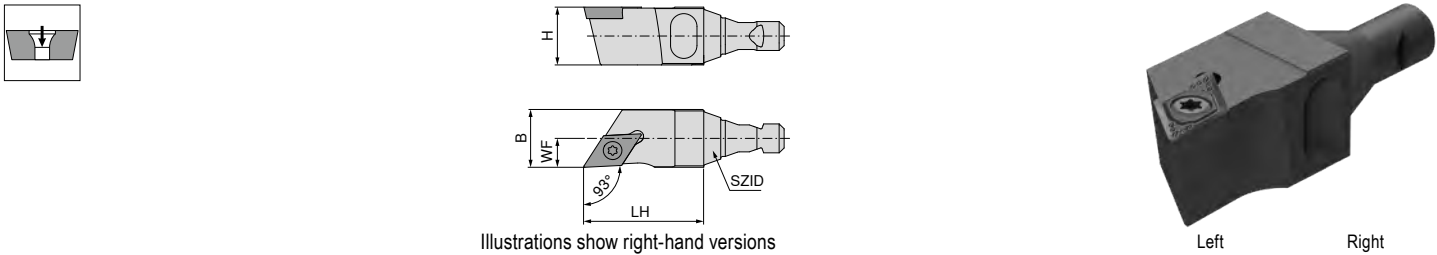


Clamping screw

AS

70 950 ...

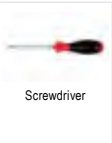
CoreLine – Turning exchangeable head SDJC 93° – XheadClamp



Designation	SZID	H mm	B mm	LH mm	WF mm	Indexable insert	Left TO 72 811 ...	Right TO 72 810 ...
SDJC R/L 07-BH12	12	12	12	24	6	DC.. 0702	230	230
SDJC R/L 11-BH12	12	12	12	24	6	DC.. 11T3	231	231
SDJC R/L 07-BH16	16	16	16	28	8	DC.. 0702	630	630
SDJC R/L 11-BH16	16	16	16	28	8	DC.. 11T3	631	631

Spare parts
Indexable insert

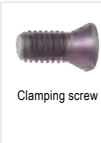
DC.. 0702	T08	110	M2,5x6 - T08	13800
DC.. 11T3	T15	113	M4x11	174



Screwdriver

AS

80 950 ...

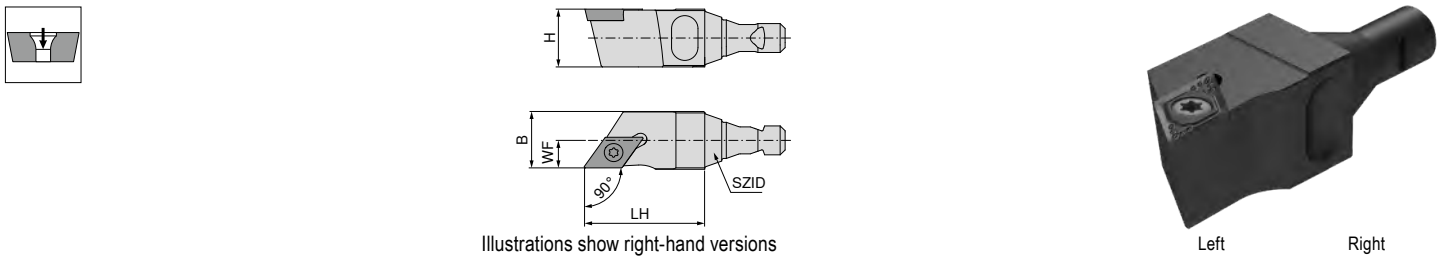


Clamping screw

AS

70 950 ...

CoreLine – Turning exchangeable head SDAC 90° – XheadClamp



Designation	SZID	B mm	H mm	LH mm	WF mm	Indexable insert	TO	
							72 811 ...	72 810 ...
SDACR 07-BH12	12	12	12	24	6	DC.. 0702	228	228
SDACR 11-BH12	12	12	12	24	6	DC.. 11T3	229	229
SDACR 07-BH16	16	16	16	28	8	DC.. 0702	628	628
SDACR 11-BH16	16	16	16	28	8	DC.. 11T3	629	629

Spare parts
Indexable insert

DC.. 0702	T08	110			M2,5x6 - T08	13800
DC.. 11T3			T15/SW	398	M3,5x11	113
DC.. 11T3			T15/SW	398	M4x11	174



Screwdriver

AS

80 950 ...



Combi key

AS

70 950 ...

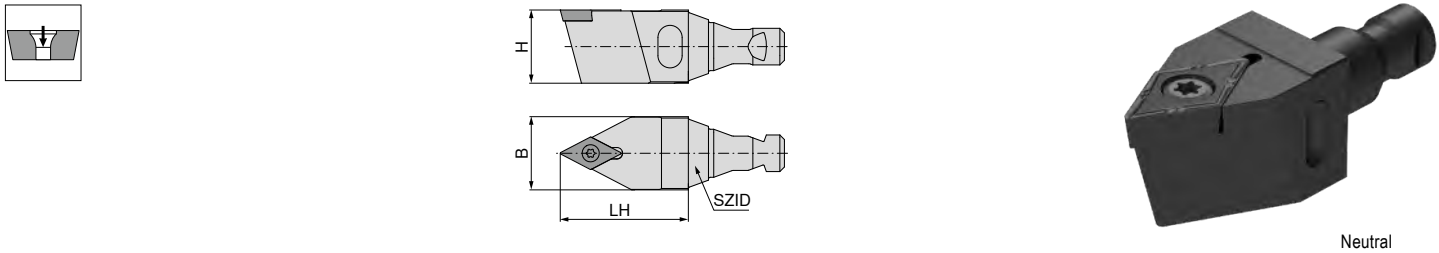


Clamping screw

AS

70 950 ...

CoreLine – Turning exchangeable head SDNC 62.5° – XheadClamp



Designation	SZID	H mm	B mm	LH mm	Indexable insert
SDNC N 07-BH12	12	12	12	28	DC.. 0702
SDNC N 11-BH12	12	12	12	24	DC.. 11T3
SDNC N 07-BH16	16	16	16	28	DC.. 0702
SDNC N 11-BH16	16	16	16	28	DC.. 11T3

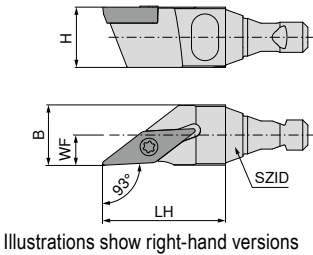
Neutral
TO
72 814 ...
232
233
632
633

Spare parts
for article number

72 814 232	T08	110	M2,5x6 - T08	13800
72 814 233			M4x11	174
72 814 632	T08	110	M2,5x6 - T08	13800
72 814 633			M4x11	174

 Screwdriver	 Combi key	 Clamping screw
AS	AS	AS
80 950 ...	70 950 ...	70 950 ...

CoreLine – Turning exchangeable head SVJC 93° – XheadClamp



Illustrations show right-hand versions

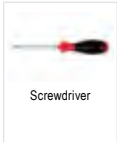


Left Right

Designation	SZID	H mm	B mm	LH mm	WF mm	Indexable insert	TO 72 813 ...	TO 72 812 ...
SVJC R/L 11-BH12	12	12	12	24	6	VC.. 1103	234	234
SVJC R/L 11-BH16	16	16	16	28	8	VC.. 1103	634	634

Spare parts
Indexable insert

VC.. 1103	T08	AS 80 950 ... 110	M2,5x6 - T08	AS 70 950 ... 13800
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Screwdriver

AS

80 950 ...

110



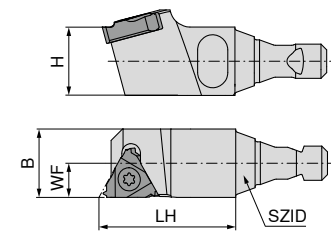
Clamping screw

AS

70 950 ...

13800

CoreLine – Standard exchangeable head – External thread – XheadClamp



Illustrations show right-hand versions



Designation	SZID	H mm	LH mm	WF mm	Indexable insert
SE R/L 11-BH12	12	12	24	6	11 ..
SE R/L 11-BH16	16	16	28	8	11 ..

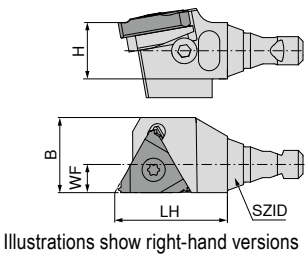
Left	Right
TO	TO
72 803 ...	72 802 ...
241	241
641	641

Spare parts
Indexable insert

11 ..

	
Screwdriver	Clamping screw
AS	AS
80 950 ...	71 950 ...
T08	
110	230

CoreLine – Standard exchangeable head – External thread – XheadClamp



Designation	SZID	H mm	LH mm	WF mm	Indexable insert
SE R/L 16-BH12	12	12	24	16	16 ..
SE R/L 16-BH16	16	16	28	18	16 ..

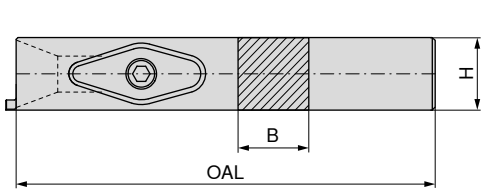
Left	Right
TO	TO
72 805 ...	72 804 ...
242	242
642	642

Spare parts
Indexable insert

16 ..	EL 16 / IR 16	129	234	T08	110	231
16 ..	ER 16 / IL 16	121	234	T08	110	231

			
Shim	Screw U	Screwdriver	Clamping screw
AS	AS	AS	AS
71 950 ...	71 950 ...	80 950 ...	71 950 ...

CoreLine – Base holder – XheadClamp



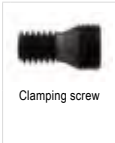
Illustrations show right-hand versions



Designation	H mm	B mm	OAL mm	For exchange- able heads	Left		Right	
					TO		TO	
BHSH.12X93 R/L	12	12	93	BH12	72 841 ...		72 840 ...	
BHSH.12X63 R/L	12	12	63	BH12	293		293	
BHSH.16X63 R/L	16	16	63	BH16	263		263	
BHSH.16X89 R/L	16	16	89	BH16	663		663	
					693		693	

Spare parts
For exchangeable heads

BH12	SR.BHSH.12	801	PR.BHSH.12	800	SW2,5	175
BH16	SR.BHSH.16	803	PR.BHSH.16	802	SW3	176



Clamping screw

AS
72 950 ...



Clamping claw

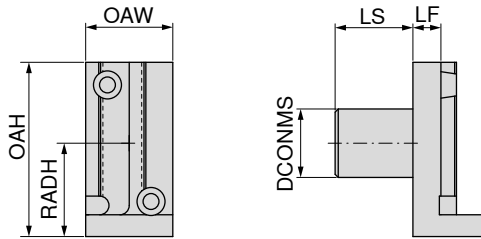
AS
72 950 ...



Key I

AS
70 950 ...

CoreLine – Machine base holder for CITIZEN



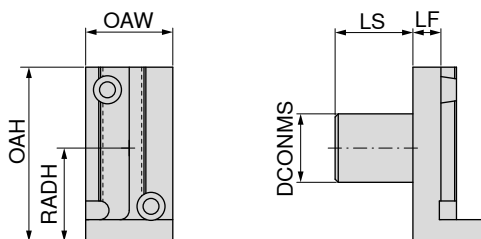
Designation	DCONMS mm	OAW mm	OAH mm	LF mm	LS mm	RADH mm	TO 72 951 ...
CI.GH 3/4"-40	19.05	28	56	9	40	30	07004
CI.GH 25-30	25.00	28	56	9	30	30	07002
CI.GH 1"-60	25.40	28	56	9	60	30	07003
CI.GH 31-15	31.00	34	58	9	15	32	07001

Suitable for the following machines:

Article no.	Machine manufacturer	Machine type
72 951 07001	Citizen	A32-VII with drive
72 951 07002	Citizen	L12 / A20 / L20 with drive
72 951 07003	Citizen	A20 / A32 / C32 / L32 / M32 without drive
72 951 07004	Citizen	C16 / L12 / L20 / M16

CoreLine – Machine base holder for DOOSAN

▲ For **DOOSAN** Puma ST20G

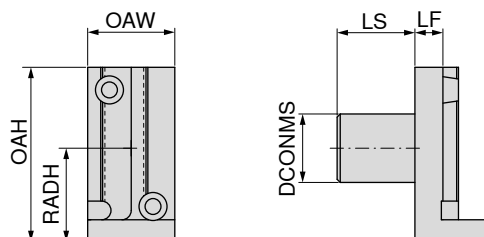


Designation	DCONMS mm	OAW mm	OAH mm	LF mm	LS mm	RADH mm	TO 72 952 ...
DO.GH 32-25	32	34	56	9	25	30	07001

Suitable for the following machines:

Article no.	Machine manufacturer	Machine type
72 952 07001	Doosan	Puma ST20G

CoreLine – Machine base holder for HANWHA



Designation	DCONMS mm	OAW mm	OAH mm	LF mm	LS mm	RADH mm
HA.GH 25-40	25	28	56	9	40	30
HA.GH 32-27	32	38	56	34	27	30
HA.GH 33-40	33	28	56	9	40	30

TO

72 953 ...

07003

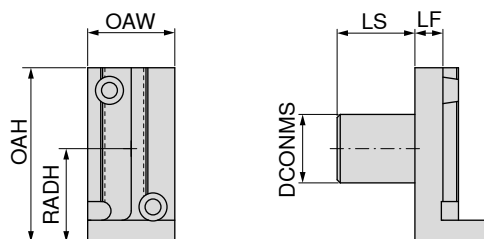
07002

07001

Suitable for the following machines:

Article no.	Machine manufacturer	Machine type
72 953 07001	Hanwha	XD20 / 26 / 32 / 38
72 953 07002	Hanwha	XD38H
72 953 07003	Hanwha	XE26

CoreLine – Machine base holder for MAIER



Designation	DCONMS mm	OAW mm	OAH mm	LF mm	LS mm	RADH mm
MA.GH 34-20	34	38	56	9	20	30

TO

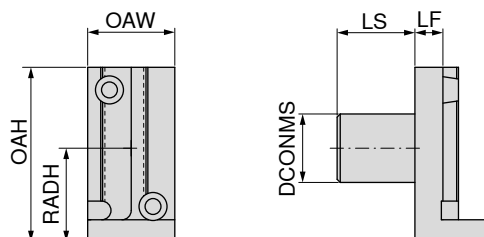
72 954 ...

07001

Suitable for the following machines:

Article no.	Machine manufacturer	Machine type
72 954 07001	Maier	ML26 / ML32 / ML12C / ML16C / ML16D / ML20

CoreLine – Machine base holder for STAR

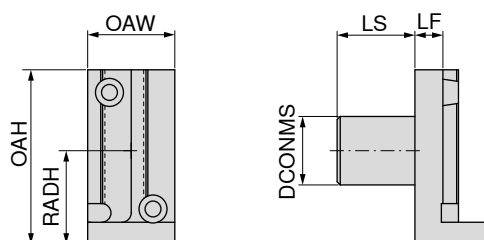


Designation	DCONMS mm	OAW mm	OAH mm	LF mm	LS mm	RADH mm	TO 72 955 ...
ST.GH 22-20	22	38	56	9	20	30	07001
ST.GH 22-25	22	28	56	9	25	30	07002

Suitable for the following machines:

Article no.	Machine manufacturer	Machine type
72 955 07001	Star	SR32 / SR32J / SR32JN (from mach. no. 161)
72 955 07002	Star	ECAS12 / ECAS20 / SR20RIII / SR20N / SR20JN / SR32J / SR10J / SR16R / SR20R / SR20RII

CoreLine – Machine base holder for TORNOS

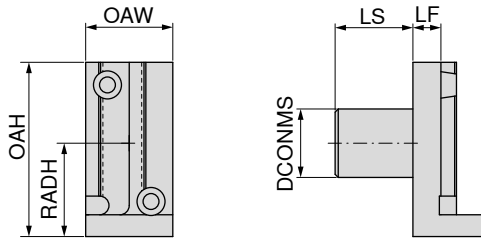


Designation	DCONMS mm	OAW mm	OAH mm	LF mm	LS mm	RADH mm	TO 72 956 ...
TO.GH 20-100	20	28	56	9	100	30	07002
TO.GH 25-100	25	28	56	9	100	30	07001

Machine type assignment

Article no.	Machine manufacturer	Machine type
72 956 07001	Tornos	Deco 7 / 10 / 13 / 20 (25 mm shank)
72 956 07002	Tornos	Deco 7 / 10 / 13 / 20 (20 mm shank)

CoreLine – Machine base holder for CITIZEN / GILDEMEISTER / HANWHA / TORNOS / TSUGAMI

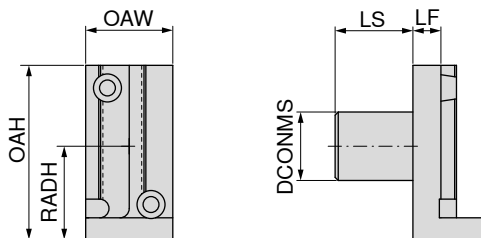


Designation	DCONMS mm	OAW mm	OAH mm	LF mm	LS mm	RADH mm	TO 72 958 ... 07001
CI/GI/HA/TO/TS.GH 20-40	20	28	56	9	40	30	

Suitable for the following machines:

Article no.	Machine manufacturer	Machine type
72 958 07001	Citizen	K16
	Gildemeister	Sprint 20
	Hanwha	SL 12H
	Tornos	Delta 20 / Gamma 20
	Tsugami	BO 125 / 205

CoreLine – Machine base holder for TORNOS / TSUGAMI



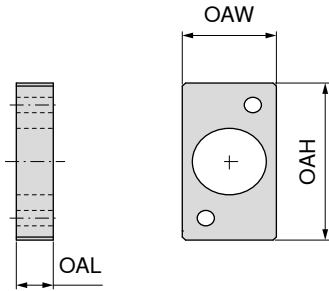
Designation	DCONMS mm	OAW mm	OAH mm	LF mm	LS mm	RADH mm	TO 72 958 ... 07002
TO/TS.GH 32-50	32	28	56	9	50	30	

Suitable for the following machines:

Article no.	Machine manufacturer	Machine type
72 958 07002	Tornos	Delta 385 without drive
	Tsugami	BO 385 / BH 38

Distance plate

▲ Flexible adjustment of the projection length

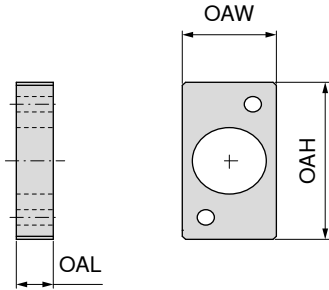


Designation	OAW mm	OAH mm	OAL mm	Base holder
CI.DP-GH1"-60-11	28	52	11	CI.GH1"-60
CI.DP-GH25-30-11	28	52	11	CI.GH25-30
CI.DP-GH3/4"-40-11	28	52	11	CI.GH3/4"-40

AS
72 951 ...
04006
04005
04007

Distance plate

▲ Flexible adjustment of the projection length

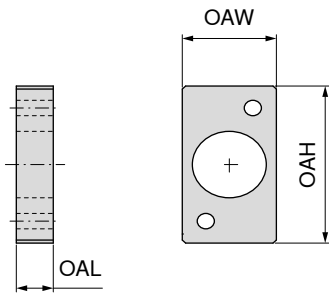


Designation	OAW mm	OAH mm	OAL mm	Base holder
HA.DP-GH33-40-11	35	52	11	HA.GH33-40

AS
72 953 ...
04004

Distance plate

▲ Flexible adjustment of the projection length



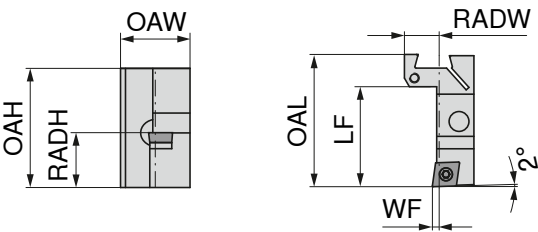
Designation	OAW mm	OAH mm	OAL mm	Base holder
ST.DP-GH22-25-11	28	52	11	ST.GH22-25

AS

72 955 ...

04003

CoreLine – Tool holder block with screw clamping for CC.. indexable inserts



Designation	OAW mm	OAH mm	LF mm	RADW mm	RADH mm	WF mm	OAL mm	Indexable insert
MU.AH-CC09-R	28	48	41	14	22	2.5	54	CC.. 09T3

TO

72 981 ...

08001

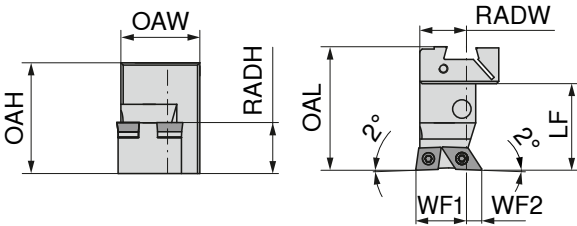
Spare parts
for article number

72 981 08001

 Screwdriver	 Clamping screw	 Carbide seat C	 Threaded bush
AS	AS	AS	AS
80 950 ...	70 950 ...	70 950 ...	70 950 ...
113	113	165	171

CoreLine

– Tool holder block (double) with screw clamping for CC../DC.. indexable inserts



Double

TO

72 981 ...

08011

Designation	OAH mm	LF mm	RADW mm	RADH mm	OAL mm	WF_1 mm	WF_2 mm	Indexable insert
MU.AH-CC09-L-DC11-R	48	38	20	22	54	22	7	CC.. 09T3 / DC.. 11T3

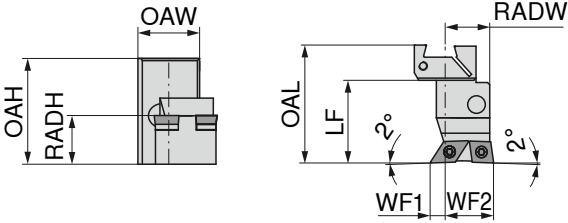
Spare parts
for article number

72 981 08011

					
Screwdriver	Combi key	Clamping screw	Carbide seat D	Carbide seat C	Threaded bush
AS	AS	AS	AS	AS	AS
80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
113	398	113	106	165	171

CoreLine

– Tool holder block (double) with screw clamping for CC../DC.. indexable inserts



Double

TO

72 981 ...

08010

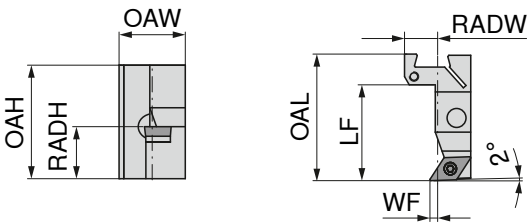
Designation	OAH mm	LF mm	RADW mm	RADH mm	OAL mm	WF_1 mm	WF_2 mm	Indexable insert
MU.AH-CC09-R-DC11-L	48	38	20	22	54	22	7	CC.. 09T3 / DC.. 11T3

Spare parts
for article number

72 981 08010

					
Screwdriver	Combi key	Clamping screw	Carbide seat D	Carbide seat C	Threaded bush
AS	AS	AS	AS	AS	AS
80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
113	398	113	106	165	171

CoreLine – Tool holder block with screw clamping for DC.. indexable inserts



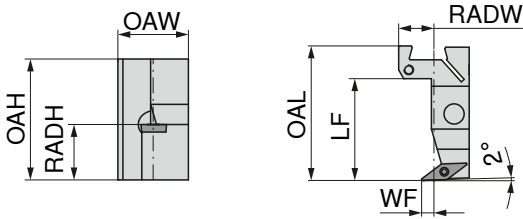
Designation	OAW mm	OAH mm	LF mm	RADW mm	RADH mm	WF mm	OAL mm	Indexable insert	TO 72 981 ... 08002 08003
MU.AH-DC07-R	28	48	41	14	22	3.0	54	DC.. 0702	
MU.AH-DC11-R	28	48	41	14	22	3.5	54	DC.. 11T3	

Spare parts
for article number

72 981 08002	110	398	13800	106	171
72 981 08003					

 Screwdriver	 Combi key	 Clamping screw	 Carbide seat D	 Threaded bush
AS 80 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...

CoreLine – Tool holder block with screw clamping for VC.. indexable inserts



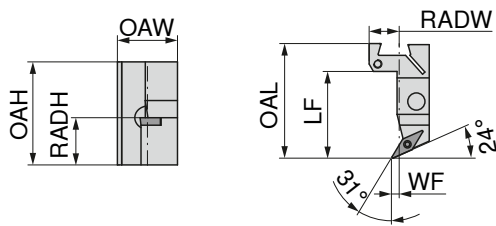
Designation	OAW mm	OAH mm	LF mm	RADW mm	RADH mm	WF mm	OAL mm	Indexable insert	TO 72 981 ... 08004 08005
MU.AH-VC11-R	28	48	41	14	22	5.0	54	VC.. 1103	
MU.AH-VC16-R	28	48	41	14	22	14.5	54	VC.. 1604	

Spare parts
for article number

72 981 08004	110							
72 981 08005		398						

 Screwdriver	 Combi key	 Clamping screw	 Carbide seat V	 Threaded bush
AS 80 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
		13800 113	107	171

CoreLine – Tool holder block with screw clamping for VC.. indexable inserts



Designation	OAW mm	OAH mm	LF mm	RADW mm	RADH mm	WF mm	OAL mm	Indexable insert
MU.AH-VC11-24-R	28	48	41	14	22	3	54	VC.. 1103

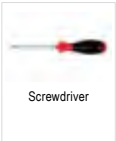
TO

72 981 ...

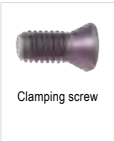
08006

Spare parts
for article number

72 981 08006



Screwdriver



Clamping screw

AS

80 950 ...

110

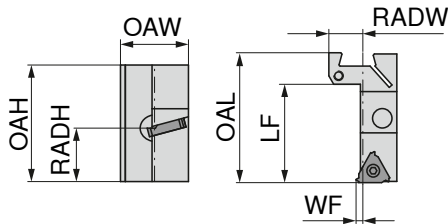
AS

70 950 ...

13800

CoreLine – Tool holder block for right external thread-turning inserts

- ▲ Tool holder with approach angle 1.5°
- ▲ Thread-turning inserts with pitch max. 1.5 mm



Right

Designation	OAW mm	OAH mm	LF mm	RADW mm	RADH mm	WF mm	OAL mm	Indexable insert
MU.AH-ER16-R	28	48	41	14	22	3	54	16 ER..

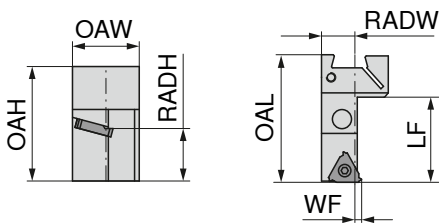
TO

72 981 ...

08007

CoreLine – Tool holder block for left external thread-turning inserts

- ▲ Tool holder with approach angle 1.5°
- ▲ Thread-turning inserts with pitch max. 1.5 mm



Left

Designation	OAW mm	OAH mm	LF mm	RADW mm	RADH mm	WF mm	OAL mm	Indexable insert
MU.AH-ER16-L	28	48	34	14	22	3	54	16 EL..

TO

72 981 ...

08008

Spare parts
for article number

72 981 08008



Screwdriver

AS

80 950 ...

112



Clamping screw

AS

71 950 ...

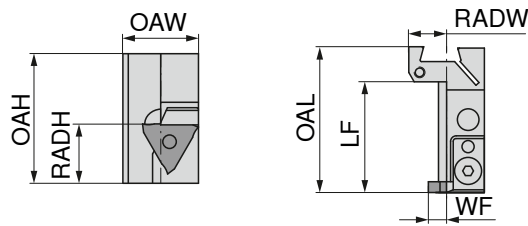
231



Suitable indexable inserts can be found in the **Thread turning tools** chapter.

CoreLine – Tool holder block for TX grooving inserts

▲ Insert width 0.5-4.0 mm



Right

Designation	OAW mm	OAH mm	LF mm	RADW mm	RADH mm	WF mm	OAL mm	Indexable insert
MU.AH-TX-R	28	48	41	14	22	7	54	TX R/N/L ...2/3/4

TO

72 986 ...

16001

Spare parts
for article number

72 986 16001

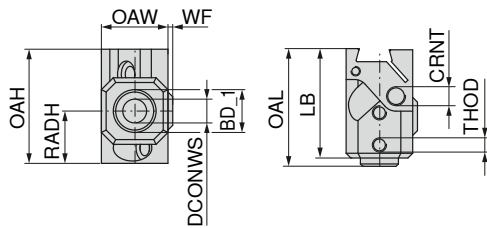
			
Clamping claw	Lock washer	Countersunk screw	Guide pin with flange
AS	AS	AS	AS
72 950 ...	72 950 ...	72 950 ...	72 950 ...
19001	19002	19003	19004



Suitable indexable inserts can be found in the **Grooving tools chapter**.

CoreLine – Tool holder block for drills and boring bars

▲ With inner high-pressure coolant supply through the tool



Designation	DCONWS	BD_1	OAW	OAH	LB	WF	OAL	RADH	THOD
	mm	mm	mm	mm	mm	mm	mm	mm	
MU.AH-BH06IK	6	12	28	48	46.0		48.5	22	M6
MU.AH-BH08IK	8	14	28	48	46.0		48.5	22	M8
MU.AH-BH10IK	10	16	28	48	46.0		49.5	22	M8
MU.AH-BH12IK	12	18	28	48	50.0		52.5	22	M10
MU.AH-BH14IK	14	19	28	48	50.5		54.0	22	M10
MU.AH-BH16IK	16	21	28	48	50.5	2	54.0	22	M10

TO
72 982 ...
03001
03002
03003
03004
03005
03006

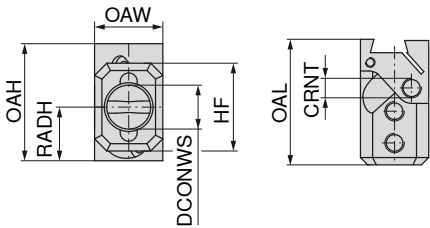
Spare parts
for article number

- 72 982 03001
- 72 982 03002
- 72 982 03003
- 72 982 03004
- 72 982 03005
- 72 982 03006

	
Set Screw	Set Screw
CT	AS
83 950 ...	72 950 ...
464	19011
464	
	19013
	19013
	19013

CoreLine – Tool holder block for clamping inserts

- ▲ Through coolant directly through base holder
- ▲ Also suitable for collet chucks



Designation	DCONWS <small>H6</small>	HF	OAW	OAH	RADH	OAL	CRNT
MU.AH-S20IK	20	36	28	48	22	51.5	M8x1

TO

72 983 ...

20001

Spare parts
for article number

72 983 20001



Set Screw

CT

83 950 ...

464

Adjustment device for setting height of tool block holder

- ▲ Reduced setup times thanks to convenient presetting away from the machine
- ▲ Prevention of machine downtimes
- ▲ Best positional accuracy following tool change by presetting away from the machine

Scope of supply:

72 996 05001: Adjustment device with dial gage and dial gage stand
72 996 05002: Adjustment device without dial gage and dial gage stand



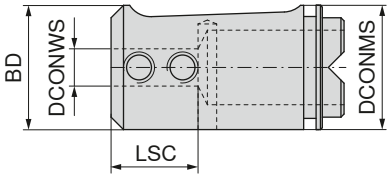
Designation	AS
MU.EV MAX	72 996 ...
MU.EV MAX-OMU	05001 05002



Information on correct application and any conversions required can be found in the technical appendix.

CoreLine – Clamping insert for UltraMini cutting inserts

▲ With inner high-pressure coolant supply through the tool



Designation	DCONMS _{g6} mm	DCONWS mm	BD _{g6} mm	LSC mm
MU.ULTRAMINI.KH-DM4	20	4	20	13
MU.ULTRAMINI.KH-DM5	20	5	20	14
MU.ULTRAMINI.KH-DM6	20	6	20	14
MU.ULTRAMINI.KH-DM7	20	7	20	14
MU.ULTRAMINI.KH-DM8	20	8	20	19

TO
72 995 ...
08001
08002
08003
08004
08005

Spare parts
DCONWS

4
5 - 7
8


Set Screw
AS
72 950 ...
19009
19010
19012

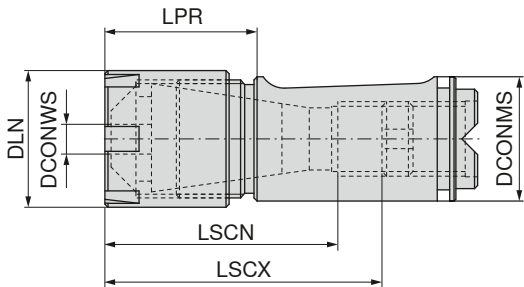


Suitable UltraMini cutting inserts can be found in the **Miniature turning tools** chapter.

CoreLine – ER collet chuck (mini lock nut)

▲ With inner high-pressure coolant supply through the tool

Scope of supply:
Base body without lock nut



Designation	LPR	DCONMS _{g6}	DLN	LSCX	LSCN	for collet	TO 72 984 ... 06001 06002
MU.S20-SPZH-ER16-IK	25.0	20	22	55	38	426E (ER16)	
MU.S20-SPZH-ER20-IK	27.5	20	28	56	40	428E (ER20)	

Spare parts
for article number

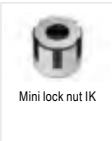
72 984 06001	101	058
72 984 06002	102	059



ER-Mini clamping key

CT

83 950 ...



Mini lock nut IK

CT

83 950 ...

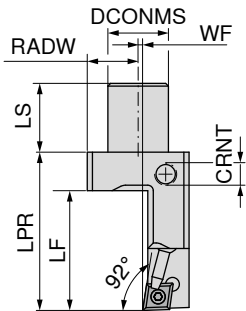
 You will find sealing discs in the **Adapters and accessories** chapter.

CoreLine – Rear holder with screw clamping for CC.. indexable inserts

▲ For **STAR** SR 20 R-IV / 20 JII / 32 JII / 38 / SW 12 / 20 / SV 20 R

Scope of supply:

Holder with coolant nozzle and screw plug, without coolant connection



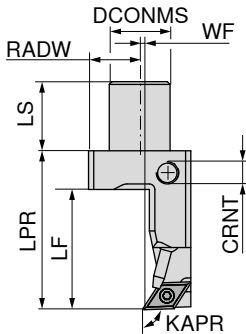
Designation	DCONMS _{g6} mm	LS mm	LF mm	WF mm	LPR mm	RADW mm	CRNT	Indexable insert	TO	
									72 955 ...	
ST.SR20R4-RE-K-CC09-L-IK	22	25	43.5	1.5	77.5	18.5	M8x1	CC.. 09T3		08005
ST.SR20R4-RE-K-CC09-R-IK	22	25	43.5	1.5	57.5	18.5	M8x1	CC.. 09T3		08004

Spare parts for article number								
	AS	AS	AS	AS	AS	AS	AS	AS
	72 950 ...	72 950 ...	72 989 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	72 950 ...
72 955 08005	19006	19007	10002	398	113	165	171	19008
72 955 08004	19006	19007	10002	398	113	165	171	19008

CoreLine – Rear holder with screw clamping for DC.. indexable inserts

▲ For **STAR** SR 20 R-IV / 20 JII / 32 JII / 38 / SW 12 / 20 / SV 20 R

Scope of supply:
Holder with coolant nozzle and screw plug, without coolant connection



Designation	DCONMS _{g6} mm	LS mm	LF mm	WF mm	LPR mm	RADW mm	CRNT	KAPR °	Indexable insert	TO	
										72 955 ...	
ST.SR20R4-RE-K-DC07-R-IK	22	25	43.5	1.5	57.5	18.5	M8x1	92	DC.. 0702		08006
ST.SR20R4-RE-K-DC11-R-IK	22	25	43.5	1.0	57.5	18.5	M8x1	92	DC.. 11T3		08008
ST.SR20R4-RE-L-DC07-R-IK	22	25	43.5	1.5	77.5	18.5	M8x1	92	DC.. 0702		08007
ST.SR20R4-RE-L-DC11-R-IK	22	25	43.5	1.0	77.5	18.5	M8x1	92	DC.. 11T3		08009

Spare parts
for article number

	Combi key	Clamping screw	Carbide seat D	Threaded bush	Alu ring
72 955 08006	AS	AS	AS	AS	AS
72 955 08008	70 950 ...	70 950 ...	70 950 ...	72 950 ...	72 950 ...
72 955 08007		13800			19008
72 955 08009	398	113	106	19005	19008

Spare parts
for article number

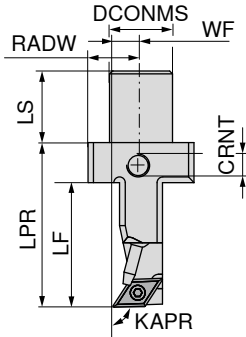
	Screw plug	Countersunk screw	Screwdriver	Coolant nozzle
72 955 08006	AS	AS	AS	AS
72 955 08008	72 950 ...	72 950 ...	80 950 ...	72 989 ...
72 955 08007	19006	19007	110	10002
72 955 08009	19006	19007	110	10002

CoreLine – Rear holder with screw clamping for DC.. indexable inserts

▲ For **STAR** SR 20 R-IV / 20 JII / 32 JII / 38 / SW 12 / 20 / SV 20 R

Scope of supply:

Holder with coolant nozzle and screw plug, without coolant connection



Designation	DCONMS _{g6} mm	LS mm	LF mm	WF mm	LPR mm	RADW mm	CRNT	KAPR °	Indexable insert	TO	
										72 955 ...	
ST.SR20R4-RX-K-DC11-R-IK	22	25	43.5	10	57.5	18.5	M8x1	92	DC.. 11T3		08010
ST.SR20R4-RX-L-DC11-R-IK	22	25	43.5	10	77.5	18.5	M8x1	92	DC.. 11T3		08011

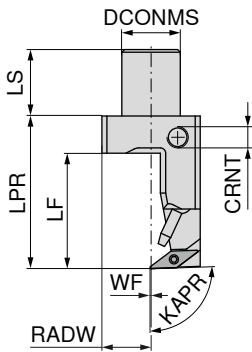
**Spare parts
for article number**

	 Screw plug	 Countersunk screw	 Coolant nozzle	 Combi key	 Clamping screw	 Carbide seat D	 Threaded bush	 Alu ring
	AS	AS	AS	AS	AS	AS	AS	AS
72 955 08010	19006	19007	10002	398	113	106	171	19008
72 955 08011	19006	19007	10002	398	113	106	171	19008

CoreLine – Rear holder with screw clamping for VC.. indexable inserts

▲ For **STAR** SR 20 R-IV / 20 JII / 32 JII / 38 / SW 12 / 20 / SV 20 R

Scope of supply:
Holder with coolant nozzle and screw plug, without coolant connection



Designation	DCONMS _{g6} mm	LS mm	LF mm	WF mm	LPR mm	RADW mm	CRNT	KAPR °	Indexable insert	TO	
										72 955 ...	
ST.SR20R4-RE-K-VC11-R-IK	22	25	43.5	0.5	57.5	18.5	M8x1	92	VC.. 1103		08012
ST.SR20R4-RE-L-VC11-R-IK	22	25	43.5	0.5	77.5	18.5	M8x1	92	VC.. 1103		08013

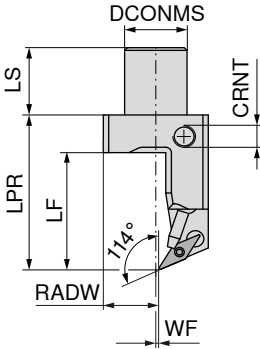
Spare parts
for article number

	 Screw plug	 Countersunk screw	 Screwdriver	 Coolant nozzle	 Clamping screw	 Alu ring
	AS 72 950 ...	AS 72 950 ...	AS 80 950 ...	AS 72 989 ...	AS 70 950 ...	AS 72 950 ...
72 955 08012	19006	19007	110	10002	13800	19008
72 955 08013	19006	19007	110	10002	13800	19008

CoreLine – Rear holder with screw clamping for VC.. indexable inserts

▲ For **STAR** SR 20 R-IV / 20 JII / 32 JII / 38 / SW 12 / 20 / SV 20 R

Scope of supply:
Holder with coolant nozzle and screw plug, without coolant connection



Designation	DCONMS _{g6} mm	LS mm	LF mm	WF mm	LPR mm	RADW mm	CRNT	Indexable insert	TO	
									72 955 ...	
ST.SR20R4-RE-K-VC11-24-R-IK	22	25	43.5	1.1	57.5	18.5	M8x1	VC.. 1103		08014
ST.SR20R4-RE-L-VC11-24-R-IK	22	25	43.5	1.1	77.5	18.5	M8x1	VC.. 1103		08015

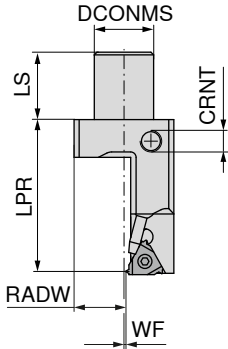
Spare parts
for article number

	 Screw plug	 Countersunk screw	 Screwdriver	 Coolant nozzle	 Clamping screw	 Alu ring
	AS 72 950 ...	AS 72 950 ...	AS 80 950 ...	AS 72 989 ...	AS 70 950 ...	AS 72 950 ...
72 955 08014	19006	19007	110	10002	13800	19008
72 955 08015	19006	19007	110	10002	13800	19008

CoreLine – Rear holder for right outer thread-turning inserts (ER 16..)

- ▲ For **STAR** SR 20 R-IV / 20 JII / 32 JII / 38 / SW 12 / 20 / SV 20 R
- ▲ Tool holder with approach angle 1.5°
- ▲ Thread-turning inserts with pitch max. 1.5 mm

Scope of supply:
Holder with coolant nozzle and screw plug, without coolant connection



Designation	DCONMS _{g6} mm	LS mm	WF mm	LPR mm	RADW mm	CRNT	Indexable insert	Right TO	
								72 955 ...	
ST.SR20R4-RE-K-ER16-R-IK	22	25	0.7	57.5	18.5	M8x1	16 ER..		08016
ST.SR20R4-RE-L-ER16-R-IK	22	25	0.7	77.5	18.5	M8x1	16 ER..		08017

Spare parts
for article number

	Screw plug	Countersunk screw	Screwdriver	Coolant nozzle	Clamping screw	Alu ring
72 955 08016	19006	19007	112	10002	231	19008
72 955 08017	19006	19007	112	10002	231	19008



Suitable indexable inserts can be found in the **Thread turning tools chapter**.

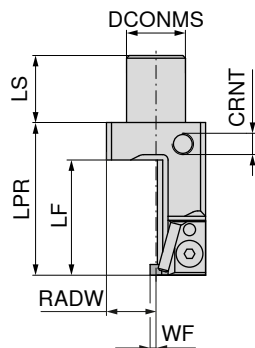
CoreLine – Rear holder for TX grooving inserts

▲ For **STAR** SR 20 R-IV / 20 JII / 32 JII / 38 / SW 12 / 20 / SV 20 R

▲ Insert width 0.5-4.0 mm

Scope of supply:

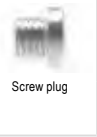
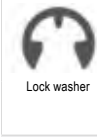
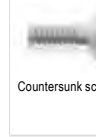
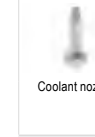
Holder with coolant nozzle and screw plug, without coolant connection



Designation	DCONMS _{g6} mm	LS mm	LF mm	WF mm	LPR mm	RADW mm	CRNT	Indexable insert	TO 72 955 ...
ST.SR20R4-RE-K-TX-R-IK	22	25	43	2	57	18.5	M8x1	TX R/N/L ...2/3/4	16018
ST.SR20R4-RE-L-TX-R-IK	22	25	43	2	77	18.5	M8x1	TX R/N/L ...2/3/4	16019

Spare parts for article number

	AS 72 950 ...	AS 72 950 ...	AS 72 950 ...	AS 72 950 ...	AS 72 989 ...	AS 72 950 ...	AS 72 950 ...
72 955 16018	19006	19001	19002	19003	10001	19004	19008
72 955 16019	19006	19001	19002	19003	10001	19004	19008

						
Screw plug	Clamping claw	Lock washer	Countersunk screw	Coolant nozzle	Guide pin with flange	Alu ring

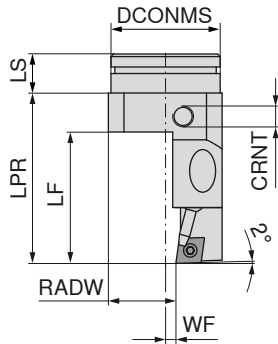


Suitable indexable inserts can be found in the **Grooving tools chapter**.

CoreLine – Rear holder with screw clamping for CC.. indexable inserts

▲ For **TSUGAMI** BO 266 / 326 / 386 / 38T / HS 267 / 237 / 38M / BW 269 / 329

Scope of supply:
Holder with coolant nozzle and screw plug, without coolant connection



Designation	DCONMS _{g6} mm	LS mm	LF mm	WF mm	LPR mm	RADW mm	CRNT	Indexable insert	TO 72 957 ... 08001
TS.RE42.65-CC09-R-IK	42	15	50.5	4	65.5	26	M8x1	CC.. 09T3	

Spare parts
for article number

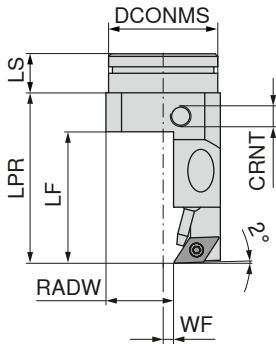
72 957 08001

 Screw plug	 Countersunk screw	 Screwdriver	 Coolant nozzle	 Clamping screw	 Carbide seat C	 Threaded bush	 Alu ring
AS	AS	AS	AS	AS	AS	AS	AS
72 950 ...	72 950 ...	80 950 ...	72 989 ...	70 950 ...	70 950 ...	70 950 ...	72 950 ...
19006	19007	113	10002	113	165	171	19008

CoreLine – Rear holder with screw clamping for DC.. indexable inserts

▲ For **TSUGAMI** BO 266 / 326 / 386 / 38T / HS 267 / 237 / 38M / BW 269 / 329

Scope of supply:
Holder with coolant nozzle and screw plug, without coolant connection



Designation	DCONMS _{g6} mm	LS mm	LF mm	WF mm	LPR mm	RADW mm	CRNT	Indexable insert	TO 72 957 ... 08002	
TS.RE42.65-DC11-R-IK	42	15	50.5	4	65.5	26	M8x1	DC.. 11T3		

Spare parts
for article number

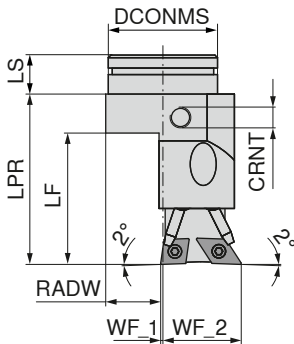
72 957 08002

 Screw plug	 Countersunk screw	 Coolant nozzle	 Combi key	 Clamping screw	 Carbide seat D	 Threaded bush	 Alu ring
AS 72 950 ... 19006	AS 72 950 ... 19007	AS 72 989 ... 10002	AS 70 950 ... 398	AS 70 950 ... 113	AS 70 950 ... 106	AS 70 950 ... 171	AS 72 950 ... 19008

CoreLine – Rear holder (double) with screw clamping for CC.. / DC.. indexable inserts

▲ For **TSUGAMI** BO 266 / 326 / 386 / 38T / HS 267 / 237 / 38M / BW 269 / 329

Scope of supply:
Holder with coolant nozzle and screw plug, without coolant connection



Designation	DCONMS mm	LS mm	LF mm	LPR mm	WF_1 mm	WF_2 mm	RADW mm	CRNT	Indexable insert	Double	
										TO	
										72 957 ...	08009
TS.RD42.65-CC09-R-DC11-L-IK	42	15	50.5	65.5	1	30	21	M8x1	CC.. 09T3 / DC.. 11T3		

Spare parts
for article number

72 957 08009

 Clamping screw	 Carbide seat D	 Carbide seat C	 Threaded bush	 Alu ring
AS	AS	AS	AS	AS
70 950 ...	70 950 ...	70 950 ...	70 950 ...	72 950 ...
113	106	165	171	19008
 Screw plug	 Countersunk screw	 Screwdriver	 Coolant nozzle	 Combi key
AS	AS	AS	AS	AS
72 950 ...	72 950 ...	80 950 ...	72 989 ...	70 950 ...
19006	19007	113	10002	398

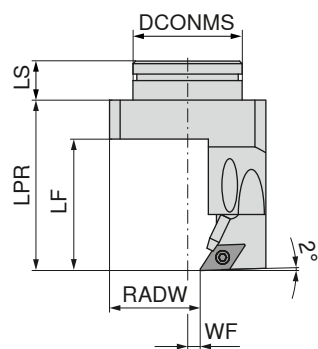
Spare parts
for article number

72 957 08009

CoreLine – Overhead rear holder with screw clamping for DC.. indexable inserts

▲ For **TSUGAMI** BO 266 / 326 / 386 / 38T / HS 267 / 237 / 38M / BW 269 / 329

Scope of supply:
Holder with coolant nozzle and screw plug, without coolant connection



Designation	DCONMS _{g6} mm	LS mm	LF mm	LPR mm	WF mm	RADW mm	Indexable insert	TO 72 957 ... 08007
TS.RY42.65-DC11-R-IK	42	15	50.5	65.5	4.5	34.5	DC.. 11T3	

Spare parts
for article number

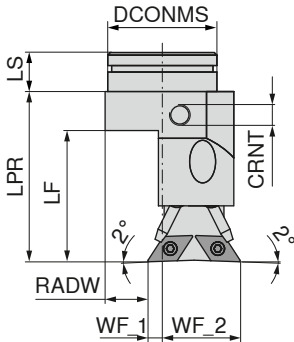
72 957 08007

 Screw plug	 Countersunk screw	 Coolant nozzle	 Combi key	 Clamping screw	 Carbide seat D	 Threaded bush	 Alu ring
AS 72 950 ... 19006	AS 72 950 ... 19007	AS 72 989 ... 10002	AS 70 950 ... 398	AS 70 950 ... 113	AS 70 950 ... 106	AS 70 950 ... 171	AS 72 950 ... 19008

CoreLine – Rear holder (double) with screw clamping for DC.. indexable inserts

▲ For **TSUGAMI** BO 266 / 326 / 386 / 38T / HS 267 / 237 / 38M / BW 269 / 329

Scope of supply:
Holder with coolant nozzle and screw plug, without coolant connection



Designation										Double
										TO
										72 957 ... 08011
TS.RD42.65-DC11-R-DC11-L-IK	DCONMS _{g6} mm	LS mm	LF mm	LPR mm	WF_1 mm	WF_2 mm	RADW mm	CRNT	Indexable insert	
	42	15	50.5	65.5	5.5	30	16.5	M8x1	DC.. 11T3	

Spare parts
for article number

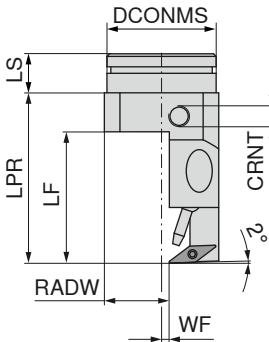
72 957 08011

							
Screw plug	Countersunk screw	Coolant nozzle	Combi key	Clamping screw	Carbide seat D	Threaded bush	Alu ring
AS	AS	AS	AS	AS	AS	AS	AS
72 950 ...	72 950 ...	72 989 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	72 950 ...
19006	19007	10002	398	113	106	171	19008

CoreLine – Rear holder with screw clamping for VC.. indexable inserts

▲ For **TSUGAMI** BO 266 / 326 / 386 / 38T / HS 267 / 237 / 38M / BW 269 / 329

Scope of supply:
Holder with coolant nozzle and screw plug, without coolant connection



Designation	DCONMS _{g6} mm	LS mm	LF mm	LPR mm	WF mm	RADW mm	CRNT	Indexable insert	TO 72 957 ... 08003	
TS.RE42.65-VC11-R-IK	42	15	50.5	65.5	3	25	M8x1	VC.. 1103		

Spare parts
for article number

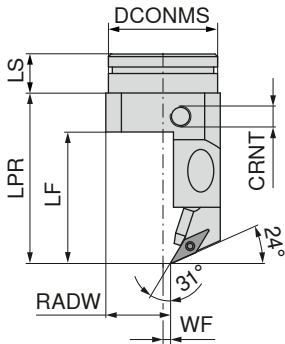
72 957 08003

 Screw plug	 Countersunk screw	 Screwdriver	 Coolant nozzle	 Clamping screw	 Alu ring
AS 72 950 ... 19006	AS 72 950 ... 19007	AS 80 950 ... 110	AS 72 989 ... 10002	AS 70 950 ... 13800	AS 72 950 ... 19008

CoreLine – Rear holder with screw clamping for VC.. indexable inserts

▲ For **TSUGAMI** BO 266 / 326 / 386 / 38T / HS 267 / 237 / 38M / BW 269 / 329

Scope of supply:
Holder with coolant nozzle and screw plug, without coolant connection



Designation	DCONMS _{g6} mm	LS mm	LF mm	LPR mm	WF mm	RADW mm	CRNT	Indexable insert	TO 72 957 ... 08004	
TS.RE42.65-VC11-24-R-IK	42	15	50.5	65.5	3	25	M8x1	VC.. 1103		

Spare parts
for article number

72 957 08004

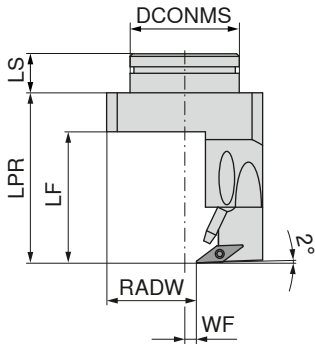
 Screw plug	 Countersunk screw	 Screwdriver	 Coolant nozzle	 Clamping screw	 Alu ring
AS 72 950 ... 19006	AS 72 950 ... 19007	AS 80 950 ... 110	AS 72 989 ... 10002	AS 70 950 ... 13800	AS 72 950 ... 19008

CoreLine

– Overhead rear holder with screw clamping for VC.. indexable inserts

▲ For **TSUGAMI** BO 266 / 326 / 386 / 38T / HS 267 / 237 / 38M / BW 269 / 329

Scope of supply:
Holder with coolant nozzle and screw plug, without coolant connection



Designation	DCONMS _{g6} mm	LS mm	WF mm	LF mm	LPR mm	RADW mm	CRNT	Indexable insert	TO 72 957 ... 08008	
TS.RY42.65-VC11-R-IK	42	15	3	50.5	65.5	25	M8x1	VC.. 1103		

Spare parts
for article number

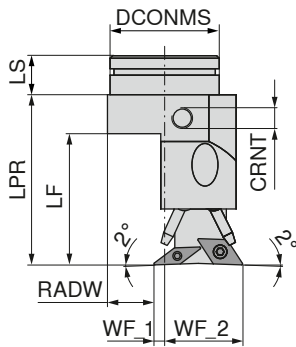
72 957 08008

 Screw plug	 Countersunk screw	 Screwdriver	 Coolant nozzle	 Clamping screw	 Alu ring
AS 72 950 ... 19006	AS 72 950 ... 19007	AS 80 950 ... 110	AS 72 989 ... 10002	AS 70 950 ... 13800	AS 72 950 ... 19008

CoreLine – Rear holder (double) with screw clamping for VC.. / DC.. indexable inserts

▲ For **TSUGAMI** BO 266 / 326 / 386 / 38T / HS 267 / 237 / 38M / BW 269 / 329

Scope of supply:
Holder with coolant nozzle and screw plug, without coolant connection



Double

Designation	DCONMS _{g6}	LS	LF	LPR	WF_1	WF_2	RADW	CRNT	Indexable insert	TO 72 957 ... 08010
TS.RD42.65-VC11-R-DC11-L-IK	42	15	50.5	65.5	4	30	18	M8x1	VC.. 1103 / DC.. 11T3	
	mm	mm	mm	mm	mm	mm	mm	mm		

Spare parts
for article number

72 957 08010

 Combi key	 Clamping screw	 Carbide seat D	 Threaded bush	 Alu ring
AS	AS	AS	AS	AS
70 950 ...	70 950 ...	70 950 ...	70 950 ...	72 950 ...
398	113	106	171	19008
 Screw plug	 Countersunk screw	 Screwdriver	 Coolant nozzle	
AS	AS	AS	AS	
72 950 ...	72 950 ...	80 950 ...	72 989 ...	
19006	19007	110	10002	

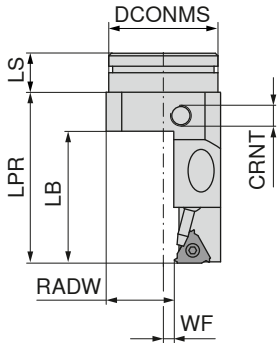
Spare parts
for article number

72 957 08010

CoreLine – Rear holder for right outer thread-turning inserts (ER 16..)

- ▲ For **TSUGAMI** BO 266 / 326 / 386 / 38T / HS 267 / 237 / 38M / BW 269 / 329
- ▲ Tool holder with approach angle 1.5°
- ▲ Thread-turning inserts with pitch max. 1.5 mm

Scope of supply:
Holder with coolant nozzle and screw plug, without coolant connection



Designation	DCONMS _{g6} mm	LS mm	LF mm	WF mm	LPR mm	RADW mm	CRNT	Indexable insert	Right TO 72 957 ... 08005
TS.RE42.65-ER16-R-IK	42	15	50.5	4	65.5	26	M8x1	16 ER..	

Spare parts
for article number

72 957 08005

 Screw plug	 Countersunk screw	 Screwdriver	 Coolant nozzle	 Clamping screw	 Alu ring
AS 72 950 ... 19006	AS 72 950 ... 19007	AS 80 950 ... 112	AS 72 989 ... 10002	AS 71 950 ... 231	AS 72 950 ... 19008

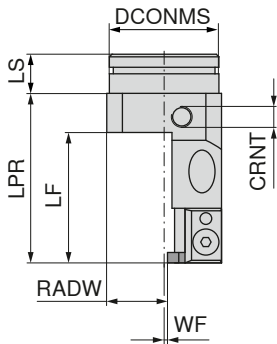


Suitable indexable inserts can be found in the **Thread turning tools chapter**.

CoreLine – Rear holder for TX grooving inserts

- ▲ For **TSUGAMI** BO 266 / 326 / 386 / 38T / HS 267 / 237 / 38M / BW 269 / 329
- ▲ Insert width 0.5-4.0 mm

Scope of supply:
Holder with coolant nozzle and screw plug, without coolant connection



Designation	DCONMS _{g6}	LS	LF	WF	LPR	RADW	CRNT	Indexable insert	TO 72 957 ... 16006
TS.RE42.65-TX-R-IK	42	15	50	1	65.5	23	M8x1	TX R/N/L ...2/3/4	

Spare parts
for article number

72 957 16006

 Screw plug	 Clamping claw	 Lock washer	 Countersunk screw	 Coolant nozzle	 Guide pin with flange	 Alu ring
AS 72 950 ... 19006	AS 72 950 ... 19001	AS 72 950 ... 19002	AS 72 950 ... 19003	AS 72 989 ... 10001	AS 72 950 ... 19004	AS 72 950 ... 19008

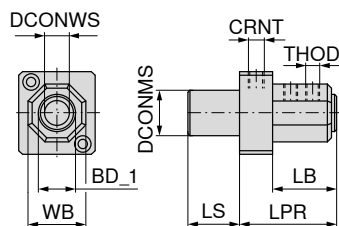


Suitable indexable inserts can be found in the **Grooving tools** chapter.

CoreLine – Rear holder for drills and boring bars

▲ For **STAR** SR 20 R-IV / 20 JII / 32 JII / 38 / SW 12 / 20 / SV 20 R

▲ With inner high-pressure coolant supply through the tool



Designation	DCONMS _{g6} mm	DCONWS mm	BD_1 mm	LPR mm	LS mm	WB mm	LB mm	THOD
ST.SR20R4-BH-06-1K	22	6	12	47	25	28	31	M6
ST.SR20R4-BH-08-1K	22	8	14	47	25	28	31	M8
ST.SR20R4-BH-10-1K	22	10	16	47	25	28	31	M8
ST.SR20R4-BH-12-1K	22	12	18	47	25	28	31	M10
ST.SR20R4-BH-14-1K	22	14	19	47	25	28	31	M10
ST.SR20R4-BH-66-1K	22	16	21	47	25	32	31	M10

TO

72 955 ...

03020

03021

03022

03023

03024

03025

Spare parts
for article number

72 955 03020

72 955 03021

72 955 03022

72 955 03023

72 955 03024

72 955 03025



Set Screw

CT

83 950 ...



Set Screw

AS

72 950 ...

19011

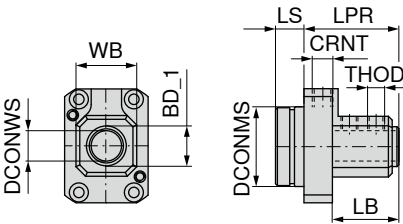
19013

19013

19013

CoreLine – Rear holder for drills and boring bars

- ▲ For **TSUGAMI** BO 266 / 326 / 386 / 38T / HS 267 / 237 / 38M / BW 269 / 329
- ▲ With inner high-pressure coolant supply through the tool



Designation	DCONMS _{g6} mm	DCONWS mm	BD_1 mm	LPR mm	LS mm	WB mm	LB mm	THOD
TS.RE42.65-BH-06-IK	42	6	12	50	15	28	35	M6
TS.RE42.65-BH-08-IK	42	8	14	50	15	28	35	M8
TS.RE42.65-BH-10-IK	42	10	16	50	15	28	35	M8
TS.RE42.65-BH-12-IK	42	12	18	50	15	28	35	M10
TS.RE42.65-BH-14-IK	42	14	18	50	15	28	35	M10
TS.RE42.65-BH-16-IK	42	16	21	50	15	32	35	M10

TO
72 957 ...
03012
03013
03014
03015
03016
03017

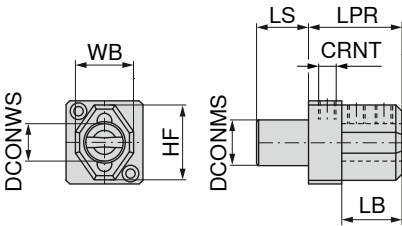
Spare parts
for article number

72 957 03012
72 957 03013
72 957 03014
72 957 03015
72 957 03016
72 957 03017

 Set Screw	 Set Screw
CT	AS
83 950 ...	72 950 ...
464	19011
464	19013
	19013
	19013

CoreLine – Rear holder for clamping inserts

- ▲ For **STAR** SR 20 R-IV / 20 JII / 32 JII / 38 / SW 12 / 20 / SV 20 R
- ▲ Through coolant directly through base holder
- ▲ Also suitable for collet holders



Designation	DCONMS _{g6} mm	DCONWS _{H6} mm	HF mm	LS mm	LB mm	WB mm	LPR mm	CRNT
ST.SR20R4-S20-IK	22	20	36	25	29	28	45	M8x1

TO

72 955 ...

20027

Spare parts
for article number

72 955 20027



CT

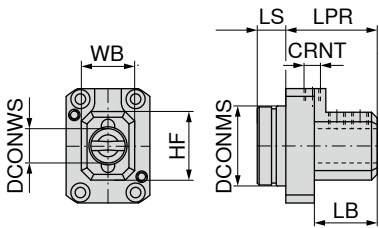
83 950 ...

464

→ You will find matching clamping inserts and collet holders here.

CoreLine – Rear holder for clamping inserts

- ▲ For **TSUGAMI** BO 266 / 326 / 386 / 38T / HS 267 / 237 / 38M / BW 269 / 329
- ▲ Through coolant directly through base holder
- ▲ Also suitable for collet holders



Designation	DCONMS _{g6} mm	DCONWS _{H6} mm	HF mm	LS mm	LB mm	WB mm	LPR mm	CRNT
TS.RE42.65-S-20-IK	42	20	36	15	33	28	48	M8x1

TO

72 957 ...

20018

Spare parts
for article number

72 957 20018



CT

83 950 ...

464



→ You will find matching clamping inserts and collet holders here.

Coolant attachment for height-adjustable insert holder, left



Left

Designation	for
MU.KS-KA-AH-L	MU.AH-...-L

AS

72 985 ...

09003

Coolant attachment for height-adjustable insert holder, right



Right

Designation	for
MU.KS-KA-AH-R	MU.AH-...-R

AS

72 985 ...

09001

Coolant attachment for height-adjustable insert holder, double



Double

Designation	for
MU.KS-KA-AH-D	MU.AH-...-R/L

AS

72 985 ...

09002

Coolant attachment for STAR



Designation
ST.KS-KA-STAR

AS
72 955 ...
09026

Coolant distributor for high-pressure connections - 6 outlets

Scope of supply:
Without quick-couplers



Designation
MU.KSV-45-30-35x6

AS
72 991 ...
12003

Coolant distributor for high-pressure connections - 7 outlets

Scope of supply:
Without quick-couplers



Designation
MU.KSV-80-30-30x7

AS
72 991 ...
12002

Coolant distributor for high-pressure connections - 8 outlets

Scope of supply:

Without quick-couplers

**Designation**

MU.KSV-110-30-30x8

AS

72 991 ...

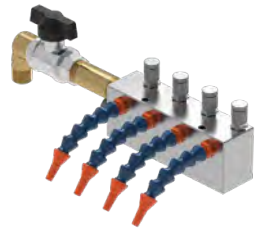
12001

Coolant distributor for STAR SR 32

▲ 4x high-pressure and 4x low-pressure connections (G1/8")

Scope of supply:

Without quick-couplers

**Designation**

MU.KSV-45-30-35x6

AS

72 991 ...

12004

Coolant nozzle for high-pressure applications

**Designation**

MU.KS-KD-HD

AS

72 989 ...

10002

Coolant nozzle for TX grooving tool holder



Designation	AS
MU.KS-KD-HO	72 989 ... 10001

Coolant nozzle for low-pressure applications



Designation	AS
MU.KS-KD-ND	72 989 ... 10003

G1/8" screw plug

- ▲ Maximum 200 bar/2900 psi
- ▲ No sealing ring required



Designation	THSZMS	AS
VS.G1/8	G1/8"	72 950 ... 010

Angled coolant connection - short



Short

Designation	THOD
MU.KS-KA-VU-K	M8x1

AS
72 987 ...
18001

Angled coolant connection - long



Long

Designation	THOD
MU.KS-KA-VU-L	M8x1

AS
72 987 ...
18002

Angled coolant connection for distributor



Designation	THOD	THID
MU.KS-KA-KSV	G1/8"	G1/8"

AS
72 987 ...
18003

Threaded adapter



THID	THOD	THLGTH mm	DRVS mm	OAL mm
G1/8"	G1/4"	11.5	17	15.0
G1/8"	M8x1	11.5	14	15.0
G1/8"	M12x1	11.5	14	15.0
G1/8"	M14x1	11.5	17	15.0
M8x1	G1/4"	11.5	17	15.0
M8x1	M12x1	11.5	14	15.0
M8x1	M14x1	11.5	17	15.0
M8x1	G1/8"	11.5	14	23.5

AS
72 988 ...
01005
01006
01007
01008
01003
01001
01002
01004

Flexible coolant hoses

- ▲ Incl. prefitted quick-coupler and coupler connector
- ▲ Extremely flexible
- ▲ Pressure-resistant up to 300 bar

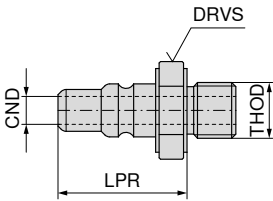


Designation	BD mm	CND mm	OAL mm
MU.KSS-DN3-150	6.0	3	150
MU.KSS-DN3-250	6.0	3	250
MU.KSS-DN5-200	9.5	5	200
MU.KSS-DN5-300	9.5	5	300
MU.KSS-DN5-400	9.5	5	400
MU.KSS-DN5-500	9.5	5	500

AS
72 990 ...
11005
11006
11001
11002
11003
11004

Coupler connector

▲ Pressure-resistant up to at least 400 bar



Designation	LPR mm	CND mm	DRVS mm	OAL mm
MU.KSKS-M8x1	18.5	4	12	19

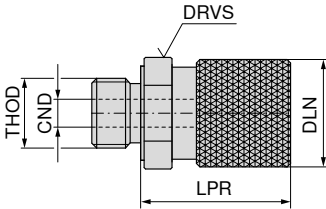
AS

72 992 ...

13001

Quick-coupler

- ▲ Pressure-resistant up to at least 400 bar
- ▲ Rapid change of coolant distribution without screws thanks to click system



THOD	BD mm	DLN mm	LPR mm	CND mm
G1/8"	16	15.5	21.5	4

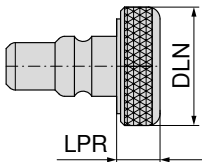
AS

72 993 ...

15001

Sealing plug

▲ For closing off the quick-coupler to protect against contamination



Designation	LPR mm	DLN mm
MU.KSVS	5.5	15.5

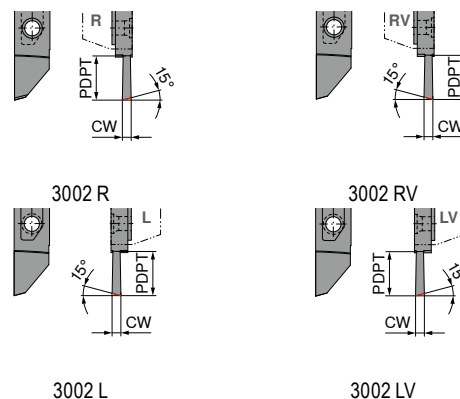
AS

72 994 ...

17001

3002 L / 3002 LV / 3002 R / 3002 RV

Designation	CW mm	PDPT mm
3002-0,8-6	0.8	6
3002-0,8-10	0.8	10
3002-1,0-6	1.0	6
3002-1,0-13	1.0	13
3002-1,2-6	1.2	6
3002-1,5-8	1.5	8
3002-1,5-16	1.5	16
3002-1,8-8	1.8	8
3002-2,0-10	2.0	10
3002-2,0-16	2.0	16
3002-2,5-13	2.5	13
3002-2,5-16	2.5	16
3002-3,0-16	3.0	16



CoreLine – Carbide turning indexable insert

3002_L / 3002_LV / 3002_R / 3002_RV

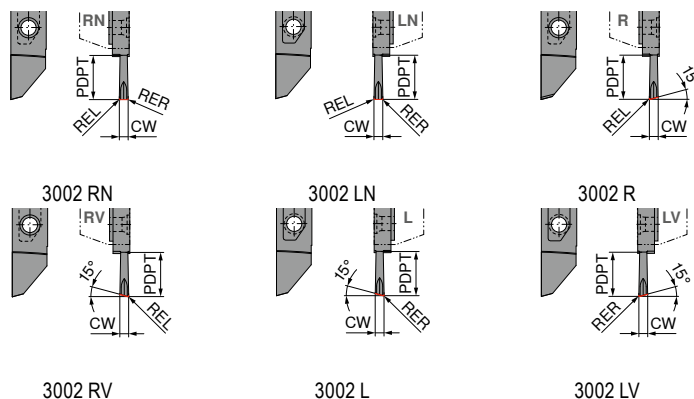
▲ For parting off

Designation	IG	IG	IG	IG
	72 420 ...	72 422 ...	72 416 ...	72 418 ...
3002-0,8-6	510	510	510	510
3002-0,8-10	530	530	530	530
3002-1,0-6	512	512	512	512
3002-1,0-13	532	532	532	532
3002-1,2-6	514	514	514	514
3002-1,5-8	516	516	516	516
3002-1,5-16	536	536	536	536
3002-1,8-8	518	518	518	518
3002-2,0-10	520	520	520	520
3002-2,0-16	540	540	540	540
3002-2,5-13	522 ¹⁾	522 ¹⁾	522 ¹⁾	522 ¹⁾
3002-2,5-16	542 ¹⁾	542 ¹⁾	542 ¹⁾	542 ¹⁾
3002-3,0-16	524 ¹⁾	524 ¹⁾	524 ¹⁾	524 ¹⁾
P	●	●	●	●
M	●	●	●	●
K	●	●	●	●
N	○	○	○	○
S	●	●	●	●
H	●	●	●	●
O	○	○	○	○

1) Used from holder cross-sections of 12 mm

3002 L / 3002 LN / 3002 LV / 3002 R / 3002 RN / 3002 RV

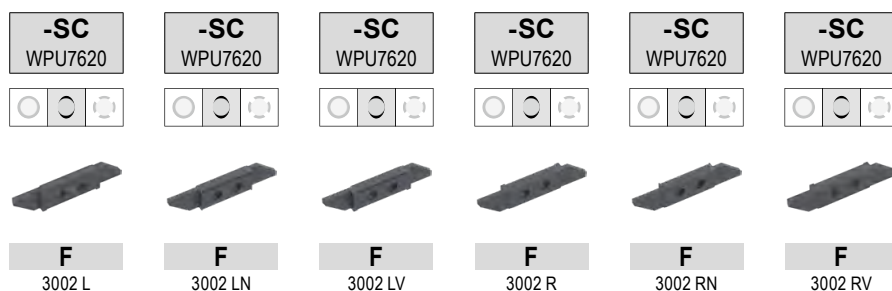
Designation	CW mm	PDPT mm
3002-1,5-8	1.5	8
3002-1,5-10	1.5	10
3002-1,5-16	1.5	16
3002-2,0-10	2.0	10
3002-2,0-16	2.0	16
3002-2,5-13	2.5	13
3002-2,5-16	2.5	16
3002-3,0-16	3.0	16



CoreLine – Carbide turning indexable insert

3002_L / 3002_LN / 3002_LV / 3002_R / 3002_RN / 3002_RV

▲ For parting off



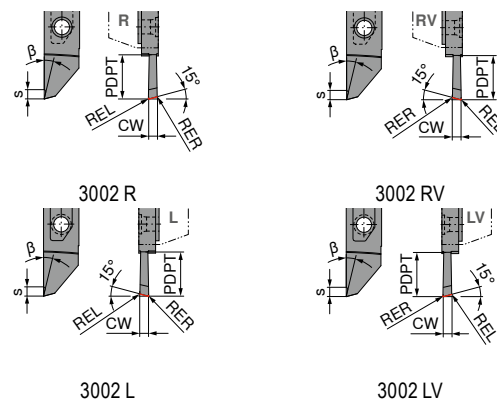
Designation	REL mm	RER mm	IG	IG	IG	IG	IG	IG
3002-1,5-8	0.00	0.08	72 432 ...	72 426 ...	72 434 ...	72 428 ...	72 424 ...	72 430 ...
3002-1,5-8	0.08	0.00	508		508	508		508
3002-1,5-10	0.08	0.08		510			510	
3002-1,5-16	0.08	0.08		530			530	
3002-1,5-16	0.08	0.00				528		528
3002-1,5-16	0.00	0.08	528		528			
3002-2,0-10	0.08	0.08		512			512	
3002-2,0-10	0.08	0.00				510		510
3002-2,0-16	0.00	0.08	510		510			
3002-2,0-16	0.08	0.08		532			532	
3002-2,0-16	0.08	0.00				530		530
3002-2,0-16	0.00	0.08	530		530			
3002-2,5-13	0.08	0.08		514 ¹⁾			514 ¹⁾	
3002-2,5-13	0.08	0.00				512 ¹⁾		512 ¹⁾
3002-2,5-13	0.00	0.08	512 ¹⁾		512 ¹⁾			
3002-2,5-16	0.08	0.08		534 ¹⁾			534 ¹⁾	
3002-2,5-16	0.08	0.00				532 ¹⁾		532 ¹⁾
3002-2,5-16	0.00	0.08	532 ¹⁾		532 ¹⁾			
3002-3,0-16	0.08	0.08		516 ¹⁾			516 ¹⁾	
3002-3,0-16	0.08	0.00				514 ¹⁾		514 ¹⁾
3002-3,0-16	0.00	0.08	514 ¹⁾		514 ¹⁾			

P	●	●	●	●	●	●
M	●	●	●	●	●	●
K						
N	○	○	○	○	○	○
S	●	●	●	●	●	●
H						
O	○	○	○	○	○	○

1) Used from holder cross-sections of 12 mm

3002 L / 3002 LV / 3002 R / 3002 RV

Designation	CW mm	PDPT mm	s mm
3002-0,8-10	0.8	10	2
3002-0,8-10	1.0	10	2
3002-1,0-13	1.0	13	2
3002-1,5-8..	1.5	8	2
3002-1,5-16	1.5	16	2
3002-2,0-10..	2.0	10	2
3002-2,0-16..	2.0	16	2
3002-2,5-13..	2.5	13	2
3002-2,5-16..	2.5	16	2
3002-3,0-16..	3.0	16	2

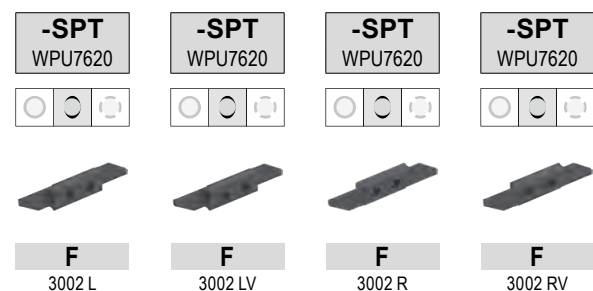


CoreLine – Carbide turning indexable insert

3002_L / 3002_LV / 3002_R / 3002_RV

▲ For parting off

Designation	REL mm	RER mm
3002-0,8-10	0.00	0.00
3002-1,0-13	0.00	0.00
3002-1,5-16	0.00	0.00
3002-1,5-8-06	0.00	0.05
3002-1,5-8-06	0.05	0.00
3002-1,5-8-12	0.00	0.05
3002-1,5-8-12	0.05	0.00
3002-2,0-10-06	0.00	0.05
3002-2,0-10-06	0.05	0.00
3002-2,0-10-12	0.00	0.05
3002-2,0-10-12	0.05	0.00
3002-2,0-16-06	0.00	0.05
3002-2,0-16-06	0.05	0.00
3002-2,0-16-12	0.00	0.05
3002-2,0-16-12	0.05	0.00
3002-2,5-13-06	0.00	0.05
3002-2,5-13-06	0.05	0.00
3002-2,5-13-12	0.00	0.05
3002-2,5-13-12	0.05	0.00
3002-2,5-16-06	0.00	0.05
3002-2,5-16-06	0.05	0.00
3002-2,5-16-12	0.00	0.05
3002-2,5-16-12	0.05	0.00
3002-3,0-16-06	0.00	0.05
3002-3,0-16-06	0.05	0.00
3002-3,0-16-12	0.00	0.05
3002-3,0-16-12	0.05	0.00

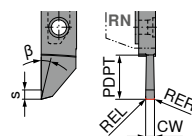


IG	IG	IG	IG
72 440 ...	72 442 ...	72 436 ...	72 438 ...
50600	50600	50600	50600
52800	52800	52800	52800
53000	53000	53000	53000
540	540	540	540
570	570	570	570
572	572	572	572
582	582	582	582
552	552	552	552
592	592	592	592
554	554	554	554
584	584	584	584
574	574	574	574
594	594	594	594
556	556	556	556
586	586	586	586

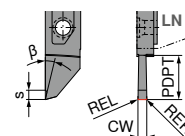
P	●	●	●	●
M	●	●	●	●
K	○	○	○	○
N	○	○	○	○
S	●	●	●	●
H	○	○	○	○
O	○	○	○	○

3002 LN / 3002 RN

Designation	CW mm	PDPT mm	s mm	β°
3002-1,0-10	1.0	10	2	20
3002-1,5-10-06	1.5	10	2	6
3002-1,5-10-12	1.5	10	2	12
3002-1,5-16	1.5	16	2	20
3002-2,0-10-06	2.0	10	2	6
3002-2,0-10-12	2.0	10	2	12
3002-2,0-16-12	2.0	16	2	12
3002-2,0-16-06	2.0	16	2	6
3002-2,5-13-12	2.5	13	2	12
3002-2,5-13-06	2.5	13	2	6
3002-2,5-16-06	2.5	16	2	6
3002-2,5-16-12	2.5	16	2	12
3002-3,0-16-12	3.0	16	2	12
3002-3,0-16-06	3.0	16	2	6



3002 RN



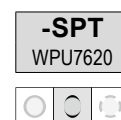
3002 LN

CoreLine – Carbide turning indexable insert

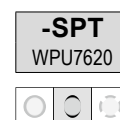
3002_LN / 3002_RN

▲ For parting off

Designation	REL mm	RER mm
3002-1,0-10	0.05	0.05
3002-1,5-10-06	0.05	0.05
3002-1,5-10-12	0.05	0.05
3002-1,5-16	0.05	0.05
3002-2,0-10-06	0.05	0.05
3002-2,0-10-12	0.05	0.05
3002-2,0-16-06	0.05	0.05
3002-2,0-16-12	0.05	0.05
3002-2,5-13-06	0.05	0.05
3002-2,5-13-12	0.05	0.05
3002-2,5-16-06	0.05	0.05
3002-2,5-16-12	0.05	0.05
3002-3,0-16-06	0.05	0.05
3002-3,0-16-12	0.05	0.05



F
3002 LN



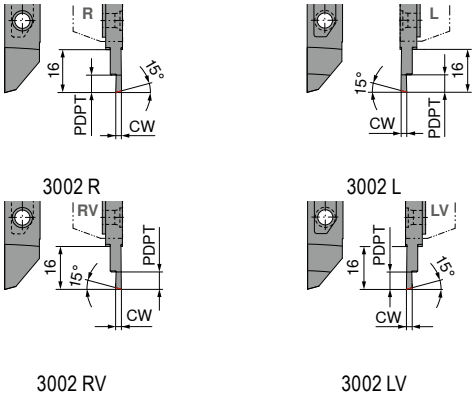
F
3002 RN

IG	IG
72 515 ...	72 514 ...
50800	50800
550	550
580	580
53000	53000
572	572
582	582
552	552
592	592
554	554
584	584
574	574
594	594
556	556
586	586

P	●	●
M	●	●
K		
N	○	○
S	●	●
H		
O	○	○

3002 L-16 / 3002 LV-16 / 3002 R-16 / 3002 RV-16

Designation	CW mm	PDPT mm
3002-0,8-..	0.8	6
3002-1,0-..	1.0	6
3002-1,2-..	1.2	6



CoreLine – Carbide turning indexable insert

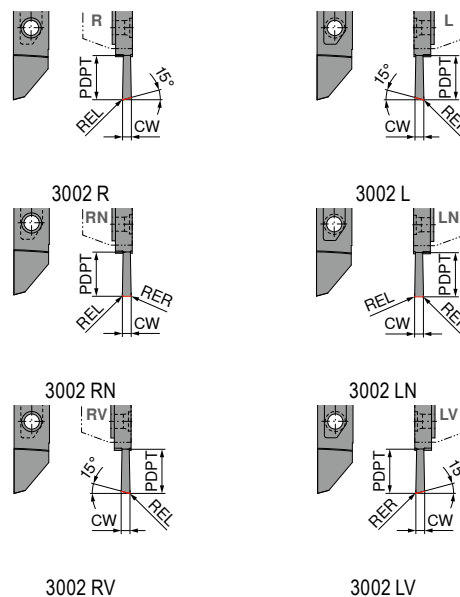
3002_L_16 / 3002_LV_16 / 3002_R_16 / 3002_RV_16

▲ For parting off with pick-up spindle

Designation	WPU7620			
	F 3002 L-16	F 3002 LV-16	F 3002 R-16	F 3002 RV-16
	IG 72 497 ...	IG 72 499 ...	IG 72 496 ...	IG 72 498 ...
3002-0,8-6-16	510	510	510	510
3002-1,0-6-16	51200	51200	51200	51200
3002-1,2-6-16	514	514	514	514
P	●	●	●	●
M	●	●	●	●
K	●	●	●	●
N	○	○	○	○
S	●	●	●	●
H				
O	○	○	○	○

3002 L / 3002 LN / 3002 LV / 3002 R / 3002 RN / 3002 RV

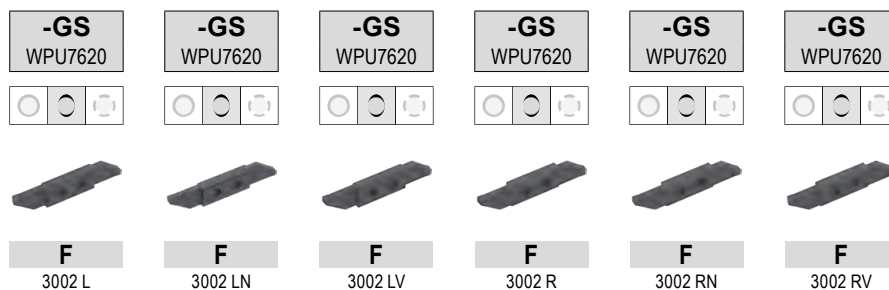
Designation	CW mm	PDPT mm
3002-2,0-10..	2	10



CoreLine – Carbide turning indexable insert

3002_L / 3002_LN / 3002_LV / 3002_R / 3002_RN / 3002_RV

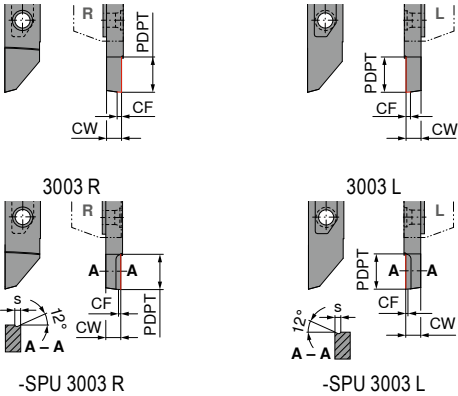
- ▲ For parting off
- ▲ E: Rounded cutting edges
- ▲ F: Sharp cutting edges



Designation	REL mm	RER mm	IG	IG	IG	IG	IG	IG
3002-2,0-10 E	0.2	0.2	72 501 ...	72 505 ...	72 507 ...	72 500 ...	72 504 ...	72 506 ...
3002-2,0-10 E	0.2	0.0		512		512	512	512
3002-2,0-10 E	0.0	0.2	512		512			512
3002-2,0-10 F	0.2	0.2		552		552	552	
3002-2,0-10 F	0.2	0.0			552	552		552
3002-2,0-10 F	0.0	0.2	552		552			552
P			●	●	●	●	●	●
M			●	●	●	●	●	●
K								
N			○	○	○	○	○	○
S			●	●	●	●	●	●
H								
O			○	○	○	○	○	○

3003 L / 3003 R

Designation	CBMD	CW	CF	s	PDPT
		mm	mm	mm	mm
3003-3,4-..	-SPU	3.4	0.2	1.2	8
3003-3,4-..		3.4	1.0	-	8



CoreLine – Carbide turning indexable insert

3003_L / 3003_R

▲ For front turning

WPU7620

F

3003 L

TR

72 446 ...

510

WPU7620

F

3003 R

TR

72 444 ...

510

-SPU WPU7620

F

3003 L

TR

72 521 ...

510

-SPU WPU7620

F

3003 R

TR

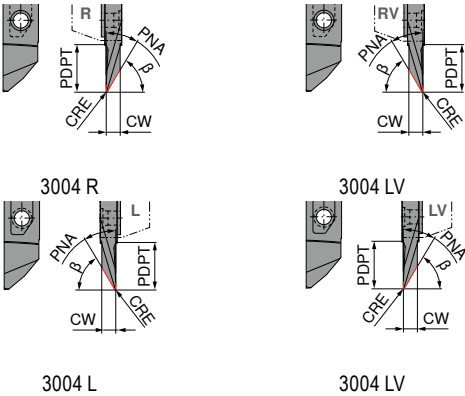
72 520 ...

510

Designation				
3003-3,4-8				
P		●	●	●
M		●	●	●
K				
N		○	○	○
S		●	●	●
H				
O		○	○	○

3004 L / 3004 LV / 3004 R / 3004 RV

Designation	CRE mm	CW mm	PDPT mm	PNA °	β°
3004-3,2-5 35015	0.15	3.2	11	35	55
3004-3,2-5 35035	0.35	3.2	11	35	55
3004-3,2-6 29008	0.08	3.2	11	29	61
3004-3,2-6 29015	0.15	3.2	11	29	61
3004-3,2-6 29035	0.35	3.2	11	29	61
3004-3,2-6 29075	0.75	3.2	11	29	61



CoreLine – Carbide turning indexable insert

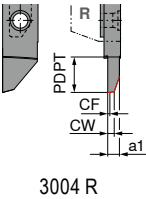
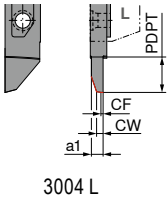
3004_L / 3004_LV / 3004_R / 3004_RV

▲ For back turning

Designation	-SP WPU7620			
	F 3004 L	F 3004 LV	F 3004 R	F 3004 RV
	TR 72 562 ...	TR 72 563 ...	TR 72 560 ...	TR 72 561 ...
3004-3,2-5 35015	514		514	
3004-3,2-5 35035	516		516	
3004-3,2-6 29008	508	508	508	508
3004-3,2-6 29015	510	510	510	510
3004-3,2-6 29035	512	512	512	512
3004-3,2-6 29075	515	515	515	515
P	●	●	●	●
M	●	●	●	●
K				
N	○	○	○	○
S	●	●	●	●
H				
O	○	○	○	○

3004 L / 3004 R

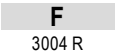
Designation	CW mm	CF mm	PDPT mm	a ₁ mm
3004-0,8-..	0.8	0.5	6	2.0
3004-1,0-..	1.0	0.5	6	2.2
3004-1,2-..	1.2	0.5	8	2.4
3004-1,5-..	1.5	0.5	8	2.7
3004-1,8-..	1.8	0.5	8	3.0



CoreLine – Carbide turning indexable insert

3004_L / 3004_R

▲ For back turning

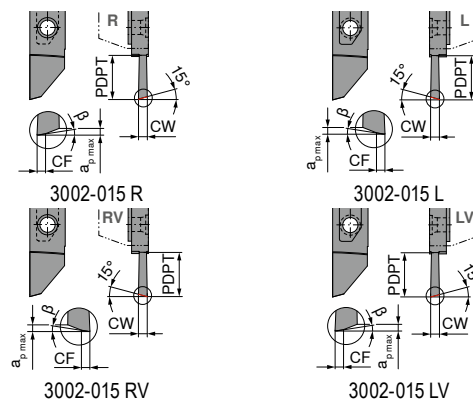


Designation
3004-0,8-6
3004-1,0-6
3004-1,2-8
3004-1,5-8
3004-1,8-8
P
M
K
N
S
H
O

TR
72 457 ...
504
506
508
510
512

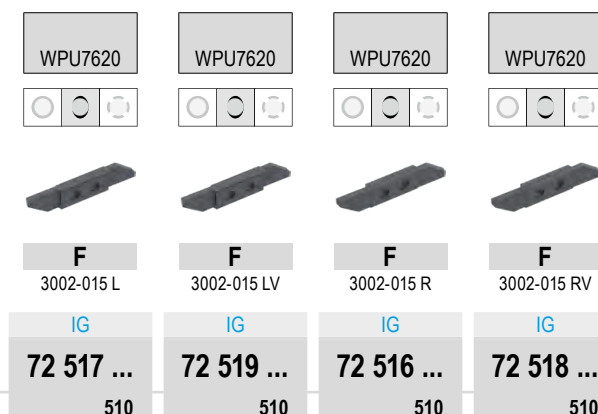
TR
72 456 ...
504
506
508
510
512

Designation	CW mm	CF mm	PDPT mm	β°	a_p max. mm
3002-015-..	2	0.3	10	1,5	0.45



3002_015 L / 3002_015 LV / 3002_015 R / 3002_015 RV

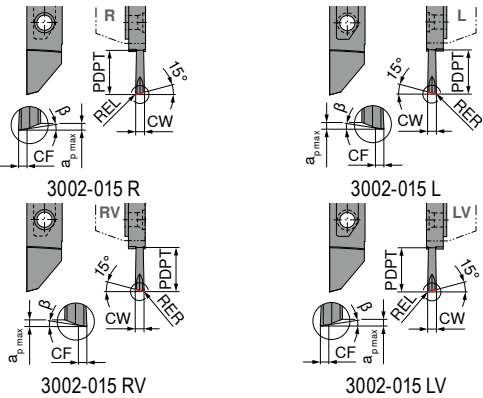
▲ For turning and parting off



Designation	72 517 ...	72 519 ...	72 516 ...	72 518 ...
3002-015-2,0-10	510	510	510	510
P	●	●	●	●
M	●	●	●	●
K				
N	○	○	○	○
S	●	●	●	●
H				
Q	○	○	○	○

3002-015 L / 3002-015 LV / 3002-015 R / 3002-015 RV

Designation	CW mm	CF mm	PDPT mm	β°	$a_{p\max}$ mm
3002-015-..	2	0.3	10	15	0.45



CoreLine – Carbide turning indexable insert

3002_015_L / 3002_015_LV / 3002_015_R / 3002_015_RV

▲ For turning and parting off

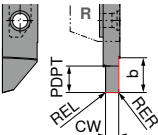
Designation	REL mm	RER mm
3002-015-2,0-10	0.15	0.00
3002-015-2,0-10	0.00	0.15

-SC WPU7620	-SC WPU7620	-SC WPU7620	-SC WPU7620
F 3002-015 L	F 3002-015 LV	F 3002-015 R	F 3002-015 RV
IG 72 511 ... 510	IG 72 513 ... 510	IG 72 510 ... 510	IG 72 512 ... 510

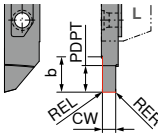
P				
M				
K				
N				
S				
H				
O				

3005 L / 3005 R

Designation	CW mm	PDPT mm	b mm
3005-1,0-..	1.0	2.5	8
3005-1,5-..	1.5	3.0	8
3005-2,0-..	2.0	4.0	8
3005-2,5-..	2.5	5.0	8
3005-3,0-..	3.0	6.0	8



3005 R



3005 L

CoreLine – Carbide turning indexable insert

3005_L / 3005_R

▲ For grooving and longitudinal turning

Designation	REL mm	RER mm
3005-1,0-2,5	0.05	0.05
3005-1,5-3	0.05	0.05
3005-2,0-4	0.05	0.05
3005-2,5-5	0.05	0.05
3005-3,0-6	0.05	0.05



F
3005 L

F
3005 R

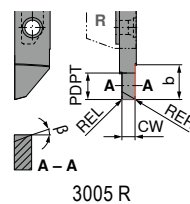
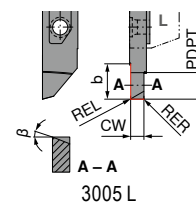
TR
72 466 ...
518
510
512
514
516

TR
72 464 ...
518
510
512
514
516

P	●	●
M	●	●
K		
N	○	○
S	●	●
H		
O	○	○

3005 L / 3005 R

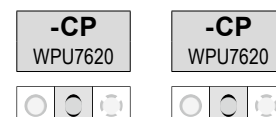
Designation	CW mm	PDPT mm	b mm	β°
3005-0,8-2,5	0.8	2.5	8	10
3005-1,0-3,5	1.0	3.5	8	10
3005-1,5-4	1.5	4.0	8	10
3005-1,5-4 R08	1.5	4.0	8	10
3005-2,0-5	2.0	5.0	8	10
3005-2,0-5 R08	2.0	5.0	8	10
3005-2,0-5 R15	2.0	5.0	8	10
3005-2,5-6	2.5	6.0	8	10
3005-2,5-6 R08	2.5	6.0	8	10
3005-2,5-6 R15	2.5	6.0	8	10
3005-3,0-6	3.0	6.0	8	10
3005-3,0-6 R08	3.0	6.0	8	10
3005-3,0-6 R15	3.0	6.0	8	10



CoreLine – Carbide turning indexable insert

3005_L / 3005_R

▲ For grooving and longitudinal turning



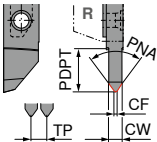
Designation	REL mm	RER mm
3005-0,8-2,5	0.00	0.00
3005-1,0-3,5	0.00	0.00
3005-1,5-4	0.00	0.00
3005-1,5-4 R08	0.08	0.08
3005-2,0-5	0.00	0.00
3005-2,0-5 R08	0.08	0.08
3005-2,0-5 R15	0.15	0.15
3005-2,5-6	0.00	0.00
3005-2,5-6 R08	0.08	0.08
3005-2,5-6 R15	0.15	0.15
3005-3,0-6	0.00	0.00
3005-3,0-6 R08	0.08	0.08
3005-3,0-6 R15	0.15	0.15

TR	TR
72 470 ...	72 468 ...
508	508
518	518
510	528
519	519
512	512
522	522
532	532
514	514
524	524
534	534
516	516
526	526
536	536

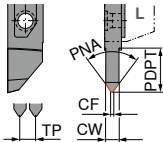
P	●	●
M	●	●
K		
N	○	○
S	●	●
H		
O	○	○

3006 L / 3006 R

Designation	TP mm	CW mm	PDPT mm	PNA °	CF mm
3006-2-6-..	0,25 - 2,0	2	6	60	0.035
3006-3-10-..	0,25 - 2,0	3	10	60	0.035



3006 R

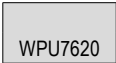
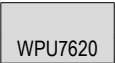


3006 L

CoreLine – Carbide turning indexable insert

3006_L / 3006_R

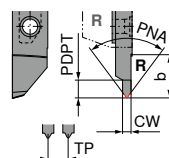
▲ For thread turning (partial profile)



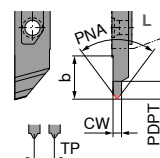
Designation		TR	TR
3006-2-6-60		72 478 ...	72 476 ...
3006-3-10-60		510	510
		512	512
P		●	●
M		●	●
K			
N		○	○
S		●	●
H			
O		○	○

3006 VP L / 3006 VP R

Designation	TP mm	TD mm	CW mm	PDPT mm	b mm	PNA °
3006-0,15..	0.15	M0,6	0.16	0.275	8	60
3006-0,25..	0.25	M1 - M1,2	0.28	0.275	8	60
3006-0,35..	0.35	M1,6 - M1,8	0.36	0.275	8	60
3006-0,35..	0.35	M1,6 - M1,8	0.38	0.275	8	60
3006-0,4..	0.40	M2	0.44	0.275	8	60
3006-0,45..	0.45	M2,2 - M2,5	0.50	0.275	8	60
3006-0,5..	0.50	M3	0.70	1.400	8	60
3006-0,6..	0.60	M3,5	0.80	1.400	8	60
3006-0,7..	0.70	M4	0.90	1.800	8	60
3006-0,75..	0.75	M4,5	0.95	1.900	8	60
3006-0,8..	0.80	M5	1.00	2.000	8	60
3006-1,0..	1.00	M6 - M7	1.20	2.400	8	60
3006-1,25..	1.25	M8 - M9	1.45	2.900	8	60
3006-1,5..	1.50	M10 - M11	1.74	3.400	8	60
3006-1,75..	1.75	M12	1.95	3.900	8	60
3006-2,0..	2.00	M14 - M16	2.20	4.000	8	60



3006 R

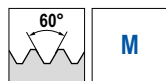


3006 L

CoreLine – Carbide turning indexable insert

3006_VP_L / 3006_VP_R

▲ For thread turning (full profile)



F
3006 VP L

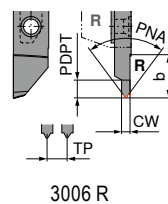
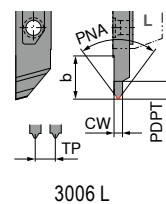


F
3006 VP R

Designation	TR	TR
3006-0,15-10-60 VP	72 474 ...	72 472 ...
3006-0,25-10-60 VP	50800	50800
3006-0,35-10-60 VP	510	510
3006-0,4-10-60 VP	512	512
3006-0,45-10-60 VP	514	514
3006-0,5-10-60 VP	516	516
3006-0,6-10-60 VP	518	518
3006-0,7-10-60 VP	520	520
3006-0,75-10-60 VP	522	522
3006-0,8-10-60 VP	524	524
3006-1,0-10-60 VP	526	526
3006-1,25-10-60 VP	528	528
3006-1,5-10-60 VP	530	530
3006-1,75-10-60 VP	532	532
3006-2,0-10-60 VP	534	534
		53600
P	●	●
M	●	●
K		
N	○	○
S	●	●
H		
O	○	○

3006 VP L / 3006 VP R

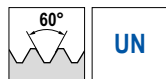
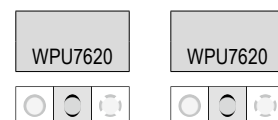
Designation	TP mm	CW mm	PDPT mm	b mm	PNA °
3006-13 U..	1.954	2.4	4.2	8	60
3006-14 U..	1.814	2.2	3.9	8	60
3006-16 U..	1.588	1.8	3.6	8	60
3006-18 U..	1.411	1.6	3.4	8	60
3006-20 U..	1.270	1.4	2.9	8	60
3006-24 U..	1.058	1.2	2.4	8	60
3006-28 U..	0.907	1.2	2.2	8	60
3006-32 U..	0.794	1.0	2.0	8	60
3006-36 U..	0.705	0.8	1.8	8	60
3006-40 U..	0.635	0.8	1.8	8	60
3006-44 U..	0.577	0.8	1.4	8	60
3006-48 U..	0.529	0.6	1.4	8	60



CoreLine – Carbide turning indexable insert

3006_VP_L / 3006_VP_R

▲ For thread turning (full profile UN)



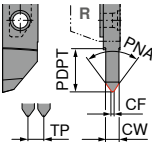
F
3006 VP L

F
3006 VP R

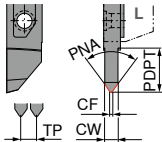
Designation	TR 72 531 ...	TR 72 530 ...
3006-13 UN 10-60 VP	52400	52400
3006-14 UN 10-60 VP	52200	52200
3006-16 UN 10-60 VP	52000	52000
3006-18 UN 10-60 VP	51800	51800
3006-20 UN 10-60 VP	51600	51600
3006-24 UN 10-60 VP	51400	51400
3006-28 UN 10-60 VP	51200	51200
3006-32 UN 10-60 VP	51000	51000
3006-36 UN 10-60 VP	50800	50800
3006-40 UN 10-60 VP	50600	50600
3006-44 UN 10-60 VP	50400	50400
3006-48 UN 10-60 VP	50200	50200
P	●	●
M	●	●
K		
N	○	○
S	●	●
H		
O	○	○

3006 L / 3006 R

Designation	TP mm	CW mm	PDPT mm	PNA °	CF mm
3006-2-6-..	0,25 - 2,0	2	6	55	0.035
3006-3-10-..	0,25 - 2,0	3	10	55	0.035



3006 R



3006 L

CoreLine – Carbide turning indexable insert

3006_L / 3006_R

▲ For thread turning (partial profile)



WPU7620



WPU7620



F
3006 L

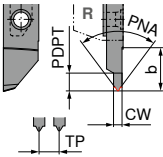


F
3006 R

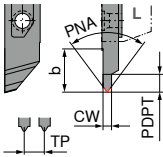
Designation	TR 72 527 ...	TR 72 526 ...
3006-2-6-55	50000	50000
3006-3-10-55	50200	50200
P	●	●
M	●	●
K		
N	○	○
S	●	●
H		
O	○	○

3006 VP L / 3006 VP R

Designation	TP mm	TD mm	CW mm	PDPT mm	b mm	PNA °
3006-G11-..	2.309	1-11 - 6-11	2.54	5.0	8	55
3006-G14-..	1.814	1/2-14 - 7/8-14	2.00	4.5	8	55
3006-G19-..	1.337	1/4-19 - 3/8-19	1.48	3.3	8	55
3006-G28-..	0.907	1/8-28 - 1/16-28	1.00	2.3	8	55



3006 R

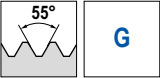
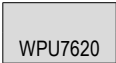
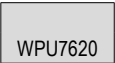


3006 L

CoreLine – Carbide turning indexable insert

3006_VP_L / 3006_VP_R

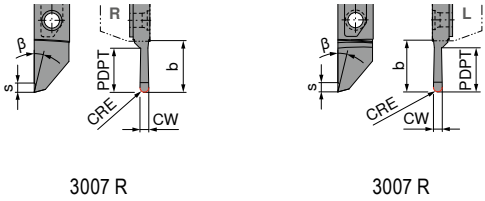
▲ For thread turning (full profile)



Designation		72 529 ...	72 528 ...
3006-G11-10-55 VP		51100	51100
3006-G14-10-55 VP		51400	51400
3006-G19-10-55 VP		51900	51900
3006-G28-10-55 VP		52800	52800
P		●	●
M		●	●
K			
N		○	○
S		●	●
H			
O		○	○

3007 L / 3007 R

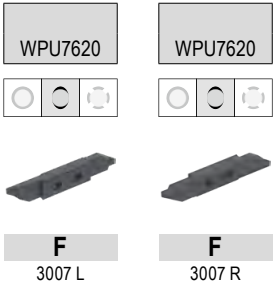
Designation	CW mm	b mm	PDPT mm	CRE mm	s mm	β°
3007-R0,25-2-..	0.5	12	2.0	0.25	2	6
3007-R0,5-2,5-..	1.0	12	2.5	0.50	2	6
3007-R0,6-2,5-..	1.2	12	2.5	0.60	2	6
3007-R0,75-3-..	1.5	12	3.0	0.75	2	6
3007-R0,8-3-1-..	1.6	12	3.0	0.80	2	6
3007-R1,0-10	2.0	12	10.0	1.00	2	6
3007-R1,5-10	3.0	12	10.0	1.50	2	6
3007-R1,5-16	3.0	17	16.0	1.50	2	6



CoreLine – Carbide turning indexable insert

3007_L / 3007_R

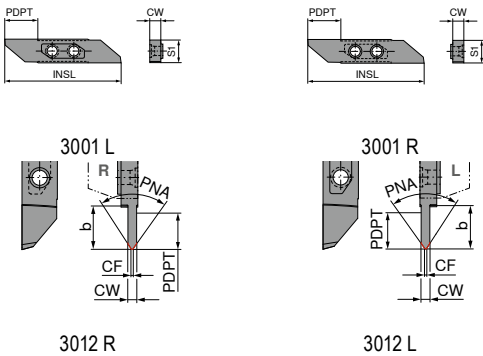
▲ For radius grooving



Designation	TR	TR
3007-R0,25-2-10	72 482 ...	72 480 ...
3007-R0,5-2,5-10	510	510
3007-R0,6-2,5-10	512	512
3007-R0,75-3-10	514	514
3007-R0,8-3-10	516	516
3007-R1,0-10	518	518
3007-R1,5-10	520	520
3007-R1,5-16	522	522
	524	524
P	●	●
M	●	●
K	●	●
N	○	○
S	●	●
H	○	○
O	○	○

3012 L / 3012 R / 3001 L / 3001 R

Designation	CW mm	PDPT mm	b mm	PNA °	CF mm
3012-2-6-..	2.0	2	10	60	0.035
3012-2-10-..	2.0	10	12	90	0.02
3001-3,5-..	3.5	11	-	-	-
3001-3,6-..	3.6	17	-	-	-



CoreLine – Carbide turning indexable insert

3012_L / 3012_R

▲ For chamfering



WPU7620





F
3012 L

WPU7620



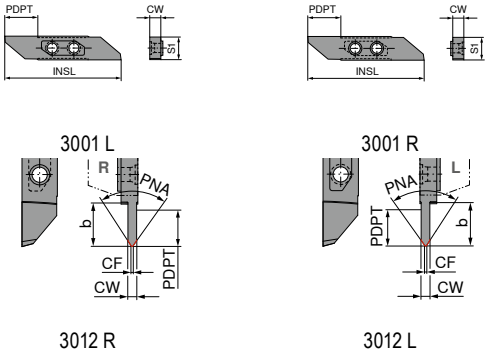


F
3012 R

Designation	TR 72 486 ...	TR 72 484 ...
3012-2-6-60	51000	51000
3012-2-10-45	51200	51200
P	●	●
M	●	●
K		
N	○	○
S	●	●
H		
O	○	○

3012 L / 3012 R / 3001 L / 3001 R

Designation	CW	PDPT	S1	INSL
	mm	mm	mm	mm
3001-3,5-..	3.5	11	8	40.5
3001-3,6-..	3.6	17	8	51.5
3012-2-10..	2.0	10	8	40.0
3012-2-6-..	2.0	2	8	40.0



CoreLine – Carbide turning indexable insert

3001_L / 3001_R

▲ Blank

Designation		
3001-3,5-10		
3001-3,6-17		

WUU7620



3001 L

TR

72 414 ...

11000

13000

WUU7620



3001 R

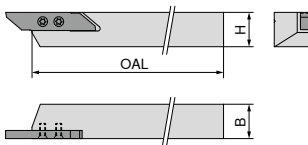
TR

72 412 ...

11000

13000

CoreLine – Standard tool holder – VertiClamp



Illustrations show right-hand versions

Designation	H mm	B mm	OAL mm	Indexable insert
3000-08x100 .	8	8	100	30..
3000-10x100 .	10	10	100	30..
3000-12x100 .	12	12	100	30..
3000-16x125 .	16	16	125	30..
3000-20x125 .	20	20	125	30..
3000-25x150 .	25	25	150	30..

Left	Right
TO	TO
72 302 ...	72 300 ...
008	008
010	010
012	012
016	016
020	020
025	

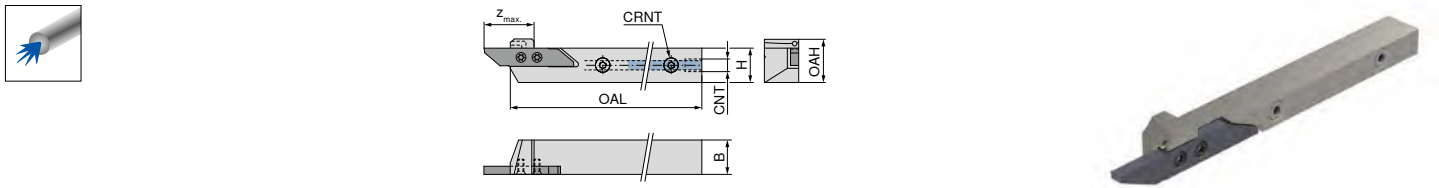
Spare parts
for article number

72 300 008 / 72 302 008
72 300 010 / 72 302 010
72 300 012 / 72 302 012
72 300 016 / 72 302 016
72 300 020 / 72 302 020
72 302 025

	
Screwdriver	Clamping screw
AS	AS
80 950 ...	72 950 ...
T08 110	004
T08 110	005
T08 110	005
T08 110	005
T08 110	005
T08 110	005

CoreLine – Standard tool holder with through coolant – VertiClamp

Scope of supply:
Holder without coolant connection



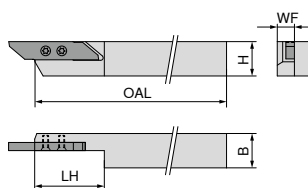
Illustrations show right-hand versions

Designation	H mm	B mm	OAL mm	OAH mm	z _{max} mm	CRNT	CNT	Indexable insert	Left	Right
									TO	TO
3000-08x100 .IC	8	12	100	12.2	26	M5	M5	30..	72 311 ...	72 310 ...
3000-10x100 .IC	10	12	100	14.0	26	M5	M5	30..	008	008
3000-12x100 .IC	12	12	100	16.0	26	M5	M5	30..	010	010
3000-16x100 .IC	16	16	125	20.0	26	M5	G1/8"	30..	012	012
3000-20x100 .IC	20	20	125	24.0	26	M5	G1/8"	30..	016	016
3000-25x100 .IC	25	25	125	29.0	26	M5	G1/8"	30..	020	020
									025	025

Spare parts
for article number

	Screw plug		Screw plug		Screwdriver		Clamping screw	
	AS	72 950 ...	AS	72 950 ...	AS	80 950 ...	AS	72 950 ...
72 310 008 / 72 311 008			M5x4	011	T08	110		004
72 310 010 / 72 311 010			M5x4	011	T08	110		005
72 310 012 / 72 311 012			M5x4	011	T08	110		005
72 310 016 / 72 311 016	G1/8"	010	M5x4	011	T08	110		005
72 310 020 / 72 311 020	G1/8"	010	M5x4	011	T08	110		005
72 310 025 / 72 311 025	G1/8"	010	M5x4	011	T08	110		005

CoreLine – Offset tool holder – VertiClamp



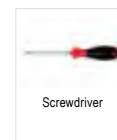
Illustrations show right-hand versions



Designation	H mm	B mm	OAL mm	LH mm	WF mm	Indexable insert	Left TO 72 309 ... 006 008 010	Right TO 72 308 ... 006 008 010
3000-10x100 .A	10	10	100	37	8	30..		
3000-12x100 .A	12	12	100	37	8	30..		
3000-16x125 .A	16	16	125	37	8	30..		

Spare parts for article number

72 308 006 / 72 309 006	T08	110	004
72 308 008 / 72 309 008	T08	110	004
72 308 010 / 72 309 010	T08	110	004



Screwdriver



Clamping screw

AS

80 950 ...

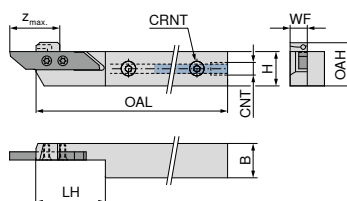
AS

72 950 ...

CoreLine – Offset tool holder with through coolant – VertiClamp

Scope of supply:

Holder without coolant connection



Illustrations show right-hand versions



Designation	H mm	B mm	OAL mm	WF mm	LH mm	OAH mm	z_max. mm	CNT	CRNT	Indexable insert	Left TO 72 315 ... 016	Right TO 72 314 ... 016
3000-16x125 .A IC	16	16	125	8	37	20	27	G1/8"	M5	30..		

Spare parts for article number

72 314 016 / 72 315 016	G1/8"	010	M5x4	011	T08	110	004
-------------------------	-------	-----	------	-----	-----	-----	-----



Screw plug



Screw plug



Screwdriver



Clamping screw

AS

72 950 ...

AS

72 950 ...

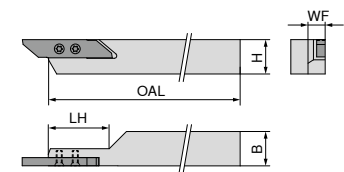
AS

80 950 ...

AS

72 950 ...

CoreLine – Offset tool holder with offset insert seat – VertiClamp



Illustrations show right-hand versions

Designation	H mm	B mm	OAL mm	LH mm	WF mm	Indexable insert
3000-10x100 .AV	10	10	100	28	8	30..
3000-12x100 .AV	12	12	100	28	8	30..
3000-16x125 .AV	16	16	125	28	8	30..

Left	Right
TO	TO
72 317 ...	72 316 ...
010	010
012	
016	016

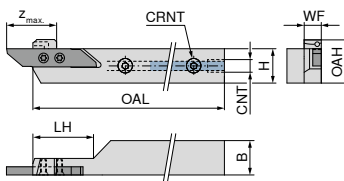
Spare parts
for article number

72 316 010 / 72 317 010	T08
72 317 012	T08
72 316 016 / 72 317 016	T08

Screwdriver	Clamping screw
AS	AS
80 950 ...	72 950 ...
110	004
110	004
110	004

CoreLine – Offset tool holder with offset insert seat and through coolant – VertiClamp

Scope of supply:
Holder without coolant connection



Illustrations show right-hand versions

Designation	H mm	B mm	OAL mm	OAH mm	Z _{max} mm	CRNT	CNT	Indexable insert
3000-16x125 .AV IC	16	16	125	20	27	M5	G1/8"	30..

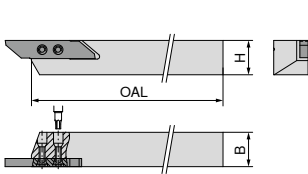
Left	Right
TO	TO
72 313 ...	72 312 ...
016	016

Spare parts
for article number

72 312 016 / 72 313 016	G1/8"	M5x4	T08
-------------------------	-------	------	-----

Screw plug	Screw plug	Screwdriver	Clamping screw
AS	AS	AS	AS
72 950 ...	72 950 ...	80 950 ...	72 950 ...
010	011	110	004

CoreLine – Combi tool holder – VertiClamp



Illustrations show right-hand versions

Designation	H mm	B mm	OAL mm	Indexable insert
3000-08x100 .C	8	8	100	30..
3000-10x100 .C	10	10	100	30..
3000-12x100 .C	12	12	100	30..
3000-16x125 .C	16	16	125	30..
3000-20x125 .C	20	20	125	30..

Left	Right
TO	TO
72 306 ...	72 304 ...
008	008
010	010
012	012
016	016
020	020

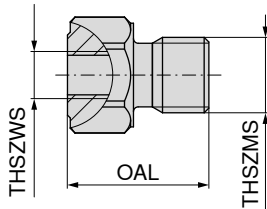
Spare parts
for article number

72 304 008 / 72 306 008
72 304 010 / 72 306 010
72 304 012 / 72 306 012
72 304 016 / 72 306 016
72 304 020 / 72 306 020

		
Screwdriver	Clamping screw	Threaded bush
AS	AS	AS
80 950 ...	72 950 ...	72 950 ...
T08 110	003 008	008 008
T08 110	003 008	008 008
T08 110	003 008	008 008
T08 110	003 008	008 008
T08 110	003 008	008 008

Reduction fitting

- ▲ Maximum 200 bar/2900 psi
- ▲ No sealing ring required



Designation	THSZWS	THSZMS	OAL mm
RV.100.M6-M5	M5	M6	18
RV.100.M8x1-M5	M5	M8x1	15
RV.100.M10x1-M5	M5	M10x1	15
RV.100.G1/8-M5	M5	G1/8"	15

AS

72 301 ...

002

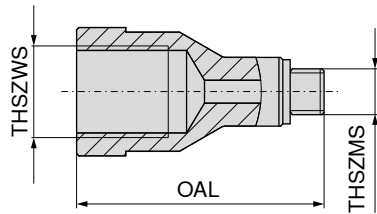
008

007

006

Reduction fitting

- ▲ Maximum 200 bar/2900 psi
- ▲ Including sealing ring



Designation	THSZWS	THSZMS	OAL mm
RV.100.M5-M6	M6	M5	15
RV.100.M5-M8x1	M8x1	M5	23
RV.100.M5-M10x1	M10x1	M5	27
RV.100.M5-G1/8	G1/8"	M5	27

AS
72 301 ...
001
003
005
004

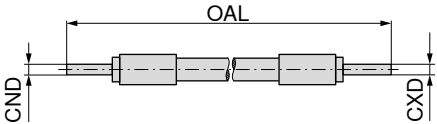
Spare parts
for article number

72 301 001	M5
72 301 003	M5
72 301 005	M5
72 301 004	M5

 Sealing ring
AS
72 950 ...
009
009
009
009

Hose (connector/connector)

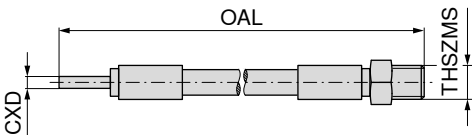
▲ Maximum 200 bar/2900 psi



Designation	CND mm	CXD mm	OAL mm	AS
HDKS.150.4-4	4	4	150	72 305 ...
HDKS.200.4-4	4	4	200	003
HDKS.300.4-4	4	4	300	014
HDKS.500.4-4	4	4	500	025
				037

Hose (connector/thread)

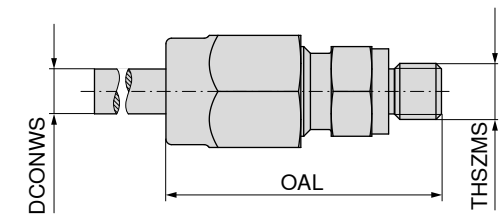
- ▲ Maximum 200 bar/2900 psi
- ▲ No sealing ring required



Designation	THSZMS	CXD mm	OAL mm	AS
HDKS.150.M5-4	M5	4	150	72 305 ...
HDKS.200.M5-4	M5	4	200	010
HDKS.300.M5-4	M5	4	300	021
HDKS.500.M5-4	M5	4	500	033
				045

Straight fitting

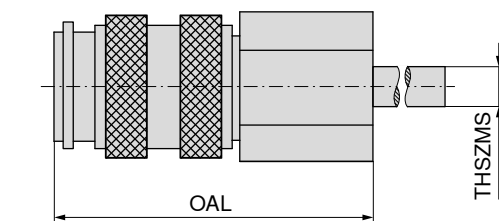
▲ Maximum 200 bar/2900 psi



Designation	DCONWS mm	THSZMS	OAL mm	AS 72 307 ... 009 003
KA. M5-4	4	M5	27	
KA. G1/8-4	4	G1/8"	32	

Quick connection (coupling)

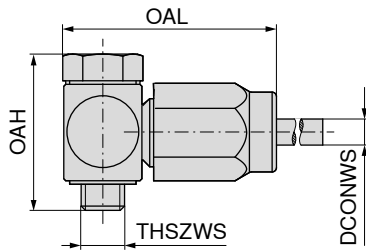
▲ Maximum 200 bar/2900 psi



Designation	THSZMS	OAL mm	AS 72 319 ... 001
KIG.M5	M5	26	

Swivel fitting

▲ Maximum 200 bar/2900 psi

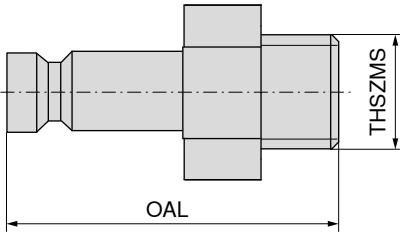


Designation	DCONWS mm	OAH mm	THSZMS	OAL mm
KA.SV.M5-4	4	21	M5	28
KA.SV.G1/8-4	4	30	G1/8"	37

AS
72 307 ...
017
012

Quick connection (plug-in)

- ▲ Maximum 200 bar/2900 psi
- ▲ No sealing ring required



Designation	THSZMS	OAL mm
SAG.M5	M5	20

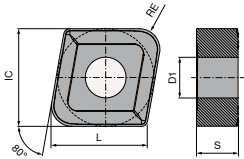
AS
72 320 ...
001



Wheel set machining

CNMX

Designation	L	S	D1	IC
	mm	mm	mm	mm
CNMX 1907..	19.3	7.94	7.94	19.05



MaxiTurn – Carbide turning indexable insert

CNMX

CTCK120-P

CTCP115-P

CTC10RW1

DRAGONSKIN

R

CNMX

R

CNMX

R

CNMX

IA

74 108 ...

56101 ¹⁾

IA

74 108 ...

26100

IA

74 108 ...

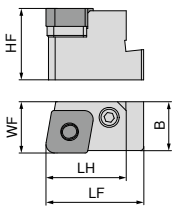
36100

ISO	RE mm
190740SN	4

P			○	●	●
M					
K			●	○	○
N					
S					
H					
O					

1) Not in stock

MaxiTurn – Wheel set cartridge CNMX 19..



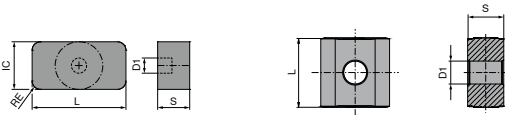
Designation	B mm	LH mm	LF mm	WF mm	HF mm	Indexable insert	Left	Right
							TO 74 612 ...	TO 74 612 ...
RK 3223-C19 R/L	21.9	36	42.7	23	31	CNMX 19..	02301	02300
RK 3219-C19 R/L	17.9	36	42.7	19	31	CNMX 19..	01901	01900

Spare parts
for article number

		Key I	Shim	Assembly pin	Toggle lever	Clamping screw	Carbide seat C
		AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
74 612 02300 / 74 612 02301	SW4	396	392	395	386	389	89900
74 612 01900 / 74 612 01901	SW4	396	392	395	386	389	89900

LNUX / LNMR

Designation	L	S	D1	IC
	mm	mm	mm	mm
LNUX 1919..	19.05	10.0	6.35	19.05
LNUX 3019..	30.00	12.0	6.35	19.05
LNMR 3112..	31.80	12.7	7.90	19.05



LNMR

LNUX

MaxiTurn – Carbide turning indexable insert

LNUX

-R70

CTCP115-P

R

LNUX

IA

74 081 ...

20200

-R70

CTCP125-P

R

LNUX

IA

74 081 ...

60200

-R70

CTC10RW1

R

LNUX

IA

74 078 ...

30200

30400

ISO	RE
	mm
191940SN	4
301940SN	4
P	
M	
K	
N	
S	
H	
O	

MaxiTurn – Carbide turning indexable insert

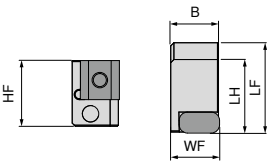
LNUX / LNMR

ISO	RE mm
191940SN	4.0
301940SN	4.0
311248SN	4.8

-R74 CTCP115-P	-R74 CTCP125-P	-R74 CTC10RW1	-R75 CTC10RW1
R LNUX	R LNUX	R LNUX	R LNMR
IA	IA	IA	IA
74 082 ... 20200	74 082 ... 60200	74 079 ... 30200	74 080 ...
20400		30400	30600

P	•	•	•	•
M				
K	○	○	○	○
N				
S				
H				
O				

MaxiTurn – Wheel set cartridge LNUX



Designation	B mm	LH mm	LF mm	WF mm	HF mm	Indexable insert
RK 3223-L19 R/L Q	22.5	35	43	23	32	LNUX 19..

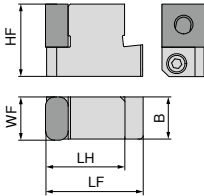
Left	Right
TO	TO
74 613 ... 42301	74 613 ... 42300

Spare parts
for article number

74 613 42300 / 74 613 42301

 Key I	 Toggle lever	 Clamping screw
AS	AS	AS
70 950 ...	70 950 ...	70 950 ...
SW3 176	89800	28500

MaxiTurn – Wheel set cartridge LNUX 19..



Designation	B mm	LH mm	LF mm	WF mm	HF mm	Indexable insert
RK 3219-L19 R/L	18.6	35	43	19	32	LNUX 19..

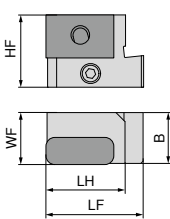
Left	Right
TO	TO
74 613 ... 01901	74 613 ... 01900

Spare parts
for article number

74 613 01900 / 74 613 01901

 Key I	 Toggle lever	 Clamping screw
AS	AS	AS
70 950 ...	70 950 ...	70 950 ...
SW3 176	89800	28500

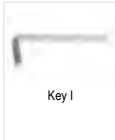
MaxiTurn – Wheel set cartridge LNUX



Designation	B mm	LH mm	LF mm	WF mm	HF mm	Indexable insert	Left	Right
							TO 74 613 ... 02301 22301	TO 74 613 ... 02300 22300
RK 3223-L19 R/L	22.5	35	43	23	32	LNUX 19..		
RK 3223-L30 R/L	22.5	35	43	23	32	LNUX 30..		

Spare parts
for article number

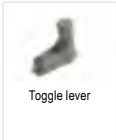
74 613 02300 / 74 613 02301	SW3	176	89800	28500
74 613 22300 / 74 613 22301	SW3	176	89800	28500



Key I

AS

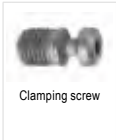
70 950 ...



Toggle lever

AS

70 950 ...



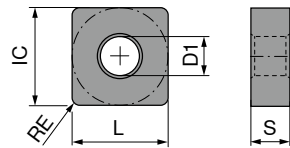
Clamping screw

AS

70 950 ...

SNMG / SNMM

Designation	L	S	D1	IC
	mm	mm	mm	mm
SNMG 1910..	19.0	10.0	7.94	19.05
SNMG 2110..	21.0	10.5	7.94	21.00
SNMM 2507..	25.4	7.94	9.12	25.40



MaxiTurn – Carbide turning indexable insert

SNMG

ISO	RE mm
191040SN	4

-M23

CTCP125-P

M

SNMG

IA

74 083 ...

60200

-M23

CTC10RW1

M

SNMG

IA

74 112 ...

34000

P		●	●
M			
K		○	○
N			
S			
H			
O			

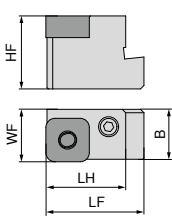
SNMG

ISO	RE mm					
191040SN	4					
211040SN	4					
P						
M						
K						
N						
S						
H						
O						

SNMM

ISO	RE mm		-R88 CTC10RW1
250724SN	2.4		<div data-bbox="1391 1281 1498 1321"> <div data-bbox="1391 1281 1431 1296">○</div> <div data-bbox="1431 1281 1469 1296">○</div> <div data-bbox="1469 1281 1498 1296">⊞</div> </div> <div data-bbox="1391 1321 1498 1431">  </div>
			R SNMM
			TR
			74 116 ... 34800
P		●	
M			
K		○	
N			
S			
H			
O			

MaxiTurn – Wheel set cartridge SNMG



Designation	B mm	LH mm	LF mm	WF mm	HF mm	Indexable insert
RK 3219-S19 R/L	18.55	35	43	19	32	SNMG 19..
RK 3223-S19 R/L	21.90	35	43	23	32	SNMG 19..
RK 3226-S21 R/L	24.80	35	43	26	32	SNMG 21..

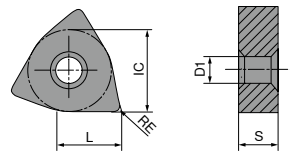
Left	Right
TO	TO
74 614 ...	74 614 ...
01901	01900
02301	02300
02601	02600

Spare parts
for article number

	Key I	Shim	Assembly pin	Toggle lever	Clamping screw	Carbide seat S
	AS	AS	AS	AS	AS	AS
	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
74 614 01900 / 74 614 01901	SW4				389	
74 614 02300 / 74 614 02301	SW4		395	386	389	
74 614 02600 / 74 614 02601	SW4	392	395	386	389	90000

WNMG

Designation	L	S	IC
	mm	mm	mm
WNMG 1210..	12	10.0	19.05
WNMG 1217..	12	17.0	19.05

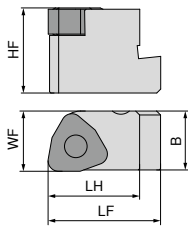


MaxiTurn – Carbide turning indexable insert

WNMG

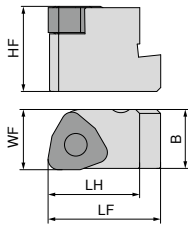
		-M23 CTCP125-P	-M23 CTC10RW1	-M23 CTC15RW1	-R33 CTCP115-P
		M WNMG	M WNMG	M WNMG	R WNMG
		IA 74 109 ... 64000	IA 74 109 ... 84000	IA 74 109 ... 54000 54100	IA 74 110 ... 24000 24100
ISO	RE mm				
121040SN	4				
121740SN	4				
P		●	●	●	●
M					
K		○	○		○
N					
S					
H					
O					

MaxiTurn – Wheel set cartridge WNMG



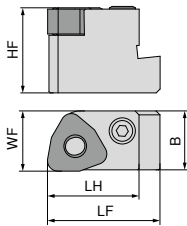
Designation	B mm	LH mm	LF mm	WF mm	HF mm	Indexable insert	Left TO	Right TO
RK 3223D-W12L	22.5	35	42	23	32	WNMG 12..	74 615 ... 02301	74 615 ... 02300
RK 3223D-W12R	22.5	35	42	23	32	WNMG 12..		

MaxiTurn – Wheel set cartridge WNMG



Designation	B mm	LH mm	LF mm	WF mm	HF mm	Indexable insert	Left TO	Right TO
RK 3223D-W1217L	22.5	35	42	23	32	WNMG 1217..	74 615 ... 12301	74 615 ... 12300
RK 3223D-W1217R	22.5	35	42	23	32	WNMG 1217..		

MaxiTurn – Wheel set cartridge WNMG



Designation	B mm	LH mm	LF mm	WF mm	HF mm	Indexable insert
RK 3223-W12L	22.5	35	42	23	32	WNMG 12..
RK 3223-W12R	22.5	35	42	23	32	WNMG 12..

Left	Right
TO	TO
74 616 ... 02301	74 616 ... 02300

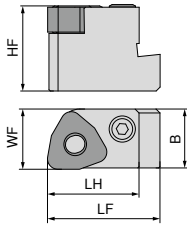
Spare parts
for article number

74 616 02301	SW4	396	386	389
74 616 02300	SW4	396	386	389



AS	AS	AS
70 950 ...	70 950 ...	70 950 ...

MaxiTurn – Wheel set cartridge WNMG



Designation	B mm	LH mm	LF mm	WF mm	HF mm	Indexable insert
RK 3223-W1217L-95°	22.5	35	42	23	32	WNMG 1217..
RK 3223-W1217R-95°	22.5	35	42	23	32	WNMG 1217..

Left	Right
TO	TO
74 616 ... 12301	74 616 ... 12300

Spare parts
for article number

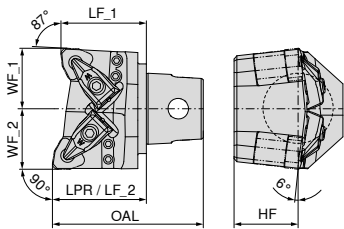
74 616 12301	SW4	396	386	389
74 616 12300	SW4	396	386	389



AS	AS	AS
70 950 ...	70 950 ...	70 950 ...

MaxiTurn – Base holder for wheel set cartridges – Right-hand version

Scope of supply:
Base holder incl. clamping claw without cartridges



Designation	OAL mm	LPR mm	LF_1 mm	LF_2 mm	WF_1 mm	WF_2 mm	HF mm	SZID	Left	Right
									TO	TO
UT63-RKH-L-43066-RK 3223	106	66	60	66	42.5	42.5	45	UTS 63	74 617 ... 16331	74 617 ... 06331
UT63-RKH-R-43066-RK 3223	106	66	60	66	42.5	42.5	45	UTS 63		

**Spare parts
for article number**

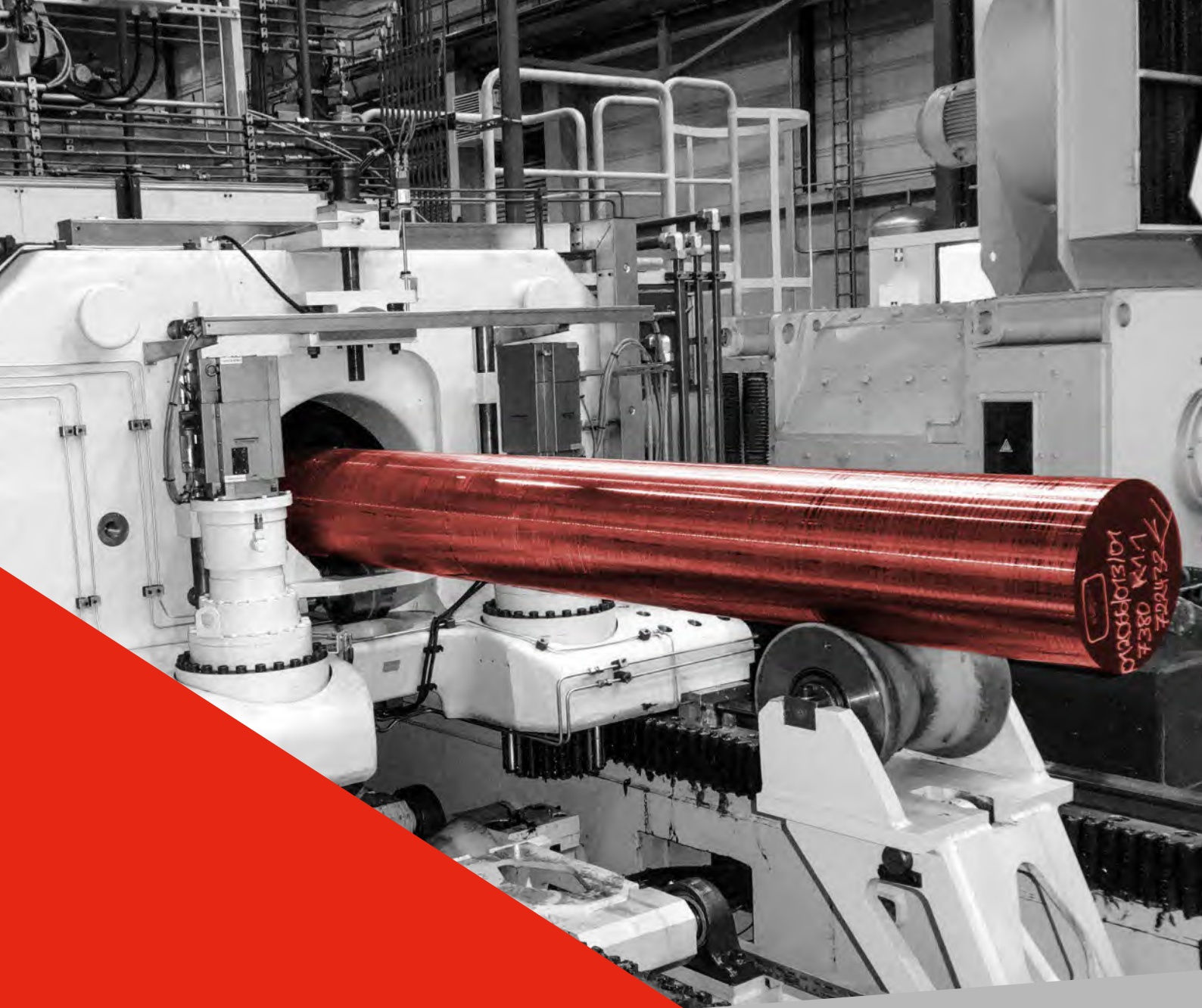
74 617 16331	SW8	80 950 ... 188	93700
74 617 06331	SW8	80 950 ... 188	93700



Hexagonal key



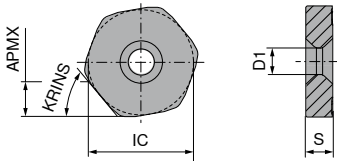
Clamping claw



Bar peeling

MaxiTurn – Carbide bar peeling indexable insert

HNMJ



-R51
CTCP625

DRAGONSKIN

R
HNMJ

-R51
CTCP635

DRAGONSKIN

R
HNMJ

-R57
CTCP625

DRAGONSKIN

R
HNMJ

-R57
CTCP635

DRAGONSKIN

R
HNMJ

Designation	IC mm	APMX mm	S mm	D1 mm	KRINS °	NOI
HNMJ 131050S60-R51	22	4	10.0	7.2	50	12
HNMJ 131050S60-R57	22	4	10.0	7.2	50	12
HNMJ 221550S60-R51	38	8	15.0	9.2	50	12
HNMJ 221550S60-R57	38	8	15.0	9.2	50	12
HNMJ 281850S60-R51	50	12	18.0	12.2	50	12
HNMJ 281850S60-R57	50	12	18.0	12.2	50	12

IA	IA	IA	IA
74 017 ... 48100	74 017 ... 02100	74 019 ... 48100	74 019 ... 08100
	06100		02100
			06100

P	•	•	•	•
M	•	•	•	•
K				
N				
S	•	•	•	•
H				
O				

Spare parts
Indexable insert

HN.. 13..
HN.. 22..
HN.. 28..

Clamping screw
indexable insert

AS

70 950 ...
53000

Clamping screw
indexable insert

AS

70 950 ...
53200
52500

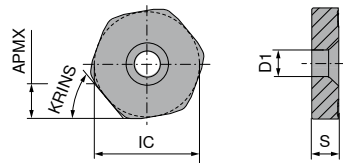
Carbide shim

AS

70 950 ...
54000
54100
54200

MaxiTurn – Carbide bar peeling indexable insert

HNMH



-R51

CTCP635

DRAGONSKIN

R

HNMH

-R57

CTCP635

DRAGONSKIN

R

HNMH

Designation	IC mm	APMX mm	S mm	D1 mm	KRINS °	NOI
HNMH 221550S60-R51	38	8	15.0	9.2	50	6
HNMH 221550S60-R57	38	8	15.0	9.2	50	6
HNMH 281850S60-R51	50	12	18.0	11.6	50	6
HNMH 281850S60-R57	50	12	18.0	12.2	50	6

IA

74 011 ...

02100

06100

IA

74 014 ...

02100

06100

P	•	•
M	•	•
K		
N		
S	•	•
H		
O		

Spare parts

Indexable insert

HN.. 22..	53200	54100
HN.. 28..	52500	54200

Clamping screw
indexable insert

AS

70 950 ...

53200

52500

Carbide shim

AS

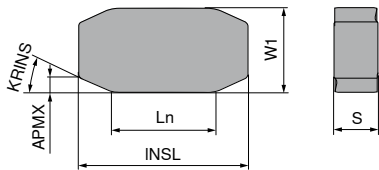
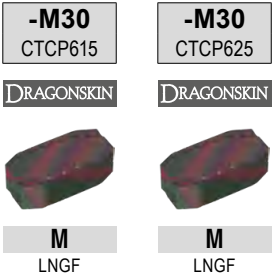
70 950 ...

54100

54200

MaxiTurn – Carbide bar peeling indexable insert

LNGF



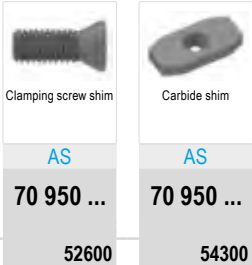
Designation	Ln mm	APMX mm	S mm	KRINS °	INS� mm	W1 mm	NOI
LNGF 231025P53-M30	23	3	10.0	25	40	20	4
LNGF 231025S42-M30	23	3	10.0	25	40	20	4
LNGF 231025S43-M30	23	3	10.0	25	40	20	4
LNGF 231225P53-M30	23	3	12.0	25	40	20	4
LNGF 231225P60-M30	23	3	12.0	25	40	20	4
LNGF 231225S42-M30	23	3	12.0	25	40	20	4
LNGF 231225S43-M30	23	3	12.0	25	40	20	4
LNGF 231225S50-M30	23	3	12.0	25	40	20	4

IA	IA
74 095 ...	74 095 ...
72000	42000
72200	42100
72300	42200
72400	42300
72500	42400
72600	42500
72700	42600

P	•	•
M	•	•
K	○	
N		
S	•	•
H		
O		

Spare parts
Indexable insert

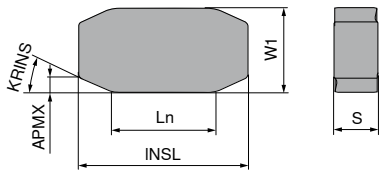
LN.. 23..



AS	AS
70 950 ...	70 950 ...
52600	54300

MaxiTurn – Carbide bar peeling indexable insert

LNGF



-R50
CTCP625

-R50
CTCP635

DRAGONSKIN

DRAGONSKIN



R
LNGF

R
LNGF

Designation	Ln mm	APMX mm	S mm	KRINS °	INSL mm	W1 mm	NOI
LNGF 231025S42-R50	23	3	10.0	25	40	20	4
LNGF 231025S50-R50	23	3	10.0	25	40	20	4

IA
74 020 ...
42300
42400

IA
74 020 ...
02400

P	•	•
M	•	•
K		
N		
S	•	•
H		
O		



Clamping screw shim



Carbide shim

Spare parts
Indexable insert

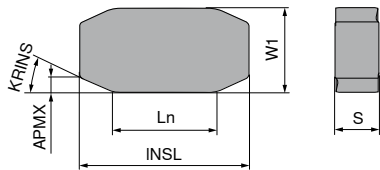
LN.. 23..

AS
70 950 ...
52600

AS
70 950 ...
54300

MaxiTurn – Carbide bar peeling indexable insert

LNGF



-R51

CTCP615

DRAGONSKIN

R

LNGF

-R51

CTCP625

DRAGONSKIN

R

LNGF

Designation	Ln mm	APMX mm	S mm	KRINS °	INSL mm	W1 mm	NOI
LNGF 231025P50-R51	23	3	10.0	25	40	20	4
LNGF 231025S42-R51	23	3	10.0	25	40	20	4
LNGF 231025S50-R51	23	3	10.0	25	40	20	4
LNGF 231225P50-R51	23	3	12.0	25	40	20	4

IA	IA
74 021 ...	74 021 ...
	42200
	42300
72400	42400
	42600

P	●	●
M	●	●
K	○	
N		
S	●	●
H		
O		

Spare parts
Indexable insert

LN.. 23..

Clamping screw shim

AS

70 950 ...

52600

Carbide shim

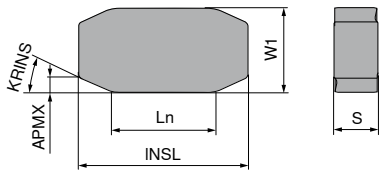
AS

70 950 ...

54300

MaxiTurn – Carbide bar peeling indexable insert

LNGF



-R59
CTCP625

DRAGONSKIN



R
LNGF

Designation	Ln mm	APMX mm	S mm	KRINS °	INSL mm	W1 mm	NOI
LNGF 231225P43-R59	23	3	12.0	25	40	20	4
LNGF 231225P53-R59	23	3	12.0	25	40	20	4
LNGF 231225S43-R59	23	3	12.0	25	40	20	4
LNGF 231225S53-R59	23	3	12.0	25	40	20	4
LNGF 231225S55-R59	23	3	12.0	25	40	20	4

IA

74 022 ...

42400

42600

42300

42500

42100

P	●
M	●
K	
N	
S	●
H	
O	

Spare parts
Indexable insert

LN.. 23..



Clamping screw shim

AS

70 950 ...

52600



Carbide shim

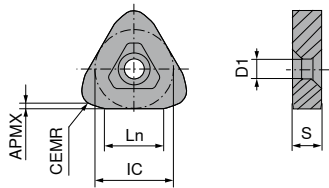
AS

70 950 ...

54300

MaxiTurn – Carbide bar peeling indexable insert

NNUX



-M40
CTCP625

-M40
CTCP635

DRAGONSKIN

DRAGONSKIN



M
NNUX

M
NNUX

Designation	Ln mm	APMX mm	S mm	CEMR mm	IC mm	D1 mm	NOI
NNUX 120800S50-M40	12	1.5	8.0	8	22	7	6

IA
74 066 ...
40100

IA
74 066 ...
00100

P	•	•
M	•	•
K		
N		
S	•	•
H		
O		

Spare parts
Indexable insert

NN.. 12..



Clamping screw
indexable insert



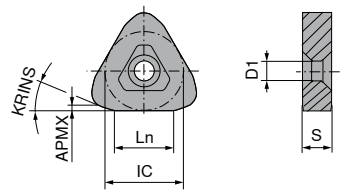
Carbide shim

AS
70 950 ...
53000

AS
70 950 ...
54500

MaxiTurn – Carbide bar peeling indexable insert

NNUX



-M43
CTCP625

DRAGONSKIN



M
NNUX

Designation	Ln mm	APMX mm	S mm	KRINS °	IC mm	D1 mm	NOI
NNUX 150820P60-M43	15	2	8.0	20	22	7	6
NNUX 150820S42-M43	15	2	8.0	20	22	7	6

IA

74 064 ...

42200

72300

P	●
M	●
K	
N	
S	●
H	
O	

Spare parts
Indexable insert

NN.. 15..


Clamping screw
indexable insert

AS

70 950 ...

53000


Carbide shim

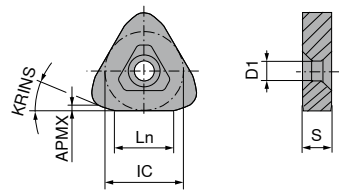
AS

70 950 ...

54600

MaxiTurn – Carbide bar peeling indexable insert

NNUX



-M46 CTCP615	-M46 CTCP625	-M46 CTCP635
DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
M NNUX	M NNUX	M NNUX
IA	IA	IA
74 006 ...	74 006 ...	74 006 ...
	42200	02200
72300	42300	
72400	42400	02400
●	●	●
●	●	●
○		
●	●	●

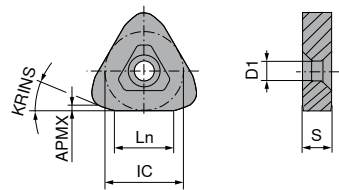
Spare parts
Indexable insert

NN.. 15..

AS	AS
70 950 ...	70 950 ...
53000	54600

MaxiTurn – Carbide bar peeling indexable insert

NNUX



<div>-M40</div> <div>CTCP615</div>	<div>-M40</div> <div>CTCP625</div>	<div>-M40</div> <div>CTCP635</div>
<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>
<div>M</div> <div>NNUX</div>	<div>M</div> <div>NNUX</div>	<div>M</div> <div>NNUX</div>
<div>IA</div> <div>74 066 ...</div> <div>74100</div> <div>74200</div>	<div>IA</div> <div>74 066 ...</div> <div>44100</div> <div>44200</div>	<div>IA</div> <div>74 066 ...</div> <div></div> <div>04200</div>

Designation	Ln mm	APMX mm	S mm	KRINS °	IC mm	D1 mm	NOI
NNUX 201020S42-M40	20	2.5	10.0	20	28	7	6
NNUX 201020S50-M40	20	2.5	10.0	20	28	7	6

P	•	•	•
M	•	•	•
K	○		
N			
S	•	•	•
H			
O			

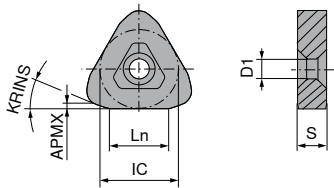
Spare parts
Indexable insert

NN.. 20..

<div>AS</div> <div>70 950 ...</div> <div>53000</div>	<div>AS</div> <div>70 950 ...</div> <div>54700</div>

MaxiTurn – Carbide bar peeling indexable insert

NNUX



-M43

CTCP605

DRAGONSKIN

M

NNUX

-M43

CTCP615

DRAGONSKIN

M

NNUX

-M43

CTCP625

DRAGONSKIN

M

NNUX

-M43

CTCP635

DRAGONSKIN

M

NNUX

Designation	Ln mm	APMX mm	S mm	KRINS °	IC mm	D1 mm	NOI
NNUX 201020P30-M43	20	2.5	10.0	20	28	7	6
NNUX 201020P50-M43	20	2.5	10.0	20	28	7	6
NNUX 201020P60-M43	20	2.5	10.0	20	28	7	6
NNUX 201020S42-M43	20	2.5	10.0	20	28	7	6
NNUX 201020S50-M43	20	2.5	10.0	20	28	7	6

IA

74 064 ...

44101

74200

44301

74300

44401

74400

74500

IA

74 064 ...

44200

74300

74400

44500

IA

74 064 ...

44200

44300

44400

44500

IA

74 064 ...

04500

P		•	•	•	•
M			•	•	•
K		○	○		
N		○			
S			•	•	•
H					
O					

Spare parts
Indexable insert

NN.. 20..

Clamping screw
indexable insert

AS

70 950 ...

53000

Carbide shim

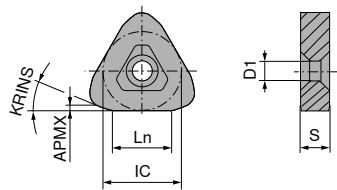
AS

70 950 ...

54700

MaxiTurn – Carbide bar peeling indexable insert

NNUX



-M41
CTCP615

DRAGONSKIN



M
NNUX

Designation	Ln mm	APMX mm	S mm	KRINS °	IC mm	D1 mm	NOI
NNUX 201020S50-M41	20	2.5	10.0	20	28	7	6

IA
74 067 ...
74100

P	●
M	●
K	○
N	
S	●
H	
O	

Spare parts
Indexable insert

NN.. 20..



Clamping screw
indexable insert

AS

70 950 ...

53000



Carbide shim

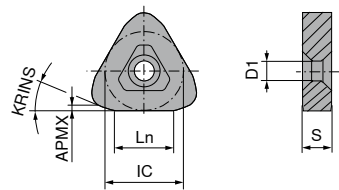
AS

70 950 ...

54700

MaxiTurn – Carbide bar peeling indexable insert

NNUX



-M45
CTCP635

DRAGONSKIN



M
NNUX

Designation	Ln mm	APMX mm	S mm	KRINS °	IC mm	D1 mm	NOI
NNUX 201020P53-M45	20	2.5	10.0	20	28	7	6

IA
74 005 ...
04100

P	•
M	•
K	
N	
S	•
H	
O	

Spare parts
Indexable insert

NN.. 20..



Clamping screw
indexable insert

AS

70 950 ...

53000



Carbide shim

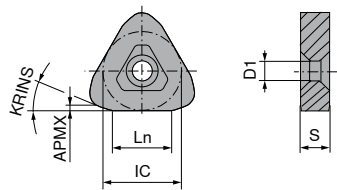
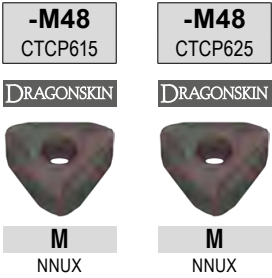
AS

70 950 ...

54700

MaxiTurn – Carbide bar peeling indexable insert

NNUX



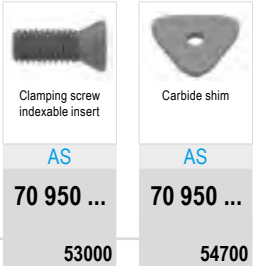
Designation	Ln mm	APMX mm	S mm	KRINS °	IC mm	D1 mm	NOI
NNUX 201020P30-M48	20	2.5	10.0	20	28	7	6
NNUX 201020S42-M48	20	2.5	10.0	20	28	7	6
NNUX 201020S50-M48	20	2.5	10.0	20	28	7	6
NNUX 201020S60-M48	20	2.5	10.0	20	28	7	6

IA	IA
74 069 ...	74 069 ...
74000	44200
74300	44400

P	●	●
M	●	●
K	○	
N		
S	●	●
H		
O		

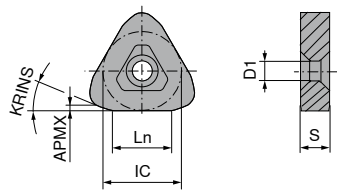
Spare parts
Indexable insert

NN.. 20..



MaxiTurn – Carbide bar peeling indexable insert

NNUX



-M43
CTCP625

DRAGONSKIN



M
NNUX

Designation	Ln mm	APMX mm	S mm	KRINS °	IC mm	D1 mm	NOI
NNUX 271220P60-M43	27	2.5	12.0	20	32	9	6
NNUX 271220S50-M43	27	2.5	12.0	20	32	9	6

IA

74 064 ...

46100

46200

P	●
M	●
K	
N	
S	●
H	
O	

Spare parts
Indexable insert

NN.. 27..


Clamping screw
indexable insert

AS

70 950 ...

52200


Carbide shim

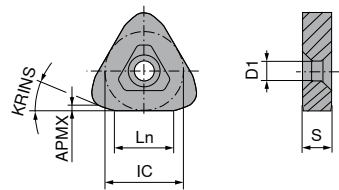
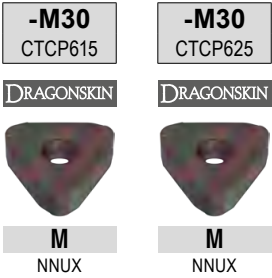
AS

70 950 ...

54800

MaxiTurn – Carbide bar peeling indexable insert

NNUX



Designation	Ln mm	APMX mm	S mm	KRINS °	IC mm	D1 mm	NOI
NNUX 150820P60-M30	15	2.0	8.0	20	22	7	6
NNUX 150820S42-M30	15	2.0	8.0	20	22	7	6
NNUX 150820S50-M30	15	2.0	8.0	20	22	7	6
NNUX 201020P60-M30	20	2.5	10.0	20	28	7	6
NNUX 201020S42-M30	20	2.5	10.0	20	28	7	6
NNUX 201020S50-M30	20	2.5	10.0	20	28	7	6

IA	IA
74 096 ...	74 096 ...
72000	42000
72100	42100
72200	42200
74000	44000
74100	44100
74200	44200

P	●	●
M	●	●
K	○	
N		
S	●	●
H		
O		

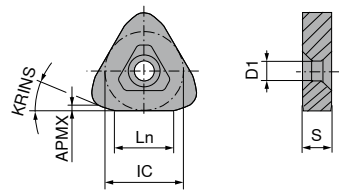
Spare parts
Indexable insert

NN.. 15..	53000	54600
NN.. 20..	53000	54700

 Clamping screw indexable insert	 Carbide shim
AS	AS
70 950 ...	70 950 ...
53000	54600
53000	54700

MaxiTurn – Carbide bar peeling indexable insert

NNXX



-M40
CTCP615

DRAGONSKIN



M
NNXX

Designation	Ln mm	APMX mm	S mm	KRINS °	IC mm	D1 mm	NOI
NNXX 201020S50-M40	20	2.5	10.0	20	28	7	6

IA
74 024 ...
72100

P	●
M	●
K	○
N	
S	●
H	
O	

Spare parts
Indexable insert

NN.. 20..



Clamping screw
indexable insert

AS

70 950 ...

53000



Carbide shim

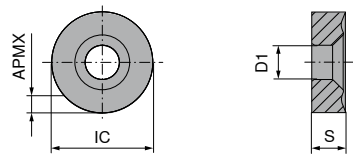
AS

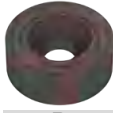
70 950 ...

54700

MaxiTurn – Carbide bar peeling indexable insert

RNMH



<div>-R50</div> <div>CTCP635</div>	<div>-R56</div> <div>CTCP625</div>	<div>-R56</div> <div>CTCP635</div>
<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>
<div></div> <div>R</div> <div>RNMH</div>	<div></div> <div>R</div> <div>RNMH</div>	<div></div> <div>R</div> <div>RNMH</div>
<div>IA</div> <div>74 030 ...</div> <div>02200</div>	<div>IA</div> <div>74 032 ...</div> <div>40000</div>	<div>IA</div> <div>74 032 ...</div> <div>00000</div> <div>00100</div> <div>02100</div>

Designation	APMX mm	S mm	IC mm	D1 mm	NOI
RNMH 200800E00-R56	3	8.0	20	7	5
RNMH 200800P15-R56	3	8.0	20	7	5
RNMH 281000E00-R50	5	10.5	28	9	5
RNMH 281000P15-R56	5	10.5	28	9	5

P			
M			
K			
N			
S			
H			
O			

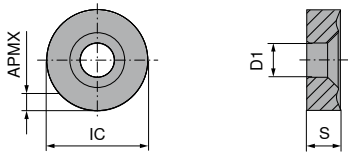
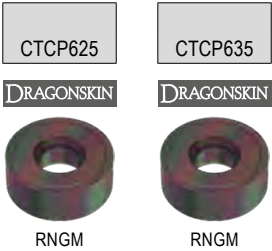
Spare parts
Indexable insert

RN.. 20..	53000	52200	54900
RN.. 28..			55000

<div></div> <div>Clamping screw indexable insert</div>	<div></div> <div>Clamping screw indexable insert</div>	<div></div> <div>Carbide shim</div>
<div>AS</div> <div>70 950 ...</div> <div>53000</div>	<div>AS</div> <div>70 950 ...</div> <div>52200</div>	<div>AS</div> <div>70 950 ...</div> <div>54900</div> <div>55000</div>

MaxiTurn – Carbide bar peeling indexable insert

RNGM



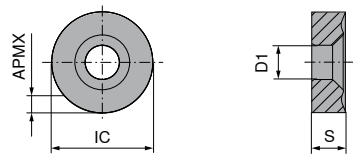
Designation	APMX mm	S mm	IC mm	D1 mm	NOI
RNMG 250900EN	4	9.5	25	9	5

IA	IA
74 097 ... 46000	74 097 ... 06000

P	•	•
M	•	•
K		
N		
S	•	•
H		
O		

MaxiTurn – Carbide bar peeling indexable insert

RNGH



-R50 CTCP635	-R55 CTCP635	-R56 CTCP625	-R56 CTCP635
DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
			
R RNGH	R RNGH	R RNGH	R RNGH

Designation	APMX mm	S mm	IC mm	D1 mm	NOI
RNGH 381200E00-R56	7	12.0	38	12.7	5
RNGH 381200P15-R50	7	12.0	38	12.7	5
RNGH 381200P15-R55	7	12.0	38	12.7	5
RNGH 381200P15-R56	7	12.0	38	12.7	5

IA 74 027 ... 06100	IA 74 070 ... 06100	IA 74 028 ... 46100	IA 74 028 ... 06000 06100
---------------------------	---------------------------	---------------------------	------------------------------------

P				
M				
K				
N				
S				
H				
O				

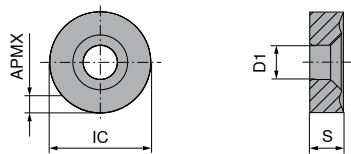
Spare parts
Indexable insert

RN.. 38..

	
Clamping screw indexable insert	Carbide shim
AS 70 950 ... 52500	AS 70 950 ... 55100

MaxiTurn – Carbide bar peeling indexable insert

RNGX



-R56
CTCP635

DRAGONSKIN



R
RNGX

Designation	APMX mm	S mm	IC mm	D1 mm	NOI
RNGX 381200E00-R56	7	12.0	38	8.8	5

IA
74 029 ...
06100

P	●
M	●
K	
N	
S	●
H	
O	

Spare parts
Indexable insert

RN.. 38..



Clamping screw
indexable insert

AS

70 950 ...

52200



Carbide shim

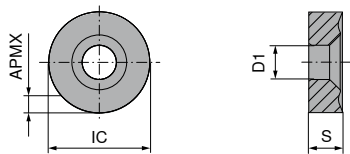
AS

70 950 ...

55100

MaxiTurn – Carbide bar peeling indexable insert

RNMH / RNMX



-R55
CTCP635

-R56
CTCP630

-R56
CTCP635

-R50
CTCP635

DRAGONSKIN

DRAGONSKIN

DRAGONSKIN

DRAGONSKIN



R
RNMH

R
RNMH

R
RNMH

R
RNMX

Designation	APMX mm	S mm	IC mm	D1 mm	NOI
RNMH 5018MOE00-R55	9	18.0	50	12.7	5
RNMH 5018MOP15-R56	9	18.0	50	12.7	5
RNMX 5018MOE00-R50	9	18.0	50	12.7	5

IA

74 031 ...
06100

IA

74 032 ...
06301

IA

74 032 ...
06300

IA

74 033 ...
06100

P				
M				
K				
N				
S				
H				
O				

Spare parts
Indexable insert

RN.. 50..



Clamping screw
indexable insert



Carbide shim

AS

70 950 ...

52500

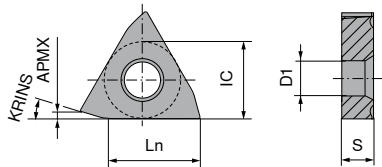
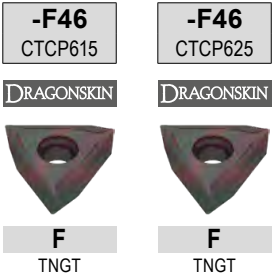
AS

70 950 ...

55200

MaxiTurn – Carbide bar peeling indexable insert

TNGT



Designation	APMX mm	S mm	IC mm	D1 mm	NOI
TNGT 220815S42-F46	1	8.0	19	8	3
TNGT 220815S50-F46	1	8.0	19	8	3

IA	IA
74 034 ...	74 034 ...
72100	
72200	42200

P	●	●
M	●	●
K	○	
N		
S	●	●
H		
O		

Spare parts
Indexable insert

TN.. 22..



Clamping screw

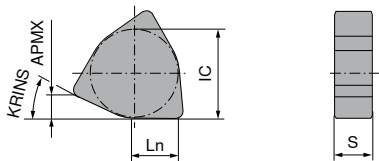
AS

70 950 ...

822

MaxiTurn – Carbide bar peeling indexable insert

WNEF



-R50

CTCP625

DRAGONSKIN

R

WNEF

-R50

CTCP635

DRAGONSKIN

R

WNEF

-R55

CTCP625

DRAGONSKIN

R

WNEF

-R55

CTCP635

DRAGONSKIN

R

WNEF

Designation	Ln mm	APMX mm	S mm	KRINS °	IC mm	NOI	IA	IA	IA	IA
WNEF 161325P50-R50	16	7	13.0	25	32	6	74 035 ...	74 035 ...	74 036 ...	74 036 ...
WNEF 161325P60-R50	16	7	13.0	25	32	6	40400	00400		
WNEF 161325S50-R50	16	7	13.0	25	32	6	40100	00100		
WNEF 161325S50-R55	16	7	13.0	25	32	6	40200		40100	00100
P							•	•	•	•
M							•	•	•	•
K										
N										
S							•	•	•	•
H										
O										

Spare parts
Indexable insert

WN.. 16..

Clamping screw shim

AS

70 950 ...

52600

Carbide shim

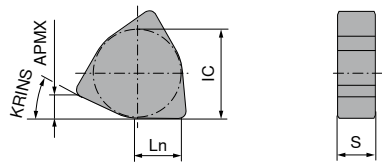
AS

70 950 ...

55600

MaxiTurn – Carbide bar peeling indexable insert

WNEF



-R59
CTCP625

DRAGONSKIN



R
WNEF

Designation	Ln mm	APMX mm	S mm	KRINS °	IC mm	NOI
WNEF 161325P55-R59	16	7	13.0	25	32	6

IA
74 072 ...
40300

P	•
M	•
K	
N	
S	•
H	
O	



Clamping screw shim

AS

70 950 ...

52600



Carbide shim

AS

70 950 ...

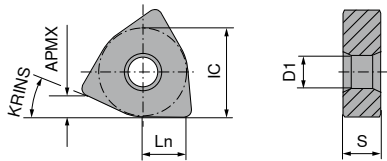
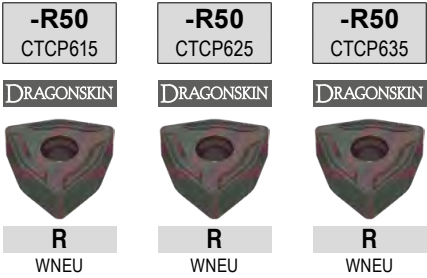
55600

Spare parts
Indexable insert

WN.. 16..

MaxiTurn – Carbide bar peeling indexable insert

WNEU



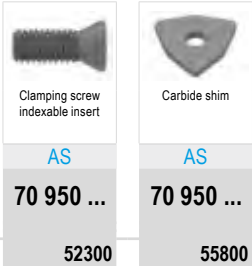
Designation	L _n mm	APMX mm	S mm	KRINS °	IC mm	D1 mm	NOI
WNEU 161325S42-R50	16	7	13.0	25	32	9	6
WNEU 161325S50-R50	16	7	13.0	25	32	9	6
WNEU 161425S42-R50	16	7	14.0	25	32	9	6
WNEU 161425S50-R50	16	7	14.0	25	32	9	6

IA	IA	IA
74 037 ...	74 037 ...	74 037 ...
70100		
70200	40200	00200
70500		
70600	40600	

P	•	•	•
M	•	•	•
K	○		
N			
S	•	•	•
H			
O			

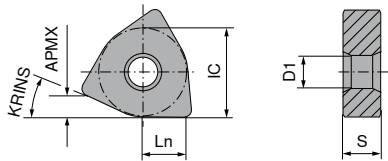
Spare parts
Indexable insert

WN.. 16..



MaxiTurn – Carbide bar peeling indexable insert

WNEU



-R51
H216T

DRAGONSKIN



R
WNEU

Designation	L _n mm	APMX mm	S mm	KRINS °	IC mm	D1 mm	NOI
WNEU 161325P50-R51	16	7	13.0	25	32	9	6

IA
74 038 ...
10102

P	
M	
K	●
N	○
S	●
H	
O	

Spare parts
Indexable insert

WN.. 16..



Clamping screw
indexable insert

AS

70 950 ...

52300



Carbide shim

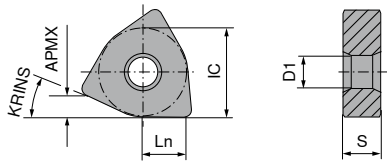
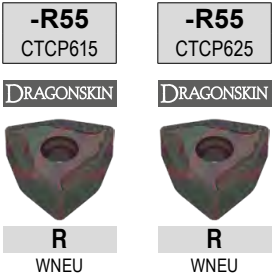
AS

70 950 ...

55800

MaxiTurn – Carbide bar peeling indexable insert

WNEU



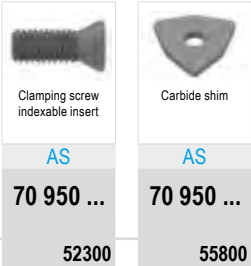
Designation	L _n mm	APMX mm	S mm	KRINS °	IC mm	D1 mm	NOI
WNEU 161325S42-R55	16	7	13.0	25	32	9	6
WNEU 161325S50-R55	16	7	13.0	25	32	9	6
WNEU 161425S42-R55	16	7	14.0	25	32	9	6
WNEU 161425S50-R55	16	7	14.0	25	32	9	6

IA	IA
74 039 ...	74 039 ...
70100	40100
70200	40200
	40300
	40400

P	•	•
M	•	•
K	○	
N		
S	•	•
H		
O		

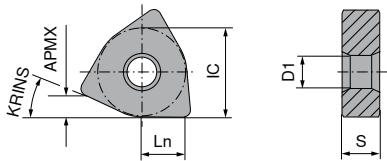
Spare parts
Indexable insert

WN.. 16..



MaxiTurn – Carbide bar peeling indexable insert

WNEU



-R59
CTCP625

DRAGONSKIN



R
WNEU

Designation	L _n mm	APMX mm	S mm	KRINS °	IC mm	D1 mm	NOI
WNEU 161325S45-R59	16	7	13.0	25	32	9	6

IA
74 040 ...
40300

P	•
M	•
K	
N	
S	•
H	
O	

Spare parts
Indexable insert

WN.. 16..



Clamping screw
indexable insert

AS

70 950 ...

52300



Carbide shim

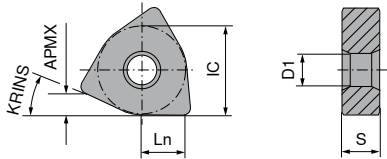
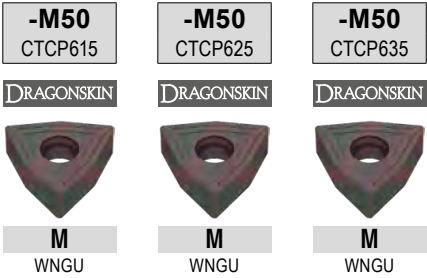
AS

70 950 ...

55800

MaxiTurn – Carbide bar peeling indexable insert

WNGU



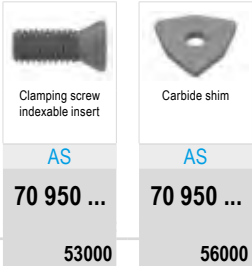
Designation	L _n mm	APMX mm	S mm	KRINS °	IC mm	D1 mm	NOI
WNGU 151015E00-M50	15	3	10.0	15	22	8	6
WNGU 151015P60-M50	15	3	10.0	15	22	8	6
WNGU 151015S42-M50	15	3	10.0	15	22	8	6
WNGU 151015S50-M50	15	3	10.0	15	22	8	6

IA	IA	IA
74 042 ...	74 042 ...	74 042 ...
	42500	02500
	42100	02100
72200	42200	
72300	42300	02300

P	•	•	•
M	•	•	•
K	○		
N			
S	•	•	•
H			
O			

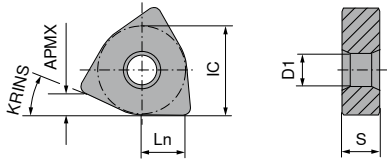
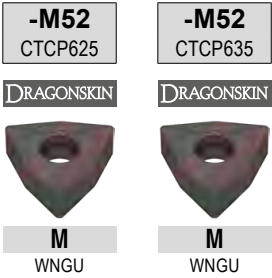
Spare parts
Indexable insert

WN.. 15..



MaxiTurn – Carbide bar peeling indexable insert

WNGU



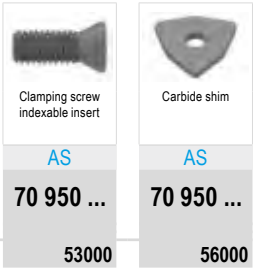
Designation	L _n mm	APMX mm	S mm	KRINS °	IC mm	D1 mm	NOI
WNGU 151015P60-M52	15	3	10.0	15	22	8	6
WNGU 151015S50-M52	15	3	10.0	15	22	8	6

IA	IA
74 043 ...	74 043 ...
42100	02200

P	•	•
M	•	•
K		
N		
S	•	•
H		
O		

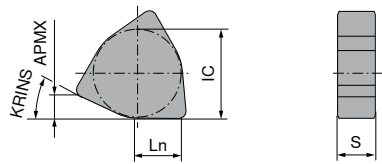
Spare parts
Indexable insert

WN.. 15..



MaxiTurn – Carbide bar peeling indexable insert

WNMF



-R51

CTCP615

DRAGONSKIN

R

WNMF

IA

74 047 ...

76000

-R51

CTCP625

DRAGONSKIN

R

WNMF

IA

74 047 ...

46400

-R51

CTCP635

DRAGONSKIN

R

WNMF

IA

74 047 ...

06300

Designation	Ln mm	APMX mm	S mm	KRINS °	IC mm	NOI
WNMF 96P73-R51	16	6	9.0	30	28	6
WNMF 96S00-R51	16	6	9.0	30	28	6
WNMF 96S53-R51	16	6	9.0	30	28	6

P	•	•	•
M	•	•	•
K	○		
N			
S	•	•	•
H			
O			

Spare parts
Indexable insert

WN.. 96..

Clamping screw shim

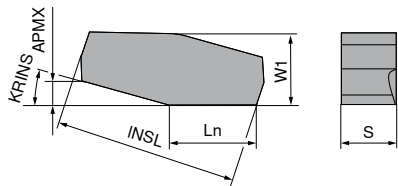
AS

70 950 ...

53100

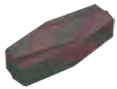
MaxiTurn – Carbide bar peeling indexable insert

YNGX



-M50
CTCP635

DRAGONSKIN



M
YNGX

Designation	Ln mm	APMX mm	S mm	KRINS °	INSL mm	W1 mm	NOI
YNGX 150815S50-M50	15	3	8.0	15	31	12	4

IA
74 058 ...
02100

P	•
M	•
K	
N	
S	•
H	
O	



Clamping screw shim

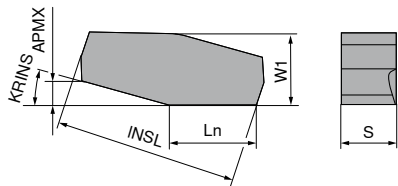
Spare parts
Indexable insert

YNGX 150815

AS
70 950 ...
53100

MaxiTurn – Carbide bar peeling indexable insert

YNGX



-R52
CTCP635

DRAGONSKIN



R
YNGX

Designation	Ln mm	APMX mm	S mm	KRINS °	INSL mm	W1 mm	NOI
YNGX 150820P57-R52	15	3.5	8.0	20	31	12	4

IA
74 060 ...
02100

P	●
M	●
K	
N	
S	●
H	
O	



Clamping screw shim

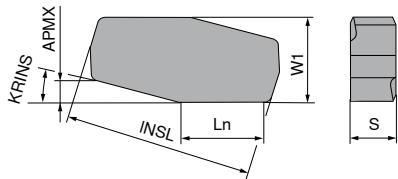
Spare parts
Indexable insert

YNGX 150820

AS
70 950 ...
53100

MaxiTurn – Carbide bar peeling indexable insert

YNUX



-M50
CTCP625

DRAGONSKIN



M
YNUX

Designation	Ln mm	APMX mm	S mm	KRINS °	INSL mm	W1 mm	NOI
YNUX 100615S50-M50	10	2	6.0	15	22	10	4

IA
74 063 ...
40100

P	•
M	•
K	
N	
S	•
H	
O	



Clamping screw shim

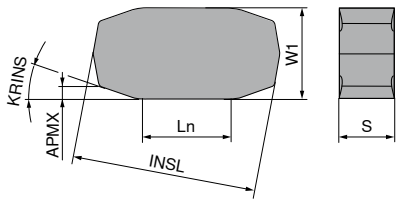
Spare parts
Indexable insert

YNUX 100615

AS
70 950 ...
53100

MaxiTurn – Carbide bar peeling indexable insert

YNUF



-M30
CTCP615

-M30
CTCP625

DRAGONSKIN

DRAGONSKIN



M
YNUF

M
YNUF

Designation	L _n mm	APMX mm	S mm	KRINS °	INSL mm	W1 mm	NOI
YNUF 170820P60-M30	17	1.5	8.0	20	31	12	4
YNUF 170820S42-M30	17	1.5	8.0	20	31	12	4
YNUF 170820S50-M30	17	1.5	8.0	20	31	12	4
YNUF 201220P60-M30	20	2.0	12.0	20	37	18	4
YNUF 201220S42-M30	20	2.0	12.0	20	37	18	4
YNUF 201220S50-M30	20	2.0	12.0	20	37	18	4

IA
74 098 ...
70000
70100
70200
72000
72100
72200

IA
74 098 ...
40000
40100
40200
42000
42100
42200

P	●	●
M	●	●
K	○	
N		
S	●	●
H		
O		

Spare parts
Indexable insert

YNUF 17..	53100	56300
YNUF 20..	52600	56400



Clamping screw shim



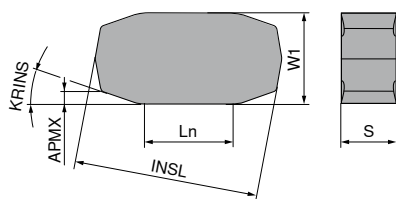
Carbide shim

AS
70 950 ...
53100
52600

AS
70 950 ...
56300
56400

MaxiTurn – Carbide bar peeling indexable insert

YNUF



Designation	L _n mm	APMX mm	S mm	KRINS °	INS _L mm	W1 mm	NOI
YNUF 170820P30-M48	17	1.5	8.0	20	31	12	4
YNUF 170820P60-M48	17	1.5	8.0	20	31	12	4
YNUF 170820S42-M48	17	1.5	8.0	20	31	12	4
YNUF 170820S50-M48	17	1.5	8.0	20	31	12	4
YNUF 170820S60-M48	17	1.5	8.0	20	31	12	4
YNUF 201220P30-M48	20	2.0	12.0	20	37	18	4
YNUF 201220P60-M48	20	2.0	12.0	20	37	18	4
YNUF 201220S42-M48	20	2.0	12.0	20	37	18	4
YNUF 201220S50-M48	20	2.0	12.0	20	37	18	4
YNUF 201220S60-M48	20	2.0	12.0	20	37	18	4

P	•	•	•
M		•	•
K	○	○	
N	○		
S		•	•
H			
O			

-M48 CTCP605	-M48 CTCP615	-M48 CTCP625
DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
M YNUF	M YNUF	M YNUF
IA 74 009 ...	IA 74 009 ...	IA 74 009 ...
40501	70500	
40101	70100	40100
40601	70600	40600
40201	70200	40200
40301	70300	40300
42701	72700	
42801	72800	42800
42901	72900	42900
43001	73000	43000
		43100

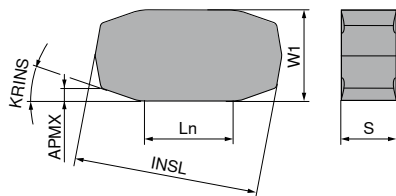
Spare parts Indexable insert

YNUF 17..	53100	56300
YNUF 20..	52600	56400

AS	AS
70 950 ...	70 950 ...
53100	56300
52600	56400

MaxiTurn – Carbide bar peeling indexable insert

YNUF



Designation	L _n mm	APMX mm	S mm	KRINS °	INSL mm	W1 mm	NOI
YNUF 170820P30-M50	17	1.5	8.0	20	31	12	4
YNUF 170820P60-M50	17	1.5	8.0	20	31	12	4
YNUF 170820S42-M50	17	1.5	8.0	20	31	12	4
YNUF 170820S50-M50	17	1.5	8.0	20	31	12	4
YNUF 170820S60-M50	17	1.5	8.0	20	31	12	4
YNUF 201220P30-M50	20	2.0	12.0	20	37	18	4
YNUF 201220P60-M50	20	2.0	12.0	20	37	18	4
YNUF 201220S42-M50	20	2.0	12.0	20	37	18	4
YNUF 201220S50-M50	20	2.0	12.0	20	37	18	4
YNUF 201220S60-M50	20	2.0	12.0	20	37	18	4
YNUF 241020S60-M50	24	1.2	10.0	20	35	15	4
YNUF 271220P60-M50	27	2.0	12.0	20	43	18	4
YNUF 271220S42-M50	27	2.0	12.0	20	43	18	4
YNUF 271220S50-M50	27	2.0	12.0	20	43	18	4
YNUF 271220S60-M50	27	2.0	12.0	20	43	18	4

-M50
CTCP605

DRAGONSKIN

M
YNUF

-M50
CTCP615

DRAGONSKIN

M
YNUF

-M50
CTCP625

DRAGONSKIN

M
YNUF

-M50
CTCP635

DRAGONSKIN

M
YNUF

IA	IA	IA	IA
74 007 ...	74 007 ...	74 007 ...	74 007 ...
40701	70700		
40401	70400	40400	00400
40101	70100	40100	
	70200	40200	00200
40301	70300		
	72600		
	73000	43000	03000
42701	72700	42700	
42801	72800	42800	02800
42901		42900	
44401			
			06500
46201	76200		
46301	76300	46300	06300
46401			

P	•	•	•	•
M	•	•	•	•
K	○	○		
N	○			
S		•	•	•
H				
O				

Spare parts
Indexable insert

YNUF 17..	53100	56300
YNUF 20..	52600	56400
YNUF 24..	52600	56600
YNUF 27..	52600	56700



Clamping screw shim



Carbide shim

AS

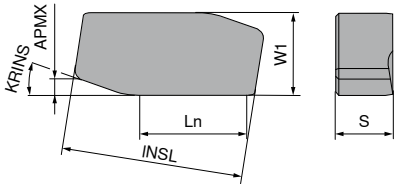
70 950 ...

AS

70 950 ...

MaxiTurn – Carbide bar peeling indexable insert

YNUR



-M40

CTCP615

DRAGONSKIN

M

YNUR

-M40

CTCP625

DRAGONSKIN

M

YNUR

-M40

CTCP635

DRAGONSKIN

M

YNUR

Designation	Ln mm	APMX mm	S mm	KRINS °	INSL mm	W1 mm	NOI
YNUR 271220S50-M40	27	3	12.0	20	38	18	2

IA	IA	IA
74 062 ...	74 062 ...	74 062 ...
74100	44100	04100

P			
M			
K			
N			
S			
H			
O			

Spare parts
Indexable insert

YNUR 27..

Clamping screw shim

AS

70 950 ...

53100

Carbide shim

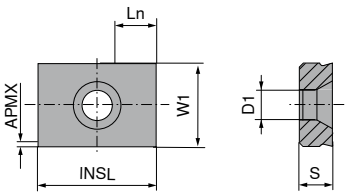
AS

70 950 ...

56800

MaxiTurn – Carbide bar peeling indexable insert

LNGX



-F50
CTPM225

DRAGONSKIN



F
LNGX

Designation	Ln mm	APMX mm	S mm	KRINS °	INSL mm	W1 mm	NOI
LNGX 170400E00-F50	6	0.7	4.76	6	17	12	4

IA
74 068 ...
20203

P	●
M	●
K	
N	
S	●
H	
O	



Clamping screw

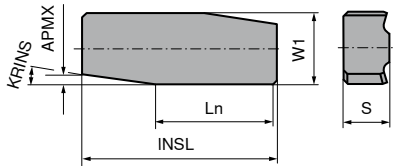
Spare parts
Indexable insert

AS
70 950 ...
839

LN.. 17..

MaxiTurn – Carbide bar peeling indexable insert

YNCR



-F50
CTCP625

DRAGONSKIN



F
YNCR

-F51
CTCP625

DRAGONSKIN



F
YNCR

Designation	Ln mm	APMX mm	S mm	KRINS °	INSL mm	W1 mm	NOI
YNCR 080308P10-F50	8	0.5	3.5	8	14.85	5.5	2
YNCR 080308P10-F51	8	0.5	3.5	8	14.85	5.5	2

IA

74 056 ...
42000

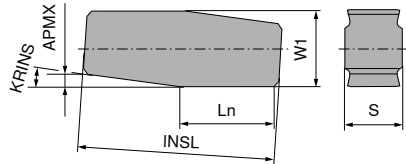
IA

74 074 ...
42000

P	•	•
M	•	•
K		
N		
S	•	•
H		
O		

MaxiTurn – Carbide bar peeling indexable insert

YNCF



-F50
CTCP125-P

DRAGONSKIN



F
YNCF

-F50
CTCP625

DRAGONSKIN



F
YNCF

-F51
CTCP125-P

DRAGONSKIN



F
YNCF

-F51
CTCP625

DRAGONSKIN



F
YNCF

Designation	Ln mm	APMX mm	S mm	KRINS °	INSL mm	W1 mm	NOI
YNCF 090608P90-F50	9	0.8	6.0	8	20.45	8	4
YNCF 090608P90-F51	9	0.8	6.0	8	20.45	8	4

IA

74 053 ...
60101

IA

74 053 ...
40100

IA

74 054 ...
60101

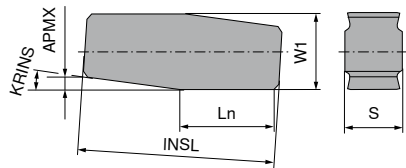
IA

74 054 ...
40100

P	•	•	•	•
M	○	•	○	•
K				
N				
S	•	•	•	•
H				
O				

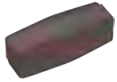
MaxiTurn – Carbide bar peeling indexable insert

YNCF



-F52
CTCP625

DRAGONSKIN



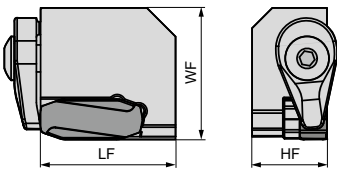
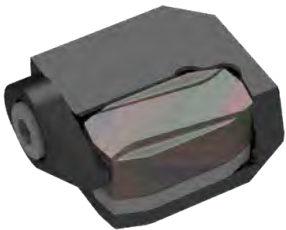
F
YNCF

Designation	Ln mm	APMX mm	S mm	KRINS °	INSL mm	W1 mm	NOI
YNCF 090608P90-F52	9	0.8	6.0	8	20.45	8	4

IA
74 055 ...
40100

P	•
M	•
K	
N	
S	•
H	
O	

MaxiTurn – Single cartridge CA..-YNUF..



Single

Designation	LF mm	HF mm	WF mm	Indexable insert
CA00-YNUF17	40	22	39	YNUF 170820
CA00-YNUF20	42	22	39	YNUF 201220
CA00-YNUF24	42	22	39	YNUF 241020
CA00-YNUF27	49	22	39	YNUF 271220

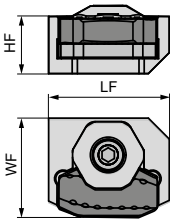
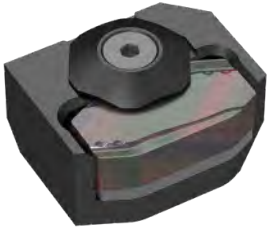
TO
74 610 ...
07100
07500
07700
07900

Spare parts
for article number

74 610 07100
74 610 07500
74 610 07700
74 610 07900

				
AS	AS	AS	AS	AS
80 397 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
025	53600	53100	53300	56300
030	53600	52600	53300	56400
030	53600	52600	53300	56600
030	53600	52600	53300	56700

MaxiTurn – Single cartridge CA..-LNGF..



Single

Designation	LF mm	HF mm	WF mm	Indexable insert
CA00-LNGF2310	49	22	39	LNGF 231025
CA00-LNGF2312	49	22	39	LNGF 231225

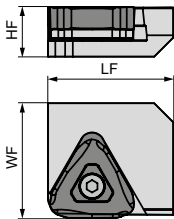
TO
74 610 ...
00200
00400

Spare parts
for article number

74 610 00200
74 610 00400

				
AS	AS	AS	AS	AS
80 397 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
030	52600	52700	53400	54400
030	52600	52700	53400	54300

MaxiTurn – Single cartridge CA..-NNUX..



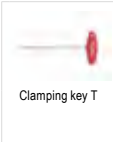
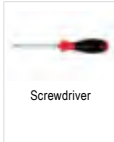
Single

Designation	LF mm	HF mm	WF mm	Indexable insert
CA00-NNUX12	42	22	39	NNUX 120800
CA00-NNUX15	42	22	39	NNUX 150820
CAXX-NNUX20	51	25	46	NNUX 201020

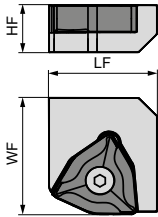
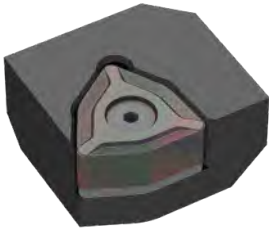
TO
74 610 ...
02200
02400
02600

Spare parts
for article number

74 610 02200
74 610 02400
74 610 02600

 Clamping key T	 Screwdriver	 Clamping screw indexable insert	 Carbide shim
AS	AS	AS	AS
80 397 ...	80 950 ...	70 950 ...	70 950 ...
060	114	53000	54500
060	114	53000	54600
060	114	53000	54700

MaxiTurn – Single cartridge CA..-WNGU..



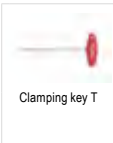
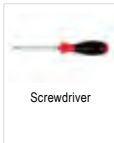
Single

Designation	LF mm	HF mm	WF mm	Indexable insert
CA00-WNGU15	42	22	39	WNGU 151015

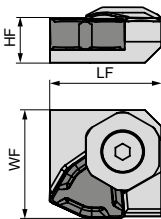
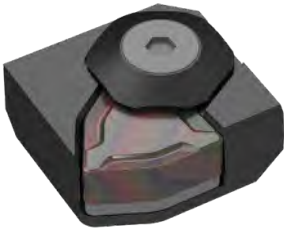
TO
74 610 ...
05400

Spare parts
for article number

74 610 05400

 Clamping key T	 Screwdriver	 Clamping screw indexable insert	 Carbide shim
AS	AS	AS	AS
80 397 ...	80 950 ...	70 950 ...	70 950 ...
060	114	53000	56000

MaxiTurn – Single cartridge CA..-WNEF..



Single

Designation	LF mm	HF mm	WF mm	Indexable insert
CAXX-WNEF1613	58	22	55	WNEF 161325
CA12-WNEF1613	110	40	65	WNEF 161325

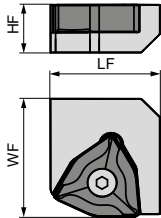
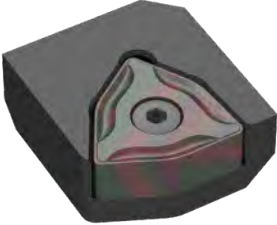
TO
74 610 ...
03200
03400

Spare parts
for article number

74 610 03200
74 610 03400

				
Clamping key T	Clamping screw shim	Clamping screw gripping finger	Gripping finger	Carbide shim
AS	AS	AS	AS	AS
80 397 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
		52400	53500	
	030	52600	53500	55600

MaxiTurn – Single cartridge CA..-WNEU..



Single

Designation	LF mm	HF mm	WF mm	Indexable insert
CAXX-WNEU1613	50	22	55	WNEU 161325
CAXX-WNEU1614	50	22	55	WNEU 161425
CA12-WNEU1613	110	40	65	WNEU 161325

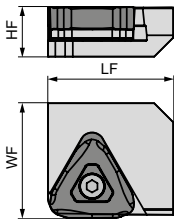
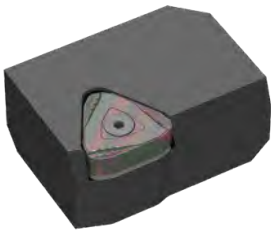
TO
74 610 ...
04200
04400
04600

Spare parts
for article number

74 610 04200
74 610 04400
74 610 04600

		
Clamping key T	Clamping screw indexing insert	Carbide shim
AS	AS	AS
80 397 ...	70 950 ...	70 950 ...
050	52800	
050	52800	
050	52300	55800

MaxiTurn – Single cartridge CA..-NNUX..



Single

Designation	LF mm	HF mm	WF mm	Indexable insert
CA12-NN20-40-65-90	90	40	65	NNUX 201020

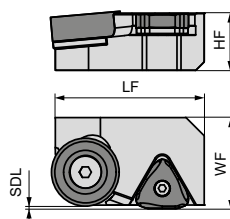
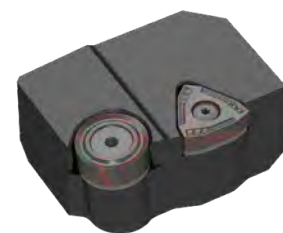
TO
74 610 ...
01200

Spare parts
for article number

74 610 01200

 <p>Clamping key T</p>	 <p>Screwdriver</p>	 <p>Clamping screw indexable insert</p>	 <p>Carbide shim</p>
AS	AS	AS	AS
80 397 ...	80 950 ...	70 950 ...	70 950 ...
060	114	53000	54700

MaxiTurn – Tandem cartridge TCA..-RN../NN..



Tandem

Designation	LF mm	HF mm	WF mm	SDL mm	Indexable insert
TCAXX-RN20NN15	55	22	39	1.2	RNMH 2008.. / NNUX 150820
TCAXX-RN28NN15	90	40	65	1.0	RNMH 2810.. / NNUX 150820
TCA12-RN50NN20	110	40	65	1.5	RNMH 5018.. / NNUX 201020

TO

74 611 ...

01200

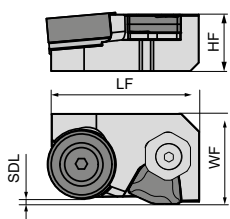
01400

01600

Spare parts for article number

					
AS	AS	AS	AS	AS	AS
80 397 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
060	114	53000		54900	54600
050	114	53000	52200	55000	54600
060	114	53000	52500	55200	54700

MaxiTurn – Tandem cartridge TCA..-RN../WNEF



Tandem

Designation	LF mm	HF mm	WF mm	SDL mm	Indexable insert
TCA12-RN38WNEF16	110	40	65	2.5	RNGH 3812.. / WNEF 161325

TO

74 611 ...

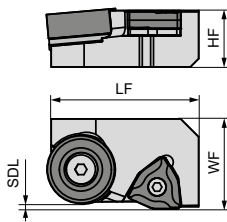
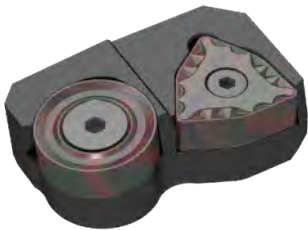
07200

Spare parts for article number

						
AS	AS	AS	AS	AS	AS	AS
80 397 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
030	52500	52600	52400	53500	55600	55100

74 611 07200

MaxiTurn – Tandem cartridge TCA..-RN../WNEU



Tandem

Designation	LF mm	HF mm	WF mm	SDL mm	Indexable insert
TCA12-RN38WNEU16	110	40	65	2.5	RNGH 3812.. / WNEU 1613/1425..
TCA12-RN50WNEU16	110	40	65	3.5	RNMH 5018.. / WNEU 1613/1425..

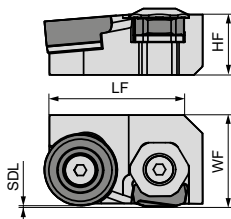
TO
74 611 ...
06200
06400

Spare parts
for article number

74 611 06200
74 611 06400

				
Clamping key T	Clamping screw indexable insert	Clamping screw indexable insert	Carbide shim	Carbide shim
AS	AS	AS	AS	AS
80 397 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
050	52300	52500	55800	55100
050	52300	52500	55800	55200

MaxiTurn – Tandem cartridge TCA..-RN../YN..



Tandem

Designation	LF mm	HF mm	WF mm	SDL mm	Indexable insert	TO 74 611 ...
TCAXX-RN20YN20	64	22	39	1.0	RNMH 2008.. / YNUF 201220	00200
TCA12-RN38YN20	110	40	65	1.2	RNGH 3812.. / YNUF 201220	00400
TCA12-RN38YN27	110	40	65	1.2	RNGH 3812.. / YNUF 271220	00800
TCA12-RN50YN20	110	40	65	1.2	RNMH 5018.. / YNUF 201220	00600

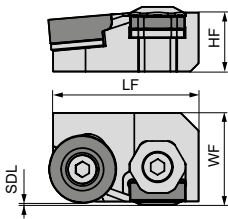
Spare parts
for article number

	Clamping screw shim AS 70 950 ...	Clamping screw gripping finger AS 70 950 ...	Gripping finger AS 70 950 ...	Carbide shim AS 70 950 ...	Carbide shim AS 70 950 ...
74 611 00200	52600	52700	53400	56400	54900
74 611 00400	52600	52400	53500	56400	55100
74 611 00800	52600	52400	53500	56700	55100
74 611 00600	52600	52400	53500	56400	55200

Spare parts
for article number

	Clamping key T AS 80 397 ...	Screwdriver AS 80 950 ...	Clamping screw indexable insert AS 70 950 ...	Clamping screw indexable insert AS 70 950 ...
74 611 00200	030	114	53000	
74 611 00400	030			52500
74 611 00800	030			52500
74 611 00600	030			52500

MaxiTurn – Tandem cartridge TCA..-RN../LN..



Tandem

Designation	LF mm	HF mm	WF mm	SDL mm	Indexable insert
TCA12-RN50LN23	110	40	65	1.2	RNMH 5018.. / LNGF 231225

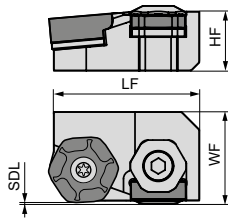
TO
74 611 ...
04200

Spare parts
for article number

74 611 04200

 Clamping key T	 Clamping screw indexable insert	 Clamping screw shim	 Clamping screw gripping finger	 Gripping finger	 Carbide shim	 Carbide shim
AS	AS	AS	AS	AS	AS	AS
80 397 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
030	52500	52600	52400	53500	55200	54300

MaxiTurn – Tandem cartridge TCAS..-HN../LN..



Tandem

Designation	LF mm	HF mm	WF mm	SDL mm	Indexable insert
TCAS12-HN28LN23	110	40	65	1.2	HNMH 2818.. / LNGF 231225

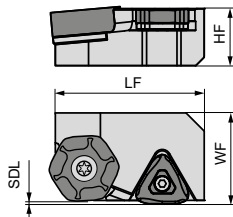
TO
74 611 ...
05200

Spare parts
for article number

74 611 05200

 Clamping key T	 Slotted nut	 Clamping screw indexable insert	 Clamping screw shim	 Clamping screw gripping finger	 Gripping finger	 Carbide shim	 Carbide shim
AS	AS	AS	AS	AS	AS	AS	AS
80 397 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
030	53900	52500	52600	52400	53500	54300	54200

MaxiTurn – Tandem cartridge TCAS..-HN../NN..



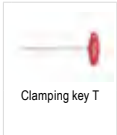
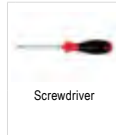
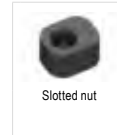
Tandem

Designation	LF mm	HF mm	WF mm	SDL mm	Indexable insert
TCASXX-HN13NN15	55	22	39	1.2	HNMJ 1310.. / NNUX 150820
TCAS12-HN28NN20	110	40	65	1.2	HNMH 2818.. / NNUX 201020

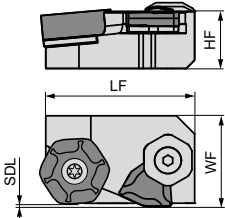
TO
74 611 ...
02200
02400

Spare parts
for article number

74 611 02200	060	114	53700	53000	70 950 ...	54600	54000
74 611 02400	060	114	53900	53000	52500	54700	54200

 Clamping key T	 Screwdriver	 Slotted nut	 Clamping screw indexable insert	 Clamping screw indexable insert	 Carbide shim	 Carbide shim
AS	AS	AS	AS	AS	AS	AS
80 397 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
060	114	53700	53000	70 950 ...	54600	54000
060	114	53900	53000	52500	54700	54200

MaxiTurn – Tandem cartridge TCAS..-HN../WNEF



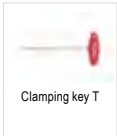
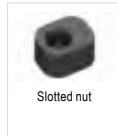
Tandem

Designation	LF mm	HF mm	WF mm	SDL mm	Indexable insert
TCAS12-HN22WNEF16	110	40	65	2.5	HNMH 2215.. / WNEF 161325

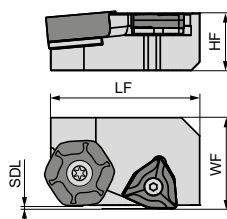
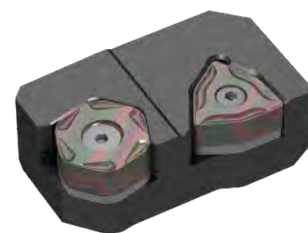
TO
74 611 ...
09200

Spare parts
for article number

74 611 09200	030	53800	53200	52600	55600	54100
--------------	-----	-------	-------	-------	-------	-------

 Clamping key T	 Slotted nut	 Clamping screw indexable insert	 Clamping screw shim	 Carbide shim	 Carbide shim
AS	AS	AS	AS	AS	AS
80 397 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
030	53800	53200	52600	55600	54100

MaxiTurn – Tandem cartridge TCAS..-HN../WNEU



Tandem

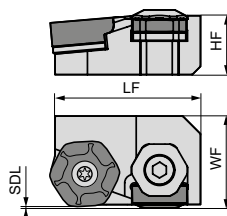
Designation	LF mm	HF mm	WF mm	SDL mm	Indexable insert	TO 74 611 ...
TCAS12-HN22WNEU16	110	40	65	2.5	HNMH 2215.. / WNEU 1613/1425..	08200
TCAS12-HN28WNEU16	110	40	65	3.5	HNMH 2818.. / WNEU 1613/1425..	08400

Spare parts for article number

	AS 80 397 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
74 611 08200	050	53800	52300	53200	55800	54100
74 611 08400	050	53900	52300	52500	55800	54200

					
Clamping key T	Slotted nut	Clamping screw indexable insert	Clamping screw indexable insert	Carbide shim	Carbide shim
AS	AS	AS	AS	AS	AS
80 397 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
050	53800	52300	53200	55800	54100
050	53900	52300	52500	55800	54200

MaxiTurn – Tandem cartridge TCAS..-HN../YN..



Tandem

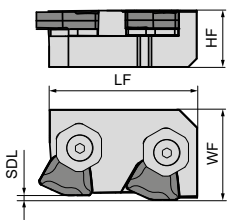
Designation	LF mm	HF mm	WF mm	SDL mm	Indexable insert	TO 74 611 ...
TCAS12-HN22YN20	110	40	65	1.2	HNMH 2215.. / YNUF 201220	03200
TCAS12-HN22YN27	110	40	65	1.2	HNMH 2215.. / YNUF 271220	03600
TCAS12-HN28YN20	110	40	65	1.2	HNMH 2818.. / YNUF 201220	03400

Spare parts for article number

	AS 80 397 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
74 611 03200	030	53800	53200	52600	52400	53500	56400
74 611 03600	030	53800	53200	52600	52400	53500	56700
74 611 03400	030	53900	52500	52600	52400	53500	56400

							
Clamping key T	Slotted nut	Clamping screw indexable insert	Clamping screw shim	Clamping screw gripping finger	Gripping finger	Carbide shim	Carbide shim
AS	AS	AS	AS	AS	AS	AS	AS
80 397 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
030	53800	53200	52600	52400	53500	56400	54100
030	53800	53200	52600	52400	53500	56700	54100
030	53900	52500	52600	52400	53500	56400	54200

MaxiTurn – Tandem cartridge TCA..-WNEF/WNEF



Tandem

Designation	LF mm	HF mm	WF mm	SDL mm	Indexable insert
TCA12-WNEF16WNEF16	110	40	65	2.5	WNEF 161325 / WNEF 161325

TO
74 611 ...
10200

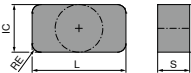
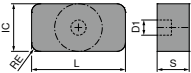
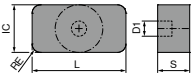
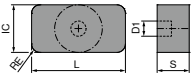
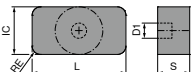
Spare parts
for article number

74 611 10200

 Clamping key T	 Clamping screw shim	 Clamping screw gripping finger	 Gripping finger	 Carbide shim
AS	AS	AS	AS	AS
80 397 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
030	52600	52400	53500	55600

LNMN / LNMR

Designation	L mm	S mm	IC mm
LNMN 6688..	38.1	12.7	19.05
LNMR 5014..	50.8	14.2	25.40



MaxiTurn – CERAMIC turning indexable insert

LNMN

		CTWK601	CTSH110	CTS3105	CTM3110	CTN3110	CTCK120	CTKX715
		F LNMN	F LNMN	F LNMN	F LNMN	F LNMN	F LNMN	F LNMN
		IA	IC	IC	IC	IC	IA	IC
ISO	RE mm	74 204 ...	74 204 ...	74 204 ...	74 204 ...	74 204 ...	74 204 ...	74 204 ...
6688PN	3.0		10100	20100	30100	40100		00100
6688SN	3.0	50200					60100	
6688SN	3.0	50100						
P								○
M								
K		●	●	●	●	●	●	○
N								
S								●
H		○	●	●				●
O								

MaxiTurn – Carbide turning indexable insert

LNMR

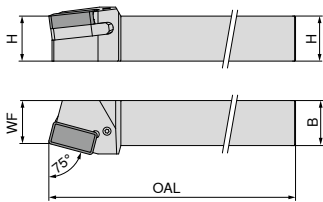
		-R90 CTCP625	-R90 CTCP115-P	-R90 CTCP125-P	-R90 CTCK110	-R96 CTCP115-P	-R96 CTCP125-P
		R LNMR	R LNMR	R LNMR	R LNMR	R LNMR	R LNMR
		IA	IA	IA	IA	IA	IA
ISO	RE mm	74 226 ... 21001	74 226 ... 31001	74 226 ... 51001	74 226 ... 01000	74 227 ... 31001	74 227 ... 51001
501432SN	3.2						
P		•	•	•	○	•	•
M		•					
K			○	○	•	○	○
N							
S		•					
H							
O							

MaxiTurn – Carbide turning indexable insert

LNMR

		-R98 CTCP625	-R98 CTCP125-P	-R98 CTP1127	CTS12D
		R LNMR	R LNMR	R LNMR	F LNMR
		IA	IA	IA	IA
ISO	RE mm	74 228 ... 41001	74 228 ... 51001	74 228 ... 01001	74 229 ... 61001
501432SN	3.2				
P		•	•	•	
M		•		•	
K			○		
N					•
S		•			
H					
O					•

MaxiTurn – Tools for indexable inserts LNMR 50..



Illustrations show right-hand versions



Designation	H mm	B mm	OAL mm
HDHTL 5050U.1LN50SC.75		50	350
HDHTR 5050U.1LN50SC.75	50	50	350

Left	Right
TO	TO
74 626 ... 25000	74 626 ... 05000

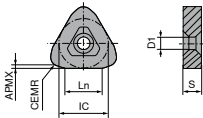
Spare parts
for article number

74 626 25000
74 626 05000

 HSS shim	 Grub screw
AS	AS
70 950 ...	70 950 ...
75400	M8x16 75500
75200	M8x16 75500

NNUX

Designation	Ln	S	CEMR	IC
NNUX 201000S42-M46	mm20	mm10.0	mm12	mm28



MaxiTurn – Carbide bar peeling indexable insert

NNUX

-M46
CTCP125-P

DRAGONSKIN



M
NNUX

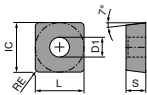
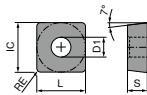
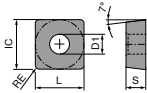
IA
74 006 ...
64101

Designation
NNUX 201000S42-M46

P	●
M	○
K	
N	
S	●
H	
O	

SCMT

Designation	L	S	D1	IC
	mm	mm	mm	mm
SCMT 2509..	25.4	9.525	8.7	25.4
SCMT 2509..	38.1	9.525	8.7	38.1
SCMT 3809..	38.1	9.525	8.7	38.1



MaxiTurn – Carbide turning indexable insert

SCMT

		<div><div>-R90</div><div>CTCP115-P</div></div>	<div><div>-R90</div><div>CTCP125-P</div></div>	<div><div>-R90</div><div>CTCP135-P</div></div>	<div><div>-R90</div><div>CTCK110</div></div>	<div><div>-R90</div><div>CTP1127</div></div>
		<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>	<div>DRAGONSKIN</div>
		<div><div><div></div><div></div><div></div></div></div>	<div><div><div></div><div></div><div></div></div></div>	<div><div><div></div><div></div><div></div></div></div>	<div><div><div></div><div></div><div></div></div></div>	<div><div><div></div><div></div><div></div></div></div>
		<div></div>	<div></div>	<div></div>	<div></div>	<div></div>
		<div><div>R</div><div>SCMT</div></div>	<div><div>R</div><div>SCMT</div></div>	<div><div>R</div><div>SCMT</div></div>	<div><div>R</div><div>SCMT</div></div>	<div><div>R</div><div>SCMT</div></div>
		<div>IA</div>	<div>IA</div>	<div>IA</div>	<div>IA</div>	<div>IA</div>
ISO	RE	<div>74 223 ...</div>	<div>74 223 ...</div>	<div>74 223 ...</div>	<div>74 223 ...</div>	<div>74 223 ...</div>
	mm					
250924SN	2.4	<div>31001</div>		<div>71001</div>	<div>01000</div>	
250924SN	2.4		<div>51001</div>			
380932SN	3.2	<div>32201</div>	<div>52201</div>	<div>72201</div>		<div>02201</div>
P		<div>●</div>	<div>●</div>	<div>●</div>		<div>●</div>
M				<div>○</div>		<div>●</div>
K		<div>○</div>	<div>○</div>			
N						
S						
H						
O						

MaxiTurn – Carbide turning indexable insert

SCMT

ISO	RE mm
250924SN	2.4
380932SN	3.2

P			
M			
K			
N			
S			
H			
O			

-R91 CTCP115-P	-R91 CTCP125-P	-R91 CTCP135-P	-R91 CTCK110
DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
R SCMT	R SCMT	R SCMT	R SCMT
IA 74 224 ... 31001	IA 74 224 ... 51001	IA 74 224 ... 72201	IA 74 224 ... 01000
32201	52201		

MaxiTurn – Carbide turning indexable insert

SCMT

ISO	RE mm
380932SN	3.2

P			
M			
K			
N			
S			
H			
O			

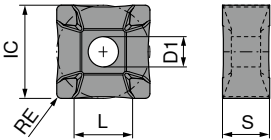
-R95 CTCP115-P	-R95 CTCP125-P	-R95 CTP1127
DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
R SCMT	R SCMT	R SCMT
IA 74 225 ... 32201	IA 74 225 ... 52201	IA 74 225 ... 02201



**Heavy duty
machining**

SNMG

Designation	L	S	D1	IC
	mm	mm	mm	mm
1507-R..	15.88	7.94	5.16	15.88
SNMG 1..	19.05	7.94	7.94	19.05



CoreLine – Carbide scraper indexable insert

SNMG

CTCM135



F
SNMG

ISO	RE mm
1507-R07	0.8
1507-R09	0.8
1507-R11	0.8
1507-R13	0.8
1507-R15	0.8
1507-R18	0.8
1507-R20	0.8
1507-R22	0.8
1507-R25	0.8
1507-R27	0.8
1507-R30	0.8
1507-R35	0.8
1507-R40	0.8
1507-R45	0.8
1507-R50	0.8
1507-R60	0.8
1507-R70	0.8
1507-R80	0.8

TR
74 222 ...
00100
00200
00300
00400
00500
00600
00700
00800
00900
01000
01100
01200
01300
01400
01500
01600
01700
01800

P	•
M	•
K	
N	
S	
H	
O	

CoreLine – Carbide scraper indexable insert

SNMG

CTCM135



F

SNMG

ISO	RE mm		TR
			74 221 ...
1907-R00	0.8		00100
1907-R10	0.8		00200
1907-R11	0.8		00400
1907-R12	0.8		00500
1907-R13	0.8		00600
1907-R15	0.8		00700
1907-R18	0.8		00800
1907-R20	0.8		00900
1907-R22	0.8		01000
1907-R25	0.8		01100
1907-R30	0.8		01200
1907-R35	0.8		01300
1907-R45	0.8		01400
1907-R50	0.8		01500
1907-R55	0.8		01600
1907-R60	0.8		01700
1907-R70	0.8		01800
1907-R80	0.8		01900
1907-R90	0.8		02000
1907-R100	0.8		00300
P			●
M			●
K			
N			
S			
H			
O			

Material examples for cutting data tables

	Material sub-group	Index	Composition / Structure / Heat treatment	Hardness HB / HRC Tensile strength at rupture (Rm) lbf/in ²	Material number Material designation	Material number Material designation
P	Unalloyed steel	P.1.1	< 0.15 % C, annealed	60900 lbf/in ² / 125 HB	1.0401 1015	1.0301 1010
		P.1.2	< 0.45 % C, annealed	92800 lbf/in ² / 190 HB	1.1191 1045	1.0737 12L14
		P.1.3	< 0.45 % C, tempered	121800 lbf/in ² / 250 HB	1.1191 1045	1.0503 1043
		P.1.4	< 0.75 % C, annealed	132000 lbf/in ² / 270 HB	1.1223 1060	1.0535 1055
		P.1.5	< 0.75 % C, tempered	146500 lbf/in ² / 300 HB	1.1223 1060	1.1274 1095
	Low-alloy steel	P.2.1	Annealed	88500 lbf/in ² / 180 HB	1.7131 5115	1.6523 8620
		P.2.2	Tempered	134900 lbf/in ² / 275 HB	1.7131 5115	1.6582 4340
		P.2.3	Tempered	146500 lbf/in ² / 300 HB	1.7225 4142	1.7131 5115
		P.2.4	Tempered	174000 lbf/in ² / 375 HB	1.7225 4142	1.7223 4140
	High-alloy steel and high-alloy tool steel	P.3.1	Annealed	98600 lbf/in ² / 200 HB	1.4021 420	1.2379 D2
		P.3.2	Hardened and tempered	159500 lbf/in ² / 300 HB	1.2343 H11	1.3343 M2
		P.3.3	Hardened and tempered	188500 lbf/in ² / 400 HB	1.2343 H11	1.2363 A2
	Stainless steel	P.4.1	Ferritic / martensitic, annealed	98600 lbf/in ² / 200 HB	1.4016 430	1.4125 440C
		P.4.2	Martensitic, tempered	117500 lbf/in ² / 300 HB	1.4112 S44003	1.4021 420
M	Stainless steel	M.1.1	Austenitic / austenitic-ferritic, quenched	88500 lbf/in ² / 180 HB	1.4301 304	1.4401 316
		M.2.1	Austenitic, tempered	300 HB	1.4841 314	1.4568 17-7 PH
		M.3.1	Austenitic / ferritic (Duplex)	113100 lbf/in ² / 230 HB	1.4462 S32205	1.4410 S32750
K	Grey cast iron	K.1.1	Pearlitic / ferritic	88500 lbf/in ² / 180 HB	0.6010 A48-20B	0.6025 A48-40 B
		K.1.2	Pearlitic (martensitic)	127600 lbf/in ² / 260 HB	0.6030 A48-45B	0.6040 A48-60 B
	Spherulitic graphite cast iron	K.2.1	Ferritic	78300 lbf/in ² / 160 HB	0.7040 60-40-18	0.7050 65-45-12
		K.2.2	Pearlitic	122600 lbf/in ² / 250 HB	0.7070 100-70-03	0.7660 A439 Type D2
	Malleable iron	K.3.1	Ferritic	63800 lbf/in ² / 130 HB	0.8035 GTW-35-04	
		K.3.2	Pearlitic	113100 lbf/in ² / 230 HB	0.8170 70003	
N	Aluminium wrought alloy	N.1.1	Non-hardenable	60 HB	3.0255 A91060	3.0255 A91060
		N.1.2	Hardenable, age-hardened	49300 lbf/in ² / 100 HB	3.1355 2024	3.1355 2024
	Cast aluminium alloy	N.2.1	≤ 12 % Si, non-hardenable	36300 lbf/in ² / 75 HB	3.2581 A04130 / A413-0	3.2581 A04130 / A413-0
		N.2.2	≤ 12 % Si, hardenable, age-hardened	43500 lbf/in ² / 90 HB	3.2134 G-AISi5Cu1Mg	
		N.2.3	> 12 % Si, non-hardenable	63800 lbf/in ² / 130 HB	G-AISi17Cu4Mg	
	Copper and copper alloys (bronze/brass)	N.3.1	Free-machining alloys, Pb > 1 %	54400 lbf/in ² / 110 HB	2.0380 CuZn39Pb2 (Ms58)	2.0380 C37700
		N.3.2	CuZn, CuSnZn	43500 lbf/in ² / 90 HB	2.0331 CuZn15	2.0331 C34000
		N.3.3	CuSn, lead-free copper and electrolytic copper	49300 lbf/in ² / 100 HB	2.0060 E-Cu57	
	Magnesium alloys	N.4.1	Magnesium and magnesium alloys	70 HB	3.5612 MgAl6Zn	
S	Heat-resistant alloys	S.1.1	Fe basis, annealed	98600 lbf/in ² / 200 HB	1.4864 X12NiCrSi 36-16	1.4864 330
		S.1.2	Fe basis, age-hardened	137800 lbf/in ² / 280 HB	1.4980 X6NiCrTiMoVB25-15-2	1.4980 S66286
		S.2.1	Ni or Co basis, annealed	121800 lbf/in ² / 250 HB	2.4856 Inconel 625	2.4812 Hastelloy C
		S.2.2	Ni or Co basis, age-hardened	171100 lbf/in ² / 350 HB	2.4952 Nimonic 80A	2.4668 Inconel 718
		S.2.3	Ni or Co basis, cast	156600 lbf/in ² / 320 HB	2.4674 Nimocast PK24	2.4670 Nimocast 713
	Titanium alloys	S.3.1	Pure titanium	5800 lbf/in ²	3.7025 Ti99,8	
		S.3.2	Alpha + beta alloys, age-hardened	152300 lbf/in ² / 320 HB	3.7165 TiAl6V4	
		S.3.3	Beta alloys	203100 lbf/in ² / 410 HB	Ti555.3 Ti-5Al-5V-5Mo-3Cr	
H	Hardened steel	H.1.1	Hardened and tempered	46–55 HRC		
		H.1.2	Hardened and tempered	56–60 HRC		
		H.1.3	Hardened and tempered	61–65 HRC		
		H.1.4	Hardened and tempered	66–70 HRC		
	Chilled iron	H.2.1	Cast	400 HB		
	Hardened cast iron	H.3.1	Hardened and tempered	55 HRC		
O	Non-metal materials	O.1.1	Plastics, duroplastic	≤ 21800 lbf/in ²	EP, MF, PF, UP	
		O.1.2	Plastics, thermoplastic	≤ 14500 lbf/in ²	PA, PC, PE, PI, PMMA, POM, PP, PS, PTFE, PVC	
		O.2.1	Aramid fibre-reinforced	≤ 145000 lbf/in ²	AFK	
		O.2.2	Glass/carbon-fibre reinforced	≤ 145000 lbf/in ²	CFRP, GFRP	
		O.3.1	Graphite			

Cutting data standard values

Index	DRAGONSKIN															
	TCM407	TCM10	CTEP110	CTCP115-P	CTCP125-P	CTCP135-P	CTCK110	CTCK120	CTPM125	CTCM120	CTCM130	CTPX710 -F34 -M34 -M42	CTPX710 -F05 -25P -25Q	CTPX715 -27 -29	H210T	H10T H216T
	v _c in m/min															
P.1.1	380	310	460	370	295	210	395	330	200	230	185	325	340	275		
P.1.2	330	265	400	315	250	175	345	280	170	200	150	290	300	235		
P.1.3	280	230	350	270	210	145	300	240	140	175	125	250	260	200		
P.1.4	265	210	330	250	200	135	280	220	130	165	115	240	250	190		
P.1.5	240	190	300	230	180	120	260	200	120	150	100	220	235	170		
P.2.1	335	270	410	325	260	180	350	290	175	200	160	290	300	240		
P.2.2	260	210	325	250	195	130	280	220	130	160	110	235	250	185		
P.2.3	240	190	300	230	180	120	260	200	120	150	100	220	235	170		
P.2.4	180	145	230	170	130	85	200	150	80	115	60	175	190	125		
P.3.1	280	220	345	200	170	150	270	220	140	160	125	140	150	140		
P.3.2	225	170	280	140	105	95	225	175	100	115	80	85	95	80		
P.3.3	170	115	210	85	40	35	180	130	50	75	40	30	35	25		
P.4.1	280	220	345	200	170	155			140	160	125	140	155	140		
P.4.2	250	195	310	170	135	125			120	140	100	115	130	110		
M.1.1	280	220	345			155			140	160	125	140	150	140		
M.2.1						95			100	115	80	85	90	80		
M.3.1						135			130	150	110	125	130	120		
K.1.1			410	255	170		400	275						200	170	140
K.1.2			310	235	160		310	265						160	130	115
K.2.1	355	260	440	270	180		320	290						190	180	150
K.2.2	315	215	350	205	160		275	230						150	130	110
K.3.1	325	300	415	250	200		310	275						210	190	170
K.3.2	250	205	250	210	160		265	230						180	160	140
N.1.1												1840	1840	1750	1650	1400
N.1.2												1600	1600	1500	1350	1100
N.2.1												1250	1250	1200	1200	950
N.2.2												1250	1250	1200	1100	950
N.2.3												750	750	700	600	500
N.3.1												650	650	625	525	425
N.3.2												630	630	600	500	400
N.3.3												500	500	475	375	275
N.4.1												340	340	325	275	225
S.1.1											35	100	110	40	45	
S.1.2											25	80	85	30	35	
S.2.1											20	65	75	30	35	
S.2.2											20	40	45	25	25	
S.2.3											20	40	45	20	20	
S.3.1											110	95	100	110	110	
S.3.2											65	55	60	70	70	
S.3.3											45	40	45	50	50	
H.1.1																
H.1.2																
H.1.3																
H.1.4																
H.2.1																
H.3.1																
O.1.1														140	160	130
O.1.2																
O.2.1														150	140	105
O.2.2																
O.3.1																



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material, and type of machine. The specified values represent guideline cutting data that can be adjusted by approx. **±20%** according to the usage conditions.

Cutting data standard values

Index	DRAGONSKIN														H210T	H10T H216T
	TCM407	TCM10	CTEP110	CTCP115-P	CTCP125-P	CTCP135-P	CTCK110	CTCK120	CTPM125	CTCM120	CTCM130	CTPX710 -F34 -M34 -M42	CTPX710 -F05 -25P -25Q	CTPX715 -27 -29		
	v _c in m/min															
P.1.1	1250	1020	1530	1220	970	690	1300	1080	670	750	610	1070	1120	910		
P.1.2	1080	880	1330	1040	830	580	1140	930	560	660	500	940	990	780		
P.1.3	930	750	1150	890	690	480	980	780	470	570	400	830	860	660		
P.1.4	870	700	1090	830	660	450	930	740	440	540	370	790	830	620		
P.1.5	790	640	1000	760	590	400	850	670	390	500	320	730	780	560		
P.2.1	1110	900	1360	1070	860	590	1160	950	580	670	520	960	990	800		
P.2.2	860	690	1070	830	640	430	920	730	430	530	360	780	830	610		
P.2.3	790	640	1000	760	590	400	850	670	390	500	320	730	780	560		
P.2.4	600	480	770	560	430	280	660	490	270	380	200	580	630	410		
P.3.1	930	720	1140	660	560	500	900	730	470	520	410	460	500	450		
P.3.2	740	550	920	460	350	310	740	580	320	380	270	280	310	270		
P.3.3	550	380	700	280	130	120	590	430	170	240	130	100	120	80		
P.4.1	930	720	1140	660	560	510			470	520	410	460	510	450		
P.4.2	830	640	1030	560	450	410			390	450	340	370	430	360		
M.1.1	930	720	1140			510			470	520	410	460	500	450		
M.2.1						310			320	380	270	280	300	270		
M.3.1						450			420	480	370	410	430	400		
K.1.1			1350	840	560		1320	910						660	560	460
K.1.2			1020	780	530		1020	870						530	430	380
K.2.1	1170	860	1450	890	590		1060	960						630	590	500
K.2.2	1040	710	1160	680	530		910	760						500	430	360
K.3.1	1070	990	1370	830	660		1020	910						690	630	560
K.3.2	830	680	830	690	530		870	760						590	530	460
N.1.1												6070	6070	5780	5450	4620
N.1.2												5280	5280	4950	4460	3630
N.2.1												4130	4130	3960	3960	3140
N.2.2												4130	4130	3960	3630	3140
N.2.3												2480	2480	2310	1980	1650
N.3.1												2150	2150	2060	1730	1400
N.3.2												2080	2080	1980	1650	1320
N.3.3												1650	1650	1570	1240	910
N.4.1												1120	1120	1070	910	740
S.1.1											115	330	365	130	140	
S.1.2											85	265	280	100	110	
S.2.1											65	210	250	100	110	
S.2.2											65	130	150	80	80	
S.2.3											60	125	140	65	65	
S.3.1											365	315	330	365	365	
S.3.2											210	180	200	230	230	
S.3.3											150	130	150	165	165	
H.1.1																
H.1.2																
H.1.3																
H.1.4																
H.2.1																
H.3.1																
O.1.1														460	530	430
O.1.2																
O.2.1														495	460	350
O.2.2																
O.3.1																



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material, and type of machine. The specified values represent guideline cutting data that can be adjusted by approx. **±20%** according to the usage conditions.

Cutting data standard values for diamond cutting materials CTD PD20 / PS30 / PU20 / CD10 / MD05

IndexMaterial group			a _p = 0,04–0,4 mm		a _p = 0,4–1,0 mm		a _p = 0,4–2,5 mm	
			Surface roughness R _z in µm		Surface roughness R _z in µm		Surface roughness R _z in µm	
			2,5–5,0	5,0–10	2,5–5,0	5,0–10	2,5–5,0	5,0–10
			CTD ...	CTD ...	CTD ...	CTD ...	CTD ...	CTD ...
N.1.1 N.1.2	Aluminium wrought alloys without Si f=0.002–0.020 inch/rev.	 Cutting material v _c in m/min	PD20 / PU20 / CD10 / MD05 min. 400	PD20 / PU20 / CD10 / MD05 min. 400	PD20 / PU20 / CD10 / MD05 min. 400	PD20 / PU20 / CD10 / MD05 min. 400	PD20 / PU20 / CD10 / MD05 min. 400	PD20 / PU20 / CD10 / MD05 min. 400
		 Cutting material v _c in m/min	PD20 / CD10 min. 400		PD20 / CD10 min. 400		PD20 / CD10 min. 400	
		 Cutting material v _c in m/min	PD20 / PU20 min. 400	PD20 / PU20 min. 400	PD20 / PU20 min. 400	PD20 / PU20 min. 400	PD20 / PU20 min. 400	PD20 / PU20 min. 400
N.2.1	Cast Aluminium Alloys Si≤12 % – hardened or Si=12–20% – non hardened f=0.002–0.020 inch/rev.	 Cutting material v _c in m/min	PS30 / PU20 / CD10 / MD05 min. 600	PS30 / PU20 / CD10 / MD05 min. 600	PS30 / PU20 / CD10 / MD05 min. 600	PS30 / PU20 / CD10 / MD05 min. 600	PS30 / PU20 / CD10 / MD05 min. 600	PS30 / PU20 / CD10 / MD05 min. 600
		 Cutting material v _c in m/min	PD20 / PU20 / CD10 min. 400	PD20 / PU20 / CD10 min. 400	PD20 / PU20 / CD10 min. 400	PS30 / PU20 / CD10 min. 600	PS30 / PU20 / CD10 min. 400	PS30 / PU20 / CD10 min. 400
		 Cutting material v _c in m/min	PS30 min. 600	PS30 min. 600	PS30 min. 600	PS30 min. 600	PS30 min. 600	
N.2.2 N.2.3	Aluminium cast alloys Si=12–20 % f=0.002–0.020 inch/rev.	 Cutting material v _c in m/min	PU20 / CD10 / MD05 min. 800	PU20 / CD10 / MD05 min. 400	PU20 / CD10 / MD05 min. 700	PU20 / CD10 / MD05 min. 400	PU20 / CD10 / MD05 min. 600	PU20 / CD10 / MD05 min. 400
		 Cutting material v _c in m/min	PU20 / CD10 min. 600		PU20 / CD10 min. 600		PU20 / CD10 min. 600	
		 Cutting material v _c in m/min		PU20 min. 600		PU20 min. 600		
N.3.1 N.3.2 N.3.3	Copper and copper wrought alloys f=0.002–0.020 inch/rev.	 Cutting material v _c in m/min	PD20 / PU20 / CD10 / MD05 min. 400	PD20 / PU20 / CD10 / MD05 min. 400	PD20 / PU20 / CD10 / MD05 min. 400	PS30 / PU20 / CD10 / MD05 300–1600	PD20 / PU20 / CD10 / MD05 min. 400	PD20 / PU20 / CD10 / MD05 min. 400
		 Cutting material v _c in m/min	PU20 / CD10 min. 300	PD20 / PU20 / CD10 min. 300	PD20 / PU20 / CD10 min. 400	PS30 / PU20 / CD10 min. 300	PD20 / PU20 / CD10 min. 400	PD20 / PU20 / CD10 min. 300
		 Cutting material v _c in m/min		PD20 / PU20 min. 300		PS30 / PU20 min. 300	PD20 / PU20 min. 300	PS30 / PU20 min. 200
O.1.1 O.1.2	Plastic materials without rein- forcement (acrylic glass) f=0.002–0.028 inch/rev.	 Cutting material v _c in m/min		PD20 / CD10 / MD05 min. 400		PD20 / CD10 / MD05 min. 300		PS30 / CD10 / MD05 min. 200
		 Cutting material v _c in m/min	PD20 / CD10 min. 300		PD20 / CD10 min. 200		PS30 / CD10 min. 200	
		 Cutting material v _c in m/min		PD20 / CD10 min. 400		PD20 / CD10 min. 300		PD20 / CD10 min. 200
O.2.1 O.2.2	Plastic materials with reinforce- ment (glass-fibre, carbon-fibre reinforced) f=0.002–0.028 inch/rev.	 Cutting material v _c in m/min	PS30 / PU20 / CD10 / MD05 min. 500		PS30 / PU20 / CD10 / MD05 min. 400	PS30 / PU20 / CD10 / MD05 min. 300	PS30 / PU20 / CD10 / MD05 min. 300	PS30 / PU20 / CD10 / MD05 min. 200
		 Cutting material v _c in m/min	PS30 / PU20 / CD10 min. 400		PS30 / PU20 / CD10 min. 300	PS30 / PU20 / CD10 min. 200	PS30 / PU20 / CD10 min. 200	PS30 / PU20 / CD10 min. 200
		 Cutting material v _c in m/min	PU20 min. 500		PU20 min. 400	PU20 min. 300	PU20 min. 300	
O.3.1	Graphite	Cutting material v _c in m/min	PD20 / PS30 / PU20 / CD10 min. 100		PD20 / PS30 / PU20 / CD10 min. 100		PD20 / PS30 / PU20 / CD10 min. 100	
 Smooth cut			 Irregular cut			 Interrupted cut		

Cutting data standard values for diamond cutting materials CTD PD20 / PS30 / PU20 / CD10 / MD05

Index	Material group	ap = 0.0015"–0.016"		ap = 0.0016"–0.040"		ap = 0.0016"–0.100"		
		Surface roughness R _z in µm		Surface roughness R _z in µm		Surface roughness R _z in µm		
		2.5–5.0	5.0–10	2.5–5.0	5.0–10	2.5–5.0	5.0–10	
		CTD ...	CTD ...	CTD ...	CTD ...	CTD ...	CTD ...	
N.1.1 N.1.2	Aluminium wrought alloys without Si f=0.002–0.020 inch/rev.	 Cutting material v _c in ft/min.	PD20 / PU20 / CD10 / MD05 1300–8250	PD20 / PU20 / CD10 / MD05 1300–8250	PD20 / PU20 / CD10 / MD05 1300–6600	PD20 / PU20 / CD10 / MD05 1300–6600	PD20 / PU20 / CD10 / MD05 1300–5300	PD20 / PU20 / CD10 / MD05 1300–5300
		 Cutting material v _c in ft/min.	PD20 / CD10 1300–8250		PD20 / CD10 1300–6600		PD20 / CD10 1300–5300	
		 Cutting material v _c in ft/min.	PD20 / PU20 1300–8250	PD20 / PU20 1300–8250	PD20 / PU20 1300–6600	PD20 / PU20 1300–6600	PD20 / PU20 1300–5300	PD20 / PU20 1300–5300
N.2.1	Cast Aluminium Alloys Si≤12 % – hardened or Si=12–20% – non hardened f=0.002–0.020 inch/rev.	 Cutting material v _c in ft/min.	PS30 / PU20 / CD10 / MD05 2000–6600	PS30 / PU20 / CD10 / MD05 2000–7000	PS30 / PU20 / CD10 / MD05 2000–6000	PS30 / PU20 / CD10 / MD05 2000–6600	PS30 / PU20 / CD10 / MD05 2000–5000	PS30 / PU20 / CD10 / MD05 2000–6000
		 Cutting material v _c in ft/min.	PD20 / PU20 / CD10 1300–6600	PD20 / PU20 / CD10 1300–7000	PD20 / PU20 / CD10 1300–6000	PS30 / PU20 / CD10 2000–6600	PS30 / PU20 / CD10 1000–5000	PS30 / PU20 / CD10 1300–6000
		 Cutting material v _c in ft/min.	PS30 2000–6600	PS30 2000–7000	PS30 2000–6000	PS30 2000–6600	PS30 2000–5000	
N.2.2 N.2.3	Aluminium cast alloys Si=12–20 % f=0.002–0.020 inch/rev.	 Cutting material v _c in ft/min.	PU20 / CD10 / MD05 2600–4000	PU20 / CD10 / MD05 1300–6000	PU20 / CD10 / MD05 2300–3300	PU20 / CD10 / MD05 1000–5000	PU20 / CD10 / MD05 2000–3000	PU20 / CD10 / MD05 1200–4000
		 Cutting material v _c in ft/min.	PU20 / CD10 2000–6000		PU20 / CD10 2000–5000		PU20 / CD10 2000–4000	
		 Cutting material v _c in ft/min.		PU20 2000–6000		PU20 2000–5000		
N.3.1 N.3.2 N.3.3	Copper and copper wrought alloys f=0.002–0.020 inch/rev.	 Cutting material v _c in ft/min.	PD20 / PU20 / CD10 / MD05 1300–6000	PD20 / PU20 / CD10 / MD05 1000–5200	PD20 / PU20 / CD10 / MD05 1300–5300	PS30 / PU20 / CD10 / MD05 1000–5000	PD20 / PU20 / CD10 / MD05 1300–4600	PD20 / PU20 / CD10 / MD05 1300–5300
		 Cutting material v _c in ft/min.	PU20 / CD10 1000–5000	PD20 / PU20 / CD10 1000–5000	PD20 / PU20 / CD10 1300–5300	PS30 / PU20 / CD10 1000–5000	PD20 / PU20 / CD10 1300–5300	PD20 / PU20 / CD10 1000–5000
		 Cutting material v _c in ft/min.		PD20 / PU20 1000–6000		PS30 / PU20 1000–5700	PD20 / PU20 1000–5000	PS30 / PU20 650–4300
O.1.1 O.1.2	Plastic materials without reinforcement (acrylic glass) f=0.002–0.028 inch/rev.	 Cutting material v _c in ft/min.		PD20 / CD10 / MD05 1200–4000		PD20 / CD10 / MD05 1000–3300		PS30 / CD10 / MD05 650–3300
		 Cutting material v _c in ft/min.	PD20 / CD10 1000–4000		PD20 / CD10 650–3300		PS30 / CD10 650–3000	
		 Cutting material v _c in ft/min.		PD20 / CD10 1200–4000		PD20 / CD10 1000–3300		PD20 / CD10 650–3300
O.2.1 O.2.2	Plastic materials with reinforcement (glass-fibre, carbon-fibre reinforced) f=0.002–0.028 inch/rev.	 Cutting material v _c in ft/min.	PS30 / PU20 / CD10 / MD05 1650–3300		PS30 / PU20 / CD10 / MD05 1200–3000	PS30 / PU20 / CD10 / MD05 1000–3000	PS30 / PU20 / CD10 / MD05 1300–5300	PS30 / PU20 / CD10 / MD05 650–4000
		 Cutting material v _c in ft/min.	PS30 / PU20 / CD10 1300–3000		PS30 / PU20 / CD10 1300–5300	PS30 / PU20 / CD10 650–3000	PS30 / PU20 / CD10 650–3000	PS30 / PU20 / CD10 650–4600
		 Cutting material v _c in ft/min.	PU20 1650–3300		PU20 1300–2600	PU20 1000–3300	PU20 1300–5300	
O.3.1	Graphite	 Cutting material v _c in ft/min.	PD20 / PS30 / PU20 / CD10 330–11000		PD20 / PS30 / PU20 / CD10 330–10000		PD20 / PS30 / PU20 / CD10 330–10000	
		 Smooth cut	 Irregular cut			 Interrupted cut		

Cutting data standard values for negative inserts

Indexable insert			-CF20 (Cermet)			-F50			-TFQ		
Form	Size	Radius	f mm/rev.	a _p mm	min. – Recommended – max.	f mm/rev.	a _p mm	min. – Recommended – max.	f mm/rev.	a _p mm	min. – Recommended – max.
			min. – Recommended – max.	min. – Recommended – max.		min. – Recommended – max.	min. – Recommended – max.		min. – Recommended – max.	min. – Recommended – max.	
 CN..	0903	04				0,06 0,15 0,25	0,2 0,5 1,5				
		08				0,10 0,20 0,30	0,4 1,0 2,0				
	1204	04	0,05 0,15 0,25	0,3 0,5 1,5		0,06 0,15 0,25	0,2 0,6 1,5		0,10 0,15 0,35	0,4 1,0 3,0	
		08	0,07 0,15 0,25	0,3 0,5 1,5		0,10 0,20 0,30	0,4 1,0 2,0		0,10 0,25 0,50	0,5 1,5 4,0	
		12				0,14 0,25 0,35	0,6 1,4 2,6		0,15 0,30 0,70	0,8 2,0 5,0	
		16									
	1606	08									
		12									
		16									
	1906	08									
		12									
		16									
 DN..	1104	02				0,04 0,10 0,20	0,1 0,4 2,3				
		04	0,05 0,15 0,25	0,3 0,5 1,5		0,06 0,15 0,25	0,2 0,6 1,5				
		08	0,07 0,15 0,25	0,3 0,5 1,5		0,10 0,20 0,30	0,4 1,0 2,0				
		12				0,14 0,25 0,35	0,6 1,4 2,6				
	1504	04				0,06 0,15 0,25	0,2 0,6 1,5				
		08				0,10 0,20 0,30	0,4 1,0 2,0				
		12				0,14 0,25 0,35	0,6 1,4 2,6				
		16									
	1506	04	0,05 0,15 0,25	0,3 0,5 1,5		0,06 0,15 0,25	0,2 0,6 1,5		0,10 0,15 0,30	0,4 1,0 3,0	
		08	0,07 0,15 0,25	0,3 0,5 1,5		0,10 0,20 0,30	0,4 1,0 2,0		0,10 0,25 0,40	0,5 1,5 4,0	
		12	0,10 0,20 0,30	0,5 0,7 1,5		0,14 0,25 0,35	0,6 1,4 2,6		0,10 0,35 0,50	1,0 2,5 4,0	
		16									
 SN..	0903	08				0,10 0,20 0,30	0,4 1,0 2,0				
		04				0,06 0,15 0,25	0,2 0,6 1,5				
	1204	08				0,10 0,20 0,30	0,4 1,0 2,0				
		12				0,14 0,25 0,35	0,6 1,4 2,6				
		16									
	1506	08									
		12									
		16									
	1906	12									
		16									
		24									
 TN..	1103	04				0,06 0,15 0,25	0,2 0,6 1,5				
		08				0,10 0,20 0,30	0,4 1,0 2,0				
	1604	04	0,05 0,15 0,25	0,3 0,5 1,5		0,06 0,15 0,25	0,2 0,6 1,5				
		08	0,07 0,15 0,25	0,3 0,5 1,5		0,10 0,20 0,30	0,4 1,0 2,0				
		12	0,10 0,20 0,30	0,5 0,7 1,5		0,14 0,25 0,35	0,6 1,4 2,6				
		16									
	2204	04									
		08									
		12									
		16									
 VN..	1604	04				0,06 0,15 0,25	0,2 0,6 1,5				
		08				0,10 0,20 0,30	0,4 1,0 2,0				
		12									
 WN..	0604	04	0,05 0,15 0,25	0,3 0,5 1,5		0,06 0,15 0,25	0,2 0,6 1,5		0,10 0,18 0,35	0,4 0,8 3,0	
		08	0,07 0,15 0,25	0,3 0,5 1,5		0,10 0,20 0,30	0,4 1,0 2,0		0,10 0,20 0,50	0,5 1,5 3,0	
		12									
	0804	04				0,06 0,15 0,25	0,2 0,6 1,5		0,10 0,15 0,35	0,4 1,0 3,0	
		08	0,07 0,15 0,25	0,3 0,5 1,5		0,10 0,20 0,30	0,4 1,0 2,0		0,10 0,25 0,50	0,5 1,5 4,0	
		12				0,14 0,25 0,35	0,6 1,4 2,6		0,15 0,30 0,70	0,8 2,0 5,0	
		16									



The cited cutting data are recommended values. We recommend adjusting the values to the actual conditions.

Cutting data standard values for negative inserts

Indexable insert			-XU			-M50			-TMQ		
Form	Size	Radius	f mm/rev.			f mm/rev.			f mm/rev.		
			min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.
 CN..	0903	04									
		08									
	1204	04	0,08 0,15 0,25	0,3 1,5 2,5	0,10 0,20 0,30	0,4 2,0 5,0					
		08	0,13 0,25 0,35	0,6 2,0 3,0	0,15 0,25 0,40	0,6 2,0 5,0	0,20 0,40 0,65	0,8 3,0 5,0			
		12	0,15 0,30 0,45	0,9 2,0 3,5	0,20 0,30 0,50	1,0 2,0 5,0	0,25 0,50 0,85	1,0 3,0 6,0			
		16			0,25 0,40 0,60	1,4 2,0 5,0					
	1606	08			0,15 0,25 0,40	0,6 3,0 8,0					
		12			0,20 0,30 0,50	1,0 3,0 8,0					
		16			0,25 0,40 0,60	1,4 3,0 8,0					
		24									
	1906	08									
		12									
		16									
	2509	24									
 DN..	1104	02									
		04			0,10 0,20 0,30	0,4 1,5 4,0					
		08			0,15 0,25 0,40	0,6 1,5 4,0					
		12			0,20 0,30 0,50	1,0 1,5 4,0					
	1504	04			0,10 0,20 0,30	0,4 2,0 5,0					
		08			0,15 0,25 0,40	0,6 2,0 5,0					
		12			0,20 0,30 0,50	1,0 2,0 5,0					
		16			0,25 0,40 0,60	1,4 2,0 5,0					
	1506	04	0,08 0,15 0,25	0,3 1,5 2,5	0,10 0,20 0,30	0,4 2,0 5,0					
		08	0,13 0,25 0,35	0,6 2,0 3,0	0,15 0,25 0,40	0,6 2,0 5,0	0,15 0,30 0,50	0,8 2,5 5,0			
		12	0,15 0,25 0,40	0,9 2,0 3,5	0,20 0,30 0,50	1,0 2,0 5,0	0,20 0,40 0,60	1,0 3,0 5,0			
		16			0,25 0,40 0,60	1,4 2,0 5,0					
 SN..	0903	08									
		04									
	1204	08			0,15 0,25 0,40	0,6 2,0 5,0					
		12			0,20 0,30 0,50	1,0 2,0 5,0					
		16			0,25 0,40 0,60	1,4 2,0 5,0					
	1506	08			0,15 0,25 0,40	0,6 3,0 8,0					
		12			0,20 0,30 0,50	1,0 3,0 8,0					
		16			0,25 0,40 0,60	1,4 3,0 8,0					
	1906	12									
		16									
	2507	24									
	2509	24									
 TN..	1103	04									
		08									
	1604	04			0,10 0,20 0,30	0,4 2,0 5,0					
		08			0,15 0,25 0,40	0,6 2,0 5,0					
		12			0,20 0,30 0,50	1,0 2,0 5,0					
	2204	04									
		08			0,15 0,25 0,40	0,6 3,0 8,0					
		12			0,20 0,30 0,50	1,0 3,0 8,0					
		16									
 VN..	1604	04	0,08 0,15 0,20	0,3 1,0 1,8	0,10 0,20 0,30	0,4 1,0 4,0					
		08	0,13 0,20 0,30	0,6 1,5 2,5	0,15 0,25 0,40	0,6 1,0 4,0					
		12			0,20 0,30 0,50	1,0 1,0 4,0					
 WN..	0604	04			0,10 0,20 0,30	0,4 1,0 3,0					
		08			0,15 0,25 0,40	0,6 1,0 3,0					
		12			0,20 0,30 0,50	1,0 1,0 3,0					
	0804	04	0,08 0,15 0,25	0,3 1,5 2,5	0,10 0,20 0,30	0,4 1,5 4,0					
		08	0,13 0,22 0,35	0,6 2,0 3,0	0,15 0,25 0,40	0,6 1,5 4,0	0,20 0,30 0,65	0,8 3,0 5,0			
		12	0,15 0,25 0,45	0,9 2,0 3,5	0,20 0,30 0,50	1,0 1,5 4,0	0,25 0,40 0,85	1,0 3,0 6,0			
		16			0,25 0,40 0,60	1,4 1,5 4,0					



→ Here you will find a detailed chip groove description.

Cutting data standard values for negative inserts

Indexable insert			-M70		-R28		-R58	
Form	Size	Radius	f mm/rev.	a _p mm	f mm/rev.	a _p mm	f mm/rev.	a _p mm
			min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.
 CN..	0903	04						
		08						
	1204	04						
		08	0,20 0,30 0,45	0,8 3,0 6,0	0,25 0,35 0,55	0,8 3,0 7,0	0,25 0,45 0,70	1,0 3,0 7,0
		12	0,25 0,40 0,60	1,2 3,0 6,0	0,30 0,45 0,70	1,0 3,0 7,0	0,30 0,55 0,85	1,5 3,0 7,0
		16	0,30 0,45 0,70	1,6 3,0 6,0	0,30 0,60 0,90	1,5 3,0 7,0	0,35 0,65 1,00	2,0 3,0 7,0
	1606	08	0,20 0,30 0,45	0,8 4,0 8,0				
		12	0,25 0,40 0,60	1,2 4,0 8,0	0,30 0,45 0,70	1,0 4,0 9,0	0,30 0,55 0,85	1,5 4,0 9,0
		16	0,30 0,45 0,70	1,6 4,0 8,0	0,35 0,60 0,90	1,5 4,0 9,0	0,35 0,65 1,00	2,0 4,0 9,0
		24	0,40 0,70 1,20	2,4 4,0 8,0			0,40 0,75 1,20	2,5 4,0 9,0
	1906	08	0,20 0,30 0,45	0,8 4,5 9,0				
		12	0,25 0,40 0,60	1,2 4,5 9,0	0,30 0,45 0,70	1,0 5,5 12,0	0,35 0,55 0,85	1,5 5,5 12,0
		16	0,30 0,45 0,70	1,6 4,5 9,0	0,35 0,60 0,90	1,5 5,5 12,0	0,40 0,65 1,00	2,0 5,5 12,0
		24	0,40 0,70 1,20	2,4 4,5 9,0	0,35 0,65 1,00	2,0 5,5 12,0	0,40 0,75 1,20	2,5 5,5 12,0
	2509	24	0,40 0,70 1,20	2,4 6,0 13,0	0,35 0,70 1,00	2,0 7,0 16,0	0,45 0,80 1,30	2,5 8,0 16,0
 DN..	1104	02						
		04						
		08	0,20 0,25 0,45	0,8 2,0 5,0				
		12	0,25 0,35 0,60	1,2 2,0 5,0				
	1504	04						
		08	0,20 0,25 0,45	0,8 2,5 6,0				
		12	0,25 0,35 0,60	1,2 2,5 6,0				
		16	0,30 0,40 0,70	1,6 2,5 6,0				
	1506	04						
		08	0,20 0,25 0,45	0,8 2,5 6,0				
		12	0,25 0,35 0,60	1,2 2,5 6,0	0,25 0,45 0,70	1,0 2,5 6,0	0,30 0,50 0,80	1,5 2,5 6,0
		16	0,30 0,40 0,70	1,6 2,5 6,0	0,30 0,60 0,85	1,5 2,5 6,0	0,35 0,60 0,90	2,0 2,5 6,0
 SN..	0903	08						
		04						
	1204	08	0,20 0,30 0,50	0,8 3,0 6,0			0,25 0,45 0,70	1,0 3,0 7,0
		12	0,25 0,40 0,65	1,2 3,0 6,0			0,30 0,55 0,85	1,5 3,0 7,0
		16	0,30 0,45 0,70	1,6 3,0 6,0				
	1506	08						
		12	0,25 0,40 0,65	1,2 4,0 8,0	0,30 0,35 0,70	1,0 4,0 9,0	0,30 0,55 0,85	1,5 4,0 9,0
		16	0,30 0,45 0,75	1,6 4,0 8,0	0,35 0,60 0,90	1,5 4,0 9,0	0,35 0,65 1,00	2,0 4,0 9,0
	1906	12	0,25 0,40 0,65	1,2 4,5 9,0			0,35 0,55 0,85	1,5 5,5 12,0
		16	0,30 0,45 0,75	1,6 4,5 9,0	0,35 0,60 0,90	1,5 5,5 12,0	0,40 0,65 1,00	2,0 5,5 12,0
		24	0,40 0,70 1,20	2,4 4,5 9,0			0,40 0,75 1,20	2,0 5,5 12,0
	2507	24			0,35 0,65 1,00	2,0 7,0 16,0	0,45 0,80 1,30	2,5 8,0 16,0
	2509	24	0,40 0,70 1,20	2,4 6,0 13,0	0,35 0,65 1,00	2,0 7,0 16,0	0,45 0,80 1,30	2,5 8,0 16,0
 TN..	1103	04						
		08						
	1604	04						
		08	0,20 0,25 0,45	0,8 2,5 6,0				
		12	0,25 0,35 0,60	1,2 2,5 6,0				
	2204	04	0,15 0,20 0,30	0,4 3,0 7,0				
		08	0,20 0,25 0,45	0,8 3,0 7,0				
		12	0,25 0,35 0,60	1,2 3,0 7,0			0,30 0,50 0,80	1,5 3,0 7,0
16		0,30 0,40 0,70	1,6 3,0 7,0	0,30 0,55 0,85	1,5 3,0 7,0			
 VN..	1604	04						
		08						
		12						
 WN..	0604	04						
		08	0,20 0,30 0,45	0,8 2,0 4,0				
		12	0,25 0,40 0,60	1,2 2,0 4,0				
	0804	04						
		08	0,20 0,30 0,45	0,8 2,5 5,0				
		12	0,25 0,40 0,60	1,2 2,5 5,0				
		16	0,30 0,45 0,70	1,6 2,5 5,0				



The cited cutting data are recommended values. We recommend adjusting the values to the actual conditions.

Cutting data standard values for negative inserts

Indexable insert			-R88		-F30		-M30	
Form	Size	Radius	f mm/rev.	a _p mm	f mm/rev.	a _p mm	f mm/rev.	a _p mm
			min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.
 CN..	0903	04						
		08						
	1204	04			0,05 0,15 0,25	0,4 1,0 2,0		
		08			0,10 0,22 0,35	0,8 1,5 2,5	0,15 0,25 0,40	1,0 2,0 4,5
		12					0,20 0,30 0,50	1,2 2,5 5,0
		16					0,25 0,35 0,55	1,6 2,5 5,0
	1606	08						
		12						
		16						
	1906	24	0,40 0,70 1,20	2,0 5,0 9,0				
		08						
		12						
		16	0,40 0,70 1,00	2,0 5,0 12,0				
 DN..	1104	02						
		04			0,05 0,15 0,25	0,4 1,0 2,0		
		08			0,10 0,20 0,35	0,8 1,5 2,5	0,15 0,25 0,40	1,0 2,0 4,5
		12					0,20 0,30 0,50	1,2 2,0 4,5
	1504	04			0,05 0,15 0,25	0,4 1,0 2,0		
		08			0,1 0,2 0,35	0,8 1,5 2,5	0,15 0,25 0,35	1,0 2,5 4,0
		12					0,20 0,30 0,50	1,0 2,5 4,0
	1506	16						
		04			0,05 0,15 0,25	0,4 1,0 2,0		
		08			0,10 0,20 0,35	0,8 1,5 2,5	0,15 0,25 0,40	1,0 2,0 5,5
		12					0,20 0,30 0,50	1,2 2,0 5,5
 SN..	0903	08						
		04			0,10 0,15 0,30	0,4 1,0 2,0		
	1204	08			0,15 0,20 0,40	0,8 1,5 2,5	0,20 0,25 0,45	1,0 2,0 4,5
		12			0,15 0,20 0,40	1,2 1,8 2,5	0,25 0,30 0,50	1,2 2,0 5,0
		16						
	1506	08						
		12						
		16						
	1906	12						
		16	0,40 0,70 1,00	2,0 5,0 12,0				
	2507	24	0,40 0,70 1,20	2,0 5,0 12,0				
		24	0,60 1,00 1,50	3,5 10,0 18,0				
 TN..	1103	04						
		08						
	1604	04						
		08						
	2204	12			0,05 0,15 0,25	0,4 1,0 2,0		
		04			0,10 0,15 0,35	0,8 1,5 2,5	0,15 0,25 0,40	1,0 2,0 4,5
		08					0,20 0,30 0,50	1,2 2,0 4,5
	1604	12						
		04			0,08 0,10 0,20	0,4 1,0 2,0		
		08			0,10 0,15 0,30	0,8 1,5 2,5	0,15 0,25 0,40	1,0 1,5 4,0
 VN..	0604	04						
		08			0,15 0,25 0,40	1,0 1,5 3,5	0,15 0,25 0,40	1,0 1,5 3,5
	0804	12			0,20 0,30 0,45	1,2 1,5 4,0	0,20 0,30 0,45	1,2 1,5 4,0
		04						
		08			0,15 0,25 0,40	1,0 2,0 4,5	0,15 0,25 0,40	1,0 2,0 4,5
	1604	12			0,20 0,30 0,50	1,2 2,0 5,0	0,20 0,30 0,50	1,2 2,0 5,0
		16						
	1604	04						
		08						
		12						
	1604	04						
		08						
		12						



→ Here you will find a detailed chip groove description.

Cutting data standard values for negative inserts

Indexable insert			-M60			-M34			-M42		
Form	Size	Radius	f mm/rev.			f mm/rev.			f mm/rev.		
			min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.
 CN..	0903	04									
		08									
	1204	04				0,08 0,12 0,18	1,0 1,5 3,0	0,10 0,20 0,25	0,8 1,5 4,0		
		08	0,25 0,30 0,50	1,5 2,5 6,0	0,10 0,15 0,35	1,0 1,8 3,5	0,20 0,30 0,44	1,0 2,5 4,0			
		12	0,30 0,35 0,55	2,0 3,0 6,0	0,13 0,20 0,40	1,5 2,0 4,0	0,28 0,35 0,55	1,2 3,0 4,2			
		16	0,30 0,40 0,60	2,0 3,0 6,0	0,15 0,25 0,45	2,0 3,0 4,5					
	1606	08									
		12	0,30 0,35 0,55	2,0 3,0 8,0							
		16									
	1906	08									
		12									
		16									
 DN..	1104	02									
		04						0,15 0,25 0,30	1,0 2,0 3,5		
		08						0,20 0,30 0,40	1,2 2,5 4,0		
		12									
	1504	04			0,08 0,12 0,18	0,8 1,2 2,5	0,15 0,25 0,35	1,0 2,0 4,0			
		08	0,25 0,30 0,45	1,5 2,5 6,0	0,10 0,15 0,30	1,0 1,8 3,5	0,20 0,30 0,40	1,2 2,5 5,0			
		12	0,30 0,40 0,55	1,5 2,5 6,0	0,13 0,20 0,38	1,5 2,0 4,0					
		16									
	1506	04						0,15 0,25 0,35	1,0 2,0 4,0		
		08	0,25 0,30 0,45	1,5 2,5 6,0	0,10 0,15 0,30	1,0 1,8 3,5	0,20 0,30 0,44	1,2 2,5 5,0			
		12	0,30 0,40 0,55	1,5 2,5 6,0	0,13 0,20 0,38	1,5 2,0 4,0					
		16									
 SN..	0903	08									
		04									
	1204	08	0,30 0,35 0,50	1,5 2,0 6,0	0,15 0,25 0,40	1,0 2,0 4,0	0,15 0,25 0,40	1,0 2,0 4,5			
		12	0,30 0,40 0,55	2,0 2,5 6,0	0,15 0,25 0,45	1,5 2,5 4,5	0,20 0,25 0,45	1,0 2,0 5,0			
		16	0,30 0,40 0,60	2,0 2,5 6,0							
	1506	08									
		12									
		16									
	1906	12									
		16									
		24									
	2507	24									
	2509	24									
 TN..	1103	04									
		08									
	1604	04						0,10 0,20 0,30	0,8 2,0 5,0		
		08	0,25 0,25 0,45	1,5 2,5 5,0	0,10 0,15 0,35	1,0 2,0 4,0	0,12 0,20 0,35	0,8 2,0 5,0			
		12	0,30 0,30 0,55	2,0 2,5 5,5							
		16									
	2204	04			0,10 0,15 0,35	1,0 2,0 4,0					
		08			0,13 0,20 0,40	1,5 2,5 4,0					
		12									
		16			0,15 0,25 0,45	2,0 2,5 4,5					
 VN..	1604	04			0,07 0,10 0,18	0,8 1,2 2,0					
		08			0,10 0,15 0,20	1,0 1,5 2,5					
		12			0,13 0,18 0,25	1,5 1,8 3,0					
 WN..	0604	04					0,1 0,22 0,35	0,5 1,0 3,0			
		08	0,25 0,30 0,45	1,5 2,0 4,0			0,1 0,22 0,35	0,5 1,0 3,0			
		12	0,30 0,35 0,50	2,0 2,5 4,5							
	0804	04					0,10 0,20 0,35	0,4 1,5 4,0			
		08	0,25 0,30 0,50	1,5 2,0 5,0	0,10 0,15 0,35	1,0 2,0 4,0	0,15 0,25 0,40	0,8 1,5 4,0			
		12	0,30 0,35 0,55	2,0 2,5 5,5	0,13 0,20 0,40	1,5 2,0 4,0	0,20 0,30 0,45	1,0 2,0 4,0			
		16									



The cited cutting data are recommended values. We recommend adjusting the values to the actual conditions.

Cutting data standard values for positive inserts

Indexable insert			-CF05		-SF		-CF55	
Form	Size	Radius	f mm/rev.	a _p mm	f mm/rev.	a _p mm	f mm/rev.	a _p mm
			min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.
 CC..	0602	00			0,02 0,035 0,05	0,1 0,4 1,5		
		01			0,02 0,035 0,05	0,2 0,4 1,5		
		02	0,03 0,08 0,12	0,1 0,3 1,3	0,03 0,10 0,15	0,2 0,4 1,5		
		04	0,05 0,10 0,12	0,1 0,3 1,3	0,05 0,10 0,20	0,2 0,6 1,5	0,05 0,12 0,22	0,2 0,5 1,3
		08			0,05 0,125 0,20	0,2 1,0 1,5		
	09T3	00			0,02 0,035 0,05	0,2 0,75 2,0		
		01			0,02 0,035 0,05	0,2 0,75 2,0		
		02	0,03 0,08 0,12	0,1 0,3 1,3	0,05 0,075 0,10	0,2 0,75 2,0		
		04	0,05 0,10 0,22	0,2 0,4 1,3	0,05 0,12 0,20	0,2 0,75 2,0	0,05 0,12 0,22	0,2 0,5 1,3
		08	0,06 0,13 0,25	0,2 0,4 1,3	0,05 0,125 0,25	0,4 1,0 2,0	0,06 0,15 0,25	0,2 0,5 1,3
		12						
	1204	02			0,05 0,075 0,10	0,2 0,8 2,5		
		04			0,05 0,12 0,20	0,2 1,0 2,5	0,05 0,12 0,22	0,2 0,5 1,3
		08			0,08 0,15 0,25	0,4 1,0 2,5		
		12			0,08 0,15 0,25	0,4 1,5 2,5		
 DC..	0702	005						
		01						
		015						
		02	0,03 0,08 0,12	0,1 0,3 1,3	0,03 0,10 0,15	0,1 0,4 1,5	0,03 0,10 0,12	0,1 0,4 1,3
		04	0,05 0,10 0,22	0,2 0,4 1,3	0,05 0,12 0,20	0,2 0,6 1,5	0,05 0,12 0,22	0,2 0,5 1,3
		08						
	11T3	005						
		01						
		015						
		02	0,03 0,08 0,12	0,1 0,3 1,3				
		04	0,05 0,10 0,22	0,2 0,4 1,3	0,05 0,12 0,20	0,2 0,7 2,0	0,05 0,12 0,22	0,2 0,5 1,3
 RC..	0602	MO						
		MO						
		MO						
		MO						
		MO						
		MO						
		MO						
		MO						
 SC..	09T3	04	0,05 0,10 0,22	0,2 0,4 1,3	0,05 0,12 0,20	0,2 0,7 2,0	0,05 0,12 0,22	0,2 0,5 1,3
		08	0,06 0,13 0,25	0,2 0,4 1,3	0,08 0,15 0,25	0,4 1,0 2,0	0,06 0,15 0,25	0,2 0,5 1,3
	1204	08			0,08 0,15 0,25	0,4 1,0 2,5		
		12						
 TC..	0902	04						
		02	0,03 0,08 0,12	0,1 0,3 1,3				
		04	0,05 0,10 0,22	0,2 0,4 1,3	0,05 0,12 0,20	0,2 0,7 2,0	0,05 0,12 0,22	0,2 0,5 1,3
	1102	04	0,05 0,10 0,22	0,2 0,4 1,3	0,08 0,15 0,25	0,4 1,0 2,0		
		08	0,06 0,13 0,25	0,2 0,4 1,3				
		02						
	16T3	04	0,05 0,10 0,22	0,2 0,4 1,3	0,05 0,12 0,20	0,2 0,8 2,5		
		08			0,08 0,15 0,25	0,4 1,0 2,5	0,06 0,15 0,25	0,2 0,5 1,3
		12						
 VC..	1103	005						
		01						
		015						
		02	0,03 0,06 0,12	0,1 0,3 1,3	0,02 0,08 0,15	0,1 0,4 1,5		
		04	0,05 0,08 0,22	0,2 0,4 1,3	0,05 0,10 0,20	0,2 0,6 1,5	0,05 0,10 0,22	0,2 0,5 1,3
		08			0,08 0,12 0,22	0,4 1,0 1,5		
	1604	02						
		04	0,05 0,08 0,22	0,2 0,4 1,3	0,05 0,10 0,20	0,2 0,7 2,0	0,05 0,10 0,22	0,2 0,5 1,3
		08	0,06 0,10 0,22	0,2 0,4 1,3	0,08 0,12 0,22	0,4 1,0 2,0	0,06 0,12 0,22	0,2 0,5 1,3
 WC..	0201	02			0,02 0,075 0,10	0,1 0,4 1,0		
		04			0,02 0,10 0,20	0,1 0,6 1,5		

Cutting data standard values for positive inserts

Indexable insert			-SMF		-SM		-SMQ	
Form	Size	Radius	f mm/rev.	a _p mm	f mm/rev.	a _p mm	f mm/rev.	a _p mm
			min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.
 CC..	0602	00						
		01						
		02			0,04 0,12 0,20	0,2 0,6 2,5		
		04	0,07 0,15 0,25	0,3 0,7 2,0	0,08 0,17 0,30	0,4 0,8 2,5		
		08	0,10 0,17 0,27	0,6 1,0 2,0	0,12 0,20 0,35	0,8 1,0 2,5		
	09T3	00						
		01						
		02						
		04	0,07 0,15 0,25	0,3 0,8 2,5	0,08 0,17 0,30	0,4 1,0 3,0	0,10 0,25 0,40	0,4 2,0 4,0
		08	0,10 0,17 0,27	0,6 1,0 2,5	0,12 0,20 0,35	0,8 1,2 3,0	0,15 0,30 0,50	0,8 2,0 4,0
		12			0,15 0,22 0,40	1,2 1,5 3,0		
	1204	02						
		04	0,07 0,15 0,25	0,3 1,0 3,0	0,08 0,17 0,30	0,4 1,2 3,5	0,10 0,25 0,40	0,4 2,0 4,0
		08	0,10 0,17 0,27	0,6 1,2 3,0	0,12 0,20 0,35	0,8 1,5 3,5	0,15 0,30 0,50	0,8 2,0 4,0
		12			0,15 0,22 0,40	1,2 2,0 3,5		
 DC..	0702	005						
		01						
		015						
		02			0,04 0,12 0,20	0,2 0,6 2,5		
		04	0,07 0,15 0,25	0,3 0,7 2,0	0,08 0,17 0,30	0,4 0,8 2,5	0,10 0,18 0,25	0,4 1,5 3,0
		08	0,10 0,17 0,27	0,6 1,0 2,0	0,12 0,20 0,30	0,8 1,0 2,5		
	11T3	005						
		01						
		015						
		02						
		04	0,07 0,15 0,25	0,3 0,8 2,5	0,80 0,17 0,30	0,4 1,0 3,0	0,10 0,25 0,40	0,4 2,0 4,0
		08	0,10 0,17 0,27	0,6 1,2 2,5	0,12 0,20 0,35	0,8 1,2 3,0	0,15 0,30 0,50	0,8 2,0 4,0
		12			0,15 0,22 0,40	1,2 1,7 3,0		
 RC..	0602	MO			0,20 0,30 0,50	0,2 0,5 1,5		
	0803	MO			0,20 0,30 0,60	0,2 0,6 2,0		
	1003	MO			0,25 0,40 0,70	0,2 0,7 2,5		
	1204	MO			0,30 0,50 0,80	0,2 0,8 3,0		
	1606	MO	0,15 0,30 0,60	0,25 2,0 3,5	0,40 0,60 1,00	0,3 1,0 3,5		
	2006	MO			0,50 0,80 1,20	0,4 1,2 4,0		
	2507	MO			0,60 0,90 1,40	0,6 2,0 5,0		
 SC..	09T3	04	0,07 0,15 0,25	0,3 0,8 2,5	0,08 0,17 0,30	0,4 1,0 3,0		
		08	0,10 0,17 0,27	0,6 1,0 2,5	0,12 0,20 0,35	0,8 1,2 3,0		
	1204	08	0,10 0,17 0,27	0,6 1,2 3,0	0,12 0,20 0,35	0,8 1,5 3,5		
		12			0,15 0,22 0,40	1,2 2,0 3,5		
 TC..	0902	04			0,08 0,12 0,20	0,4 0,8 2,0		
		02			0,08 0,10 0,20	0,4 0,6 3,0		
	1102	04			0,12 0,20 0,35	0,8 1,2 3,0		
		08	0,10 0,17 0,27	0,6 1,0 2,5	0,12 0,20 0,35	0,8 1,2 3,0		
	16T3	02						
		04	0,07 0,15 0,25	0,3 1,0 3,0	0,08 0,17 0,30	0,4 1,2 3,5		
		08	0,10 0,17 0,27	0,6 1,2 3,0	0,12 0,20 0,35	0,8 1,5 3,5		
		12			0,15 0,22 0,40	1,2 1,7 3,5		
	2204	08			0,12 0,20 0,35	0,8 2,5 6,0		
 VC..	1103	005						
		01						
		015						
		02	0,05 0,10 0,18	0,2 0,5 2,0				
		04	0,07 0,15 0,23	0,3 0,7 2,0				
	1604	02						
		04	0,07 0,15 0,23	0,3 0,8 2,5	0,08 0,17 0,25	0,4 1,0 3,0		
		08	0,10 0,17 0,27	0,6 1,0 2,5	0,12 0,20 0,30	0,8 1,2 3,0		
		12			0,15 0,22 0,32	1,2 1,5 3,0		
		2205	30					
 WC..	0201	02						
		04						

Cutting data standard values for positive inserts

Indexable insert			-M25		-M55		-F05	
Form	Size	Radius	f mm/rev.	a _p mm	f mm/rev.	a _p mm	f mm/rev.	a _p mm
			min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.
 CC..	0602	00						
		01					0,02 0,03 0,05	0,1 1,0 2,0
		02					0,02 0,05 0,10	0,1 1,0 2,0
		04	0,06 0,13 0,20	0,2 1,1 2,0	0,06 0,13 0,20	0,4 1,5 2,6	0,02 0,10 0,20	0,1 1,0 2,0
		08						
	09T3	00						
		01						
		02						
		04	0,06 0,14 0,22	0,2 1,2 2,2	0,08 0,16 0,24	0,4 1,7 3,0		
		08	0,10 0,20 0,30	0,4 1,8 3,2	0,12 0,24 0,35	0,8 2,4 4,0		
		12						
	1204	02						
		04			0,08 0,18 0,28	0,4 2,2 4,0		
		08			0,12 0,26 0,40	0,8 2,8 4,8		
		12						
 DC..	0702	005					0,02 0,025 0,04	0,1 1,0 2,0
		01					0,02 0,03 0,05	0,1 1,0 2,0
		015					0,02 0,04 0,075	0,1 1,0 2,0
		02	0,04 0,09 0,13	0,1 0,9 1,6			0,02 0,05 0,10	0,1 1,0 2,0
		04	0,06 0,12 0,18	0,2 1,1 2,0	0,06 0,14 0,22	0,4 1,3 2,2		
		08			0,08 0,16 0,24	0,8 1,6 2,4		
	11T3	005					0,02 0,025 0,04	0,1 1,25 2,5
		01					0,02 0,03 0,05	0,1 1,25 2,5
		015					0,02 0,04 0,075	0,1 1,25 2,5
		02	0,04 0,10 0,16	0,1 1,1 2,0			0,02 0,075 0,10	0,1 1,25 2,5
		04	0,06 0,14 0,22	0,2 1,2 2,2	0,08 0,16 0,24	0,4 1,7 3,0	0,02 0,10 0,25	0,1 1,25 2,5
		08	0,10 0,20 0,30	0,4 1,8 3,2	0,12 0,24 0,35	0,8 2,4 4,0		
		12						
 RC..	0602	MO						
	0803	MO						
	1003	MO						
	1204	MO						
	1606	MO						
	2006	MO						
	2507	MO						
 SC..	09T3	04			0,12 0,24 0,35	0,8 2,4 4,0		
		08			0,12 0,26 0,40	0,8 2,8 4,8		
	1204	08						
		12						
 TC..	0902	04			0,06 0,12 0,18	0,4 1,3 2,2		
		02						
	1102	04	0,06 0,13 0,20	0,2 1,2 2,2	0,06 0,14 0,22	0,4 1,4 2,4		
		08						
	16T3	02						
		04	0,06 0,14 0,22	0,2 1,6 3,0				
		08	0,10 0,20 0,30	0,4 1,9 3,4	0,12 0,24 0,35	0,8 2,6 4,4		
	2204	12						
		08						
 VC..	1103	005					0,02 0,025 0,04	0,1 1,25 2,5
		01					0,02 0,03 0,05	0,1 1,25 2,5
		015					0,02 0,04 0,075	0,1 1,25 2,5
		02					0,02 0,075 0,10	0,1 1,25 2,5
		04					0,02 0,15 0,25	0,1 1,25 2,5
	1604	08						
		02						
		04	0,06 0,13 0,20	0,2 1,2 2,2	0,08 0,14 0,20	0,4 1,7 3,0		
		08	0,10 0,15 0,25	0,4 1,4 3,0	0,12 0,21 0,30	0,8 2,1 3,4		
	2205	12						
		30						
 WC..	0201	02						
		04						

Cutting data standard values for negative inserts

Indexable insert			-CF20 (Cermet)		-F50		-TFQ	
Form	Size	Radius	f inch/rev.	a _p inch	f inch/rev.	a _p inch	f inch/rev.	a _p inch
			min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.
 CN..	0903	04			0.002 0.006 0.010	0.008 0.020 0.059		
		08			0.004 0.008 0.012	0.016 0.039 0.079		
	1204	04	0.002 0.006 0.010	0.012 0.020 0.059	0.002 0.006 0.010	0.008 0.024 0.059	0.004 0.006 0.014	0.016 0.039 0.118
		08	0.003 0.006 0.010	0.012 0.020 0.059	0.004 0.008 0.012	0.016 0.039 0.079	0.004 0.010 0.020	0.020 0.059 0.157
		12			0.006 0.010 0.014	0.024 0.055 0.102	0.006 0.012 0.028	0.031 0.079 0.197
		16						
	1606	08						
		12						
		16						
		24						
	1906	08						
		12						
		16						
	2509	24						
 DN..	1104	02			0.002 0.004 0.008	0.004 0.016 0.091		
		04	0.002 0.006 0.010	0.012 0.020 0.059	0.002 0.006 0.010	0.008 0.024 0.059		
		08	0.003 0.006 0.010	0.012 0.020 0.059	0.004 0.008 0.012	0.016 0.039 0.079		
		12			0.006 0.010 0.014	0.024 0.055 0.102		
	1504	04			0.002 0.006 0.010	0.008 0.024 0.059		
		08			0.004 0.008 0.012	0.016 0.039 0.079		
		12			0.006 0.010 0.014	0.024 0.055 0.102		
		16						
	1506	04	0.002 0.006 0.010	0.012 0.020 0.059	0.002 0.006 0.010	0.008 0.024 0.059	0.004 0.006 0.012	0.016 0.039 0.118
		08	0.003 0.006 0.010	0.012 0.020 0.059	0.004 0.008 0.012	0.016 0.039 0.079	0.004 0.010 0.016	0.020 0.059 0.157
		12	0.004 0.008 0.012	0.020 0.028 0.059	0.006 0.010 0.014	0.024 0.055 0.102	0.004 0.014 0.020	0.039 0.098 0.157
		16						
 SN..	0903	08			0.004 0.008 0.012	0.016 0.039 0.079		
		04			0.002 0.006 0.010	0.008 0.024 0.059		
	1204	08			0.004 0.008 0.012	0.016 0.039 0.079		
		12			0.006 0.010 0.014	0.024 0.055 0.102		
		16						
	1506	08						
		12						
		16						
	1906	12						
		24						
	2507	24						
	2509	24						
 TN..	1103	04			0.002 0.006 0.010	0.008 0.024 0.059		
		08			0.004 0.008 0.012	0.016 0.039 0.079		
	1604	04	0.002 0.006 0.010	0.012 0.020 0.059	0.002 0.006 0.010	0.008 0.024 0.059		
		08	0.003 0.006 0.010	0.012 0.020 0.059	0.004 0.008 0.012	0.016 0.039 0.079		
		12	0.004 0.008 0.012	0.020 0.028 0.059	0.006 0.010 0.014	0.024 0.055 0.102		
		16						
	2204	04						
		08						
		12						
		16						
 VN..	1604	04			0.002 0.006 0.010	0.008 0.024 0.059		
		08			0.004 0.008 0.012	0.016 0.039 0.079		
		12						
 WN..	0604	04	0.002 0.006 0.010	0.012 0.020 0.059	0.002 0.006 0.010	0.008 0.024 0.059	0.004 0.007 0.014	0.016 0.031 0.118
		08	0.003 0.006 0.010	0.012 0.020 0.059	0.004 0.008 0.012	0.016 0.039 0.079	0.004 0.008 0.020	0.020 0.059 0.118
		12						
	0804	04			0.002 0.006 0.010	0.008 0.024 0.059	0.004 0.006 0.014	0.016 0.039 0.118
		08	0.003 0.006 0.010	0.012 0.020 0.059	0.004 0.008 0.012	0.016 0.039 0.079	0.004 0.010 0.020	0.020 0.059 0.157
		12			0.006 0.010 0.014	0.024 0.055 0.102	0.006 0.012 0.028	0.031 0.079 0.197
		16						



The cited cutting data are recommended values. We recommend adjusting the values to the actual conditions.

Cutting data standard values for negative inserts

Indexable insert			-XU		-M50		-TMQ	
Form	Size	Radius	f inch/rev.	a _p inch	f inch/rev.	a _p inch	f inch/rev.	a _p inch
			min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.
 CN..	0903	04						
		08						
	1204	04	0.003 0.006 0.010	0.012 0.059 0.098	0.004 0.008 0.012	0.016 0.079 0.197		
		08	0.005 0.010 0.014	0.024 0.079 0.118	0.006 0.010 0.016	0.024 0.079 0.197	0.008 0.016 0.026	0.031 0.118 0.197
		12	0.006 0.012 0.018	0.035 0.079 0.138	0.008 0.012 0.020	0.039 0.079 0.197	0.010 0.020 0.033	0.039 0.118 0.236
		16			0.010 0.016 0.024	0.055 0.079 0.197		
	1606	08			0.006 0.010 0.016	0.024 0.118 0.315		
		12			0.008 0.012 0.020	0.039 0.118 0.315		
		16			0.010 0.016 0.024	0.055 0.118 0.315		
		24						
	1906	08						
		12						
		16						
 DN..	1104	02						
		04			0.004 0.008 0.012	0.016 0.059 0.157		
		08			0.006 0.010 0.016	0.024 0.059 0.157		
		12			0.008 0.012 0.020	0.039 0.059 0.157		
	1504	04			0.004 0.008 0.012	0.016 0.079 0.197		
		08			0.006 0.010 0.016	0.024 0.079 0.197		
		12			0.008 0.012 0.020	0.039 0.079 0.197		
		16			0.010 0.016 0.024	0.055 0.079 0.197		
	1506	04	0.003 0.006 0.010	0.012 0.059 0.098	0.004 0.008 0.012	0.016 0.079 0.197		
		08	0.005 0.010 0.014	0.024 0.079 0.118	0.006 0.010 0.016	0.024 0.079 0.197	0.006 0.012 0.020	0.031 0.098 0.197
		12	0.006 0.010 0.016	0.035 0.079 0.138	0.008 0.012 0.020	0.039 0.079 0.197	0.008 0.016 0.024	0.039 0.118 0.197
		16			0.010 0.016 0.024	0.055 0.079 0.197		
 SN..	0903	08						
		04						
	1204	08			0.006 0.010 0.016	0.024 0.079 0.197		
		12			0.008 0.012 0.020	0.039 0.079 0.197		
		16			0.010 0.016 0.024	0.055 0.079 0.197		
	1506	08			0.006 0.010 0.016	0.024 0.118 0.315		
		12			0.008 0.012 0.020	0.039 0.118 0.315		
		16			0.010 0.016 0.024	0.055 0.118 0.315		
	1906	12						
		16						
		24						
	2507	24						
 TN..	1103	04						
		08						
	1604	04			0.004 0.008 0.012	0.016 0.079 0.197		
		08			0.006 0.010 0.016	0.024 0.079 0.197		
		12			0.008 0.012 0.020	0.039 0.079 0.197		
	2204	04						
		08			0.006 0.010 0.016	0.024 0.118 0.315		
		12			0.008 0.012 0.020	0.039 0.118 0.315		
		16						
 VN..	1604	04	0.003 0.006 0.008	0.012 0.039 0.071	0.004 0.008 0.012	0.016 0.039 0.157		
		08	0.005 0.008 0.012	0.024 0.059 0.098	0.006 0.010 0.016	0.024 0.039 0.157		
		12			0.008 0.012 0.020	0.039 0.039 0.157		
 WN..	0604	04			0.004 0.008 0.012	0.016 0.039 0.118		
		08			0.006 0.010 0.016	0.024 0.039 0.118		
		12			0.008 0.012 0.020	0.039 0.039 0.118		
	0804	04	0.003 0.006 0.010	0.012 0.059 0.098	0.004 0.008 0.012	0.016 0.059 0.157		
		08	0.005 0.009 0.014	0.024 0.079 0.118	0.006 0.010 0.016	0.024 0.059 0.157	0.008 0.012 0.026	0.031 0.118 0.197
		12	0.006 0.010 0.018	0.035 0.079 0.138	0.008 0.012 0.020	0.039 0.059 0.157	0.010 0.016 0.033	0.039 0.118 0.236
		16			0.010 0.016 0.024	0.055 0.059 0.157		



→ Here you will find a detailed chip groove description.

Cutting data standard values for negative inserts

Indexable insert			-M70			-R28			-R58		
Form	Size	Radius	f inch/rev.	a _p inch	min. – Recommended – max.	f inch/rev.	a _p inch	min. – Recommended – max.	f inch/rev.	a _p inch	min. – Recommended – max.
			min. – Recommended – max.	min. – Recommended – max.		min. – Recommended – max.	min. – Recommended – max.		min. – Recommended – max.	min. – Recommended – max.	
 CN..	0903	04									
		08									
	1204	04									
		08	0.008 0.012 0.018	0.031 0.118 0.236		0.010 0.014 0.022	0.031 0.118 0.276		0.010 0.018 0.028	0.039 0.118 0.276	
		12	0.010 0.016 0.024	0.047 0.118 0.236		0.012 0.018 0.028	0.039 0.118 0.276		0.012 0.022 0.033	0.059 0.118 0.276	
		16	0.012 0.018 0.028	0.063 0.118 0.236		0.012 0.024 0.035	0.059 0.118 0.276		0.014 0.026 0.039	0.079 0.118 0.276	
	1606	08	0.008 0.012 0.018	0.031 0.157 0.315							
		12	0.010 0.016 0.024	0.047 0.157 0.315		0.012 0.018 0.028	0.039 0.157 0.354		0.012 0.022 0.033	0.059 0.157 0.354	
		16	0.012 0.018 0.028	0.063 0.157 0.315		0.014 0.024 0.035	0.059 0.157 0.354		0.014 0.026 0.039	0.079 0.157 0.354	
	1906	08	0.008 0.012 0.018	0.031 0.177 0.354							
		12	0.010 0.016 0.024	0.047 0.177 0.354		0.012 0.018 0.028	0.039 0.217 0.472		0.014 0.022 0.033	0.059 0.217 0.472	
		16	0.012 0.018 0.028	0.063 0.177 0.354		0.014 0.024 0.035	0.059 0.217 0.472		0.016 0.026 0.039	0.079 0.217 0.472	
 DN..	1104	02									
		04									
		08	0.008 0.010 0.018	0.031 0.079 0.197							
	1504	04									
		08	0.008 0.010 0.018	0.031 0.098 0.236							
		12	0.010 0.014 0.024	0.047 0.098 0.236							
	1506	04									
		08	0.008 0.010 0.018	0.031 0.098 0.236							
		12	0.010 0.014 0.024	0.047 0.098 0.236		0.010 0.018 0.028	0.039 0.098 0.236		0.012 0.020 0.031	0.059 0.098 0.236	
	2509	04									
		08	0.008 0.010 0.018	0.031 0.098 0.236		0.010 0.018 0.028	0.039 0.098 0.236		0.012 0.020 0.031	0.059 0.098 0.236	
		16	0.012 0.016 0.028	0.063 0.098 0.236		0.012 0.024 0.033	0.059 0.098 0.236		0.014 0.024 0.035	0.079 0.098 0.236	
 SN..	0903	08									
		04									
	1204	08	0.008 0.012 0.020	0.031 0.118 0.236					0.010 0.018 0.028	0.039 0.118 0.276	
		12	0.010 0.016 0.026	0.047 0.118 0.236					0.012 0.022 0.033	0.059 0.118 0.276	
		16	0.012 0.018 0.028	0.063 0.118 0.236							
	1506	08									
		12	0.010 0.016 0.026	0.047 0.157 0.315		0.012 0.014 0.028	0.039 0.157 0.354		0.012 0.022 0.033	0.059 0.157 0.354	
		16	0.012 0.018 0.030	0.063 0.157 0.315		0.014 0.024 0.035	0.059 0.157 0.354		0.014 0.026 0.039	0.079 0.157 0.354	
	1906	08									
		12	0.010 0.016 0.026	0.047 0.177 0.354					0.014 0.022 0.033	0.059 0.217 0.472	
		16	0.012 0.018 0.030	0.063 0.177 0.354		0.014 0.024 0.035	0.059 0.217 0.472		0.016 0.026 0.039	0.079 0.217 0.472	
 TN..	1103	04									
		08									
		12									
	1604	08	0.008 0.010 0.018	0.031 0.098 0.236							
		12	0.010 0.014 0.024	0.047 0.098 0.236							
		16									
	2204	04	0.006 0.008 0.012	0.016 0.118 0.276							
		08	0.008 0.010 0.018	0.031 0.118 0.276							
		12	0.010 0.014 0.024	0.047 0.118 0.276					0.012 0.020 0.031	0.059 0.118 0.276	
	2509	04									
		08	0.008 0.010 0.018	0.031 0.098 0.236		0.012 0.022 0.033	0.059 0.118 0.276				
		16	0.012 0.016 0.028	0.063 0.118 0.276		0.012 0.022 0.033	0.059 0.118 0.276				
 VN..	0604	04									
		08	0.008 0.012 0.018	0.031 0.079 0.157							
		12	0.010 0.016 0.024	0.047 0.079 0.157							
	0804	04									
		08	0.008 0.012 0.018	0.031 0.098 0.197							
		12	0.010 0.016 0.024	0.047 0.098 0.197							
	1604	04									
		08									
		12									
 WN..	0604	04									
		08	0.008 0.012 0.018	0.031 0.079 0.157							
		12	0.010 0.016 0.024	0.047 0.079 0.157							
	0804	04									
		08	0.008 0.012 0.018	0.031 0.098 0.197							
		12	0.010 0.016 0.024	0.047 0.098 0.197							
	1604	04									
		08									
		12									



The cited cutting data are recommended values. We recommend adjusting the values to the actual conditions.

Cutting data standard values for negative inserts

Indexable insert			-R88		-F30		-M30	
Form	Size	Radius	f inch/rev.	a _p inch	f inch/rev.	a _p inch	f inch/rev.	a _p inch
			min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.
 CN..	0903	04						
		08						
	1204	04			0.002 0.006 0.010	0.016 0.039 0.079		
		08			0.004 0.009 0.014	0.031 0.059 0.098	0.006 0.010 0.016	0.039 0.079 0.177
		12					0.008 0.012 0.020	0.047 0.098 0.197
		16					0.010 0.014 0.022	0.063 0.098 0.197
	1606	08						
		12						
		16						
	1906	24	0.016 0.028 0.047	0.079 0.197 0.354				
		08						
		12						
	2509	16	0.016 0.028 0.039	0.079 0.197 0.472				
		24	0.016 0.028 0.047	0.079 0.197 0.472				
		24	0.024 0.039 0.059	0.138 0.394 0.709				
 DN..	1104	02						
		04			0.002 0.006 0.010	0.016 0.039 0.079		
		08			0.004 0.008 0.014	0.031 0.059 0.098	0.006 0.010 0.016	0.039 0.079 0.177
		12					0.008 0.012 0.020	0.047 0.079 0.177
	1504	04			0.002 0.006 0.010	0.016 0.039 0.079		
		08			0.004 0.008 0.014	0.031 0.059 0.098	0.006 0.010 0.014	0.039 0.098 0.157
		12					0.008 0.012 0.020	0.039 0.098 0.157
		16						
	1506	04			0.002 0.006 0.010	0.016 0.039 0.079		
		08			0.004 0.008 0.014	0.031 0.059 0.098	0.006 0.010 0.016	0.039 0.079 0.217
		12					0.008 0.012 0.020	0.047 0.079 0.217
		16						
 SN..	0903	08						
		04			0.004 0.006 0.012	0.016 0.039 0.079		
	1204	08			0.006 0.008 0.016	0.031 0.059 0.098	0.008 0.010 0.018	0.039 0.079 0.177
		12			0.006 0.008 0.016	0.047 0.071 0.098	0.010 0.012 0.020	0.047 0.079 0.197
		16						
	1506	08						
		12						
		16						
	1906	16	0.016 0.028 0.039	0.079 0.197 0.472				
		24	0.016 0.028 0.047	0.079 0.197 0.472				
		24	0.024 0.039 0.059	0.138 0.394 0.709				
	2509	24	0.024 0.039 0.059	0.138 0.394 0.709				
 TN..	1103	04						
		08						
	1604	04			0.002 0.006 0.010	0.016 0.039 0.079		
		08			0.004 0.006 0.014	0.031 0.059 0.098	0.006 0.010 0.016	0.039 0.079 0.177
		12					0.008 0.012 0.020	0.047 0.079 0.177
		16						
	2204	04						
		08						
		12						
		16						
 VN..	1604	04			0.003 0.004 0.008	0.016 0.039 0.079		
		08			0.004 0.006 0.012	0.031 0.059 0.098	0.006 0.010 0.016	0.039 0.059 0.157
		12						
 WN..	0604	04			0.002 0.006 0.010	0.016 0.039 0.079		
		08			0.004 0.008 0.012	0.031 0.059 0.098	0.006 0.010 0.016	0.039 0.059 0.138
		12					0.008 0.012 0.018	0.047 0.059 0.157
	0804	04			0.002 0.006 0.010	0.016 0.039 0.079		
		08			0.004 0.008 0.014	0.031 0.059 0.098	0.006 0.010 0.016	0.039 0.079 0.177
		12					0.008 0.012 0.020	0.047 0.079 0.197
		16						
		16						



→ Here you will find a detailed chip groove description.

Cutting data standard values for negative inserts

Indexable insert			-M60			-M34			-M42											
Form	Size	Radius	f			a _p			f			a _p								
			inch/rev.			inch			inch/rev.			inch								
			min. – Recommended – max.	min. – Recommended – max.		min. – Recommended – max.		min. – Recommended – max.		min. – Recommended – max.		min. – Recommended – max.								
 CN..	0903	04																		
		08																		
	1204	04					0.003	0.005	0.007	0.039	0.059	0.118	0.004	0.008	0.010	0.031	0.059	0.157		
		08	0.010	0.012	0.020	0.059	0.098	0.236	0.004	0.006	0.014	0.039	0.071	0.138	0.008	0.012	0.017	0.039	0.098	0.157
		12	0.012	0.014	0.022	0.079	0.118	0.236	0.005	0.008	0.016	0.059	0.079	0.157	0.011	0.014	0.022	0.047	0.118	0.165
		16	0.012	0.016	0.024	0.079	0.118	0.236	0.006	0.010	0.018	0.079	0.118	0.177						
	1606	08																		
		12	0.012	0.014	0.022	0.079	0.118	0.315												
		16																		
	1906	08																		
		12																		
		16																		
	2509	24																		
 DN..	1104	02																		
		04											0.006	0.010	0.012	0.039	0.079	0.138		
		08													0.008	0.012	0.016	0.047	0.098	0.157
		12																		
	1504	04					0.003	0.005	0.007	0.031	0.047	0.098	0.006	0.010	0.014	0.039	0.079	0.157		
		08	0.010	0.012	0.018	0.059	0.098	0.236	0.004	0.006	0.012	0.039	0.071	0.138	0.008	0.012	0.016	0.047	0.098	0.197
		12	0.012	0.016	0.022	0.059	0.098	0.236	0.005	0.008	0.015	0.059	0.079	0.157						
		16																		
	1506	04											0.006	0.010	0.014	0.039	0.079	0.157		
		08	0.010	0.012	0.018	0.059	0.098	0.236	0.004	0.006	0.012	0.039	0.071	0.138	0.008	0.012	0.017	0.047	0.098	0.197
		12	0.012	0.016	0.022	0.059	0.098	0.236	0.005	0.008	0.015	0.059	0.079	0.157						
		16																		
	 SN..	0903	08																	
04																				
1204		08	0.012	0.014	0.020	0.059	0.079	0.236	0.006	0.010	0.016	0.039	0.079	0.157	0.006	0.010	0.016	0.039	0.079	0.177
		12	0.012	0.016	0.022	0.079	0.098	0.236	0.006	0.010	0.018	0.059	0.098	0.177	0.008	0.010	0.018	0.039	0.079	0.197
		16	0.012	0.016	0.024	0.079	0.098	0.236												
		08																		
1506		12																		
		16																		
		12																		
1906		16																		
		24																		
		2507	24																	
2509		24																		
 TN..	1103	04																		
		08																		
	1604	04											0.004	0.008	0.012	0.031	0.079	0.197		
		08	0.010	0.010	0.018	0.059	0.098	0.197	0.004	0.006	0.014	0.039	0.079	0.157	0.005	0.008	0.014	0.031	0.079	0.197
		12	0.012	0.012	0.022	0.079	0.098	0.217												
		16																		
	2204	04					0.004	0.006	0.014	0.039	0.079	0.157								
		08					0.005	0.008	0.016	0.059	0.098	0.157								
		12																		
		16					0.006	0.010	0.018	0.079	0.098	0.177								
 VN..	1604	04					0.003	0.004	0.007	0.031	0.047	0.079								
		08					0.004	0.006	0.008	0.039	0.059	0.098								
		12					0.005	0.007	0.010	0.059	0.071	0.118								
 WN..	0604	04											0.004	0.009	0.014	0.020	0.039	0.118		
		08	0.010	0.012	0.018	0.059	0.079	0.157					0.004	0.009	0.014	0.020	0.039	0.118		
		12	0.012	0.014	0.020	0.079	0.098	0.177												
	0804	04											0.004	0.008	0.014	0.016	0.059	0.157		
		08	0.010	0.012	0.020	0.059	0.079	0.197	0.004	0.006	0.014	0.039	0.079	0.157	0.006	0.010	0.016	0.031	0.059	0.157
		12	0.012	0.014	0.022	0.079	0.098	0.217	0.005	0.008	0.016	0.059	0.079	0.157	0.008	0.012	0.018	0.039	0.079	0.157
		16																		



The cited cutting data are recommended values. We recommend adjusting the values to the actual conditions.

Cutting data standard values for positive inserts

Indexable insert			-CF05		-SF		-CF55	
Form	Size	Radius	f inch/rev.	a _p inch	f inch/rev.	a _p inch	f inch/rev.	a _p inch
			min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.
 CC..	0602	00			0.001 0.001 0.002	0.004 0.016 0.059		
		01			0.001 0.001 0.002	0.008 0.016 0.059		
		02	0.001 0.003 0.005	0.004 0.012 0.051	0.001 0.004 0.006	0.008 0.016 0.059		
		04	0.002 0.004 0.005	0.004 0.012 0.051	0.002 0.004 0.008	0.008 0.024 0.059	0.002 0.005 0.009	0.008 0.020 0.051
		08			0.002 0.005 0.008	0.008 0.039 0.059		
	09T3	00			0.001 0.001 0.002	0.008 0.030 0.079		
		01			0.001 0.001 0.002	0.008 0.030 0.079		
		02	0.001 0.003 0.005	0.004 0.012 0.051	0.002 0.003 0.004	0.008 0.030 0.079		
		04	0.002 0.004 0.009	0.008 0.016 0.051	0.002 0.005 0.008	0.008 0.030 0.079	0.002 0.005 0.009	0.008 0.020 0.051
		08	0.002 0.005 0.010	0.008 0.016 0.051	0.002 0.005 0.010	0.016 0.039 0.079	0.002 0.006 0.010	0.008 0.020 0.051
	1204	02			0.002 0.003 0.004	0.008 0.031 0.098		
		04			0.002 0.005 0.008	0.008 0.039 0.098	0.002 0.005 0.009	0.008 0.020 0.051
		08			0.003 0.006 0.010	0.016 0.039 0.098		
		12			0.003 0.006 0.010	0.016 0.059 0.098		
 DC..	0702	005						
		01						
		015						
		02	0.001 0.003 0.005	0.004 0.012 0.051	0.001 0.004 0.006	0.004 0.016 0.059	0.001 0.004 0.005	0.004 0.016 0.051
		04	0.002 0.004 0.009	0.008 0.016 0.051	0.002 0.005 0.008	0.008 0.024 0.059	0.002 0.005 0.009	0.008 0.020 0.051
	11T3	005						
		01						
		015						
		02	0.001 0.003 0.005	0.004 0.012 0.051				
		04	0.002 0.004 0.009	0.008 0.016 0.051	0.002 0.005 0.008	0.008 0.028 0.079	0.002 0.005 0.009	0.008 0.020 0.051
 RC..	0602	MO						
		MO						
		MO						
		MO						
		MO						
		MO						
		MO						
		MO						
 SC..	09T3	04	0.002 0.004 0.009	0.008 0.016 0.051	0.002 0.005 0.008	0.008 0.028 0.079	0.002 0.005 0.009	0.008 0.020 0.051
		08	0.002 0.005 0.010	0.008 0.016 0.051	0.003 0.006 0.010	0.016 0.039 0.079	0.002 0.006 0.010	0.008 0.020 0.051
	1204	08			0.003 0.006 0.010	0.016 0.039 0.098		
		12						
 TC..	0902	04						
		02	0.001 0.003 0.005	0.004 0.012 0.051				
		04	0.002 0.004 0.009	0.008 0.016 0.051	0.002 0.005 0.008	0.008 0.028 0.079	0.002 0.005 0.009	0.008 0.020 0.051
	1102	04	0.002 0.004 0.009	0.008 0.016 0.051	0.002 0.005 0.008	0.008 0.028 0.079	0.002 0.005 0.009	0.008 0.020 0.051
		08	0.002 0.005 0.010	0.008 0.016 0.051	0.003 0.006 0.010	0.016 0.039 0.079		
	16T3	02						
		04	0.002 0.004 0.009	0.008 0.016 0.051	0.002 0.005 0.008	0.008 0.031 0.098		
		08			0.003 0.006 0.010	0.016 0.039 0.098	0.002 0.006 0.010	0.008 0.020 0.051
 VC..	1103	005						
		01						
		015						
		02	0.001 0.002 0.005	0.004 0.012 0.051	0.001 0.003 0.006	0.004 0.016 0.059		
		04	0.002 0.003 0.009	0.008 0.016 0.051	0.002 0.004 0.008	0.008 0.024 0.059	0.002 0.004 0.009	0.008 0.020 0.051
	1604	08			0.003 0.005 0.009	0.016 0.039 0.059		
		02						
		04	0.002 0.003 0.009	0.008 0.016 0.051	0.002 0.004 0.008	0.008 0.028 0.079	0.002 0.004 0.009	0.008 0.020 0.051
		08	0.002 0.004 0.009	0.008 0.016 0.051	0.003 0.005 0.009	0.016 0.039 0.079	0.002 0.005 0.009	0.008 0.020 0.051
		12						
 WC..	0201	02			0.001 0.003 0.004	0.004 0.016 0.039		
		04			0.001 0.004 0.008	0.004 0.024 0.059		

Cutting data standard values for positive inserts

Indexable insert			-SMF		-SM		-SMQ	
Form	Size	Radius	f inch/rev.	a _p inch	f inch/rev.	a _p inch	f inch/rev.	a _p inch
			min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.
 CC..	0602	00						
		01						
		02			0.002 0.005 0.008	0.008 0.024 0.098		
		04	0.003 0.006 0.010	0.012 0.028 0.079	0.003 0.007 0.012	0.016 0.031 0.098		
		08	0.004 0.007 0.011	0.024 0.039 0.079	0.005 0.008 0.014	0.031 0.039 0.098		
	09T3	00						
		01						
		02						
		04	0.003 0.006 0.010	0.012 0.031 0.098	0.003 0.007 0.012	0.016 0.039 0.118	0.004 0.010 0.016	0.016 0.079 0.157
		08	0.004 0.007 0.011	0.024 0.039 0.098	0.005 0.008 0.014	0.031 0.047 0.118	0.006 0.012 0.020	0.031 0.079 0.157
		12			0.006 0.009 0.016	0.047 0.059 0.118		
	1204	02						
		04	0.003 0.006 0.010	0.012 0.039 0.118	0.003 0.007 0.012	0.016 0.047 0.138	0.004 0.010 0.016	0.016 0.079 0.157
		08	0.004 0.007 0.011	0.024 0.047 0.118	0.005 0.008 0.014	0.031 0.059 0.138	0.006 0.012 0.020	0.031 0.079 0.157
		12			0.006 0.009 0.016	0.047 0.079 0.138		
 DC..	0702	005						
		01						
		015						
		02			0.002 0.005 0.008	0.008 0.024 0.098		
		04	0.003 0.006 0.010	0.012 0.028 0.079	0.003 0.007 0.012	0.016 0.031 0.098	0.004 0.007 0.010	0.016 0.059 0.118
		08	0.004 0.007 0.011	0.024 0.039 0.079	0.005 0.008 0.012	0.031 0.039 0.098		
	11T3	005						
		01						
		015						
		02						
		04	0.003 0.006 0.010	0.012 0.031 0.098	0.031 0.007 0.012	0.016 0.039 0.118	0.004 0.010 0.016	0.016 0.079 0.157
		08	0.004 0.007 0.011	0.024 0.047 0.098	0.005 0.008 0.014	0.031 0.047 0.118	0.006 0.012 0.020	0.031 0.079 0.157
		12			0.006 0.009 0.016	0.047 0.067 0.118		
	1204	02						
		04	0.003 0.006 0.010	0.012 0.031 0.098	0.031 0.007 0.012	0.016 0.039 0.118	0.004 0.010 0.016	0.016 0.079 0.157
		08	0.004 0.007 0.011	0.024 0.047 0.098	0.005 0.008 0.014	0.031 0.047 0.118	0.006 0.012 0.020	0.031 0.079 0.157
 RC..	0602	MO			0.008 0.012 0.020	0.008 0.020 0.059		
	0803	MO			0.008 0.012 0.024	0.008 0.024 0.079		
	1003	MO			0.010 0.016 0.028	0.008 0.028 0.098		
	1204	MO			0.012 0.020 0.031	0.008 0.031 0.118		
	1606	MO	0.006 0.012 0.024	0.010 0.079 0.138	0.016 0.024 0.039	0.012 0.039 0.138		
	2006	MO			0.020 0.031 0.047	0.016 0.047 0.157		
	2507	MO			0.024 0.035 0.055	0.024 0.079 0.197		
 SC..	09T3	04	0.003 0.006 0.010	0.012 0.031 0.098	0.003 0.007 0.012	0.016 0.039 0.118		
		08	0.004 0.007 0.011	0.024 0.039 0.098	0.005 0.008 0.014	0.031 0.047 0.118		
	1204	08	0.004 0.007 0.011	0.024 0.047 0.118	0.005 0.008 0.014	0.031 0.059 0.138		
		12			0.006 0.009 0.016	0.047 0.079 0.138		
 TC..	0902	04			0.003 0.005 0.008	0.016 0.031 0.079		
		02			0.003 0.004 0.008	0.016 0.024 0.118		
	1102	04			0.005 0.008 0.014	0.031 0.047 0.118		
		08	0.004 0.007 0.011	0.024 0.039 0.098	0.005 0.008 0.014	0.031 0.047 0.118		
	16T3	02						
		04	0.003 0.006 0.010	0.012 0.039 0.118	0.003 0.007 0.012	0.016 0.047 0.138		
		08	0.004 0.007 0.011	0.024 0.047 0.118	0.005 0.008 0.014	0.031 0.059 0.138		
		12			0.006 0.009 0.016	0.047 0.067 0.138		
	2204	08			0.005 0.008 0.014	0.031 0.098 0.236		
 VC..	1103	005						
		01						
		015						
		02	0.002 0.004 0.007	0.008 0.020 0.079				
		04	0.003 0.006 0.009	0.012 0.028 0.079				
	1604	02						
		04	0.003 0.006 0.009	0.012 0.031 0.098	0.003 0.007 0.010	0.016 0.039 0.118		
		08	0.004 0.007 0.011	0.024 0.039 0.098	0.005 0.008 0.012	0.031 0.047 0.118		
		12			0.006 0.009 0.013	0.047 0.059 0.118		
	2205	30						
 WC..	0201	02						
		04						

Cutting data standard values for positive inserts

Indexable insert			-M25		-M55		-F05	
Form	Size	Radius	f inch/rev.	a _p inch	f inch/rev.	a _p inch	f inch/rev.	a _p inch
			min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.	min. – Recommended – max.
 CC..	0602	00						
		01					0.001 0.001	0.002 0.004 0.039 0.079
		02					0.001 0.002	0.004 0.004 0.039 0.079
		04	0.002 0.005 0.008	0.008 0.043 0.079	0,06 0.002 0.005	0.008 0.016 0.059	0.102 0.001 0.004	0.008 0.004 0.039 0.079
		08						
	09T3	00						
		01						
		02						
		04	0.002 0.006 0.009	0.008 0.047 0.087	0,08 0.003 0.006	0.009 0.016 0.067	0.118	
		08	0.004 0.008 0.012	0.016 0.071 0.126	0,12 0.005 0.009	0.014 0.031 0.094	0.157	
		12						
	1204	02						
		04			0,08 0.003 0.007	0.011 0.016 0.087	0.157	
		08			0,12 0.005 0.010	0.016 0.031 0.110	0.189	
		12						
 DC..	0702	005					0.001 0.001	0.002 0.004 0.039 0.079
		01					0.001 0.001	0.002 0.004 0.039 0.079
		015					0.001 0.002	0.003 0.004 0.039 0.079
		02	0.002 0.004 0.005	0.004 0.035 0.063			0.001 0.002	0.004 0.004 0.039 0.079
		04	0.002 0.005 0.007	0.008 0.043 0.079	0,06 0.002 0.006	0.009 0.016 0.051	0.087	
		08			0,08 0.003 0.006	0.009 0.031 0.063	0.094	
	11T3	005					0.001 0.001	0.002 0.004 0.049 0.098
		01					0.001 0.001	0.002 0.004 0.049 0.098
		015					0.001 0.002	0.003 0.004 0.049 0.098
		02	0.002 0.004 0.006	0.004 0.043 0.079			0.001 0.003	0.004 0.004 0.049 0.098
		04	0.002 0.006 0.009	0.008 0.047 0.087	0,08 0.003 0.006	0.009 0.016 0.067	0.118 0.001 0.004	0.010 0.004 0.049 0.098
		08	0.004 0.008 0.012	0.016 0.071 0.126	0,12 0.005 0.009	0.014 0.031 0.094	0.157	
		12						
 RC..	0602	MO						
	0803	MO						
	1003	MO						
	1204	MO						
	1606	MO						
	2006	MO						
	2507	MO						
 SC..	09T3	04			0,12 0.005 0.009	0.014 0.031 0.094	0.157	
		08			0,12 0.005 0.010	0.016 0.031 0.110	0.189	
	1204	08						
		12						
 TC..	0902	04			0,06 0.002 0.005	0.007 0.016 0.051	0.087	
		02						
	1102	04	0.002 0.005 0.008	0.008 0.047 0.087	0,06 0.002 0.006	0.009 0.016 0.055	0.094	
		08						
	16T3	02						
		04	0.002 0.006 0.009	0.008 0.063 0.118				
		08	0.004 0.008 0.012	0.016 0.075 0.134	0,12 0.005 0.009	0.014 0.031 0.102	0.173	
	2204	08						
 VC..	1103	005					0.001 0.001	0.002 0.004 0.049 0.098
		01					0.001 0.001	0.002 0.004 0.049 0.098
		015					0.001 0.002	0.003 0.004 0.049 0.098
		02					0.001 0.003	0.004 0.004 0.049 0.098
		04					0.001 0.006	0.010 0.004 0.049 0.098
	1604	02						
		04	0.002 0.005 0.008	0.008 0.047 0.087	0,08 0.003 0.006	0.008 0.016 0.067	0.118	
		08	0.004 0.006 0.010	0.016 0.055 0.118	0,12 0.005 0.008	0.012 0.031 0.083	0.134	
		12						
	2205	30						
 WC..	0201	02						
		04						

Cutting data standard values for CB chip breaker geometries

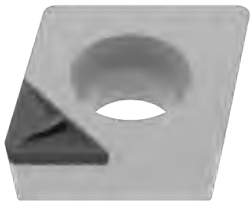
-CB1



3D chip breaker geometries -CB1				
Cutting radius (in mm)	a_p in mm		f_z mm/rev.	
	min.	max.	min.	max.
0,1	0,05	0,30	0,02	0,05
0,2	0,06	0,40	0,03	0,08
0,4	0,10	0,80	0,04	0,15
0,8	0,15	1,00	0,08	0,20
1,2	0,30	1,50	0,12	0,25

- ▲ Finish and super finish
- ▲ Extremely sharp cutting edge geometry
- ▲ Cutting depth a_p : 0.05–1.5 mm
- ▲ Lowest cutting pressure for highest precision
- ▲ For machining thin-walled and unstable workpieces

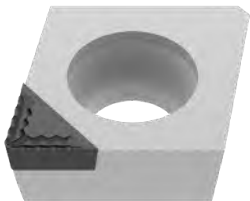
-CB2



3D chip breaker geometries -CB2				
Cutting radius (in mm)	a_p in mm		f_z mm/rev.	
	min.	max.	min.	max.
0,2	0,50	0,80	0,08	0,12
0,4	0,60	1,50	0,08	0,20
0,8	0,70	1,50	0,15	0,30
1,2	0,80	2,00	0,20	0,40

- ▲ Semi-finish and finish machining
- ▲ Slightly negative cutting edge geometry
- ▲ Cutting depth a_p : 0.5–2.0 mm
- ▲ High surface quality with the tightest tolerances
- ▲ For machining solid workpieces and under stable conditions

-CB3



3D chip breaker geometries -CB3				
Cutting radius (in mm)	a_p in mm		f_z mm/rev.	
	min.	max.	min.	max.
0,4	1,00	3,00	0,10	0,20
0,8	1,00	3,00	0,15	0,35

- ▲ Medium and rough machining
- ▲ Highly aggressive chip breaker
- ▲ Cutting depth a_p : 1.0–3.0 mm
- ▲ Stable component conditions necessary
- ▲ Cooling must be ensured

Cutting data standard values for CB chip breaker geometries

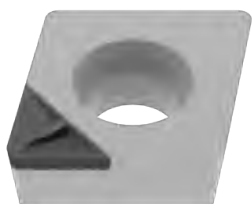
-CB1



3D chip breaker geometries -CB1				
Cutting radius (in inch)	a_p in inch		f_z in inch/rev.	
	min.	max.	min.	max.
0.004	0.002	0.012	0.001	0.002
0.008	0.002	0.016	0.001	0.003
0.016	0.004	0.031	0.002	0.006
0.032	0.006	0.039	0.003	0.008
0.064	0.012	0.059	0.005	0.010

- ▲ Finish and super finish
- ▲ Extremely sharp cutting edge geometry
- ▲ Cutting depth a_p : 0.002-0.06 inch
- ▲ Lowest cutting pressure for highest precision
- ▲ For machining thin-walled and unstable workpieces

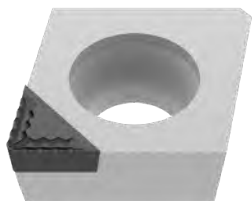
-CB2



3D chip breaker geometries -CB2				
Cutting radius (in inch)	a_p in inch		f_z in inch/rev.	
	min.	max.	min.	max.
0.008	0.020	0.031	0.003	0.005
0.016	0.024	0.059	0.003	0.008
0.032	0.028	0.059	0.006	0.012
0.064	0.031	0.079	0.008	0.016

- ▲ Semi-finish and finish machining
- ▲ Slightly negative cutting edge geometry
- ▲ Cutting depth a_p : 0.020-0.078 inch
- ▲ High surface quality with the tightest tolerances
- ▲ For machining solid workpieces and under stable conditions

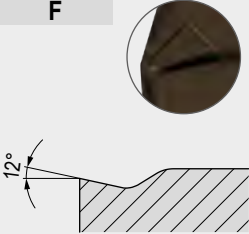
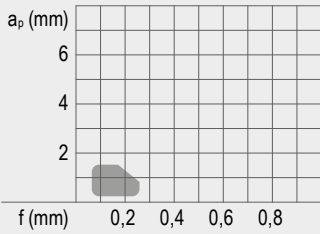
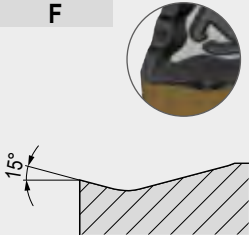
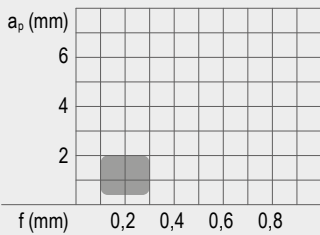
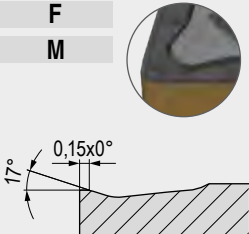
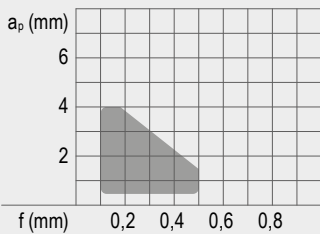
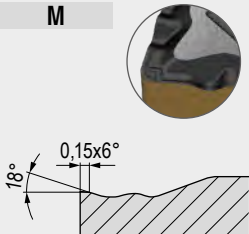
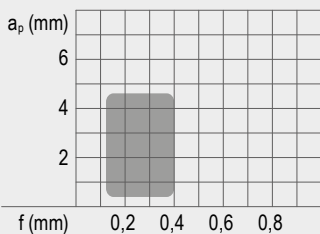
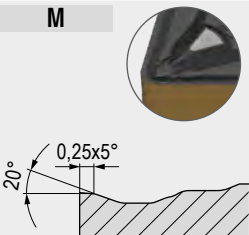
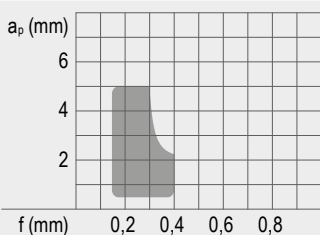
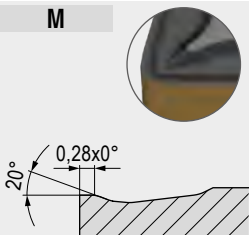
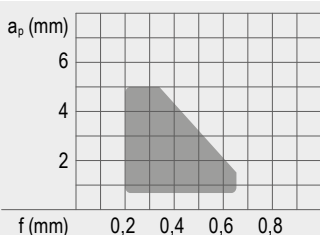
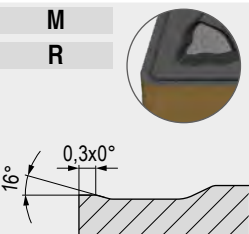
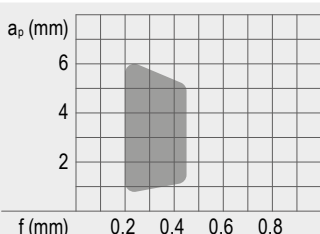
-CB3



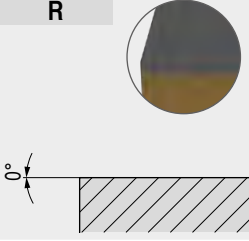
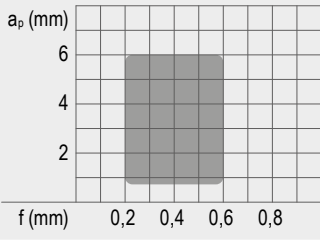
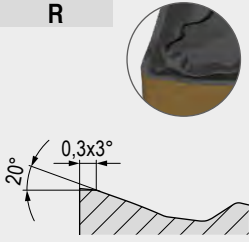
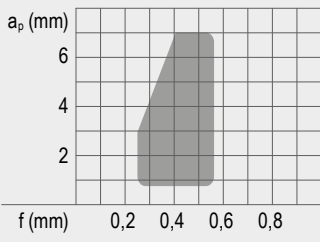
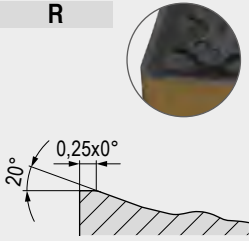
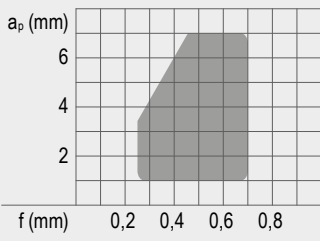
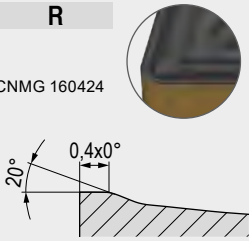
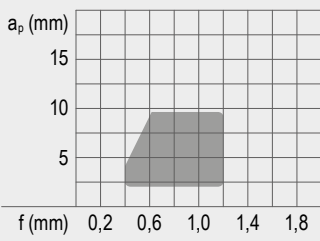
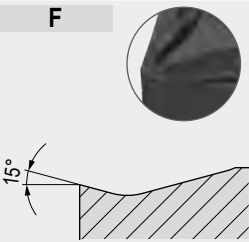
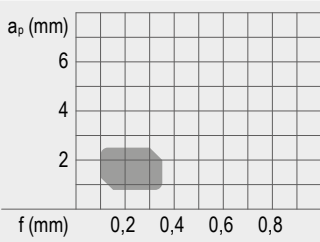
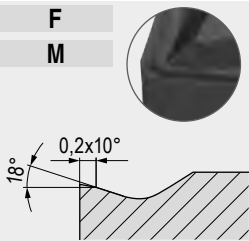
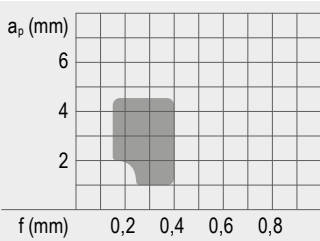
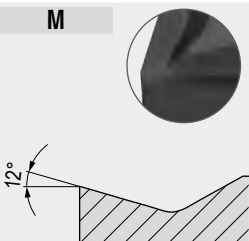
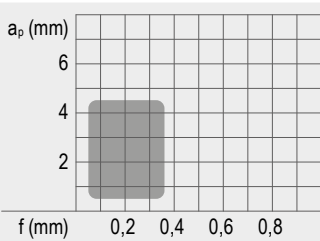
3D chip breaker geometries -CB3				
Cutting radius (in inch)	a_p in inch		f_z in inch/rev.	
	min.	max.	min.	max.
0.016	0.039	0.118	0.004	0.008
0.032	0.039	0.118	0.006	0.014

- ▲ Medium and rough machining
- ▲ Highly aggressive chip breaker
- ▲ Cutting depth a_p : 0.04-0.12 inch
- ▲ Stable component conditions necessary
- ▲ Cooling must be ensured

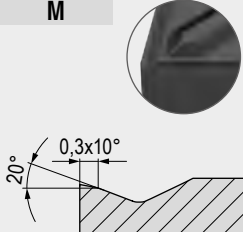
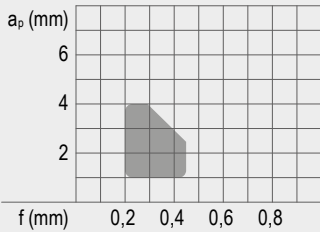
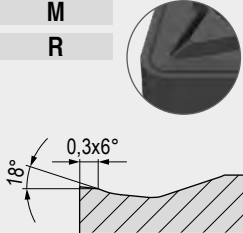
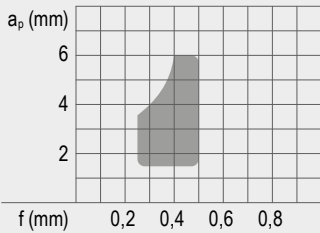
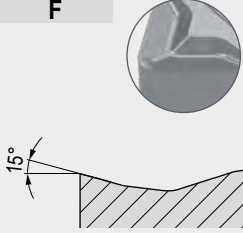
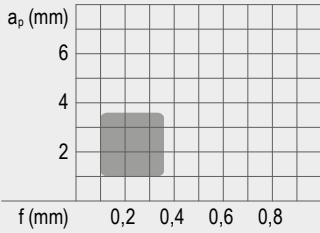
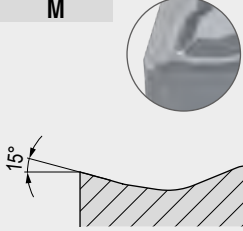
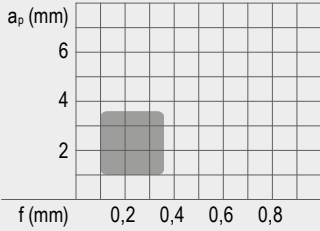
Chip breakers / Applications

Negative	Geometry Chip breaker	Cutting depth a_p (mm) Feed f (mm)	Machining situation																												
Reference indexable insert: CNMG 120408			<div> <div>○</div> <div>○</div> <div>⦿</div> </div>																												
-CF / -CF20 <ul style="list-style-type: none"> ▲ Finest finishing ▲ Sharp cutting edge for low cutting forces ▲ Good chip control even at small depths of cut ▲ High surface quality 	F 	 $a_p = 0,30-1,50$ $f = 0,07-0,25$	<table> <tr><td>P</td><td>●</td><td></td><td></td></tr> <tr><td>M</td><td>○</td><td></td><td></td></tr> <tr><td>K</td><td>○</td><td></td><td></td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td></td><td></td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	●			M	○			K	○			N				S				H				O			
P	●																														
M	○																														
K	○																														
N																															
S																															
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O																															
-F50 <ul style="list-style-type: none"> ▲ Fine turning chip breaker for fine machining ▲ First choice for finishing steel ▲ Excellent chip control ▲ High surface quality 	F 	 $a_p = 0,40-2,00$ $f = 0,10-0,30$	<table> <tr><td>P</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>M</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>K</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td></td><td></td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	●	●	●	M	○	○	○	K	●	●	●	N				S				H				O			
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M	○	○	○																												
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N																															
S																															
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O																															
-TFQ <ul style="list-style-type: none"> ▲ Wiper geometry ▲ Finishing to medium machining ▲ Very high feeds ▲ High surface quality 	F M 	 $a_p = 0,50-4,00$ $f = 0,10-0,50$	<table> <tr><td>P</td><td>●</td><td>●</td><td></td></tr> <tr><td>M</td><td>○</td><td>○</td><td></td></tr> <tr><td>K</td><td>●</td><td>●</td><td></td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td></td><td></td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	●	●		M	○	○		K	●	●		N				S				H				O			
P	●	●																													
M	○	○																													
K	●	●																													
N																															
S																															
H																															
O																															
-XU <ul style="list-style-type: none"> ▲ Finishing to medium machining ▲ Exceptional chip forming ▲ Low cutting forces 	M 	 $a_p = 0,40-4,50$ $f = 0,12-0,40$	<table> <tr><td>P</td><td>●</td><td>●</td><td></td></tr> <tr><td>M</td><td></td><td></td><td></td></tr> <tr><td>K</td><td>○</td><td>○</td><td></td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td></td><td></td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	●	●		M				K	○	○		N				S				H				O			
P	●	●																													
M																															
K	○	○																													
N																															
S																															
H																															
O																															
-M50 <ul style="list-style-type: none"> ▲ Medium machining ▲ First choice for steel machining ▲ Universal application ▲ Wide range of applications 	M 	 $a_p = 0,60-5,00$ $f = 0,15-0,40$	<table> <tr><td>P</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>M</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>K</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td></td><td></td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	●	●	●	M	○	○	○	K	●	●	●	N				S				H				O			
P	●	●	●																												
M	○	○	○																												
K	●	●	●																												
N																															
S																															
H																															
O																															
-TMQ <ul style="list-style-type: none"> ▲ Wiper geometry ▲ Medium machining to light roughing ▲ Very high feeds ▲ High surface quality 	M 	 $a_p = 0,80-5,00$ $f = 0,20-0,65$	<table> <tr><td>P</td><td>●</td><td>●</td><td></td></tr> <tr><td>M</td><td>○</td><td>○</td><td></td></tr> <tr><td>K</td><td>●</td><td>●</td><td></td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td></td><td></td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	●	●		M	○	○		K	●	●		N				S				H				O			
P	●	●																													
M	○	○																													
K	●	●																													
N																															
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-M70 <ul style="list-style-type: none"> ▲ Medium machining to roughing ▲ Casting and forging skin ▲ Stable cutting edge ▲ Interrupted cut ▲ Unmachined and forged parts 	M R 	 $a_p = 0,80-6,00$ $f = 0,20-0,45$	<table> <tr><td>P</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>M</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>K</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td></td><td></td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	●	●	●	M	○	○	○	K	●	●	●	N				S				H				O			
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Chip breakers / Applications

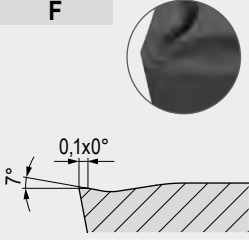
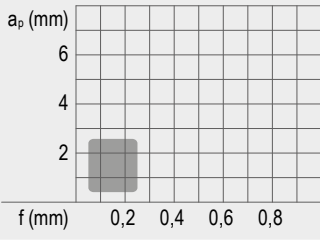
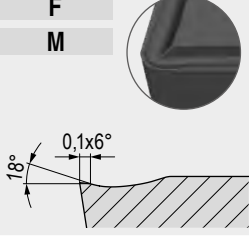
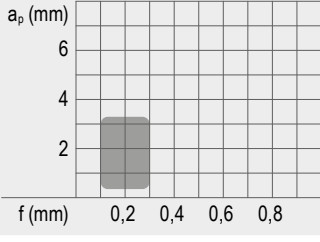
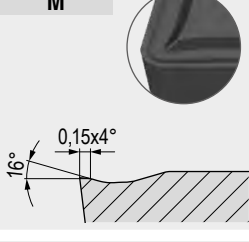
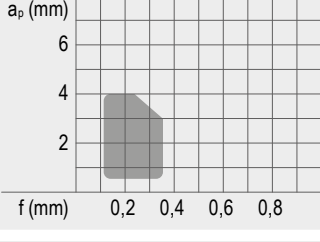
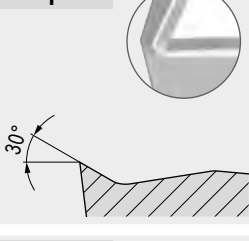
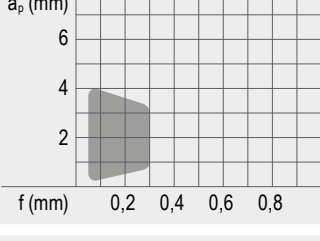
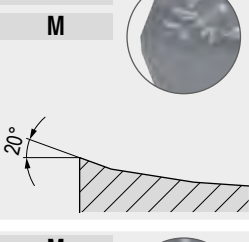
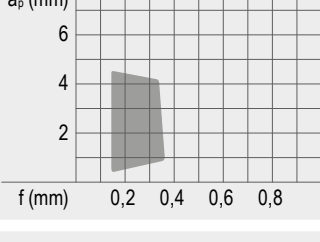
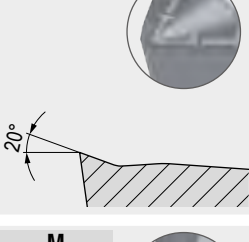
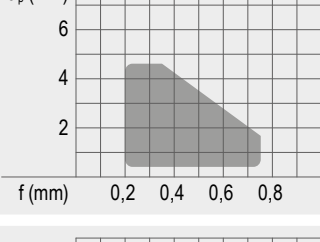
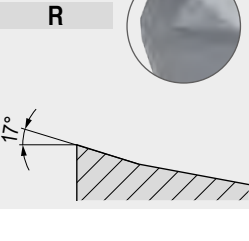
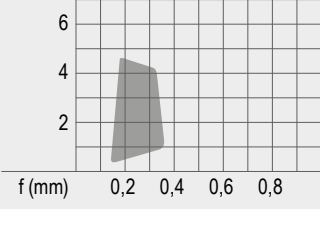
Negative	Geometry Chip breaker	Cutting depth a_p (mm) Feed f (mm)	Machining situation
Reference indexable insert: CNMG 120408			<div> <div>○</div> <div>○</div> <div>○</div> </div>
.NMA <ul style="list-style-type: none"> ▲ Rough machining ▲ Stable cutting edge ▲ For short-chipping materials ▲ First choice for gray cast iron 	R 	 $a_p = 0,80-6,00$ $f = 0,20-0,60$	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>○</div> <div>○</div> <div>●</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> </div> <div> <div>○</div> <div>○</div> <div>●</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> </div> <div> <div>○</div> <div>○</div> <div>●</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> </div>
-R28 <ul style="list-style-type: none"> ▲ One-sided roughing geometry ▲ Longitudinal turning, face turning, and copy milling ▲ Changing depths of cut ▲ Steels with low tensile strength ($< 800 \text{ N/mm}^2$) ▲ Good chip control 	R 	 $a_p = 0,80-7,00$ $f = 0,25-0,55$	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>●</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> </div> <div> <div>●</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> </div> <div> <div>●</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> </div>
-R58 <ul style="list-style-type: none"> ▲ One-sided roughing geometry ▲ Longitudinal and face turning ▲ Slightly interrupted cuts ▲ Low cutting forces ▲ Unstable machines 	R 	 $a_p = 1,00-7,00$ $f = 0,25-0,70$	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>●</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> </div> <div> <div>●</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> </div> <div> <div>●</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> </div>
-R88 <ul style="list-style-type: none"> ▲ One-sided roughing geometry ▲ Longitudinal and face turning ▲ High feeds ▲ Large cutting depths ▲ Strongly interrupted cut 	R 	 $a_p = 2,00-9,00$ $f = 0,40-1,20$	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>●</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> </div> <div> <div>●</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> </div> <div> <div>●</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> </div>
-F30 <ul style="list-style-type: none"> ▲ For the finishing of stainless steels ▲ Continuous cut ▲ High surface quality ▲ Good chip control 	F 	 $a_p = 0,80-2,50$ $f = 0,10-0,35$	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>○</div> <div>●</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> </div> <div> <div>○</div> <div>●</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> </div> <div> <div>○</div> <div>●</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> </div>
-M30 <ul style="list-style-type: none"> ▲ First choice for stainless machining ▲ Good chip control ▲ Low burr formation ▲ Low cutting forces ▲ Low built-up edge formation ▲ Can be used on unstable machines 	F M 	 $a_p = 1,00-4,50$ $f = 0,15-0,40$	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>○</div> <div>●</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> </div> <div> <div>○</div> <div>●</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> </div> <div> <div>○</div> <div>●</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> </div>
-42 <ul style="list-style-type: none"> ▲ Extremely soft-cutting chip breaker ▲ For small and medium widths of cut ▲ Suitable for thin-walled parts 	M 	 $a_p = 0,50-4,50$ $f = 0,05-0,35$	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>○</div> <div>●</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> </div> <div> <div>○</div> <div>●</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> </div> <div> <div>○</div> <div>●</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> <div>○</div> </div>

Chip breakers / Applications

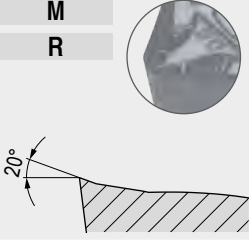
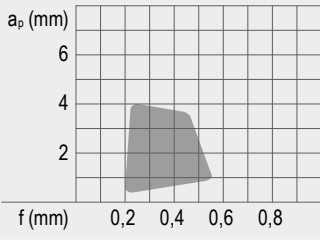
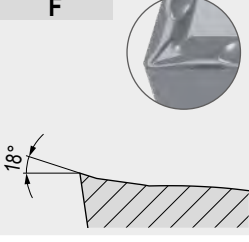
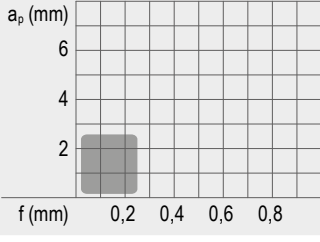
Negative Reference indexable insert: CNMG 120408	Geometry Chip breaker	Cutting depth a_p (mm) Feed f (mm)	Machining situation <div> ○ ○ ⊙ </div>																												
-M42 ▲ Universal chip breaker for medium cutting conditions ▲ Good chip control with a wide range of cutting parameters ▲ Suitable for machining stainless steels, secondary application also on general steels and super alloys	M 	 $a_p = 1,00-4,00$ $f = 0,20-0,44$	<table border="1"> <tr><td>P</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>M</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>K</td><td></td><td></td><td></td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	○	○	○	M	●	●	●	K				N				S	○	○	○	H				O			
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-M60 ▲ Medium machining to roughing ▲ Stable cutting edge ▲ Interrupted cuts ▲ Forging skin and casting skin ▲ Good chip formation with difficult-to-machine materials ▲ Good resistance to notch wear	M R 	 $a_p = 1,50-6,00$ $f = 0,25-0,50$	<table border="1"> <tr><td>P</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>M</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>K</td><td></td><td></td><td></td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	○	○	○	M	●	●	●	K				N				S	○	○	○	H				O			
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-F34 ▲ Stable, positive cutting edge ▲ Soft-cutting geometry ▲ Good chip formation ▲ Low built-up edge formation ▲ Pre-roughing: Sturdy design of the secondary cutting edge is suitable for pre-roughing	F 	 $a_p = 1,00-3,50$ $f = 0,10-0,35$	<table border="1"> <tr><td>P</td><td></td><td></td><td></td></tr> <tr><td>M</td><td>●</td><td>●</td><td></td></tr> <tr><td>K</td><td></td><td></td><td></td></tr> <tr><td>N</td><td>○</td><td>○</td><td></td></tr> <tr><td>S</td><td>●</td><td>●</td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P				M	●	●		K				N	○	○		S	●	●		H				O			
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-M34 ▲ First choice for super alloys ▲ Soft-cutting geometry ▲ Low built-up edge formation ▲ Low cutting force	M 	 $a_p = 1,00-3,50$ $f = 0,10-0,35$	<table border="1"> <tr><td>P</td><td></td><td></td><td></td></tr> <tr><td>M</td><td>●</td><td>●</td><td></td></tr> <tr><td>K</td><td></td><td></td><td></td></tr> <tr><td>N</td><td>○</td><td>○</td><td></td></tr> <tr><td>S</td><td>●</td><td>●</td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P				M	●	●		K				N	○	○		S	●	●		H				O			
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Positive	Geometry Chip breaker	Cutting depth a_p (mm) Feed f (mm)	Machining situation																												
Reference indexable insert: CCMT 09T308			<div> <div></div> <div></div> <div></div> </div>																												
-CF05 <ul style="list-style-type: none"> Finishing/contour turning Good chip control High surface quality Low cutting forces 	F	<p>a_p (mm)</p> <p>f (mm)</p> <p>$a_p = 0,40-2,00$ $f = 0,05-0,25$</p>	<table border="1"> <tr><td>P</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>M</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>K</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td></td><td></td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	●	●	●	M	○	○	○	K	●	●	●	N				S				H				O			
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-SF <ul style="list-style-type: none"> Finishing/contour turning Good chip control High surface quality Low cutting forces 	F	<p>a_p (mm)</p> <p>f (mm)</p> <p>$a_p = 0,40-2,00$ $f = 0,05-0,25$</p>	<table border="1"> <tr><td>P</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>M</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>K</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td></td><td></td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	●	●	●	M	○	○	○	K	●	●	●	N				S				H				O			
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-CF55 <ul style="list-style-type: none"> Finishing to medium machining Low cutting forces Good chip control 	F M	<p>a_p (mm)</p> <p>f (mm)</p> <p>$a_p = 0,60-2,50$ $f = 0,10-0,27$</p>	<table border="1"> <tr><td>P</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>M</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>K</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td></td><td></td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	●	●	●	M	○	○	○	K	●	●	●	N				S				H				O			
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-SMF <ul style="list-style-type: none"> Finishing to medium machining Low cutting forces Good chip control 	F M	<p>a_p (mm)</p> <p>f (mm)</p> <p>$a_p = 0,60-2,50$ $f = 0,10-0,27$</p>	<table border="1"> <tr><td>P</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>M</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>K</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td></td><td></td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	●	●	●	M	○	○	○	K	●	●	●	N				S				H				O			
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-M23 <ul style="list-style-type: none"> Universal application Soft-cutting geometry Outstanding chip breaking behavior, even at low cutting depths 	M <p>RCMT 10T3MOSN</p>	<p>a_p (mm)</p> <p>f (mm)</p> <p>$a_p = 0,20-2,50$ $f = 0,20-0,70$</p>	<table border="1"> <tr><td>P</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>M</td><td></td><td></td><td></td></tr> <tr><td>K</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td></td><td></td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	●	●	●	M				K	○	○	○	N				S				H				O			
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-SM <ul style="list-style-type: none"> Medium machining Universal application Stable cutting edge Changing depths of cut Wide range of applications 	M	<p>a_p (mm)</p> <p>f (mm)</p> <p>$a_p = 0,80-3,00$ $f = 0,12-0,35$</p>	<table border="1"> <tr><td>P</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>M</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>K</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td></td><td></td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	●	●	●	M	○	○	○	K	●	●	●	N				S				H				O			
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-SMQ <ul style="list-style-type: none"> Positive wiper geometry Finishing to medium machining Very high feeds High surface quality 	F M	<p>a_p (mm)</p> <p>f (mm)</p> <p>$a_p = 0,80-4,00$ $f = 0,15-0,45$</p>	<table border="1"> <tr><td>P</td><td>●</td><td>●</td><td></td></tr> <tr><td>M</td><td></td><td></td><td></td></tr> <tr><td>K</td><td>○</td><td>○</td><td></td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td></td><td></td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	●	●		M				K	○	○		N				S				H				O			
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Chip breakers / Applications

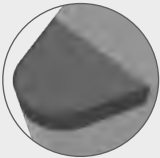
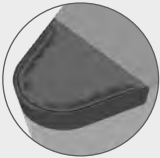
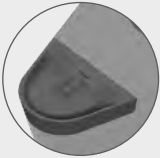
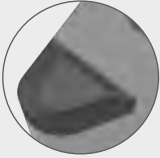
Positive	Geometry Chip breaker	Cutting depth a_p (mm) Feed f (mm)	Machining situation
Reference indexable insert: CCMT 09T308			<div> <div>○</div> <div>○</div> <div>○</div> </div>
-F43 <ul style="list-style-type: none"> ▲ For the finish machining of stainless steels ▲ Low cutting forces ▲ Good chip control ▲ High surface quality 	F 	 <p> $a_p =$ 0,50–2,50 $f =$ 0,05–0,25 </p>	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>○</div> <div>●</div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div> <div> <div>○</div> <div>●</div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div> <div> <div>○</div> <div>●</div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div>
-M25 <ul style="list-style-type: none"> ▲ First choice for the fine to medium machining of stainless steels ▲ Use under smooth to medium cutting conditions ▲ Achieves high surface quality ▲ Low built-up edge formation 	F M 	 <p> $a_p =$ 0,40–3,20 $f =$ 0,10–0,30 </p>	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>○</div> <div>●</div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div> <div> <div>○</div> <div>●</div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div> <div> <div>○</div> <div>○</div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>
-M55 <ul style="list-style-type: none"> ▲ First choice for medium machining through to roughing of stainless steels ▲ Smooth to slightly interrupted cut ▲ Good chip control ▲ Stable cutting edge 	M 	 <p> $a_p =$ 0,80–4,00 $f =$ 0,12–0,35 </p>	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>○</div> <div>●</div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div> <div> <div>○</div> <div>●</div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div> <div> <div>○</div> <div>○</div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>
-23P <ul style="list-style-type: none"> ▲ Low adhesion ▲ Good chip control with soft aluminum alloys 	F 	 <p> $a_p =$ 0,20–4,00 $f =$ 0,05–0,30 </p>	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div></div> <div></div> <div></div> <div>●</div> <div></div> <div></div> <div></div> </div> <div> <div></div> <div></div> <div></div> <div>●</div> <div></div> <div></div> <div></div> </div> <div> <div></div> <div></div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div>
-25P <ul style="list-style-type: none"> ▲ Sharp cutting edge ▲ Good chip control with softer aluminum alloys ▲ Low adhesion 	F M 	 <p> $a_p =$ 0,50–4,50 $f =$ 0,15–0,35 </p>	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>○</div> <div>○</div> <div>○</div> <div>●</div> <div>○</div> <div></div> <div></div> </div> <div> <div>○</div> <div>○</div> <div>○</div> <div>●</div> <div>○</div> <div></div> <div></div> </div> <div> <div></div> <div></div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div>
-25Q <ul style="list-style-type: none"> ▲ Wiper geometry ▲ High feeds ▲ High surface quality ▲ Good chip control with softer aluminum alloys ▲ Low adhesion 	M 	 <p> $a_p =$ 0,50–4,50 $f =$ 0,20–0,75 </p>	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>○</div> <div>○</div> <div>○</div> <div>●</div> <div>○</div> <div></div> <div></div> </div> <div> <div>○</div> <div>○</div> <div>○</div> <div>●</div> <div>○</div> <div></div> <div></div> </div> <div> <div></div> <div></div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div>
-27 <ul style="list-style-type: none"> ▲ The universal aluminum geometry ▲ Sharp cutting edge ▲ Extremely positive rake angle ▲ Low adhesion ▲ High feeds 	M R 	 <p> $a_p =$ 0,50–4,50 $f =$ 0,15–0,35 </p>	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>○</div> <div>○</div> <div>○</div> <div>●</div> <div>○</div> <div></div> <div></div> </div> <div> <div>○</div> <div>○</div> <div>○</div> <div>●</div> <div>○</div> <div></div> <div></div> </div> <div> <div></div> <div></div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div>

Chip breakers / Applications

Positive	Geometry Chip breaker	Cutting depth a_p (mm) Feed f (mm)	Machining situation																												
Reference indexable insert: CCMT 09T308			<div>○</div> <div>○</div> <div>○</div>																												
-29 ▲ Direct sintered aluminum geometry ▲ Positive rake angle ▲ Good chip control ▲ For medium to rough machining	M R 	 $a_p = 0,50-4,00$ $f = 0,20-0,35$	<table> <tr><td>P</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>M</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>K</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>N</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>S</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td>○</td><td>○</td><td>○</td></tr> </table>	P	○	○	○	M	○	○	○	K	○	○	○	N	●	●	●	S	○	○	○	H				O	○	○	○
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-F05 ▲ Ultra-fine turning chip breaker ▲ Highest tolerance class ▲ Excellent chip control even at the shallowest cutting depths ▲ Very low cutting forces	F 	 $a_p = 0,10-2,50$ $f = 0,02-0,25$	<table> <tr><td>P</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>M</td><td>●</td><td>●</td><td>○</td></tr> <tr><td>K</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>N</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>S</td><td>●</td><td>●</td><td>○</td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td>○</td><td>○</td><td>○</td></tr> </table>	P	○	○	○	M	●	●	○	K	○	○	○	N	●	●	●	S	●	●	○	H				O	○	○	○
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Supplementary chip breakers	Geometry Chip breaker	Machining situation			
			○	○	○
-EN ▲ Indexable insert without step for short-chipping materials	<div>R</div> <div>M</div> <div></div>	P	●	●	●
		M	○	○	○
		K	●	●	
		N			
		S			
		H			
		O			
-ER / -EL ▲ A problem solver for unstable conditions ▲ Can be used on less powerful machines ▲ Can be used as a secondary application for general steels and stainless materials	<div>M</div> <div></div>	P		●	●
		M			
		K			
		N			
		S			
		H			
		O			

Chip breakers / Applications

PCD	Geometry Chip breaker	Machining situation		
		○	○	○
-F4 ▲ PCD segment without chip breaker ▲ Predominantly used with interrupted cut ▲ Cutting edge finish available: sharp (F), rounded (E), chamfered (T) in line with ISO designation system	F 	P		
		M		
		K		
		N	●	●
		S		
		H		
		O		
-F41 ▲ PCD segment ▲ Chip-breakage optimized chip breaker for small cutting depths ▲ Cutting edge finish available: sharp (F), rounded (E), chamfered (T) in line with ISO designation system	F 	P		
		M		
		K		
		N	●	●
		S		
		H		
		O		
-M41 ▲ PCD segment with tried-and-tested M41 chip breaker ▲ Optimized chip breaker for low cutting pressure and ideal chip shape ▲ Cutting edge finish available: sharp (F), rounded (E), chamfered (T) in line with ISO designation system	M 	P		
		M		
		K		
		N	●	●
		S		
		H		
		O		
-R41 ▲ PCD segment with R41 chip breaker ▲ Roughing stage for pre-machining with up to 4 mm depth of cut ▲ Cutting edge finish available: sharp (F), rounded (E), chamfered (T) in line with ISO designation system	R 	P		
		M		
		K		
		N	●	●
		S		
		H		
		O		

Clamping systems

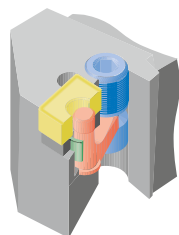
Tool holders with top clamping (MaxiLock D)



- Clamping element
- Indexable insert
- Insert seat
- Pin
- Screw

The first-choice tool for machining with negative center-hole inserts. Secure and precise positioning of the indexable insert thanks to the double clamping effect of the clamping element.

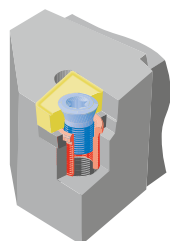
Tool holders with lever clamping (MaxiLock N)



- Clamping element
- Indexable insert
- Insert seat
- Shim
- Lever

This clamping system is suitable for all center-hole inserts with a negative basic shape. The clamping screw is easy to access from the top and bottom of the holder. When the clamping system is released, there are no loose spare parts.

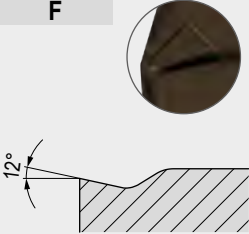
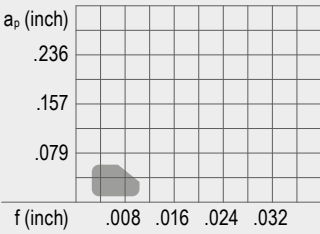
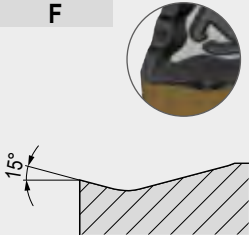
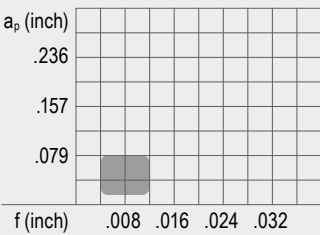
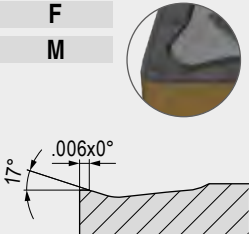
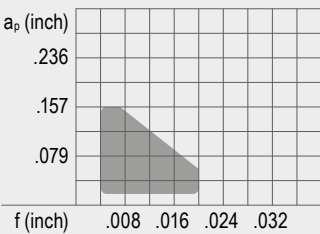
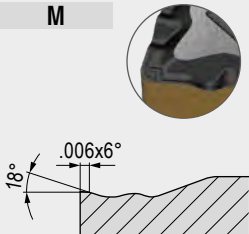
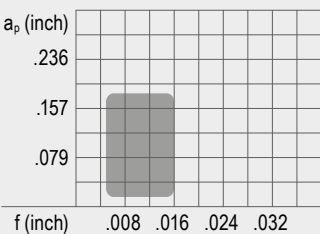
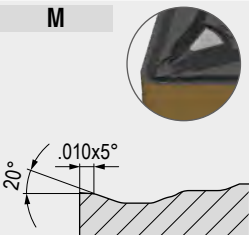
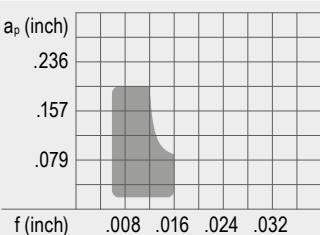
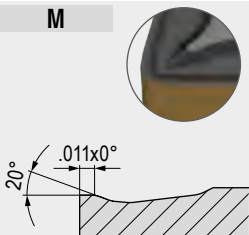
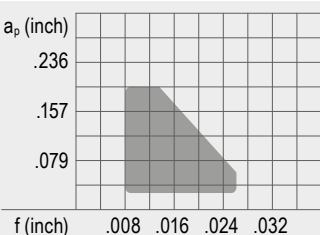
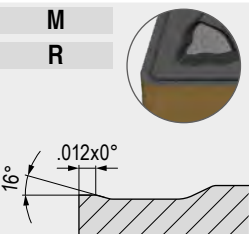
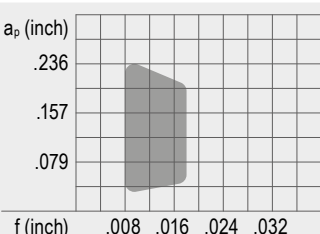
Tool holders with screw clamping (MaxiLock S)



- Clamping element
- Indexable insert
- Insert seat
- Threaded bush

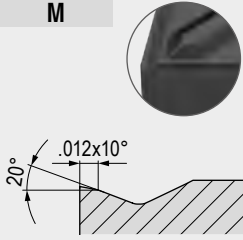
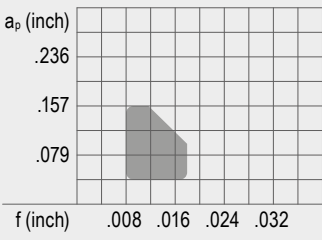
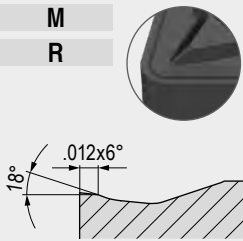
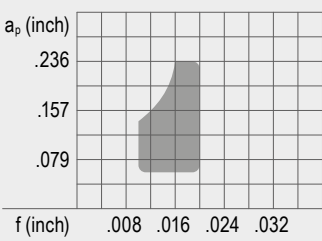
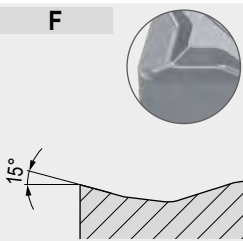
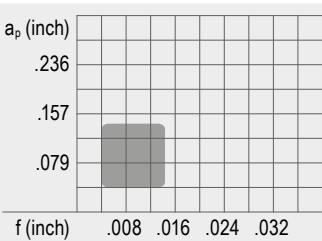
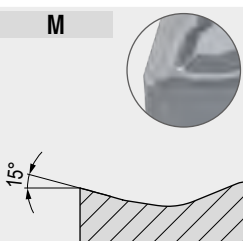
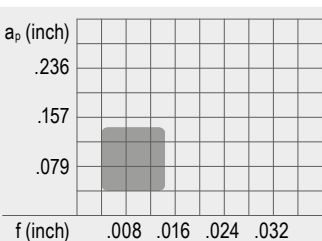
The positive screw clamping guarantees a secure connection between the indexable insert and the tool holder. The chip flow is not disrupted by protruding clamping elements. Thanks to the neutral insert position, the effective available rake angle is identical to the rake angle of the indexable insert.

Chip breakers / Applications

Negative	Geometry Chip breaker	Cutting depth a_p (inch) Feed f (inch)	Machining situation
Reference indexable insert: CNMG 120408			<div> <div>○</div> <div>○</div> <div>⊙</div> </div>
-CF / -CF20 <ul style="list-style-type: none"> ▲ Finest finishing ▲ Sharp cutting edge for low cutting forces ▲ Good chip control even at small depths of cut ▲ High surface quality 	F 	 $a_p = .012-.059$ $f = .003-.010$	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>●</div> <div>○</div> <div>○</div> <div></div> <div></div> <div></div> <div></div> </div> <div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> </div> <div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>
-F50 <ul style="list-style-type: none"> ▲ Fine turning chip breaker for fine machining ▲ First choice for finishing steel ▲ Excellent chip control ▲ High surface quality 	F 	 $a_p = .016-.079$ $f = .004-.012$	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>●</div> <div>○</div> <div>●</div> <div></div> <div></div> <div></div> <div></div> </div> <div> <div>●</div> <div>○</div> <div>●</div> <div></div> <div></div> <div></div> <div></div> </div> <div> <div>●</div> <div>○</div> <div>●</div> <div></div> <div></div> <div></div> <div></div> </div>
-TFQ <ul style="list-style-type: none"> ▲ Wiper geometry ▲ Finishing to medium machining ▲ Very high feeds ▲ High surface quality 	F M 	 $a_p = .020-.157$ $f = .004-.020$	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>●</div> <div>○</div> <div>●</div> <div></div> <div></div> <div></div> <div></div> </div> <div> <div>●</div> <div>○</div> <div>●</div> <div></div> <div></div> <div></div> <div></div> </div> <div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>
-XU <ul style="list-style-type: none"> ▲ Finishing to medium machining ▲ Exceptional chip forming ▲ Low cutting forces 	M 	 $a_p = .016-.177$ $f = .005-.016$	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>●</div> <div></div> <div>○</div> <div></div> <div></div> <div></div> <div></div> </div> <div> <div>●</div> <div></div> <div>○</div> <div></div> <div></div> <div></div> <div></div> </div> <div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>
-M50 <ul style="list-style-type: none"> ▲ Medium machining ▲ First choice for steel machining ▲ Universal application ▲ Wide range of applications 	M 	 $a_p = .021-.197$ $f = .006-.016$	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>●</div> <div>○</div> <div>●</div> <div></div> <div></div> <div></div> <div></div> </div> <div> <div>●</div> <div>○</div> <div>●</div> <div></div> <div></div> <div></div> <div></div> </div> <div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>
-TMQ <ul style="list-style-type: none"> ▲ Wiper geometry ▲ Medium machining to light roughing ▲ Very high feeds ▲ High surface quality 	M 	 $a_p = .031-.200$ $f = .008-.026$	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>●</div> <div>○</div> <div>●</div> <div></div> <div></div> <div></div> <div></div> </div> <div> <div>●</div> <div>○</div> <div>●</div> <div></div> <div></div> <div></div> <div></div> </div> <div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>
-M70 <ul style="list-style-type: none"> ▲ Medium machining to roughing ▲ Casting and forging skin ▲ Stable cutting edge ▲ Interrupted cut ▲ Unmachined and forged parts 	M R 	 $a_p = .031-.236$ $f = .008-.018$	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>●</div> <div>○</div> <div>●</div> <div></div> <div></div> <div></div> <div></div> </div> <div> <div>●</div> <div>○</div> <div>●</div> <div></div> <div></div> <div></div> <div></div> </div> <div> <div>●</div> <div>○</div> <div>●</div> <div></div> <div></div> <div></div> <div></div> </div>

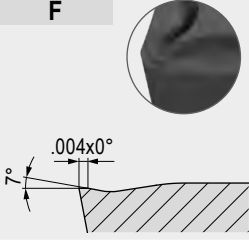
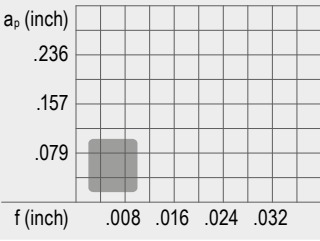
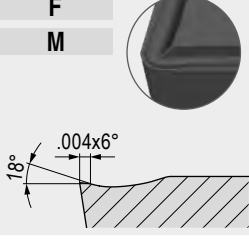
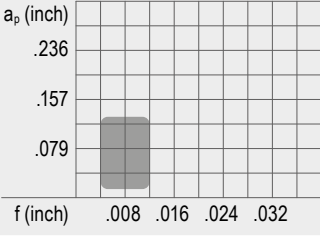
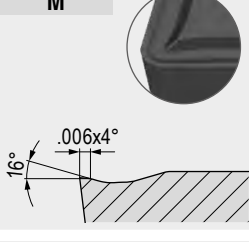
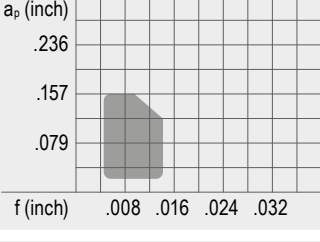
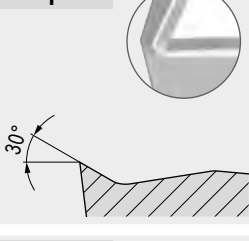
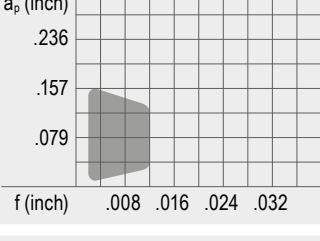
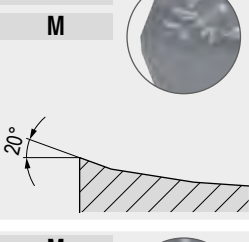
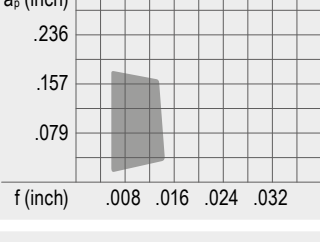
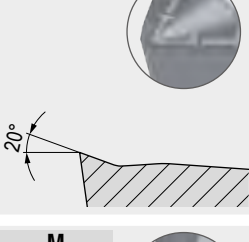
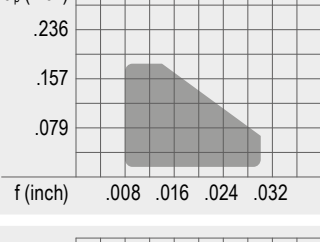
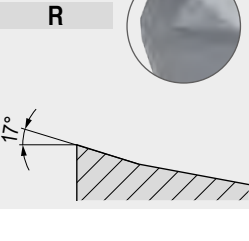
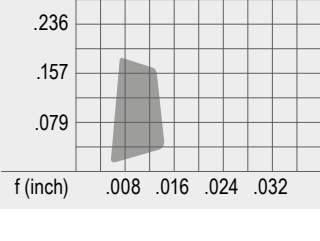
Negative		Geometry	Cutting depth a_p (inch)	Feed f (inch)	Machining situation		
Reference indexable insert: CNMG 120408		Chip breaker					
.NMA	<ul style="list-style-type: none"> ▲ Rough machining ▲ Stable cutting edge ▲ For short-chipping materials ▲ First choice for gray cast iron 	R 		$a_p = .031-.236$ $f = .008-.024$	P		
-R28	<ul style="list-style-type: none"> ▲ One-sided roughing geometry ▲ Longitudinal turning, face turning, and copy milling ▲ Changing depths of cut ▲ Steels with low tensile strength ($< 800 \text{ N/mm}^2$) ▲ Good chip control 	R 		$a_p = .031-.276$ $f = .010-.022$	P		
-R58	<ul style="list-style-type: none"> ▲ One-sided roughing geometry ▲ Longitudinal and face turning ▲ Slightly interrupted cuts ▲ Low cutting forces ▲ Unstable machines 	R 		$a_p = .039-.276$ $f = .010-.026$	P		
-R88	<ul style="list-style-type: none"> ▲ One-sided roughing geometry ▲ Longitudinal and face turning ▲ High feeds ▲ Large cutting depths ▲ Strongly interrupted cut 	R CNMG 160424 		$a_p = .079-.354$ $f = .016-.047$	P		
-F30	<ul style="list-style-type: none"> ▲ For the finishing of stainless steels ▲ Continuous cut ▲ High surface quality ▲ Good chip control 	F 		$a_p = .031-.098$ $f = .004-.014$	P		
-M30	<ul style="list-style-type: none"> ▲ First choice for stainless machining ▲ Good chip control ▲ Low burr formation ▲ Low cutting forces ▲ Low built-up edge formation ▲ Can be used on unstable machines 	F M 		$a_p = .039-.177$ $f = .006-.016$	P		
-42	<ul style="list-style-type: none"> ▲ Extremely soft-cutting chip breaker ▲ For small and medium widths of cut ▲ Suitable for thin-walled parts 	M 		$a_p = .020-.177$ $f = .002-.014$	P		

Chip breakers / Applications

Negative Reference indexable insert: CNMG 120408	Geometry Chip breaker	Cutting depth a_p (inch) Feed f (inch)	Machining situation <div> ○ ○ ⊗ </div>																												
-M42 ▲ Universal chip breaker for medium cutting conditions ▲ Good chip control with a wide range of cutting parameters ▲ Suitable for machining stainless steels, secondary application also on general steels and super alloys	M 	 $a_p = .039-.157$ $f = .008-.017$	<table border="1"> <tr><td>P</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>M</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>K</td><td></td><td></td><td></td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	○	○	○	M	●	●	●	K				N				S	○	○	○	H				O			
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-M60 ▲ Medium machining to roughing ▲ Stable cutting edge ▲ Interrupted cuts ▲ Forging skin and casting skin ▲ Good chip formation with difficult-to-machine materials ▲ Good resistance to notch wear	M R 	 $a_p = .059-.236$ $f = .010-.020$	<table border="1"> <tr><td>P</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>M</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>K</td><td></td><td></td><td></td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	○	○	○	M	●	●	●	K				N				S	○	○	○	H				O			
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-F34 ▲ Stable, positive cutting edge ▲ Soft-cutting geometry ▲ Good chip formation ▲ Low built-up edge formation ▲ Pre-roughing: Sturdy design of the secondary cutting edge is suitable for pre-roughing	F 	 $a_p = .040-.138$ $f = .004-.014$	<table border="1"> <tr><td>P</td><td></td><td></td><td></td></tr> <tr><td>M</td><td>●</td><td>●</td><td></td></tr> <tr><td>K</td><td></td><td></td><td></td></tr> <tr><td>N</td><td>○</td><td>○</td><td></td></tr> <tr><td>S</td><td>●</td><td>●</td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P				M	●	●		K				N	○	○		S	●	●		H				O			
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-M34 ▲ First choice for super alloys ▲ Soft-cutting geometry ▲ Low built-up edge formation ▲ Low cutting force	M 	 $a_p = .040-.138$ $f = .004-.014$	<table border="1"> <tr><td>P</td><td></td><td></td><td></td></tr> <tr><td>M</td><td>●</td><td>●</td><td></td></tr> <tr><td>K</td><td></td><td></td><td></td></tr> <tr><td>N</td><td>○</td><td>○</td><td></td></tr> <tr><td>S</td><td>●</td><td>●</td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P				M	●	●		K				N	○	○		S	●	●		H				O			
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Positive	Geometry Chip breaker	Cutting depth a_p (inch)	Feed f (inch)	Machining situation																												
Reference indexable insert: CCMT 09T308																																
-CF05 <ul style="list-style-type: none"> ▲ Finishing/contour turning ▲ Good chip control ▲ High surface quality ▲ Low cutting forces 	F		$a_p = .016-.079$ $f = .002-.010$	<table border="1"> <tr><td>P</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>M</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>K</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td></td><td></td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	●	●	●	M	○	○	○	K	●	●	●	N				S				H				O			
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-SF <ul style="list-style-type: none"> ▲ Finishing/contour turning ▲ Good chip control ▲ High surface quality ▲ Low cutting forces 	F		$a_p = .016-.079$ $f = .002-.010$	<table border="1"> <tr><td>P</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>M</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>K</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td></td><td></td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	●	●	●	M	○	○	○	K	●	●	●	N				S				H				O			
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-CF55 <ul style="list-style-type: none"> ▲ Finishing to medium machining ▲ Low cutting forces ▲ Good chip control 	F M		$a_p = .024-.098$ $f = .004-.011$	<table border="1"> <tr><td>P</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>M</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>K</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td></td><td></td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	●	●	●	M	○	○	○	K	●	●	●	N				S				H				O			
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-SMF <ul style="list-style-type: none"> ▲ Finishing to medium machining ▲ Low cutting forces ▲ Good chip control 	F M		$a_p = .024-.098$ $f = .004-.011$	<table border="1"> <tr><td>P</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>M</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>K</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td></td><td></td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	●	●	●	M	○	○	○	K	●	●	●	N				S				H				O			
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-M23 <ul style="list-style-type: none"> ▲ Universal application ▲ Soft-cutting geometry ▲ Outstanding chip breaking behavior, even at low cutting depths 	M		$a_p = .008-.098$ $f = .008-.028$	<table border="1"> <tr><td>P</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>M</td><td></td><td></td><td></td></tr> <tr><td>K</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td></td><td></td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	●	●	●	M				K	○	○	○	N				S				H				O			
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-SM <ul style="list-style-type: none"> ▲ Medium machining ▲ Universal application ▲ Stable cutting edge ▲ Changing depths of cut ▲ Wide range of applications 	M		$a_p = .003-.118$ $f = .005-.014$	<table border="1"> <tr><td>P</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>M</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>K</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td></td><td></td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	●	●	●	M	○	○	○	K	●	●	●	N				S				H				O			
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-SMQ <ul style="list-style-type: none"> ▲ Positive wiper geometry ▲ Finishing to medium machining ▲ Very high feeds ▲ High surface quality 	F M		$a_p = .031-.157$ $f = .006-.018$	<table border="1"> <tr><td>P</td><td>●</td><td>●</td><td></td></tr> <tr><td>M</td><td></td><td></td><td></td></tr> <tr><td>K</td><td>○</td><td>○</td><td></td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td></td><td></td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td></td><td></td><td></td></tr> </table>	P	●	●		M				K	○	○		N				S				H				O			
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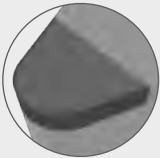
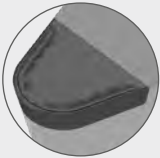
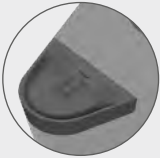
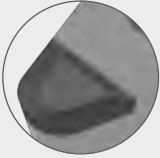
Chip breakers / Applications

Positive	Geometry Chip breaker	Cutting depth a_p (inch) Feed f (inch)	Machining situation
Reference indexable insert: CCMT 09T308			<div> <div>○</div> <div>○</div> <div>○</div> </div>
-F43 <ul style="list-style-type: none"> ▲ For the finish machining of stainless steels ▲ Low cutting forces ▲ Good chip control ▲ High surface quality 	F 	 $a_p = .020-.098$ $f = .002-.010$	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>○</div> <div>●</div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div> <div> <div>○</div> <div>●</div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div> <div> <div>○</div> <div>●</div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div>
-M25 <ul style="list-style-type: none"> ▲ First choice for the fine to medium machining of stainless steels ▲ Use under smooth to medium cutting conditions ▲ Achieves high surface quality ▲ Low built-up edge formation 	F M 	 $a_p = .016-.126$ $f = .004-.012$	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>○</div> <div>●</div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div> <div> <div>○</div> <div>●</div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div> <div> <div>○</div> <div>○</div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>
-M55 <ul style="list-style-type: none"> ▲ First choice for medium machining through to roughing of stainless steels ▲ Smooth to slightly interrupted cut ▲ Good chip control ▲ Stable cutting edge 	M 	 $a_p = .032-.157$ $f = .005-.014$	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>○</div> <div>●</div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div> <div> <div>○</div> <div>●</div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div> <div> <div>○</div> <div>○</div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>
-23P <ul style="list-style-type: none"> ▲ Low adhesion ▲ Good chip control with soft aluminum alloys 	F 	 $a_p = .008-.157$ $f = .002-.012$	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div></div> <div></div> <div></div> <div>●</div> <div></div> <div></div> <div></div> </div> <div> <div></div> <div></div> <div></div> <div>●</div> <div></div> <div></div> <div></div> </div> <div> <div></div> <div></div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div>
-25P <ul style="list-style-type: none"> ▲ Sharp cutting edge ▲ Good chip control with softer aluminum alloys ▲ Low adhesion 	F M 	 $a_p = .020-.177$ $f = .006-.014$	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>○</div> <div>○</div> <div>○</div> <div>●</div> <div>○</div> <div></div> <div></div> </div> <div> <div>○</div> <div>○</div> <div>○</div> <div>●</div> <div>○</div> <div></div> <div></div> </div> <div> <div></div> <div></div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div>
-25Q <ul style="list-style-type: none"> ▲ Wiper geometry ▲ High feeds ▲ High surface quality ▲ Good chip control with softer aluminum alloys ▲ Low adhesion 	M 	 $a_p = .020-.177$ $f = .008-.030$	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>○</div> <div>○</div> <div>○</div> <div>●</div> <div>○</div> <div></div> <div></div> </div> <div> <div>○</div> <div>○</div> <div>○</div> <div>●</div> <div>○</div> <div></div> <div></div> </div> <div> <div></div> <div></div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div>
-27 <ul style="list-style-type: none"> ▲ The universal aluminum geometry ▲ Sharp cutting edge ▲ Extremely positive rake angle ▲ Low adhesion ▲ High feeds 	M R 	 $a_p = .020-.177$ $f = .006-.014$	<div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div> <div>○</div> <div>○</div> <div>○</div> <div>●</div> <div>○</div> <div></div> <div></div> </div> <div> <div>○</div> <div>○</div> <div>○</div> <div>●</div> <div>○</div> <div></div> <div></div> </div> <div> <div></div> <div></div> <div></div> <div></div> <div>○</div> <div></div> <div></div> </div>

Positive	Geometry Chip breaker	Cutting depth a_p (inch)	Feed f (inch)	Machining situation																												
Reference indexable insert: CCMT 09T308			$a_p = .012-.158$ $f = .008-.014$	<table border="1"> <tr><td>P</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>M</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>K</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>N</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>S</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td>○</td><td>○</td><td>○</td></tr> </table>	P	○	○	○	M	○	○	○	K	○	○	○	N	●	●	●	S	○	○	○	H				O	○	○	○
P	○	○	○																													
M	○	○	○																													
K	○	○	○																													
N	●	●	●																													
S	○	○	○																													
H																																
O	○	○	○																													
-29 ▲ Direct sintered aluminum geometry ▲ Positive rake angle ▲ Good chip control ▲ For medium to rough machining			$a_p = .012-.158$ $f = .008-.014$	<table border="1"> <tr><td>P</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>M</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>K</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>N</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>S</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td>○</td><td>○</td><td>○</td></tr> </table>	P	○	○	○	M	○	○	○	K	○	○	○	N	●	●	●	S	○	○	○	H				O	○	○	○
P	○	○	○																													
M	○	○	○																													
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N	●	●	●																													
S	○	○	○																													
H																																
O	○	○	○																													
-F05 ▲ Ultra-fine turning chip breaker ▲ Highest tolerance class ▲ Excellent chip control even at the shallowest cutting depths ▲ Very low cutting forces			$a_p = .004-.098$ $f = .001-.010$	<table border="1"> <tr><td>P</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>M</td><td>●</td><td>●</td><td>○</td></tr> <tr><td>K</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>N</td><td>●</td><td>●</td><td>○</td></tr> <tr><td>S</td><td>●</td><td>●</td><td>○</td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td>○</td><td>○</td><td>○</td></tr> </table>	P	○	○	○	M	●	●	○	K	○	○	○	N	●	●	○	S	●	●	○	H				O	○	○	○
P	○	○	○																													
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S	●	●	○																													
H																																
O	○	○	○																													

Supplementary chip breakers	Geometry Chip breaker	Machining situation
		<div>○</div> <div>○</div> <div>○</div>
-EN ▲ Indexable insert without step for short-chipping materials	<div>R</div> <div>M</div>	<div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> <div> <div>●</div> <div>○</div> <div>●</div> </div> <div> <div>●</div> <div>○</div> <div>●</div> </div> <div> <div>●</div> <div>○</div> <div>●</div> </div>
-ER / -EL ▲ A problem solver for unstable conditions ▲ Can be used on less powerful machines ▲ Can be used as a secondary application for general steels and stainless steels	<div>M</div>	<div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> <div> <div>●</div> <div>○</div> <div>●</div> </div> <div> <div>●</div> <div>○</div> <div>●</div> </div> <div> <div>●</div> <div>○</div> <div>●</div> </div>

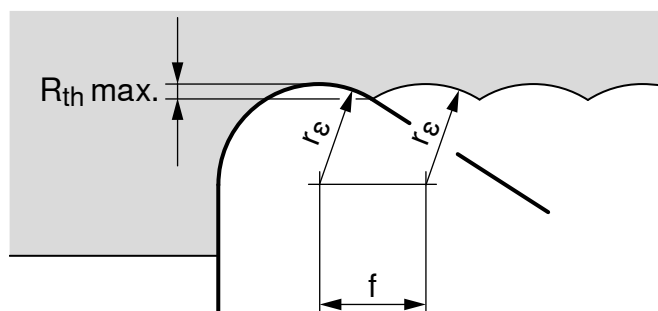
Chip breakers / Applications

PCD	Geometry Chip breaker	Machining situation		
				
-F4 ▲ PCD segment without chip breaker ▲ Predominantly used with interrupted cut ▲ Cutting edge finish available: sharp (F), rounded (E), chamfered (T) in line with ISO designation system	F 	P		
		M		
		K		
		N	•	•
		S		
		H		
		O		
-F41 ▲ PCD segment ▲ Chip-breakage optimized chip breaker for small cutting depths ▲ Cutting edge finish available: sharp (F), rounded (E), chamfered (T) in line with ISO designation system	F 	P		
		M		
		K		
		N	•	•
		S		
		H		
		O		
-M41 ▲ PCD segment with tried-and-tested M41 chip breaker ▲ Optimized chip breaker for low cutting pressure and ideal chip shape ▲ Cutting edge finish available: sharp (F), rounded (E), chamfered (T) in line with ISO designation system	M 	P		
		M		
		K		
		N	•	•
		S		
		H		
		O		
-R41 ▲ PCD segment with R41 chip breaker ▲ Roughing stage for pre-machining with up to 0.1575 inch depth of cut ▲ Cutting edge finish available: sharp (F), rounded (E), chamfered (T) in line with ISO designation system	R 	P		
		M		
		K		
		N	•	•
		S		
		H		
		O		

Surface quality

Theoretical surface quality

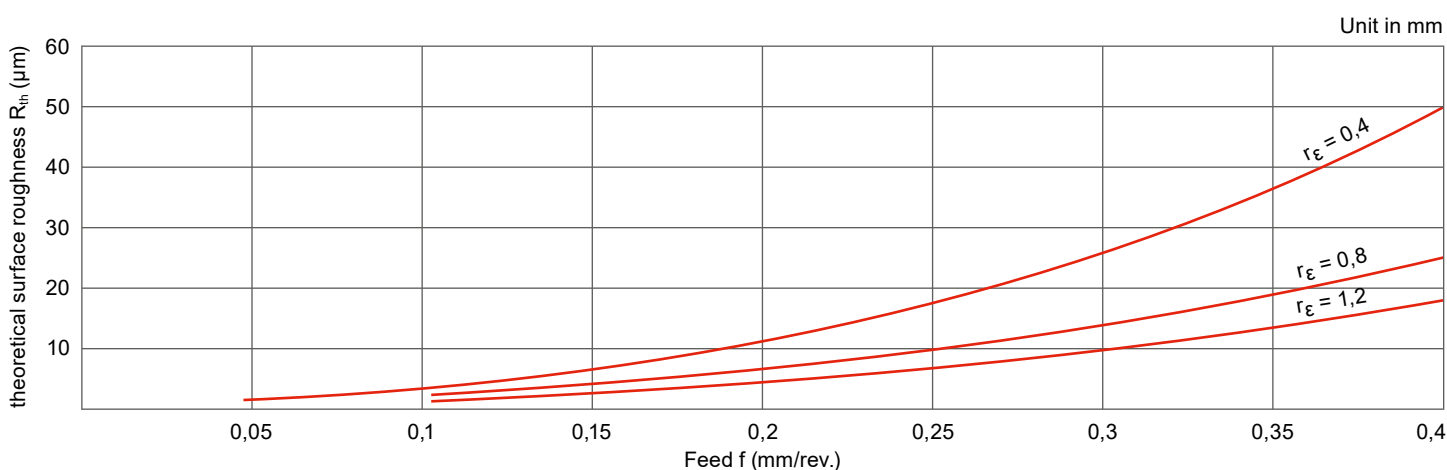
The maximum theoretical surface roughness with turning $R_{th \max.}$ is the combination of feed rate and corner radius:



$$R_{th \max.} = \left(r_{\epsilon} - \sqrt{r_{\epsilon}^2 - \frac{f^2}{4}} \right) \times 1000 \text{ (}\mu\text{m)}$$

Or approximately:

$$R_{th \max.} \approx \frac{125 \times f^2}{r_{\epsilon}} \text{ (}\mu\text{m)}$$



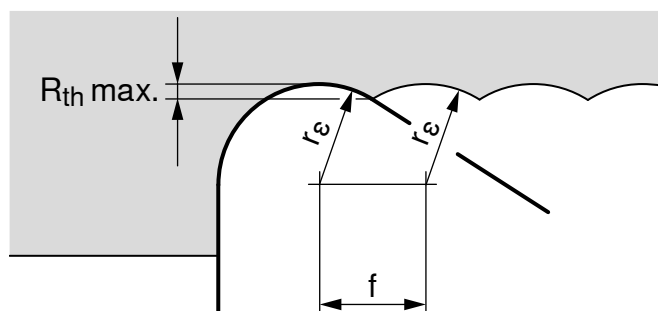
Feed rate guide values for surface quality

Average surface roughness R_z (μm)	theoretical surface roughness R_{th} (μm)	Corresponds to R_a (μm)	Roughness index	ISO 1302	Corner radius r_{ϵ} in inch and feed rate f in inch/rev.						
					RE = 0,1	RE = 0,2	RE = 0,4	RE = 0,8	RE = 1,2	RE = 1,6	RE = 2,4
63 – 100	$\sqrt{R_{th}63}$	12,5 – 25	N11	$\frac{25}{\nabla}$	0,22*	0,32*	0,45*	0,63	0,78	0,9	1,1
40 – 63	$\sqrt{R_{th}40}$	6,3 – 12,5	N10	$\frac{12,5}{\nabla}$	0,18*	0,25*	0,36	0,51	0,62	0,72	0,88
31,5 – 40	$\sqrt{R_{th}31,5}$	4,9 – 6,3	N9	$\frac{6,3}{\nabla}$	0,16*	0,22*	0,32	0,45	0,55	0,63	0,78
25 – 31,5	$\sqrt{R_{th}25}$	4,0 – 4,9			0,14*	0,2*	0,28	0,4	0,49	0,57	0,69
16 – 25	$\sqrt{R_{th}16}$	2,5 – 4,0	N8	$\frac{3,2}{\nabla}$	0,11*	0,16	0,23	0,32	0,39	0,45	0,55
10 – 16	$\sqrt{R_{th}10}$	1,6 – 2,5			0,09	0,13	0,18	0,25	0,31	0,36	0,44
6,3 – 10	$\sqrt{R_{th}6,3}$	1,0 – 1,6	N7	$\frac{1,6}{\nabla}$	0,07	0,1	0,14	0,2	0,25	0,28	0,35
4 – 6,3	$\sqrt{R_{th}4}$	0,8 – 1,0	N6	$\frac{0,8}{\nabla}$	0,06	0,08	0,11	0,16	0,2	0,23	0,28
2,5 – 4	$\sqrt{R_{th}2,5}$	0,4 – 0,8	N5	$\frac{0,4}{\nabla}$	0,04	0,06	0,09	0,13	0,15	0,18	0,22
1,6 – 2,5	$\sqrt{R_{th}1,6}$	0,2 – 0,4	N4	$\frac{0,2}{\nabla}$	0,04	0,05	0,07	0,1	0,12	0,14	0,18
1 – 1,6	$\sqrt{R_{th}1}$	0,1 – 0,2	N3	$\frac{0,1}{\nabla}$	0,03	0,04	0,06	0,08	0,1	0,11	0,14

*Please ensure that the feed rate values used do not exceed the corner radius (RE).

Surface quality

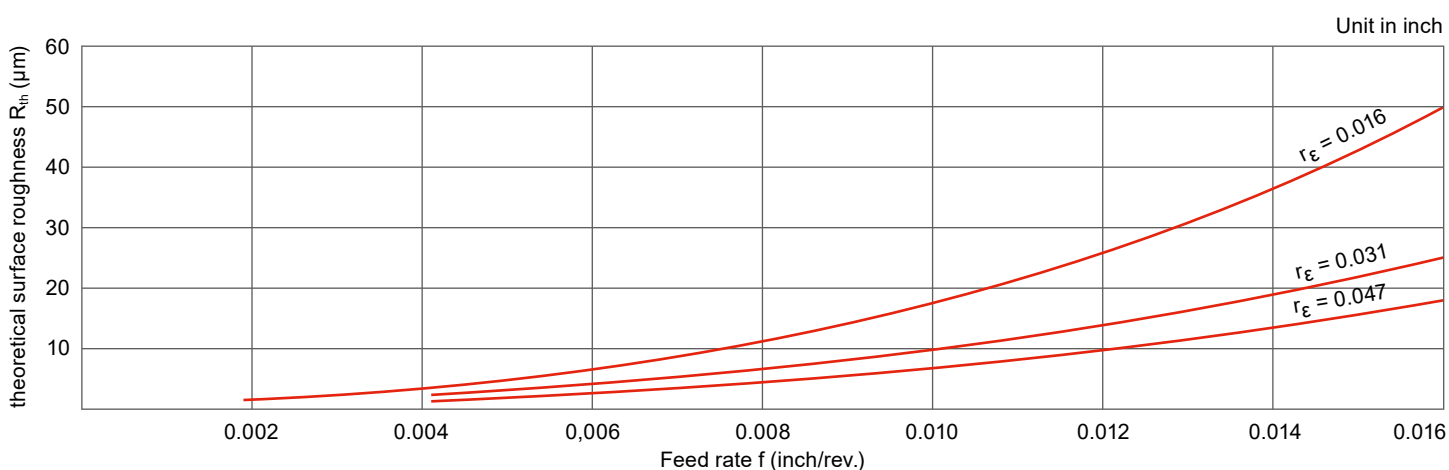
Theoretical surface quality



$$R_{th \max.} = \left(r_{\epsilon} - \sqrt{r_{\epsilon}^2 - \frac{f^2}{4}} \right) \times 1000 \text{ (}\mu\text{m)}$$

Or approximately:

$$R_{th \max.} \approx \frac{125 \times f^2}{r_{\epsilon}} \text{ (}\mu\text{m)}$$



Feed rate guide values for surface quality

Average surface roughness R_z (μm)	theoretical surface roughness R_{th} (μm)	entspricht Mittenrauwert R_a (μm)	Roughness index	ISO 1302	Corner radius r_{ϵ} in inch and feed rate f in inch/rev.						
					RE = 0.004"	RE = 0.008"	RE = 0.016"	RE = 0.032"	RE = 0.048"	RE = 0.064"	RE = 0.094"
63 – 100	$\sqrt{R_{th}63}$	12.5 – 25	N11	$\frac{25}{\nabla}$	0.008*	0.012*	0.018*	0.025	0.031	0.035	0.043
40 – 63	$\sqrt{R_{th}40}$	6.3 – 12.5	N10	$\frac{12.5}{\nabla}$	0.007*	0.010*	0.014	0.02	0.024	0.028	0.035
31.5 – 40	$\sqrt{R_{th}31.5}$	4.9 – 6.3	N9	$\frac{6.3}{\nabla}$	0.006*	0.008*	0.013	0.018	0.022	0.025	0.031
25 – 31.5	$\sqrt{R_{th}25}$	4.0 – 4.9			0.005	0.008*	0.011	0.016	0.019	0.022	0.027
16 – 25	$\sqrt{R_{th}16}$	2.5 – 4.0	N8	$\frac{3.2}{\nabla}$	0.004*	0.006	0.009	0.013	0.015	0.018	0.022
10 – 16	$\sqrt{R_{th}10}$	1.6 – 2.5			0.004	0.005	0.007	0.01	0.012	0.014	0.017
6.3 – 10	$\sqrt{R_{th}6.3}$	1.0 – 1.6	N7	$\frac{1.6}{\nabla}$	0.003	0.004	0.006	0.008	0.01	0.011	0.014
4 – 6.3	$\sqrt{R_{th}4}$	0.8 – 1.0	N6	$\frac{0.8}{\nabla}$	0.002	0.003	0.004	0.006	0.008	0.009	0.011
2.5 – 4	$\sqrt{R_{th}2.5}$	0.4 – 0.8	N5	$\frac{0.4}{\nabla}$	0.002	0.002	0.004	0.005	0.006	0.007	0.009
1.6 – 2.5	$\sqrt{R_{th}1.6}$	0.2 – 0.4	N4	$\frac{0.2}{\nabla}$	0.002	0.002	0.003	0.004	0.005	0.006	0.007
1 – 1.6	$\sqrt{R_{th}1}$	0.1 – 0.2	N3	$\frac{0.1}{\nabla}$	0.001	0.002	0.002	0.003	0.004	0.004	0.006

*Please ensure that the feed rate values used do not exceed the corner radius (RE).

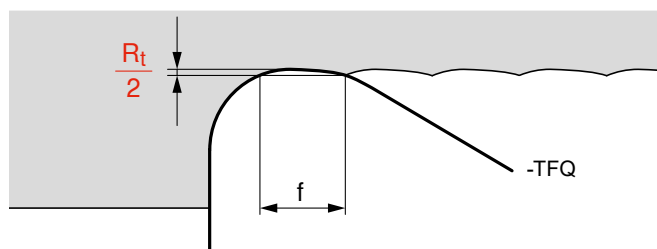
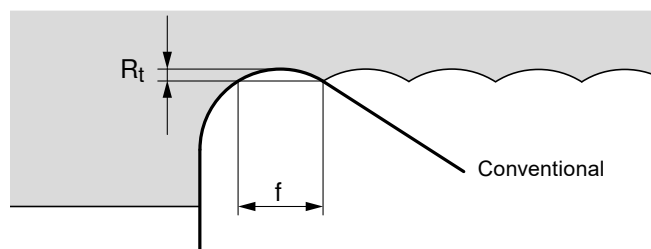
Wiper geometry

High-quality surfaces can be produced using indexable inserts with wiper geometry (-TFQ; -TMQ; -SMQ; -25Q).

Relationship of feed rate to surface roughness

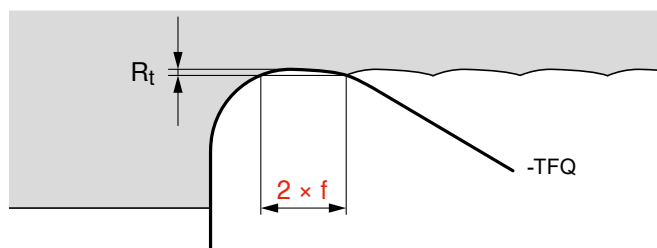
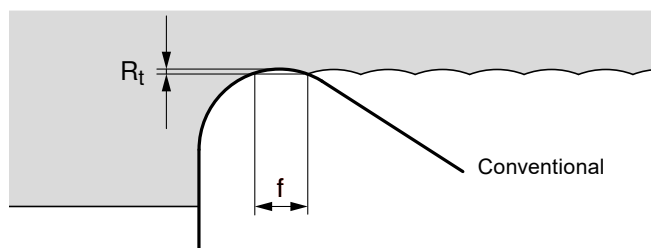
Improved surface quality

Given identical feed rates, the indexable insert with wiper geometry attains an R_t value that is many times better than a conventional indexable insert.

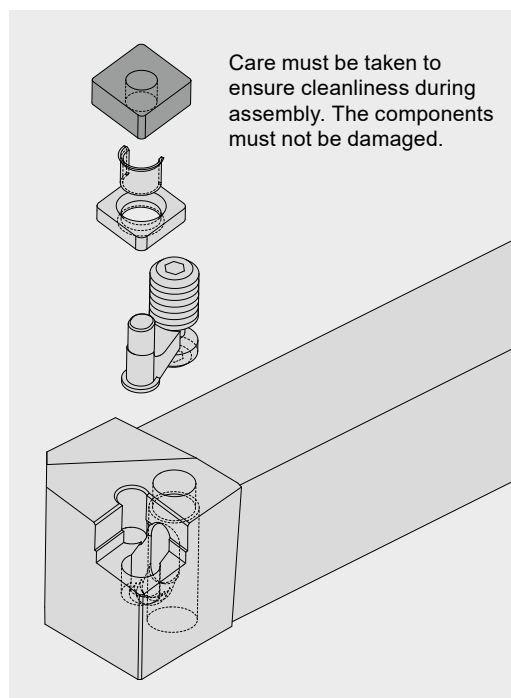
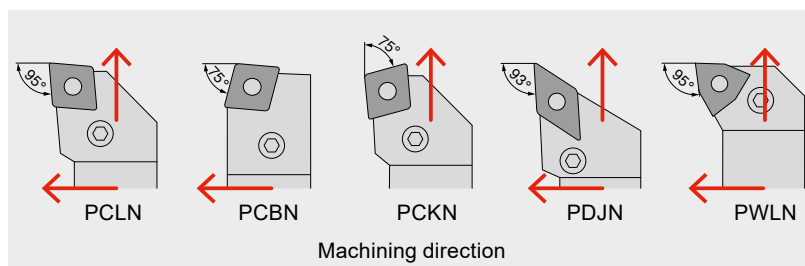
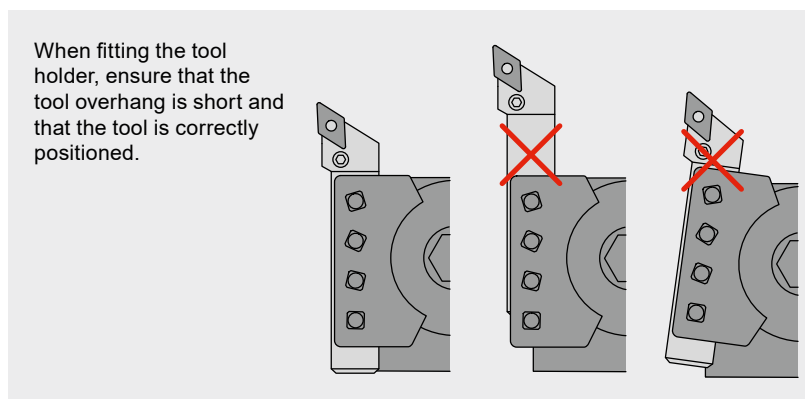


Shorter machining time

If the same R_t value is achieved as with a standard indexable insert, the indexable insert with the wiper geometry can be moved at twice the feed speed (= **lower cycle times!**)



All turning inserts with wiper geometry are clamped in standard ISO tool holders



→ Clamping systems

ISO designation system for indexable inserts

metrisch	C	N	M	G	12	04	08	E	N							-	M50
inch	C	N	M	G	4	3	2	E	N							-	M50
Indexable inserts, CBN, ceramic – metric	C	N	G	A	12	04	08	S	N	-	020D	-	B	3	-	Q	
Indexable inserts, CBN, ceramic – imperial	C	N	G	A	4	3	2	S	N	-	020D	-	B	3	-	Q	
	1	2	3	4	5	6	7	8	9		10		11	12		13	



Insert shape			Clearance angle		Tolerances								Feature			
1			2		3								4			
A		85°											A			
B		82°											B			
C		80°											C			
D		55°											F			
E		75°											G, P			
H		120°											H			
K		55°											J			
L		90°											M, P			
M		86°											N			
O		135°											Q			
R			R													
S		90°	T													
T		60°	U													
V		35°	W													
W		80°	X	Special version						Änderungen bei IC < als 1/4"						
													inch			
													IC > 1/4"		IC < 1/4"	
													N / R / F		E	
													A / M / G		D	
													X		X	

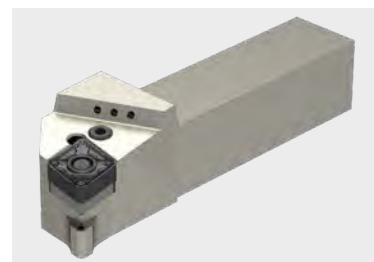
* Dependent on the insert size

Cutting length																				
5																				
Form	ISO	ANSI	L		IC		Form	ISO	ANSI	L		IC		Form	ISO	ANSI	L		IC	
			mm	inch	mm	inch				mm	inch	mm	inch				mm	inch	mm	inch
	06	2	6,4	.250	6,35	.250		07	2	7,7	.303	6,35	.250		06	2	6,35	.250	6,35	.250
	09	3	9,7	.382	9,525	.375		11	3	11,6	.457	9,525	.375		08	-	8,0	.315	8,0	.315
	12	4	12,9	.508	12,70	.500		15	4	15,5	.610	12,70	.500		09	3	9,52	.375	9,52	.375
	16	5	16,1	.634	15,875	.625		06	1.2	6,9	.272	3,97	.156		10	-	10,0	.394	10,0	.394
	19	6	19,3	.760	19,05	.750		09	1.8	9,6	.378	5,56	.219		12*	-	12,0	.472	12,0	.472
	25	8	25,8	1.016	25,4	1.000		11	2	11,0	.433	6,35	.250		12	4	12,7	.488	12,70	.488
	32	12	35,24	1.269	31,75	1.250		16	3	16,5	.650	9,525	.375		15	5	15,875	.625	15,875	.625
	06	2	6,35	.250	6,35	.250		27	5	27,5	1.083	15,875	.625		16	-	16,0	.630	16,0	.630
	09	3	9,525	.375	9,525	.375		33	6	33,0	1.299	19,05	.750		19	6	19,05	.750	19,05	.750
	12	4	12,7	.500	12,7	.500		11	2	11,1	.437	6,35	.250		25	8	25,0	.984	25,0	.984
	15	5	15,875	.625	15,875	.625		16	3	16,6	.653	9,525	.375		25*	-	25,4	1.000	25,4	1.000
	19	6	19,05	.750	19,05	.750		22	4	22,10	.870	12,70	.500		31	10	31,75	1.250	31,75	1.250
	25	8	25,4	1.000	25,4	1.000		06	3	6,5	.256	9,525	.375	32	-	32,0	1.260	32,0	1.260	
	31	10	31,75	1.250	31,75	1.250			08	4	8,7	.331	12,70	.039	* inch version					
							10		5	10,9	.429	15,875	.625							

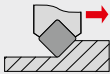
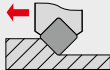
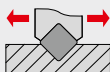
Insert thickness			Corner radius			Cutting edge		Direction of cut		Chamfer design		Number of cutting edges			
6			7			8		9		10		11			
ISO	ANSI	S	ISO	ANSI	RE	E	F	L	N	b	y	A	B	C	D
		mm			mm	Rounded	Sharp			mm	inch				
01	1	1,59	00	X0	≤ 0,05	Double-chamfered				015	0,15	00	025	0,25	010
02	1.5	2,38	01	0	0,1	Double-chamfered and rounded				020	0,20	008	025	0,25	010
03	2	3,18	02	.5	0,2	Round chamfer				050	0,50	020	075	0,75	030
T3	2.5	3,97	08	2	0,8	Chamfered and rounded				075	0,75	030	100	1,00	040
04	3	4,76	12	3	1,2	Chamfered				100	1,00	040			
05	3.5	5,56	16	4	1,6					* Two letters are assigned for double-chamfered cutting e.g., BE = Chamfer angle 1 (y ₁) = 10° Chamfer angle 2 (y ₂) = 25°		Segment length		Grade description	
06	4	6,35	20	5	2,0										
07	5	7,94	24	6	2,4					With CBN and PCD Segment direction				Here you will find a detailed chip groove description.	
09	6	9,52	28	7	2,8										
			32	8	3,2										

ISO designation system for tool holders

	P	C	L	N	R	20	20	K	12	-	T
HSK-T63	-	D	C	L	N	R			-12		
0	1	2	3	4	5	6	7	8	9		10



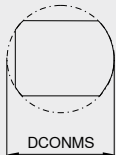
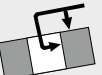
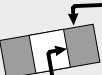
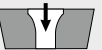
System/size	Tool holders	Insert shape	Holder shape	Clearance angle
0	1	2	3	4
HSK-T to ISO 12164 HSK-T63 = 63 mm HSK-T100 = 100 mm	C Retained from above D Retained from above and via hole M Retained from above and via hole P Retained via hole S Bolted on via hole X Special version	A 85° B 82° C 80° D 55° E 75° H 120° K 55° L 90° M 86° O 135° R 90° S 90° T 60° V 35° W 80°	A 90° B 75° C 90° D 45° E 60° F 90° G 90° H 107,5° J 93° K 75° L 95° M 50° N 63° P 117,5° R 75° S 45° T 60° U 93° V 72,5° W 60° Y 85°	A 3° B 5° C 7° D 15° E 20° F 25° G 30° N 0° O Clearance angle not included in the standard, for which particular information is required. P 11°

Direction of cut	Shank height	Shank width	Tool length						
5	6	7	8						
<div>R</div> 				OAL			OAL		
<div>L</div> 				mm	inch		mm	inch	
<div>N</div> 			<div>A</div>	32	4.000	<div>N</div>	160	4.500	
			<div>B</div>	40	4.500	<div>P</div>	170	5.500	
			<div>C</div>	50	5.000	<div>Q</div>	180	–	
			<div>D</div>	60	6.000	<div>R</div>	200	6.000	
			<div>E</div>	70	7.000	<div>S</div>	250	7.000	
			<div>F</div>	80	8.000	<div>T</div>	300	8.000	
			<div>G</div>	90	5.500	<div>U</div>	350	5.500	
			<div>H</div>	100	5.625	<div>V</div>	400	3.500	
			<div>J</div>	110	5.300	<div>W</div>	450	3.500	
			<div>K</div>	125	14.000	<div>Y</div>	500	3.750	
			<div>L</div>	140	6.800	<div>X</div>	Special version		
			<div>M</div>	150	4.400				

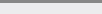
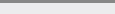
Cutting length	Manufacturer specification
9	10
	T = Toggle lever Special length (mm) Insert thickness (differs from standard) Special version (X..) Machine manufacturer (specific) DC = DirectCooling

		A	25	R		P	C	L	N	R		12	
HSK-T63	-		50	Q	-	D	C	L	N	R	-	12	
0		1	2	3		4	5	6	7	8		9	10



System/size	Shank type	Shank Ø	Tool length		Tool holders													
0	1	2	3		4													
HSK-T to ISO 12164 HSK-T63 = 63 mm HSK-T100 = 100 mm	A Steel shank with coolant hole		OAL			C  Retained from above												
	B Steel shank with vibration damping			F 80 3		D  Retained from above and via hole												
	C Carbide shank with steel head			H 100 3,5			M  Retained from above and via hole											
	D Steel shank with coolant hole and vibration damping		J 110 4	P  Retained via hole														
	E As C with coolant hole		K 125 4,5					S  Bolted on via hole										
	F As C with vibration damping		L 140 5						X Special version									
	G As C with coolant hole and vibration damping		M 150 5,5							X Special version								
	H Heavy metal		N 160 6								X Special version							
	J Heavy metal with coolant hole		P 170 6,5									X Special version						
	S Steel shank		Q 180 6,75										X Special version					
			R 200 7											X Special version				
			S 250 8												X Special version			
			T 300 10													X Special version		
			U 350 12														X Special version	
			V 400 14															X Special version
			W 450 16															
		Y 500 18	X Special version															
		20			X Special version													
		X Special version		X Special version														
						X Special version												
							X Special version											
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Insert shape			Holder shape			Clearance angle		Direction of cut								
5			6			7		8								
A		85°	M		86°	F		90°	Q		107,5°	W		60°	R	
B		82°	O		135°	K		75°	S		45°	X		*) 93°		
C		80°	R													
D		55°	S		90°											
E		75°	T		60°											
H		120°	V		35°	L		95°	U		93°	Y		85°	L	
K		55°	W		80°	*) CERATIZIT factory standard										
L		90°														
						Clearance angle not included in the standard, for which particular information is required.										
						O										
						P 11°										

Cutting length										Manufacturer specification
9										10
										<p>T = Toggle lever</p> <p>Special length (mm)</p> <p>Insert thickness (differs from standard)</p> <p>Special version (X..)</p> <p>Machine manufacturer (specific)</p>

Types of wear

Flank wear



Abrasion on the flank: normal wear after a certain period of operation.

Cause

- ▲ Cutting speed too high
- ▲ Carbide grade does not have enough wear resistance
- ▲ Feed not adapted to application

Solution

- ▲ Reduce cutting speed
- ▲ Select a carbide grade with high wear resistance
- ▲ Bring feed into the right relationship with cutting speed and cutting depth

Chipping



Increased mechanical stress on the cutting edge may result in carbide particles breaking off.

Cause

- ▲ Grade with too high a wear resistance
- ▲ Vibrations
- ▲ Feed or cutting depth is too high
- ▲ Interrupted cut
- ▲ Chip stroke

Solution

- ▲ Use tougher grade
- ▲ Use negative cutting edge geometry with a chip breaker
- ▲ Improve stability (tool, workpiece)

Crater wear



The outgoing hot chip is causing cratering of the cutting insert on the clamping flat.

Cause

- ▲ Cutting speed, feed, or both are too high
- ▲ Rake angle too low
- ▲ Grade does not have enough wear resistance
- ▲ Insufficient coolant supply

Solution

- ▲ Reduce cutting speed and/or feed
- ▲ Choose carbide grade with greater wear resistance
- ▲ Increase quantity and/or pressure of coolant, check supply
- ▲ Use more crater-resistant grade

Plastic deformation



High machining temperature with simultaneous mechanical stress can lead to plastic deformation.

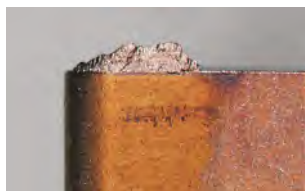
Cause

- ▲ Working temperature too high resulting in softening of the base material
- ▲ Damage to the coating
- ▲ Grade does not have enough wear resistance
- ▲ Insufficient coolant supply

Solution

- ▲ Reduce cutting speed
- ▲ Choose carbide grade with greater wear resistance
- ▲ Make provisions for cooling

Built-up edge formation



Material builds up on the cutting edge if the chip does not flow correctly due to the cutting temperature being too low.

Cause

- ▲ Cutting speed too low
- ▲ Rake angle too small
- ▲ Incorrect cutting material
- ▲ Lack of cooling/lubrication

Solution

- ▲ Increase cutting speed
- ▲ Increase rake angle
- ▲ Use TiN coating
- ▲ Use thicker emulsion

Edge breakage



If a cutting insert is overloaded, insert breakage may occur.

Cause

- ▲ Overload of the cutting material
- ▲ Lack of stability
- ▲ Wedge angle too small

Solution

- ▲ Use a tougher cutting material
- ▲ Use chamfer for edge protection
- ▲ Increase rounding of cutting edge
- ▲ Use more stable geometry

Recommendation for optimum results

Task description												Solution, measures	
Type of wear						Workpiece problems				Chip control		Explanation of symbols	
Flank wear	Crater wear	Chipping	Plastic deformation	Edge breakage	Built-up edge	Vibrations	Formation of pits and burrs	Chattered surface	Surface quality	Chip too long (snarl chip)	Chip too short (fragmented chip)		
												Raise, increase Large influence	↑
												Raise, increase Small influence	↑
												Avoid, reduce Large influence	↓
												Avoid, reduce Small influence	↓
												check, optimize	~
												Use	●
↓	↓		↓		↑	↓			↑	↓		Cutting speed	Cutting data
~		↓	↓	↓		↑		↓	↓	↑	↓	Feed	
↓	↓	↓	↓				↓	↓	↓			Feed rate at center	
		↑	~		↓	~	↓	↓	↓	↓	↑	Chip breaker	Indexable insert selection
↑		↑	↑	↑		↓	↓	↓	↑			Corner radius	
↑	↑	↓	↑	↓								Cutting material	
		~		~		~		~	~			Tool clamping	General criteria
		~		~		~		~	~			Workpiece clamping	
		~		~		~			↓			Overhang	
~		~				~	~		~			Tip height	
●	~		●		●		●		●	●		Cooling lubricant	

Grade description

Grades		ISO application range															Grade description	
Main application ● Secondary application ○		○ V _c + Wear-resistantV _c - ● Tough															Specification / Application recommendation	
TCM407	P ●																Specification: Composition: Co 8.0%; WC 16.0%; TaNbC 10.0%; TiCN balance Grain size: 2-3 μm Hardness: HV ₃₀ 1760 Usage recommendation: The uncoated cermet grade for fine finishing steel materials.	
	M ○																	
	K ○																	
	N																	
	S																	
	H																	
	O																	
CTEP110 DRAGONSKIN	P ●																Specification: Composition: Co/Ni 12.2%; WC 15.0%; TaNbC 10.0%; TiCN balance Grain size: 2-3 μm Hardness: HV ₃₀ 1650 Layer system: CVD TiCN-Al ₂ O ₃ multilayer Usage recommendation: The cermet grade with reserves of toughness for finish machining at high cutting speeds.	
	M ○																	
	K ○																	
	N																	
	S																	
	H																	
	O																	
TCM10	P ●																Specification: Composition: Cermet Co/Ni 12.2%; WC 15.0%; TaNbC 10.0%; TiCN balance Grain size: 2-3 μm Hardness: HV ₃₀ 1650 Usage recommendation: The uncoated cermet grade for finishing steel, stainless steel, and hardened steel.	
	M ○																	
	K ○																	
	N																	
	S																	
	H																	
	O																	
CTCK110-P DRAGONSKIN	P ●																Specification: Composition: Co 5.0%, mixed carbides 2.0%, WC balance Grain size: 1-2 μm Hardness: HV ₃₀ 1730 Layer system: CVD TiCN-Al ₂ O ₃ -TiN Usage recommendation: The wear-resistant grade for machining cast iron materials and steels at high cutting speeds with a continuous cut.	
	M																	
	K ●																	
	N																	
	S																	
	H																	
	O																	
CTCK120-P DRAGONSKIN	P ●																Specification: Composition: Co 6.0%, mixed carbides 2.0%, WC balance Grain size: 1 μm Hardness: HV ₃₀ 1630 Layer system: CVD TiCN-Al ₂ O ₃ -TiN Usage recommendation: The grade for cast iron machining with high toughness reserves for difficult conditions and interrupted cuts.	
	M																	
	K ●																	
	N																	
	S																	
	H																	
	O																	
CTCP115-P DRAGONSKIN	P ●																Specification: Composition: Co 5.5%; mixed carbides 6.5%; WC balance Grain size: 1 μm Hardness: HV ₃₀ 1530 Layer system: CVD TiCN-Al ₂ O ₃ Usage recommendation: The wear-resistant high-performance grade for steel machining with stable conditions and a continuous cut.	
	M																	
	K ○																	
	N																	
	S																	
	H																	
	O																	
CTCP125-P DRAGONSKIN	P ●																Specification: Composition: Co 7.0%, mixed carbides 6.0%, WC balance Grain size: 1-2 μm Hardness: HV ₃₀ 1500 Layer system: CVD TiCN-Al ₂ O ₃ Usage recommendation: The first choice for the universal machining of steels.	
	M																	
	K ○																	
	N																	
	S																	
	H																	
	O																	
CTCP135-P DRAGONSKIN	P ●																Specification: Composition: Co 9.6%, mixed carbides 7.8%, WC balance Grain size: 1-2 μm Hardness: HV ₃₀ 1460 Layer system: CVD TiCN-Al ₂ O ₃ Usage recommendation: The tough alternative for extremely interrupted cutting conditions.	
	M ○																	
	K																	
	N																	
	S																	
	H																	
	O																	

01 05 10 15 20 25 30 35 40 45 50

Grade description

Grades		ISO application range															Grade description	
Main application ● Secondary application ○		○ V _C + Wear-resistantV _C – Tough															Specification / Application recommendation	
		0105101520253035404550																
CTCM120 DRAGONSkin	P	○															Specification: Composition: Co 7%, mixed carbides 6%, WC balance Grain size: 1-2 μm grain size Hardness: HV ₃₀ 1500 Layer system: CVD TiCN-Al ₂ O ₃ Usage recommendation: Wear-resistant carbide grade for austenitic, stainless steel with the best levels of performance with a smooth cut.	
	M	●																
	K	○																
	N	○																
	S	○																
	H	○																
	O	○																
CTPM125 DRAGONSkin	P	○															Specification: Composition: Co 7%, mixed carbides 6%, WC balance Grain size: 1-2 μm grain size Hardness: HV ₃₀ 1500 Layer system: CVD TiCN-Al ₂ O ₃ Usage recommendation: Wear-resistant carbide grade for austenitic, stainless steel with the best levels of performance with a smooth cut.	
	M	●																
	K	○																
	N	○																
	S	○																
	H	○																
	O	○																
CTCM130 DRAGONSkin	P	○															Specification: Composition: Co 9.6%, mixed carbides 7.8%, WC balance Grain size: 1-2 μm grain size Hardness: HV ₃₀ 1460 Layer system: CVD TiCN-Al ₂ O ₃ Usage recommendation: Tough turning grade for austenitic, stainless steel with interrupted cutting conditions.	
	M	●																
	K	○																
	N	○																
	S	○																
	H	○																
	O	○																
H210T	P	○															Specification: Composition: Co 6.0%; WC balance Grain size: 0.8 μm Hardness: HV ₃₀ 1850 Application recommendation: The wear-resistant, uncoated carbide grade for machining aluminum and other non-ferrous metals.	
	M	○																
	K	○																
	N	○																
	S	○																
	H	○																
	O	○																
H10T	P	○															Specification: Composition: Co 6.0%; WC balance Grain size: 1 μm Hardness: HV ₃₀ 1630 Recommended application: The uncoated carbide grade for the machining of aluminium and other non-ferrous metals	
	M	○																
	K	○																
	N	○																
	S	○																
	H	○																
	O	○																
H216T	P	○															Specification: Composition: Co 6.0%; WC balance Grain size: 1 μm Hardness: HV ₃₀ 1630 Recommended application: The uncoated carbide grade for the machining of aluminium and other non-ferrous metals	
	M	○																
	K	○																
	N	○																
	S	○																
	H	○																
	O	○																
CTPX710 DRAGONSkin	P	○															Specification: Composition: Co 6.0%; WC balance Grain size: 0.8 μm Hardness: HV ₃₀ 1820 Layer system: PVD AlTiN Usage recommendation: The universal carbide grade for the most demanding machining requirements for multiple materials.	
	M	○																
	K	○																
	N	○																
	S	○																
	H	○																
	O	○																
CTPX715 DRAGONSkin	P	○															Specification: Composition: Co 6.0%; WC balance Grain size: 1 μm Hardness: HV ₃₀ 1650 Layer system: PVD AlTiN Usage recommendation: The universal carbide grade for the most demanding machining requirements for multiple materials.	
	M	○																
	K	○																
	N	○																
	S	○																
	H	○																
	O	○																

Designation key

C

T

C

P

1

2

5

-P

(Example)

CT

CERATIZIT

-P

(Performance)

Coating

W

Carbide, uncoated

C

CVD-coated carbide

P

PVD-coated carbide

T

Cermet, uncoated

E

Cermet, coated

N

Silicon nitride, uncoated

M

Silicon nitride, coated

Main application - material

P

Steel

M

Stainless steel

K

Cast iron

N

Non-ferrous metals

S

Heat-resistant

H

Hardened steel

O

Non-metal materials

X

Universal application

Process

1

Turning

2

Milling

3

Grooving

4

Drilling

5

Thread turning

6

Other

7

Several processes

Degree of hardness

05

ISO 05

10

ISO 10

15

ISO 15

20

ISO 20

25

ISO 25

30

ISO 30

35

ISO 35

40

ISO 40

○

↕

□

Diamond as a cutting material



Ensures

- ▲ Optimal surface quality
- ▲ Burr-free workpieces
- ▲ Long tool life
- ▲ Lowest cutting forces
- ▲ High process security

Complete program of roughing, finishing, and wiper inserts for machining aluminum, non-ferrous metals, plastics, ...

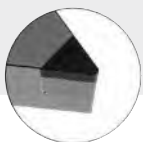
The cutting materials

	CTD CD10 (CVD)	CTD PD20 (PKD)	CTD PU20 (PKD)	CTD PS30 (PKD)
	Fine grain grade (N10)	Fine grain grade (N20)	Coarse grain grade (N20)	Coarse grain grade (N30)
Characteristics	<ul style="list-style-type: none"> ▲ Optimum sharpness of the cutting edges ▲ No cutting pressure ▲ Very tight tolerances ▲ Maximum wear resistance with increased toughness ▲ Very high thermal conductivity 	<ul style="list-style-type: none"> ▲ Good cutting edge sharpness ▲ Lower cutting pressure than with PDC-S ▲ Tight tolerances ▲ Low wear resistance with increased toughness 	<ul style="list-style-type: none"> ▲ Good cutting edge sharpness ▲ Reduced cutting pressure ▲ Tight tolerances ▲ Very high level of wear resistance and toughness 	<ul style="list-style-type: none"> ▲ Good cutting edge sharpness ▲ Reduced cutting pressure ▲ Tight tolerances ▲ Lower wear resistance than with PDC, with increased toughness
Material	Suitable for super-finishing to semi-finishing all non-ferrous metals and non-ferrous composite materials with low to high proportions of abrasive fillers	Suitable for fine finishing and finishing all non-ferrous materials with low proportions of abrasive fillers	Suitable for finishing to roughing non-ferrous metals and non-ferrous materials with highly abrasive fillers. High chip removal volume on fiber-reinforced plastics such as CFRP and GFRP	Suitable for fine finishing and finishing all non-ferrous materials and non-ferrous metals with low to very high proportions of abrasive fillers

Cutting edge geometries

Neutral rake angle:

- ▲ Higher cutting pressure
- ▲ Higher cutting temperature
- ▲ Improved surface quality
- ▲ For more stable workpieces



Positive rake angle: 5° / 7°

- ▲ Lower cutting pressure
- ▲ Lower cutting temperature
- ▲ Slight reduction in surface quality
- ▲ For unstable workpieces
- ▲ Improved dimensional stability



CB chip breaker geometries:

- ▲ Reliable chip control
- ▲ Ideal for low-alloy aluminum
- ▲ For F | M | R applications



Notes on diamond usage

- ▲ Coolant is not generally needed, however it does facilitate chip removal
- ▲ Note the chemical reaction to carbide-forming elements (PCD)
- ▲ Note the thermal interaction and critical temperature:
PCD: 600 °C (1112 °F), CVD: 700 °C (1292 °F)
Depending on the material, use cooling.

Cutting data standard values – VertiClamp system

Index	Parting off				Longitudinal turning				
	WPU7620	Fine	Medium	Coarse	WPU7620		Fine	Medium	Coarse
	v_c in m/min	f	f	f	v_c in m/min	a_p in mm	f	f	f
P.1.1	80	0,005-0,080	0,02-0,15	0,10-0,25	80	< 3	0,005-0,080	0,02-0,15	0,10-0,25
P.1.2	75	0,005-0,080	0,02-0,15	0,10-0,25	75	< 3	0,005-0,080	0,02-0,15	0,10-0,25
P.1.3	75	0,005-0,080	0,02-0,15	0,10-0,25	75	< 3	0,005-0,080	0,02-0,15	0,10-0,25
P.1.4	75	0,005-0,080	0,02-0,15	0,10-0,25	75	< 3	0,005-0,080	0,02-0,15	0,10-0,25
P.1.5	75	0,005-0,080	0,02-0,15	0,10-0,25	75	< 3	0,005-0,080	0,02-0,15	0,10-0,25
P.2.1	75	0,005-0,080	0,02-0,15	0,10-0,25	75	< 3	0,005-0,080	0,02-0,15	0,10-0,25
P.2.2	75	0,005-0,080	0,02-0,15	0,10-0,25	75	< 3	0,005-0,080	0,02-0,15	0,10-0,25
P.2.3	75	0,005-0,080	0,02-0,15	0,10-0,25	75	< 3	0,005-0,080	0,02-0,15	0,10-0,25
P.2.4	75	0,005-0,080	0,02-0,15	0,10-0,25	75	< 3	0,005-0,080	0,02-0,15	0,10-0,25
P.3.1	75	0,005-0,080	0,02-0,15	0,10-0,25	75	< 3	0,005-0,080	0,02-0,15	0,10-0,25
P.3.2	75	0,005-0,080	0,02-0,15	0,10-0,25	75	< 3	0,005-0,080	0,02-0,15	0,10-0,25
P.3.3	75	0,005-0,080	0,02-0,15	0,10-0,25	75	< 3	0,005-0,080	0,02-0,15	0,10-0,25
P.4.1	75	0,005-0,080	0,01-0,12	0,10-0,20	75	< 2,5	0,005-0,080	0,01-0,12	0,10-0,20
P.4.2	75	0,005-0,080	0,01-0,12	0,10-0,20	75	< 2,5	0,005-0,080	0,01-0,12	0,10-0,20
M.1.1	55	0,005-0,080	0,01-0,12	0,10-0,20	55	< 2,5	0,005-0,080	0,01-0,12	0,10-0,20
M.2.1	55	0,005-0,080	0,01-0,12	0,10-0,20	55	< 2,5	0,005-0,080	0,01-0,12	0,10-0,20
M.3.1	55	0,005-0,080	0,01-0,12	0,10-0,20	55	< 2,5	0,005-0,080	0,01-0,12	0,10-0,20
K.1.1	70	0,005-0,080	0,01-0,12	0,10-0,20	70	< 2,5	0,005-0,080	0,01-0,12	0,10-0,20
K.1.2	70	0,005-0,080	0,01-0,12	0,10-0,20	70	< 2,5	0,005-0,080	0,01-0,12	0,10-0,20
K.2.1	70	0,005-0,080	0,01-0,12	0,10-0,20	70	< 2,5	0,005-0,080	0,01-0,12	0,10-0,20
K.2.2	70	0,005-0,080	0,01-0,12	0,10-0,20	70	< 2,5	0,005-0,080	0,01-0,12	0,10-0,20
K.3.1	70	0,005-0,080	0,01-0,12	0,10-0,20	70	< 2,5	0,005-0,080	0,01-0,12	0,10-0,20
K.3.2	70	0,005-0,080	0,01-0,12	0,10-0,20	70	< 2,5	0,005-0,080	0,01-0,12	0,10-0,20
N.1.1	180	0,050-0,200	0,02-0,25	0,10-0,30	180	< 3	0,050-0,200	0,02-0,25	0,10-0,30
N.1.2	180	0,050-0,200	0,02-0,25	0,10-0,30	180	< 3	0,050-0,200	0,02-0,25	0,10-0,30
N.2.1	180	0,050-0,200	0,02-0,25	0,10-0,30	180	< 3	0,050-0,200	0,02-0,25	0,10-0,30
N.2.2	180	0,050-0,200	0,02-0,25	0,10-0,30	180	< 3	0,050-0,200	0,02-0,25	0,10-0,30
N.2.3	180	0,050-0,200	0,02-0,25	0,10-0,30	180	< 3	0,050-0,200	0,02-0,25	0,10-0,30
N.3.1	180	0,050-0,200	0,02-0,25	0,10-0,40	180	< 3	0,050-0,200	0,02-0,25	0,10-0,30
N.3.2	180	0,050-0,200	0,02-0,25	0,10-0,30	180	< 3	0,050-0,200	0,02-0,25	0,10-0,30
N.3.3	180	0,050-0,200	0,02-0,25	0,10-0,30	180	< 3	0,050-0,200	0,02-0,25	0,10-0,30
N.4.1	180	0,050-0,200	0,02-0,25	0,10-0,30	180	< 3	0,050-0,200	0,02-0,25	0,10-0,30
S.1.1	45	0,005-0,060	0,02-0,08	0,10-0,25	45	< 2,5	0,005-0,060	0,02-0,08	0,10-0,25
S.1.2	45	0,005-0,060	0,02-0,08	0,10-0,25	45	< 2,5	0,005-0,060	0,02-0,08	0,10-0,25
S.2.1	40	0,005-0,060	0,02-0,08	0,10-0,25	40	< 2,5	0,005-0,060	0,02-0,08	0,10-0,25
S.2.2	40	0,005-0,060	0,02-0,08	0,10-0,25	40	< 2,5	0,005-0,060	0,02-0,08	0,10-0,25
S.2.3									
S.3.1									
S.3.2	45	0,005-0,060	0,02-0,08	0,10-0,25	45	< 2,5	0,005-0,060	0,02-0,08	0,10-0,25
S.3.3	45	0,005-0,060	0,02-0,08	0,10-0,25	45	< 2,5	0,005-0,060	0,02-0,08	0,10-0,25
H.1.1									
H.1.2									
H.1.3									
H.1.4									
H.2.1									
H.3.1									
O.1.1	220	0,050-0,200	0,02-0,25	0,10-0,30	220	< 3	0,050-0,200	0,02-0,25	0,10-0,30
O.1.2	220	0,050-0,200	0,02-0,25	0,10-0,30	220	< 3	0,050-0,200	0,02-0,25	0,10-0,30
O.2.1									
O.2.2									
O.3.1									



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material, and type of machine. The specified values represent guideline cutting data that must be corrected according to the usage conditions!

Cutting data standard values – VertiClamp system and TriClamp system

Index	VertiClamp system				TriClamp system					
	Grooving				Longitudinal turning					
	WPU7620	Fine	Medium	Coarse	WUU7610	WPU7610	WPU7620	WUU7620		
	v_c in m/min	f	f	f	v_c in m/min				f	$a_{p\max}$ in mm
P.1.1	80	0,005-0,080	0,02-0,15	0,10-0,25	85	110	115	80	0,005-0,080	1,5
P.1.2	75	0,005-0,080	0,02-0,15	0,10-0,25	50	65	70	40	0,005-0,080	1,5
P.1.3	75	0,005-0,080	0,02-0,15	0,10-0,25	50	65	70	40	0,005-0,080	1,5
P.1.4	75	0,005-0,080	0,02-0,15	0,10-0,25	50	65	70	40	0,005-0,080	1,5
P.1.5	75	0,005-0,080	0,02-0,15	0,10-0,25	50	65	70	40	0,005-0,080	1,5
P.2.1	75	0,005-0,080	0,02-0,15	0,10-0,25	50	65	70	40	0,005-0,080	1,5
P.2.2	75	0,005-0,080	0,02-0,15	0,10-0,25	50	65	70	40	0,005-0,080	1,5
P.2.3	75	0,005-0,080	0,02-0,15	0,10-0,25	50	65	70	40	0,005-0,080	1,5
P.2.4	75	0,005-0,080	0,02-0,15	0,10-0,25	50	65	70	40	0,005-0,080	1,5
P.3.1	75	0,005-0,080	0,02-0,15	0,10-0,25	50	65	70	40	0,005-0,080	1,5
P.3.2	75	0,005-0,080	0,02-0,15	0,10-0,25	50	65	70	40	0,005-0,080	1,5
P.3.3	75	0,005-0,080	0,02-0,15	0,10-0,25	50	65	70	40	0,005-0,080	1,5
P.4.1	75	0,005-0,080	0,01-0,12	0,10-0,20	50	65	70	40	0,005-0,080	1,5
P.4.2	75	0,005-0,080	0,01-0,12	0,10-0,20	50	65	70	40	0,005-0,080	1,5
M.1.1	55	0,005-0,080	0,01-0,12	0,10-0,20		55	65		0,005-0,080	1,5
M.2.1	55	0,005-0,080	0,01-0,12	0,10-0,20		40	45		0,005-0,080	1,5
M.3.1	55	0,005-0,080	0,01-0,12	0,10-0,20		55	65		0,005-0,080	1,5
K.1.1	70	0,005-0,080	0,01-0,12	0,10-0,20		110	115		0,005-0,080	1,5
K.1.2	70	0,005-0,080	0,01-0,12	0,10-0,20		110	115		0,005-0,080	1,5
K.2.1	70	0,005-0,080	0,01-0,12	0,10-0,20		110	115		0,005-0,080	1,5
K.2.2	70	0,005-0,080	0,01-0,12	0,10-0,20		110	115		0,005-0,080	1,5
K.3.1	70	0,005-0,080	0,01-0,12	0,10-0,20		110	115		0,005-0,080	1,5
K.3.2	70	0,005-0,080	0,01-0,12	0,10-0,20		110	115		0,005-0,080	1,5
N.1.1	180	0,050-0,200	0,02-0,25	0,10-0,30	180	200	220	180	0,050-0,200	1,5
N.1.2	180	0,050-0,200	0,02-0,25	0,10-0,30	180	200	220	180	0,050-0,200	1,5
N.2.1	180	0,050-0,200	0,02-0,25	0,10-0,30	180	200	220	180	0,050-0,200	1,5
N.2.2	180	0,050-0,200	0,02-0,25	0,10-0,30	180	200	220	180	0,050-0,200	1,5
N.2.3	180	0,050-0,200	0,02-0,25	0,10-0,30	180	200	220	180	0,050-0,200	1,5
N.3.1	180	0,050-0,200	0,02-0,25	0,10-0,30	180	200	220	180	0,050-0,200	1,5
N.3.2	180	0,050-0,200	0,02-0,25	0,10-0,30	180	200	220	180	0,050-0,200	1,5
N.3.3	180	0,050-0,200	0,02-0,25	0,10-0,30	180	200	220	180	0,050-0,200	1,5
N.4.1	180	0,050-0,200	0,02-0,25	0,10-0,30	180	200	220	180	0,050-0,200	1,5
S.1.1	45	0,005-0,060	0,02-0,08	0,10-0,25	40	45	45	40	0,005-0,060	1,0
S.1.2	45	0,005-0,060	0,02-0,08	0,10-0,25	40	45	45	40	0,005-0,060	1,0
S.2.1	40	0,005-0,060	0,02-0,08	0,10-0,25	35	40	40	35	0,005-0,060	1,0
S.2.2	40	0,005-0,060	0,02-0,08	0,10-0,25	35	40	40	35	0,005-0,060	1,0
S.2.3										
S.3.1										
S.3.2	45	0,005-0,060	0,02-0,08	0,10-0,25	35	45	45	40	0,005-0,060	1,0
S.3.3	45	0,005-0,060	0,02-0,08	0,10-0,25	35	45	45	40	0,005-0,060	1,0
H.1.1										
H.1.2										
H.1.3										
H.1.4										
H.2.1										
H.3.1										
O.1.1	220	0,050-0,200	0,02-0,25	0,10-0,30	180	200	220	180	0,050-0,200	2,0
O.1.2	220	0,050-0,200	0,02-0,25	0,10-0,30	180	200	220	180	0,050-0,200	2,0
O.2.1										
O.2.2										
O.3.1										



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material, and type of machine. The specified values represent guideline cutting data that must be corrected according to the usage conditions!

Adjustment device

The adjustment device is profitable if the tool system is expanded with several tool holder blocks on several machines. The tool system can be preset so that the holder on every machine demonstrates the appropriate center height in relation to the turning center of the machine.

Adjustment device

1. Zero the dial gage on the surface of the measuring stick.



2. Place tool holder block on the device and gently tighten the clamping screw until the holder sits on the device free of play. Ideally, set the center height slightly below the center, so that the tool holder block is pushed upward when the height is set.



3. Carefully place the dial gage on the tip of the tool's cutting edge.

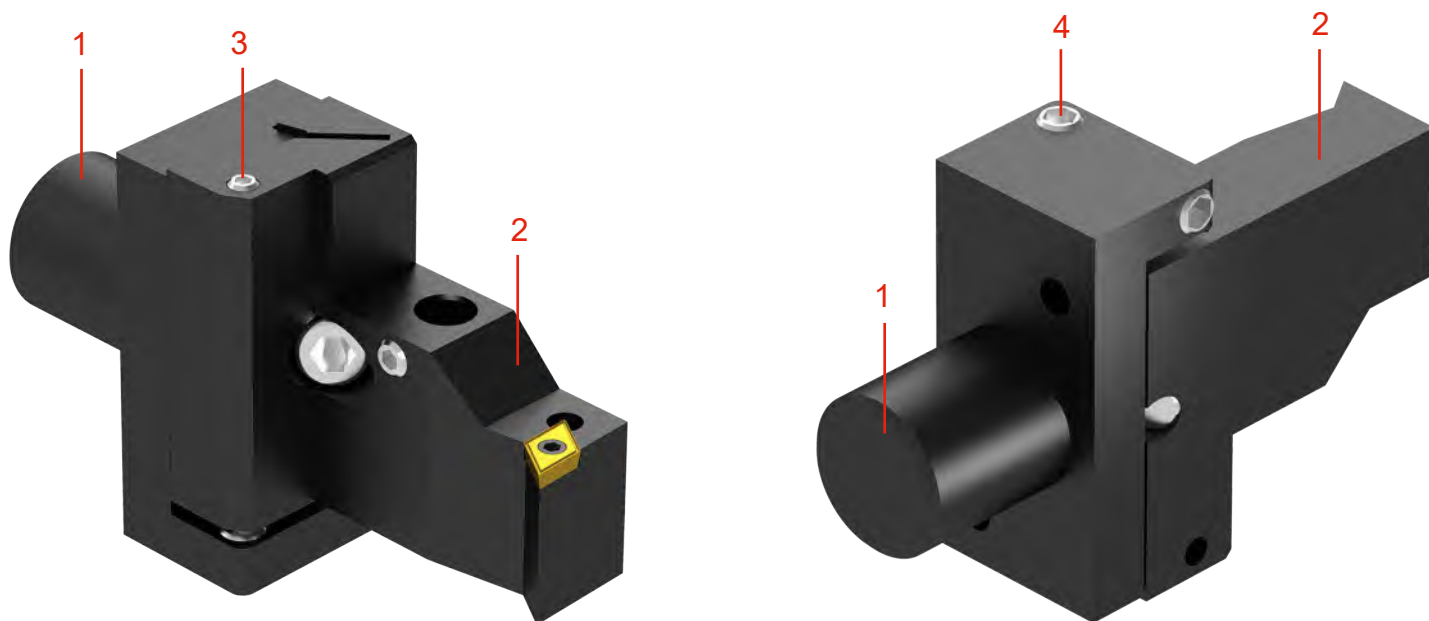


4. Adjust the height adjustment screw until the dial gage is set to zero.



Procedure when retrofitting on the CT tool system

1. Screw all base holders (1) into the machine.
2. Clamp the height-adjustable screw (4) of the individual base holders (1) and set to the same height using the dial gage.
3. Clamp a tool holder block (2) onto any base holder (1) and set precisely on the turning center using the height-adjustable screw (3) of the tool holder block (2).
4. Remove the tool holder block (2) from the machine and clamp it on the height presetting device.
5. Set the dial gage on the tool to zero and adjust the measuring pin on the presetting device.
6. Each additional tool holder block (2) is set to zero once on the presetting device using the measuring pin and dial gage.



If several tool holders are arranged side-by-side, you can quickly and reliably fix them at the same height using height adjustment screws (3) and (4).

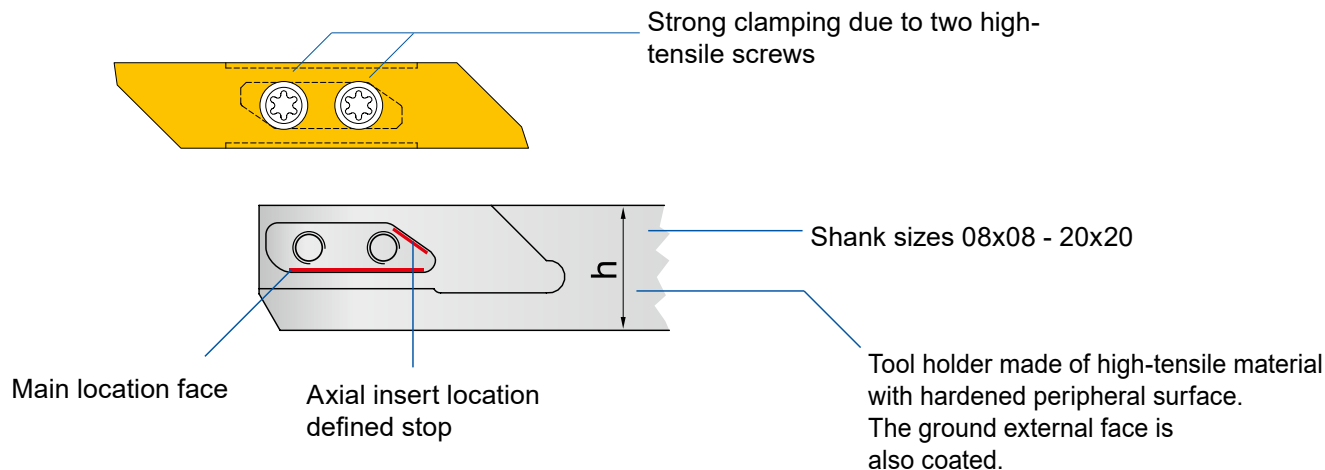
The same tool holders (2) can be used for multiple machines without presetting them again individually. However, the base holders (1) of the other machines must be adjusted to one another.

This is done as follows:

1. Screw all base holders into machine 2.
2. Clamp a preset tool block holder from machine 1 on any base holder in machine 2 and adjust the turning center precisely using the height-adjustment screw of the base holder.
3. Set all other height-adjustable screws on the rest of the base holders in machine 2 to the same height using the dial gage. The preset tool block holders can thus be used on each tool station of several machines without readjustment.

VertiClamp

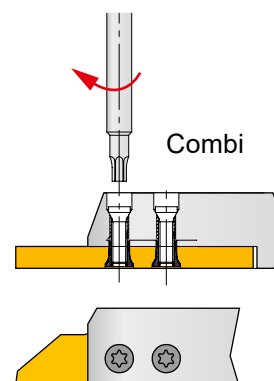
Features



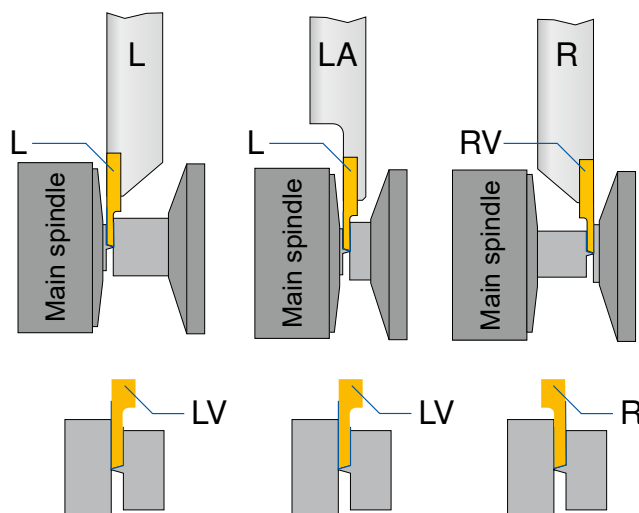
Advantages

- ▲ The connection between the indexable insert and tool holder guarantees optimum fixation
- ▲ The second cutting edge can always be used, even if the first cutting edge is broken off
- ▲ Shearing forces do not act on the screws
- ▲ For all cutting edge forms, the overhang of the cutting edge from the tool holder is identical
- ▲ Vertical insert orientation maintained thanks to large seating surface
- ▲ The indexable insert seat is completely protected from chips
- ▲ Inserts are clamped through two high-tensile screws and a tapered axial stop of 30° in all cutting directions

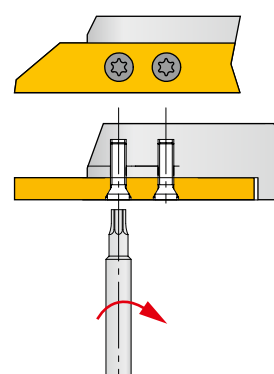
Clamping the cutting edge with combi holders



Parting off with counter spindle



Clamping the cutting edge with standard holders

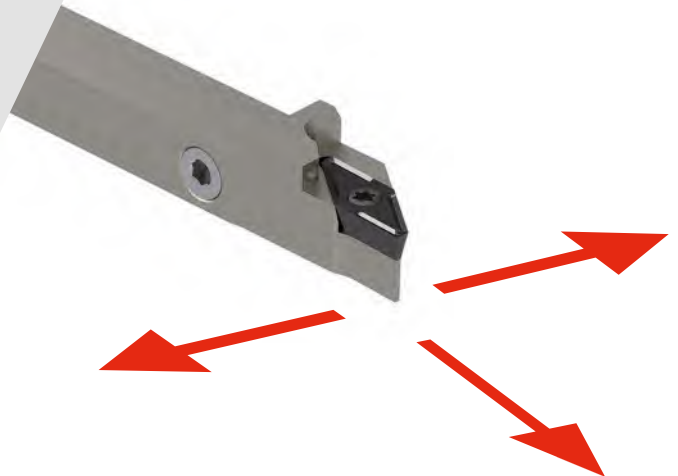


TriClamp

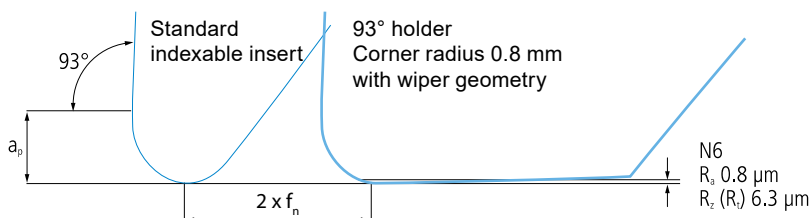
By using TriClamp with a wiper geometry and the 93° holder, it is possible to achieve up to double the feed rate. This means that machining times can be significantly reduced while maintaining the same quality, or the surface quality can be improved in the same machining time. The ability to machine in a radial direction and in both axial directions makes this system particularly flexible.

Advantages

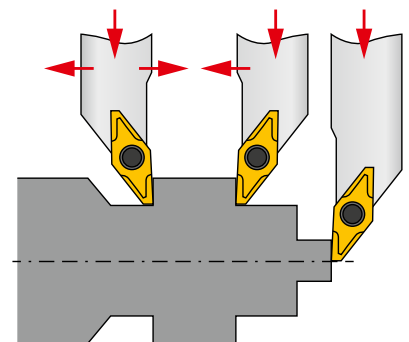
- ▲ Expansion of the ISO range
- ▲ Turning in three directions
- ▲ All cutting edges can easily be replaced
- ▲ Sharp positive edges with 11° clearance angle
- ▲ Small corner radii of 0.08 mm and 0.2 mm
- ▲ Perfect chip control
- ▲ Special holders for sliding head lathes (shanks 8x8 mm to 16x16 mm)



Wiper geometry in detail:

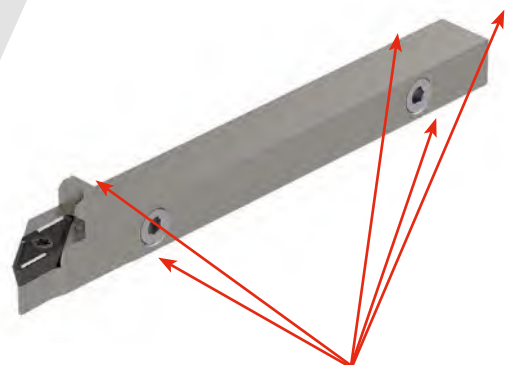


Applications:



Tool holders with a through coolant supply enhance the performance of indexable inserts and improve component quality, especially when machining difficult materials such as stainless steels and super alloys.

- ▲ All IC holders have five coolant supply options
- ▲ Made of highly tempered steel
- ▲ Precise coolant jet on the cutting edge
- ▲ Can be used at any coolant pressure



Coolant connection options

XheadClamp

Fast tool changes with high repeatability have become a competitive advantage in series production, which usually has to be carried out with the highest possible output. CERATIZIT meets this production requirement with the newly developed XheadClamp holder system. Time savings and an extremely short setup process are key advantages of the system. Furthermore, the XheadClamp system impresses with its flexibility and ease of use. Changing the indexable insert, switching to a different geometry, and changing from turning to grooving inserts can all take place quickly and easily with the XheadClamp – and with the highest precision.

Clamping

- ▲ Very high clamping forces
- ▲ Release and clamping of an exchangeable head with just one screw
- ▲ Repeatability of less than $\pm 7.5 \mu\text{m}$
- ▲ Maximum stability



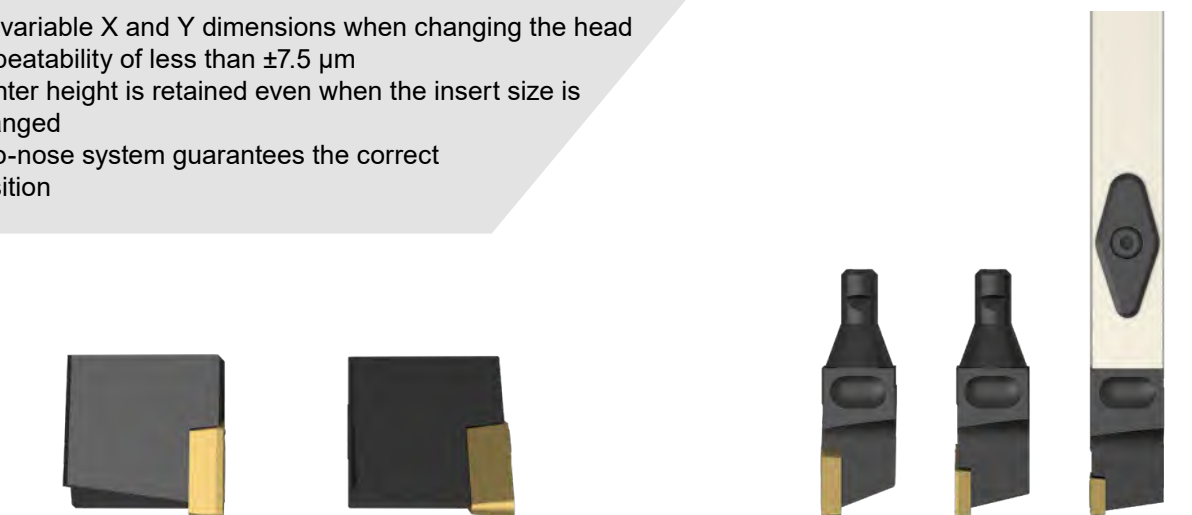
Versatility

- ▲ All heads can be installed regardless of system size
- ▲ Tools can be adapted to the component
- ▲ Fastest indexable insert change thanks to exchangeable head

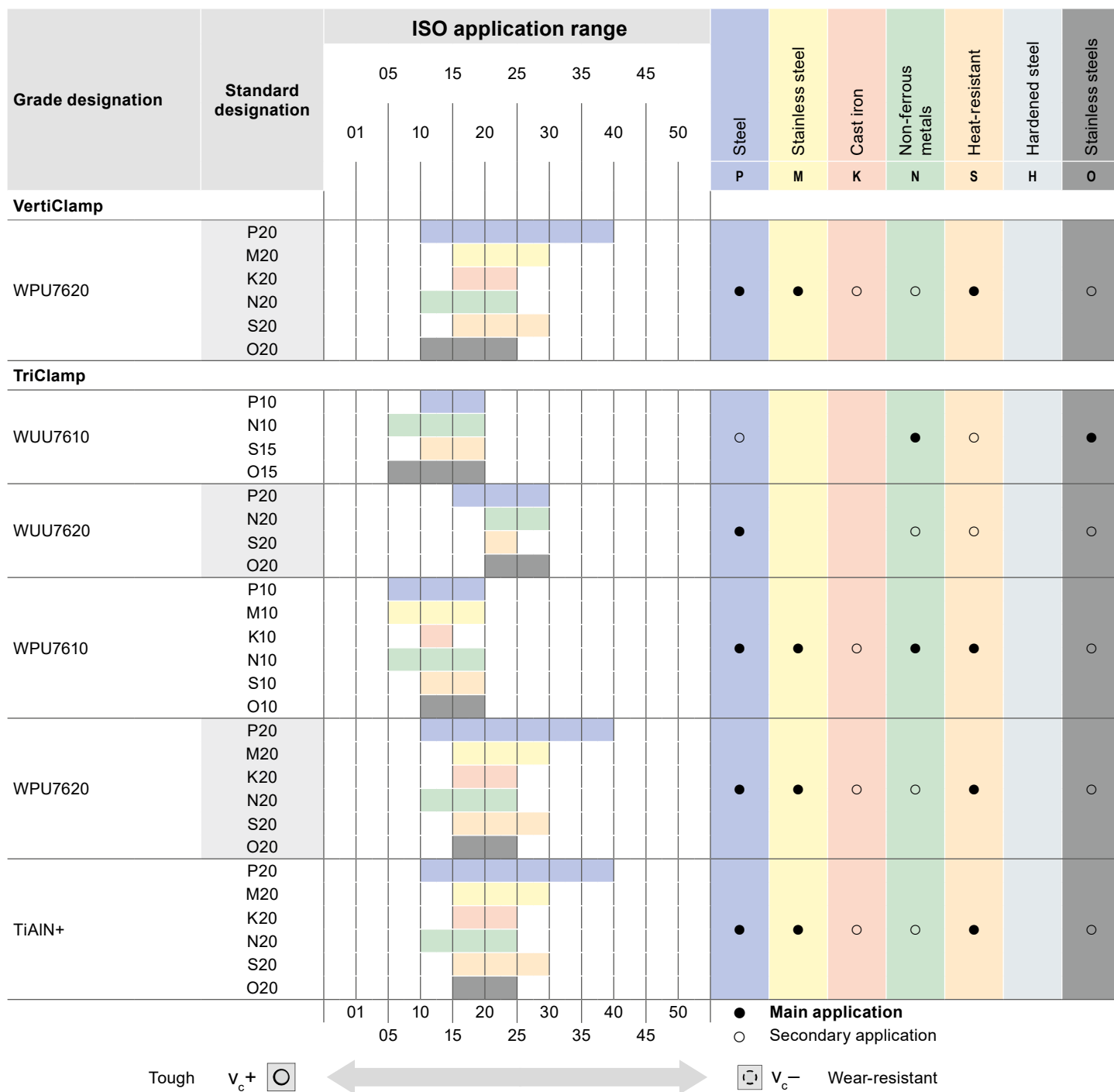


Accuracy

- ▲ No variable X and Y dimensions when changing the head
- ▲ Repeatability of less than $\pm 7.5 \mu\text{m}$
- ▲ Center height is retained even when the insert size is changed
- ▲ Two-nose system guarantees the correct position



Grades overview





Multifunction



Contents

- Explanation of symbols
- Advantages
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- Overview of tools
- Toolfinder
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- **EcoCut** – Mini
- **EcoCut** – Classic
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- **EcoCut** – ProfileMaster
- Cutting data
- Technical information
- Application tips
- Chip breakers
- Grade description
- Recommendation for optimum results
- Troubleshooting
- Designation system

Explanation of symbols

	Face turning		External / internal radial grooving		Internal coolant supply
	Longitudinal turning, external		Axial grooving	<div><div>-28P</div><div>H216T</div></div>	Chip breaker Carbide grade
	Drilling into solid material			<div><div>○</div><div>○</div><div>○</div></div>	Smooth cut
	Longitudinal turning, internal	<div><div>F</div><div>M</div><div>R</div></div>	Fine machining Medium machining Rough machining	<div><div>○</div><div>○</div><div>○</div></div>	Irregular cut
				<div><div>○</div><div>○</div><div>○</div></div>	Interrupted cut

●

 = Main application

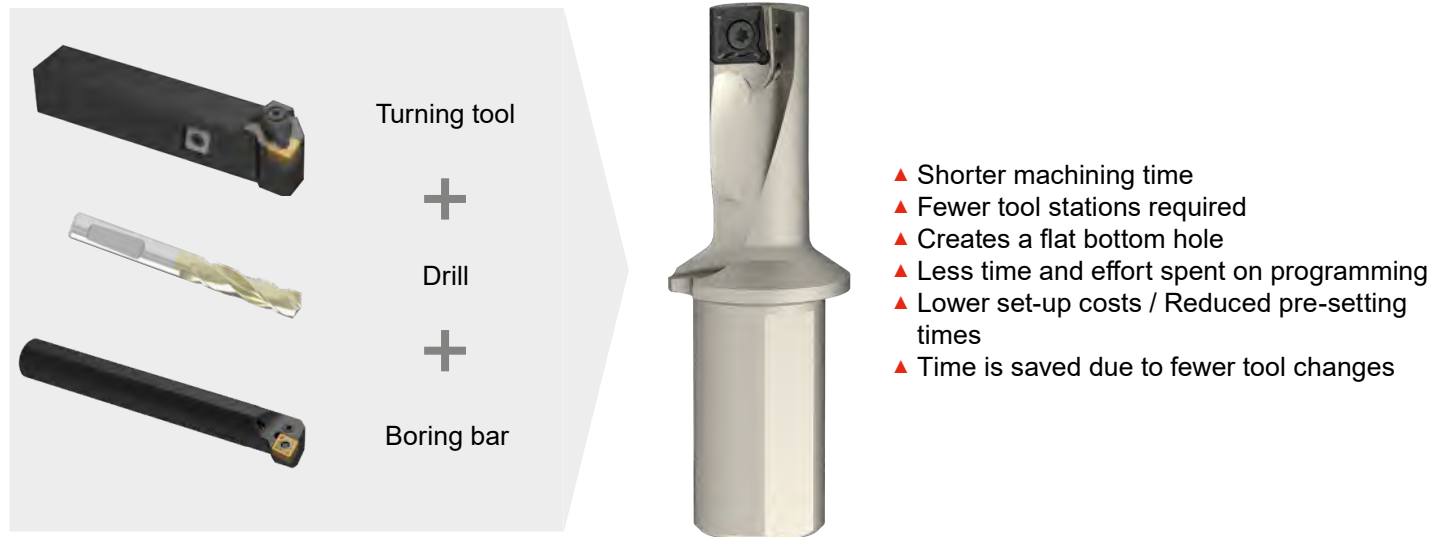
○

 = Secondary application

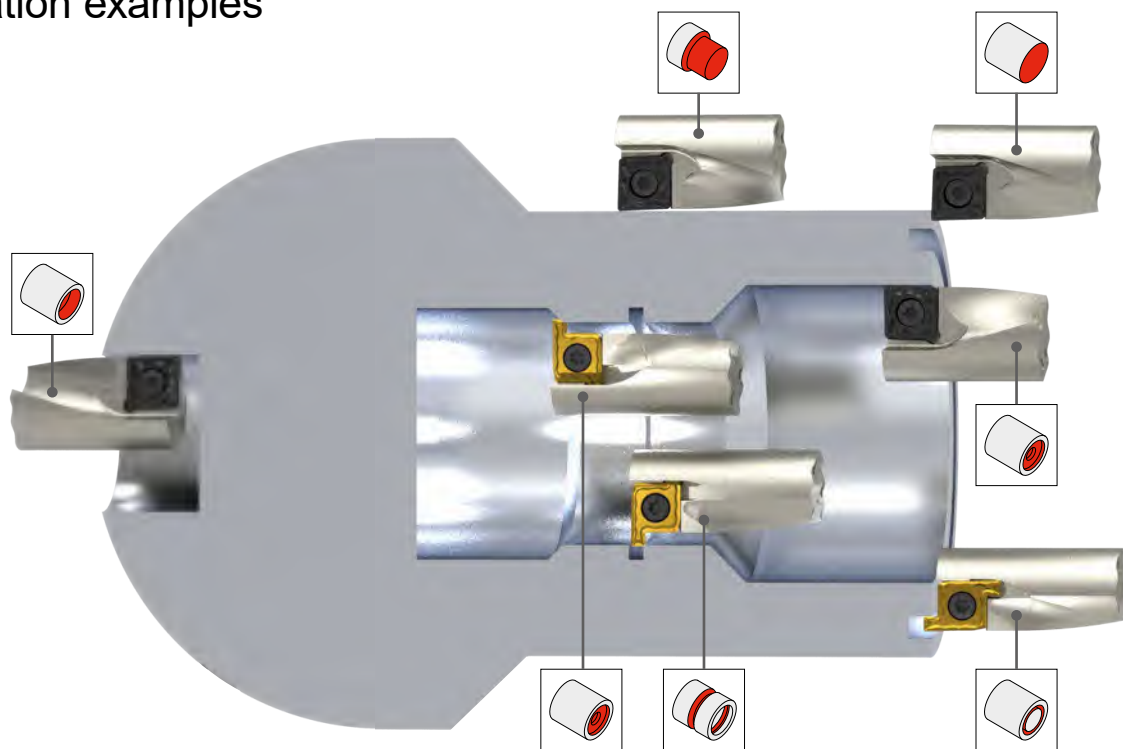
Advantages

Whether you are turning face, inside and outside profiles or drilling with a stationary or rotating tool, EcoCut is the leading tool for a number of applications.

EcoCut tools are available in three versions: EcoCut – Mini, EcoCut – Classic, EcoCut – ProfileMaster and the new EcoCut – Solid.



Application examples



Overview of tools

EcoCut – Mini



- ▲ For small component dimensions
→ Various sizes available
- ▲ Several applications with one tool
→ Saves time and tool stations in the machine
- ▲ Made from solid carbide
→ Increases stability even for interrupted cuts
- ▲ Through coolant supply
→ Less wear and fewer stuck chips

EcoCut – Classic



- ▲ Several applications are covered with one tool
→ Saves time and tool stations in the machine
- ▲ EcoCut – Classic is extremely high-performance and robust
→ Optimized tool geometry and reduced wear
- ▲ Highest process security
→ Indexable insert with reliable chip breaker

EcoCut – Solid



- ▲ The entire tool holder including insert seat is made from solid carbide, which has a high density as well as a higher modulus of elasticity. The material properties of carbide make a considerable contribution to dampening vibrations.
- ▲ No vibrations
→ Underlying processing that is process-secure
→ High surface quality
→ For demanding tolerances
→ Longer tool life of the insert
- ▲ Solid carbide holder material
→ Longer service life of the tool
→ Stable and robust
→ Zero to very little displacement

EcoCut – ProfileMaster



- ▲ Saves time and tool stations in the machine
- ▲ No radial and axial plunging operations possible
- ▲ Machining of undercuts
- ▲ Turning of inside profiles

Stability comparison

The following provides a comparison of the three different holder materials (solid carbide, Densimet, steel).

Material
Modulus of elasticity (E modulus)
Density

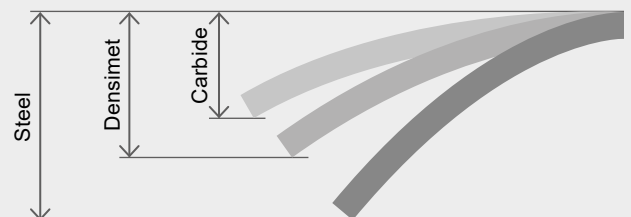
Carbide
550.000 MPa
14,1 g/cm³



Densimet
360.000 MPa
17,5 g/cm³



Steel
210.000 MPa
7,85 g/cm³

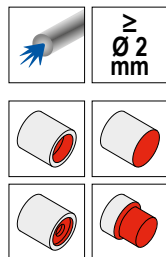
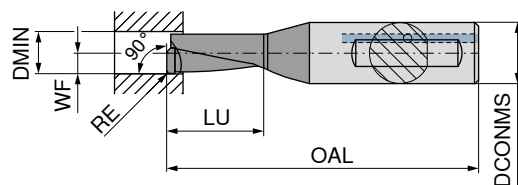


It is clear to see how differently the various materials behave at the same load.

System							<div>Indexable insert</div> <div>Smooth cut</div> <div>Irregular cut</div> <div>Interrupted cut</div> <div>Fine machining</div> <div>Medium machining</div> <div>Rough machining</div> <div> <div>P</div> <div>M</div> <div>K</div> <div>N</div> <div>S</div> <div>H</div> <div>O</div> </div> <div>Steel</div> <div>Stainless steel</div> <div>Cast iron</div> <div>Non-ferrous metals</div> <div>Heat-resistant</div> <div>Hardened steel</div> <div>Non-metal materials</div>							
EcoCut – Mini														
EcoCut – Classic														
EcoCut – Solid														
EcoCut – ProfileMaster														

EcoCut – Drilling and turning tool for small diameters – Mini

▲ Drilling and turning tool for small diameters



Illustrations show right-hand versions



Solid carbide
Left

Solid carbide
Right

Solid carbide
Left

Solid carbide
Right

Designation	DMIN mm	DCONMS mm	OAL mm	LU mm	WF mm	RE mm
ECM 02 R/L 2,25D	2.0	4	28	4.50	1.00	0.1
ECM 02 R/L 2,25D AL	2.0	4	28	4.50	1.00	0.1
ECM 02 R/L 4,00D	2.0	4	31	8.00	1.00	0.1
ECM 02 R/L 4,00D AL	2.0	4	31	8.00	1.00	0.1
ECM 02,5 R/L 2,25D	2.5	4	29	5.63	1.25	0.1
ECM 02,5 R/L 2,25D AL	2.5	4	29	5.63	1.25	0.1
ECM 02,5 R/L 4,00D	2.5	4	33	10.00	1.25	0.1
ECM 02,5 R/L 4,00D AL	2.5	4	33	10.00	1.25	0.1
ECM 03 R/L 2,25D	3.0	4	31	6.75	1.50	0.1
ECM 03 R/L 2,25D AL	3.0	4	31	6.75	1.50	0.1
ECM 03 R/L 4,00D	3.0	4	35	12.00	1.50	0.1
ECM 03 R/L 4,00D AL	3.0	4	35	12.00	1.50	0.1
ECM 03,5 R/L 2,25D	3.5	4	32	7.88	1.75	0.1
ECM 03,5 R/L 2,25D AL	3.5	4	32	7.88	1.75	0.1
ECM 03,5 R/L 4,00D	3.5	4	37	14.00	1.75	0.1
ECM 03,5 R/L 4,00D AL	3.5	4	37	14.00	1.75	0.1
ECM 04 R/L 2,25D	4.0	6	35	9.00	2.00	0.2
ECM 04 R/L 2,25D AL	4.0	6	35	9.00	2.00	0.2
ECM 04 R/L 4,00D	4.0	6	41	16.00	2.00	0.2
ECM 04 R/L 4,00D AL	4.0	6	41	16.00	2.00	0.2
ECM 05 R/L 2,25D	5.0	6	37	11.25	2.50	0.2
ECM 05 R/L 2,25D AL	5.0	6	37	11.25	2.50	0.2
ECM 05 R/L 4,00D	5.0	6	45	20.00	2.50	0.2
ECM 05 R/L 4,00D AL	5.0	6	45	20.00	2.50	0.2
ECM 06 R/L 2,25D	6.0	8	38	13.50	3.00	0.2
ECM 06 R/L 2,25D AL	6.0	8	38	13.50	3.00	0.2
ECM 06 R/L 4,00D	6.0	8	49	24.00	3.00	0.2
ECM 06 R/L 4,00D AL	6.0	8	49	24.00	3.00	0.2
ECM 07 R/L 2,25D	7.0	8	42	15.75	3.50	0.2
ECM 07 R/L 2,25D AL	7.0	8	42	15.75	3.50	0.2
ECM 07 R/L 4,00D	7.0	8	53	28.00	3.50	0.2
ECM 07 R/L 4,00D AL	7.0	8	53	28.00	3.50	0.2
ECM 08 R/L 2,25D	8.0	8	45	18.00	4.00	0.2
ECM 08 R/L 2,25D AL	8.0	8	45	18.00	4.00	0.2
ECM 08 R/L 4,00D	8.0	8	57	32.00	4.00	0.2
ECM 08 R/L 4,00D AL	8.0	8	57	32.00	4.00	0.2

SH	SH	SH	SH
70 805 ...	70 804 ...	70 805 ...	70 804 ...
320	320		
321	321	420	420
325	325	421	421
326	326	425	425
330	330	426	426
331	331	430	430
335	335	431	431
336	336	435	435
300	300	436	436
301	301	450	450
302	302	451	451
303	303	452	452
306	306	453	453
312	312	456	456
308	308	462	462
314	314	458	458
310	310	464	464
316	316	460	460
		466	466

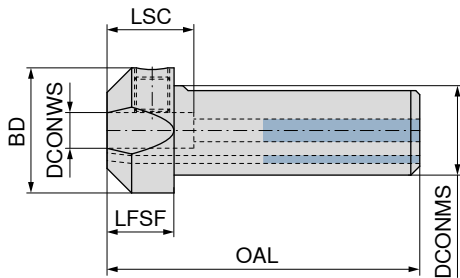
P	●	●		
M	○	○		
K	○	○	○	○
N	○	○	●	●
S	●	●	○	○
H				
O	○	○	○	○



- Find the recommended values for cutting speeds here.
→ You can find the recommended feed values here.

EcoCut – Adapter – Mini

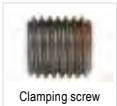
Scope of supply:
Base body equipped with a clamping screw



Designation	DCONWS	DCONMS	BD	OAL	LFSF	LSC	TO	
							70 800 ...	
EC-ADX16-04	4	16	22	59	14	18		716
EC-ADX20-04	4	20	25	64	14	18		720
EC-ADX16-06	6	16	22	59	14	18		976
EC-ADX20-06	6	20	25	64	14	18		996
EC-ADX16-08	8	16	22	59	14	18		978
EC-ADX20-08	8	20	25	64	14	18		998

Spare parts
DCONWS

4	M5x10 ISO 4026	867
6	M8x1x8 - SW4	123
8	M8x1x8 - SW4	123

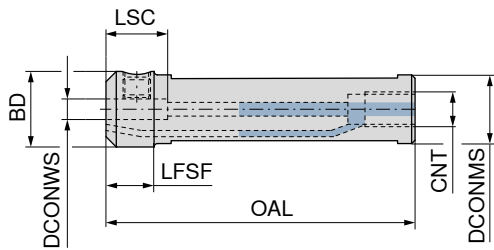


Clamping screw

AS	
70 950 ...	

EcoCut – Adapter with coolant connection thread – Mini

Scope of supply:
Base body equipped with a clamping screw



Designation	DCONWS mm	DCONMS mm	BD mm	OAL mm	LFSF mm	LSC mm	CNT
ECA 16-04	4	16	20.0	75	14	18	G 1/8
ECA 20-04	4	20	19.6	90	14	18	G 1/8
ECA 22-04	4	22	21.6	110	14	18	G 1/8
ECA 16-06	6	16	22.0	75	14	18	G 1/8
ECA 20-06	6	20	22.0	90	14	18	G 1/8
ECA 22-06	6	22	21.6	110	14	18	G 1/8
ECA 16-08	8	16	22.0	75	14	18	G 1/8
ECA 20-08	8	20	22.0	90	14	18	G 1/8
ECA 22-08	8	22	21.6	110	14	18	G 1/8

TO
70 801 ...
716
720
722
816
820
822
916
920
922

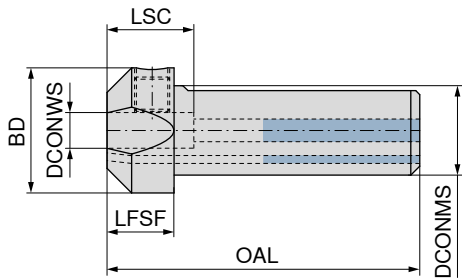
Spare parts
DCONWS

4	M5X8 - DIN 913
6	M8x1x8 - SW4
8	M8x1x8 - SW4


Clamping screw
AS
70 950 ...
13200
123
123

EcoCut – Adapter – Mini

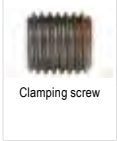
Scope of supply:
Base body equipped with a clamping screw



Designation							TO	
	DCONWS inch	DCONMS inch	BD inch	OAL inch	LFSF inch	LSC inch	70 800 ...	
EC-ADX12-04-E	0.157	0.750	0.984	2.500	0.551	0.709		719
EC-ADX12-06-E	0.236	0.750	0.984	2.500	0.551	0.709		986
EC-ADX12-08-E	0.315	0.750	0.984	2.500	0.551	0.709		988

Spare parts
DCONWS

0.157	M5x10 ISO 4026	867
0.236	M8x1x8 - SW4	123
0.315	M8x1x8 - SW4	123



Clamping screw

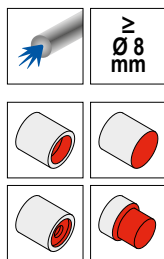
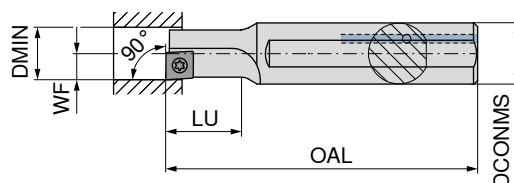
AS	
70 950 ...	

EcoCut – Drilling and turning tool – Classic 1,5xD

▲ Drilling and turning tool

Scope of supply:

Base body equipped with 1 clamping screw + 2 spare screws and screwdriver



Illustrations show right-hand versions



Left

Right

Designation	DMIN mm	DCONMS mm	OAL mm	LU mm	WF mm	Tightening torque Nm	Indexable insert
ECC 08 L 1,5D 04	8	12	80	12.0	4.0	0,4	XC.T 0401..EL
ECC 08 R 1,5D 04	8	12	80	12.0	4.0	0,4	XC.T 0401..ER
ECC 10 R/L 1,5D 05	10	12	90	15.0	5.0	0,7	XC.T 0502..
ECC 12 R/L 1,5D 06	12	16	100	18.0	6.0	1,0	XC.T 0602..
ECC 14 R/L 1,5D 07	14	16	110	21.0	7.0	1,2	XC.T 0703..
ECC 16 R/L 1,5D 08	16	20	125	24.0	8.0	2,2	XC.T 0803..
ECC 18 R/L 1,5D 09	18	25	135	27.0	9.0	2,2	XC.T 09T3..
ECC 20 R/L 1,5D 10	20	25	150	30.0	10.0	3,2	XC.T 10T3..
ECC 25 R/L 1,5D 13	25	32	180	37.5	12.5	5,0	XC.T 1304..
ECC 32 R/L 1,5D 17	32	40	200	48.0	16.0	5,0	XC.T 1705..

TO	TO
70 805 ...	70 804 ...
008 ²⁾	008 ¹⁾
010	010
012	012
014	014
016	016
018	018
020	020
025	025
032	032

1) Caution! Right hand insert for right hand tool

2) Caution! Left hand insert for left hand tool



- Find suitable indexable inserts here.
- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

Spare parts

Indexable insert

		AS		AS
		80 950 ...		70 950 ...
XC.T 0401..EL	T06 - IP	116	M1,8x3,6 - 06IP	862
XC.T 0401..ER	T06 - IP	116	M1,8x3,6 - 06IP	862
XC.T 0502..	T06 - IP	116	M2x4,3 - 06IP	863
XC.T 0602..	T07 - IP	117	M2,2x5 - 07IP	856
XC.T 0703..	T08 - IP	039	M2,5x6 - 08IP	857
XC.T 0803..	T09 - IP	118	M3x7 - 09IP	819
XC.T 09T3..	T09 - IP	118	M3x7 - 09IP	819
XC.T 10T3..	T15 - IP	120	M3,5x8,6 - 15IP	859
XC.T 1304..	T20 - IP	121	M4,5x10,5 - 20IP	864
XC.T 1705..	T20 - IP	121	M4,5x10,5 - 20IP	864



Screwdriver



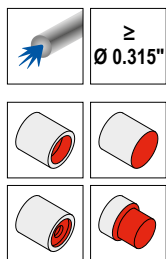
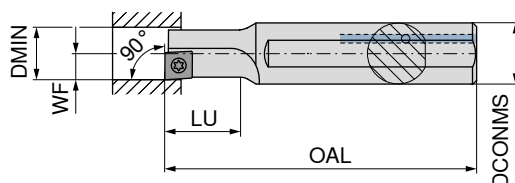
Clamping screw

EcoCut – Drilling and turning tool – Classic 1,5xD

▲ Drilling and turning tool

Scope of supply:

Base body equipped with 1 clamping screw + 2 spare screws and screwdriver



Illustrations show right-hand versions



Left

Right

Designation	DMIN inch	DCONMS inch	OAL inch	LU inch	WF inch	Tightening torque Nm	Indexable insert	TO 78 805 ...	TO 78 804 ...
ECC 08 L 1,5D 04-E	0.315	0.500	3.100	0.470	0.157	0,4	XC.T 0401..EL	00800 ²⁾	
ECC 08 R 1,5D 04-E	0.315	0.500	3.100	0.470	0.157	0,4	XC.T 0401..ER		00800 ¹⁾
ECC 10 R/L 1,5D 05-E	0.394	0.500	3.500	0.590	0.197	0,7	XC.T 0502..	01000	01000
ECC 12 R/L 1,5D 06-E	0.472	0.625	3.900	0.710	0.236	1,0	XC.T 0602..	01200	01200
ECC 14 R/L 1,5D 07-E	0.551	0.625	4.300	0.830	0.276	1,2	XC.T 0703..	01400	01400
ECC 16 R/L 1,5D 08-E	0.630	0.750	4.900	0.940	0.315	2,2	XC.T 0803..	01600	01600
ECC 18 R/L 1,5D 09-E	0.709	1.000	5.300	1.060	0.354	2,2	XC.T 09T3..	01800	01800
ECC 20 R/L 1,5D 10-E	0.787	1.000	5.900	1.180	0.394	3,2	XC.T 10T3..	02000	02000
ECC 25 R/L 1,5D 13-E	0.984	1.250	7.000	1.480	0.492	5,0	XC.T 1304..	02500	02500
ECC 32 R/L 1,5D 17-E	1.260	1.500	7.800	1.890	0.630	5,0	XC.T 1705..	03200	03200

1) Caution! Right hand insert for right hand tool

2) Caution! Left hand insert for left hand tool



- Find suitable indexable inserts here.
- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

Spare parts

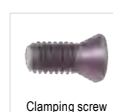
Indexable insert

		AS 80 950 ...	AS 70 950 ...
XC.T 0401..EL	T06 - IP	116	M1,8x3,6 - 06IP 862
XC.T 0401..ER	T06 - IP	116	M1,8x3,6 - 06IP 862
XC.T 0502..	T06 - IP	116	M2x4,3 - 06IP 863
XC.T 0602..	T07 - IP	117	M2,2x5 - 07IP 856
XC.T 0703..	T08 - IP	039	M2,5x6 - 08IP 857
XC.T 0803..	T09 - IP	118	M3x7 - 09IP 819
XC.T 09T3..	T09 - IP	118	M3x7 - 09IP 819
XC.T 10T3..	T15 - IP	120	M3,5x8,6 - 15IP 859
XC.T 1304..	T20 - IP	121	M4,5x10,5 - 20IP 864
XC.T 1705..	T20 - IP	121	M4,5x10,5 - 20IP 864



AS

80 950 ...



AS

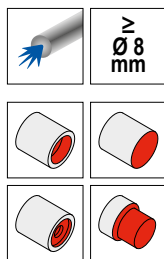
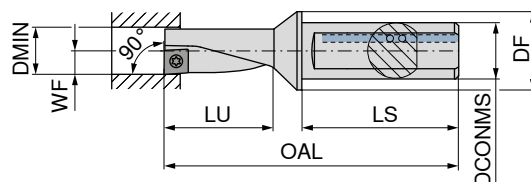
70 950 ...

EcoCut – Drilling and turning tool – Classic 2,25xD

▲ Drilling and turning tool

Scope of supply:

Base body equipped with 1 clamping screw + 2 spare screws and screwdriver



Illustrations show right-hand versions



Left

Right

Designation	DMIN mm	DCONMS mm	DF mm	OAL mm	LU mm	LS mm	WF mm	Tightening torque Nm	Indexable insert	TO 70 805 ...	TO 70 804 ...
ECC 08 L 2,25D 04	8	10	15	60.0	18.0	38	4.0	0,4	XC.T 0401..EL	108 ²⁾	
ECC 08 R 2,25D 04	8	10	15	60.0	18.0	38	4.0	0,4	XC.T 0401..ER		108 ¹⁾
ECC 10 R/L 2,25D 05	10	12	18	69.5	22.5	42	5.0	0,7	XC.T 0502..	110	110
ECC 12 R/L 2,25D 06	12	16	22	78.0	27.0	45	6.0	1,0	XC.T 0602..	112	112
ECC 14 R/L 2,25D 07	14	16	23	83.5	31.5	45	7.0	1,2	XC.T 0703..	114	114
ECC 16 R/L 2,25D 08	16	20	28	94.0	36.0	50	8.0	2,2	XC.T 0803..	116	116
ECC 18 R/L 2,25D 09	18	25	36	109.5	40.5	56	9.0	2,2	XC.T 09T3..	118	118
ECC 20 R/L 2,25D 10	20	25	35	111.0	45.0	56	10.0	3,2	XC.T 10T3..	120	120
ECC 25 R/L 2,25D 13	25	32	44	129.0	56.5	60	12.5	5,0	XC.T 1304..	125	125
ECC 32 R/L 2,25D 17	32	40	54	158.0	72.0	70	16.0	5,0	XC.T 1705..	132	132

1) Caution! Right hand insert for right hand tool

2) Caution! Left hand insert for left hand tool



- Find suitable indexable inserts here.
- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

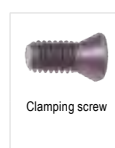
Spare parts

Indexable insert

		AS 80 950 ...	AS 70 950 ...
XC.T 0401..EL	T06 - IP	116	M1,8x3,6 - 06IP 862
XC.T 0401..ER	T06 - IP	116	M1,8x3,6 - 06IP 862
XC.T 0502..	T06 - IP	116	M2x4,3 - 06IP 863
XC.T 0602..	T07 - IP	117	M2,2x5 - 07IP 856
XC.T 0703..	T08 - IP	039	M2,5x6 - 08IP 857
XC.T 0803..	T09 - IP	118	M3x7 - 09IP 819
XC.T 09T3..	T09 - IP	118	M3x7 - 09IP 819
XC.T 10T3..	T15 - IP	120	M3,5x8,6 - 15IP 859
XC.T 1304..	T20 - IP	121	M4,5x10,5 - 20IP 864
XC.T 1705..	T20 - IP	121	M4,5x10,5 - 20IP 864



Screwdriver



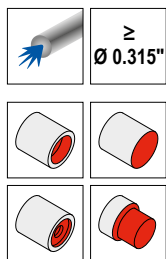
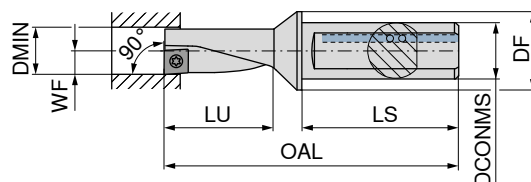
Clamping screw

EcoCut – Drilling and turning tool – Classic 2,25xD

▲ Drilling and turning tool

Scope of supply:

Base body equipped with 1 clamping screw + 2 spare screws and screwdriver



Illustrations show right-hand versions



Left

Right

Designation	DMIN inch	DCONMS inch	DF inch	OAL inch	LU inch	LS inch	WF inch	Tightening torque Nm	Indexable insert	TO 78 805 ...	TO 78 804 ...
ECC 08 L 2,25D 04-E	0.315	0.375	0.472	2.300	0.710	1.430	0.157	0,4	XC.T 0401..EL	10800 ²⁾	
ECC 08 R 2,25D 04-E	0.315	0.375	0.472	2.300	0.710	1.430	0.157	0,4	XC.T 0401..ER		10800 ¹⁾
ECC 10 R/L 2,25D 05-E	0.394	0.500	0.630	2.700	0.890	1.615	0.197	0,7	XC.T 0502..	11000	11000
ECC 12 R/L 2,25D 06-E	0.472	0.625	0.787	3.000	1.060	1.700	0.236	1,0	XC.T 0602..	11200	11200
ECC 14 R/L 2,25D 07-E	0.551	0.625	0.787	3.200	1.240	1.700	0.276	1,2	XC.T 0703..	11400	11400
ECC 16 R/L 2,25D 08-E	0.630	0.750	0.984	3.700	1.420	1.970	0.315	2,2	XC.T 0803..	11600	11600
ECC 18 R/L 2,25D 09-E	0.709	1.000	1.260	4.300	1.590	2.190	0.354	2,2	XC.T 09T3..	11800	11800
ECC 20 R/L 2,25D 10-E	0.787	1.000	1.260	4.400	1.770	2.230	0.394	3,2	XC.T 10T3..	12000	12000
ECC 25 R/L 2,25D 13-E	0.984	1.250	1.575	5.000	2.220	2.285	0.492	5,0	XC.T 1304..	12500	12500
ECC 32 R/L 2,25D 17-E	1.260	1.500	1.969	6.200	2.830	2.740	0.630	5,0	XC.T 1705..	13200	13200

1) Caution! Right hand insert for right hand tool

2) Caution! Left hand insert for left hand tool



- Find suitable indexable inserts here.
- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

Spare parts

Indexable insert

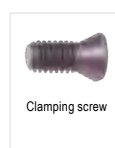
		AS 80 950 ...	AS 70 950 ...
XC.T 0401..EL	T06 - IP	116	M1,8x3,6 - 06IP 862
XC.T 0401..ER	T06 - IP	116	M1,8x3,6 - 06IP 862
XC.T 0502..	T06 - IP	116	M2x4,3 - 06IP 863
XC.T 0602..	T07 - IP	117	M2,2x5 - 07IP 856
XC.T 0703..	T08 - IP	039	M2,5x6 - 08IP 857
XC.T 0803..	T09 - IP	118	M3x7 - 09IP 819
XC.T 09T3..	T09 - IP	118	M3x7 - 09IP 819
XC.T 10T3..	T15 - IP	120	M3,5x8,6 - 15IP 859
XC.T 1304..	T20 - IP	121	M4,5x10,5 - 20IP 864
XC.T 1705..	T20 - IP	121	M4,5x10,5 - 20IP 864



Screwdriver

AS

80 950 ...



Clamping screw

AS

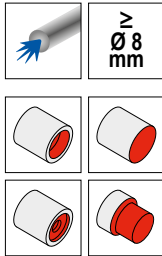
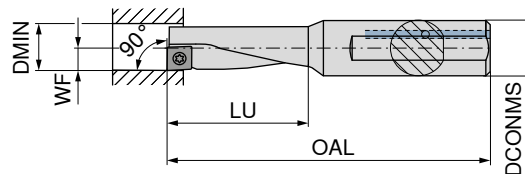
70 950 ...

EcoCut – Drilling and turning tool – Heavy metal – Classic 3,0xD

- ▲ Drilling and turning tool
- ▲ Vibration-damped

Scope of supply:

Base body equipped with 1 clamping screw + 2 spare screws and screwdriver



Illustrations show right-hand versions



Left

Right

Designation	DMIN mm	DCONMS mm	OAL mm	LU mm	WF mm	Tightening torque Nm	Indexable insert	Left TO 70 805 ...	Right TO 70 804 ...
ECC 08 L 3,00D 04 H	8	12	80	24	4.0	0,4	XC.T 0401..EL	608 ²⁾	
ECC 08 R 3,00D 04 H	8	12	80	24	4.0	0,4	XC.T 0401..ER		608 ¹⁾
ECC 10 R/L 3,00D 05 H	10	12	85	30	5.0	0,7	XC.T 0502..	610	610
ECC 12 R/L 3,00D 06 H	12	16	95	36	6.0	1,0	XC.T 0602..	612	612
ECC 14 R/L 3,00D 07 H	14	16	100	42	7.0	1,2	XC.T 0703..	614	614
ECC 16 R/L 3,00D 08 H	16	20	110	48	8.0	2,2	XC.T 0803..	616	616
ECC 18 R/L 3,00D 09 H	18	25	125	54	9.0	2,2	XC.T 09T3..	618	618
ECC 20 R/L 3,00D 10 H	20	25	130	60	10.0	3,2	XC.T 10T3..	620	620
ECC 25 R/L 3,00D 13 H	25	32	150	75	12.5	5,0	XC.T 1304..	625	625
ECC 32 R/L 3,00D 17 H	32	40	185	96	16.0	5,0	XC.T 1705..	632	632

- 1) Caution! Right hand insert for right hand tool
- 2) Caution! Left hand insert for left hand tool

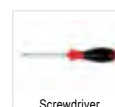


- Find suitable indexable inserts here.
- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

Spare parts

Indexable insert

Designation	T	AS 80 950 ...	AS 70 950 ...
XC.T 0401..EL	T06 - IP	116	M1,8x3,6 - 06IP 862
XC.T 0401..ER	T06 - IP	116	M1,8x3,6 - 06IP 862
XC.T 0502..	T06 - IP	116	M2x4,3 - 06IP 863
XC.T 0602..	T07 - IP	117	M2,2x5 - 07IP 856
XC.T 0703..	T08 - IP	039	M2,5x6 - 08IP 857
XC.T 0803..	T09 - IP	118	M3x7 - 09IP 819
XC.T 09T3..	T09 - IP	118	M3x7 - 09IP 819
XC.T 10T3..	T15 - IP	120	M3,5x8,6 - 15IP 859
XC.T 1304..	T20 - IP	121	M4,5x10,5 - 20IP 864
XC.T 1705..	T20 - IP	121	M4,5x10,5 - 20IP 864



Screwdriver

AS

80 950 ...



Clamping screw

AS

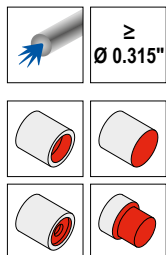
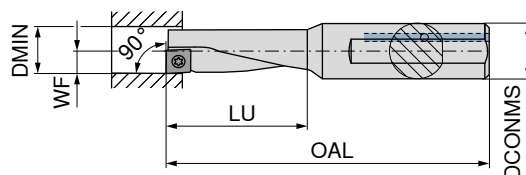
70 950 ...

EcoCut – Drilling and turning tool – Heavy metal – Classic 3,0xD

- ▲ Drilling and turning tool
- ▲ vibration-damped

Scope of supply:

Base body equipped with 1 clamping screw + 2 spare screws and screwdriver



Illustrations show right-hand versions



Left

Right

Designation	DMIN inch	DCONMS inch	OAL inch	LU inch	WF inch	Tightening torque Nm	Indexable insert
ECC 08 L 3,00D 04 H-E	0.315	0.500	3.100	0.940	0.157	0,4	XC.T 0401..EL
ECC 08 R 3,00D 04 H-E	0.315	0.500	3.100	0.940	0.157	0,4	XC.T 0401..ER
ECC 10 R/L 3,00D 05 H-E	0.394	0.500	3.300	1.180	0.197	0,7	XC.T 0502..
ECC 12 R/L 3,00D 06 H-E	0.472	0.625	3.700	1.420	0.236	1,0	XC.T 0602..
ECC 14 R/L 3,00D 07 H-E	0.551	0.625	3.900	1.650	0.276	1,2	XC.T 0703..
ECC 16 R/L 3,00D 08 H-E	0.630	0.750	4.300	1.860	0.315	2,2	XC.T 0803..
ECC 18 R/L 3,00D 09 H-E	0.709	1.000	5.000	2.120	0.354	2,2	XC.T 09T3..
ECC 20 R/L 3,00D 10 H-E	0.787	1.000	5.100	2.360	0.394	3,2	XC.T 10T3..
ECC 25 R/L 3,00D 13 H-E	0.984	1.250	5.900	2.950	0.492	5,0	XC.T 1304..
ECC 32 R/L 3,00D 17 H-E	1.260	1.500	7.200	3.780	0.630	5,0	XC.T 1705..

TO	TO
78 805 ...	78 804 ...
60800 ²⁾	60800 ¹⁾
61000	61000
61200	61200
61400	61400
61600	61600
61800	61800
62000	62000
62500	62500
63200	63200

- 1) Caution! Right hand insert for right hand tool
- 2) Caution! Left hand insert for left hand tool

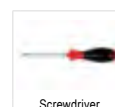


- Find suitable indexable inserts here.
- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

Spare parts

Indexable insert

XC.T 0401..EL	T06 - IP	116	M1,8x3,6 - 06IP	862
XC.T 0401..ER	T06 - IP	116	M1,8x3,6 - 06IP	862
XC.T 0502..	T06 - IP	116	M2x4,3 - 06IP	863
XC.T 0602..	T07 - IP	117	M2,2x5 - 07IP	856
XC.T 0703..	T08 - IP	039	M2,5x6 - 08IP	857
XC.T 0803..	T09 - IP	118	M3x7 - 09IP	819
XC.T 09T3..	T09 - IP	118	M3x7 - 09IP	819
XC.T 10T3..	T15 - IP	120	M3,5x8,6 - 15IP	859
XC.T 1304..	T20 - IP	121	M4,5x10,5 - 20IP	864
XC.T 1705..	T20 - IP	121	M4,5x10,5 - 20IP	864



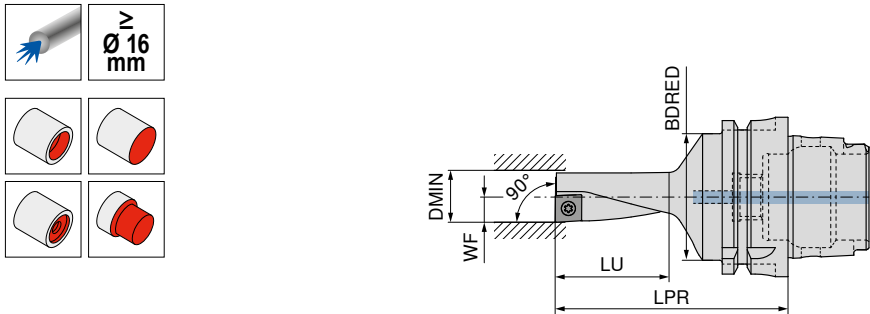
Screwdriver



Clamping screw

EcoCut – Drilling and turning tool - HSK-T – Classic 2,25xD

Scope of supply:
Base body equipped with 1 clamping screw + 2 spare screws and screwdriver



Illustrations show right-hand versions



Designation	Adapter	LPR mm	LU mm	BDRED mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	Left	Right
									TO 74 591 ...	TO 74 590 ...
HSK-T 63 ECC 16 R/L 2,25D 08	HSK-T 63	84	36.00	50	8.0	16	2,2	XC.T 0803..	51637	51637
HSK-T 63 ECC 20 R/L 2,25D 10	HSK-T 63	92	45.00	50	10.0	20	3,2	XC.T 10T3..	52037	52037
HSK-T 63 ECC 25 R/L 2,25D 13	HSK-T 63	104	56.25	50	12.5	25	5,0	XC.T 1304..	52537	52537
HSK-T 63 ECC 32 R/L 2,25D 17	HSK-T 63	120	72.00	50	16.0	32	5,0	XC.T 1705..	53237	53237

-
- Find suitable indexable inserts here.

→ Find the recommended values for cutting speeds here.

→ You can find the recommended feed values here.

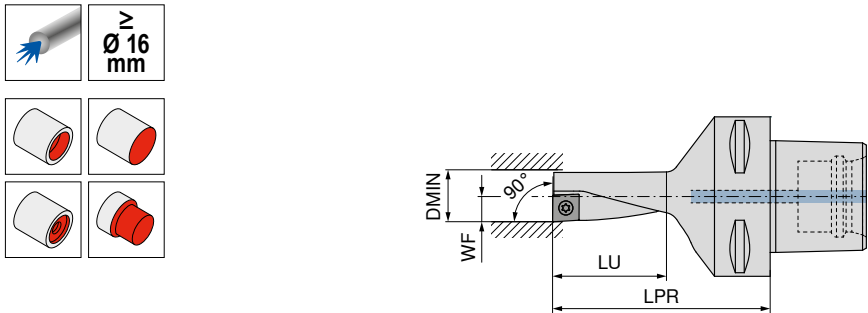
Spare parts
Indexable insert

XC.T 0803..	T09 - IP	118	M3x7 - 09IP	819
XC.T 10T3..	T15 - IP	120	M3,5x8,6 - 15IP	859
XC.T 1304..	T20 - IP	121	M4,5x10,5 - 20IP	864
XC.T 1705..	T20 - IP	121	M4,5x10,5 - 20IP	864

Screwdriver	Clamping screw
AS 80 950 ...	AS 70 950 ...

EcoCut – Drilling and turning tool - PSC – Classic 2,25xD

Scope of supply:
Base body equipped with 1 clamping screw + 2 spare screws and screwdriver



Illustrations show right-hand versions



Designation	Adapter	LPR mm	LU mm	WF mm	DMIN mm	Tightening torque Nm	Indexable insert	Left	Right
								TO 74 591 ...	TO 74 590 ...
PSC 50 ECC 16 R/L 2,25D 08	PSC 50	70	36.00	8.0	16	2,2	XC.T 0803..	51694	51694
PSC 50 ECC 20 R/L 2,25D 10	PSC 50	81	45.00	10.0	20	3,2	XC.T 10T3..	52094	52094
PSC 50 ECC 25 R/L 2,25D 13	PSC 50	93	56.25	12.5	25	5,0	XC.T 1304..	52594	52594
PSC 50 ECC 32 R/L 2,25D 17	PSC 50	110	72.00	16.0	32	5,0	XC.T 1705..	53294	53294
PSC 63 ECC 16 R/L 2,25D 08	PSC 63	75	36.00	8.0	16	2,2	XC.T 0803..	51693	51693
PSC 63 ECC 20 R/L 2,25D 10	PSC 63	86	45.00	10.0	20	3,2	XC.T 10T3..	52093	52093
PSC 63 ECC 25 R/L 2,25D 13	PSC 63	97	56.25	12.5	25	5,0	XC.T 1304..	52593	52593
PSC 63 ECC 32 R/L 2,25D 17	PSC 63	114	72.00	16.0	32	5,0	XC.T 1705..	53293	53293

-
- Find suitable indexable inserts here.

→ Find the recommended values for cutting speeds here.

→ You can find the recommended feed values here.

Spare parts
Indexable insert

XC.T 0803..	T09 - IP	118	M3x7 - 09IP	819
XC.T 10T3..	T15 - IP	120	M3,5x8,6 - 15IP	859
XC.T 1304..	T20 - IP	121	M4,5x10,5 - 20IP	864
XC.T 1705..	T20 - IP	121	M4,5x10,5 - 20IP	864



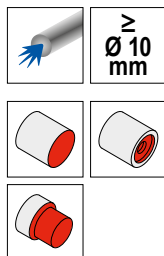
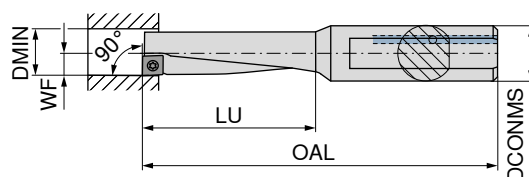
AS	AS
80 950 ...	70 950 ...

EcoCut – Turning tool – Solid 4xD

- ▲ Low-vibration turning tool
- ▲ Wear-resistant
- ▲ Not suitable for drilling into solid

Scope of supply:

Base body equipped with 1 clamping screw + 2 spare screws and screwdriver



Illustrations show right-hand versions



Left

Right

Designation	DMIN mm	DCONMS mm	OAL mm	LU mm	WF mm	Tightening torque Nm	Indexable insert
ECS 10 L 4,0D 04 C	10	12	101	40	5.0	0,4	XC.T 0401..EL
ECS 10 R 4,0D 04 C	10	12	101	40	5.0	0,4	XC.T 0401..ER
ECS 12 R/L 4,0D 05 C	12	16	111	48	6.0	0,7	XC.T 0502..
ECS 16 R/L 4,0D 06 C	16	20	126	64	8.0	1,0	XC.T 0602..
ECS 20 R/L 4,0D 08 C	20	25	152	80	10.0	2,2	XC.T 0803..
ECS 25 R/L 4,0D 10 C	25	32	175	100	12.5	3,2	XC.T 10T3..

TO	TO
70 807 ...	70 806 ...
01000 ²⁾	01000 ¹⁾
01200	01200
01600	01600
02000	02000
02500	02500

- 1) Caution! Right hand insert for right hand tool
- 2) Caution! Left hand insert for left hand tool



- Find suitable indexable inserts here.
- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

Spare parts

Indexable insert

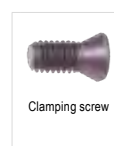
XC.T 0401..EL	T06 - IP	116	M1,8x3,6 - 06IP	862
XC.T 0401..ER	T06 - IP	116	M1,8x3,6 - 06IP	862
XC.T 0502..	T06 - IP	116	M2x4,3 - 06IP	863
XC.T 0602..	T07 - IP	117	M2,2x5 - 07IP	856
XC.T 0803..	T09 - IP	118	M3x7 - 09IP	819
XC.T 10T3..	T15 - IP	120	M3,5x8,6 - 15IP	859



Screwdriver

AS

80 950 ...

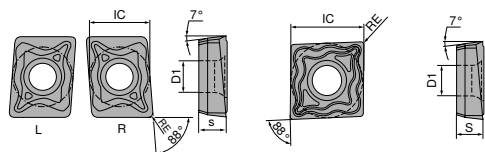


Clamping screw

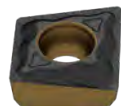
AS

70 950 ...

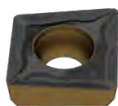
EcoCut – HM indexable insert



XC.T 04..

XC.T 05.. / 06.. / 07.. / 08.. /
09.. / 10.. / 13.. / 17..**M**

XCNT

**M**

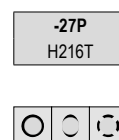
XCNT

**M**

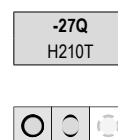
XCNT

**M**

XCNT

**M**

XCET

**M**

XCET

Designation	S mm	D1 mm	IC mm	RE mm
XCET 040102FL	1.8	2.10	4.5	0.2
XCET 040102FR	1.8	2.10	4.5	0.2
XCNT 040102EL	1.8	2.10	4.5	0.2
XCNT 040102ER	1.8	2.10	4.5	0.2
XCET 040104FL	1.8	2.10	4.5	0.4
XCET 040104FR	1.8	2.10	4.5	0.4
XCNT 040104EL	1.8	2.10	4.5	0.4
XCNT 040104ER	1.8	2.10	4.5	0.4
XCET 050202FN	2.1	2.25	5.8	0.2
XCNT 050202EN	2.1	2.25	5.8	0.2
XCET 050204FN	2.1	2.25	5.8	0.4
XCNT 050204EN	2.1	2.25	5.8	0.4
XCET 060202FN	2.38	2.50	6.5	0.2
XCNT 060202EN	2.38	2.50	6.5	0.2
XCET 060204FN	2.38	2.50	6.5	0.4
XCNT 060204EN	2.38	2.50	6.5	0.4
XCET 070304FN	3.18	2.80	7.6	0.4
XCNT 070304EN	3.18	2.80	7.6	0.4
XCET 080304FN	3.18	3.40	8.5	0.4
XCNT 080304EN	3.18	3.40	8.5	0.4
XCET 09T304FN	3.97	3.40	9.6	0.4
XCNT 09T304EN	3.97	3.40	9.6	0.4
XCET 10T304FN	3.97	4.40	10.6	0.4
XCNT 10T304EN	3.97	4.40	10.6	0.4
XCET 10T308FN	3.97	4.40	10.6	0.8
XCNT 10T308EN	3.97	4.40	10.6	0.8
XCET 130404FN	4.76	5.30	13.5	0.4
XCNT 130404EN	4.76	5.30	13.5	0.4
XCET 130408FN	4.76	5.30	13.5	0.8
XCNT 130408EN	4.76	5.30	13.5	0.8
XCET 170508FN	5.56	5.30	17.5	0.8
XCNT 170508EN	5.56	5.30	17.5	0.8

MT

70 386 ...

MT

70 386 ...

MT

70 386 ...

MT

70 386 ...

MT

70 286 ...

MT

70 286 ...

620

622

600

602

623

603

624

604

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111

112

P	●	●	●	●		
M	○	○	○	○		
K	●	●	○	○	○	○
N				○	●	●
S				○	●	●
H						
O				○	○	○



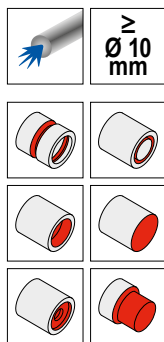
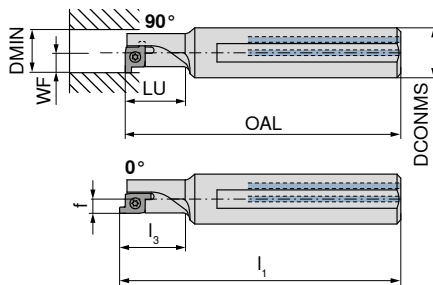
→ Find the recommended values for cutting speeds here.

EcoCut – Drilling, turning and grooving tool – ProfileMaster 1,5xD

▲ Drilling, turning and grooving tool

Scope of supply:

Base body equipped with one clamping screw and one screwdriver



Illustrations show right-hand versions



Designation	DMIN mm	DCONMS mm	OAL mm	LU mm	WF mm	I ₁ mm	I ₃ mm	f mm	Tightening torque Nm	Indexable insert
PMC 10 R/L 1,5D	10	12	80	15	5.0				0,4	PM 10R/L
PMC 12 R/L 1,5D	12	16	90	18	6.0				1,0	PM 12R/L
PMC 16 R/L 1,5D	16	20	125	24	8.0	127.3	26.3	5.7	2,2	PM 16R/L
PMC 20 R/L 1,5D	20	25	150	30	10.0	152.8	32.8	7.2	2,2	PM 20R/L
PMC 25 R/L 1,5D	25	32	180	38	12.5	183.3	40.8	9.2	3,2	PM 25R/L
PMC 32 R/L 1,5D	32	40	200	48	16.0	204.3	52.3	11.7	5,0	PM 32R/L

Left

Right

TO	TO
70 821 ...	70 820 ...
010 ¹⁾	010 ¹⁾
012 ¹⁾	012 ¹⁾
016	016
020	020
025	025
032	032

1) Only usable as 90° version



- Find suitable indexable inserts here.
- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

Spare parts

Indexable insert

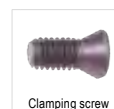
PM 10R/L	T06 - IP	116	M1,8x3,6 - 06IP	862
PM 12R/L	T07 - IP	117	M2,2x4,2 - 07IP	137
PM 16R/L	T09 - IP	118	M3x5,7 - 09IP	008
PM 20R/L	T15 - IP	120	M3x5,7 - 15IP	009
PM 25R/L	T15 - IP	120	M3,5x8,6 - 15IP	859
PM 32R/L	T20 - IP	121	M5x10,8 - 20IP	010



Screwdriver

AS

80 950 ...



Clamping screw

AS

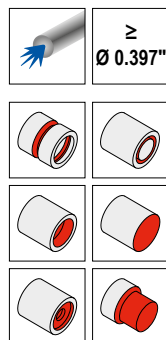
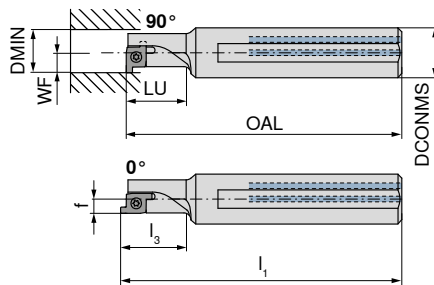
70 950 ...

EcoCut – Drilling, turning and grooving tool – ProfileMaster 1,5xD

▲ Drilling, turning and grooving tool

Scope of supply:

Base body equipped with one clamping screw and one screwdriver



Illustrations show right-hand versions



Designation	DMIN inch	DCONMS inch	OAL inch	LU inch	WF inch	I ₁ inch	I ₃ inch	f inch	Tightening torque Nm	Indexable insert
PMC 10 R/L 1,5D-E	0.394	0.500	3.100	0.590	0.197				0,4	PM 10R/L
PMC 12 R/L 1,5D-E	0.472	0.625	3.500	0.709	0.236				1,0	PM 12R/L
PMC 16 R/L 1,5D-E	0.630	0.750	4.900	1.004	0.315	4.991	1.094	0.224	2,2	PM 16R/L
PMC 20 R/L 1,5D-E	0.787	1.000	5.900	1.181	0.394	6.010	1.291	0.283	2,2	PM 20R/L
PMC 25 R/L 1,5D-E	0.984	1.250	7.000	1.476	0.492	7.130	1.606	0.362	3,2	PM 25R/L
PMC 32 R/L 1,5D-E	1.260	1.500	7.800	1.890	0.630	7.969	2.059	0.461	5,0	PM 32R/L

Left

Right

TO	TO
78 811 ...	78 810 ...
01000 ¹⁾	01000 ¹⁾
01200 ¹⁾	01200 ¹⁾
01600	01600
02000	02000
02500	02500
03200	03200

1) Only usable as 90° version

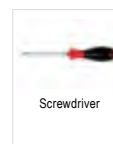


- Find suitable indexable inserts here.
- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

Spare parts

Indexable insert

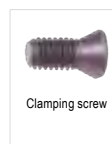
Designation	Indexable insert	AS	AS
PM 10R/L	T06	100	57300
PM 12R/L	T07	101	360
PM 16R/L	T08	102	365
PM 20R/L	T15	105	110
PM 25R/L	T15	105	304
PM 32R/L	T20 - IP	121	010



Screwdriver

AS

80 950 ...



Clamping screw

AS

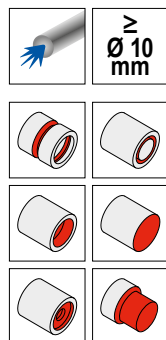
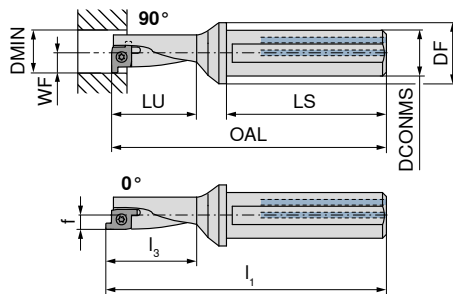
70 950 ...

EcoCut – Drilling, turning and grooving tool – ProfileMaster 2,25xD

▲ Drilling, turning and grooving tool

Scope of supply:

Base body equipped with one clamping screw and one screwdriver



Illustrations show right-hand versions



Designation	DMIN mm	DCONMS mm	DF mm	OAL mm	LU mm	LS mm	WF mm	I ₁ mm	I ₃ mm	f mm	Tightening torque Nm	Indexable insert
PMC 10 R/L 2,25D	10	12	18	72.4	22.50	42	5.0				0,4	PM 10R/L
PMC 12 R/L 2,25D	12	16	22	78.0	27.00	45	6.0				1,0	PM 12R/L
PMC 16 R/L 2,25D	16	20	28	96.5	36.00	50	8.0	98.8	38.3	5.7	2,2	PM 16R/L
PMC 20 R/L 2,25D	20	25	32	111.0	45.00	56	10.0	113.8	47.8	7.2	2,2	PM 20R/L
PMC 25 R/L 2,25D	25	32	44	132.6	56.25	60	12.5	135.9	59.6	9.2	3,2	PM 25R/L
PMC 32 R/L 2,25D	32	40	54	158.0	72.00	70	16.0	162.3	76.3	11.7	5,0	PM 32R/L

Left

Right

TO	TO
70 821 ...	70 820 ...
110 ¹⁾	110 ¹⁾
112 ¹⁾	112 ¹⁾
116	116
120	120
125	125
132	132

1) Only usable as 90° version



- Find suitable indexable inserts here.
- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

Spare parts

Indexable insert

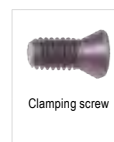
PM 10R/L	T06 - IP	116	M1,8x3,6 - 06IP	862
PM 12R/L	T07 - IP	117	M2,2x4,2 - 07IP	137
PM 16R/L	T09 - IP	118	M3x5,7 - 09IP	008
PM 20R/L	T15 - IP	120	M3x5,7 - 15IP	009
PM 25R/L	T15 - IP	120	M3,5x8,6 - 15IP	859
PM 32R/L	T20 - IP	121	M5x10,8 - 20IP	010



Screwdriver

AS

80 950 ...



Clamping screw

AS

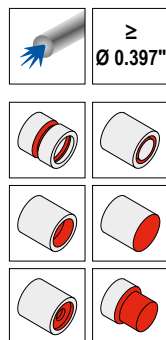
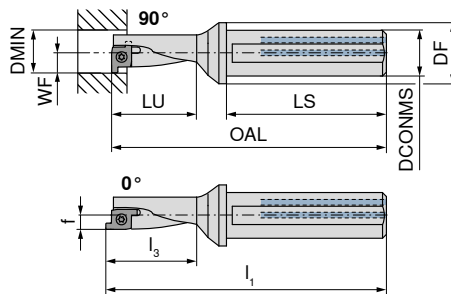
70 950 ...

EcoCut – Drilling, turning and grooving tool – ProfileMaster 2,25xD

▲ Drilling, turning and grooving tool

Scope of supply:

Base body equipped with one clamping screw and one screwdriver



Designation	DMIN inch	DCONMS inch	DF inch	OAL inch	LU inch	LS inch	WF inch	l_1 inch	l_3 inch	f inch	Tightening torque Nm	Indexable insert	Left TO 78 811 ...	Right TO 78 810 ...
PMC 10 R/L 2,25D-E	0.394	0.500	0.630	2.800	0.886	1.625	0.197				0,4	PM 10R/L	11000 ¹⁾	11000 ¹⁾
PMC 12 R/L 2,25D-E	0.472	0.625	0.787	3.000	1.063	1.750	0.236				1,0	PM 12R/L	11200 ¹⁾	11200 ¹⁾
PMC 16 R/L 2,25D-E	0.630	0.750	0.984	3.800	1.417	2.000	0.315	3.891	1.508	0.224	2,2	PM 16R/L	11600	11600
PMC 20 R/L 2,25D-E	0.787	1.000	1.260	4.400	1.772	2.250	0.394	4.510	1.882	0.283	2,2	PM 20R/L	12000	12000
PMC 25 R/L 2,25D-E	0.984	1.250	1.575	5.200	2.217	2.375	0.492	5.330	2.347	0.362	3,2	PM 25R/L	12500	12500
PMC 32 R/L 2,25D-E	1.260	1.500	1.969	6.200	2.835	2.750	0.630	6.369	3.004	0.461	5,0	PM 32R/L	13200	13200

1) Only usable as 90° version

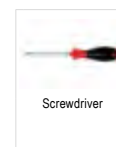


- Find suitable indexable inserts here.
- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

Spare parts

Indexable insert

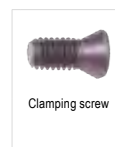
Designation	Indexable insert	AS 80 950 ...	AS 70 950 ...
PM 10R/L	T06	100	M1,8x3,8 57300
PM 12R/L	T07	101	M2,2x4 360
PM 16R/L	T08	102	M3x5,7 365
PM 20R/L	T15	105	M3,5x7,2 110
PM 25R/L	T15	105	M3,5x8,6 304
PM 32R/L	T20 - IP	121	M5x10,8 - 20IP 010



Screwdriver

AS

80 950 ...

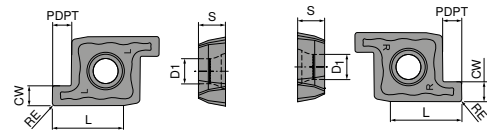
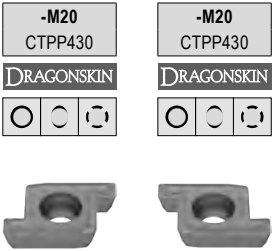


Clamping screw

AS

70 950 ...

EcoCut – HM indexable insert



M

PM-L

M

PM-R

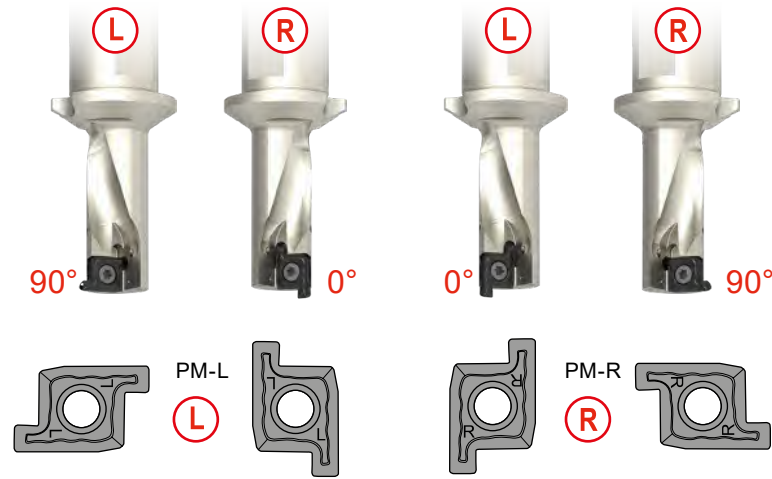
ISO	CW mm	PDPT mm	L mm	S mm	D1 mm	RE mm
PM 10 G 201504	2.0	1.5	5.0	2.1	2.1	0.4
PM 12 G 201804	2.0	1.8	6.0	2.3	2.5	0.4
PM 16 G 252004	2.5	2.0	8.0	2.8	3.4	0.4
PM 20 G 302504	3.0	2.5	10.0	3.7	4.0	0.4
PM 25 G 353004	3.5	3.0	12.5	4.5	4.4	0.4
PM 32 G 404004	4.0	4.0	16.0	5.6	6.0	0.4

MT	MT
70 289 ...	70 289 ...
510	511
515	516
520	521
525	526
530	531
535	536

P	●	●
M	●	●
K	○	○
N	○	○
S	●	●
H		
O	○	○



→ Find the recommended values for cutting speeds here.



Material examples for cutting data tables

	Material sub-group	Index	Composition / Structure / Heat treatment	Hardness HB / HRC Tensile strength at rupture (Rm) lbf/in ²	Material number Material designation	Material number Material designation
P	Unalloyed steel	P.1.1	< 0.15 % C, annealed	60900 lbf/in ² / 125 HB	1.0401 1015	1.0301 1010
		P.1.2	< 0.45 % C, annealed	92800 lbf/in ² / 190 HB	1.1191 1045	1.0737 12L14
		P.1.3	< 0.45 % C, tempered	121800 lbf/in ² / 250 HB	1.1191 1045	1.0503 1043
		P.1.4	< 0.75 % C, annealed	132000 lbf/in ² / 270 HB	1.1223 1060	1.0535 1055
		P.1.5	< 0.75 % C, tempered	146500 lbf/in ² / 300 HB	1.1223 1060	1.1274 1095
	Low-alloy steel	P.2.1	Annealed	88500 lbf/in ² / 180 HB	1.7131 5115	1.6523 8620
		P.2.2	Tempered	134900 lbf/in ² / 275 HB	1.7131 5115	1.6582 4340
		P.2.3	Tempered	146500 lbf/in ² / 300 HB	1.7225 4142	1.7131 5115
		P.2.4	Tempered	174000 lbf/in ² / 375 HB	1.7225 4142	1.7223 4140
	High-alloy steel and high-alloy tool steel	P.3.1	Annealed	98600 lbf/in ² / 200 HB	1.4021 420	1.2379 D2
		P.3.2	Hardened and tempered	159500 lbf/in ² / 300 HB	1.2343 H11	1.3343 M2
		P.3.3	Hardened and tempered	188500 lbf/in ² / 400 HB	1.2343 H11	1.2363 A2
	Stainless steel	P.4.1	Ferritic / martensitic, annealed	98600 lbf/in ² / 200 HB	1.4016 430	1.4125 440C
		P.4.2	Martensitic, tempered	117500 lbf/in ² / 300 HB	1.4112 S44003	1.4021 420
M	Stainless steel	M.1.1	Austenitic / austenitic-ferritic, quenched	88500 lbf/in ² / 180 HB	1.4301 304	1.4401 316
		M.2.1	Austenitic, tempered	300 HB	1.4841 314	1.4568 17-7 PH
		M.3.1	Austenitic / ferritic (Duplex)	113100 lbf/in ² / 230 HB	1.4462 S32205	1.4410 S32750
K	Grey cast iron	K.1.1	Pearlitic / ferritic	88500 lbf/in ² / 180 HB	0.6010 A48-20B	0.6025 A48-40 B
		K.1.2	Pearlitic (martensitic)	127600 lbf/in ² / 260 HB	0.6030 A48-45B	0.6040 A48-60 B
	Spherulitic graphite cast iron	K.2.1	Ferritic	78300 lbf/in ² / 160 HB	0.7040 60-40-18	0.7050 65-45-12
		K.2.2	Pearlitic	122600 lbf/in ² / 250 HB	0.7070 100-70-03	0.7660 A439 Type D2
	Malleable iron	K.3.1	Ferritic	63800 lbf/in ² / 130 HB	0.8035 GTW-35-04	
		K.3.2	Pearlitic	113100 lbf/in ² / 230 HB	0.8170 70003	
N	Aluminium wrought alloy	N.1.1	Non-hardenable	60 HB	3.0255 A91060	3.0255 A91060
		N.1.2	Hardenable, age-hardened	49300 lbf/in ² / 100 HB	3.1355 2024	3.1355 2024
	Cast aluminium alloy	N.2.1	≤ 12 % Si, non-hardenable	36300 lbf/in ² / 75 HB	3.2581 A04130 / A413-0	3.2581 A04130 / A413-0
		N.2.2	≤ 12 % Si, hardenable, age-hardened	43500 lbf/in ² / 90 HB	3.2134 G-AISi5Cu1Mg	
		N.2.3	> 12 % Si, non-hardenable	63800 lbf/in ² / 130 HB	G-AISi17Cu4Mg	
	Copper and copper alloys (bronze/brass)	N.3.1	Free-machining alloys, Pb > 1 %	54400 lbf/in ² / 110 HB	2.0380 CuZn39Pb2 (Ms58)	2.0380 C37700
		N.3.2	CuZn, CuSnZn	43500 lbf/in ² / 90 HB	2.0331 CuZn15	2.0331 C34000
		N.3.3	CuSn, lead-free copper and electrolytic copper	49300 lbf/in ² / 100 HB	2.0060 E-Cu57	
	Magnesium alloys	N.4.1	Magnesium and magnesium alloys	70 HB	3.5612 MgAl6Zn	
S	Heat-resistant alloys	S.1.1	Fe basis, annealed	98600 lbf/in ² / 200 HB	1.4864 X12NiCrSi 36-16	1.4864 330
		S.1.2	Fe basis, age-hardened	137800 lbf/in ² / 280 HB	1.4980 X6NiCrTiMoVB25-15-2	1.4980 S66286
		S.2.1	Ni or Co basis, annealed	121800 lbf/in ² / 250 HB	2.4856 Inconel 625	2.4812 Hastelloy C
		S.2.2	Ni or Co basis, age-hardened	171100 lbf/in ² / 350 HB	2.4952 Nimonic 80A	2.4668 Inconel 718
		S.2.3	Ni or Co basis, cast	156600 lbf/in ² / 320 HB	2.4674 Nimocast PK24	2.4670 Nimocast 713
	Titanium alloys	S.3.1	Pure titanium	5800 lbf/in ²	3.7025 Ti99,8	
		S.3.2	Alpha + beta alloys, age-hardened	152300 lbf/in ² / 320 HB	3.7165 TiAl6V4	
		S.3.3	Beta alloys	203100 lbf/in ² / 410 HB	Ti555.3 Ti-5Al-5V-5Mo-3Cr	
H	Hardened steel	H.1.1	Hardened and tempered	46–55 HRC		
		H.1.2	Hardened and tempered	56–60 HRC		
		H.1.3	Hardened and tempered	61–65 HRC		
		H.1.4	Hardened and tempered	66–70 HRC		
	Chilled iron	H.2.1	Cast	400 HB		
	Hardened cast iron	H.3.1	Hardened and tempered	55 HRC		
O	Non-metal materials	O.1.1	Plastics, duroplastic	≤ 21800 lbf/in ²	EP, MF, PF, UP	
		O.1.2	Plastics, thermoplastic	≤ 14500 lbf/in ²	PA, PC, PE, PI, PMMA, POM, PP, PS, PTFE, PVC	
		O.2.1	Aramid fibre-reinforced	≤ 145000 lbf/in ²	AFK	
		O.2.2	Glass/carbon-fibre reinforced	≤ 145000 lbf/in ²	CFRP, GFRP	
		O.3.1	Graphite			

EcoCut – Cutting data standard values

Index	EcoCut – Mini		EcoCut – Classic / EcoCut – Solid					EcoCut – ProfileMaster
	CTWN425	CTPP435 DRAGONSKIN	CTCP425-P DRAGONSKIN	CTCP435-P DRAGONSKIN	CTPP430 DRAGONSKIN	H210T	H216T	CTPP430 DRAGONSKIN
	v _c (m/min)		v _c (m/min)					v _c (m/min)
P.1.1		145	300	270	240			240
P.1.2		125	280	250	230			230
P.1.3		105	250	230	210			210
P.1.4		100	240	220	200			200
P.1.5		90	220	200	180			180
P.2.1		130	280	250	230			230
P.2.2		100	250	230	210			210
P.2.3		90	230	210	190			190
P.2.4		70	210	190	170			170
P.3.1		105	250	230	210			210
P.3.2		70	200	180	160			160
P.3.3		60	180	160	140			140
P.4.1		104	230	210	190			190
P.4.2		85	200	180	160			160
M.1.1		105	200	200	180			180
M.2.1		65			120			120
M.3.1		95			160			160
K.1.1	140	140	240	220	160	170	110	160
K.1.2	115	120	230	210	140	130	90	140
K.2.1	150	140	220	200	160	180	120	160
K.2.2	110	120	210	190	140	130	85	140
K.3.1	170	150	200	185	125	190	140	125
K.3.2	140	125	200	185	110	160	110	110
N.1.1	420	330			400	600	400	400
N.1.2	220	180			290	310	290	290
N.2.1	220	180			290	320	290	290
N.2.2	210	170			190	300	190	190
N.2.3	280	220			340	400	340	340
N.3.1	320	260			240	460	240	240
N.3.2	320	260			240	460	240	240
N.3.3	250	200			190	360	190	190
N.4.1	180	150			140	260	140	140
S.1.1	40	35			55	45	35	55
S.1.2	30	30			55	35	25	55
S.2.1	30	20			55	35	25	55
S.2.2	25	15			55	25	20	55
S.2.3	20	15			55	20	20	55
S.3.1	90	85			70	110	65	70
S.3.2	55	40			60	70	43	60
S.3.3	40	30			40	50	30	40
H.1.1								
H.1.2								
H.1.3								
H.1.4								
H.2.1								
H.3.1								
O.1.1	130	110			110	110	155	130
O.1.2								
O.2.1	105	95			95	95	140	105
O.2.2								
O.3.1								



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approximately **±20%** according to the usage conditions.

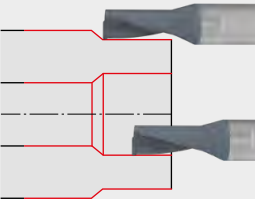
EcoCut – Cutting data standard values

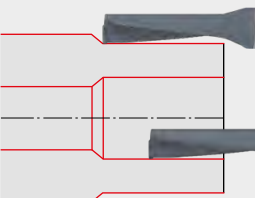
Index	EcoCut – Mini		EcoCut – Classic / EcoCut – Solid					EcoCut – ProfileMaster
	CTWN425	CTPP435 DRAGONSKIN	CTCP425-P DRAGONSKIN	CTCP435-P DRAGONSKIN	CTPP430 DRAGONSKIN	H210T	H216T	CTPP430 DRAGONSKIN
	v_c (ft/min)		v_c (ft/min)					v_c (ft/min)
P.1.1		480	980	890	780			790
P.1.2		410	920	820	750			750
P.1.3		340	820	750	690			690
P.1.4		330	790	720	650			660
P.1.5		300	720	650	590			590
P.2.1		430	910	820	750			750
P.2.2		330	820	750	690			690
P.2.3		300	750	690	620			620
P.2.4		230	690	620	560			560
P.3.1		340	820	750	690			690
P.3.2		230	650	590	520			520
P.3.3		200	590	520	460			460
P.4.1		340	750	690	620			620
P.4.2		280	650	590	520			520
M.1.1		340	650	650	590			590
M.2.1		210			390			390
M.3.1		310			530			530
K.1.1	460	460	780	720	530	560	360	530
K.1.2	380	400	750	690	460	430	290	460
K.2.1	500	460	720	650	530	590	390	530
K.2.2	360	390	690	620	460	430	280	460
K.3.1	560	490	650	610	410	620	460	410
K.3.2	460	410	650	610	360	520	360	360
N.1.1	1380	1080			1310	1970	1310	1310
N.1.2	720	590			950	1020	950	950
N.2.1	720	590			950	1050	950	950
N.2.2	690	560			620	980	620	620
N.2.3	910	720			1120	1310	1120	1120
N.3.1	1050	850			790	1510	790	790
N.3.2	1050	850			790	1510	790	790
N.3.3	820	660			620	1180	620	620
N.4.1	590	500			460	850	460	460
S.1.1	130	120			180	150	110	180
S.1.2	100	100			180	110	80	180
S.2.1	100	60			180	110	80	180
S.2.2	80	50			180	80	70	180
S.2.3	70	50			180	70	70	180
S.3.1	300	280			230	350	210	230
S.3.2	180	130			200	230	140	200
S.3.3	130	100			130	160	100	130
H.1.1								
H.1.2								
H.1.3								
H.1.4								
H.2.1								
H.3.1								
O.1.1	430	360			360	360	510	430
O.1.2								
O.2.1	350	310			310	310	460	340
O.2.2								
O.3.1								

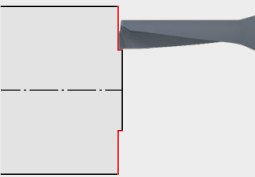


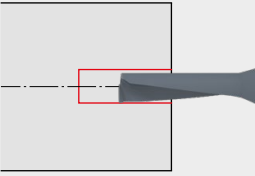
The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approximately $\pm 20\%$ according to the usage conditions.

EcoCut – Mini – Cutting depths and feed rates

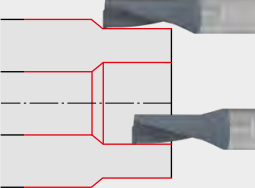
Longitudinal turning		2,25xD									
	Size	Depth of cut a_p (mm)									
		0,25	0,5	0,75	1,0	1,5	2,0	2,5	3,0	3,5	4,0
		Feed f (mm/rev.)									
	ECM 02	0,02–0,07	0,02–0,07								
	ECM 02,5	0,02–0,07	0,02–0,07	0,02–0,05							
	ECM 03	0,02–0,07	0,02–0,07	0,02–0,05	0,02–0,05						
	ECM 03,5	0,02–0,07	0,02–0,07	0,02–0,05	0,02–0,05	0,02–0,05					
	ECM 04	0,04–0,1	0,04–0,1	0,04–0,1	0,04–0,1	0,03–0,07	0,01–0,05				
	ECM 05	0,04–0,1	0,04–0,1	0,04–0,1	0,04–0,1	0,03–0,08	0,02–0,06	0,01–0,04			
	ECM 06	0,04–0,1	0,04–0,1	0,04–0,1	0,04–0,1	0,04–0,1	0,03–0,08	0,02–0,06	0,01–0,04		
	ECM 07	0,04–0,1	0,04–0,1	0,04–0,1	0,04–0,1	0,04–0,1	0,04–0,1	0,03–0,08	0,02–0,06	0,01–0,04	
	ECM 08	0,04–0,1	0,04–0,1	0,04–0,1	0,04–0,1	0,04–0,1	0,04–0,1	0,04–0,1	0,03–0,08	0,02–0,06	0,01–0,04

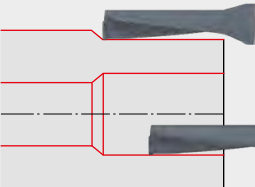
Longitudinal turning		4xD								
	Size	Depth of cut a_p (mm)								
		0,25	0,5	0,75	1,0	1,5	2,0	2,5	3,0	
		Feed f (mm/rev.)								
	ECM 02	0,02–0,05	0,01–0,05							
	ECM 02,5	0,02–0,05	0,01–0,05							
	ECM 03	0,02–0,05	0,02–0,05	0,01–0,05						
	ECM 03,5	0,02–0,05	0,02–0,05	0,02–0,05	0,01–0,05					
	ECM 04	0,04–0,1	0,04–0,1	0,04–0,1	0,03–0,08	0,01–0,05				
	ECM 05	0,04–0,1	0,04–0,1	0,04–0,1	0,03–0,085	0,02–0,06	0,01–0,04			
	ECM 06	0,04–0,1	0,04–0,1	0,04–0,1	0,03–0,085	0,02–0,06	0,01–0,04			
	ECM 07	0,04–0,1	0,04–0,1	0,04–0,1	0,04–0,1	0,03–0,08	0,02–0,06	0,01–0,04		
	ECM 08	0,04–0,1	0,04–0,1	0,04–0,1	0,04–0,1	0,04–0,095	0,03–0,08	0,02–0,06	0,01–0,04	

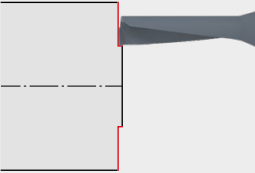
Face turning		2,25xD		4xD	
	Size	Depth of cut a_p max. (mm)		Depth of cut a_p max. (mm)	
		Feed f (mm/rev)		Feed f (mm/rev)	
	ECM 02	0,30	0,01–0,05	0,30	0,01–0,03
	ECM 02,5	0,30	0,01–0,05	0,30	0,01–0,03
	ECM 03	0,50	0,01–0,06	0,50	0,01–0,04
	ECM 03,5	0,50	0,01–0,06	0,50	0,01–0,04
	ECM 04	0,70	0,03–0,07	0,70	0,02–0,05
	ECM 05	0,70	0,03–0,07	0,70	0,02–0,05
	ECM 06	0,70	0,03–0,07	0,70	0,02–0,05
	ECM 07	1,00	0,04–0,08	1,00	0,03–0,06
	ECM 08	1,00	0,04–0,08	1,00	0,03–0,06

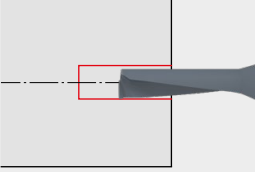
Drilling		2,25xD		4xD	
	Size	Feed f (mm/rev)		Feed f (mm/rev)	
		Max. hole depth (mm)		Max. hole depth (mm)	
	ECM 02	0,0025–0,0075	4,50	0,0025–0,005	8,0
	ECM 02,5	0,0025–0,010	5,63	0,0025–0,005	10,0
	ECM 03	0,0025–0,0125	6,75	0,0025–0,010	12,0
	ECM 03,5	0,0025–0,0150	7,88	0,0025–0,010	14,0
	ECM 04	0,005–0,030	9,0	0,005–0,0125	16,0
	ECM 05	0,005–0,030	11,25	0,005–0,015	20,0
	ECM 06	0,005–0,030	13,5	0,005–0,020	24,0
	ECM 07	0,005–0,035	15,75	0,005–0,025	28,0
	ECM 08	0,005–0,040	18,0	0,005–0,030	32,0

EcoCut – Mini – Cutting depths and feed rates

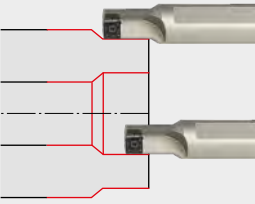
Longitudinal turning		2.25xD									
	Size	Depth of Cut a_p (inch)									
		0.010	0.020	0.030	0.040	0.060	0.080	0.100	0.120	0.140	0.160
		Feed rate f (inch/rev.)									
	ECM 02	.0008–.0028	.0008–.0028								
	ECM 02,5	.0008–.0028	.0008–.0028	.0008–.0020							
	ECM 03	.0008–.0028	.0008–.0028	.0008–.0020	.0008–.0020						
	ECM 03,5	.0008–.0028	.0008–.0028	.0008–.0020	.0008–.0020	.0008–.0020					
	ECM 04	.0016–.0040	.0016–.0040	.0016–.0040	.0016–.0040	.0012–.0028	.0004–.0020				
	ECM 05	.0016–.0040	.0016–.0040	.0016–.0040	.0016–.0040	.0012–.0032	.0008–.0024	.0004–.0016			
	ECM 06	.0016–.0040	.0016–.0040	.0016–.0040	.0016–.0040	.0016–.0040	.0012–.0032	.0008–.0024	.0004–.0016		
	ECM 07	.0016–.0040	.0016–.0040	.0016–.0040	.0016–.0040	.0016–.0040	.0016–.0040	.0012–.0032	.0008–.0024	.0004–.0016	
	ECM 08	.0016–.0040	.0016–.0040	.0016–.0040	.0016–.0040	.0016–.0040	.0016–.0040	.0016–.0040	.0012–.0032	.0008–.0024	.0004–.0016

Longitudinal turning		4xD									
	Size	Depth of Cut a_p (inch)									
		0.010	0.020	0.030	0.040	0.060	0.080	0.100	0.120		
		Feed rate f (inch/rev.)									
	ECM 02	.0008–.0020	.0004–.0020								
	ECM 02,5	.0008–.0020	.0004–.0020								
	ECM 03	.0008–.0020	.0008–.0020	.0004–.0020							
	ECM 03,5	.0008–.0020	.0008–.0020	.0008–.0020	.0004–.0020						
	ECM 04	.0016–.0040	.0016–.0040	.0016–.0040	.0012–.0032	.0004–.0020					
	ECM 05	.0016–.0040	.0016–.0040	.0016–.0040	.0012–.00325	.0008–.0024	.0004–.0016				
	ECM 06	.0016–.0040	.0016–.0040	.0016–.0040	.0012–.00325	.0008–.0024	.0004–.0016				
	ECM 07	.0016–.0040	.0016–.0040	.0016–.0040	.0016–.0040	.0012–.0032	.0008–.0024	.0004–.0016			
	ECM 08	.0016–.0040	.0016–.0040	.0016–.0040	.0016–.0040	.0016–.00365	.0012–.0032	.0008–.0024	.0004–.0016		

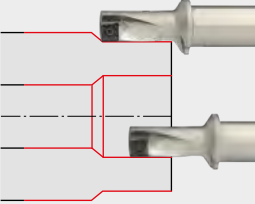
Face turning		2.25xD		4xD	
	Size	Depth of cut a_p max. (inch)		Depth of cut a_p max. (inch)	
		Feed f (inch/rev)		Feed f (inch/rev)	
	ECM 02	0.012	.0004–.0020	0.012	.0004–.0012
	ECM 02,5	0.012	.0004–.0020	0.012	.0004–.0012
	ECM 03	0.020	.0004–.0024	0.020	.0004–.0016
	ECM 03,5	0.020	.0004–.0024	0.020	.0004–.0016
	ECM 04	0.028	.0012–.0028	0.028	.0008–.0020
	ECM 05	0.028	.0012–.0028	0.028	.0008–.0020
	ECM 06	0.028	.0012–.0028	0.028	.0008–.0020
	ECM 07	0.039	.0016–.0032	0.039	.0012–.0024
	ECM 08	0.039	.0016–.0032	0.039	.0012–.0024

Drilling		2.25xD		4xD	
	Size	Feed f (inch/rev)		Feed f (inch/rev)	
		Max. hole depth (inch)		Max. hole depth (inch)	
	ECM 02	.0001–.0003	0.177	.0001–.0003	0.315
	ECM 02,5	.0001–.0004	0.222	.0001–.0004	0.394
	ECM 03	.0001–.0005	0.266	.0001–.0005	0.472
	ECM 03,5	.0001–.0006	0.310	.0001–.0006	0.551
	ECM 04	.0002–.0012	0.354	.0002–.0012	0.630
	ECM 05	.0002–.0012	0.443	.0002–.0012	0.787
	ECM 06	.0002–.0012	0.531	.0002–.0012	0.945
	ECM 07	.0002–.0014	0.620	.0002–.0014	1.102
	ECM 08	.0002–.0016	0.709	.0002–.0016	1.260

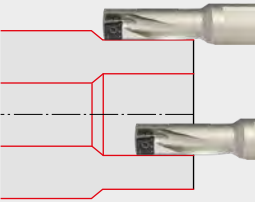
EcoCut – Classic – Cutting depths and feed rates

Longitudinal turning		1,5xD											
	Size	Depth of cut a_p (mm)											
		1,0	2,0	3,0	4,0	5,0	6,0	7,0	8,0	9,0	10,0	12,0	14,0
		Feed f (mm/rev.)											
	ECC 08	0,05–0,20	0,05–0,15	0,05–0,10	0,05–0,10								
	ECC 10	0,05–0,20	0,05–0,18	0,05–0,13	0,05–0,11	0,05–0,10							
	ECC 12	0,05–0,20	0,05–0,18	0,05–0,16	0,05–0,14	0,05–0,12	0,05–0,10						
	ECC 14	0,09–0,20	0,09–0,20	0,09–0,18	0,09–0,16	0,07–0,15	0,05–0,12	0,05–0,1					
	ECC 16	0,10–0,20	0,10–0,20	0,10–0,20	0,10–0,20	0,08–0,18	0,06–0,16	0,05–0,14	0,05–0,12				
	ECC 18	0,10–0,20	0,10–0,20	0,10–0,20	0,10–0,20	0,10–0,20	0,09–0,20	0,07–0,18	0,05–0,16	0,05–0,13			
	ECC 20	0,10–0,40	0,10–0,40	0,10–0,40	0,10–0,30	0,10–0,30	0,10–0,25	0,10–0,21	0,10–0,19	0,08–0,17	0,08–0,15		
	ECC 25	0,10–0,40	0,10–0,40	0,10–0,40	0,10–0,35	0,10–0,30	0,10–0,30	0,10–0,25	0,10–0,25	0,10–0,22	0,10–0,20	0,10–0,16	
	ECC 32	0,10–0,40	0,10–0,40	0,10–0,40	0,10–0,35	0,10–0,35	0,10–0,30	0,10–0,25	0,10–0,25	0,10–0,25	0,10–0,25	0,10–0,22	0,10–0,20

 Feeds f pertain to the tool and should be adjusted based on the insert radius. If -M50Q or -27Q are used, the feeds can be increased by 25 to 50%.

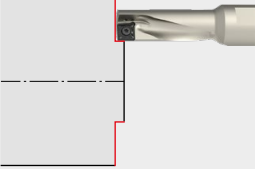
Longitudinal turning		2,25xD											
	Size	Depth of cut a_p (mm)											
		1,0	2,0	2,5	3,0	3,5	4,0	4,5	5,0	5,5	6,0	7,0	
		Feed f (mm/rev.)											
	ECC 08	0,05–0,20	0,05–0,15	0,05–0,10									
	ECC 10	0,05–0,20	0,05–0,15	0,05–0,11	0,05–0,09								
	ECC 12	0,05–0,20	0,05–0,20	0,05–0,15	0,05–0,12	0,05–0,10							
	ECC 14	0,09–0,20	0,09–0,20	0,07–0,15	0,05–0,14	0,05–0,13	0,05–0,11						
	ECC 16	0,10–0,20	0,10–0,20	0,10–0,19	0,07–0,17	0,05–0,15	0,05–0,15						
	ECC 18	0,10–0,20	0,10–0,20	0,10–0,20	0,09–0,20	0,07–0,18	0,05–0,16	0,05–0,14					
	ECC 20	0,10–0,40	0,10–0,40	0,10–0,35	0,10–0,35	0,10–0,30	0,10–0,25	0,10–0,18	0,05–0,16				
	ECC 25	0,10–0,40	0,10–0,40	0,10–0,40	0,10–0,40	0,10–0,35	0,10–0,30	0,10–0,25	0,08–0,20	0,06–0,19	0,05–0,17		
	ECC 32	0,10–0,40	0,10–0,40	0,10–0,40	0,10–0,40	0,10–0,40	0,10–0,35	0,10–0,30	0,10–0,27	0,10–0,25	0,10–0,23	0,10–0,20	

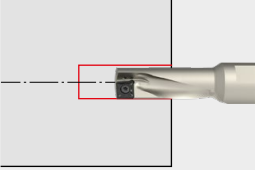
 Feeds f pertain to the tool and should be adjusted based on the insert radius. If -M50Q or -27Q are used, the feeds can be increased by 25 to 50%.

Longitudinal turning		3xD							
	Size	Depth of cut a_p (mm)							
		1,0	2,0	2,5	3,0	3,5	4,0	5,0	
		Feed f (mm/rev.)							
	ECC 08	0,05–0,20	0,05–0,15						
	ECC 10	0,05–0,20	0,05–0,15						
	ECC 12	0,05–0,20	0,05–0,15	0,05–0,12					
	ECC 14	0,09–0,20	0,09–0,18	0,09–0,15					
	ECC 16	0,10–0,20	0,10–0,18	0,10–0,15	0,10–0,12				
	ECC 18	0,10–0,20	0,10–0,20	0,10–0,17	0,10–0,15				
	ECC 20	0,10–0,40	0,10–0,40	0,10–0,35	0,10–0,30	0,10–0,28	0,10–0,25		
	ECC 25	0,10–0,40	0,10–0,40	0,10–0,35	0,10–0,32	0,10–0,30	0,10–0,25		
	ECC 32	0,10–0,40	0,10–0,40	0,10–0,40	0,10–0,38	0,10–0,35	0,10–0,30	0,10–0,25	

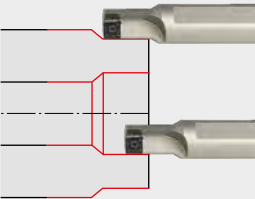
 Feeds f pertain to the tool and should be adjusted based on the insert radius. If -M50Q or -27Q are used, the feeds can be increased by 25 to 50%.

EcoCut – Classic – Cutting depths and feed rates

Face turning		1,5xD		2,25xD		3xD	
	Size	Depth of cut a_p (mm)	Feed f (mm/rev)	Depth of cut a_p (mm)	Feed f (mm/rev)	Depth of cut a_p (mm)	Feed f (mm/rev)
	ECC 08	2,00	0,05–0,10	1,90	0,04–0,09	1,10	0,04–0,07
	ECC 10	2,50	0,06–0,12	2,20	0,05–0,10	1,20	0,04–0,09
	ECC 12	3,00	0,07–0,14	2,60	0,06–0,12	1,40	0,05–0,11
	ECC 14	3,50	0,08–0,16	3,00	0,07–0,14	1,60	0,06–0,12
	ECC 16	4,00	0,09–0,18	3,40	0,08–0,16	1,90	0,06–0,13
	ECC 18	4,50	0,10–0,20	3,80	0,09–0,18	2,00	0,07–0,14
	ECC 20	5,00	0,11–0,22	4,20	0,10–0,20	2,20	0,08–0,15
	ECC 25	6,00	0,12–0,24	5,00	0,11–0,22	2,60	0,09–0,18
	ECC 32	8,00	0,13–0,27	6,00	0,12–0,25	3,00	0,10–0,20

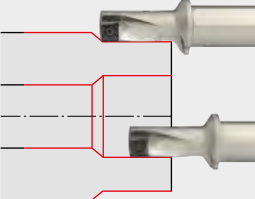
Drilling		1,5xD		2,25xD		3xD	
	Size	Feed f (mm/rev)	Max. hole depth (mm)	Feed f (mm/rev)	Max. hole depth (mm)	Feed f (mm/rev)	Max. hole depth (mm)
	ECC 08	0,01–0,04	12,0	0,01–0,04	18,0	0,01–0,02	24,0
	ECC 10	0,01–0,05	15,0	0,01–0,05	22,5	0,01–0,03	30,0
	ECC 12	0,01–0,05	18,0	0,01–0,05	27,0	0,01–0,04	36,0
	ECC 14	0,01–0,07	21,0	0,01–0,07	31,5	0,01–0,05	42,0
	ECC 16	0,02–0,08	24,0	0,02–0,08	36,0	0,02–0,06	48,0
	ECC 18	0,03–0,09	27,0	0,03–0,09	40,5	0,03–0,07	54,0
	ECC 20	0,03–0,10	30,0	0,03–0,10	45,0	0,03–0,08	60,0
	ECC 25	0,03–0,12	37,5	0,03–0,12	56,5	0,04–0,09	75,0
	ECC 32	0,05–0,15	48,0	0,05–0,15	72,0	0,05–0,11	96,0

EcoCut – Classic – Cutting depths and feed rates

Longitudinal turning		1.5xD											
	Size	Depth of Cut a_p (inch)											
		0.039	0.079	0.118	0.157	0.197	0.236	0.276	0.315	0.354	0.394	0.472	0.551
		Feed rate f (inch/rev.)											
	ECC 08	.0020–.0080	.0020–.0060	.0020–.0040	.0020–.0040								
	ECC 10	.0020–.0080	.0020–.0071	.0020–.0051	.0020–.0043	.0020–.0040							
	ECC 12	.0020–.0080	.0020–.0071	.0020–.0063	.0020–.0055	.0020–.0047	.0020–.0040						
	ECC 14	.0036–.0080	.0036–.0080	.0036–.0071	.0036–.0063	.0028–.0060	.0020–.0047	.0020–.0040					
	ECC 16	.0040–.0080	.0040–.0080	.0040–.0080	.0040–.0080	.0031–.0071	.0024–.0063	.0020–.0055	.0020–.0047				
	ECC 18	.0040–.0080	.0040–.0080	.0040–.0080	.0040–.0080	.0040–.0080	.0036–.0080	.0028–.0071	.0020–.0063	.0020–.0051			
	ECC 20	.0040–.0160	.0040–.0160	.0040–.0160	.0040–.0118	.0040–.0118	.0040–.0098	.0040–.0083	.0040–.0075	.0031–.0067	.0031–.0060		
	ECC 25	.0040–.0160	.0040–.0160	.0040–.0160	.0040–.0138	.0040–.0118	.0040–.0118	.0040–.0098	.0040–.0098	.0040–.0087	.0040–.0080	.0040–.0063	
	ECC 32	.0040–.0160	.0040–.0160	.0040–.0160	.0040–.0138	.0040–.0138	.0040–.0118	.0040–.0098	.0040–.0098	.0040–.0098	.0040–.0098	.0040–.0087	.0040–.0080

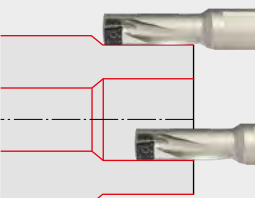


Feeds f pertain to the tool and should be adjusted based on the insert radius. If -M50Q or -27Q are used, the feeds can be increased by 25 to 50%.

Longitudinal turning		2.25xD											
	Size	Depth of Cut a_p (inch)											
		0.039	0.079	0.098	0.118	0.138	0.157	0.177	0.197	0.217	0.236	0.276	
		Feed rate f (inch/rev.)											
	ECC 08	.0020–.0080	.0020–.0060	.0020–.0040									
	ECC 10	.0020–.0080	.0020–.0060	.0020–.0043	.0020–.0036								
	ECC 12	.0020–.0080	.0020–.0080	.0020–.0060	.0020–.0047	.0020–.0040							
	ECC 14	.0036–.0080	.0036–.0080	.0028–.0060	.0020–.0055	.0020–.0051	.0020–.0043						
	ECC 16	.0040–.0080	.0040–.0080	.0040–.0075	.0028–.0067	.0020–.0060	.0020–.0060						
	ECC 18	.0040–.0080	.0040–.0080	.0040–.0080	.0036–.0080	.0028–.0071	.0020–.0063	.0020–.0055					
	ECC 20	.0040–.0160	.0040–.0160	.0040–.0138	.0040–.0138	.0040–.0118	.0040–.0098	.0040–.0071	.0020–.0063				
	ECC 25	.0040–.0160	.0040–.0160	.0040–.0160	.0040–.0160	.0040–.0138	.0040–.0118	.0040–.0098	.0031–.0080	.0024–.0075	.0020–.0067		
	ECC 32	.0040–.0160	.0040–.0160	.0040–.0160	.0040–.0160	.0040–.0160	.0040–.0138	.0040–.0118	.0040–.0106	.0040–.0098	.0040–.0091	.0040–.0080	



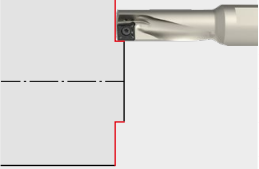
Feeds f pertain to the tool and should be adjusted based on the insert radius. If -M50Q or -27Q are used, the feeds can be increased by 25 to 50%.

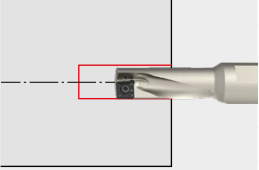
Longitudinal turning		3xD							
	Size	Depth of Cut a_p (inch)							
		0.039	0.079	0.098	0.118	0.138	0.157	0.197	
		Feed rate f (inch/rev.)							
	ECC 08	.0020–.0080	.0020–.0060						
	ECC 10	.0020–.0080	.0020–.0060						
	ECC 12	.0020–.0080	.0020–.0060	.0020–.0047					
	ECC 14	.0036–.0080	.0036–.0071	.0036–.0060					
	ECC 16	.0040–.0080	.0040–.0071	.0040–.0060	.0040–.0047				
	ECC 18	.0040–.0080	.0040–.0080	.0040–.0067	.0040–.0060				
	ECC 20	.0040–.0160	.0040–.0160	.0040–.0138	.0040–.0118	.0040–.0110	.0040–.0098		
	ECC 25	.0040–.0160	.0040–.0160	.0040–.0138	.0040–.0126	.0040–.0118	.0040–.0098		
	ECC 32	.0040–.0160	.0040–.0160	.0040–.0160	.0040–.0150	.0040–.0138	.0040–.0118	.0040–.0098	



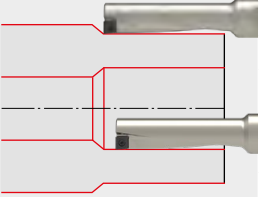
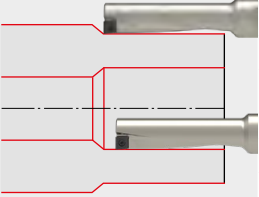
Feeds f pertain to the tool and should be adjusted based on the insert radius. If -M50Q or -27Q are used, the feeds can be increased by 25 to 50%.

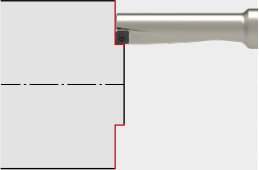
EcoCut – Classic – Cutting depths and feed rates

Face turning		1.5xD		2.25xD		3xD	
	Size	Depth of cut a_p (inch)	Feed f (inch/rev)	Depth of cut a_p (inch)	Feed f (inch/rev)	Depth of cut a_p (inch)	Feed f (inch/rev)
	ECC 08	0.079	.0020–.0040	0.075	.0016–.0036	0.043	.0016–.0028
	ECC 10	0.098	.0024–.0048	0.087	.0020–.0040	0.047	.0016–.0036
	ECC 12	0.118	.0028–.0056	0.102	.0024–.0048	0.055	.0020–.0044
	ECC 14	0.138	.0032–.0064	0.118	.0028–.0056	0.063	.0024–.0048
	ECC 16	0.157	.0036–.0072	0.134	.0032–.0064	0.075	.0024–.0052
	ECC 18	0.177	.0040–.0080	0.150	.0036–.0072	0.079	.0028–.0056
	ECC 20	0.197	.0044–.0088	0.165	.0040–.0080	0.087	.0032–.0060
	ECC 25	0.236	.0048–.0094	0.197	.0044–.0088	0.102	.0036–.0072
	ECC 32	0.315	.0052–.0106	0.236	.0048–.0100	0.118	.0040–.0080

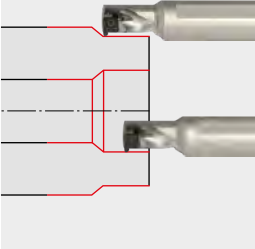
Drilling		1.5xD		2.25xD		3xD	
	Size	Feed f (inch/rev)	Max. hole depth (inch)	Feed f (inch/rev)	Max. hole depth (inch)	Feed f (inch/rev)	Max. hole depth (inch)
	ECC 08	.0004–.0016	0.472	.0004–.0016	0.709	.0004–.0008	0.945
	ECC 10	.0004–.0020	0.591	.0004–.0020	0.886	.0004–.0012	1.181
	ECC 12	.0004–.0020	0.709	.0004–.0020	1.063	.0004–.0016	1.417
	ECC 14	.0004–.0028	0.827	.0004–.0028	1.240	.0004–.0020	1.654
	ECC 16	.0008–.0032	0.945	.0008–.0032	1.417	.0008–.0024	1.890
	ECC 18	.0012–.0036	1.063	.0012–.0036	1.594	.0012–.0028	2.126
	ECC 20	.0012–.0040	1.181	.0012–.0040	1.772	.0012–.0032	2.362
	ECC 25	.0012–.0048	1.476	.0012–.0048	2.224	.0016–.0036	2.953
	ECC 32	.0020–.0060	1.890	.0020–.0060	2.835	.0020–.0044	3.780

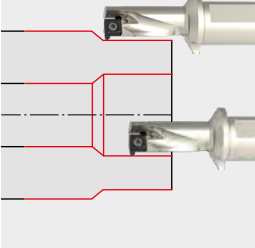
EcoCut – Solid – Cutting depths and feed rates

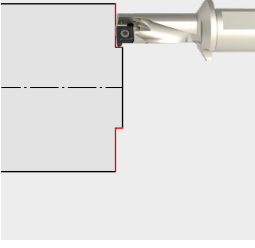
Longitudinal turning		4xD					
	Size	Depth of cut a_p (mm)					
		1,0	2,0	2,5	3,0	3,5	4,0
		Feed f (mm/rev.)					
	ECS 10	0,05–0,10	0,02–0,06				
	ECS 12	0,06–0,11	0,03–0,07				
	ECS 16	0,06–0,12	0,04–0,10	0,02–0,08			
	ECS 20	0,07–0,15	0,06–0,14	0,04–0,12	0,02–0,09		
	ECS 25	0,09–0,18	0,09–0,18	0,09–0,18	0,07–0,16	0,05–0,14	0,03–0,12

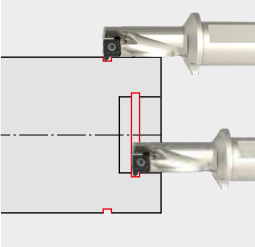
Face turning		4xD	
	Size	Depth of cut a_p max. (mm)	Feed f (mm/rev)
	ECS 10	1,1	0,04–0,07
	ECS 12	1,2	0,04–0,09
	ECS 16	1,4	0,05–0,11
	ECS 20	1,9	0,06–0,13
	ECS 25	2,2	0,08–0,15

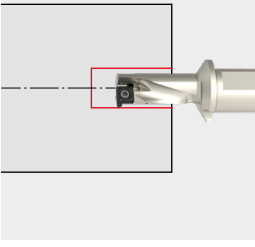
EcoCut – ProfileMaster 90° – Cutting depths and feed rates

Longitudinal turning		1,5xD							
	Size	Depth of cut a_p (mm)							
		1,0	2,0	3,0	4,0	5,0	6,0	7,0	8,0
		Feed f (mm/rev.)							
	PMC 10	0,07–0,20	0,05–0,17	0,02–0,12					
	PMC 12	0,07–0,20	0,05–0,17	0,02–0,12					
	PMC 16	0,10–0,25	0,07–0,23	0,05–0,21	0,02–0,17				
	PMC 20	0,12–0,27	0,10–0,26	0,07–0,24	0,05–0,20	0,02–0,14			
	PMC 25	0,15–0,30	0,15–0,30	0,13–0,28	0,10–0,26	0,05–0,22	0,02–0,18		
	PMC 32	0,15–0,30	0,15–0,30	0,15–0,30	0,15–0,30	0,10–0,27	0,07–0,24	0,05–0,21	0,02–0,15

Longitudinal turning		2,25xD				
	Size	Depth of cut a_p (mm)				
		1,0	2,0	3,0	4,0	5,0
		Feed f (mm/rev.)				
	PMC 10	0,07–0,19	0,02–0,13			
	PMC 12	0,07–0,19	0,02–0,13			
	PMC 16	0,10–0,25	0,07–0,21	0,02–0,13		
	PMC 20	0,12–0,27	0,07–0,24	0,05–0,19		
	PMC 25	0,15–0,30	0,10–0,27	0,07–0,23	0,02–0,15	
	PMC 32	0,15–0,30	0,15–0,30	0,10–0,27	0,07–0,23	0,02–0,15

Face turning		1,5xD / 2,25xD					
	Size	Depth of cut a_p (mm)					
		1,0	1,5	2,0	2,5	3,0	3,5
		Feed f (mm/rev.)					
	PMC 10	0,02–0,15	0,02–0,15				
	PMC 12	0,02–0,15	0,02–0,15				
	PMC 16	0,05–0,20	0,05–0,20	0,05–0,20			
	PMC 20	0,08–0,22	0,08–0,22	0,08–0,22	0,08–0,22		
	PMC 25	0,10–0,25	0,10–0,25	0,10–0,25	0,10–0,25	0,10–0,25	
	PMC 32	0,10–0,25	0,10–0,25	0,10–0,25	0,10–0,25	0,10–0,25	0,10–0,25

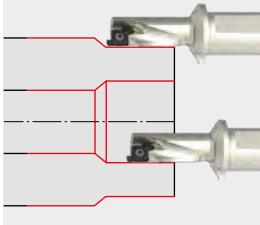
Radial grooving		1,5xD / 2,25xD	
	Size	Feed f (mm/rev)	
	PMC 10	0,01–0,08	
	PMC 12	0,02–0,10	
	PMC 16	0,04–0,15	
	PMC 20	0,04–0,16	
	PMC 25	0,07–0,20	
	PMC 32	0,08–0,22	

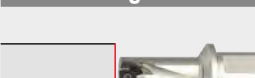
Drilling		1,5xD		2,25xD	
	Size	Feed f (mm/rev)	Max. hole depth (mm)	Feed f (mm/rev)	Max. hole depth (mm)
	PMC 10	0,01–0,05	15,0	0,01–0,05	22,5
	PMC 12	0,01–0,06	18,0	0,01–0,06	27,0
	PMC 16	0,02–0,09	24,0	0,02–0,09	36,0
	PMC 20	0,03–0,10	30,0	0,03–0,10	45,0
	PMC 25	0,04–0,12	37,5	0,04–0,12	56,3
	PMC 32	0,04–0,14	48,0	0,04–0,14	72,0

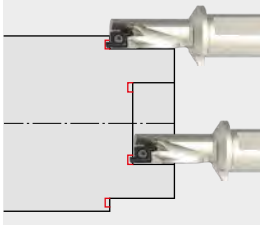
EcoCut – ProfileMaster 0° – Cutting depths and feed rates



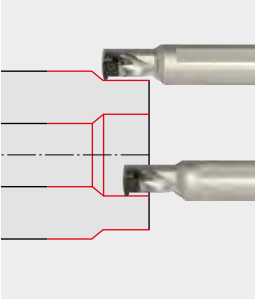
EcoCut ProfileMaster sizes 10 and 12 cannot be used as a 0° version.

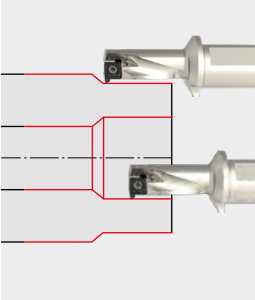
Longitudinal turning		1,5xD / 2,25xD					
	Size	Depth of cut a_p (mm)					
		1,0	1,5	2,0	2,5	3,0	3,5
		Feed f (mm/rev.)					
	PMC 16	0,04–0,20	0,04–0,20	0,04–0,20			
	PMC 20	0,06–0,22	0,06–0,22	0,06–0,22	0,06–0,22		
	PMC 25	0,08–0,25	0,08–0,25	0,08–0,25	0,08–0,25	0,08–0,25	
	PMC 32	0,10–0,28	0,10–0,28	0,10–0,28	0,10–0,28	0,10–0,28	0,10–0,28

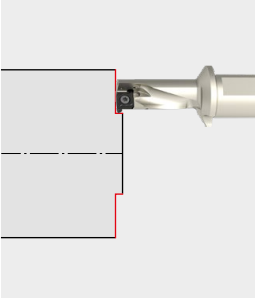
Face turning		1,5xD / 2,25xD						
	Size	Depth of cut a_p (mm)						
		1,0	1,5	2,0	2,5	3,0	3,5	4,0
		Feed f (mm/rev.)						
	PMC 16	0,05–0,20	0,05–0,20	0,05–0,20				
	PMC 20	0,05–0,20	0,05–0,20	0,05–0,20	0,05–0,20			
	PMC 25	0,10–0,25	0,10–0,25	0,10–0,25	0,10–0,25	0,10–0,25		
PMC 32	0,10–0,25	0,10–0,25	0,10–0,25	0,10–0,25	0,10–0,25	0,10–0,25	0,10–0,25	

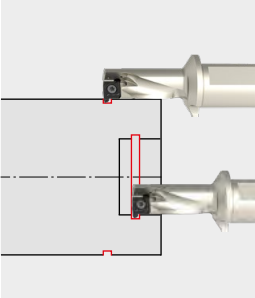
Axial grooving		1,5xD / 2,25xD					
	Size	Feed f (mm/rev)					
	PMC 16	0,02–0,12					
	PMC 20	0,04–0,14					
	PMC 25	0,06–0,18					
	PMC 32	0,08–0,20					

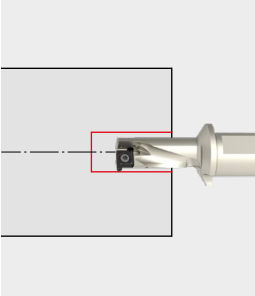
EcoCut – ProfileMaster 90° – Cutting depths and feed rates

Longitudinal turning		1.5xD							
	Size	Depth of Cut a_p (inch)							
		0.039	0.079	0.118	0.157	0.197	0.236	0.276	0.315
		Feed rate f (inch/rev.)							
	PMC 10	.0028–.0080	.0020–.0068	.0008–.0048					
	PMC 12	.0028–.0080	.0020–.0068	.0008–.0048					
	PMC 16	.0040–.0100	.0028–.0092	.0020–.0084	.0008–.0068				
	PMC 20	.0048–.0108	.0040–.0104	.0027–.0096	.0020–.0080	.0008–.0056			
	PMC 25	.0060–.0118	.0060–.0118	.0052–.0110	.0040–.0104	.0020–.0088	.0008–.0072		
	PMC 32	.0060–.0118	.0060–.0118	.0060–.0118	.0060–.0118	.0040–.0108	.0028–.0096	.0020–.0084	.0008–.0060

Longitudinal turning		2.25xD							
	Size	Depth of Cut a_p (inch)							
		0.039	0.079	0.118	0.157	0.197			
		Feed rate f (inch/rev.)							
	PMC 10	.0028–.0076	.0008–.0052						
	PMC 12	.0028–.0076	.0008–.0052						
	PMC 16	.0040–.0100	.0028–.0084	.0008–.0052					
	PMC 20	.0048–.0108	.0028–.0096	.0020–.0076					
	PMC 25	.0060–.0118	.0040–.0108	.0028–.0092	.0008–.0060				
	PMC 32	.0060–.0118	.0060–.0118	.0040–.0108	.0028–.0092	.0008–.0060			

Face turning		1.5xD / 2.25xD							
	Size	Depth of Cut a_p (inch)							
		0.039	0.059	0.079	0.098	0.118	0.138		
		Feed rate f (inch/rev.)							
	PMC 10	.0008–.0060	.0008–.0060						
	PMC 12	.0008–.0060	.0008–.0060						
	PMC 16	.0020–.0080	.0020–.0080	.0020–.0080					
	PMC 20	.0032–.0088	.0032–.0088	.0032–.0088	.0032–.0088				
	PMC 25	.0040–.0100	.0040–.0100	.0040–.0100	.0040–.0100	.0040–.0100			
	PMC 32	.0040–.0100	.0040–.0100	.0040–.0100	.0040–.0100	.0040–.0100	.0040–.0100		

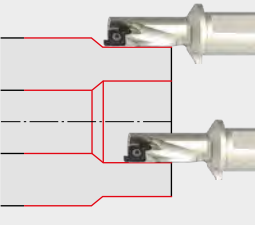
Radial grooving		1.5xD / 2.25xD							
	Size	Feed f (inch/rev)							
	PMC 10	.0004–.0032							
	PMC 12	.0008–.0040							
	PMC 16	.0016–.0060							
	PMC 20	.0016–.0064							
	PMC 25	.0028–.0080							
	PMC 32	.0032–.0088							

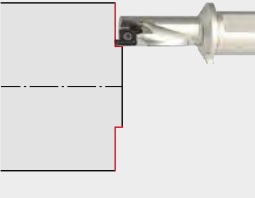
Drilling		1.5xD		2.25xD	
	Size	Feed f (inch/rev)	Max. hole depth (inch)	Feed f (inch/rev)	Max. hole depth (inch)
	PMC 10	.0004–.0020	0.59	.0004–.0020	0.89
	PMC 12	.0004–.0024	0.71	.0004–.0024	1.06
	PMC 16	.0008–.0036	0.94	.0008–.0036	1.42
	PMC 20	.0012–.0040	1.18	.0012–.0040	1.77
	PMC 25	.0016–.0048	1.48	.0016–.0048	2.22
	PMC 32	.0016–.0056	1.89	.0016–.0056	2.83

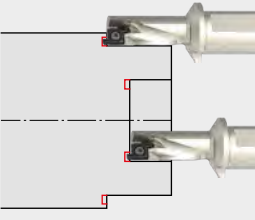
EcoCut – ProfileMaster 0° – Cutting depths and feed rates



EcoCut ProfileMaster sizes 10 and 12 cannot be used as a 0° version.

Longitudinal turning		1.5xD / 2.25xD					
	Size	Depth of Cut a_p (inch)					
		0.039	0.059	0.079	0.098	0.118	0.138
		Feed rate f (inch/rev.)					
	PMC 16	.0016–.0080	.0016–.0080	.0016–.0080			
	PMC 20	.0024–.0088	.0024–.0088	.0024–.0088	.0024–.0088		
	PMC 25	.0032–.0100	.0032–.0100	.0032–.0100	.0032–.0100	.0032–.0100	
	PMC 32	.0040–.0112	.0040–.0112	.0040–.0112	.0040–.0112	.0040–.0112	.0040–.0112

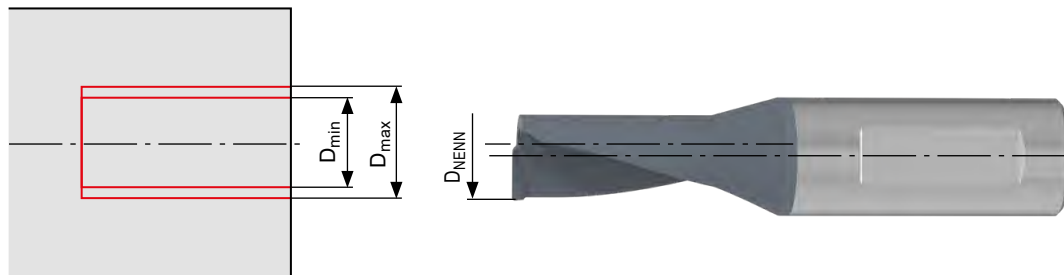
Face turning		1.5xD / 2.25xD					
	Size	Depth of Cut a_p (inch)					
		0.039	0.059	0.079	0.098	0.118	0.138
		Feed rate f (inch/rev.)					
	PMC 16	.0020–.0080	.0020–.0080	.0020–.0080			
	PMC 20	.0020–.0080	.0020–.0080	.0020–.0080	.0020–.0080		
	PMC 25	.0040–.0100	.0040–.0100	.0040–.0100	.0040–.0100	.0040–.0100	
	PMC 32	.0040–.0100	.0040–.0100	.0040–.0100	.0040–.0100	.0040–.0100	.0040–.0100

Axial grooving		1.5xD / 2.25xD					
	Size	Feed f (inch/rev)					
	PMC 16	.0008–.0048					
	PMC 20	.0016–.0056					
	PMC 25	.0024–.0072					
	PMC 32	.0032–.0080					

EcoCut – Mini – Application tips

Drilling off-center

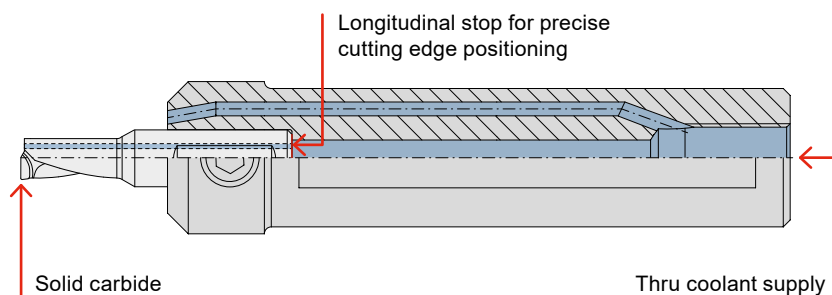
Thanks to the special design, EcoCut tools can perform off-center drilling. Therefore corresponding deviations from the nominal tool diameter can be achieved.



Size	Tool nominal Ø	Workpiece hole Ø	
	D_{NENN} (mm)	D_{min} (mm)	D_{max} (mm)
ECM 02	2	1,95	2,1
ECM 02,5	2,5	2,45	2,6
ECM 03	3	2,95	3,15
ECM 03,5	3,5	3,45	3,65
ECM 04	4	3,90	4,20
ECM 05	5	4,90	5,20
ECM 06	6	5,90	6,20
ECM 07	7	6,90	7,20
ECM 08	8	7,90	8,20

Mini – Adapter

Cross-section rotated by 90° for clarity

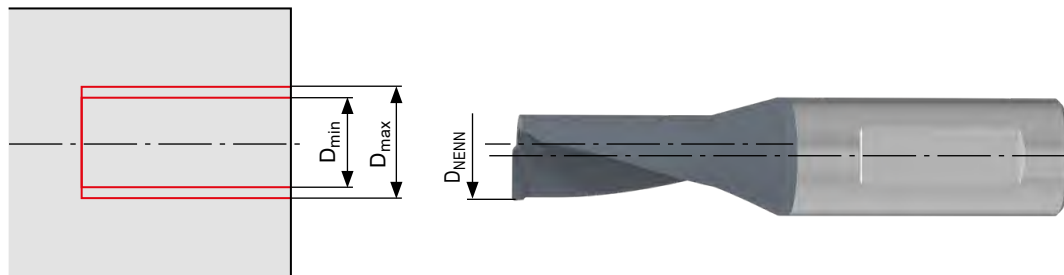


In order to guarantee efficient chip transport out of a hole, the coolant pressure must be at least 3 – 6 bar (ideally 7 – 10 bar).

EcoCut – Mini – Application tips

Drilling off-center

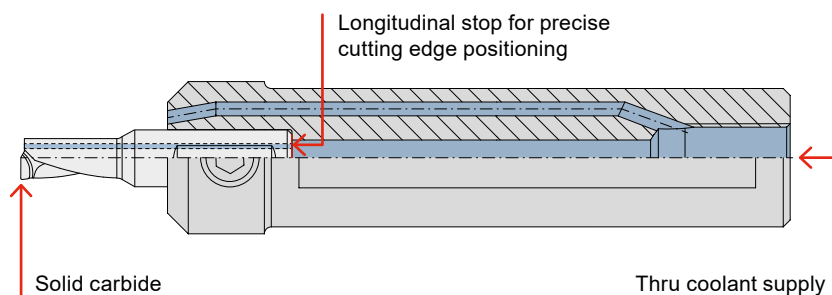
Thanks to the special design, EcoCut tools can perform off-center drilling. Therefore corresponding deviations from the nominal tool diameter can be achieved.



Size	Tool nominal Ø	Workpiece hole Ø	
	D_{NENN} (inch)	D_{min} (inch)	D_{max} (inch)
ECM 02	0.079	0.077	0.083
ECM 02,5	0.098	0.096	0.102
ECM 03	0.118	0.116	0.124
ECM 03,5	0.138	0.136	0.144
ECM 04	0.157	0.154	0.165
ECM 05	0.197	0.193	0.205
ECM 06	0.236	0.232	0.244
ECM 07	0.276	0.272	0.283
ECM 08	0.315	0.311	0.323

Mini – Adapter

Cross-section rotated by 90° for clarity

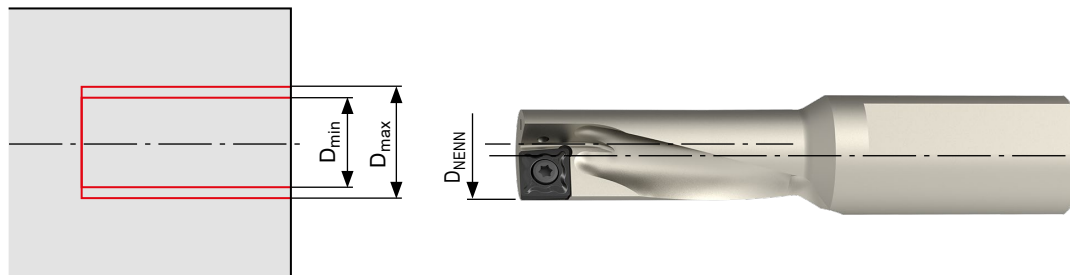


In order to guarantee efficient chip transport out of a hole, the coolant pressure must be at least 3 – 6 bar (ideally 7 – 10 bar).

EcoCut – Classic – Application tips

Drilling off-center

The special design of the tool and indexable insert enables EcoCut tools to perform off-center drilling. Therefore corresponding deviations from the nominal tool diameter can be achieved.



Size	Tool nominal Ø	Workpiece hole Ø	
	D _{NENN} (mm)	D _{min} (mm)	D _{max} (mm)
ECC 08	8	7,85	8,30
ECC 10	10	9,85	10,50
ECC 12	12	11,85	12,50
ECC 14	14	13,85	14,50
ECC 16	16	15,85	16,50
ECC 18	18	17,85	18,50
ECC 20	20	19,80	20,50
ECC 25	25	24,80	25,80
ECC 32	32	31,80	33,00

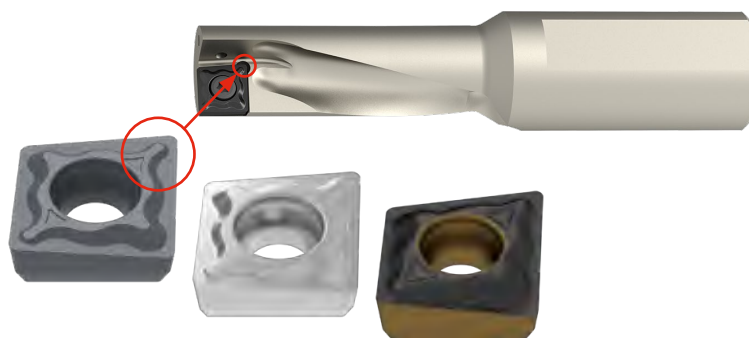
Mounting of the indexable insert

For tools up to Ø 8 mm / 0.315" right and left handed inserts are required.

From Ø 10–32 mm / 0.394"–1.260" neutral inserts are used.

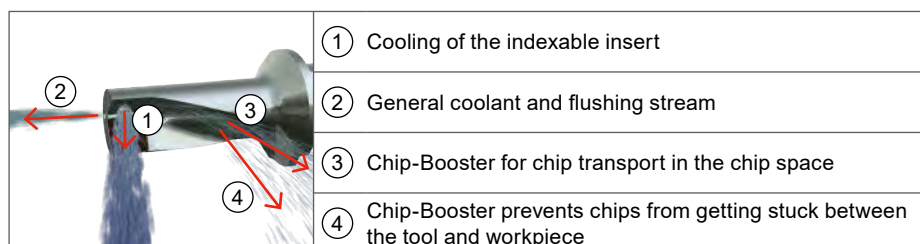
Caution!

Ensure correct orientation upon installation.



Innovative chip removal – Chip-Booster

EcoCut tools are equipped with a unique coolant and chip removal system.

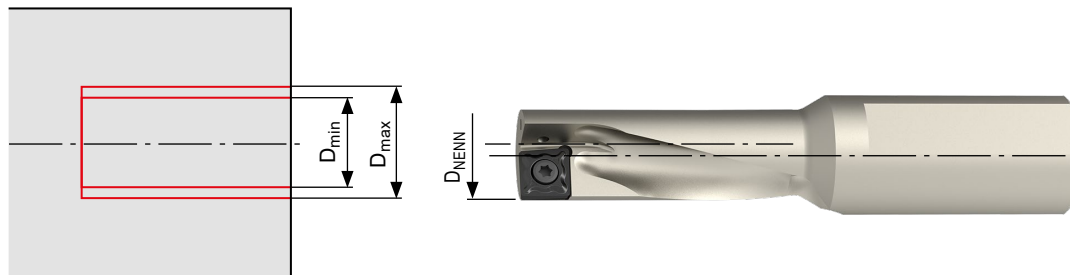


In order to guarantee efficient chip transport out of a hole, the coolant pressure must be at least 3 – 6 bar (ideally 7 – 10 bar).

EcoCut – Classic – Application tips

Drilling off-center

The special design of the tool and indexable insert enables EcoCut tools to perform off-center drilling. Therefore corresponding deviations from the nominal tool diameter can be achieved.



Size	Tool nominal Ø	Workpiece hole Ø	
	D _{NENN} (inch)	D _{min} (inch)	D _{max} (inch)
ECC 08	0.315	0.309	0.327
ECC 10	0.394	0.388	0.413
ECC 12	0.472	0.467	0.492
ECC 14	0.551	0.545	0.571
ECC 16	0.630	0.624	0.650
ECC 18	0.709	0.703	0.728
ECC 20	0.787	0.780	0.807
ECC 25	0.984	0.976	1.016
ECC 32	1.260	1.252	1.299

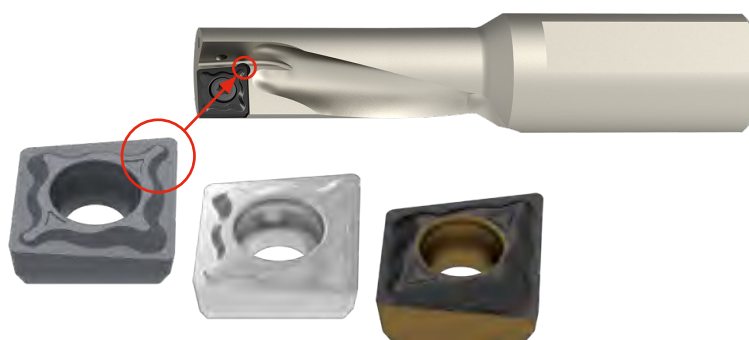
Mounting of the indexable insert

For tools up to Ø 8 mm / 0.315" right and left handed inserts are required.

From Ø 10–32 mm / 0.394"–1.260" neutral inserts are used.

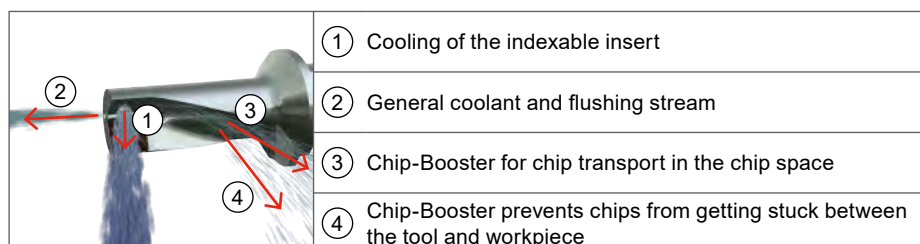
Caution!

Ensure correct orientation upon installation.



Innovative chip removal – Chip-Booster

EcoCut tools are equipped with a unique coolant and chip removal system.



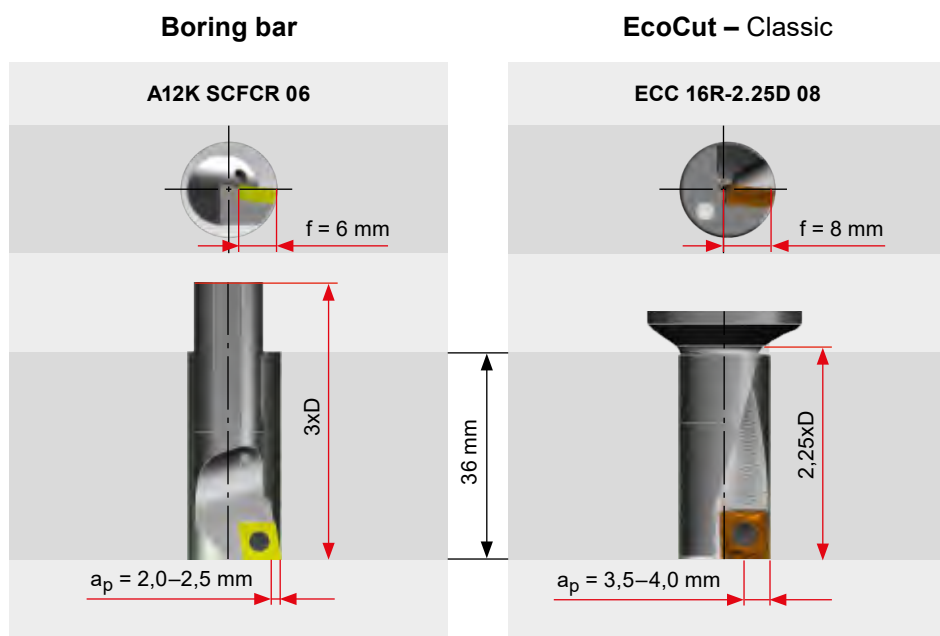
In order to guarantee efficient chip transport out of a hole, the coolant pressure must be at least 3 – 6 bar (ideally 7 – 10 bar).

EcoCut– Classic – Application as the most stable boring tool

EcoCut is not just suitable as a multi-function tool. EcoCut also provides enormous advantages to the user as a pure boring tool compared to a boring bar.

Example: machining bores, 0.629" (16 mm) diameter by 1.420" (36 mm) depth

Differences in the tool



Your benefits

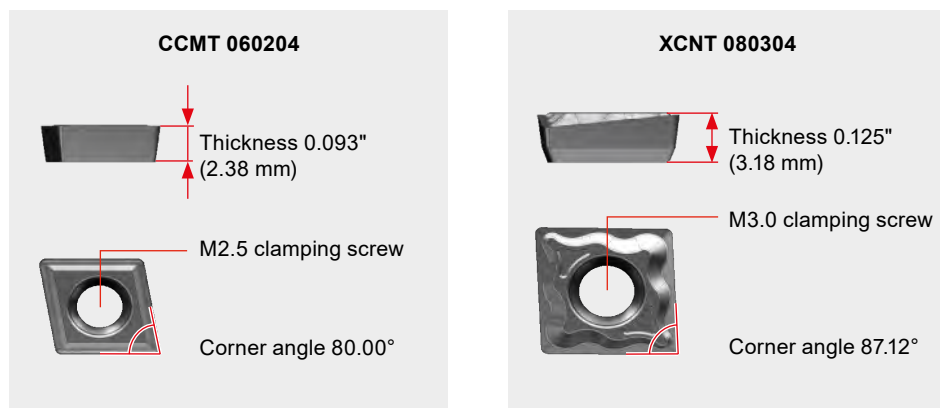
Stable solid base body

- ▲ Able to handle higher cutting forces
- ▲ Less vibration
- ▲ Chip-Booster for perfect cooling and chip clearance

Benefits

- ▲ High surface quality
- ▲ Perfect chip breakage
- ▲ Unbeatable process security

Differences in the indexable inserts



Large and stable indexable insert

- ▲ Increased process security
- ▲ Enables large cutting depths
- ▲ Higher cutting data
- ▲ Longer tool life

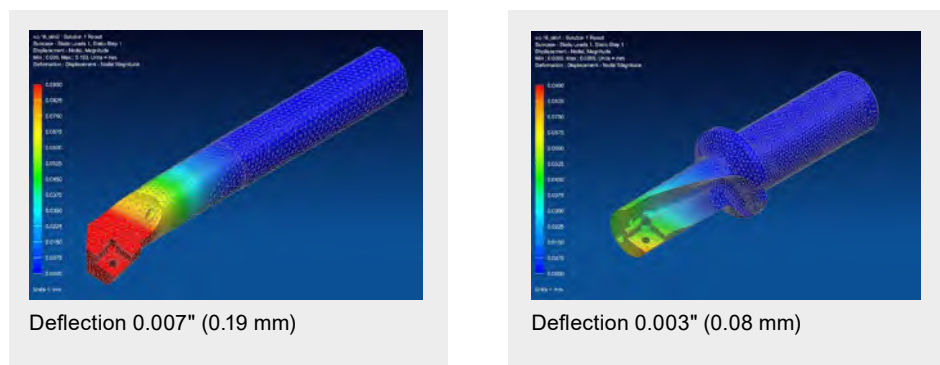
Benefits

- ▲ Reduces the machining time
- ▲ Increased productivity
- ▲ Reduction in tool costs

Stability comparison

Calculation via FEM

At a load of 1000 N on the insert seat corresponds to approx. $a_p = 2.0$ mm and $f = 0.2$ mm



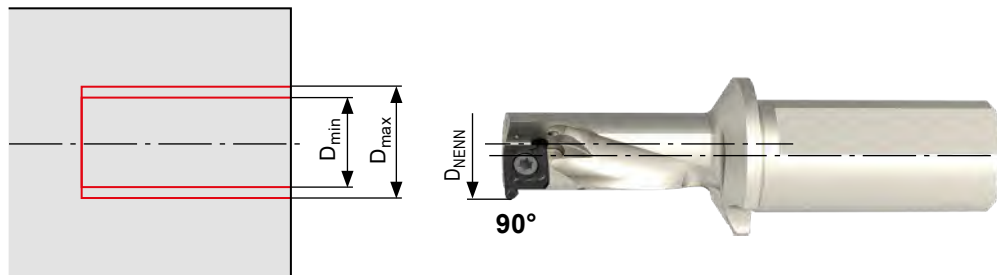
Experience shows that:

- ▲ Machining time reduced by up to **75%**
- ▲ Tool life increase of up to **400%** possible

EcoCut – ProfileMaster – Application tips

ProfileMaster 90° – Drilling off-center

The special design of the tool and indexable insert enables EcoCut tools to perform off-center drilling. Therefore corresponding deviations from the nominal tool diameter can be achieved.

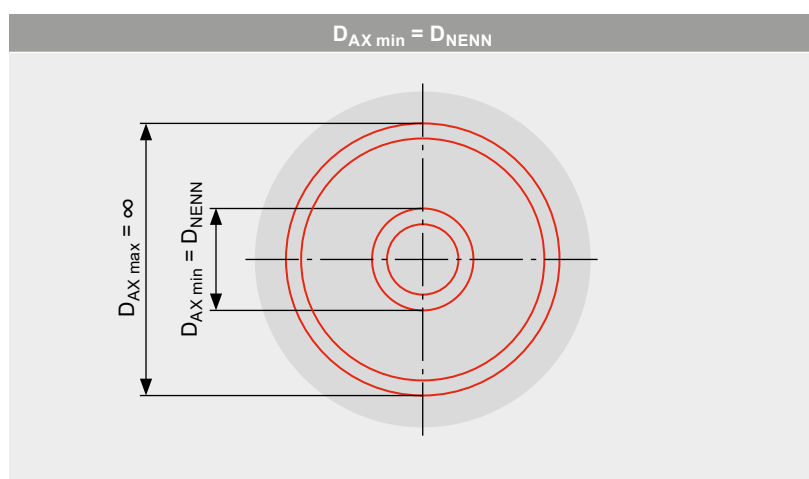


Size	Tool nominal Ø	Workpiece hole Ø	
	D_{NENN} (mm)	D_{min} (mm)	D_{max} (mm)
PMC 10	10	9,85	12
PMC 12	12	11,85	15
PMC 16	16	15,85	19
PMC 20	20	19,80	24
PMC 25	25	24,80	29
PMC 32	32	31,80	38

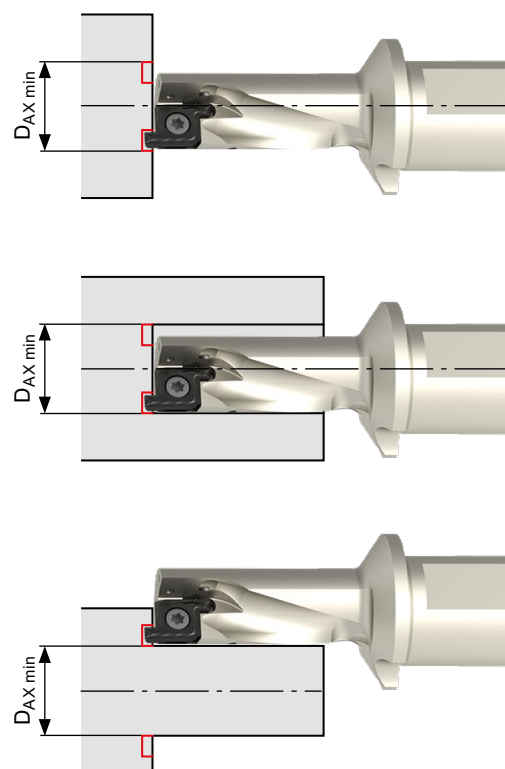


ProfileMaster 0° – Not suitable for drilling!

ProfileMaster 0° – Axial grooving



Size	Tool nominal Ø	Smallest diameter to the axial grooving	Largest diameter to the axial grooving
	D_{NENN} (mm)	$D_{AX min}$ (mm)	$D_{AX max}$ (mm)
PMC 16	16	16	> 16
PMC 20	20	20	> 20
PMC 25	25	25	> 25
PMC 32	32	32	> 32

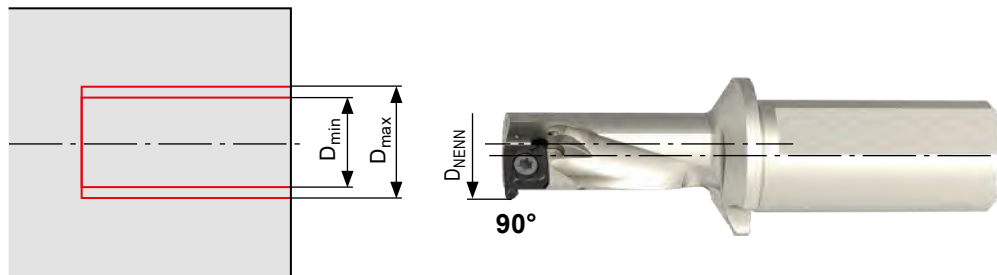


In order to guarantee efficient chip transport out of a hole, the coolant pressure must be at least 3 – 6 bar (ideally 7 – 10 bar).

EcoCut – ProfileMaster – Application tips

ProfileMaster 90° – Drilling off-center

The special design of the tool and indexable insert enables EcoCut tools to perform off-center drilling. Therefore corresponding deviations from the nominal tool diameter can be achieved.

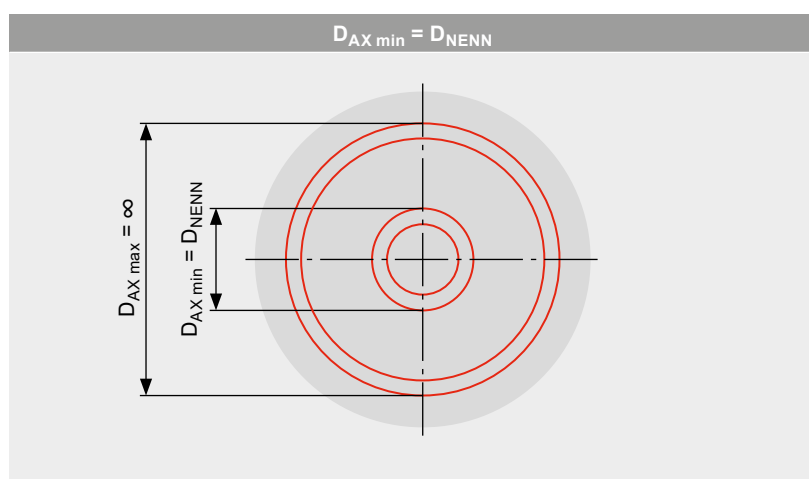


Size	Tool nominal Ø	Workpiece hole Ø	
	D_{NENN} (inch)	D_{min} (inch)	D_{max} (inch)
PMC 10	0.394	0.388	0.472
PMC 12	0.472	0.467	0.591
PMC 16	0.630	0.624	0.748
PMC 20	0.787	0.780	0.945
PMC 25	0.984	0.976	1.142
PMC 32	1.260	1.252	1.496

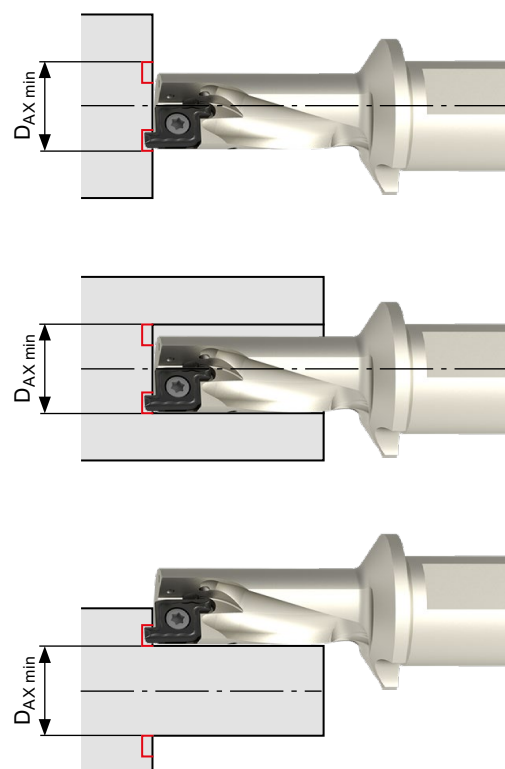


ProfileMaster 0° – Not suitable for drilling!

ProfileMaster 0° – Axial grooving



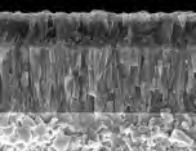
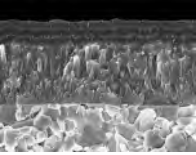
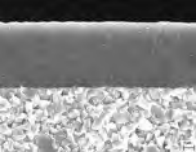
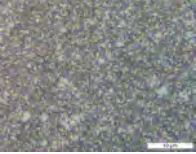
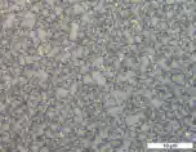
Size	Tool nominal Ø	Smallest diameter to the axial grooving	Largest diameter to the axial grooving
	D_{NENN} (inch)	$D_{AX min}$ (inch)	$D_{AX max}$ (inch)
PMC 16	0.630	0.630	> 0.630
PMC 20	0.787	0.787	> 0.787
PMC 25	0.984	0.984	> 0.984
PMC 32	1.260	1.260	> 1.260



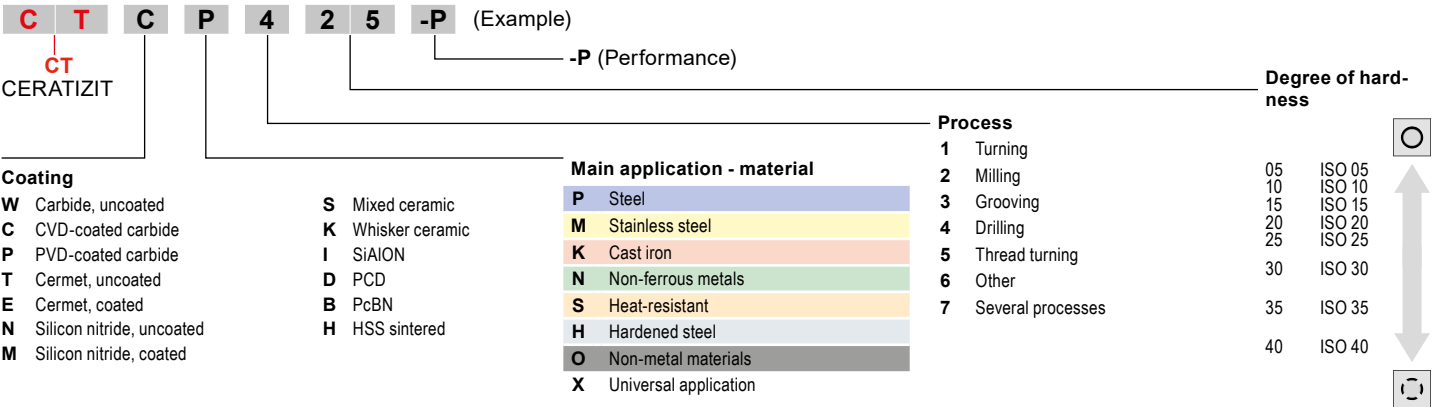
In order to guarantee efficient chip transport out of a hole, the coolant pressure must be at least 3 – 6 bar (ideally 7 – 10 bar).

Grade description

EcoCut – Classic / EcoCut – Solid

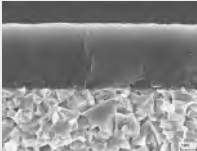
Grades		ISO application range		Grade description	
Main application ● Secondary application ○		○ V _C + V _C – □ Wear-resistant Tough		Specification / Application recommendation	
		01 05 10 15 20 25 30 35 40 45 50			
CTCP425-P <small>DRAGONSKIN</small> 	P ●			Specification: Composition: Co 7.0%, mixed carbides 8.1%, WC balance Grain size: 1-2 μm Hardness: HV ₃₀ 1470 Layer system: CVD TiCN-Al ₂ O ₃ Multilayer Application recommendation: The wear-resistant choice for steel and cast materials for stable behavior and high cutting speeds.	
	M ○				
	K ●				
	N ●				
	S ●				
	H ●				
	O ●				
CTCP435-P <small>DRAGONSKIN</small> 	P ●			Specification: Composition: Co 9.6%, mixed carbides 7.8%, other 0.4%, WC balance Grain size: 1-2 μm Hardness: HV ₃₀ 1400 Layer system: CVD TiCN-Al ₂ O ₃ Multilayer Application recommendation: The reliable choice for steel and cast materials in unstable conditions.	
	M ○				
	K ○				
	N ●				
	S ●				
	H ●				
	O ●				
CTPP430 <small>DRAGONSKIN</small> 	P ●			Specification: Composition: Co 9.0%; Others 0.75%; WC balance Grain size: 0.85 μm Hardness: HV ₃₀ 1590 Layer system: PVD TiAlTaN Application recommendation: The all-purpose, high-performance grade for steel materials, austenitic steel, and heat-resistant alloys.	
	M ●				
	K ○				
	N ○				
	S ○				
	H ●				
	O ○				
H210T 	P ●			Specification: Composition: Co 6.0%; WC balance Grain size: 0.8 μm Hardness: HV ₃₀ 1850 Application recommendation: The wear-resistant, uncoated carbide grade for machining aluminum and other non-ferrous metals.	
	M ●				
	K ○				
	N ●				
	S ●				
	H ●				
	O ○				
H216T 	P ●			Specification: Composition: Co 6.0%; WC balance Grain size: 1 μm Hardness: HV ₃₀ 1630 Recommended application: The uncoated carbide grade for the machining of aluminium and other non-ferrous metals	
	M ●				
	K ○				
	N ●				
	S ●				
	H ●				
	O ○				

Designation key

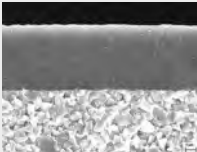


Grade description

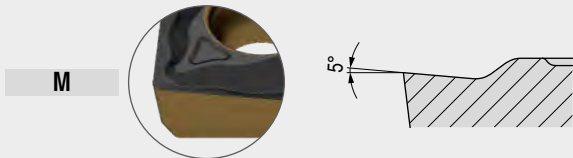
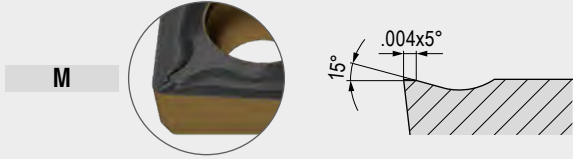
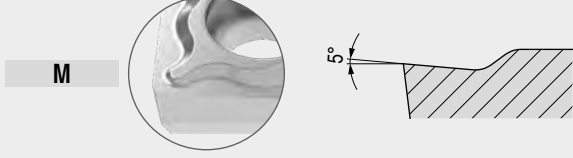
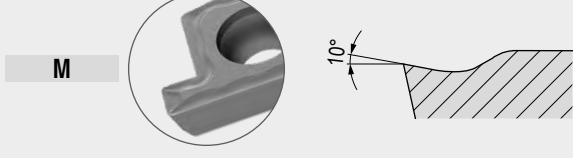
EcoCut – Mini

Grades		ISO application range		Grade description	
Main application ● Secondary application ○		<div><div>○ V_C +</div><div>Wear-resistant</div><div>V_C - <div>●</div></div><div>Tough</div></div>		Specification / Application recommendation	
CTPP435 DRAGONSKIN 	P ●				Specification: Composition: Co 10.3%; Others 1.2%; WC balance Grain size: 0.7 μm Hardness: HV ₃₀ 1600 Layer system: PVD TiAlTaN Application recommendation: The all-purpose, high-performance grade for steel materials, austenitic steel, and heat-resistant alloys.
	M ●				
	K ○				
	N ○				
	S ●				
	H ○				
	O ○				
CTWN425 	P ●				Specification: Composition: Co 10.3%; Others 1.2%; WC balance Grain size: 0.7 (submicron grade) μm Hardness: HV ₃₀ 1600 Application recommendation: The uncoated carbide grade for machining aluminum and other non-ferrous metals.
	M ●				
	K ○				
	N ●				
	S ○				
	H ○				
	O ○				
		01	05 10 15 20 25 30 35 40 45 50		

EcoCut – ProfileMaster

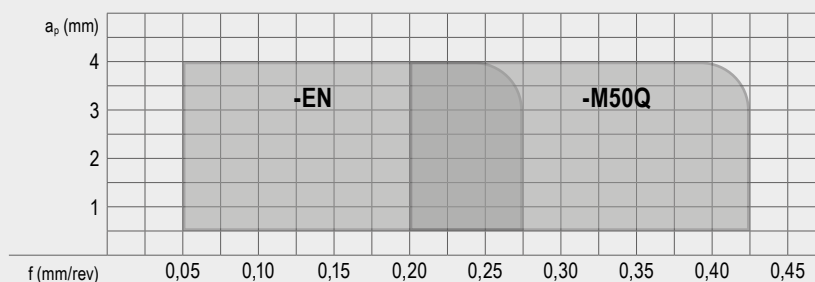
Grades		ISO application range		Grade description								
Main application ● Secondary application ○		<div><div>☐ V_C+</div><div>Wear-resistant</div></div> <div><div>V_C-☐</div><div>Tough</div></div>		Specification / Application recommendation								
CTPP430 <div>DRAGONSKIN</div> <div></div>	P ●				Specification: Composition: Co 9.0%; Others 0.75%; WC balance Grain size: 0.85 μm Hardness: HV ₃₀ 1590 Layer system: PVD TiAlTaN Application recommendation: The all-purpose, high-performance grade for steel materials, austenitic steel, and heat-resistant alloys.							
	M ●											
	K ○											
	N ○											
	S ●											
	H ○											
	O ○											
		01	05	10	15	20	25	30	35	40	45	50

Chip breakers / Applications

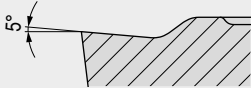
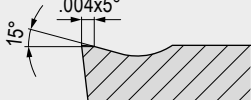
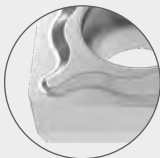
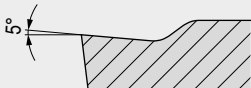
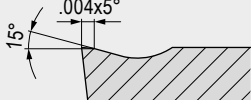
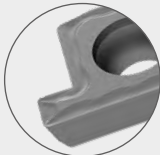
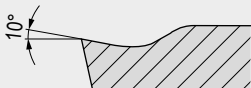
EcoCut – Classic EcoCut – Solid		Geometry Chip breaker	Feed f	Machining situation				
					○	○	○	
-EN ▲ Universal geometry ▲ Excellent chip breakage ▲ Positive cutting edge ▲ Low to medium feeds		<div>M</div> 	0,05 mm – 0,275 mm	P	●	●	●	
M				●	●	●		
K				○	○	○		
N				○	○	○		
S				○	○	○		
H								
O				○	○	○		
-M50Q ▲ With wiper geometry ▲ Excellent surface qualities ▲ Good chip formation ▲ Medium to high feeds		<div>M</div> 	0,2 mm – 0,425 mm	P	●	●		
M				○				
K				○	○			
N								
S								
H								
O								
-27P ▲ Positive cutting edge ▲ Periphery ground ▲ Polished clamping flat ▲ First choice for non-ferrous metals		<div>M</div> 	0,1 mm – 0,4 mm	P				
M								
K				●	●	●		
N				●	●	●		
S				○	○			
H								
O				○	○			
-27Q ▲ With wiper geometry ▲ Extremely positive geometry ▲ Periphery ground ▲ Low adhesion		<div>M</div> 	0,2 mm – 0,5 mm	P				
M								
K				○	○			
N				●	●			
S				●	●			
H								
O				○	○			
EcoCut – ProfileMaster		Geometry Chip breaker	Feed f	Machining situation				
					○	○	○	
-M20 ▲ Positive geometry ▲ Universal application ▲ Low to medium feeds		<div>M</div> 	0,05 mm – 0,25 mm	P	●	●	●	
M				●	●	●		
K				○	○	○		
N				○	○	○		
S				●	●			
H								
O				○	○	○		

EcoCut Classic 2,25xD – ECC16 – XCNT-080304

Application area of -EN and -M50Q chip breakers

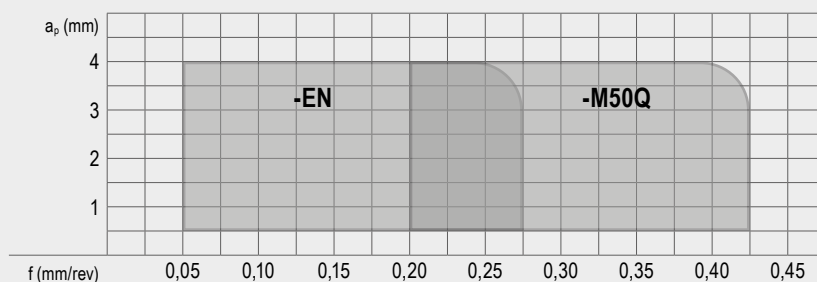


Chip breakers / Applications

EcoCut – Classic EcoCut – Solid	Geometry Chip breaker	Feed f	Machining situation			
-EN <ul style="list-style-type: none">▲ Universal geometry▲ Excellent chip breakage▲ Positive cutting edge▲ Low to medium feeds	 	0.002" – 0.011"	P			
			M			
			K			
			N			
			S			
			H			
			O			
-M50Q <ul style="list-style-type: none">▲ With wiper geometry▲ Excellent surface qualities▲ Good chip formation▲ Medium to high feeds	 	0.008" – 0.017"	P			
			M			
			K			
			N			
			S			
			H			
			O			
-27P <ul style="list-style-type: none">▲ Positive cutting edge▲ Periphery ground▲ Polished clamping flat▲ First choice for non-ferrous metals	 	0.004" – 0.016"	P			
			M			
			K			
			N			
			S			
			H			
			O			
-27Q <ul style="list-style-type: none">▲ With wiper geometry▲ Extremely positive geometry▲ Periphery ground▲ Low adhesion	 	0.008" – 0.020"	P			
			M			
			K			
			N			
			S			
			H			
			O			
EcoCut – ProfileMaster	Geometry Chip breaker	Feed f	Machining situation			
-M20 <ul style="list-style-type: none">▲ Positive geometry▲ Universal application▲ Low to medium feeds	 	0.002" – 0.010"	P			
			M			
			K			
			N			
			S			
			H			
			O			

EcoCut Classic 2.25xD – ECC16 – XCNT-080304

Application area of -EN and -M50Q chip breakers



Recommendation for optimum results

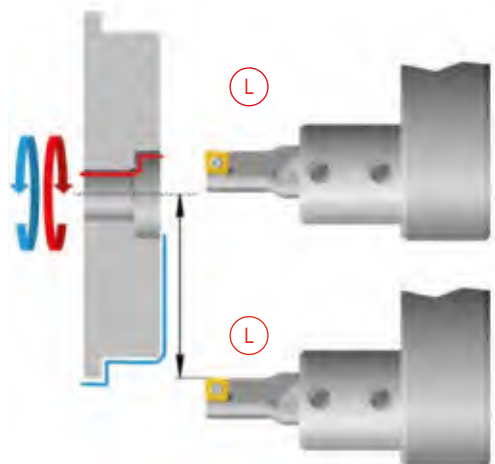
Task description								Solution, measures	
Type of wear				Workpiece problems		Chip control		Explanation of symbols	
Fracture	Built-up edge	Flank wear	Plastic deformation	Vibrations	Surface quality	Chip too long (snarl chip)	Chip too short (fragmented chip)	Raise, increase Large influence	↑
								Raise, increase Small influence	↑
								Avoid, reduce Large influence	↓
								Avoid, reduce Small influence	↓
								check, optimize	~
								Use	●
	↑	↓	↓	↓	↑	↓		Cutting speed	Cutting data
↓		~	↓	↑	↓	↑	↓	Feed	
↑		↑	↑	↓	↑			Corner radius	Indexable insert selection
↓		↑	↑					Cutting material	
								larger smaller	↕
								Wear resistance Toughness	↕
~				~	~			Tool clamping	General criteria
~				~	~			Workpiece clamping	
~				~	↓			Overhang	
~		~		~	~			Tip height	
	●	●	●		●	●		Cooling lubricant	

Troubleshooting

Machining over center

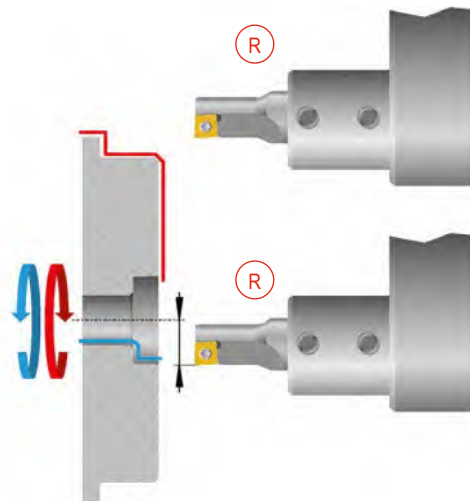
Problems

If the machine is unable to move freely over the central axis, the outer diameter cannot be machined with the same tool.



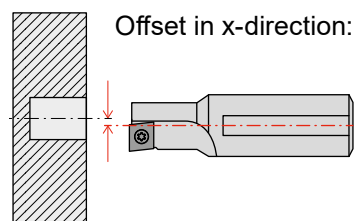
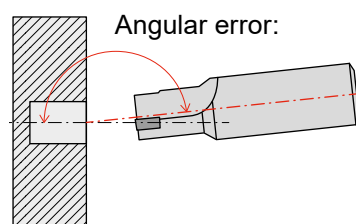
Solution

Use a right hand EcoCut tool.

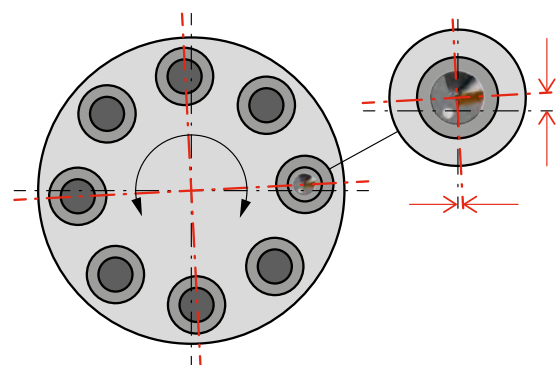


With axial offset there is the danger of collision!

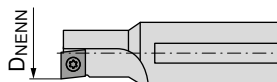
Problems



Turret position error:

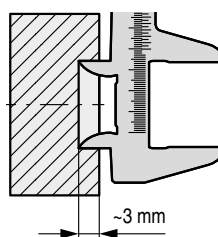


Solution



When pre-setting the tool:

- ▲ Definition as an internal turning tool for programming
- ▲ Enter the tool nominal $\varnothing$ as hole target $\varnothing$



At the machine:

- ▲ Make measuring cut, approx. 0.120" (3 mm) deep
- ▲ Determine bore diameter produced
- ▲ If necessary correct drilling $\varnothing$
- ▲ Start machining

Designation system

EcoCut – Classic / EcoCut – Solid – Indexable inserts

X	C	E	T	17	05	08	F	N	-27P
Insert shape	Clearance angle	Tolerances	Feature	Cutting length	Insert thickness	Corner radius	Cutting edge	Direction of cut	Chip breaker

EcoCut – Classic / EcoCut – Solid – Holders

ECC	32	R	3,0D	17	H
ECC = EcoCut – Classic ECS = EcoCut – Solid	Nominal diameter in mm	Direction of cut	Maximum hole depth	Indexable insert size	Tool holder version H = Densimet C = Carbide

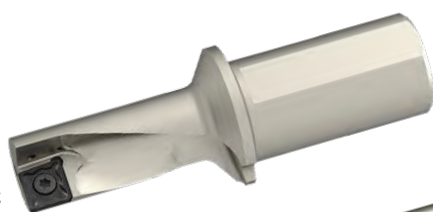
EcoCut – ProfileMaster – Indexable inserts

PM	25	R	G	35	30	04	-M20
ProfileMaster	Nominal diameter in mm	Direction of cut	Version	Groove width in mm/10	Groove depth in mm/10	Corner radius	Chip breaker

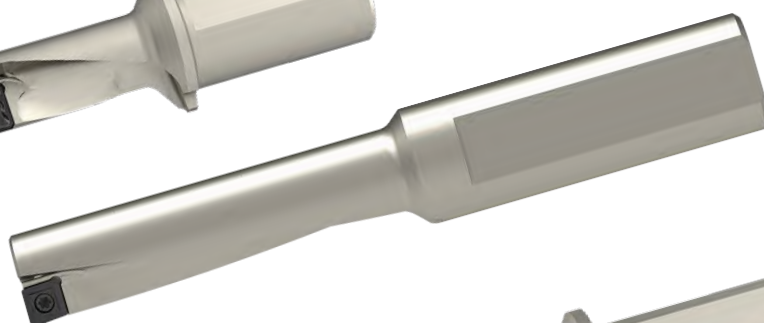
EcoCut – ProfileMaster – Holders

PMC	25	R	2,25D
ProfileMaster	Nominal diameter in mm	Direction of cut	Maximum hole depth

EcoCut – Classic



EcoCut – Solid



EcoCut – ProfileMaster 90°



0°

Designation system

EcoCut – Classic / EcoCut – Solid – Indexable inserts

X	C	E	T	17	05	08	F	N	-27P
Insert shape	Clearance angle	Tolerances	Feature	Cutting length	Insert thickness	Corner radius	Cutting edge	Direction of cut	Chip breaker

EcoCut – Classic / EcoCut – Solid – Holders

ECC	32	R	3.0D	17	H	E
ECC = EcoCut – Classic ECS = EcoCut – Solid	Nominal diameter in mm	Direction of cut	Maximum hole depth	Indexable insert size	Tool holder version H = Densimet C = Carbide	Inch size shank

EcoCut – ProfileMaster – Indexable inserts

PM	25	R	G	35	30	04	-M20
ProfileMaster	Nominal diameter in mm	Direction of cut	Version	Groove width in mm/10	Groove depth in mm/10	Corner radius	Chip breaker

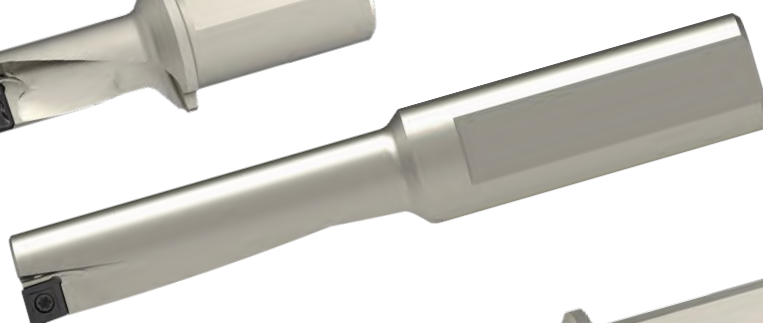
EcoCut – ProfileMaster – Holders

PMC	25	R	2.25D	E
ProfileMaster	Nominal diameter in mm	Direction of cut	Maximum hole depth	Inch size shank

EcoCut – Classic



EcoCut – Solid



EcoCut – ProfileMaster 90°



0°



Parting and Grooving



Contents

- Explanation of symbols
- System overview
 - Toolfinder
- SX, LX
- GX09, GX16
- GX24
- GX35, FX, AX, TX, MaxiClick (MC)
- OvalFlex, MaxiGroove
- MaxiChange
- Cutting data
- Cutting depths and feed rates
- Technical information
 - Grooving depth reduction
 - Clamping functions
 - Tightening torque ModularClamp module screws
 - Advantages due to DirectCooling
 - Advantages of the trochoidal turning strategy
 - General information
 - Measures for problems and causes of wear
 - Chip breaker descriptions and overview
 - Example of coding grooving tools
 - Grade description and overview

Explanation of symbols

	Grooving
	Parting off
	Grooving and turning
	Copy turning
	Axial grooving and turning
	Circlip
	Internal machining

- = Main application
- = Secondary application

	DirectCooling
	Internal coolant supply
	Repeatability
	Fine machining
	Medium machining
	Rough Machining
	Chip breaker
	Carbide grade
	Smooth cut
	Irregular cut
	Interrupted cut

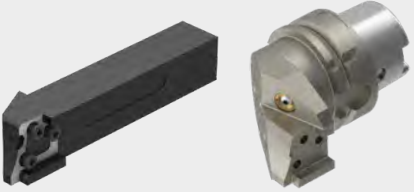
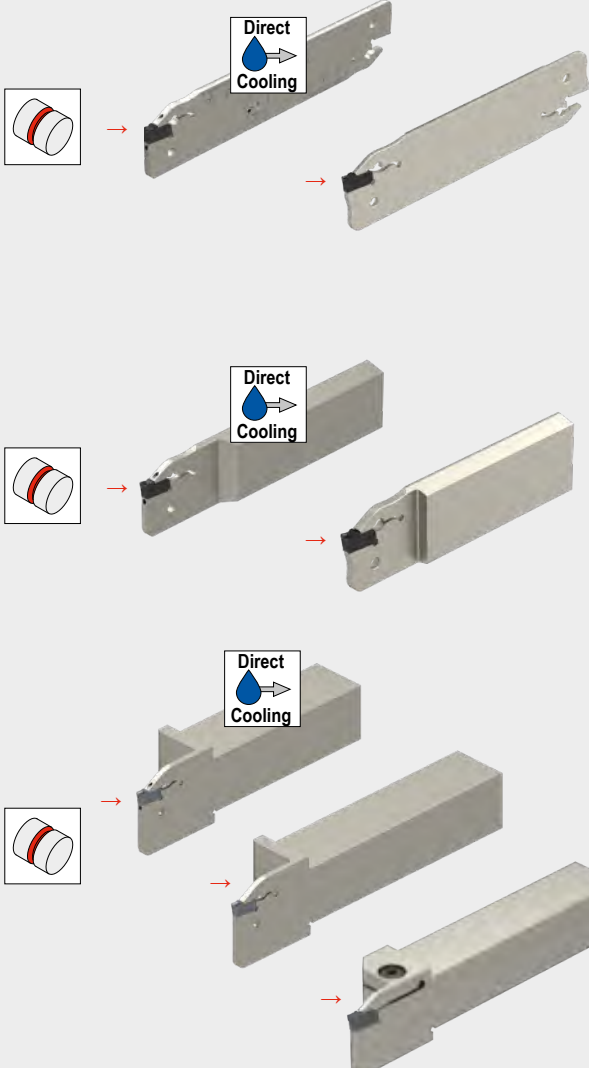
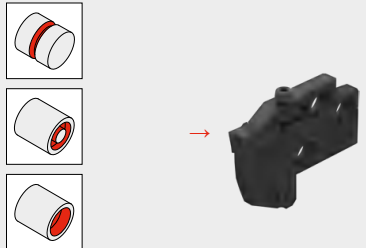
System overview

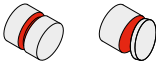
No. of cutting edges	System	Grooving	Parting off	Grooving and turning	Copy turning	Axial grooving and turning	Circlip	Internal machining	External machining		Internal machining		Axial machining	
									CW	CDX max.	DMIN	CDX max.	DAXIN	CDX max.
1	→ SX								2 - 6 mm .078" - .236"	60 mm 2.362"				
	→ LX								8 - 10 mm .314" - .393"	80 mm 3.149"	200 mm 7.874"	34 mm 1.339"	500 mm 19.685"	39 mm 1.535"
	→ FX								2,2 - 8,2 mm .087" - .323"	80 mm 3.149"				
2	→ GX09								2 - 3,5 mm .078" - .138"	7 mm .275"	16 mm .630"	6 mm .236"		
	→ GX16								2 - 6 mm .078" - .236"	12 mm .472"	20,5 mm .807"	11 mm .433"		
	→ GX24								2 - 8 mm .078" - .314"	21 mm .827"	42 mm 1.654"	19 mm .748"	45 mm 1.772"	25 mm .984"
	→ GX35								3 mm .118"	34 mm 1.339"				
	→ AX								3 mm .118"	15 mm .591"			10 mm .394"	15 mm .591"
3	→ TX								0,5-5,15 mm .020" - .203"	8 mm .314"	46 mm 1.811"	2 mm .078"	20 mm .787"	3 mm .118"
4-5	→ MC								1 - 2,5 mm .039" - .098"	10 mm .394"				

OvalFlex / MaxiGroove

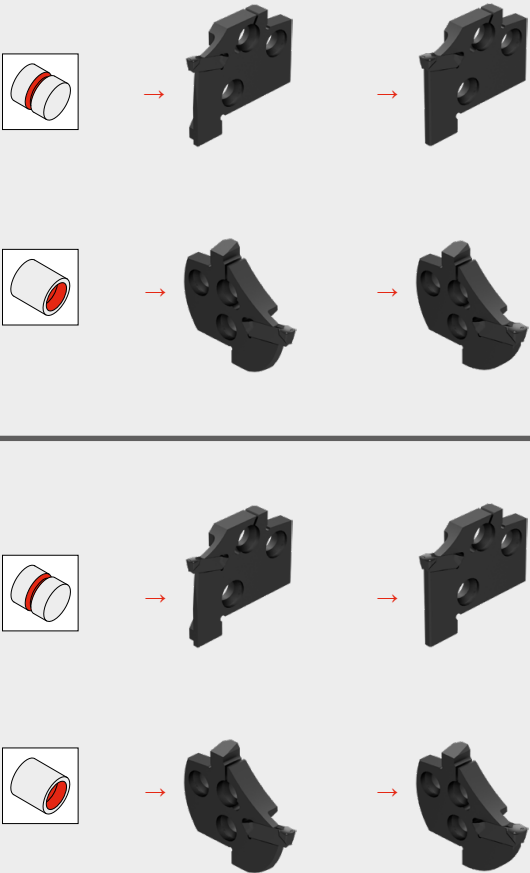
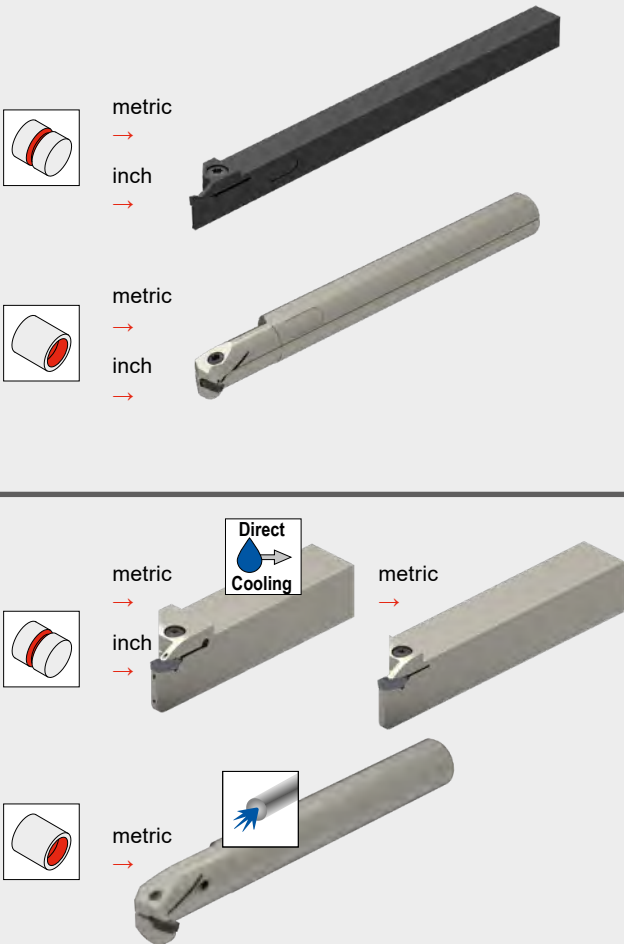
2	→ X32								3,2 - 8 mm .126" - .314"	24 mm .945"				
	→ GX40								8 - 12 mm .314" - .472"	35 mm 1.378"				
1	→ HX								16 - 60 mm .630" - 2.362"					
	→ MX								4 - 10 mm .157" - .394"					

Toolfinder

System	ModularClamp	MonoClamp
	 <p>metric → 0° → 90° → 0° inch → 0° → 90° → 45°</p>	<p>metric → inch →</p>  <p>metric → inch →</p> <p>metric → inch →</p> <p>→ Adapters and accessories</p>
SX		
LX		

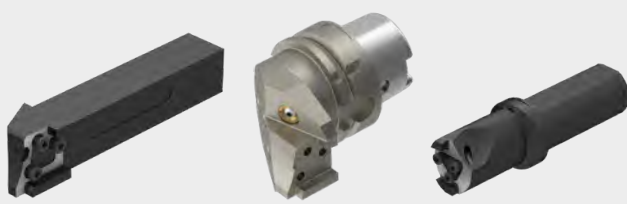
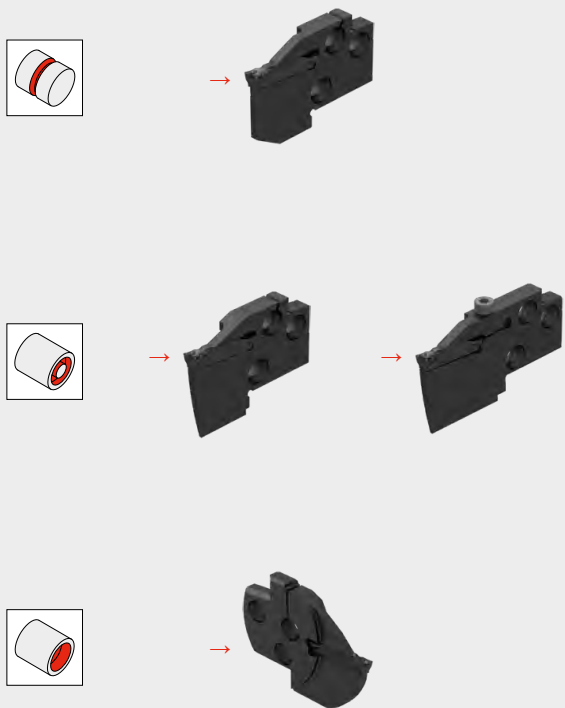
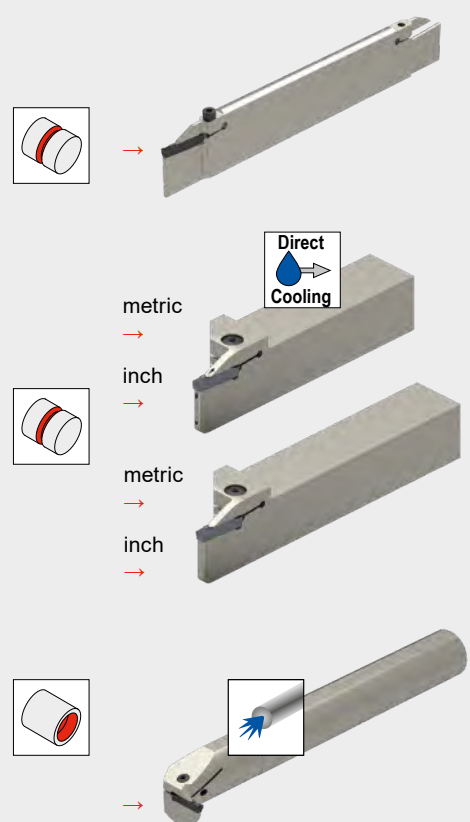
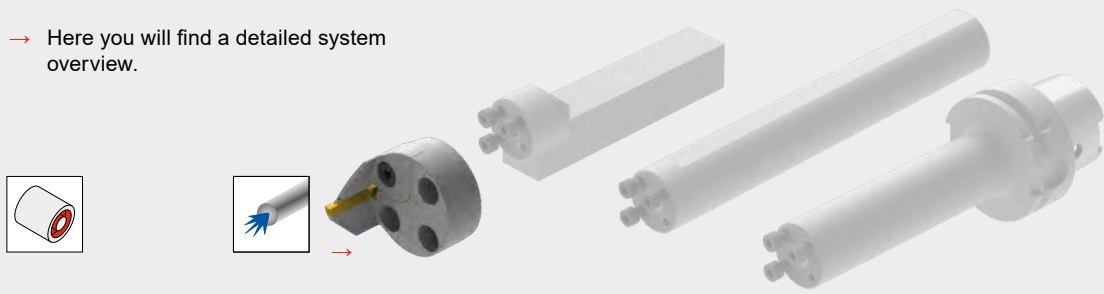
System		Chip breaker	Groove width	Grooving	Parting off	Grooving and turning	Copy turning	Axial grooving and turning	Circlip	Fine machining	Medium machining	Rough Machining							
													P	M	K	N	S	H	O
SX		-F2	2 - 4 mm .078" - .157"							F			●	●	●	○	●		○
		-M1	2 - 6 mm .078" - .236"							M			●	●	●	○	●		○
		-M2	2 - 6 mm .078" - .236"							M			●	●	●	○	●		○
		-M3	CRE 1,5 - 3,0 mm .059" - .118"							M			●	●	●	○	●		○
		-M7	2 - 6 mm .078" - .236"							M			●	●	●	○	●		○
		-M8	2 - 6 mm .078" - .236"							F			●	●	●	○	●		○
		-27P	2 - 4 mm .078" - .157"							M					●	●	○		○
LX		-M2	8 - 10 mm .314" - .393"							M			●	●	●	○	●		○
		-M3	CRE 4,0 mm .157"							M			●	●	●	○	●		○

Toolfinder

System	ModularClamp	MonoClamp
GX09	 <p>metric → 0° → 90° → 0° → 1,5xD / 2,5xD inch → 0° → 90° → 45° → 1.5xD / 2.5xD</p>	 <p>→ Adapters and accessories</p>
GX16		 <p>metric → inch →</p> <p>metric → inch →</p> <p>metric → inch →</p> <p>metric →</p> <p>metric →</p> <p>Direct Cooling</p>
GX16	<p>→ Here you will find a detailed system overview.</p>  <p>→ Indexable insert turning tools Here you will find suitable base adapters.</p>	

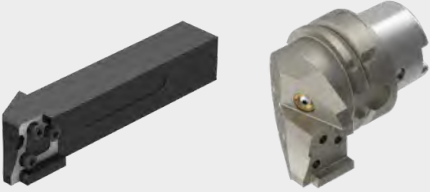
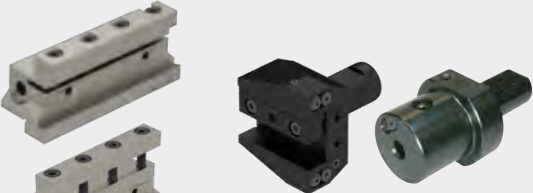
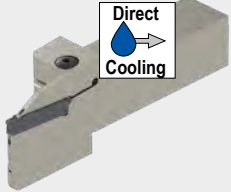
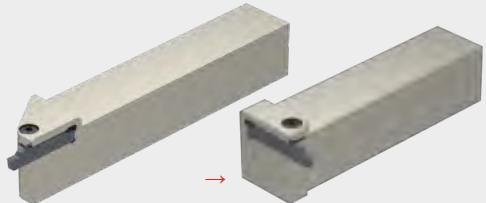
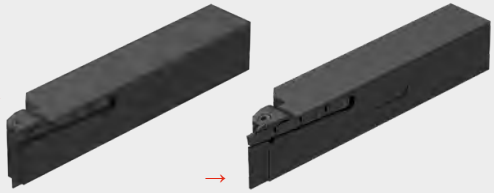
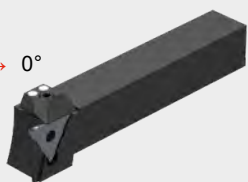
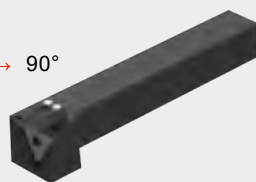
System		Chip breaker	Groove width	Grooving	Parting off	Grooving and turning	Copy turning	Axial grooving and turning	Circlip	Fine machining	Medium machining	Rough Machining	Steel	Stainless steel	Cast iron	Non-ferrous metals	Heat-resistant	Hardened steel	Non-metal materials
													P	M	K	N	S	H	O
GX09	→ N 	-F2	2 - 3 mm .078" - .118"	  						F			●	●	●	○	●		○
	→ N 	Standard	2 - 3 mm .078" - .118"	  						F			●	●	●	○	●		○
	→ N 	-M40	2 - 3 mm .078" - .118"	  							M		●	●	●	○	●		○
	→ N 	Standard	CRE 1 - 1,2 mm .039" - .047"			 				F			●	●	●	○	●		○
	→ N 	Standard	1 - 3,25 mm .039" - .128"							F			●	●	●	○	●		○
GX16	→ L N R 	-F2	2 - 5 mm .078" - .196"	  						F			●	●	●	○	●		○
	→ N 	Standard	2 - 6 mm .078" - .236"	  						F			●	●	●	○	●		○
	→ N 	-M40	2 - 6 mm .078" - .236"	  							M		●	●	●	○	●		○
	→ L N R 	-M7	2 - 3 mm .078" - .118"	 							M		●	●	●	○	●		○
	→ L N R 	-M1	2 - 4 mm .078" - .157"	 							M		●	●	●	○	●		○
	→ L N R 	-27P	2 - 6 mm .078" - .236"	  							M				●	●	○		○
	→ N 	-M3	CRE 3 - 6 mm .118" - .236"			 					M		●	○	●				
	→ N 	-27P	CRE 1,5 - 2,5 mm			 				F					●	●	○		○
	→ N 	Standard	CRE 0,8 - 3,0 mm .031" - .118"			 				F			●	●	●	○	●		○
	→ N 	Standard	1 - 4,25 mm .039" - .167"							F			●	●	●	○	●		○

Toolfinder

	ModularClamp	MonoClamp
System	 <p>metric → 0° → 90° → 0° → 1,5xD / 2,5xD inch → 0° → 90° → 45° → 1.5xD / 2.5xD</p>	 <p>metric → inch →</p> <p>metric → inch →</p> <p>→ Adapters and accessories</p>
GX24		 <p>metric → inch →</p> <p>metric → inch →</p> <p>metric → inch →</p> <p>Direct Cooling</p>
	<div>MaxiChange</div> <p>→ Here you will find a detailed system overview.</p>  <p>→ Indexable insert turning tools Here you will find suitable base adapters.</p>	

System		Chip breaker	Groove width	Grooving	Parting off	Grooving and turning	Copy turning	Axial grooving and turning	Circlip	Fine machining	Medium machining	Rough Machining							
													P	M	K	N	S	H	O
GX24		-F2	3 - 6 mm .118" - .236"								F		●	●	●	○	●		○
		-E	3 - 6 mm .118" - .236"							F			●	●	●	○	●		○
		-M1	2 - 4 mm .079" - .157"								M		●	●	●	○	●		○
		-M40	3 - 6 mm .118" - .236"								M		●	●	●	○	●		○
		-M40 Single-edged indexable insert for deeper grooves																	
		-M45	3 - 6 mm .118" - .236"								M		●	●	●	○	●		○
		-M3	CRE 1,5 - 3,0 mm .059" - .118"								M		●	○	●		○		
		-M33	CRE 1,5 - 3,0 mm .059" - .118"								M		●	○	●		○		
		-27P	3 - 6 mm .118" - .236"								M				●	●	○		○
		-27PF	CRE 3 - 4 mm .118" - .157"								M				●	●	○		○

Toolfinder

	ModularClamp	MonoClamp
System	<div><p>metric → 0° → 90° inch → 0° → 90° → 45°</p><p>→ 0°</p></div>	<div><p>metric → inch →</p><p>metric → inch →</p><p>→ Adapters and accessories</p></div>
GX35		<div><p>→</p><p>Direct Cooling</p></div>
FX	<div><p>→</p></div>	<div><p>→</p><p>metric → inch →</p></div>
AX	<div><p>→</p></div>	<div><p>→</p></div>
MC		<div><p>→</p></div>
TX	<div><p>→ 0°</p><p>→ 0°</p></div>	<div><p>→ 90°</p><p>→</p></div>

System		Chip breaker	Groove width	Grooving	Parting off	Grooving and turning	Copy turning	Axial grooving and turning	Circlip	Fine machining	Medium machining	Rough Machining	Steel	Stainless steel	Cast iron	Non-ferrous metals	Heat-resistant	Hardened steel	Non-metal materials
GX35		-M1	3 mm								M		●	●	●	○	●		○
FX		-F1	2,2-4,1 mm .087"-.161"								M		●	●	●	○	●		○
		-M1 narrow version	2,2 mm .087"								M		●	●	●	○	●		○
		-M1 wide version	3,1-8,2 mm .122"-.323"								M		●	●	●	○	●		○
		-R2	3,1-4,1 mm .122"-.161"								M		●	●	●	○	●		○
		-27P	2,2-4,1 mm .087"-.161"								M				●	●	○		○
AX		-F50	3 mm							F			●	●	●	○	●		○
MC		-F2	1,0 mm 1,5 mm								M		●	●	●	○	●		○
		-F2	1,5 mm 2,0 mm 2,5 mm																
		-F3																	
TX			1,99-2,79 mm								M		●	●	●	●	●	○	●
			0,57-5,29 mm								M		●	●	●	●	●	○	●
			CRE 0,25-2,0 mm								M		●	●	●	●	●	○	●
			1,5-4,0 mm								M		●	●	●	●	●	○	●
			1,5-3,0 mm								M		●	●	●	●	●	○	●

System	Adapters and accessories	Chip breaker	Groove width	Grooving	Grooving and turning	Copy turning	Fine machining	Medium machining	Rough Machining	Steel	Stainless steel	Cast iron	Non-ferrous metals	Heat-resistant	Hardened steel	Non-metal materials													
										P	M	K	N	S	H	O													
X32		→	-35P	CRE 4		F																							
		→	-27PF	CRE 3-4																									
		→	-27DPF	CRE 3-4																									
		→	-24PF	CRE 3-4																									
		→	-27PF	4,0		F																							
		→	-27P	3,2																									
			→	-R41													CRE 3-4		F	M	R								
			→	-M41													CRE 3-4												
	→		-F41	CRE 3-4																									
	→		-F4	CRE 3-4																									
		→	-R41	3,2 - 4,0		F	M	R																					
		→	-M41	3,2 - 4,0																									
→		-F41	3,2 - 4,0																										
→		-F4	3,2 - 4,0																										
GX40		→	-M41	CRE 4-6		M	R	M																					
		→	-R41	CRE 4-6																									
		→	-28P	CRE 4-6																									
HX		→	-R70	32-60		R																							
		→	-R71	16-25																									
		→	-R81	16-60																									
MX		→		4-10		F																							
		→		5-10																									

MaxiChange – Program overview

As the MaxiChange exchangeable head system is modular, it is extremely flexible and can be used for a variety of applications thanks to the wide selection of exchangeable heads. On top of these advantages, the MaxiChange GX also includes a grooving function for internal and external machining as well as axial and radial machining.

Exchangeable heads

→ Indexable insert turning tools

For negative inserts

PCLN 95°



PDUN 93°



PDQN 107,5°



PWLN 95°



For positive inserts

SCLC 95°



SDUC 93°



SDQC 107,5°



SVPC 117,5°



SVUC 93°



SVQC 107,5°



For internal threads



→ Grooving tools

→ GX 16

For radial grooving



→ GX 24

For axial grooving



Holders

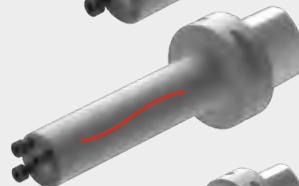
→ Indexable insert turning tools

PSC



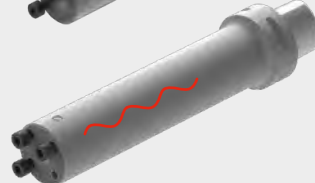
PSC

Vibration-damped



PSC

Actively vibration-damped

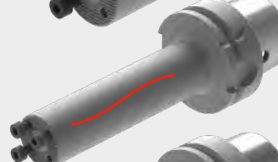


HSK-T



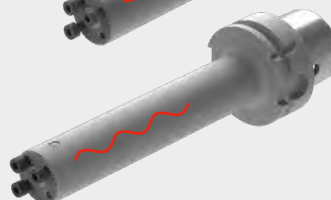
HSK-T

Vibration-damped

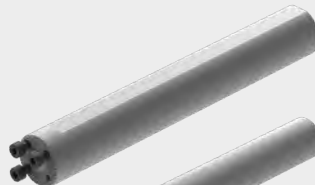


HSK-T

Actively vibration-damped

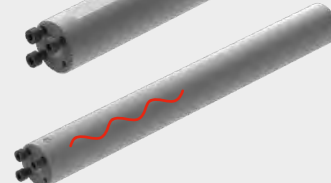


Cylindrical shank

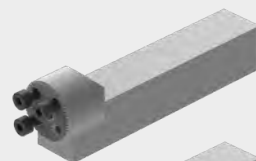


Cylindrical shank

Actively vibration-damped



Square shank holder 0°



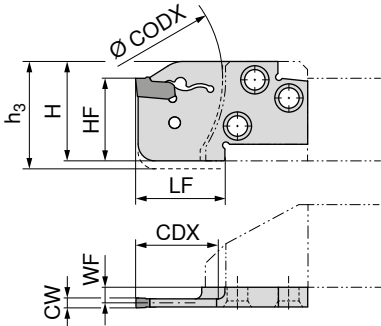
Square shank holder 90°



CoreLine – SX radial grooving module – ModularClamp

▲ For grooving, parting off, and finish turning

Scope of supply:
Grooving module only



Illustrations show right-hand versions



Designation	HF mm	CW mm	WF mm	LF mm	H mm	h ₃ mm	CODX mm	CDX mm	For grooving inserts
E20 R/L 20-SX2	20	2	3.57	22	24	27	60	20	SX .2..
E20 R/L 20-SX3	20	3	3.20	22	24	27	60	20	SX .3..
E25 R/L 20-SX2	25	2	5.07	22	30		75	20	SX .2..
E25 R/L 25-SX3	25	3	4.70	27	30		75	25	SX .3..
E25 R/L 35-SX3	25	3	4.70	37	30		75	35	SX .3..
E25 R/L 25-SX4	25	4	4.30	27	30		75	25	SX .4..
E25 R/L 35-SX4	25	4	4.30	37	30		75	35	SX .4..

Left	Right
TO	TO
70 897 ...	70 896 ...
020	020
120	120
025	025
125	125
225	225
325	325
425	425



Please order SX assembly key separately if required.

Spare parts
For grooving inserts

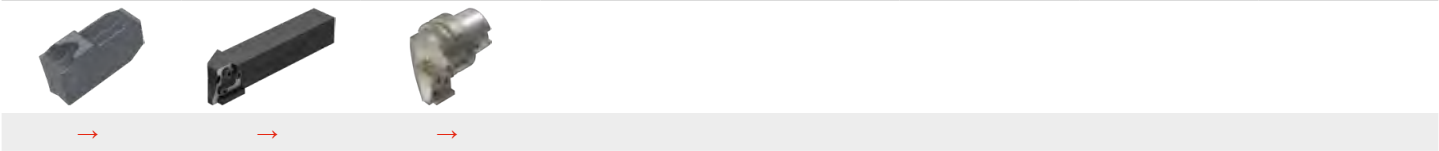
SX .2..	SX 2-3	836
SX .3..	SX 2-3	836
SX .4..	SX 4-6	837



Insert mounting
key SX

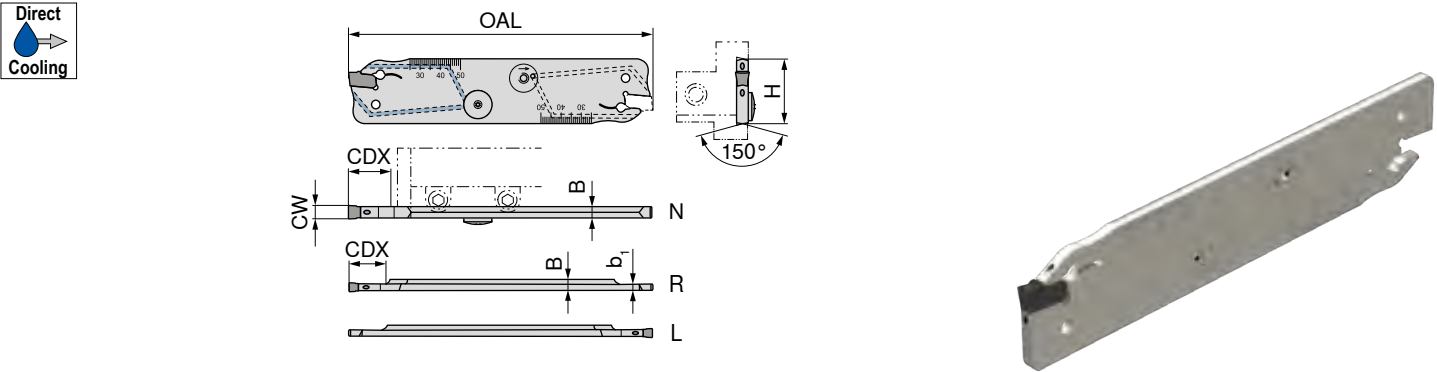
AS

70 950 ...



CoreLine – SX-DC standard radial blade

Scope of supply:
Blade incl. 1 sealing screw



Designation	R/L/N	CW mm	H mm	B mm	b ₁ mm	OAL mm	CDX mm	For grooving inserts
XLCF L 2602-DC-SX2	L	2	26	2.4	1.6	110	25	SX .2..
XLCF R 2602-DC-SX2	R	2	26	2.4	1.6	110	25	SX .2..
XLCF N 2603-DC-SX3	N	3	26	2.5		110	35	SX .3..
XLCF N 2604-DC-SX4	N	4	26	3.3		110	40	SX .4..
XLCF L 3202-DC-SX2	L	2	32	2.4	1.6	150	26	SX .2..
XLCF R 3202-DC-SX2	R	2	32	2.4	1.6	150	26	SX .2..
XLCF N 3203-DC-SX3	N	3	32	2.5		150	50	SX .3..
XLCF N 3204-DC-SX4	N	4	32	3.3		150	50	SX .4..
XLCF N 3205-DC-SX5	N	5	32	4.3		150	55	SX .5..
XLCF N 3206-DC-SX6	N	6	32	5.2		150	60	SX .6..

TO
70 884 ...
712
512
613
614
702
502
603
604
605
606

i

Please order SX assembly key separately if required.

Spare parts
For grooving inserts

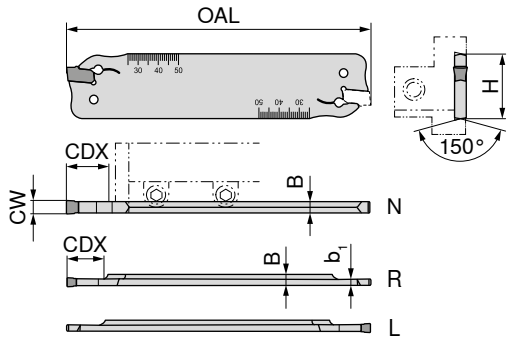
		AS 80 950 ...		AS 70 950 ...		AS 70 950 ...
SX .2..	T15 - IP	120	SX 2-3	836	M4 x 3	450
SX .3..	T15 - IP	120	SX 2-3	836	M4 x 3	450
SX .4..	T15 - IP	120	SX 4-6	837	M4 x 3	450
SX .5..	T15 - IP	120	SX 4-6	837	M4 x 3	450
SX .6..	T15 - IP	120	SX 4-6	837	M4 x 3	450



→ Adapters and accessories

CoreLine – SX standard radial blade

Scope of supply:
Blade only



Designation	R/L/N	CW mm	H mm	B mm	b ₁ mm	OAL mm	CDX mm	For grooving inserts
XLCF L 2602-SX2	L	2	26	2.4	1.5	110	25	SX .2..
XLCF R 2602-SX2	R	2	26	2.4	1.5	110	25	SX .2..
XLCF N 2603-SX3	N	3	26	2.4		110	35	SX .3..
XCLF N 2604-SX4	N	4	26	3.2		110	40	SX .4..
XLCF L 3202-SX2	L	2	32	2.4	1.5	150	25	SX .2..
XLCF R 3202-SX2	R	2	32	2.4	1.5	150	25	SX .2..
XLCF N 3203-SX3	N	3	32	2.4		150	50	SX .3..
XLCF N 3204-SX4	N	4	32	3.2		150	50	SX .4..
XLCF N 3205-SX5	N	5	32	4.2		150	55	SX .5..
XLCF N 3206-SX6	N	6	32	5.2		150	60	SX .6..

TO
70 884 ...
212
012
113
114
202
002
103
104
105
106



Please order SX assembly key separately if required.



Insert mounting
key SX

Spare parts
For grooving inserts

SX .2..	SX 2-3	836
SX .3..	SX 2-3	836
SX .4..	SX 4-6	837
SX .5..	SX 4-6	837
SX .6..	SX 4-6	837

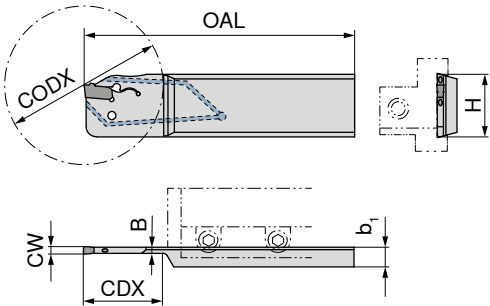
AS
70 950 ...



→ Adapters and accessories

CoreLine – SX-DC reinforced radial blade

Scope of supply:
Blade only



Illustrations show right-hand versions



Designation	R/L/N	CW mm	H mm	B mm	b ₁ mm	OAL mm	CODX mm	CDX mm	For grooving inserts
XLCF L 2608-DC-SX3	L	3	26	2.5	8	110	66	33	SX .3..
XLCF R 2608-DC-SX3	R	3	26	2.5	8	110	66	33	SX .3..
XLCF L 3208-DC-SX3	L	3	32	2.5	8	110	66	33	SX .3..
XLCF R 3208-DC-SX3	R	3	32	2.5	8	110	66	33	SX .3..

TO
70 879 ...
713
513
703
503



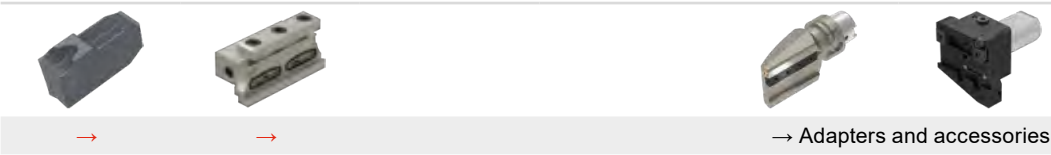
Please order SX assembly key separately if required.



AS
70 950 ...
836

Spare parts
For grooving inserts

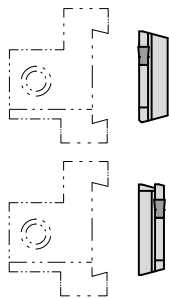
SX .3..	SX 2-3
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→ Adapters and accessories

Correct tool selection

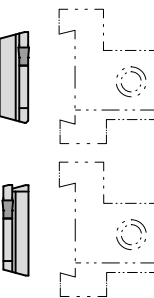
Right-hand tool



Standard version

Contra version

Left-hand tool



■ Grooving insert

Standard version

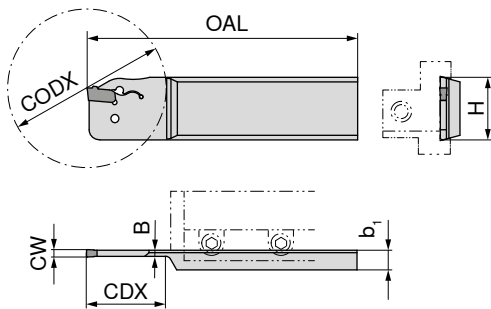


Contra version



CoreLine – SX reinforced radial blade

Scope of supply:
Blade only



Illustrations show right-hand versions



Designation	R/L/N	CW mm	H mm	B mm	b ₁ mm	OAL mm	CODX mm	CDX mm	For grooving inserts
XLCF L 2608-SX3	L	3	26	2.5	8	110	44	22	SX .3..
XLCF R 2608-SX3	R	3	26	2.5	8	110	44	22	SX .3..
XLCF L 3208-SX3	L	3	32	2.5	8	110	66	33	SX .3..
XLCF R 3208-SX3	R	3	32	2.5	8	110	66	33	SX .3..
XLCF L 3208-SX4	L	4	32	3.4	8	110	66	33	SX .4..
XLCF R 3208-SX4	R	4	32	3.4	8	110	66	33	SX .4..

1) Double-sided



Please order SX assembly key separately if required.

TO
70 879 ...
213 ¹⁾
013 ¹⁾
203
003
204
004

Spare parts
For grooving inserts

SX .3..	SX 2-3	836
SX .4..	SX 4-6	837



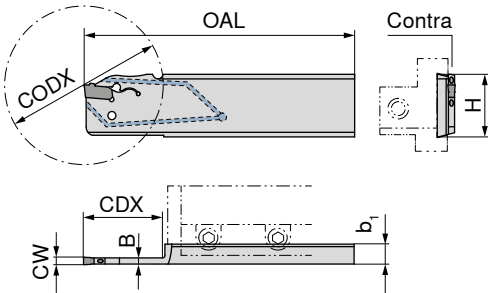
AS
70 950 ...
836
837



→ Adapters and accessories

CoreLine – SX-DC reinforced Contra radial blade

Scope of supply:
Blade only



Illustrations show right-hand versions



Designation	R/L/N	Version	CW mm	H mm	B mm	b ₁ mm	OAL mm	CODX mm	CDX mm	For grooving inserts
XLCF L 3208C-DC-SX3	L	Contra	3	32	2.5	8	110	66	33	SX .3..
XLCF R 3208C-DC-SX3	R	Contra	3	32	2.5	8	110	66	33	SX .3..

TO
70 877 ...
703
503



Please order SX assembly key separately if required.



AS
70 950 ...
836

Spare parts
For grooving inserts

SX .3..

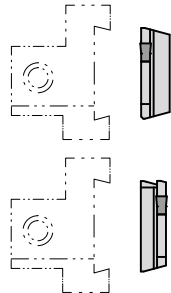
SX 2-3



→ Adapters and accessories

Correct tool selection

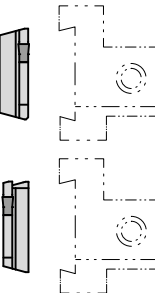
Right-hand tool



Standard version

Contra version

Left-hand tool



Grooving insert

Standard version

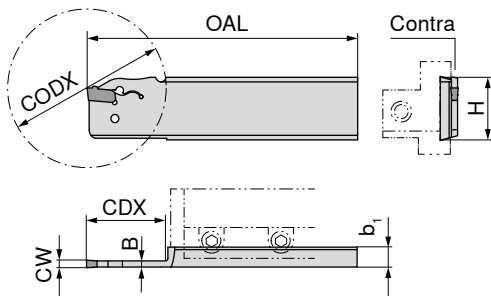


Contra version



CoreLine – SX reinforced Contra radial blade

Scope of supply:
Blade only



Illustrations show right-hand versions



Designation	R/L/N	Version	CW mm	H mm	B mm	b ₁ mm	OAL mm	CODX mm	CDX mm	For grooving inserts
XLCF L 3208C-SX3	L	Contra	3	32	2.5	8	110	66	33	SX .3..
XLCF R 3208C-SX3	R	Contra	3	32	2.5	8	110	66	33	SX .3..

TO
70 877 ...
203
003



Please order SX assembly key separately if required.

Spare parts
For grooving inserts

SX .3..	SX 2-3
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Insert mounting key SX
AS
70 950 ...
836

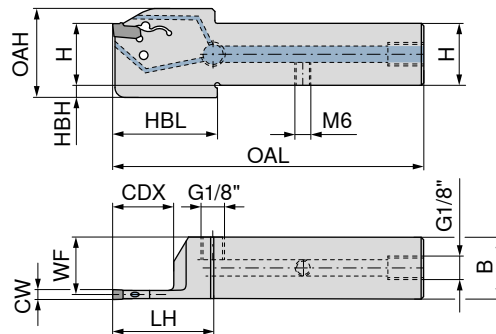


→ Adapters and accessories

CoreLine – Radial Monoholder SX-DC

Scope of supply:

Mono holder incl. screw plug and grub screw



Illustrations show right-hand versions



Designation	H mm	B mm	CW mm	WF mm	OAL mm	LH mm	OAH mm	CDX mm	HBH mm	HBL mm	For grooving inserts	Left TO	Right TO
												70 847 ...	70 847 ...
E12 R/L 0022-1212X-K-DC-SX2	12	12	2	11.20	71	27	22	22	5	28	SX .2..	21201	21200
E16 R/L 0026-1616X-K-DC-SX2	16	16	2	15.20	87	32	26	26	4	33	SX .2..	21601	21600
E16 R/L 0026-1616X-K-DC-SX3	16	16	3	14.75	87	32	26	26	4	33	SX .3..	31601	31600
E20 R/L 0026-2020X-K-DC-SX2	20	20	2	19.20	102	32	31	26	5	33	SX .2..	22001	22000
E20 R/L 0026-2020X-K-DC-SX3	20	20	3	18.75	102	32	31	26	5	33	SX .3..	32001	32000
E20 R/L 0033-2020X-K-DC-SX4	20	20	4	18.30	109	39	32	33	5	40	SX .4..	42001	42000
E25 R/L 0033-2525X-K-DC-SX2	25	25	2	24.20	126	41	36	33	5	42	SX .2..	22501	22500
E25 R/L 0026-2525X-K-DC-SX3	25	25	3	23.75	117	33	31	26			SX .3..	32501	32500
E25 R/L 0033-2525X-K-DC-SX3	25	25	3	23.75	126	41	36	33	5	42	SX .3..	32601	32600
E25 R/L 0033-2525X-K-DC-SX4	25	25	4	23.30	126	41	37	33	5	42	SX .4..	42501	42500
E25 R/L 0040-2525X-K-DC-SX4	25	25	4	23.30	133	48	38	40	6	49	SX .4..	42601	42600
E25 R/L 0040-2525X-K-DC-SX5	25	25	5	22.85	133	48	38	40	6	49	SX .5..	52501	52500
E25 R/L 0040-2525X-K-DC-SX6	25	25	6	22.35	133	48	38	40	6	49	SX .6..	62501	62500



Please order SX assembly key separately if required.

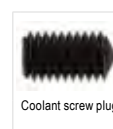
Spare parts

For grooving inserts

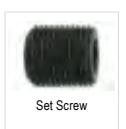
		AS 70 950 ...		AS 70 950 ...		AS 70 950 ...
SX .2..	SX 2-3	836	G 1/8"	294	M6x6	86700
SX .3..	SX 2-3	836	G 1/8"	294	M6x6	86700
SX .4..	SX 4-6	837	G 1/8"	294	M6x6	86700
SX .5..	SX 4-6	837	G 1/8"	294	M6x6	86700
SX .6..	SX 4-6	837	G 1/8"	294	M6x6	86700



Insert mounting
key SX



Coolant screw plug



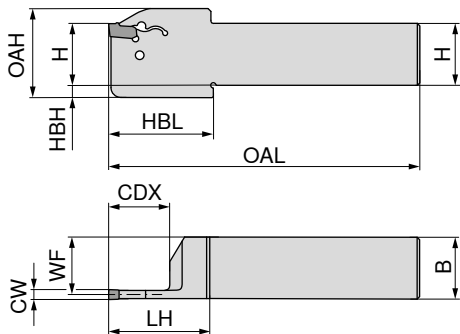
Set Screw



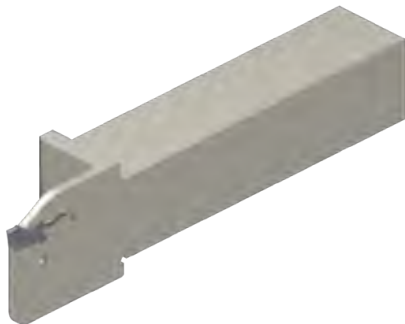
→ Adapters and accessories

CoreLine – Radial Monoholder SX

Scope of supply:
Mono holder only



Illustrations show right-hand versions



Designation	H mm	B mm	CW mm	WF mm	OAL mm	LH mm	OAH mm	CDX mm	HBH mm	HBL mm	For grooving inserts	Left	Right
												TO 70 846 ...	TO 70 846 ...
E12 R/L 0022-1212K-K-SX2	12	12	2	11.20	125	27	22	22	5	28	SX .2..	21201	21200
E16 R/L 0026-1616K-K-SX2	16	16	2	15.20	125	32	26	26	4	33	SX .2..	21601	21600
E16 R/L 0026-1616K-K-SX3	16	16	3	14.75	125	32	26	26	4	33	SX .3..	31601	31600
E20 R/L 0026-2020K-K-SX2	20	20	2	19.20	125	32	31	26	5	33	SX .2..	22001	22000
E20 R/L 0026-2020K-K-SX3	20	20	3	18.75	125	32	31	26	5	33	SX .3..	32001	32000
E20 R/L 0033-2020K-K-SX4	20	20	4	18.30	125	39	32	33	5	40	SX .4..	42001	42000
E25 R/L 0033-2525M-K-SX2	25	25	2	24.20	150	41	36	33	5	42	SX .2..	22501	22500
E25 R/L 0033-2525M-K-SX3	25	25	3	23.75	150	41	36	33	5	42	SX .3..	32601	32600
E25 R/L 0026-2525M-K-SX3	25	25	3	23.75	150	33	31	26			SX .3..	32501	32500
E25 R/L 0040-2525M-K-SX4	25	25	4	23.30	150	48	38	40	6	49	SX .4..	42601	42600
E25 R/L 0033-2525M-K-SX4	25	25	4	23.30	150	41	37	33	5	42	SX .4..	42501	42500
E25 R/L 0040-2525M-K-SX5	25	25	5	22.85	150	48	38	40	6	49	SX .5..	52501	52500
E25 R/L 0040-2525M-K-SX6	25	25	6	22.35	150	48	38	40	6	49	SX .6..	62501	62500



Please order SX assembly key separately if required.



Insert mounting
key SX

Spare parts
For grooving inserts

SX .2..	SX 2-3	836
SX .3..	SX 2-3	836
SX .4..	SX 4-6	837
SX .5..	SX 4-6	837
SX .6..	SX 4-6	837

AS
70 950 ...

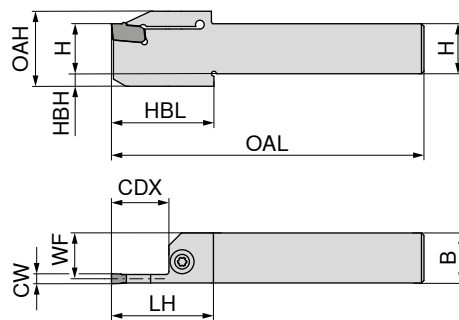


→ Adapters and accessories

CoreLine – Radial Monoholder SX

Scope of supply:

Monoholder incl. key and clamping screw



Illustrations show right-hand versions

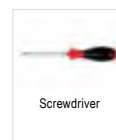


Designation	H mm	B mm	CW mm	WF mm	OAL mm	LH mm	OAH mm	CDX mm	HBH mm	HBL mm	For grooving inserts	Left	Right
												NEW TO 70 822 ...	NEW TO 70 822 ...
E12 R/L 0016-1212J-S-SX2	12	12	2	11.20	110	33	21	16	5	34	SX .2..	21201	21200
E16 R/L 0016-1616K-S-SX2	16	16	2	15.20	125	33	24	16	4	34	SX .2..	21601	21600
E16 R/L 0018-1616K-S-SX3	16	16	3	14.75	125	35	24	18	4	36	SX .3..	31601	31600
E20 R/L 0018-2020K-S-SX2	20	20	2	19.20	125	35	28	18	4	36	SX .2..	22001	22000
E20 R/L 0020-2020K-S-SX3	20	20	3	18.75	125	38	29	20	4	39	SX .3..	32001	32000
E20 R/L 0022-2020K-S-SX4	20	20	4	18.30	125	40	30	22	5	41	SX .4..	42001	42000
E25 R/L 0018-2525K-S-SX2	25	25	2	24.20	125	35	29	18			SX .2..	22501	22500
E25 R/L 0020-2525K-S-SX3	25	25	3	23.75	125	38	30	20			SX .3..	32501	32500
E25 R/L 0022-2525K-S-SX4	25	25	4	23.30	125	40	30	22			SX .4..	42501	42500
E25 R/L 0026-2525M-S-SX5	25	25	5	22.85	150	44	30	26			SX .5..	52501	52500
E25 R/L 0026-2525M-S-SX6	25	25	6	22.35	150	44	30	26			SX .6..	62501	62500

Spare parts

For grooving inserts

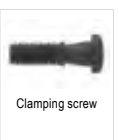
SX .2..	T15 - IP	AS 80 950 ...	M5x18 - 15IP	AS 70 950 ...
SX .3..	T15 - IP	120	M5x18 - 15IP	865
SX .4..	T15 - IP	120	M5x18 - 15IP	865
SX .5..	T15 - IP	120	M5x18 - 15IP	865
SX .6..	T15 - IP	120	M5x18 - 15IP	865



Screwdriver

AS

80 950 ...



Clamping screw

AS

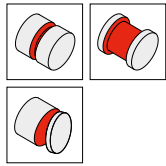
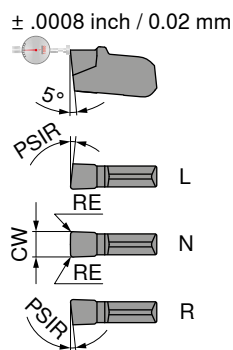
70 950 ...



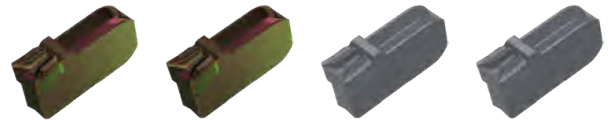
→ Adapters and accessories

CoreLine – Carbide grooving insert – SX

- ▲ High precision ground geometry
- ▲ R/L angled indexable insert for pip-free parting off
- ▲ Reduce feed rate values by 20–50% with R/L version



-F2 CTCP325	-F2 CTCP335	-F2 CTPP345	-F2 CTP1340
DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN



F	F	F	F
IG	IG	IG	IG
70 346 ...	70 346 ...	70 346 ...	70 346 ...
			02101
			03101
		822	622
923	523	823	623
		824	624
			02001
			03001

Designation	IH	CW ± 0.02 mm	RE ± 0.05 mm	PDPT mm	PSIR	For tool holder
SX E2.00 L 6	L	2		2.0	6°	-SX2
SX E3.00 L 6	L	3		2.0	6°	-SX3
SX E2.00 N 0.20	N	2	0.2	1.5		-SX2
SX E3.00 N 0.30	N	3	0.3	2.0		-SX3
SX E4.00 N 0.40	N	4	0.4	2.5		-SX4
SX E2.00 R 6	R	2		1.5	6°	-SX2
SX E3.00 R 6	R	3		1.5	6°	-SX3

P	●	●	●	●
M	○	○	●	●
K	●	●		●
N				○
S	○		○	●
H				
O				○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.
- Here you will find additional product information.



Note: Reduce feed rate value by 20–50% for R/L version.

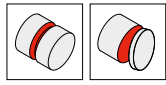
Internal machining

External machining

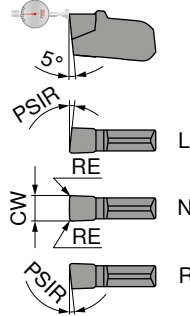


CoreLine – Carbide grooving insert – SX

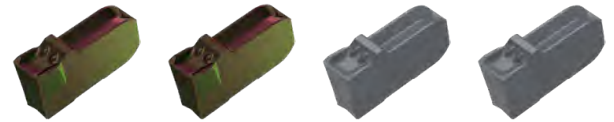
- ▲ Geometry with negative edge-chamfers available in right, left, and neutral versions
- ▲ R/L angled indexable insert for pip-free parting off
- ▲ Reduce feed rate values by 20–50% with R/L version



± .0039 inch / 0.10 mm



-M1 CTCP325	-M1 CTCP335	-M1 CTPP345	-M1 CTP1340
DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN



M	M	M	M
IG	IG	IG	IG
70 342 ...	70 342 ...	70 342 ...	70 342 ...
913			612
			613
			614
922	52200	822	622
923	523	823	623
924	524	824	624
925	52500	825	625
926	52600	826	626
903			602
			603
			604

Designation	IH	CW ± 0.05 mm	RE ± 0.05 mm	PSIR	For tool holder
SX E2.00 L 6	L	2	0.2	6°	-SX2
SX E3.00 L 6	L	3	0.2	6°	-SX3
SX E4.00 L 6	L	4	0.3	6°	-SX4
SX E2.00 N 0.20	N	2	0.2		-SX2
SX E3.00 N 0.20	N	3	0.2		-SX3
SX E4.00 N 0.30	N	4	0.3		-SX4
SX E5.00 N 0.30	N	5	0.3		-SX5
SX E6.00 N 0.40	N	6	0.4		-SX6
SX E2.00 R 6	R	2	0.2	6°	-SX2
SX E3.00 R 6	R	3	0.2	6°	-SX3
SX E4.00 R 6	R	4	0.3	6°	-SX4

P	●	●	●	●
M	○	○	●	●
K	●	●	●	●
N				○
S	○		○	●
H				
O				○



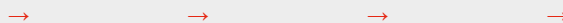
- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.
- Here you will find additional product information.



Note: Reduce feed rate value by 20–50% for R/L version.

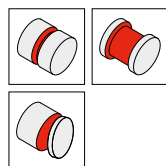
Internal machining

External machining

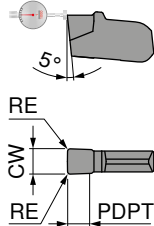


CoreLine – Carbide grooving insert – SX

▲ All-purpose geometry for parting off, grooving, and longitudinal turning



± .0039 inch / 0.10 mm



Designation	CW +/-0.05 mm	RE +/-0.05 mm	PDPT mm	For tool holder
SX E2.00 N 0.20	2	0.2	1.5	-SX2
SX E3.00 N 0.30	3	0.3	2.0	-SX3
SX E4.00 N 0.40	4	0.4	2.5	-SX4
SX E5.00 N 0.40	5	0.4	2.7	-SX5
SX E6.00 N 0.50	6	0.5	3.0	-SX6

M	M	M	M
IG	IG	IG	IG
70 343 ...	70 343 ...	70 343 ...	70 343 ...
922	522	822	622
923	523	823	623
924	524	824	624
925	525	825	625
926	526	826	626

P	●	●	●	●
M	○	○	●	●
K	●	●	○	○
N	○	○	○	○
S	○	○	○	○
H	○	○	○	○
O	○	○	○	○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

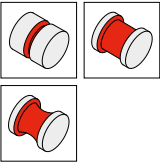
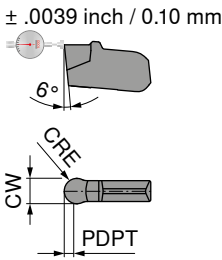
Internal machining

External machining



CoreLine – Carbide radial grooving insert – SX

- ▲ For grooving and copy turning
- ▲ Very good chip control



-M3 CTCP335	-M3 CTP1340
DRAGONSKIN	DRAGONSKIN



M	M
---	---

Designation	CW mm +/-0.05	CRE mm	PDPT mm	For tool holder
SX R1.50 N	3	1.5	1.5	-SX3
SX R2.00 N	4	2.0	2.0	-SX4
SX R2.50 N	5	2.5	2.5	-SX5
SX R3.00 N	6	3.0	3.0	-SX6

NEW IG	NEW IG
70 344 ...	70 344 ...
531	631
532	632
533	633
	634

P	●	●
M	○	●
K	●	●
N		○
S		●
H		
O		○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

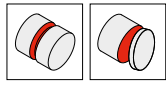
Internal machining

External machining

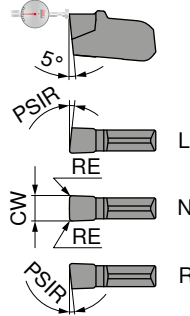


CoreLine – Carbide grooving insert – SX

- ▲ For grooving and parting off in steel at medium to high feed rates
- ▲ R/L angled indexable insert for pip-free parting off
- ▲ Reduce feed rate values by 20–50% with R/L version



± .0039 inch / 0.10 mm



M

IG

70 347 ...

02101

03101

62200

62300

62400

62500

62600

02001

03001

Designation	IH	CW ± 0.05 mm	RE ± 0.05 mm	PSIR	For tool holder
SX E2.00 L 6	L	2		6°	-SX2
SX E3.00 L 6	L	3		6°	-SX3
SX E2.00 N 0.20	N	2	0.20		-SX2
SX E3.00 N 0.20	N	3	0.20		-SX3
SX E4.00 N 0.25	N	4	0.25		-SX4
SX E5.00 N 0.30	N	5	0.30		-SX5
SX E6.00 N 0.35	N	6	0.35		-SX6
SX E2.00 R 6	R	2		6°	-SX2
SX E3.00 R 6	R	3		6°	-SX3

P	●
M	●
K	●
N	○
S	●
H	
O	○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.
- Here you will find additional product information.



Note: Reduce feed rate value by 20–50% for R/L version.

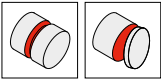
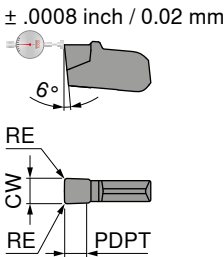
Internal machining

External machining



CoreLine – Carbide grooving insert – SX

- ▲ Ground geometry
- ▲ First choice for the grooving and parting off of stainless steel



-M8
CTP1340

DRAGONSKIN



Designation	CW <small>+/-0.05</small> mm	RE <small>+/-0.05</small> mm	PDPT mm	For tool holder
SX E2.00 N 0.20	2	0.20	1.5	-SX2
SX E3.00 N 0.20	3	0.20	2.0	-SX3
SX E4.00 N 0.25	4	0.25	2.5	-SX4
SX E5.00 N 0.30	5	0.30	2.7	-SX5
SX E6.00 N 0.35	6	0.35	3.0	-SX6

F

IG

70 348 ...

62200

62300

62400

62500

62600

P	●
M	●
K	●
N	○
S	●
H	
O	○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

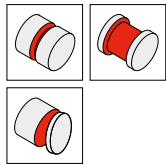
Internal machining

External machining

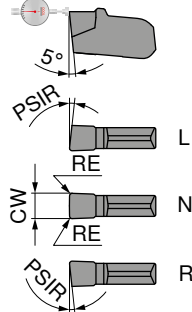
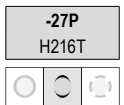


CoreLine – Carbide grooving insert – SX

- ▲ Insert with highly positive cutting edge geometry and sharp cutting edge, polished chip breaker
- ▲ Specialist for aluminum and other soft long-chipping non-ferrous metals
- ▲ R/L angled indexable insert for pip-free parting off
- ▲ Reduce feed rate values by 20–50% with R/L version



± .0008 inch / 0.02 mm



M

Designation	IH	CW ± 0.02 mm	RE ± 0.05 mm	PSIR	For tool holder
SX E2.00 L 6	L	2		6°	-SX2
SX E3.00 L 6	L	3		6°	-SX3
SX E2.00 N 0.20	N	2	0.2		-SX2
SX E3.00 N 0.30	N	3	0.3		-SX3
SX E4.00 N 0.40	N	4	0.4		-SX4
SX E2.00 R 6	R	2		6°	-SX2
SX E3.00 R 6	R	3		6°	-SX3

NEW
IG
70 349 ...
42101
43101
122
123
124
42001
43001

P	
M	
K	●
N	●
S	○
H	
O	○



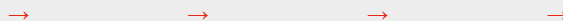
- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.
- Here you will find additional product information.



Note: Reduce feed rate value by 20–50% for R/L version.

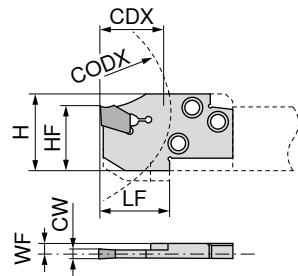
Internal machining

External machining



CoreLine – Radial grooving module FX short/long – ModularClamp

Scope of supply:
Grooving module and insert mounting key



Illustrations show right-hand versions



Designation	HF mm	CW mm	WF mm	LF mm	H mm	CODX mm	CDX mm	For grooving inserts
E20 R/L 20-FX 2.2	23	2.2	3.58	22	27	60	20	FX 2.2 ..
E20 R/L 20-FX 3.1	23	3.1	3.20	22	27	60	20	FX 3.1 ..
E25 R/L 20-FX 2.2	25	2.2	5.08	22	30	75	20	FX 2.2 ..
E25 R/L 25-FX 3.1	25	3.1	4.70	27	30	75	25	FX 3.1 ..
E25 R/L 35-FX 3.1	25	3.1	4.70	37	30	75	35	FX 3.1 ..
E25 R/L 35-FX 4.1	25	4.1	4.30	37	30	75	35	FX 4.1 ..
E25 R/L 35-FX 5.1	25	5.1	3.90	37	30	75	35	FX 5.1 ..

Left	Right
TO	TO
70 876 ...	70 875 ...
020	020
120	120
025	025
125	125
525	525
625	625
725	725

Spare parts
For grooving inserts

FX 2.2 ..
FX 3.1 ..
FX 4.1 ..
FX 5.1 ..



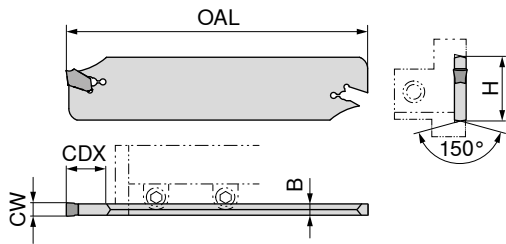
Insert mounting key

AS
70 950 ...
375
376
376
376



CoreLine – Radial blade FX

Scope of supply:
Blade and insert mounting key



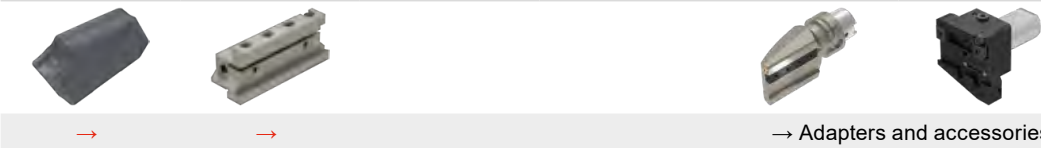
Designation	H mm	B mm	OAL mm	CW mm	CDX mm	For grooving inserts
XLCEN 2602 J 22 FX	26	1.65	110	2.2	25	FX 2.2 ..
XLCFN 2603 J 31 FX	26	2.40	110	3.1	35	FX 3.1 ..
XLCFN 2604 J 41 FX	26	3.20	110	4.1	40	FX 4.1 ..
XLCEN 3202 M 22 FX	32	1.65	150	2.2	30	FX 2.2 ..
XLCFN 3203 M 31 FX	32	2.40	150	3.1	50	FX 3.1 ..
XLCFN 3204 M 41 FX	32	3.20	150	4.1	50	FX 4.1 ..
XLCFN 3205 M 51 FX	32	4.00	150	5.1	55	FX 5.1 ..
XLCFN 3206 M 65 FX	32	5.20	150	6.5	55	FX 6.5 ..
XLCEN 4608 S 82 FX	46	6.80	250	8.2	80	FX 8.2 ..
XLCEN 4609 S 97 FX	46	8.00	250	9.7	80	FX 9.7 ..

TO
70 832 ...
101
102
103
004
104
105
106
107
108
109

Spare parts
For grooving inserts

FX 2.2 ..
FX 3.1 ..
FX 4.1 ..
FX 5.1 ..
FX 6.5 ..
FX 8.2 ..
FX 9.7 ..

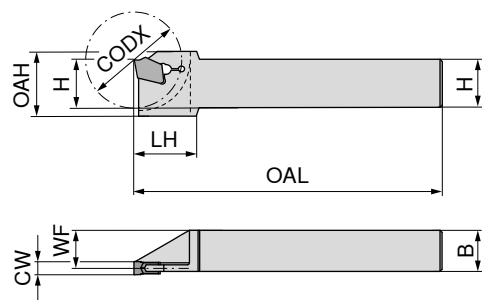
Insert mounting key
AS
70 950 ...
375
376
376
376
376
377
377



→ Adapters and accessories

CoreLine – Radial Monoholder FX

Scope of supply:
Monoholder and insert mounting key



Illustrations show right-hand versions

Designation	H mm	B mm	OAL mm	LH mm	OAH mm	CW mm	WF mm	CODX mm	For grooving inserts	Left	Right
										TO 70 837 ...	TO 70 836 ...
XLCE R/L 1010 M-FX2.2	10	10	150	19.4	21	2.2	9.18	30	FX 2.2 ..	101	101
XLCE R/L 1212 F-FX2.2	12	12	80	21.0	21	2.2	11.18	30	FX 2.2 ..	102	102
XLCE R/L 1612 H-FX3.1	16	12	100	21.4	25	3.1	10.80	35	FX 3.1 ..	106	106
XLCE R/L 2016 K-FX3.1	20	16	125	26.4	26	3.1	14.80	40	FX 3.1 ..	107	107
XLCE R/L 2520 M-FX3.1	25	20	150	35.2	34	3.1	18.80	50	FX 3.1 ..	108	108

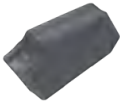
Spare parts
For grooving inserts

FX 2.2 ..	375
FX 3.1 ..	376



Insert mounting key

AS
70 950 ...

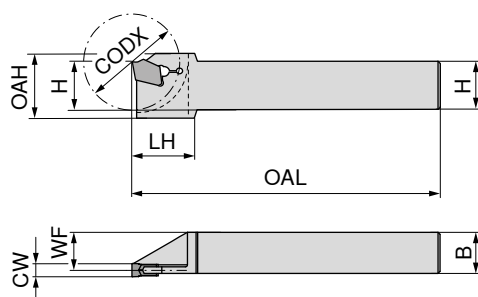


→ Adapters and accessories

CoreLine – Radial Monoholder FX

Scope of supply:

Monoholder and insert mounting key



Illustrations show right-hand versions



Designation	H inch	B inch	OAL inch	LH inch	OAH inch	CW inch	WF inch	CODX inch	For grooving inserts	Left TO	Right TO
										78 837 ...	78 836 ...
XLCE R/L 06 M22 FX-E	0.375	0.375	6.000	0.709	0.498	0.087	0.343	0.984	FX 2.2 ..	37500 ¹⁾	37500 ¹⁾
XLCE R/L 08 F22 FX-E	0.500	0.500	3.000	0.709	0.623	0.087	0.497	1.142	FX 2.2 ..	50000 ¹⁾	50000 ¹⁾
XLCE R/L 08 M22 FX-E	0.500	0.500	6.000	0.709	0.623	0.087	0.497	1.142	FX 2.2 ..	50100 ¹⁾	50100 ¹⁾
XLCE R/L 09 M22 FX-E	0.563	0.563	6.000	0.709	0.686	0.087	0.530	1.142	FX 2.2 ..	56300 ¹⁾	56300 ¹⁾
XLCE R/L 10 H22 FX-E	0.625	0.625	4.000	0.709	0.748	0.087	0.593	1.142	FX 2.2 ..	62500 ¹⁾	62500 ¹⁾
XLCE R/L 10 H31 FX-E	0.625	0.625	4.000	0.827	0.748	0.122	0.578	1.339	FX 3.1 ..	62600 ¹⁾	62600 ¹⁾
XLCE R/L 12 K31 FX-E	0.750	0.750	5.000	0.984	0.906	0.122	0.703	1.575	FX 3.1 ..	75100 ¹⁾	75100 ¹⁾
XLCE R/L 12 K41 FX-E	0.750	0.750	5.000	0.984	0.906	0.161	0.687	1.575	FX 4.1 ..	75000 ¹⁾	75000 ¹⁾
XLCE R/L 64 M31 FX-E	1.000	0.750	6.000	1.220	1.118	0.122	0.703	1.969	FX 3.1 ..	00100 ¹⁾	00100 ¹⁾
XLCE R/L 64 M41 FX-E	1.000	0.750	6.000	1.220	1.118	0.161	0.687	1.969	FX 4.1 ..	00000 ¹⁾	00000 ¹⁾

1) Not in stock

Spare parts for article number

78 836 37500 / 78 837 37500	375
78 836 50000 / 78 837 50000	375
78 836 50100 / 78 837 50100	375
78 836 56300 / 78 837 56300	375
78 836 62500 / 78 837 62500	375
78 836 62600 / 78 837 62600	376
78 836 75100 / 78 837 75100	376
78 836 75000 / 78 837 75000	376
78 836 00100 / 78 837 00100	376
78 836 00000 / 78 837 00000	376



Insert mounting key

AS

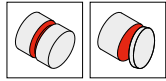
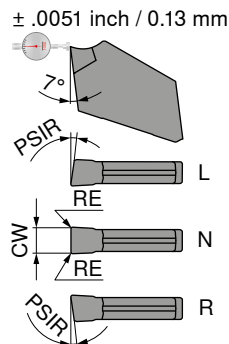
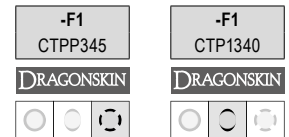
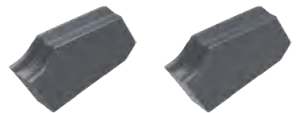
70 950 ...



→ Adapters and accessories

CoreLine – Carbide grooving insert – FX

- ▲ Excellent cutting geometry with low cutting forces
- ▲ Very good chip control also with low feed rates
- ▲ Reduced built-up edge
- ▲ R/L angled indexable insert for pip-free parting off
- ▲ Reduce feed rate values by 20–50% with R/L version



Designation	IH	CW ^{-0.1} mm	RE ^{+/-0.05} mm	PSIR	For tool holder
FX 2.2 L 5-F1	L	2.2	0.15	5°	-FX 2.2
FX 3.1 L 5-F1	L	3.1	0.20	5°	-FX 3.1
FX 2.2 N 0.15-F1	N	2.2	0.15		-FX 2.2
FX 3.1 N 0.20-F1	N	3.1	0.20		-FX 3.1
FX 3.1 N 0.40-F1	N	3.1	0.40		-FX 3.1
FX 4.1 N 0.20-F1	N	4.1	0.20		-FX 4.1
FX 2.2 R 5-F1	R	2.2	0.15	5°	-FX 2.2
FX 3.1 R 5-F1	R	3.1	0.20	5°	-FX 3.1

F	F
IG	IG
70 331 ...	70 331 ...
	647
	651
848	648
852	652
856	656
860	660
	649
	653

P	●	●
M	●	●
K		●
N		○
S	○	●
H		
O		○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.
- Here you will find additional product information.



Note: Reduce feed rate value by 20–50% for R/L version.

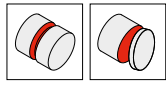
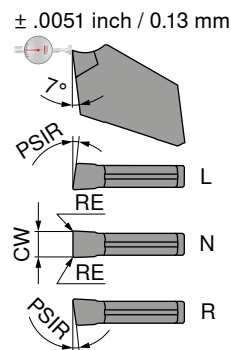
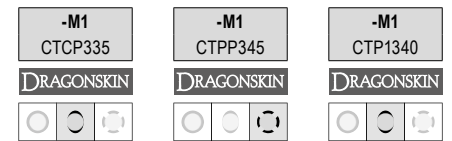
Internal machining

External machining



CoreLine – Carbide grooving insert – FX

- ▲ Narrow version
- ▲ R/L angled indexable insert for pip-free parting off
- ▲ Reduce feed rate values by 20–50% with R/L version



M	M	M
IG	IG	IG
70 330 ...	70 330 ...	70 330 ...
550	800	600
552	802	602
554	804	604

Designation	IH	CW _{-0.1} mm	RE _{±0.05} mm	PSIR	For tool holder
FX 2.2 L 4-M1	L	2.2	0.1	4°	-FX 2.2
FX 2.2 N 0.10-M1	N	2.2	0.1		-FX 2.2
FX 2.2 R 4-M1	R	2.2	0.1	4°	-FX 2.2

P	●	●	●
M	○	●	●
K	●	●	●
N	●	●	○
S	●	○	●
H	●	●	●
O	●	●	○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.
- Here you will find additional product information.



Note: Reduce feed rate value by 20–50% for R/L version.

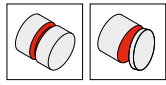
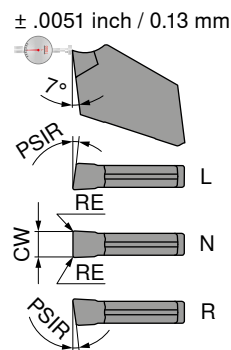
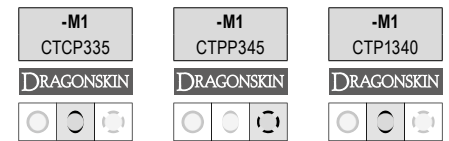
Internal machining

External machining



CoreLine – Carbide grooving insert – FX

- ▲ Wide version
- ▲ R/L angled indexable insert for pip-free parting off
- ▲ Reduce feed rate values by 20–50% with R/L version



Designation	IH	CW ± 0.05 mm	RE ± 0.05 mm	PSIR	For tool holder
FX 3.1 L 6-M1	L	3.1	0.15	6°	-FX 3.1
FX 4.1 L 6-M1	L	4.1	0.20	6°	-FX 4.1
FX 3.1 N 0.15-M1	N	3.1	0.15		-FX 3.1
FX 4.1 N 0.20-M1	N	4.1	0.20		-FX 4.1
FX 5.1 N 0.25-M1	N	5.1	0.25		-FX 5.1
FX 6.5 N 0.30-M1	N	6.5	0.30		-FX 6.5
FX 8.2 N 0.40-M1	N	8.2	0.40		XLCEN 4608
FX 3.1 R 6-M1	R	3.1	0.15	6°	-FX 3.1
FX 4.1 R 6-M1	R	4.1	0.20	6°	-FX 4.1

M	M	M
IG	IG	IG
70 332 ...	70 332 ...	70 332 ...
550		600
556		606
552	802	602
558	808	608
564	814	614
570		620
574		624
554		604
560		610

P			
M			
K			
N			
S			
H			
O			



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.
- Here you will find additional product information.



Note: Reduce feed rate value by 20–50% for R/L version.

Internal machining

External machining



CoreLine – Carbide grooving insert – FX

- ▲ Grooving insert with highly positive cutting edge geometry and sharp cutting edge
- ▲ Reduced built-up edge formation



Designation	IH	CW _{-0.1} mm	RE _{+/-0.05} mm	For tool holder
FX 2.2 N 0.10	N	2.2	0.10	-FX 2.2
FX 3.1 N 0.15	N	3.1	0.15	-FX 3.1
FX 4.1 N 0.15	N	4.1	0.15	-FX 4.1

M

IG

70 334 ...

650

652

654

P	
M	
K	●
N	●
S	○
H	
O	○

→ Find the recommended values for cutting speeds here.

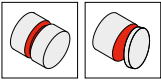
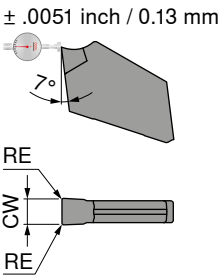
→ You can find the recommended feed values here.

Internal machining

External machining

CoreLine – Carbide grooving insert – FX

- ▲ Insert with excellent chip control for a wide range of feed rates
- ▲ Very stable cutting edge



Designation	IH	CW _{-.0.1} mm	RE _{+/-0.05} mm	For tool holder
FX 3.1 N 0.40-R2	N	3.1	0.4	-FX 3.1
FX 4.1 N 0.50-R2	N	4.1	0.5	-FX 4.1

R
IG
70 335 ...
852
858

R
IG
70 335 ...
652
658

P	●	●
M	●	●
K		●
N		○
S	○	●
H		
O		○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

Internal machining

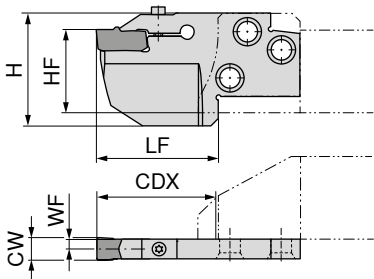
External machining



CoreLine – Axial and radial grooving module LX – ModularClamp

- ▲ Grooving width 0.315 and 0.94 inch / 8 and 10 mm
- ▲ Axial grooving from Ø 19.7 inch / 500 mm onwards
- ▲ Internal grooving and turning, from Ø 7.9 inch / 200 mm onwards

Scope of supply:
Grooving module only



Designation	CW mm	WF mm	LF mm	HF mm	H mm	CDX (1) mm	CDX (2) mm	CDX (3) mm	For grooving inserts
E32 N 25-LX	8 / 10	3.4	27	32	44	25	19	14	LX ..
E32 N 32-LX	8 / 10	3.4	34	32	44	32	26	21	LX ..
E32 N 45-LX	8 / 10	3.4	47	32	44	45	39	34	LX ..

Neutral
TO
70 835 ...
032
132
232

Radial grooving

Axial grooving

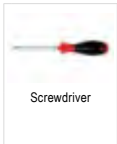
DAXIN > 500 mm

Internal grooving

DMIN > 200 mm

Spare parts
For grooving inserts

LX ..	T20	114	M4x18	204
-------	-----	-----	-------	-----



Screwdriver

AS

80 950 ...



Clamping screw

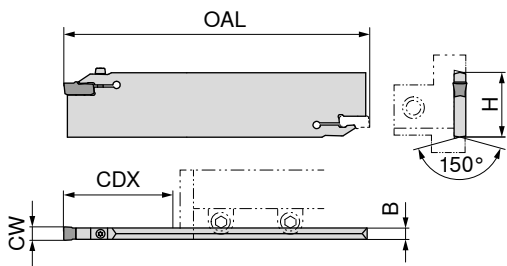
AS

70 950 ...



CoreLine – Blade LX

Scope of supply:
Blade incl. key and clamping screw



Designation	H mm	B mm	OAL mm	CW mm	CDX mm	For grooving inserts
XLCEN 4608-LX	46	6.8	250	8/10	80	LX ..

TO
70 833 ...
108

Spare parts
For grooving inserts

LX ..


Screwdriver
AS
80 950 ...
T20 114

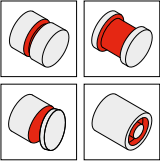
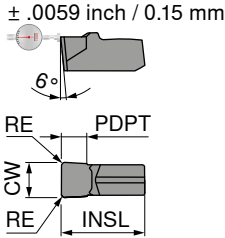

Clamping screw
AS
70 950 ...
M4x18 204



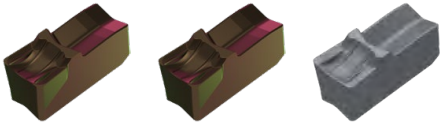
→ Adapters and accessories

CoreLine – Carbide grooving insert – LX

- ▲ Grooving width 0.315 and 0.394 inch / 8 and 10 mm
- ▲ Axial grooving from Ø 19.7 inch / 500 mm onwards
- ▲ Internal grooving and turning, from Ø 7.9 inch / 200 mm onwards



-M2 CTCP325	-M2 CTCP335	-M2 CTP1340
DRAGONSKIN	DRAGONSKIN	DRAGONSKIN



M	M	M
---	---	---

Designation	INSL mm	CW -/+0.08 mm	RE +/-0.1 mm	PDPT mm	For tool holder	IG 70 337 ... 928 932	IG 70 337 ... 578 582	IG 70 337 ... 682 678
LXE 8.00N0.80-M2	19	8	0.8	5	E32 N..-LX			
LXE 10.00N0.80-M2	19	10	0.8	5	E32 N..-LX			
P						●	●	●
M						○	○	●
K						●	●	○
N								○
S						○		●
H								
O								○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

Internal machining

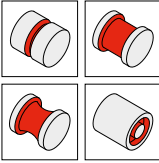
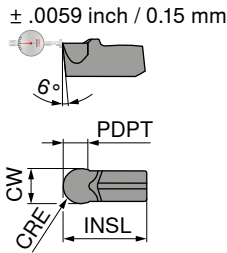


External machining



CoreLine – Carbide radial grooving insert – LX

- ▲ Grooving width 0.315 inch / 8 mm
- ▲ Axial grooving from Ø 19.7 inch / 500 mm
- ▲ Internal grooving and turning, from Ø 7.9 inch / 200 mm



-M3 CTCP325	-M3 CTCP335	-M3 CTP1340
DRAGONSKIN	DRAGONSKIN	DRAGONSKIN



M	M	M
IG	IG	IG
70 337 ... 908	70 337 ... 518	70 337 ... 618

Designation	INSL mm	CW mm -/+0.08	CRE mm	PDPT mm	For tool holder
LXR 4.00N-M3	19	8	4	5	E32 N ...-LX

P	●	●	●
M	○	○	●
K	●	●	●
N			○
S	○		●
H			
O			○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

Internal machining



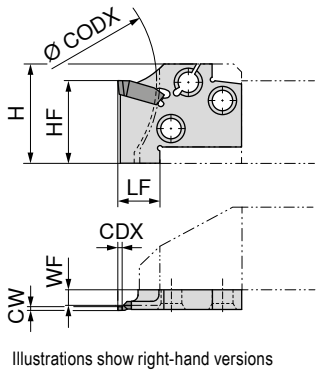
External machining



CoreLine – Radial grooving module GX09 – ModularClamp

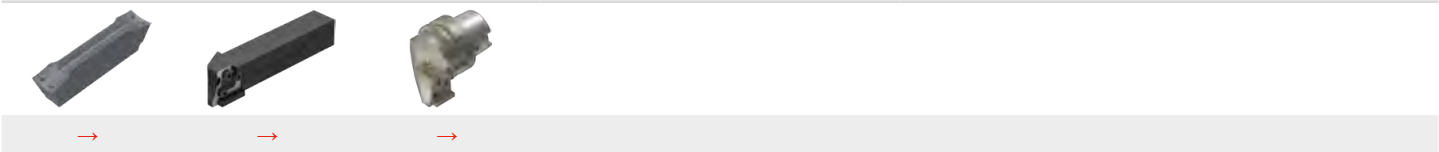
- ▲ For circlip grooves ≤ 0.1083 inch / 2.75 mm
- ▲ For radius grooves up to ≤ 0.0472 inch / 1.2 mm
- ▲ For external recessing

Scope of supply:
Grooving module only



Designation	CW mm	WF mm	LF mm	HF mm	H mm	CODX mm	CDX mm	For grooving inserts
E16 R/L 02-GX 09-1	<1,95	3.15	8	16	19.5	48	2	GX 09-1 ..R/L

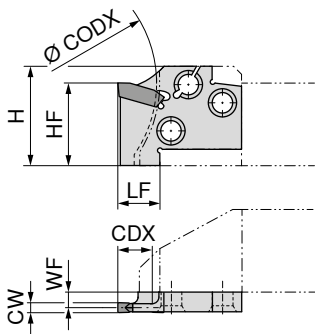
Left	Right
TO	TO
70 871 ...	70 870 ...
116	116



CoreLine – Radial grooving module GX09 – ModularClamp

- ▲ For grooving and turning
- ▲ For circlip grooves ≤ 0.2067 inch / 5.25 mm
- ▲ For radius grooves up to ≤ 0.0984 inch / 2.5 mm
- ▲ For external recessing

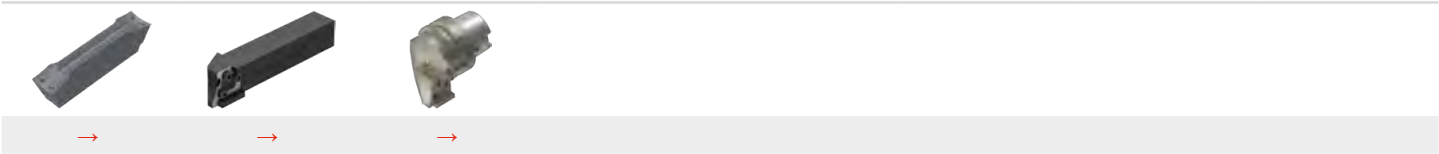
Scope of supply:
Grooving module only



Illustrations show right-hand versions



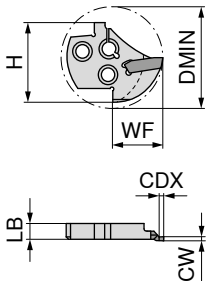
Designation	CW mm	WF mm	LF mm	HF mm	H mm	CODX mm	CDX mm	For grooving inserts	TO	
									70 866 ...	70 865 ...
E16 R/L 07-GX 09-1	2,00 - 2,75	3.15	8	16	19.5	48	7	GX 09-1 ..N	016	016
E16 R/L 07-GX 09-2	2,76 - 3,75	2.80	8	16	19.5	48	7	GX 09-2 ..N	116	116



CoreLine – Radial grooving module GX09 for internal machining – ModularClamp

- ▲ For circlip grooves ≤ 0.1083 inch / 2.75 mm
- ▲ For radius grooves up to ≤ 0.0472 inch / 1.2 mm

Scope of supply:
Grooving module only



Illustrations show right-hand versions



Designation	CW mm	LB mm	WF mm	H mm	CDX mm	DMIN mm	For grooving inserts	Left	Right
								TO	TO
I16 R/L 02-GX 09-1	<1,95	3.8	10.0	16.4	2	20	GX 09-1 ..R/L	70 886 ... 016	70 885 ... 016
I20 R/L 02-GX 09-1	<1,95	3.8	12.0	20.3	2	25	GX 09-1 ..R/L	020	020
I25 R/L 02-GX 09-1	<1,95	3.8	15.5	24.9	2	32	GX 09-1 ..R/L	025	025



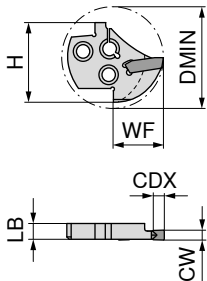
In right-hand module → insert left-hand grooving insert
In left-hand module → insert right-hand grooving insert



CoreLine – Radial grooving module GX09 for internal machining – ModularClamp

- ▲ For circlip grooves ≤ 0.2067 inch / 5.25 mm
- ▲ For radius grooves up to ≤ 0.0984 inch / 2.5 mm

Scope of supply:
Grooving module only



Illustrations show right-hand versions

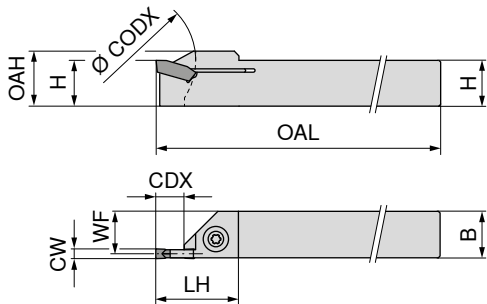


Designation	CW mm	LB mm	WF mm	H mm	CDX mm	DMIN mm	For grooving inserts	Left	Right
								TO 70 881 ...	TO 70 880 ...
I16 R/L 04-GX 09-1	2,00 - 2,75	3.8	10.0	16.4	4	20	GX 09-1 ..N	017	017
I16 R/L 04-GX 09-2	2,76 - 3,75	3.8	10.0	16.4	4	20	GX 09-2 ..N	117	117
I20 R/L 05-GX 09-1	2,00 - 2,75	3.8	12.0	20.3	5	25	GX 09-1 ..N	021	021
I20 R/L 05-GX 09-2	2,76 - 3,75	3.8	12.0	20.3	5	25	GX 09-2 ..N	121	121
I25 R/L 06-GX 09-1	2,00 - 2,75	3.8	15.5	24.9	6	32	GX 09-1 ..N	026	026
I25 R/L 06-GX 09-2	2,76 - 3,75	3.8	15.5	24.9	6	32	GX 09-2 ..N	126	126



CoreLine – Radial Monoholder GX09

Scope of supply:
Monoholder incl. Torx key and clamping screw



Illustrations show right-hand versions



Designation	H mm	B mm	CW mm	WF mm	OAH mm	OAL mm	LH mm	CODX mm	CDX mm	For grooving inserts
E10 R/L 00-1010M-GX09	10	10	2,00 - 3,50	9.35	12	150	18	30	7	GX 09 ..

Left	Right
TO	TO
70 863 ...	70 862 ...
010	010

When using "R" or "L" tools, the tool must be modified at the end face to ensure cutting clearance.

Spare parts
For grooving inserts

GX 09 ..	T15	113	M4x11	442
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Screwdriver

AS

80 950 ...

Clamping screw

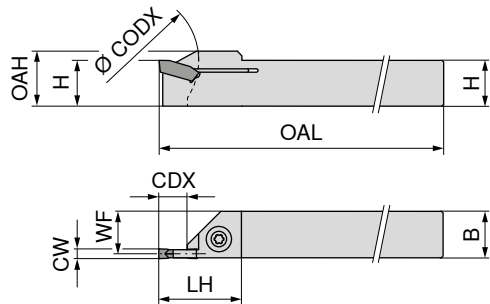
AS

70 950 ...

→ Adapters and accessories

CoreLine – Radial Monoholder GX09

Scope of supply:
Monoholder incl. Torx key and clamping screw



Illustrations show right-hand versions



Designation	H inch	B inch	CW inch	WF inch	OAH inch	OAL inch	LH inch	CODX inch	CDX inch	For grooving inserts
E10 R/L 00-06-GX09-E	0.375	0.375	2,00 - 3,50	0.349	0.472	6.000	0.709	1.181	0.270	GX 09 ..

Left	Right
TO	TO
78 863 ...	78 862 ...
03800 ¹⁾	03800 ¹⁾

1) Not in stock

When using "R" or "L" tools, the tool must be modified at the end face to ensure cutting clearance.

Spare parts
For grooving inserts

GX 09 ..	T15	113	M4x11	442
----------	-----	-----	-------	-----

Screwdriver

AS

80 950 ...

Clamping screw

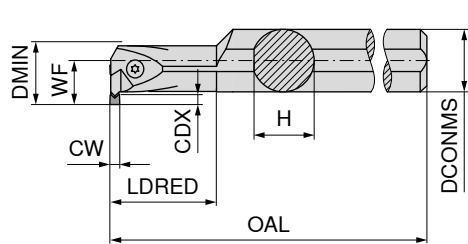
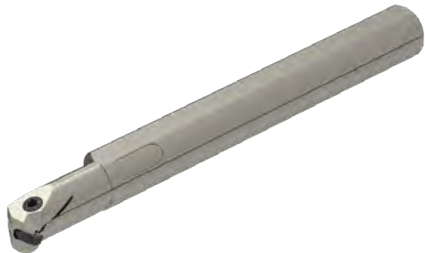
AS

70 950 ...

→ Adapters and accessories

CoreLine – Radial Mono boring bars GX09

Scope of supply:
Boring bar incl. key and clamping screw



Illustrations show right-hand versions

Designation	H mm	DCONMS mm	DMIN mm	CW mm	CDX mm	WF mm	OAL mm	LDRED mm	For grooving inserts
I12 R/L 90-2,5D-GX09	15.25	16	16	2,00 - 3,75	3	11	150	30	GX 09 ..

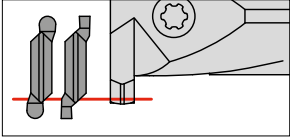
Left	Right
TO	TO
70 859 ...	70 858 ...
012	012



In right-hand boring bar → insert left-hand grooving insert
In left-hand boring bar → insert right-hand grooving insert

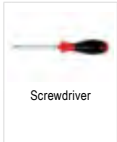
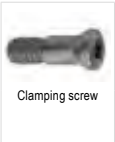


When using "R" or "L" tools, the tool must be modified at the end face to ensure cutting clearance.



Spare parts
For grooving inserts

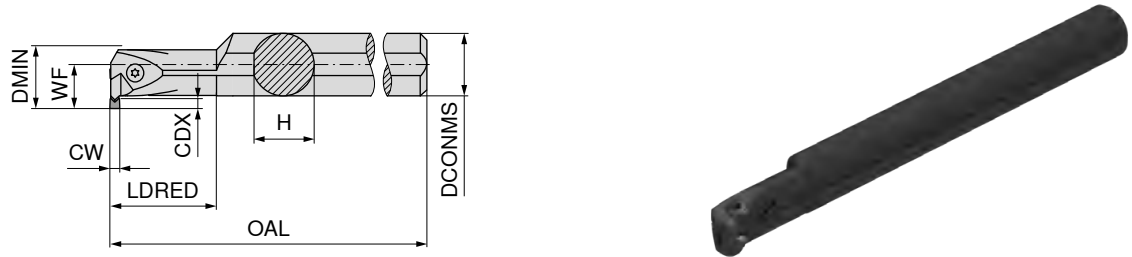
GX 09 ..	T15	AS 80 950 ... 113	M3,5x12,5	AS 70 950 ... 441
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→ Adapters and accessories

CoreLine – Radial Mono-boring bars GX09

Scope of supply:
Boring bar incl. key and clamping screw



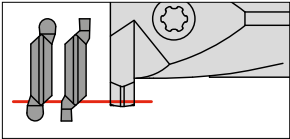
Illustrations show right-hand versions

Designation	H inch	DCONMS inch	DMIN inch	CW inch	CDX inch	WF inch	OAL inch	LDRED inch	For grooving inserts
I12 R/L 90-2.5D-GX09-E	0.600	0.625	0.630	0.079 - 0.148	0.118	0.433	6.000	1.181	GX 09 ..

1) Not in stock

In right-hand boring bar → insert left-hand grooving insert
In left-hand boring bar → insert right-hand grooving insert

When using "R" or "L" tools, the tool must be modified at the end face to ensure cutting clearance.



Left	Right
TO	TO
78 859 ...	78 858 ...
06300 1)	06300

Spare parts
For grooving inserts

GX 09 ..	T15	113	M3,5x12,5	441
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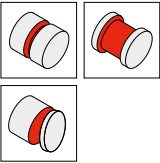
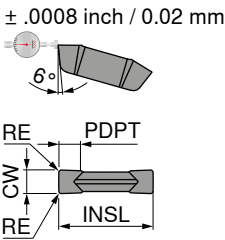
Screwdriver	Clamping screw
AS	AS
80 950 ...	70 950 ...



→ Adapters and accessories

CoreLine – Carbide grooving insert – GX09

- ▲ Insert with ground periphery
- ▲ Suitable also for parting off tubes and thin-walled workpieces



-F2
CTP1340

DRAGONSKIN



Designation	IH	INSL mm	CW +/-0.02 mm	RE +/-0.05 mm	For tool holder
GX 09-1 E2.00 N 0.20	N	9	2.0	0.2	GX 09-1
GX 09-1 E2.50 N 0.20	N	9	2.5	0.2	GX 09-1
GX 09-2 E3.00 N 0.30	N	9	3.0	0.3	GX 09-2

F

IG

70 360 ...

600

602

604

P	●
M	●
K	●
N	○
S	●
H	
O	○

→ Find the recommended values for cutting speeds here.

→ You can find the recommended feed values here.

Internal machining

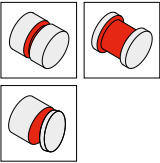
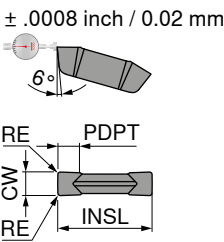
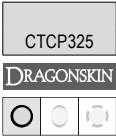


External machining



CoreLine – Carbide grooving insert – GX09

- ▲ Suitable for parting off thin-walled workpieces
- ▲ Standard geometry



Designation	INSL mm	CW mm +/-0.02	RE mm +/-0.05	PDPT mm	For tool holder
GX 09-1 E2.00 N 0.20	9	2.0	0.2	1.5	GX 09-1
GX 09-1 E2.50 N 0.20	9	2.5	0.2	1.5	GX 09-1
GX 09-2 E3.00 N 0.30	9	3.0	0.3	2.0	GX 09-2

F	F
IG	IG
70 350 ...	70 350 ...
984	634
988	638
992	642

P	●	●
M	○	●
K	●	○
N	○	○
S	○	●
H		
O		○

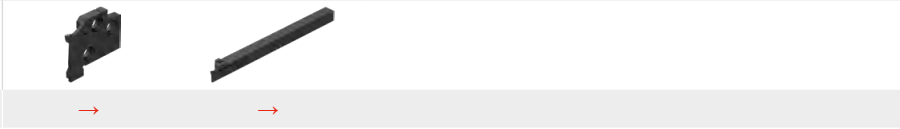


- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

Internal machining

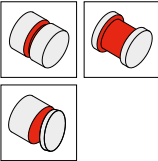


External machining

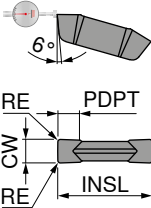


CoreLine – Carbide grooving insert – GX09

▲ Very good chip control



± .0059 inch / 0.15 mm



-M40 CTCP325	-M40 CTPP345	-M40 CTP1340
DRAGONSKIN	DRAGONSKIN	DRAGONSKIN



Designation	INSL mm	CW mm +/-0.05	RE mm +/-0.05	PDPT mm	For tool holder
GX 09-1 E2.00 N 0.20	9	2	0.2	1.5	GX 09-1
GX 09-2 E3.00 N 0.30	9	3	0.3	2.0	GX 09-2

M	M	M
IG	IG	IG
70 351 ...	70 351 ...	70 351 ...
986	886	686
994	894	694

P	●	●	●
M	○	●	●
K	●	●	●
N	○	○	○
S	○	○	●
H			
O			○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

Internal machining

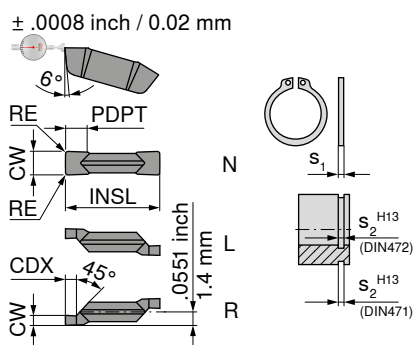
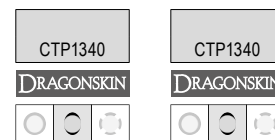
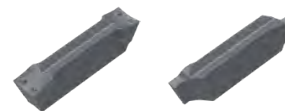


External machining



CoreLine – Carbide grooving insert for circlip grooves – GX09

▲ Standard geometry



Designation	IH	INSL	s ₁	s ₂	CW ± 0.02	RE ± 0.05	CDX	PDPT	For tool holder
GX 09-1 S1.00 L	L	9	0.80	0.90	1.00		1.14		R/L 02-GX 09-1
GX 09-1 S1.20 L	L	9	1.00	1.10	1.20		1.34		R/L 02-GX 09-1
GX 09-1 S1.40 L	L	9	1.20	1.30	1.40		1.53		R/L 02-GX 09-1
GX 09-1 S1.70 L	L	9	1.50	1.60	1.70		1.82		R/L 02-GX 09-1
GX 09-1 S1.95 N	N	9	1.75	1.85	1.95	0.1		2	GX 09-1
GX 09-1 S2.25 N	N	9	2.00	2.15	2.25	0.1		2	GX 09-1
GX 09-2 S2.75 N	N	9	2.50	2.65	2.75	0.1		2	GX 09-2
GX 09-2 S3.25 N	N	9	3.00	3.15	3.25	0.1		2	GX 09-2
GX 09-1 S1.00 R	R	9	0.80	0.90	1.00		1.14		R/L 02-GX 09-1
GX 09-1 S1.20 R	R	9	1.00	1.10	1.20		1.34		R/L 02-GX 09-1
GX 09-1 S1.40 R	R	9	1.20	1.30	1.40		1.53		R/L 02-GX 09-1
GX 09-1 S1.70 R	R	9	1.50	1.60	1.70		1.82		R/L 02-GX 09-1

F F

IG IG

70 352 ... 70 352 ...

GX 09-1 S1.95 N	692	684
GX 09-1 S2.25 N	694	686
GX 09-2 S2.75 N	696	688
GX 09-2 S3.25 N	698	690
GX 09-1 S1.00 R		676
GX 09-1 S1.20 R		678
GX 09-1 S1.40 R		680
GX 09-1 S1.70 R		682

P	●	●
M	●	●
K	●	●
N	○	○
S	●	●
H		
O	○	○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.



Attention – only applies to internal machining:

Right-hand grooving insert → left-hand module or Mono boring bar
Left-hand grooving insert → right-hand module or Mono-boring bar

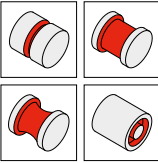
Internal machining

External machining

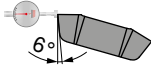
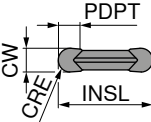


CoreLine – Carbide radial grooving insert – GX09

▲ Standard geometry



± .0008 inch / 0.02 mm



Designation	IH	INSL	CW	CRE	PDPT	For tool holder
		mm	mm	mm	mm	
GX 09-1 R1.00 N	N	9	2.0	1.0	1.0	GX 09-1
GX 09-1 R1.20 N	N	9	2.4	1.2	1.2	GX 09-1

F	F
IG	IG
70 354 ...	70 354 ...
09201	992
	996

P	●	●
M	●	○
K	●	●
N	○	○
S	●	○
H		
O	○	



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

Internal machining



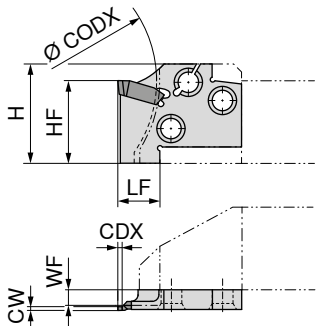
External machining



CoreLine – Radial grooving module GX16 – ModularClamp

- ▲ For circlip grooves ≤ 0.1083 inch / 2.75 mm
- ▲ For radius grooves up to ≤ 0.0472 inch / 1.2 mm
- ▲ For external recessing

Scope of supply:
Grooving module only

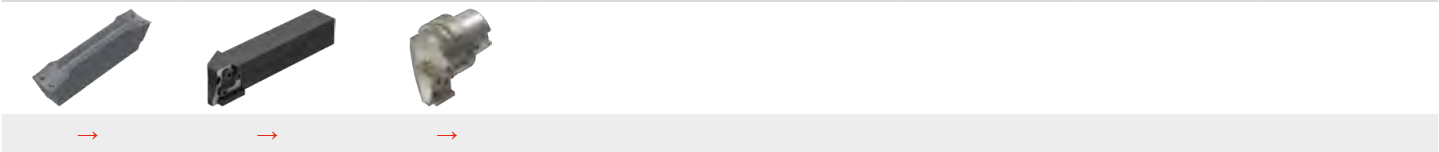


Illustrations show right-hand versions



Designation	CW mm	WF mm	LF mm	HF mm	H mm	CODX mm	CDX mm	For grooving inserts
E20 R/L 03-GX 16-2	<2,75	3.4	13	20	24	60	3	GX 16-2 ..R/L
E25 R/L 03-GX 16-2	<2,75	4.9	13	25	30	75	3	GX 16-2 ..R/L

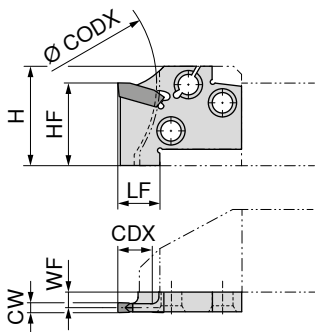
Left	Right
TO	TO
70 871 ...	70 870 ...
120	120
125	125



CoreLine – Radial grooving module GX16 – ModularClamp

- ▲ For grooving and turning
- ▲ For circlip grooves ≤ 0.2067 inch / 5.25 mm
- ▲ For radius grooves up to ≤ 0.0984 inch / 2.5 mm
- ▲ For external recessing

Scope of supply:
Grooving module only

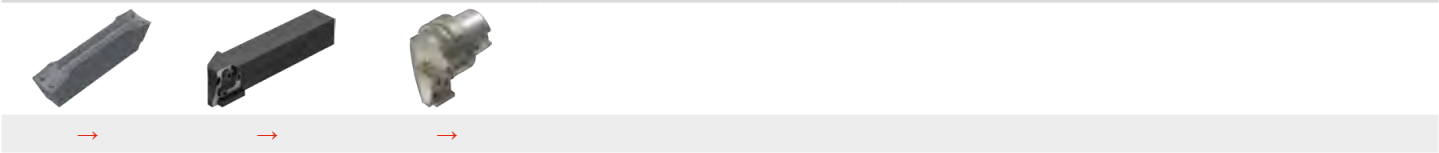


Illustrations show right-hand versions



Left Right

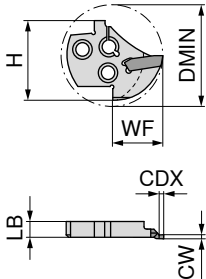
Designation	CW mm	WF mm	LF mm	HF mm	H mm	CODX mm	CDX mm	For grooving inserts	Left	Right
									TO 70 866 ...	TO 70 865 ...
E20 R/L 12-GX 16-1	2,00 - 2,75	3.75	13	20	24	60	12	GX 16-1 ..N	020	020
E20 R/L 12-GX 16-2	2,76 - 3,75	3.40	13	20	24	60	12	GX 16-2 ..N	120	120
E20 R/L 12-GX 16-3	3,76 - 5,00	2.93	13	20	24	60	12	GX 16-3 ..N	220	220
E25 R/L 12-GX 16-1	2,00 - 2,75	5.25	13	25	30	75	12	GX 16-1 ..N	025	025
E25 R/L 12-GX 16-2	2,76 - 3,75	4.90	13	25	30	75	12	GX 16-2 ..N	125	125
E25 R/L 12-GX 16-3	3,76 - 5,00	4.43	13	25	30	75	12	GX 16-3 ..N	225	225
E25 R/L 12-GX 16-4	5,01 - 6,50	3.80	13	25	30	75	12	GX 16-4 ..N	325	325



CoreLine – Radial grooving module GX16 for internal machining – ModularClamp

- ▲ For circlip grooves ≤ 0.1083 inch / 2.75 mm
- ▲ For radius grooves up to ≤ 0.0472 inch / 1.2 mm

Scope of supply:
Grooving module only



Illustrations show right-hand versions



Designation	CW mm	LB mm	WF mm	H mm	CDX mm	DMIN mm	For grooving inserts
I32 R/L 03-GX 16-2	<2,75	5.9	20.0	32.2	3	40	GX 16-2 ..R/L
I40 R/L 03-GX 16-2	<2,75	5.9	24.5	39.6	3	50	GX 16-2 ..R/L

Left	Right
TO	TO
70 886 ...	70 885 ...
032	032
040	040



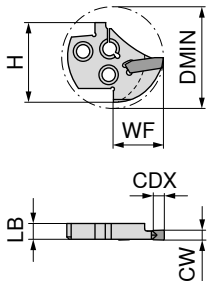
In right-hand module → insert left-hand grooving insert
In left-hand module → insert right-hand grooving insert



CoreLine – Radial grooving module GX16 for internal machining – ModularClamp

- ▲ For circlip grooves ≤ 0.2067 inch / 5.25 mm
- ▲ For radius grooves up to ≤ 0.0984 inch / 2.5 mm

Scope of supply:
Grooving module only



Illustrations show right-hand versions



Designation	CW mm	LB mm	WF mm	H mm	CDX mm	DMIN mm	For grooving inserts
I32 R/L 09-GX 16-1	2,00 - 2,75	5.9	20.0	32.2	9	40	GX 16-1 ..N
I32 R/L 09-GX 16-2	2,76 - 3,75	5.9	20.0	32.2	9	40	GX 16-2 ..N
I32 R/L 09-GX 16-3	3,76 - 5,00	5.9	20.0	32.2	9	40	GX 16-3 ..N
I32 R/L 09-GX 16-4	5,01 - 6,50	5.9	20.0	32.2	9	40	GX 16-4 ..N
I40 R/L 10-GX 16-1	2,00 - 2,75	5.9	24.5	39.6	10	50	GX 16-1 ..N
I40 R/L 10-GX 16-2	2,76 - 3,75	5.9	24.5	39.6	10	50	GX 16-2 ..N
I40 R/L 10-GX 16-3	3,76 - 5,00	5.9	24.5	39.6	10	50	GX 16-3 ..N
I40 R/L 10-GX 16-4	5,01 - 6,50	5.9	24.5	39.6	10	50	GX 16-4 ..N

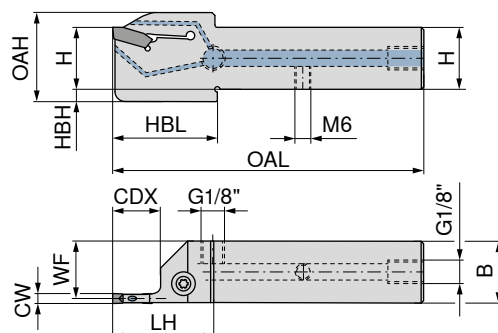
Left	Right
TO	TO
70 881 ...	70 880 ...
033	033
133	133
233	233
333	333
041	041
141	141
241	241
341	341



CoreLine – Radial Monoholder GX16-DC

Scope of supply:

Monoholder incl. Torx key and clamping screw



Illustrations show right-hand versions



Designation	H mm	B mm	CW mm	WF mm	OAH mm	OAL mm	LH mm	HBH mm	HBL mm	CDX mm	For grooving inserts
E16 R/L 0013S2-1616X-S-DC-GX16	16	16	2	15.20	25	90	35	4	36	13	GX 16-1 E2..
E16 R/L 0013S3-1616X-S-DC-GX16	16	16	3	14.85	25	90	35	4	36	13	GX 16-2 E3..
E16 R/L 0013S4-1616X-S-DC-GX16	16	16	4	14.40	25	90	35	4	36	13	GX 16-3 E4..
E16 R/L 0013S5-1616X-S-DC-GX16	16	16	5	14.00	25	90	35	4	36	13	GX 16-3 E5..
E20 R/L 0013S2-2020X-S-DC-GX16	20	20	2	19.20	25	104	35			13	GX 16-1 E2..
E20 R/L 0013S3-2020X-S-DC-GX16	20	20	3	18.85	25	104	35			13	GX 16-2 E3..
E20 R/L 0013S4-2020X-S-DC-GX16	20	20	4	18.40	25	104	35			13	GX 16-3 E4..
E20 R/L 0013S5-2020X-S-DC-GX16	20	20	5	18.00	25	104	35			13	GX 16-3 E5..
E25 R/L 0013S3-2525X-S-DC-GX16	25	25	3	23.85	30	119	35			13	GX 16-2 E3..
E25 R/L 0013S4-2525X-S-DC-GX16	25	25	4	23.40	30	119	35			13	GX 16-3 E4..
E25 R/L 0013S5-2525X-S-DC-GX16	25	25	5	23.00	30	119	35			13	GX 16-3 E5..

Left

Right

TO

TO

70 842 ...

70 842 ...

21601

21600

31601

31600

41601

41600

51601

51600

22001

22000

32001

32000

42001

42000

52001

52000

32501

32500

42501

42500

52501

52500

Spare parts

For grooving inserts

GX 16-1 E2..	T15 - IP	120	M5x18 - 15IP	865
GX 16-2 E3..	T15 - IP	120	M5x18 - 15IP	865
GX 16-3 E4..	T15 - IP	120	M5x18 - 15IP	865
GX 16-3 E5..	T15 - IP	120	M5x18 - 15IP	865



Screwdriver

AS

80 950 ...



Clamping screw

AS

70 950 ...



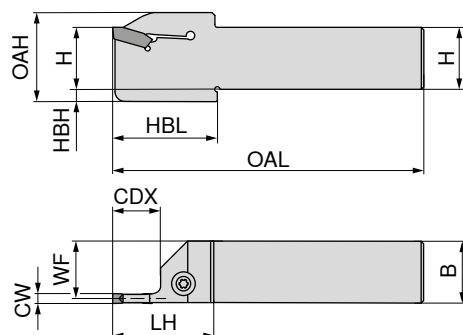
→ Adapters and accessories

→ Adapters and accessories

CoreLine – Radial Monoholder GX16

Scope of supply:

Monoholder incl. Torx key and clamping screw



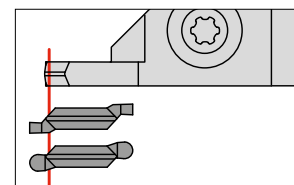
Illustrations show right-hand versions



Designation	H mm	B mm	CW mm	WF mm	OAH mm	OAL mm	LH mm	HBH mm	HBL mm	CDX mm	For grooving inserts	70 843 ...	70 843 ...
E12 R/L 0013S2-1212K-S-GX16	12	12	2	11.20	21	125	25	4	26	13	GX 16-1 E2..	21201	21200
E12 R/L 0013S3-1212K-S-GX16	12	12	3	10.85	21	125	25	4	26	13	GX 16-2 E3..	31201	31200
E16 R/L 0013S2-1616K-S-GX16	16	16	2	15.20	25	125	25	4	26	13	GX 16-1 E2..	21601	21600
E16 R/L 0013S3-1616K-S-GX16	16	16	3	14.85	25	125	25	4	26	13	GX 16-2 E3..	31601	31600
E16 R/L 0013S4-1616K-S-GX16	16	16	4	14.40	25	125	25	4	26	13	GX 16-3 E4..	41601	41600
E16 R/L 0013S5-1616K-S-GX16	16	16	5	14.00	25	125	25	4	26	13	GX 16-3 E5..	51601	51600
E20 R/L 0013S2-2020K-S-GX16	20	20	2	19.20	25	125	25			13	GX 16-1 E2..	22001	22000
E20 R/L 0013S3-2020K-S-GX16	20	20	3	18.85	25	125	25			13	GX 16-2 E3..	32001	32000
E20 R/L 0013S4-2020K-S-GX16	20	20	4	18.40	25	125	25			13	GX 16-3 E4..	42001	42000
E20 R/L 0013S5-2020K-S-GX16	20	20	5	18.00	25	125	25			13	GX 16-3 E5..	52001	52000
E25 R/L 0013S3-2525M-S-GX16	25	25	3	23.85	30	150	25			13	GX 16-2 E3..	32501	32500
E25 R/L 0013S4-2525M-S-GX16	25	25	4	23.40	30	150	25			13	GX 16-3 E4..	42501	42500
E25 R/L 0013S5-2525M-S-GX16	25	25	5	23.00	30	150	25			13	GX 16-3 E5..	52501	52500



When using "R" or "L" tools, the tool must be modified at the end face to ensure cutting clearance.



Spare parts

For grooving inserts

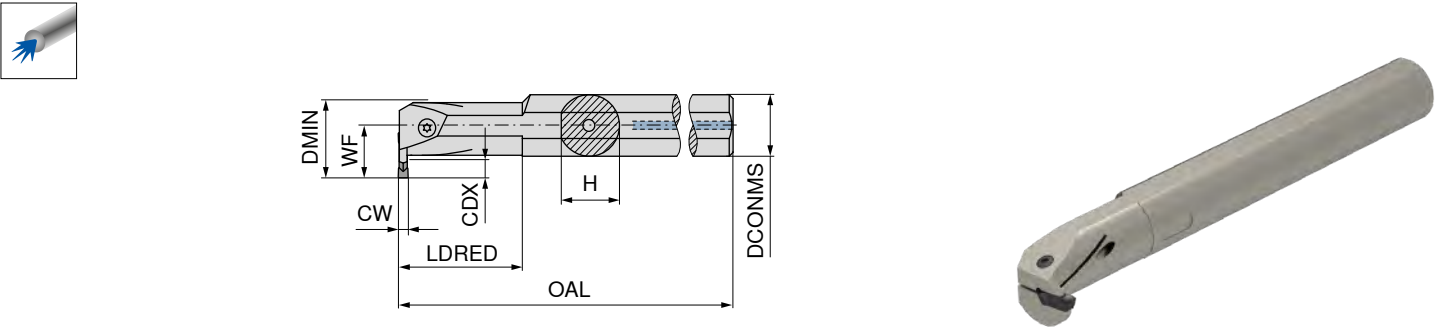
		AS 80 950 ...		AS 70 950 ...
GX 16-1 E2..	T15 - IP	120	M5x18 - 15IP	865
GX 16-2 E3..	T15 - IP	120	M5x18 - 15IP	865
GX 16-3 E4..	T15 - IP	120	M5x18 - 15IP	865
GX 16-3 E5..	T15 - IP	120	M5x18 - 15IP	865



→ Adapters and accessories

CoreLine – Radial Mono boring bars GX16

Scope of supply:
Boring bar incl. key and clamping screw

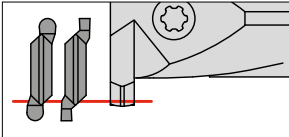


Illustrations show right-hand versions

Designation	H mm	DCONMS mm	DMIN mm	CW mm	CDX mm	WF mm	OAL mm	LDRED mm	For grooving inserts	Left	Right
										TO 70 893 ...	TO 70 892 ...
I16 R/L 90-2.0D-GX16-1	15.25	16	20.5	2,00 - 2,75	5.0	13.5	150	32	GX 16-1	516	516
I16 R/L 90-2.0D-GX16-2	15.25	16	20.5	2,76 - 3,75	5.0	13.5	150	32	GX 16-2	616	616
I20 R/L 90-2.0D-GX16-2	19.00	20	25.0	2,76 - 3,75	5.5	15.5	180	40	GX 16-2	620	620
I25 R/L 90-2.0D-GX16-2	24.00	25	32.0	2,76 - 3,75	8.0	20.5	200	50	GX 16-2	625	625
I25 R/L 90-2.0D-GX16-3	24.00	25	32.0	3,76 - 5,00	10.0	22.5	200	50	GX 16-3	725	725
I32 R/L 90-2.0D-GX16-2	31.00	32	42.0	2,76 - 3,75	11.0	27.5	250	64	GX 16-2	632	632
I32 R/L 90-2.0D-GX16-3	31.00	32	42.0	3,76 - 5,00	11.0	27.5	250	64	GX 16-3	732	732

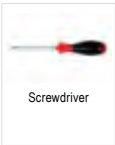
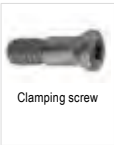
In right-hand boring bar → insert left-hand grooving insert
In left-hand boring bar → insert right-hand grooving insert

When using "R" or "L" tools, the tool must be modified at the end face to ensure cutting clearance.



Spare parts
For grooving inserts

		AS 80 950 ...	AS 70 950 ...
GX 16-1	T15	113	M4x14 403
GX 16-2	T15	113	M4x14 403
GX 16-3	T15	113	M4x14 403



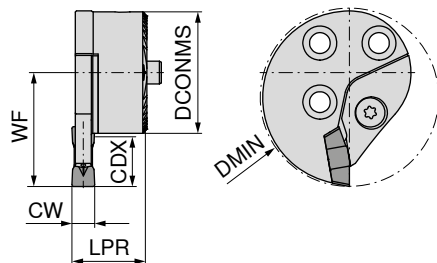
→ Adapters and accessories

CoreLine – Exchangeable grooving head GX16-DC – MaxiChange

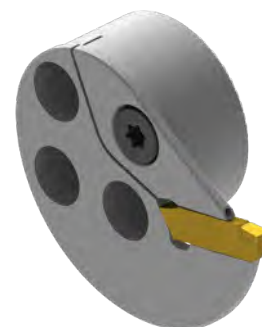
▲ For grooving and turning

Scope of supply:

Exchangeable grooving head with clamping claw and clamping screw



Illustrations show right-hand versions



Designation	DCONMS mm	CW mm	WF mm	LPR mm	DMIN mm	CDX mm	For grooving inserts	Left	Right
								TO	TO
Wk25 R/L 14-DC GX 16-S2	25	2	27	14.00	41	14	GX 16-1 ..N	84 188 ...	84 189 ...
Wk25 R/L 14-DC GX 16-S3	25	3	27	14.75	41	14	GX 16-2 ..N	22500	22500
Wk25 R/L 14-DC GX 16-S4/5	25	4/5	27	15.75	41	14	GX 16-3 ..N	32500	32500
								42500	42500
Wk32 R/L 13-DC GX 16-S4/5	32	4/5	30	17.75	47	13	GX 16-3 ..N	43200	43200
Wk32 R/L 13-DC GX 16-S6	32	6	30	19.35	47	13	GX 16-4 ..N	63200	63200

Spare parts for article number

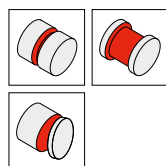
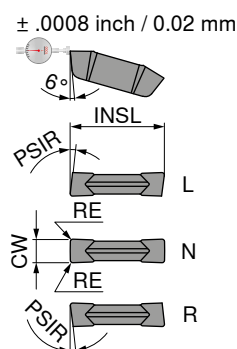
	Clamping claw	O ring	Clamping screw	Guide pin
	AS	AS	AS	AS
	84 950 ...	84 950 ...	84 950 ...	84 950 ...
84 189 22500	50400	2x1 50300	M4X4/T15 50000	D3H6X10 53000
84 188 22500	50500	2x1 50300	M4X4/T15 50000	D3H6X10 53000
84 189 32500	50600	2x1 50300	M4X4/T15 50000	D3H6X10 53000
84 188 32500	50700	2x1 50300	M4X4/T15 50000	D3H6X10 53000
84 189 42500	50800	2x1 50300	M4X4/T15 50000	D3H6X10 53000
84 188 42500	50900	2x1 50300	M4X4/T15 50000	D3H6X10 53000
84 189 43200	51000	2x1 50300	M5X5,5/T15 50100	D4H6X10 53100
84 188 43200	51100	2x1 50300	M5X5,5/T15 50100	D4H6X10 53100
84 189 63200	51200	2x1 50300	M5X5,5/T15 50100	D4H6X10 53100
84 188 63200	51300	2x1 50300	M5X5,5/T15 50100	D4H6X10 53100



→ Indexable insert turning tools

CoreLine – Carbide grooving insert – GX16

- ▲ Insert with ground periphery
- ▲ Suitable also for parting off tubes and thin-walled workpieces
- ▲ R/L angled indexable insert for pip-free parting off
- ▲ Reduce feed rate values by 20–50% with R/L version



F

NEW
IG

70 360 ...

Designation	IH	INSL mm	CW +/-0.02 mm	RE +/-0.05 mm	PSIR	For tool holder
GX 16-1 E2.00 L 6	L	16	2	0.10	6°	GX 16-1
GX 16-2 E3.00 L 6	L	16	3	0.15	6°	GX 16-2
GX 16-1 E2.00 N 0.20	N	16	2	0.20		GX 16-1
GX 16-2 E3.00 N 0.30	N	16	3	0.30		GX 16-2
GX 16-3 E4.00 N 0.40	N	16	4	0.40		GX 16-3
GX 16-3 E5.00 N 0.40	N	16	5	0.40		GX 16-3
GX 16-1 E2.00 R 6	R	16	2	0.10	6°	GX 16-1
GX 16-2 E3.00 R 6	R	16	3	0.15	6°	GX 16-2

02201
03201650
652
654
65602101
03101

P	●
M	●
K	●
N	○
S	●
H	
O	○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.
- Here you will find additional product information.



Note: Reduce feed rate value by 20–50% for R/L version.

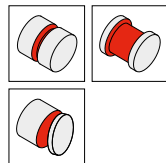
Internal machining

External machining

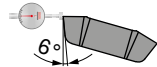
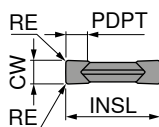
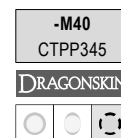


CoreLine – Carbide grooving insert – GX16

▲ Very good chip control



$\pm .0059$ inch / 0.15 mm



Designation	INSL mm	CW mm +/-0.05	RE mm +/-0.05	PDPT mm	For tool holder
GX 16-1 E2.00 N 0.20	16	2	0.2	2.3	GX 16-1
GX 16-2 E3.00 N 0.30	16	3	0.3	3.0	GX 16-2
GX 16-3 E4.00 N 0.40	16	4	0.4	3.5	GX 16-3
GX 16-3 E5.00 N 0.40	16	5	0.4	3.5	GX 16-3
GX 16-4 E6.00 N 0.50	16	6	0.5	4.0	GX 16-4

M	M	M
IG	IG	IG
70 351 ...	70 351 ...	70 351 ...
902	802	602
910	810	610
918	818	618
926	826	626
930	830	630

P	●	●	●
M	○	●	●
K	●	●	●
N	●	●	○
S	○	○	●
H	●	●	●
O	○	○	○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

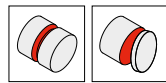
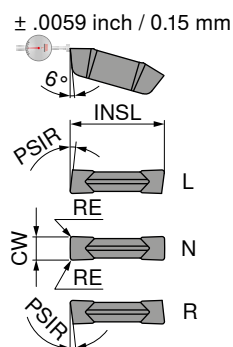
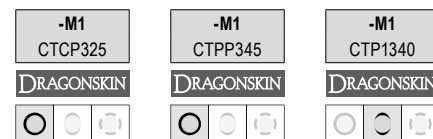
Internal machining

External machining



CoreLine – Carbide grooving insert – GX16

- ▲ Very good chip control
- ▲ R/L angled indexable insert for pip-free parting off
- ▲ Reduce feed rate values by 20–50% with R/L version



M

M

M

Designation	IH	INSL mm	CW ± 0.05 mm	RE ± 0.05 mm	PSIR	For tool holder
GX 16-1 E2.00 L 6	L	16.3	2	0.15	6°	GX 16-1
GX 16-2 E3.00 L 6	L	16.3	3	0.20	6°	GX 16-2
GX 16-1 E2.00 N 0.20	N	16.0	2	0.20		GX 16-1
GX 16-2 E3.00 N 0.20	N	16.0	3	0.20		GX 16-2
GX 16-3 E4.00 N 0.30	N	16.0	4	0.30		GX 16-3
GX 16-1 E2.00 R 6	R	16.3	2	0.15	6°	GX 16-1
GX 16-2 E3.00 R 6	R	16.3	3	0.20	6°	GX 16-2

IG	IG	NEW IG
70 362 ...	70 362 ...	70 362 ...
		02201
		03201
	800	600
902	802	602
904		604
		02101
		03101

P	●	●	●
M	○	●	●
K	●	○	●
N	○	○	○
S	○	○	●
H			
O			○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.
- Here you will find additional product information.



Note: Reduce feed rate value by 20–50% for R/L version.

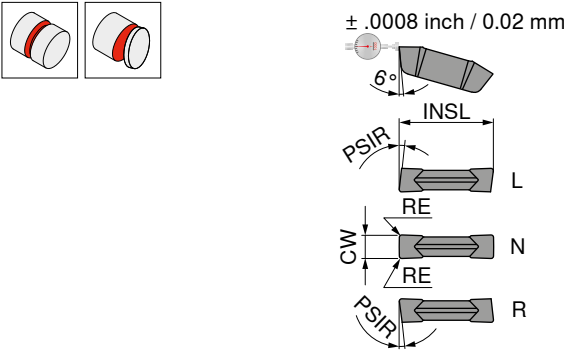
Internal machining

External machining



CoreLine – Carbide grooving insert – GX16

- ▲ R/L angled indexable insert for pip-free parting off
- ▲ Reduce feed rate values by 20–50% with R/L version



Designation	IH	INSL mm	CW +/-0.05 mm	RE +/-0.05 mm	PSIR	For tool holder
GX 16-1 E2.00 L 6	L	16.3	2	0.15	6°	GX 16-1
GX 16-2 E3.00 L 6	L	16.3	3	0.20	6°	GX 16-2
GX 16-1 E2.00 N 0.20	N	16.0	2	0.20		GX 16-1
GX 16-2 E3.00 N 0.20	N	16.0	3	0.20		GX 16-2
GX 16-1 E2.00 R 6	R	16.3	2	0.15	6°	GX 16-1
GX 16-2 E3.00 R 6	R	16.3	3	0.20	6°	GX 16-2

M

IG

70 404 ...

02201

03201

02001

03001

02101

03101

P

M

K

N

S

H

O

- 
- Find the recommended values for cutting speeds here.
 - You can find the recommended feed values here.
 - Here you will find additional product information.



Note: Reduce feed rate value by 20–50% for R/L version.

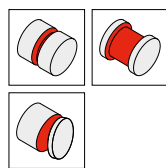
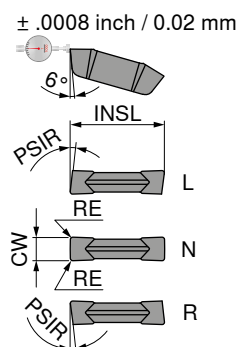
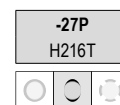
Internal machining

External machining



CoreLine – Carbide grooving insert – GX16

- ▲ Insert with highly positive cutting edge geometry and sharp cutting edge, polished chip breaker
- ▲ ground periphery
- ▲ R/L angled indexable insert for pip-free parting off
- ▲ Reduce feed rate values by 20–50% with R/L version



M

NEW
IG

70 350 ...

Designation	IH	INSL mm	CW +/-0.02 mm	RE +/-0.05 mm	PSIR	For tool holder
GX 16-1 E2.00 L 6	L	16	2	0.10	6°	GX 16-1
GX 16-2 E3.00 L 6	L	16	3	0.15	6°	GX 16-2
GX 16-1 E2.00 N 0.20	N	16	2	0.20		GX 16-1
GX 16-2 E3.00 N 0.30	N	16	3	0.30		GX 16-2
GX 16-3 E4.00 N 0.40	N	16	4	0.40		GX 16-3
GX 16-4 E6.00 N 0.50	N	16	6	0.50		GX 16-4
GX 16-1 E2.00 R 6	R	16	2	0.10	6°	GX 16-1
GX 16-2 E3.00 R 6	R	16	3	0.15	6°	GX 16-2

42201

43201

650

658

670

678

42101

43101

P	
M	
K	●
N	●
S	○
H	
O	



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.
- Here you will find additional product information.



Note: Reduce feed rate value by 20–50% for R/L version.

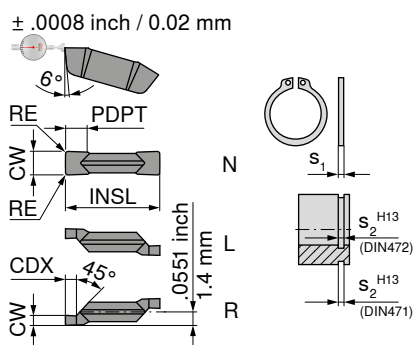
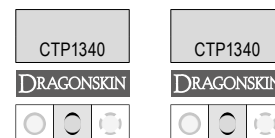
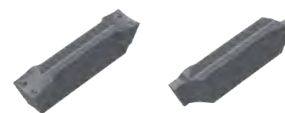
Internal machining

External machining



CoreLine – Carbide grooving insert for circlip grooves – GX16

▲ Standard geometry



Designation	IH	INSL	s ₁	s ₂	CW ± 0.02	RE ± 0.05	CDX	PDPT	For tool holder
GX 16-2 S0.60 L	L	16	0.40	0.50	0.60		0.75		R/L 03-GX 16-2
GX 16-2 S0.80 L	L	16	0.60	0.70	0.80		0.94		R/L 03-GX 16-2
GX 16-2 S0.90 L	L	16	0.70	0.80	0.90		1.04		R/L 03-GX 16-2
GX 16-2 S1.00 L	L	16	0.80	0.90	1.00		1.14		R/L 03-GX 16-2
GX 16-2 S1.20 L	L	16	1.00	1.10	1.20		1.34		R/L 03-GX 16-2
GX 16-2 S1.40 L	L	16	1.20	1.30	1.40		1.53		R/L 03-GX 16-2
GX 16-2 S1.70 L	L	16	1.50	1.60	1.70		1.82		R/L 03-GX 16-2
GX 16-2 S1.95 L	L	16	1.75	1.85	1.95		2.07		R/L 03-GX 16-2
GX 16-2 S2.25 L	L	16	2.00	2.15	2.25		2.36		R/L 03-GX 16-2
GX 16-2 S2.75 N	N	16	2.50	2.65	2.75	0.1		3.0	GX 16-2
GX 16-2 S3.25 N	N	16	3.00	3.15	3.25	0.1		3.0	GX 16-2
GX 16-3 S4.25 N	N	16	4.00	4.15	4.25	0.2		3.5	GX 16-3
GX 16-2 S0.60 R	R	16	0.40	0.50	0.60		0.75		R/L 03-GX 16-2
GX 16-2 S0.80 R	R	16	0.60	0.70	0.80		0.94		R/L 03-GX 16-2
GX 16-2 S0.90 R	R	16	0.70	0.80	0.90		1.04		R/L 03-GX 16-2
GX 16-2 S1.00 R	R	16	0.80	0.90	1.00		1.14		R/L 03-GX 16-2
GX 16-2 S1.20 R	R	16	1.00	1.10	1.20		1.34		R/L 03-GX 16-2
GX 16-2 S1.40 R	R	16	1.20	1.30	1.40		1.53		R/L 03-GX 16-2
GX 16-2 S1.70 R	R	16	1.50	1.60	1.70		1.82		R/L 03-GX 16-2
GX 16-2 S1.95 R	R	16	1.75	1.85	1.95		2.07		R/L 03-GX 16-2
GX 16-2 S2.25 R	R	16	2.00	2.15	2.25		2.36		R/L 03-GX 16-2

F	F
IG	IG
70 352 ...	70 352 ...
	607
	609
	611
	612
	614
	616
	618
	620
	622
624	
626	
628	
	695
	697
	699
	600
	602
	604
	606
	608
	610

P	●	●
M	●	●
K	●	●
N	○	○
S	●	●
H		
O	○	○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.



Attention – only applies to internal machining:

Right-hand grooving insert → left-hand module or Mono boring bar
Left-hand grooving insert → right-hand module or Mono-boring bar

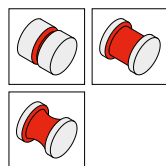
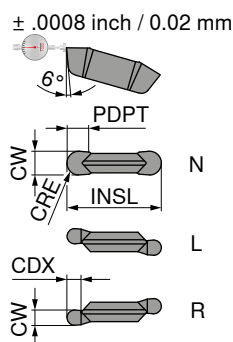
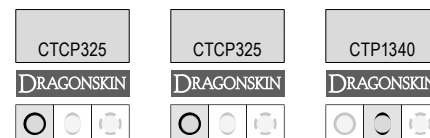
Internal machining

External machining



CoreLine – Carbide radial grooving insert – GX16

▲ Standard geometry



Designation	IH	INSL mm	CW mm	CRE mm	PDPT mm	CDX mm	For tool holder
GX 16-2 R0.80 L	L	16	1.6	0.8		1.78	R/L 03-GX 16-2
GX 16-2 R1.00 L	L	16	2.0	1.0		2.18	R/L 03-GX 16-2
GX 16-2 R1.20 L	L	16	2.4	1.2		2.58	R/L 03-GX 16-2
GX 16-2 R1.50 N	N	16	3.0	1.5	1.5		GX 16-2
GX 16-3 R2.00 N	N	16	4.0	2.0	2.0		GX 16-3
GX 16-3 R2.50 N	N	16	5.0	2.5	2.5		GX 16-3
GX 16-4 R3.00 N	N	16	6.0	3.0	3.0		GX 16-4
GX 16-2 R0.80 R	R	16	1.6	0.8		1.78	R/L 03-GX 16-2
GX 16-2 R1.00 R	R	16	2.0	1.0		2.18	R/L 03-GX 16-2
GX 16-2 R1.20 R	R	16	2.4	1.2		2.58	R/L 03-GX 16-2

F	F	F
IG	IG	IG
70 354 ...	70 354 ...	70 354 ...
912		
916		
920		
	924	624
	928	628
	932	632
	936	636
900		
904		
908		

P	●	●	●
M	○	○	●
K	●	●	●
N	○	○	○
S	○	○	●
H			
O			○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.
- Here you will find additional product information.



Attention – only applies to internal machining:

Right-hand grooving insert → left-hand module or Mono boring bar
Left-hand grooving insert → right-hand module or Mono-boring bar

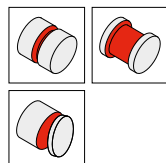
Internal machining

External machining

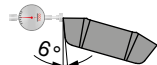
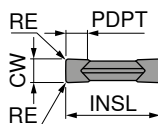
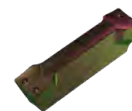


CoreLine – Carbide grooving insert – GX16

- ▲ Suitable for parting off thin-walled workpieces
- ▲ Standard geometry



± .0008 inch / 0.02 mm



Designation	INSL mm	CW mm +/-0.02	RE mm +/-0.05	PDPT mm	For tool holder
GX 16-1 E2.00 N 0.20	16	2.0	0.2	2.50	GX 16-1
GX 16-1 E2.00 N 0.20	16	2.0	0.2	2.00	GX 16-1
GX 16-1 E2.50 N 0.20	16	2.5	0.2	2.25	GX 16-1
GX 16-2 E3.00 N 0.30	16	3.0	0.3	3.00	GX 16-2
GX 16-2 E3.00 N 0.50	16	3.0	0.5	3.00	GX 16-2
GX 16-2 E3.50 N 0.30	16	3.5	0.3	3.00	GX 16-2
GX 16-3 E4.00 N 0.40	16	4.0	0.4	3.50	GX 16-3
GX 16-3 E5.00 N 0.40	16	5.0	0.4	3.50	GX 16-3
GX 16-4 E6.00 N 0.80	16	6.0	0.8	4.00	GX 16-4
GX 16-4 E6.00 N 0.50	16	6.0	0.5	4.00	GX 16-4

F

IG

70 350 ...

900

904

908

910

912

916

924

930

928

F

IG

70 350 ...

500

504

508

512

516

524

F

IG

70 350 ...

600

604

608

612

616

624

628

P	●	●	●
M	○	○	●
K	●	●	●
N			○
S	○		●
H			
O			○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

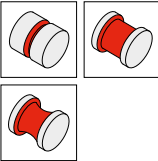
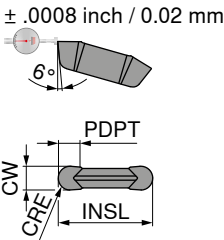
Internal machining

External machining



CoreLine – Carbide radial grooving insert – GX16

▲ Radius grooving and copy turning



-M3
CTCP335

DRAGONSKIN



M

NEW
IG

70 401 ...

51500

52000

52500

53000

Designation	INSL mm	CW mm <small>+/-0.05</small>	CRE mm	PDPT mm	For tool holder
GX 16-2 R1.50 N	16.4	3	1.5	2.22	GX 16-2
GX 16-3 R2.00 N	16.4	4	2.0	2.70	GX 16-3
GX 16-3 R2.50 N	16.4	5	2.5	3.40	GX 16-3
GX 16-4 R3.00 N	16.4	6	3.0	4.10	GX 16-4

P	●
M	○
K	●
N	
S	
H	
O	

→ Find the recommended values for cutting speeds here.

→ You can find the recommended feed values here.

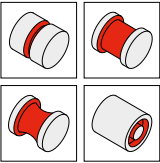
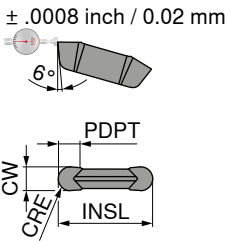
Internal machining

External machining



CoreLine – Carbide radial grooving insert – GX16

- ▲ Insert with highly positive cutting edge geometry and sharp cutting edge, polished chip breaker
- ▲ ground periphery



-27P
H216T



F

IG

70 354 ...

674

678

682

Designation	INSL mm	CW mm +/-0.02	CRE mm	PDPT mm	For tool holder
GX 16-2 R1.50 N	16	3	1.5	1.5	GX 16-2
GX 16-3 R2.00 N	16	4	2.0	2.0	GX 16-3
GX 16-3 R2.50 N	16	5	2.5	2.5	GX 16-3

P	
M	
K	●
N	●
S	○
H	
O	○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

Internal machining



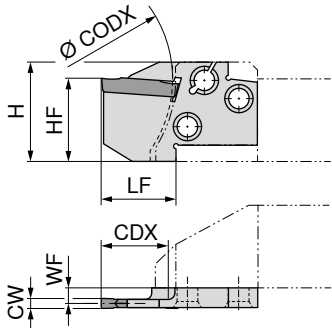
External machining



CoreLine – Radial grooving module GX24 – ModularClamp

- ▲ For deep radial grooving and parting off
- ▲ For turning

Scope of supply:
Grooving module only

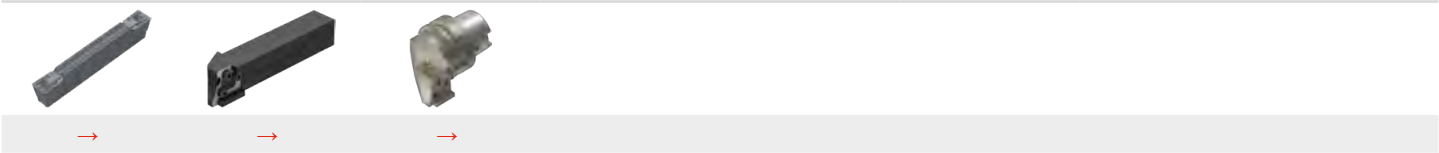


Illustrations show right-hand versions



Designation	CW mm	WF mm	LF mm	HF mm	H mm	CODX mm	CDX mm	For grooving inserts
E20 R/L 21-GX 24-1	2,00 - 2,75	3.60	22	20	24	60	21	GX 24-1
E20 R/L 21-GX 24-2	3	3.40	22	20	24	60	21	GX 24-2
E20 R/L 21-GX 24-3	4/5	2.93	22	20	24	60	21	GX 24-3
E25 R/L 21-GX 24-1	2,00 - 2,75	5.10	22	25	30	75	21	GX 24-1
E25 R/L 21-GX 24-2	3	4.90	22	25	30	75	21	GX 24-2
E25 R/L 21-GX 24-3	4/5	4.43	22	25	30	75	21	GX 24-3
E25 R/L 21-GX 24-4	6	3.80	22	25	30	75	21	GX 24-4
E25 R/L 21-GX 24-5	8	2.95	23	25	30	75	21	GX 24-5

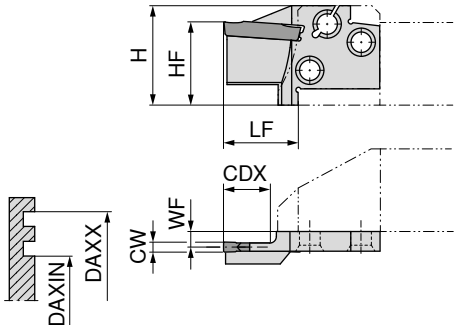
Left	Right
TO	TO
70 868 ...	70 867 ...
020	020
120	120
22000	22000
025	025
125	125
225	225
325	325
425	425



CoreLine – Axial grooving module GX24 short – ModularClamp

- ▲ For axial grooving
- ▲ For face turning

Scope of supply:
Grooving module only



Illustrations show right-hand versions



Designation	DAXIN mm	DAXX mm	CW mm	WF mm	LF mm	HF mm	H mm	CDX mm	For grooving inserts
E20 R/L 14-GX 24-2 A	44	70	3	3.40	22	20	24	14	GX 24-2
E20 R/L 14-GX 24-2 A	64	100	3	3.40	22	20	24	14	GX 24-2
E20 R/L 14-GX 24-2 A	94	150	3	3.40	22	20	24	14	GX 24-2
E25 R/L 15-GX 24-2 A	44	70	3	4.90	22	25	30	15	GX 24-2
E25 R/L 15-GX 24-2 A	64	100	3	4.90	22	25	30	15	GX 24-2
E25 R/L 15-GX 24-2 A	94	150	3	4.90	22	25	30	15	GX 24-2
E25 R/L 15-GX 24-3 A	42	70	4/5	4.43	22	25	30	15	GX 24-3
E25 R/L 15-GX 24-3 A	62	100	4/5	4.43	22	25	30	15	GX 24-3
E25 R/L 15-GX 24-3 A	92	150	4/5	4.43	22	25	30	15	GX 24-3
E25 R/L 15-GX 24-3 A	142	300	4/5	4.43	22	25	30	15	GX 24-3
E25 R/L 15-GX 24-4 A	38	70	6	3.80	22	25	30	15	GX 24-4
E25 R/L 15-GX 24-4 A	58	100	6	3.80	22	25	30	15	GX 24-4
E25 R/L 15-GX 24-4 A	88	150	6	3.80	22	25	30	15	GX 24-4
E25 R/L 15-GX 24-4 A	138	300	6	3.80	22	25	30	15	GX 24-4

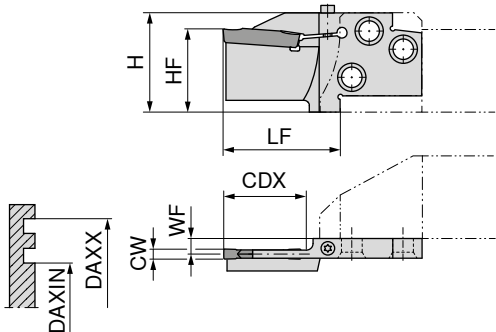
Left	Right
TO	TO
70 891 ...	70 890 ...
100	100
102	102
104	104
200	200
202	202
204	204
206	206
208	208
210	210
212	212
214	214
216	216
218	218
220	220



CoreLine – Axial grooving module GX24 long – ModularClamp

- ▲ For axial grooving
- ▲ For face turning

Scope of supply:
Grooving module only



Illustrations show right-hand versions

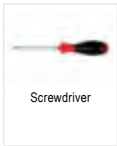


Designation	DAXIN mm	DAXX mm	CW mm	WF mm	LF mm	HF mm	H mm	CDX mm	For grooving inserts	Left	Right
										TO 70 895 ...	TO 70 894 ...
E25 R/L 21-GX 24-3 AS	42	70	4/5	4.53	35	25	30	21	GX 24-3	200	200
E25 R/L 21-GX 24-3 AS	62	100	4/5	4.53	35	25	30	21	GX 24-3	202	202
E25 R/L 21-GX 24-3 AS	92	150	4/5	4.53	35	25	30	21	GX 24-3	204	204
E25 R/L 21-GX 24-3 AS	142	300	4/5	4.53	35	25	30	21	GX 24-3	206	206
E25 R/L 25-GX 24-4 AS	38	70	6	3.90	35	25	30	25	GX 24-4	210	210
E25 R/L 25-GX 24-4 AS	58	100	6	3.90	35	25	30	25	GX 24-4	212	212
E25 R/L 25-GX 24-4 AS	88	150	6	3.90	35	25	30	25	GX 24-4	214	214
E25 R/L 25-GX 24-4 AS	138	300	6	3.90	35	25	30	25	GX 24-4	216	216

 Axial modules version "GX 24 long" can be clamped on both sides (Contra version). This means that GX 24 axial modules can be used on both a right-hand and a left-hand ModularClamp base holder.

Spare parts
For grooving inserts

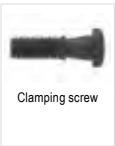
GX 24-3	T15	113	M3,5x14	160
GX 24-4	T15	113	M3,5x14	160



Screwdriver

AS

80 950 ...



Clamping screw

AS

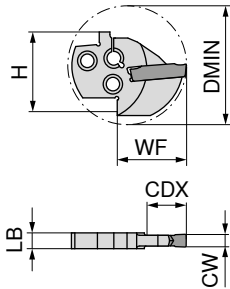
70 950 ...



CoreLine – Radial grooving module GX24 for internal machining – ModularClamp

▲ For grooving and turning

Scope of supply:
Grooving module only



Neutral

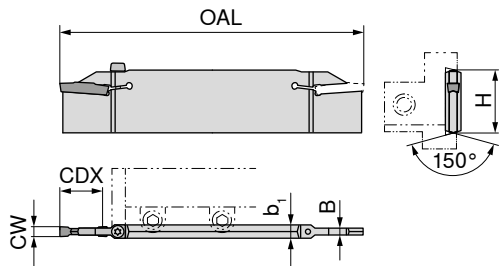
Designation	CW mm	LB mm	WF mm	H mm	CDX mm	DMIN mm	For grooving inserts
I40 N 19-GX 24-2	2,76 - 3,75	6.2	33.5	40.7	19	60	GX 24-2 ..N
I40 N 19-GX 24-3	3,76 - 5,00	6.2	33.5	40.7	19	60	GX 24-3 ..N
I40 N 19-GX 24-4	5,01 - 6,50	6.2	33.5	40.7	19	60	GX 24-4 ..N

TO
70 880 ...
340
440
540



CoreLine – Radial blade GX24

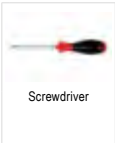
Scope of supply:
Blade incl. key and clamping screw



Designation	CW mm	H mm	B mm	b ₁ mm	OAL mm	CDX mm	For grooving inserts	TO 70 834 ...
XLCF N 3203-GX24-1S	2	32	1.05	6.2	180	21	GX 24-1	102
XLCF N 3203-GX24-2S	3	32	2.10	6.2	180	21	GX 24-2	103
XLCF N 3204-GX24-3S	4/5	32	3.05	6.2	180	21	GX 24-3	104
XLCF N 3206-GX24-4S	6	32	4.20	6.2	180	21	GX 24-4	106

Spare parts
For grooving inserts

GX 24-1	T15	80 950 ... 113	M3,5x14	70 950 ... 160
GX 24-2	T15	113	M3,5x14	160
GX 24-3	T15	113	M3,5x14	160
GX 24-4	T15	113	M3,5x14	160



Screwdriver

AS



Clamping screw

AS

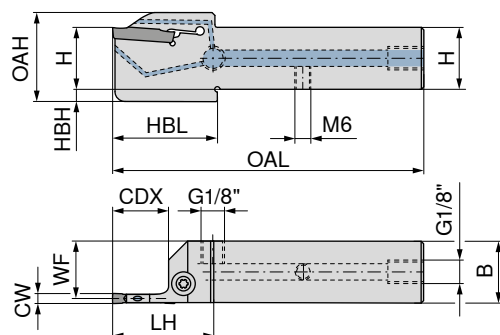


→ Adapters and accessories

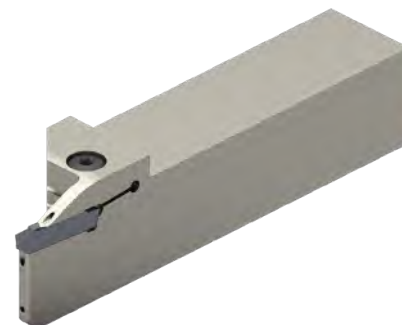
CoreLine – Radial Monoholder GX24-DC

Scope of supply:

Monoholder incl. key and clamping screw



Illustrations show right-hand versions



Designation	H mm	B mm	CW mm	WF mm	OAH mm	OAL mm	LH mm	HBH mm	HBL mm	CDX mm	For grooving inserts	Left TO	Right TO
												70 844 ...	70 844 ...
E16 R/L 0021S2-1616X-S-DC-GX24	16	16	2	15.2	26	94	39	4	40	21	GX 24-1 E2..	21601	21600
E16 R/L 0021S3-1616X-S-DC-GX24	16	16	3	14.8	26	94	39	4	40	21	GX 24-2 E3..	31601	31600
E20 R/L 0021S2-2020X-S-DC-GX24	20	20	2	19.2	26	109	40			21	GX 24-1 E2..	22001	22000
E20 R/L 0021S3-2020X-S-DC-GX24	20	20	3	18.8	26	109	40			21	GX 24-2 E3..	32001	32000
E20 R/L 0021S4-2020X-S-DC-GX24	20	20	4	18.3	26	109	40			21	GX 24-3 E4..	42001	42000
E20 R/L 0021S5-2020X-S-DC-GX24	20	20	5	18.0	26	109	40			21	GX 24-3 E5..	52001	52000
E25 R/L 0021S3-2525X-S-DC-GX24	25	25	3	23.8	31	124	40			21	GX 24-2 E3..	32501	32500
E25 R/L 0021S4-2525X-S-DC-GX24	25	25	4	23.3	31	124	40			21	GX 24-3 E4..	42501	42500
E25 R/L 0021S5-2525X-S-DC-GX24	25	25	5	23.0	31	124	40			21	GX 24-3 E5..	52501	52500
E25 R/L 0021S6-2525X-S-DC-GX24	25	25	6	22.5	31	124	40			21	GX 24-4 E6..	62501	62500

Spare parts

For grooving inserts

GX 24-1 E2..	T15 - IP	120	M5x18 - 15IP	865
GX 24-2 E3..	T15 - IP	120	M5x18 - 15IP	865
GX 24-3 E4..	T15 - IP	120	M5x18 - 15IP	865
GX 24-3 E5..	T15 - IP	120	M5x18 - 15IP	865
GX 24-4 E6..	T15 - IP	120	M5x18 - 15IP	865



Screwdriver

AS

80 950 ...



Clamping screw

AS

70 950 ...

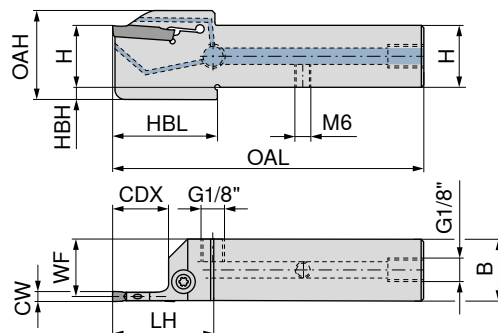
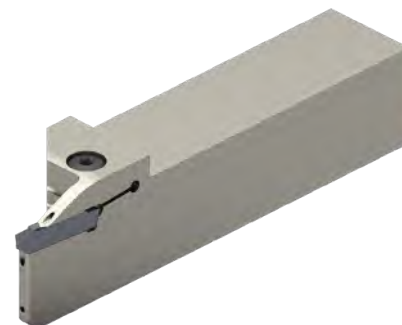


→ Adapters and accessories

CoreLine – Radial Monoholder GX24-DC

Scope of supply:

Monoholder incl. key and clamping screw

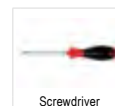


Designation	H inch	B inch	CW inch	WF inch	OAH inch	OAL inch	LH inch	HBH inch	HBL inch	CDX inch	For grooving inserts	Left TO	Right TO
												78 844 ...	78 844 ...
E16 R/L 0021S2-10X-S-DC-GX24-E-1	0.625	0.625	0.079	0.594	1.024	3.701	1.535	0.157	1.575	0.827	GX 24-1 E2..	26301	26300
E16 R/L 0021S3-10X-S-DC-GX24-E-2	0.625	0.625	0.118	0.578	1.024	3.701	1.535	0.157	1.575	0.827	GX 24-2 E3..	36301	36300
E20 R/L 0021S2-12X-S-DC-GX24-E-1	0.750	0.750	0.079	0.719	0.984	4.291	1.575			0.827	GX 24-1 E2..	27501	27500
E20 R/L 0021S3-12X-S-DC-GX24-E-2	0.750	0.750	0.118	0.703	0.984	4.291	1.575			0.827	GX 24-2 E3..	37501	37500
E20 R/L 0021S4-12X-S-DC-GX24-E-3	0.750	0.750	0.157	0.683	0.984	4.291	1.575			0.827	GX 24-3 E4..	47501	47500
E20 R/L 0021S5-12X-S-DC-GX24-E-3	0.750	0.750	0.197	0.671	0.984	4.291	1.575			0.827	GX 24-3 E5..	57501	57500
E25 R/L 0021S3-16X-S-DC-GX24-E-2	1.000	1.000	0.118	0.953	1.220	4.882	1.575			0.827	GX 24-2 E3..	30001	30000
E25 R/L 0021S4-16X-S-DC-GX24-E-3	1.000	1.000	0.157	0.933	1.220	4.882	1.575			0.827	GX 24-3 E4..	40001	40000
E25 R/L 0021S5-16X-S-DC-GX24-E-3	1.000	1.000	0.197	0.921	1.220	4.882	1.575			0.827	GX 24-3 E5..	50001	50000
E25 R/L 0021S6-16X-S-DC-GX24-E-4	1.000	1.000	0.236	0.902	1.220	4.882	1.575			0.827	GX 24-4 E6..	60001	60000

Spare parts

for article number

Part number	Part description	Part number	Part description	Part number	Part description
78 844 26300 / 78 844 26301	T15 - IP	120	M5x18 - 15IP	865	
78 844 36300 / 78 844 36301	T15 - IP	120	M5x18 - 15IP	865	
78 844 27500 / 78 844 27501	T15 - IP	120	M5x18 - 15IP	865	
78 844 37500 / 78 844 37501	T15 - IP	120	M5x18 - 15IP	865	
78 844 47500 / 78 844 47501	T15 - IP	120	M5x18 - 15IP	865	
78 844 57500 / 78 844 57501	T15 - IP	120	M5x18 - 15IP	865	
78 844 30000 / 78 844 30001	T15 - IP	120	M5x18 - 15IP	865	
78 844 40000 / 78 844 40001	T15 - IP	120	M5x18 - 15IP	865	
78 844 50000 / 78 844 50001	T15 - IP	120	M5x18 - 15IP	865	
78 844 60000 / 78 844 60001	T15 - IP	120	M5x18 - 15IP	865	



Screwdriver

AS

80 950 ...



Clamping screw

AS

70 950 ...

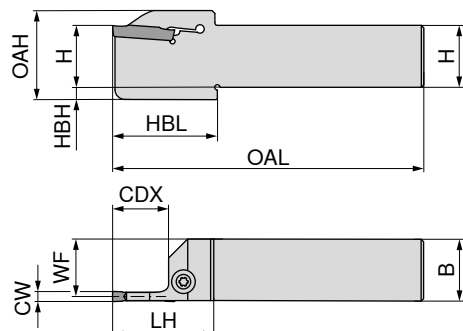


→ Adapters and accessories

CoreLine – Radial Monoholder GX24

Scope of supply:

Monoholder incl. key and clamping screw



Illustrations show right-hand versions

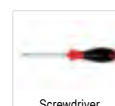


Designation	H mm	B mm	CW mm	WF mm	OAH mm	OAL mm	LH mm	HBH mm	HBL mm	CDX mm	For grooving inserts	Left	Right
												TO 70 845 ...	TO 70 845 ...
E16 R/L 0021S2-1616K-S-GX24	16	16	2	15.2	26	125	39	4	40	21	GX 24-1 E2..	21601	21600
E16 R/L 0021S3-1616K-S-GX24	16	16	3	14.8	26	125	39	4	40	21	GX 24-2 E3..	31601	31600
E20 R/L 0021S2-2020K-S-GX24	20	20	2	19.2	26	125	40			21	GX 24-1 E2..	22001	22000
E20 R/L 0021S3-2020K-S-GX24	20	20	3	18.8	26	125	40			21	GX 24-2 E3..	32001	32000
E20 R/L 0021S4-2020K-S-GX24	20	20	4	18.3	26	125	40			21	GX 24-3 E4..	42001	42000
E20 R/L 0021S5-2020K-S-GX24	20	20	5	18.0	26	125	40			21	GX 24-3 E5..	52001	52000
E25 R/L 0021S3-2525M-S-GX24	25	25	3	23.8	31	150	40			21	GX 24-2 E3..	32501	32500
E25 R/L 0021S4-2525M-S-GX24	25	25	4	23.3	31	150	40			21	GX 24-3 E4..	42501	42500
E25 R/L 0021S5-2525M-S-GX24	25	25	5	23.0	31	150	40			21	GX 24-3 E5..	52501	52500
E25 R/L 0021S6-2525M-S-GX24	25	25	6	22.5	31	150	40			21	GX 24-4 E6..	62501	62500

Spare parts

for article number

70 845 21600 / 70 845 21601	T15 - IP	120	M5x18 - 15IP	865
70 845 31600 / 70 845 31601	T15 - IP	120	M5x18 - 15IP	865
70 845 22000 / 70 845 22001	T15 - IP	120	M5x18 - 15IP	865
70 845 32000 / 70 845 32001	T15 - IP	120	M5x18 - 15IP	865
70 845 42000 / 70 845 42001	T15 - IP	120	M5x18 - 15IP	865
70 845 52000 / 70 845 52001	T15 - IP	120	M5x18 - 15IP	865
70 845 32500 / 70 845 32501	T15 - IP	120	M5x18 - 15IP	865
70 845 42500 / 70 845 42501	T15 - IP	120	M5x18 - 15IP	865
70 845 52500 / 70 845 52501	T15 - IP	120	M5x18 - 15IP	865
70 845 62500 / 70 845 62501	T15 - IP	120	M5x18 - 15IP	865



Screwdriver

AS

80 950 ...



Clamping screw

AS

70 950 ...

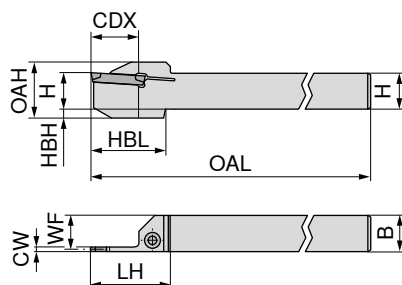


→ Adapters and accessories

CoreLine – Radial Monoholder GX24

Scope of supply:

Monoholder incl. key and clamping screw



Illustrations show right-hand versions

Designation	H inch	B inch	CW inch	WF inch	OAH inch	OAL inch	LH inch	HBH inch	HBL inch	CDX inch	For grooving inserts	Left	Right
												TO 78 863 ...	TO 78 862 ...
E 16 R/L 0021-10C-GX24-2-E	0.625	0.625	0.109 - 0.148	0.586	0.984	5.000	1.378	0.162	1.260	0.827	GX 24-2	26300 ¹⁾	26300 ¹⁾
E 20 R/L 0021-12C-GX24-2-E	0.750	0.750	0.109 - 0.148	0.711	0.947	5.000	1.378			0.827	GX 24-2	27500	27500
E 20 R/L 0021-12C-GX24-3-E	0.750	0.750	0.148 - 0.197	0.692	0.947	5.000	1.378			0.827	GX 24-3	37500 ¹⁾	37500 ¹⁾
E 25 R/L 0021-16D-GX24-2-E	1.000	1.000	0.109 - 0.148	0.961	1.197	6.000	1.378			0.827	GX 24-2	20000	20000
E 25 R/L 0021-16D-GX24-3-E	1.000	1.000	0.148 - 0.197	0.942	1.197	6.000	1.378			0.827	GX 24-3	30000 ¹⁾	30000
E 25 R/L 0021-16D-GX24-4-E	1.000	1.000	0.197 - 0.256	0.917	1.197	6.000	1.378			0.827	GX 24-4	40000 ¹⁾	40000
E 32 R/L 0021-85D-GX24-2-E	1.250	1.000	0.109 - 0.148	0.961	1.447	6.000	1.378			0.827	GX 24-2	22500 ¹⁾	22500 ¹⁾
E 32 R/L 0021-85D-GX24-3-E	1.250	1.000	0.148 - 0.197	0.942	1.447	6.000	1.378			0.827	GX 24-3	32500 ¹⁾	32500 ¹⁾
E 32 R/L 0021-85D-GX24-4-E	1.250	1.000	0.197 - 0.256	0.917	1.447	6.000	1.378			0.827	GX 24-4	42500 ¹⁾	42500 ¹⁾

1) Not in stock

Spare parts

For grooving inserts

GX 24-2	T20	114	M4x18	204
GX 24-3	T20	114	M4x18	204
GX 24-4	T20	114	M4x18	204



Screwdriver

AS

80 950 ...



Clamping screw

AS

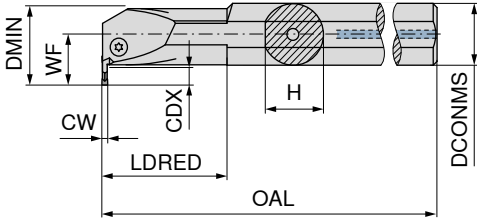
70 950 ...



→ Adapters and accessories

CoreLine – Radial Mono boring bars GX24

Scope of supply:
Boring bar incl. key and clamping screw

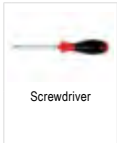


Illustrations show right-hand versions

Designation	H mm	DCONMS mm	DMIN mm	CW mm	CDX mm	WF mm	OAL mm	LDRED mm	For grooving inserts	Left	Right
										TO 70 895 ...	TO 70 894 ...
I32 R/L 90-2.0D-GX24-2	31.0	32	42	2,76 - 3,75	11	27.5	250	64	GX 24-2	132	132
I32 R/L 90-2.0D-GX24-3	31.0	32	42	3,76 - 5,00	11	27.5	250	64	GX 24-3	232	232
I40 R/L 90-2.0D-GX24-3	38.5	40	53	3,76 - 5,00	12	32.5	300	80	GX 24-3	240	240

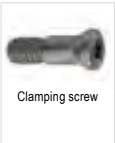
Spare parts
For grooving inserts

GX 24-2	T20	80 950 ... 114	M5x18	70 950 ... 404
GX 24-3	T20	114	M5x18	404



Screwdriver

AS



Clamping screw

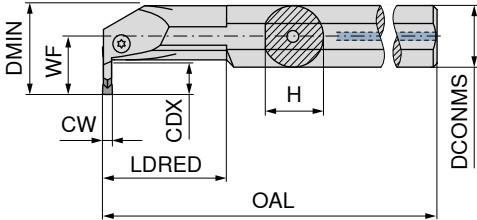
AS



→ Adapters and accessories

CoreLine – Radial Mono boring bars GX24

Scope of supply:
Boring bar incl. key and clamping screw



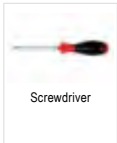
Illustrations show right-hand versions

Designation	H mm	DCONMS mm	DMIN mm	CW mm	CDX mm	WF mm	OAL mm	LDRED mm	For grooving inserts
I32 R/L 90-2.0D-GX24-4	31.0	32	47	5,01 - 6,50	17.5	30.4	250	64	GX 24-4
I40 R/L 90-2.0D-GX24-4	38.5	40	57	5,01 - 6,50	17.5	34.4	300	80	GX 24-4

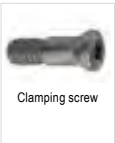
Left	Right
TO	TO
70 895 ...	70 894 ...
332	332
340	340

Spare parts
For grooving inserts

GX 24-4	T20	114	M5x18	404
---------	-----	-----	-------	-----



Screwdriver



Clamping screw

AS
80 950 ...
114

AS
70 950 ...
404



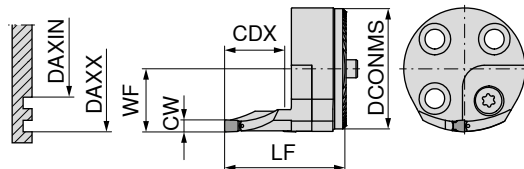
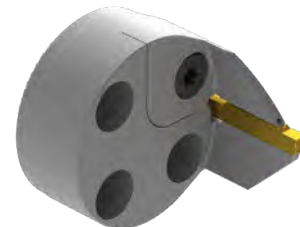
→ Adapters and accessories

CoreLine – Axial exchangeable grooving head GX24-DC – MaxiChange

▲ For axial grooving

Scope of supply:

Exchangeable grooving head with clamping claw and clamping screw



Illustrations show right-hand versions

Designation	DCONMS mm	DAXIN mm	DAXX mm	CW mm	WF mm	LF mm	CDX mm	For grooving inserts	Left TO	Right TO
									84 186 ...	84 187 ...
WK40 R/L 20-DC GX 24-S3 D50-70	40	50	70	3	21	40	20	GX 24-2 ..N	34000	34000
WK40 R/L 20-DC GX 24-S3 D70-100	40	70	100	3	21	40	20	GX 24-2 ..N	34100	34100
WK40 R/L 20-DC GX 24-S3 D100-150	40	100	150	3	21	40	20	GX 24-2 ..N	34200	34200
WK40 R/L 20-DC GX 24-S3 D150-300	40	150	300	3	21	40	20	GX 24-2 ..N	34300	34300
WK40 R/L 20-DC GX 24-S4 D50-70	40	50	70	4	21	40	20	GX 24-3 ..N	44000	44000
WK40 R/L 20-DC GX 24-S4 D70-100	40	70	100	4	21	40	20	GX 24-3 ..N	44100	44100
WK40 R/L 20-DC GX 24-S4 D100-150	40	100	150	4	21	40	20	GX 24-3 ..N	44200	44200
WK40 R/L 20-DC GX 24-S4 D150-300	40	150	300	4	21	40	20	GX 24-3 ..N	44300	44300

Spare parts for article number

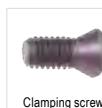
	AS 84 950 ...		AS 84 950 ...		AS 84 950 ...		AS 84 950 ...
84 187 34000	51400	2x1	50300	M6x0,5X5/T25	50200	D4H6X12	53200
84 186 34000	51800	2x1	50300	M6x0,5X5/T25	50200	D4H6X12	53200
84 187 34100	51500	2x1	50300	M6x0,5X5/T25	50200	D4H6X12	53200
84 186 34100	51900	2x1	50300	M6x0,5X5/T25	50200	D4H6X12	53200
84 187 34200	51600	2x1	50300	M6x0,5X5/T25	50200	D4H6X12	53200
84 186 34200	52000	2x1	50300	M6x0,5X5/T25	50200	D4H6X12	53200
84 187 34300	51700	2x1	50300	M6x0,5X5/T25	50200	D4H6X12	53200
84 186 34300	52100	2x1	50300	M6x0,5X5/T25	50200	D4H6X12	53200
84 187 44000	52200	2x1	50300	M6x0,5X5/T25	50200	D4H6X12	53200
84 186 44000	52600	2x1	50300	M6x0,5X5/T25	50200	D4H6X12	53200
84 187 44100	52300	2x1	50300	M6x0,5X5/T25	50200	D4H6X12	53200
84 186 44100	52700	2x1	50300	M6x0,5X5/T25	50200	D4H6X12	53200
84 187 44200	52400	2x1	50300	M6x0,5X5/T25	50200	D4H6X12	53200
84 186 44200	52800	2x1	50300	M6x0,5X5/T25	50200	D4H6X12	53200
84 187 44300	52500	2x1	50300	M6x0,5X5/T25	50200	D4H6X12	53200
84 186 44300	52900	2x1	50300	M6x0,5X5/T25	50200	D4H6X12	53200



Clamping claw



O ring



Clamping screw



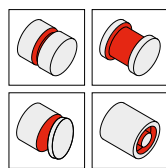
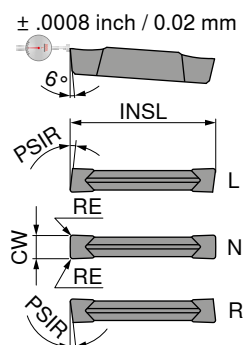
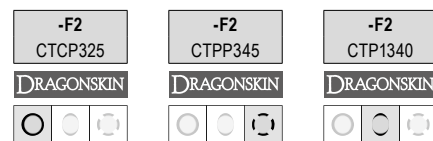
Guide pin



→ Indexable insert turning tools

CoreLine – Carbide grooving insert – GX24

- ▲ Insert with ground periphery
- ▲ Suitable also for parting off tubes and thin-walled workpieces
- ▲ R/L angled indexable insert for pip-free parting off
- ▲ Reduce feed rate values by 20–50% with R/L version



Designation	IH	INSL mm	CW ± 0.02 mm	RE ± 0.05 mm	PSIR	For tool holder
GX 24-2 E3.00 L 6	L	24	3.0	0.15	6°	GX 24-2
GX 24-2 E3.00 N 0.30	N	24	3.0	0.30		GX 24-2
GX 24-2 E3.50 N 0.30	N	24	3.5	0.30		GX 24-2
GX 24-3 E4.00 N 0.40	N	24	4.0	0.40		GX 24-3
GX 24-3 E5.00 N 0.40	N	24	5.0	0.40		GX 24-3
GX 24-4 E6.00 N 0.50	N	24	6.0	0.50		GX 24-4
GX 24-2 E3.00 R 6	R	24	3.0	0.15	6°	GX 24-2

F	F	F
IG	IG	IG
70 350 ...	70 350 ...	70 350 ...
		03201
962	862	662
	864	
966	866	666
970	870	671
	872	672
		03101

P	●	●	●
M	○	●	●
K	●	●	●
N			○
S	○	○	●
H			
O			○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.
- Here you will find additional product information.



Note: Reduce feed rate value by 20–50% for R/L version.

Internal machining

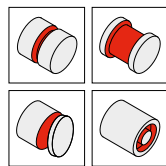
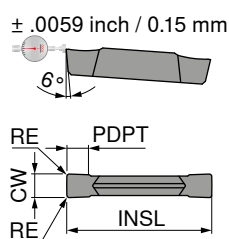


External machining



CoreLine – Carbide grooving insert – GX24

- ▲ Universal application
- ▲ First choice for axial grooving



Designation	INSL mm	CW mm +/-0.05	RE mm +/-0.05	PDPT mm	For tool holder	F IG	F IG	F IG	F IG
GX 24-2 E3.00 N 0.30	24	3	0.3	2.5	GX 24-2	70 350 ... 932	70 350 ... 532	70 350 ... 832	70 350 ... 632
GX 24-3 E4.00 N 0.40	24	4	0.4	3.0	GX 24-3	936	536	836	636
GX 24-3 E5.00 N 0.40	24	5	0.4	3.0	GX 24-3	940	540	840	640
GX 24-4 E6.00 N 0.50	24	6	0.5	3.5	GX 24-4	944	544	844	644
P						●	●	●	●
M						○	○	●	●
K						●	●		●
N									○
S						○		○	●
H									
O									○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

Internal machining

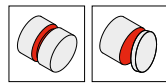
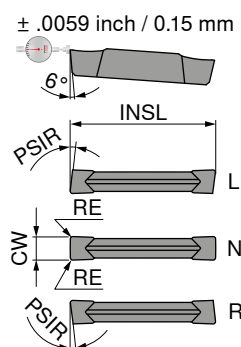
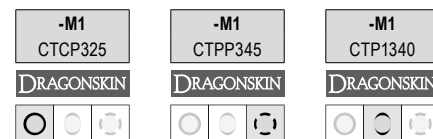


External machining



CoreLine – Carbide grooving insert – GX24

- ▲ Very good chip control
- ▲ R/L angled indexable insert for pip-free parting off
- ▲ Reduce feed rate values by 20–50% with R/L version



M

M

M

Designation	IH	INSL mm	CW ± 0.05 mm	RE ± 0.05 mm	PSIR	For tool holder
GX 24-2 E3.00 L 6	L	24.4	3	0.2	6°	GX 24-2
GX 24-3 E4.00 L 6	L	24.4	4	0.2	6°	GX 24-3
GX 24-1 E2.00 N 0.20	N	24.0	2	0.2		GX 24-1
GX 24-2 E3.00 N 0.20	N	24.0	3	0.2		GX 24-2
GX 24-3 E4.00 N 0.30	N	24.0	4	0.3		GX 24-3
GX 24-2 E3.00 R 6	R	24.4	3	0.2	6°	GX 24-2
GX 24-3 E4.00 R 6	R	24.4	4	0.2	6°	GX 24-3

IG	IG	NEW IG
70 363 ...	70 363 ...	70 363 ...
		03201
		04201
900	800	600
902	802	602
904	804	604
		03101
		04101

P	●	●	●
M	○	●	●
K	●	○	●
N	○	○	○
S	○	○	●
H			
O			○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.
- Here you will find additional product information.



Note: Reduce feed rate value by 20–50% for R/L version.

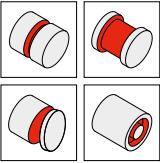
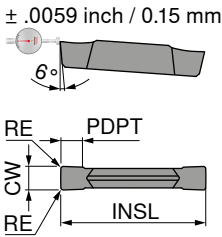
Internal machining

External machining



CoreLine – Carbide grooving insert – GX24

▲ Very good chip control



-M40 CTCP325	-M40 CTPP345	-M40 CTP1340
DRAGONSKIN	DRAGONSKIN	DRAGONSKIN



Designation	INSL mm	CW mm +/-0.05	RE mm +/-0.05	PDPT mm	For tool holder
GX 24-2 E3.00 N 0.30	24	3	0.3	3.5	GX 24-2
GX 24-3 E4.00 N 0.40	24	4	0.4	4.0	GX 24-3
GX 24-3 E5.00 N 0.40	24	5	0.4	4.0	GX 24-3
GX 24-4 E6.00 N 0.50	24	6	0.5	4.0	GX 24-4

M	M	M
IG	IG	IG
70 364 ...	70 364 ...	70 364 ...
900	800	600
902	802	602
904	804	604
906	806	606

P	●	●	●
M	○	●	●
K	●	○	●
N	○	○	○
S	○	○	●
H	○	○	○
O	○	○	○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

Internal machining

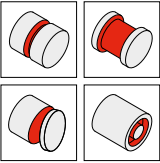
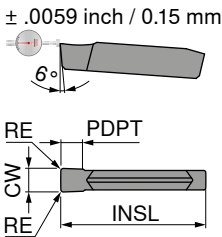


External machining



CoreLine – Carbide grooving insert – GX24

▲ Single-edged GX24 indexable insert for deeper grooves



-M40

CTP1340

DRAGONSKIN



M

NEW

IG

70 403 ...

03001

04001

05001

06001

Designation	INSL mm	CW mm +/-0.05	RE mm +/-0.05	PDPT mm	For tool holder
GX 24-2S E3.00 N 0.30	24	3	0.3	3.8	GX 24-2
GX 24-3S E4.00 N 0.40	24	4	0.4	3.8	GX 24-3
GX 24-3S E5.00 N 0.40	24	5	0.4	3.8	GX 24-3
GX 24-4S E6.00 N 0.50	24	6	0.5	4.1	GX 24-4

P	●
M	●
K	●
N	○
S	●
H	
O	○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

Internal machining

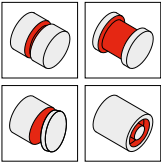
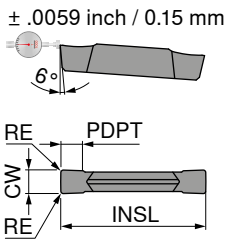


External machining

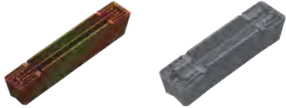


CoreLine – Carbide grooving insert – GX24

- ▲ For grooving, parting off, and groove turning
- ▲ Very well suited to ductile materials



-M45 CTCP325	-M45 CTP1340
DRAGONSKIN	DRAGONSKIN



M	M
---	---

Designation	INSL mm	CW mm +/-0.05	RE mm +/-0.05	PDPT mm	For tool holder
GX 24-2 E3.00 N 0.30	24	3	0.3	2.8	GX 24-2
GX 24-3 E4.00 N 0.40	24	4	0.4	3.5	GX 24-3
GX 24-3 E5.00 N 0.40	24	5	0.4	3.9	GX 24-3
GX 24-4 E6.00 N 0.80	24	6	0.8	4.6	GX 24-4

NEW IG	NEW IG
70 402 ...	70 402 ...
53001	
54001	
55001	
66001	56001

P	●	●
M	○	●
K	●	●
N		○
S	○	●
H		
O		○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

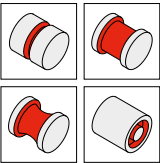
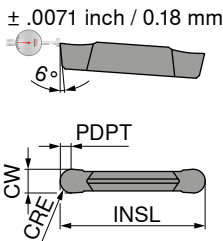
Internal machining



External machining



CoreLine – Carbide radial grooving insert – GX24



-M3 CTCP325	-M3 CTCP335
DRAGONSKIN	DRAGONSKIN



M	M
---	---

Designation	INSL mm	CW mm <small>+/-0.05</small>	CRE mm	PDPT mm	For tool holder
GX 24-2 R1.50 N	24.4	3	1.5	1.5	GX 24-2
GX 24-3 R2.00 N	24.4	4	2.0	2.5	GX 24-3
GX 24-3 R2.50 N	24.4	5	2.5	3.0	GX 24-3
GX 24-4 R3.00 N	24.4	6	3.0	4.0	GX 24-4

IG	IG
70 354 ...	70 354 ...
952	552
954	554
956	556
958	558

P	●	●
M	○	○
K	●	●
N		
S	○	
H		
O		



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.

Internal machining

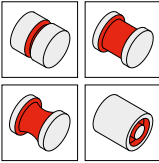
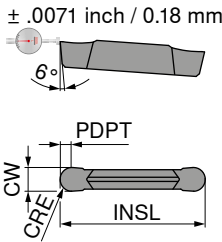


External machining



CoreLine – Carbide radial grooving insert – GX24

▲ Suitable for the machining of tough and ductile materials



-M33

CTCP325

DRAGONSKIN



Designation	INSL mm	CW mm +/-0.05	CRE mm	PDPT mm	For tool holder
GX 24-2 R1.50 N	24.4	3	1.5	1.5	GX 24-2
GX 24-3 R2.00 N	24.4	4	2.0	2.5	GX 24-3
GX 24-3 R2.50 N	24.4	5	2.5	3.0	GX 24-3
GX 24-4 R3.00 N	24.4	6	3.0	4.0	GX 24-4

M

IG

70 365 ...

95200

95400

95600

95800

P	●
M	○
K	●
N	○
S	○
H	○
O	○

→ Find the recommended values for cutting speeds here.

→ You can find the recommended feed values here.

Internal machining

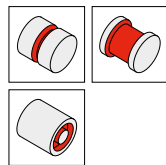
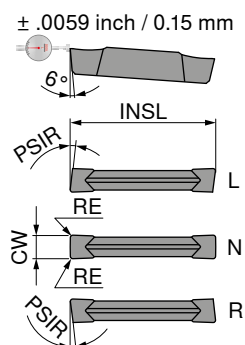
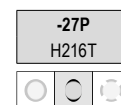


External machining



CoreLine – Carbide grooving insert – GX24

- ▲ Insert with highly positive cutting edge geometry and sharp cutting edge, polished chip breaker
- ▲ ground periphery
- ▲ R/L angled indexable insert for pip-free parting off
- ▲ Reduce feed rate values by 20–50% with R/L version



M

NEW
IG
70 350 ...
43401
682
684
686
688
43301

Designation	IH	INSL mm	CW +/-0.02 mm	RE +/-0.05 mm	PSIR	For tool holder
GX 24-2 E3.00 L 6	L	24	3	0.15	6°	GX 24-2
GX 24-2 E3.00 N 0.30	N	24	3	0.30		GX 24-2
GX 24-3 E4.00 N 0.40	N	24	4	0.40		GX 24-3
GX 24-3 E5.00 N 0.40	N	24	5	0.40		GX 24-3
GX 24-4 E6.00 N 0.50	N	24	6	0.50		GX 24-4
GX 24-2 E3.00 R 6	R	24	3	0.15	6°	GX 24-2

P	
M	
K	●
N	●
S	○
H	
O	



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.
- Here you will find additional product information.



Note: Reduce feed rate value by 20–50% for R/L version.

Internal machining

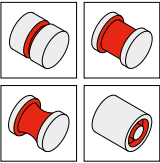
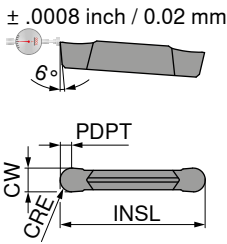


External machining



CoreLine – Carbide radial grooving insert – GX24

- ▲ Insert with highly positive cutting edge geometry and sharp cutting edge, polished chip breaker
- ▲ ground periphery



-27PF
H216T



M

IG

70 353 ...

500

506

Designation	INSL mm	CW mm +/-0.02	CRE mm	PDPT mm	For tool holder
GX 24-4 R3.00 N	25.4	6	3	4	GX 24-4
GX 24-5 R4.00 N	25.4	8	4	5	GX 24-5

P	
M	
K	●
N	●
S	○
H	
O	○

→ Find the recommended values for cutting speeds here.

→ You can find the recommended feed values here.

Internal machining

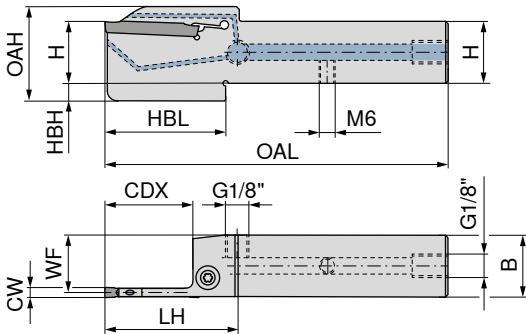


External machining



CoreLine – Radial Monoholder GX35-DC

Scope of supply:
Monoholder includes key and clamping screw



Illustrations show right-hand versions



Designation	H mm	B mm	CW mm	WF mm	OAH mm	OAL mm	LH mm	HBH mm	HBL mm	CDX mm	For grooving inserts
E20 R/L 0034S3-2020X-S-DC-GX35	20	20	3	18.75	41	117	55	10	48	34	GX 35-E3.00
E25 R/L 0034S3-2525X-S-DC-GX35	25	25	3	23.75	46	132	55	10	48	34	GX 35-E3.00

Left	Right
TO	TO
70 869 ...	70 869 ...
32001	32000
32501	32500

Spare parts
For grooving inserts

GX 35-E3.00



Screwdriver

AS

80 950 ...

T20 - IP 121

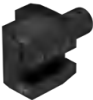


Clamping screw

AS

70 950 ...

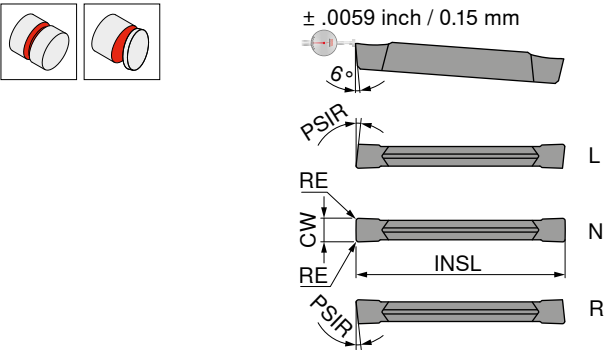
M6x22 - 20IP 92200



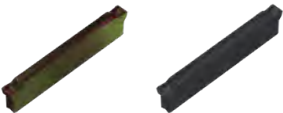
→ Adapters and accessories

CoreLine – Carbide grooving insert – GX35

- ▲ For parting and parting off
- ▲ R/L angled indexable insert for pip-free parting off
- ▲ Reduce feed rate values by 20–50% with R/L version



-M1 CTCP325	-M1 CTP1340
DRAGONSKIN	DRAGONSKIN



M	M
IG	IG
70 390 ...	70 390 ...
92300	62300
93300	63300
94300	64300

Designation	IH	INSL mm	CW mm	RE mm	PSIR	For tool holder
GX 35-E3.00 L 6	L	35	3	0.2	6°	-GX35
GX 35-E3.00 N 0.20	N	35	3	0.2	6°	-GX35
GX 35-E3.00 R 6	R	35	3	0.2	6°	-GX35

P	●	●
M	○	●
K	●	●
N	○	○
S	○	●
H		
O		○

- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.
- Here you will find additional product information.

Note: Reduce feed rate value by 20–50% for R/L version.

Internal machining

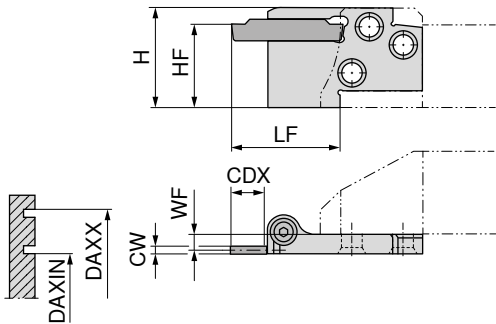
External machining



CoreLine – Axial grooving module AX – ModularClamp

▲ For axial grooving and turning

Scope of supply:
Grooving module only



Illustrations show right-hand versions



Designation	DAXIN mm	DAXX mm	CW mm	WF mm	HF mm	LF mm	H mm	CDX mm	For grooving inserts
E16 R/L 05-AX 05	4	10	3	2.5	16	24.0	20.5	5	AX05
E20 R/L 05-AX 05	4	10	3	3.1	20	28.0	25.0	5	AX05
E25 R/L 05-AX 05	4	10	3	4.6	25	27.5	30.0	5	AX05
E20 R/L 10-AX 10	14	20	3	3.1	20	33.0	25.0	10	AX10
E25 R/L 10-AX 10	14	20	3	4.6	25	32.5	30.0	10	AX10
E20 R/L 15-AX 15	24	30	3	3.1	20	44.0	25.0	15	AX15
E25 R/L 15-AX 15	24	30	3	4.6	25	43.5	30.0	15	AX15

Left	Right
TO	TO
70 827 ...	70 828 ...
016	016
020	020
025	025
120	120
125	125
220	220
225	225

Spare parts
for article number

70 827 016 / 70 828 016
70 827 020 / 70 828 020
70 827 025 / 70 828 025
70 827 120 / 70 828 120
70 827 125 / 70 828 125
70 827 220 / 70 828 220
70 827 225 / 70 828 225

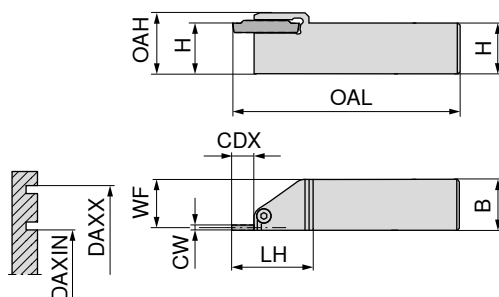
	
Screwdriver	Clamping screw
AS	AS
80 950 ...	70 950 ...
T15	M3,5x12,5
113	441
T15	M4x14
113	403
T20	M5x18
114	404
T15	M4x14
113	403
T20	M5x18
114	404



CoreLine – Axial AX grooving holder 0°, up to 15 mm groove depth

Scope of supply:

Grooving holder incl. key and clamping screw



Illustrations show right-hand versions



Designation	DAXIN mm	DAXX mm	H mm	B mm	OAL mm	LH mm	OAH mm	CDX mm	CW mm	WF mm	For grooving inserts	Left	Right
												TO 70 823 ...	TO 70 824 ...
E20 R/L 0005-2020-AX 05	4	10	20	20	140	28	25	5	3	18.7	AX05	02000	02000
E20 R/L 0010-2020-AX 10	14	20	20	20	140	38	25	10	3	18.7	AX10	12000	12000
E20 R/L 0015-2020-AX 15	24	30	20	20	140	49	25	15	3	18.7	AX15	22000	22000
E25 R/L 0005-2525-AX 05	4	10	25	25	160	28	30	5	3	23.7	AX05	02500	02500
E25 R/L 0010-2525-AX 10	14	20	25	25	160	38	30	10	3	23.7	AX10	12500	12500
E25 R/L 0015-2525-AX 15	24	30	25	25	160	49	30	15	3	23.7	AX15	22500	22500

Spare parts for article number

70 824 02000 / 70 823 02000	T20	106	M5x18	404
70 824 12000 / 70 823 12000	T20	106	M5x18	404
70 824 22000 / 70 823 22000	T20	106	M5x18	404
70 824 02500 / 70 823 02500	T20	106	M5x18	404
70 824 12500 / 70 823 12500	T20	106	M5x18	404
70 824 22500 / 70 823 22500	T20	106	M5x18	404



AS

80 950 ...



AS

70 950 ...

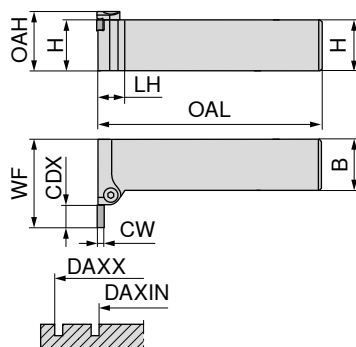


→ Adapters and accessories

CoreLine – Axial AX grooving holder 90°, up to 15 mm groove depth

Scope of supply:

Grooving holder incl. key and clamping screw



Illustrations show right-hand versions



Designation	DAXIN mm	DAXX mm	H mm	B mm	WF mm	OAH mm	OAL mm	LH mm	CDX mm	CW mm	For grooving inserts	Left	Right
												TO 70 825 ...	TO 70 826 ...
E20 R/L 9005-2020-AX 05	4	10	20	20	28	25	110	12	5	3	AX05	02000	02000
E20 R/L 9010-2020-AX 10	14	20	20	20	38	25	110	13	10	3	AX10	12000	12000
E20 R/L 9015-2020-AX 15	24	30	20	20	49	25	110	13	15	3	AX15	22000	22000
E25 R/L 9005-2525-AX 05	4	10	25	25	33	30	140	12	5	3	AX05	02500	02500
E25 R/L 9010-2525-AX 10	14	20	25	25	43	30	110	13	10	3	AX10	12500	12500
E25 R/L 9015-2525-AX 15	24	30	25	25	49	30	140	13	15	3	AX15	22500	22500

Spare parts for article number

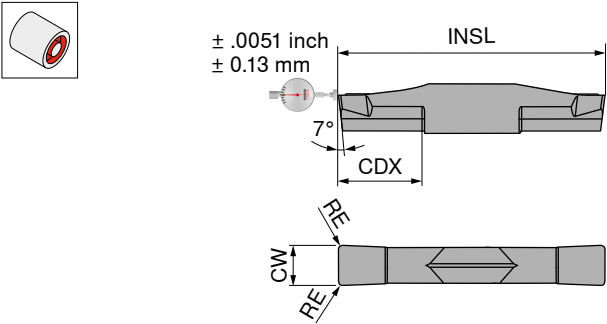
		AS 80 950 ...	AS 70 950 ...
70 825 02000 / 70 826 02000	T15	105	M4x14 403
70 825 12000 / 70 826 12000	T20	106	M5x18 404
70 825 22000 / 70 826 22000	T20	106	M5x18 404
70 825 02500 / 70 826 02500	T15	105	M4x14 403
70 825 12500 / 70 826 12500	T20	106	M5x18 404
70 825 22500 / 70 826 22500	T20	106	M5x18 404



→ Adapters and accessories

CoreLine – Carbide grooving insert – AX

- ▲ Very good chip control
- ▲ DAXN minimum groove diameter refers to the outside diameter



-F50
CTP1340

DRAGONSKIN





Designation	IH	INSL mm	CW mm +/-0.02	RE mm +/-0.05	CDX mm	For tool holder
AX 05 E3.00 N 0.30	N	24	3	0.3	5	E.. R/L... -AX 05
AX 10 E3.00 N 0.30	N	34	3	0.3	10	E.. R/L... -AX 10
AX 15 E3.00 N 0.30	N	44	3	0.3	15	E.. R/L... -AX 15

F

IG

70 327 ...

005

010

015

P	●
M	●
K	●
N	○
S	●
H	○
O	○



→ Find the recommended values for cutting speeds here.

→ You can find the recommended feed values here.

Internal machining

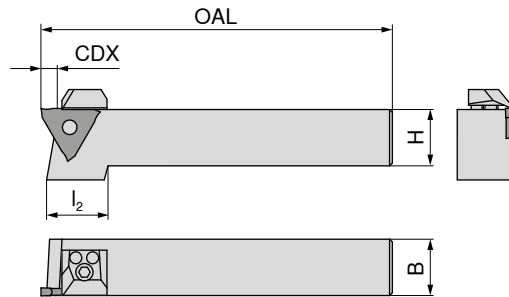
External machining



CoreLine – Radial/axial TX grooving holder 0°, up to 6 mm groove depth

- ▲ For radial and axial grooving
- ▲ Groove widths 0.5–6.3 mm

Scope of supply:
Grooving holder only



Illustrations show right-hand versions

Designation	H mm	B +0,1 mm	OAL mm	I ₂ mm	CDX mm	For grooving inserts	Left TO 73 501 ...	Right TO 73 500 ...
R/L 207.1212.1	12	12	100	24	4	TX R/N/L ...1	112	112
R/L 207.1616.1	16	16	125	22	4	TX R/N/L ...1	116	116
R/L 207.2020.1	20	20	125	21	4	TX R/N/L ...1	120	120
R/L 207.2525.1	25	25	150		4	TX R/N/L ...1	125	125
R/L 207.1616.2	16	16	125	22	6	TX R/N/L ...2	216	216
R/L 207.2020.2	20	20	125	21	6	TX R/N/L ...2	220	220
R/L 207.2525.2	25	25	150		6	TX R/N/L ...2	225	225
R/L 207.2020.3	20	20	125	21	6	TX R/N/L ...3	320	320
R/L 207.2525.3	25	25	150		6	TX R/N/L ...3	325	325
R 207.3232.3	32	32	170		6	TX R/N/L ...3		332
R/L 207.2020.4	20	20	125	21	6	TX R/N/L ...4	420	420
R/L 207.2525.4	25	25	150		6	TX R/N/L ...4	425	425

Spare parts For grooving inserts

		Key I	Right hand	Left hand		Clamping screw		Guide pin
		AS	AS	AS		AS		AS
TX R/N/L ...1	SW3	70 950 ... 176	73 950 ... 020	73 950 ... 024	M6x20	73 950 ... 028	Ø 4x18	73 950 ... 030
TX R/N/L ...1	SW3	176		024	M6x20	028	Ø 4x18	030
TX R/N/L ...2	SW3	176		024	M6x20	028	Ø 4x18	030
TX R/N/L ...2	SW3	176	020		M6x20	028	Ø 4x18	030
TX R/N/L ...3	SW3	176		024	M6x20	028	Ø 4x18	030
TX R/N/L ...3	SW3	176	020		M6x20	028	Ø 4x18	030
TX R/N/L ...4	SW3	176	022		M6x20	028	Ø 4x18	030
TX R/N/L ...4	SW3	176		026	M6x20	028	Ø 4x18	030

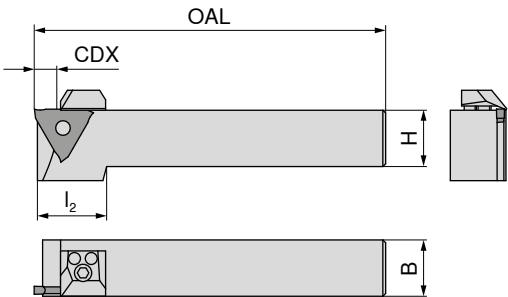


→ Adapters and accessories

CoreLine – Radial TX grooving holder 0°, up to 8 mm groove depth

- ▲ For radial grooving and parting off
- ▲ Groove widths 1.9–6.3 mm

Scope of supply:
Grooving holder only



Illustrations show right-hand versions

Designation	H mm	B +/-0,1 mm	OAL mm	I ₂ mm	CDX mm	For grooving inserts	Left	Right
							TO 73 503 ...	TO 73 502 ...
R/L 780.2020.2	20	20	125	24	8	TX R/N/L ...2	120	120
R/L 780.2525.2	25	25	150		8	TX R/N/L ...2	125	125
R/L 780.2020.3	20	20	125	24	8	TX R/N/L ...3	220	220
R/L 780.2525.3	25	25	150		8	TX R/N/L ...3	225	225
R/L 780.2020.4	20	20	125	24	8	TX R/N/L ...4	320	320
R/L 780.2525.4	25	25	150		8	TX R/N/L ...4	325	325

Spare parts
For grooving inserts

			Key I	Right hand	Left hand		Clamping screw		Guide pin
			AS 70 950 ...	AS 73 950 ...	AS 73 950 ...		AS 73 950 ...		AS 73 950 ...
TX R/N/L ...2	SW3	176		020		M6x20	028	Ø 4x18	030
TX R/N/L ...2	SW3	176			024	M6x20	028	Ø 4x18	030
TX R/N/L ...3	SW3	176		020		M6x20	028	Ø 4x18	030
TX R/N/L ...3	SW3	176			024	M6x20	028	Ø 4x18	030
TX R/N/L ...4	SW3	176		022		M6x20	028	Ø 4x18	030
TX R/N/L ...4	SW3	176			026	M6x20	028	Ø 4x18	030

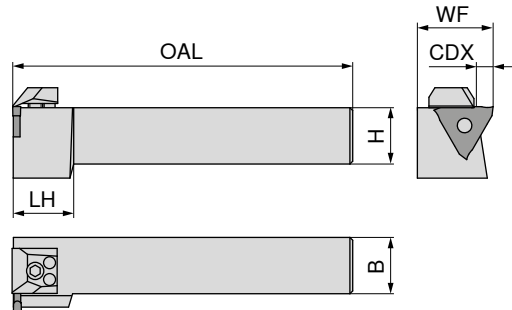


→ Adapters and accessories

CoreLine – Radial TX grooving holder 90°, up to 6 mm groove depth

- ▲ For radial grooving
- ▲ Groove widths 0.5–6.3 mm

Scope of supply:
Grooving holder only



Illustrations show right-hand versions

Designation	H mm	B mm	OAL mm	LH mm	WF mm	CDX mm	For grooving inserts	Left	Right
								TO 73 505 ...	TO 73 504 ...
R/L 738.2020.1	20	20	150	20	27	4	TX R/N/L ...1	120	120
R/L 738.2525.1	25	25	150		32	4	TX R/N/L ...1	125	125
R/L 738.2020.2	20	20	150	20	27	6	TX R/N/L ...2	220	220
R/L 738.2525.2	25	25	150		32	6	TX R/N/L ...2	225	225
R/L 738.2525.3	25	25	150		32	6	TX R/N/L ...3	325	325
R/L 738.2525.4	25	25	150		32	6	TX R/N/L ...4	425	425

Spare parts For grooving inserts

		Key I	Right hand	Left hand		Clamping screw		Guide pin
		AS 70 950 ...	AS 73 950 ...	AS 73 950 ...		AS 73 950 ...		AS 73 950 ...
TX R/N/L ...1	SW3	176	020		M6x20	028	Ø 4x18	030
TX R/N/L ...1	SW3	176		024	M6x20	028	Ø 4x18	030
TX R/N/L ...2	SW3	176		024	M6x20	028	Ø 4x18	030
TX R/N/L ...2	SW3	176	020		M6x20	028	Ø 4x18	030
TX R/N/L ...3	SW3	176		024	M6x20	028	Ø 4x18	030
TX R/N/L ...3	SW3	176	020		M6x20	028	Ø 4x18	030
TX R/N/L ...4	SW3	176	022		M6x20	028	Ø 4x18	030
TX R/N/L ...4	SW3	176		026	M6x20	028	Ø 4x18	030

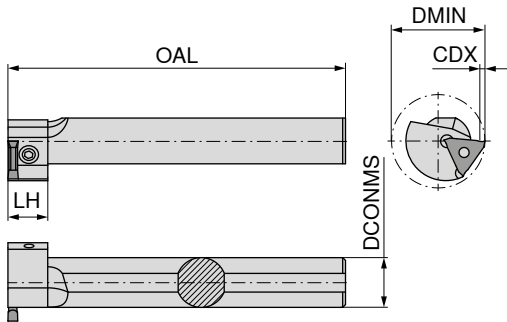


→ Adapters and accessories

CoreLine – Radial boring bar TX

- ▲ For radial internal grooving
- ▲ Groove widths 0.5–6.3 mm

Scope of supply:
Boring bar only



Illustrations show right-hand versions



Designation	DCONMS _{gr} mm	DMIN mm	OAL mm	LH mm	CDX mm	For grooving inserts	Left	Right
							TO 73 511 ...	TO 73 510 ...
R/L 660.0025.1	25	46	170	20	2	TX R/N/L ...1	125	125
R/L 660.0032.1	32	46	200	20	2	TX R/N/L ...1	132	132
R/L 660.0040.1	40	46	250		2	TX R/N/L ...1	140	140
R/L 660.0025.2	25	46	170	20	2	TX R/N/L ...2	225	225
R/L 660.0032.2	32	46	200	20	2	TX R/N/L ...2	232	232
R/L 660.0032.3	32	46	200	20	2	TX R/N/L ...3	332	332
R/L 660.0040.3	40	46	250		2	TX R/N/L ...3	340	340

Bore Ø _{min.} in mm	46	50	60	80	100	For grooving inserts
CDX _{max.} in mm	2	3	4	4,5	5	TX R/N/L ...1
	2	3	4	4,5	5	TX R/N/L ...2
	2	3	4	4,5	5	TX R/N/L ...3
	2	3	4	4,5	5	TX R/N/L ...4

Spare parts
For grooving inserts

	AS 73 950 ...	AS 70 950 ...	AS 73 950 ...
TX R/N/L ...1	011	SW3	176
TX R/N/L ...2	011	SW3	176
TX R/N/L ...3	011	SW3	176



Clamping element

AS

73 950 ...



Key I

AS

70 950 ...



Clamping screw

AS

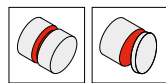
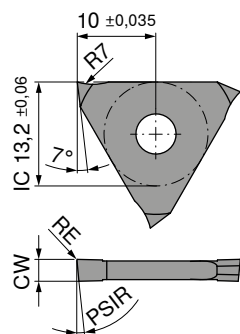
73 950 ...



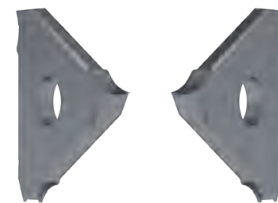
→ Adapters and accessories

CoreLine – Carbide grooving insert for grooving and parting off – TX

- ▲ Up to groove depth 5.0 mm
- ▲ Groove widths 1.99–2.79 mm



Illustrations show right-hand versions



M Left **M** Right

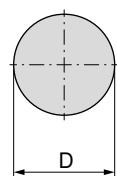
Designation	CW $_{-0.05}$ mm	RE mm	PSIR	For tool holder	IG	IG
TX R/L 0518.00.1	1.99	0.1	5°	R/L 207 ... / 780 ... 1	73 302 ... 204	73 301 ... 204
TX R/L 0521.00.2	2.29	0.1	5°	R/L 207 ... / 780 ... 2	206	206
TX R/L 0526.00.2	2.79	0.1	5°	R/L 207 ... / 780 ... 2	208	208
P					●	●
M					●	●
K					●	●
N					●	●
S					●	●
H					○	○
O					●	●



→ Find the recommended values for cutting speeds here.

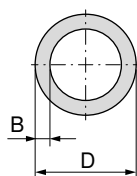
Groove depth

Solid material



max. 10 mm

Pipe



$D \leq 50$ mm: Wall thickness B = approx. 5 mm
 $D \geq 50$ mm: Wall thickness B = approx. 4 mm

Internal machining

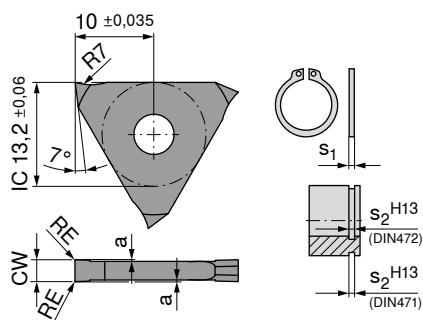
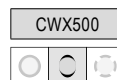


External machining



CoreLine – Carbide grooving insert for circlip grooves – TX

▲ For circlip grooves according to DIN 471 / 472



M

Neutral

IG

73 300 ...

Designation	s ₂ mm	CW mm	RE mm	a mm	For tool holder
TX N 0050.00.1	0.50	0.57	0.05	0.07	R/L ... 1
TX N 0060.00.1	0.60	0.67	0.05	0.07	R/L ... 1
TX N 0070.00.1	0.70	0.77	0.05	0.08	R/L ... 1
TX N 0080.00.1	0.80	0.87	0.05	0.08	R/L ... 1
TX N 0090.00.1	0.90	0.97	0.05	0.08	R/L ... 1
TX N 0100.00.1	1.00	1.07	0.10	0.09	R/L ... 1
TX N 0110.00.1	1.10	1.24	0.10	0.15	R/L ... 1
TX N 0130.00.1	1.30	1.44	0.10	0.15	R/L ... 1
TX N 0160.00.1	1.60	1.74	0.10	0.20	R/L ... 1
TX N 0185.00.1	1.85	1.99	0.10	0.20	R/L ... 1
TX N 0215.00.2	2.15	2.29	0.10	0.20	R/L ... 2
TX N 0265.00.2	2.65	2.79	0.10	0.20	R/L ... 2
TX N 0315.00.3	3.15	3.29	0.10	0.20	R/L ... 3
TX N 0515.00.4	5.15	5.29	0.10	0.20	R/L ... 4

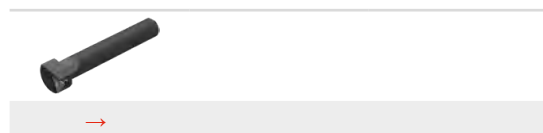
204
206
208
210
212
214
216
218
220
222
224
226
228
232

P	●
M	●
K	●
N	●
S	●
H	○
O	●

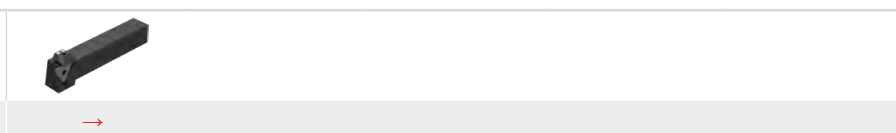


→ Find the recommended values for cutting speeds here.

Internal machining

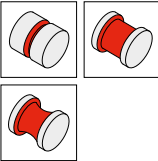
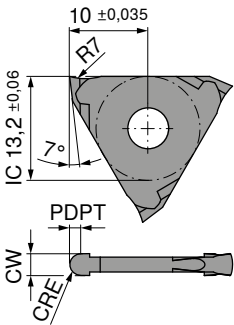
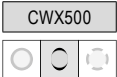


External machining



CoreLine – Carbide radius grooving insert for corner undercuts – TX

▲ Full radius for groove widths from 0.5–5.0 mm



M
Neutral

Designation	CRE mm	CW mm	PDPT mm	For tool holder
TX N 0002.05.1	0.25	0.5	0.20	R/L ...1
TX N 0005.10.1	0.50	1.0	0.35	R/L ...1
TX N 0006.12.1	0.60	1.2	0.40	R/L ...1
TX N 0008.16.1	0.80	1.6	0.55	R/L ...1
TX N 0010.20.2	1.00	2.0	0.70	R/L ...2
TX N 0012.25.2	1.25	2.5	0.85	R/L ...2
TX N 0015.30.3	1.50	3.0	1.00	R/L ...3
TX N 0020.40.4	2.00	4.0	1.20	R/L ...4

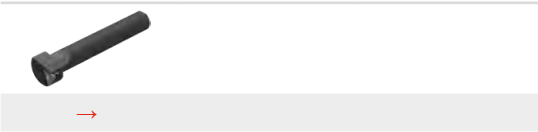
IG
73 304 ...
212
214
216
218
204
220
206
208

P	●
M	●
K	●
N	●
S	●
H	○
O	●

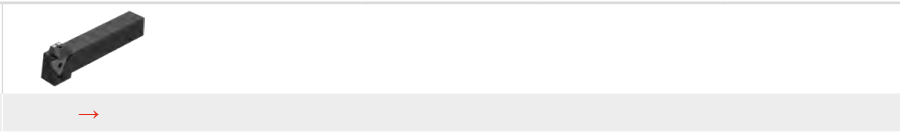


→ Find the recommended values for cutting speeds here.

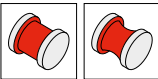
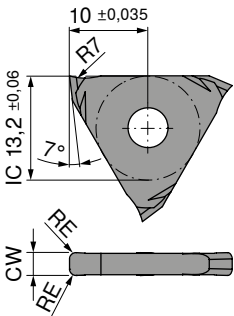
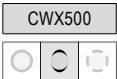
Internal machining



External machining



CoreLine – Carbide grooving insert for fine and copy turning – TX



M
Neutral

IG	
73 303 ...	
204	
206	
208	
210	
212	
214	
216	
218	
220	

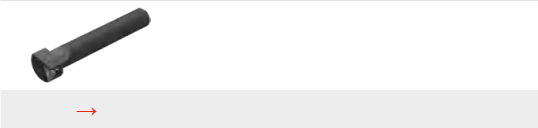
Designation	CW mm	RE mm	For tool holder
TX N 0150.02.1	1.5	0.2	R/L 207 ... / 738 ... / 660 ... 1
TX N 0200.02.1	2.0	0.2	R/L 207 ... / 738 ... / 660 ... 1
TX N 0200.04.1	2.0	0.4	R/L 207 ... / 738 ... / 660 ... 1
TX N 0300.02.2	3.0	0.2	R/L 207 ... / 738 ... / 660 ... 2
TX N 0300.06.2	3.0	0.6	R/L 207 ... / 738 ... / 660 ... 2
TX N 0300.08.2	3.0	0.8	R/L 207 ... / 738 ... / 660 ... 2
TX N 0400.02.3	4.0	0.2	R/L 207 ... / 738 ... / 660 ... 3
TX N 0400.08.3	4.0	0.8	R/L 207 ... / 738 ... / 660 ... 3
TX N 0400.12.3	4.0	1.2	R/L 207 ... / 738 ... / 660 ... 3

P	●
M	●
K	●
N	●
S	●
H	○
O	●

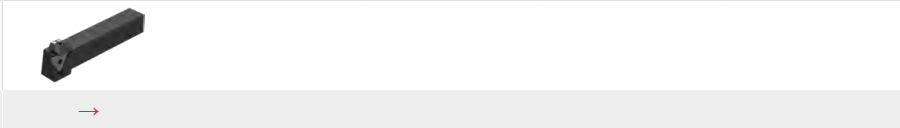


→ Find the recommended values for cutting speeds here.

Internal machining

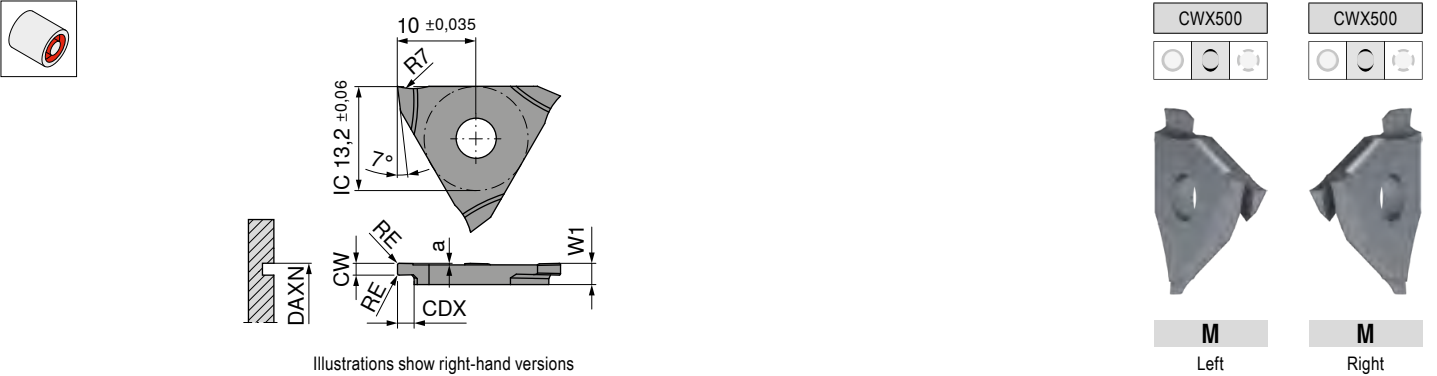


External machining



CoreLine – Carbide grooving insert for axial grooving – TX

- ▲ Up to groove depth 3.5 mm
- ▲ Groove width 1.5–5.0 mm
- ▲ Groove-Ø external $D_a \geq 20$ mm



Designation	CW mm	W1 mm	CDX mm	a mm	DAXN mm	RE mm	For tool holder		
TX R/L 2015.2.2	1.5	2.7	2	0.2	20	0.2	R/L 207 ... 2	73 306 ...	73 305 ...
TX R/L 3020.2.2	2.0	2.7	3	0.2	30	0.2	R/L 207 ... 2	204 206	204 206
P								●	●
M								●	●
K								●	●
N								●	●
S								●	●
H								○	○
O								●	●



→ Find the recommended values for cutting speeds here.

Internal machining

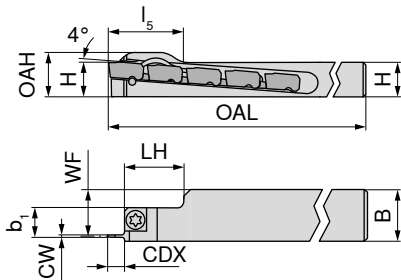
External machining





CoreLine – Tool holder – groove depth 5 mm – MaxiClick

Scope of supply:
Monoholder incl. key and clamping screw



Illustrations show right-hand versions

Designation	H mm	B mm	OAL mm	LH mm	OAH mm	CDX mm	WF mm	b ₁ mm	l ₅ mm	For grooving inserts	Left	Right
											TO 70 873 ...	TO 70 873 ...
MC 05 R/L -1212K	12	12	125	23	15	5	10.5	12	27	MC 05	212	112
MC 05 R/L -1616K	16	16	125	23	19	5	14.5	12	20	MC 05	216	116
MC 05 R/L -2020K	20	20	125	23	23	5	18.8	12	20	MC 05	220	120
MC 05 R/L -2525M	25	25	150	23	28	5	23.5	12	21	MC 05	225	125

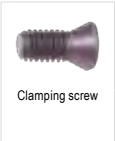
Spare parts
For grooving inserts



Key T

AS

70 950 ...



Clamping screw

AS

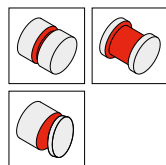
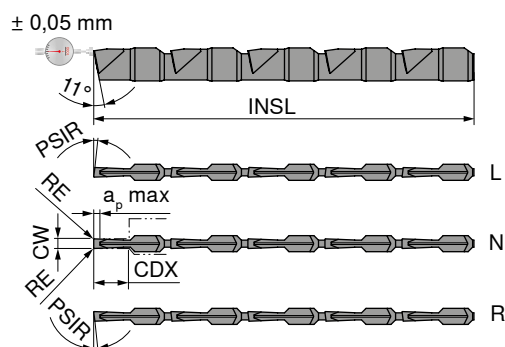
70 950 ...

MC 05	T15	738	M4x11	174
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CoreLine – Carbide grooving insert – groove depth 5 mm – MaxiClick

- ▲ 5 cutting edges
- ▲ R/L angled indexable insert for pip-free parting off
- ▲ Reduce feed rate values by 20–50% with R/L version



M

IG

70 338 ...

250

260

210

220

230

240

Designation	IH	INSL mm	CW mm	RE mm	PSIR	a _{p max} mm	CDX mm	For tool holder
MC 05-5-1.00 L 07-F2	L	59.2	1.0	0.1	7°		5	MC 05 R/L
MC 05-5-1.50 L 07-F2	L	59.2	1.5	0.1	7°		5	MC 05 R/L
MC 05-5-1.00 N 0.10-F2	N	59.2	1.0	0.1		0.5	5	MC 05 R/L
MC 05-5-1.50 N 0.10-F2	N	59.2	1.5	0.1		1.0	5	MC 05 R/L
MC 05-5-1.00 R 07-F2	R	59.2	1.0	0.1	7°		5	MC 05 R/L
MC 05-5-1.50 R 07-F2	R	59.2	1.5	0.1	7°		5	MC 05 R/L

P	●
M	●
K	●
N	○
S	●
H	○
O	○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.
- Here you will find additional product information.



Note: Reduce feed rate value by 20–50% for R/L version.

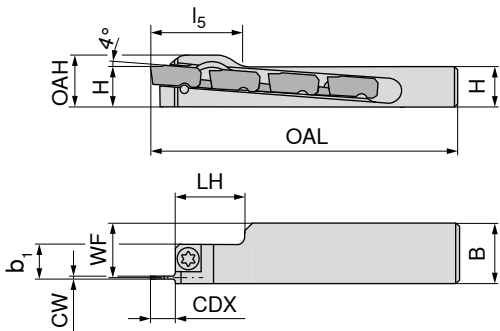
Internal machining

External machining



CoreLine – Tool holder – groove depth 10 mm – MaxiClick

Scope of supply:
Monoholder incl. key and clamping screw



Illustrations show right-hand versions



Designation	H mm	B mm	OAL mm	LH mm	OAH mm	CDX mm	WF mm	b ₁ mm	I ₅ mm	For grooving inserts	Left	Right
											TO 70 874 ...	TO 70 874 ...
MC 10 R/L -1212K	12	12	125	28	15	10	10.5	12		MC 10	212	112
MC 10 R/L -1616K	16	16	125	28	19	10	14.5	12	20	MC 10	216	116
MC 10 R/L -2020K	20	20	125	28	23	10	18.8	12	20	MC 10	220	120
MC 10 R/L -2525M	25	25	150	28	28	10	23.5	12	21	MC 10	225	125

Spare parts
For grooving inserts



Key T

AS

70 950 ...

T15738



Clamping screw

AS

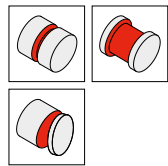
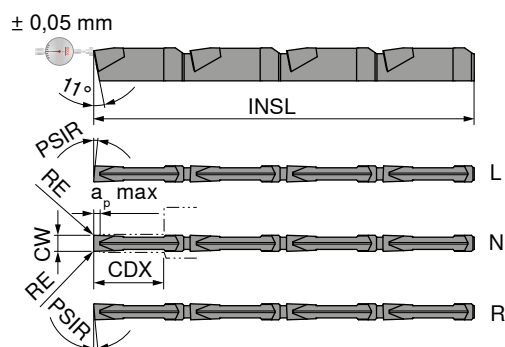
70 950 ...

M4x11174



CoreLine – Carbide grooving insert – groove depth 10 mm – MaxiClick

- ▲ 4 cutting edges
- ▲ R/L angled indexable insert for pip-free parting off
- ▲ Reduce feed rate values by 20–50% with R/L version



M

IG

70 339 ...

Designation	IH	INSL mm	CW mm	RE mm	PSIR	a _{p max} mm	CDX mm	For tool holder
MC 10-4-1.50 L 07-F2	L	59.2	1.5	0.1	7°		10	MC 10 R/L
MC 10-4-2.00 L 07-F2	L	59.2	2.0	0.1	7°		10	MC 10 R/L
MC 10-4-2.50 L 07-F2	L	59.2	2.5	0.1	7°		10	MC 10 R/L
MC 10-4-1.50 N 0.10-F2	N	59.2	1.5	0.1		1.0	10	MC 10 R/L
MC 10-4-2.00 N 0.10-F2	N	59.2	2.0	0.1		1.5	10	MC 10 R/L
MC 10-4-2.50 N 0.10-F2	N	59.2	2.5	0.1		2.0	10	MC 10 R/L
MC 10-4-1.50 R 07-F2	R	59.2	1.5	0.1	7°		10	MC 10 R/L
MC 10-4-2.00 R 07-F2	R	59.2	2.0	0.1	7°		10	MC 10 R/L
MC 10-4-2.50 R 07-F2	R	59.2	2.5	0.1	7°		10	MC 10 R/L

270

280

290

210

220

230

240

250

260

P	●
M	●
K	●
N	○
S	●
H	
O	○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.
- Here you will find additional product information.



Note: Reduce feed rate value by 20–50% for R/L version.

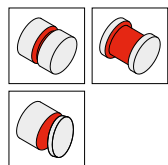
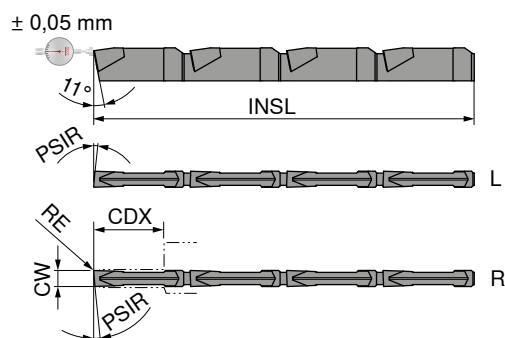
Internal machining

External machining



CoreLine – Carbide grooving insert – groove depth 10 mm – MaxiClick

- ▲ 4 cutting edges
- ▲ R/L angled indexable insert for pip-free parting off
- ▲ Reduce feed rate values by 20–50% with R/L version



M

IG

70 340 ...

270

280

290

240

250

260

Designation	IH	INSL	CW	RE	PSIR	CDX	For tool holder
MC 10-4-1.50 L 12-F3	L	59.2	1.5	0.1	12°	10	MC 10 R/L
MC 10-4-2.00 L 12-F3	L	59.2	2.0	0.1	12°	10	MC 10 R/L
MC 10-4-2.50 L 12-F3	L	59.2	2.5	0.1	12°	10	MC 10 R/L
MC 10-4-1.50 R 12-F3	R	59.2	1.5	0.1	12°	10	MC 10 R/L
MC 10-4-2.00 R 12-F3	R	59.2	2.0	0.1	12°	10	MC 10 R/L
MC 10-4-2.50 R 12-F3	R	59.2	2.5	0.1	12°	10	MC 10 R/L

P	●
M	●
K	●
N	○
S	●
H	
O	○



- Find the recommended values for cutting speeds here.
- You can find the recommended feed values here.
- Here you will find additional product information.



Note: Reduce feed rate value by 20–50% for R/L version.

Internal machining

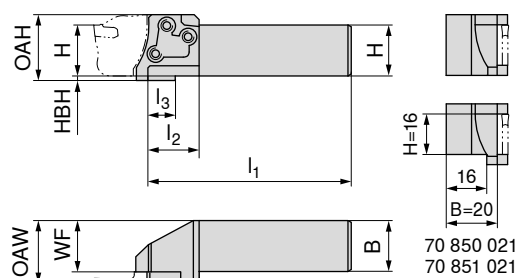
External machining



CoreLine – Base holder 0° – ModularClamp

Scope of supply:

Base holder incl. clamping screw



Illustrations show right-hand versions

Designation	H mm	B mm	OAW mm	OAH mm	WF mm	l ₁ mm	l ₂ mm	l ₃ mm	HBH mm	For modules	Left TO 70 851 ...	Right TO 70 850 ...
E16 R/L 00-1616G	16	16	19.25	19.5	15.75	90	16			E16 R/L ...	016	016
E20 R/L 00-1620G	16	20	24.25	24.0	20.15	90	20			E20 R/L/N ...	021 ¹⁾	021 ¹⁾
E20 R/L 00-2020J	20	20	24.25	24.0	20.15	110	20			E20 R/L/N ...	020	020
E25 R/L 00-2525L	25	25	31.00	30.0	25.50	140	25			E25 R/L ...	025	025
E32 R/L 00-3225N	32	25	31.00	38.0	25.50	160	32			E32 R/L ...	032	032
E32 L 00-3232N	32	32	38.00	41.8	32.50	180	32	16	3	E32 R/L ...	13200	
E32 R 00-3232Q	32	32	38.00	41.8	32.50	180	32	16	3	E32 R/L ...		13200

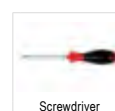
1) See drawing



For right-hand holder → use right-hand (or neutral) module
For left-hand holder → use left-hand (or neutral) module

Spare parts for article number

70 851 016 / 70 850 016	T15	113	M3,5x12,5	441
70 851 021 / 70 850 021	T15	113	M4x14	403
70 851 020 / 70 850 020	T15	113	M4x14	403
70 851 025 / 70 850 025	T20	114	M5x18	404
70 851 032 / 70 850 032	T25	115	M6x20	405



Screwdriver

AS

80 950 ...



Clamping screw

AS

70 950 ...

SX

FX

LX

GX09

GX16

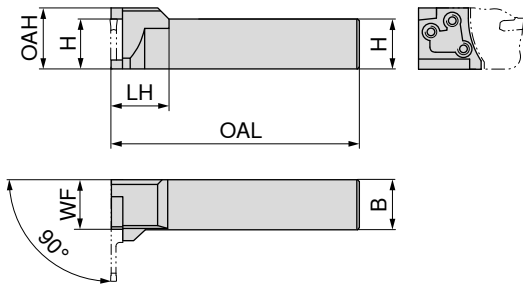
GX24

AX



CoreLine – Base holder 90° – ModularClamp

Scope of supply:
Base holder incl. clamping screw



Illustrations show right-hand versions

Designation	H mm	B mm	OAH mm	WF mm	OAL mm	LH mm	For modules
E20 R/L 90-2020J	20	20	24	20	110	20	E20 R/L/N ...
E25 R/L 90-2525L	25	25	30	25	140	28	E25 R/L ...
E32 R/L 90-3225N	32	25	38	32	160	34	E32 R/L ...

Left	Right
TO	TO
70 855 ...	70 854 ...
020	020
025	025
032	032

For right-hand holder → use left-hand (or neutral) module
For left-hand holder → use right-hand (or neutral) module

Screwdriver	Clamping screw
AS	AS
80 950 ...	70 950 ...
T15	M4x14
113	403
T20	M5x18
114	404
T25	M6x20
115	405

Spare parts
for article number

70 854 020 / 70 855 020
70 854 025 / 70 855 025
70 854 032 / 70 855 032

SX

FX

LX

GX09

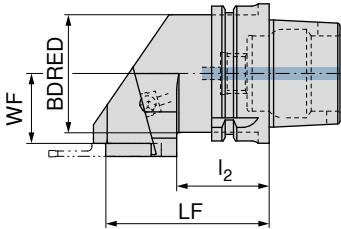
GX16

GX24

AX

CoreLine – HSK-T base holder 0° – ModularClamp

Scope of supply:
Base holder incl. clamping screw



Illustrations show right-hand versions



Designation	Adapter	LF mm	l ₂ mm	BDRED mm	WF mm	For modules	Left TO 74 581 ... 525	Right TO 74 580 ... 525
HSK T63 E25 R/L 00	HSK-T 63	67	42	53	38.7	E25 R/L...		

For right-hand holder → use right-hand module

For left-hand holder → use left-hand module

Spare parts
for article number

74 580 525 / 74 581 525	T20	80 950 ... 114	M5x18	70 950 ... 404	70 950 ... 05700
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Screwdriver
AS
80 950 ...
114

Clamping screw
AS
70 950 ...
404

Hollow key with nose
CT
70 950 ...
05700

Spare parts
for article number

74 580 525 / 74 581 525	UNJF 7/16"-20	70 950 ... 05600	UNJF 7/16"-20	70 950 ... 05500
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Sealing plug
AS
70 950 ...
05600

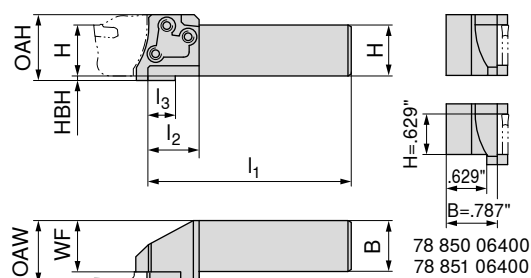
Nozzle
AS
70 950 ...
05500

SX	FX	LX	GX09	GX16	GX24	AX
→	→	→	→	→	→	→

CoreLine – Tool holder 0° – ModularClamp

Scope of supply:

Base holder incl. clamping screw



Illustrations show right-hand versions

Designation	H inch	B inch	OAW inch	OAH inch	WF inch	l ₁ inch	l ₂ inch	l ₃ inch	HBH inch	For modules
E12 R/L 00-08-E	0.500	0.500	0.650	0.598	0.512	3.000	0.472			E12 R/L ...
E16 R/L 00-10-E	0.625	0.625	0.787	0.763	0.650	3.500	0.630			E16 R/L ...
E 20 R/L 00-10-E	0.625	0.787	0.955	0.955	0.793	3.500	0.787			E20 R/L ...
E 20 R/L 00-12-E	0.750	0.750	0.955	0.907	0.793	4.500	0.787	0.393		E20 R/L ...
E 25 R/L 00-16-E	1.000	1.000	1.236	1.197	1.020	5.500	0.984			E25 R/L ...
E 32 R/L 00-20-E	1.250	1.000	1.236	1.486	1.020	6.500	1.260	0.630	0.118	E32 R/L ...
E 32 R/L 00-85-E	1.250	1.250	1.496	1.528	1.279	7.000	1.260	0.630	0.118	E32 R/L ...

Left

Right

TO	TO
78 851 ...	78 850 ...
05000 ¹⁾	05000 ¹⁾
06300 ¹⁾	06300
06400 ¹⁾	06400 ¹⁾
07500	07500
10000	10000
12500 ¹⁾	12500
12600	12600 ¹⁾

¹⁾ Not in stock



For right-hand holder → use right-hand (or neutral) module
For left-hand holder → use left-hand (or neutral) module

Spare parts for article number

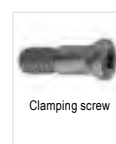
78 850 05000 / 78 851 05000	T08	110	M2,5x10	440
78 850 06300 / 78 851 06300	T15	113	M3,5x12,5	441
78 850 06400 / 78 851 06400	T15	113	M4x14	403
78 850 07500 / 78 851 07500	T15	113	M4x14	403
78 850 10000 / 78 851 10000	T20	114	M5x18	404
78 850 12500 / 78 851 12500	T25	115	M6x20	405
78 850 12600 / 78 851 12600	T25	115	M6x20	405



Screwdriver

AS

80 950 ...



Clamping screw

AS

70 950 ...

SX

FX

LX

GX09

GX16

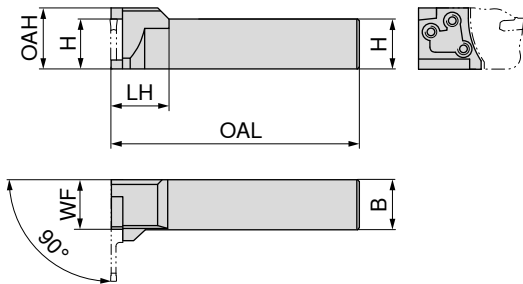
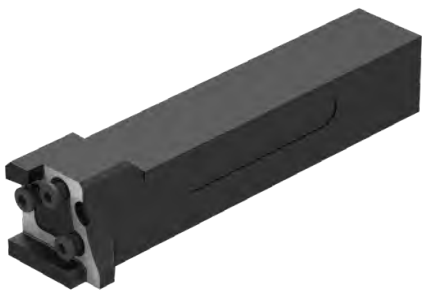
GX24

AX



CoreLine – Tool holder 90° – ModularClamp

Scope of supply:
Base holder incl. clamping screw



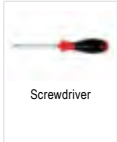
Illustrations show right-hand versions

Designation	H inch	B inch	OAH inch	WF inch	OAL inch	LH inch	For modules	Left	Right
								TO 78 855 ...	TO 78 854 ...
E20 R/L 90-12-E	0.750	0.750	0.907	0.787	4.500	0.783	E20 R/L ...	07500	07500 ¹⁾
E25 R/L 90-16-E	1.000	1.000	1.197	1.000	5.500	1.098	E25 R/L ...	10000	10000
E32 R/L 90-85-E	1.250	1.000	1.486	1.260	6.500	1.339	E32 R/L ...	12500 ¹⁾	12500 ¹⁾
E32 R/L 90-20-E	1.250	1.250	1.528	1.260	8.000	1.339	E32 R/L ...	12600 ¹⁾	12600

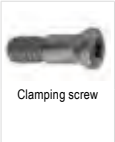
1) Not in stock



For right-hand holder → use left-hand (or neutral) module
For left-hand holder → use right-hand (or neutral) module



Screwdriver



Clamping screw

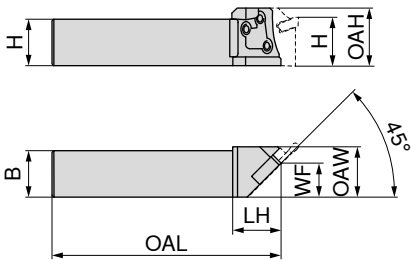
Spare parts
for article number

			AS 80 950 ...	AS 70 950 ...
78 854 07500 / 78 855 07500	T15	113	M4x14	403
78 854 10000 / 78 855 10000	T20	114	M5x18	404
78 854 12500 / 78 855 12500	T25	115	M6x20	405
78 854 12600 / 78 855 12600	T25	115	M6x20	405



CoreLine – Tool holder 45° – ModularClamp

Scope of supply:
Base holder incl. clamping screw



Illustrations show right-hand versions

Designation	H inch	B inch	OAH inch	WF inch	OAL inch	LH inch	For modules
E20 R/L 45-12-E	0.750	0.750	0.984	0.571	4.500	0.787	E20 R/L ...
E25 R/L 45-12-E	1.000	1.000	1.197	0.709	5.500	0.984	E25 R/L ...

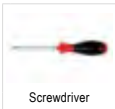
Left	Right
TO	TO
78 853 ...	78 852 ...
07500 ¹⁾	07500 ¹⁾
10000 ¹⁾	10000

1) Not in stock

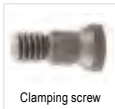
For right-hand holder → use left-hand (or neutral) module
For left-hand holder → use right-hand (or neutral) module

Spare parts
for article number

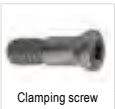
78 852 07500 / 78 853 07500	T15	113	M4x11	442	M4x14	403
78 852 10000 / 78 853 10000	T20	114	M5x13,5	513	M5x18	404



Screwdriver



Clamping screw



Clamping screw

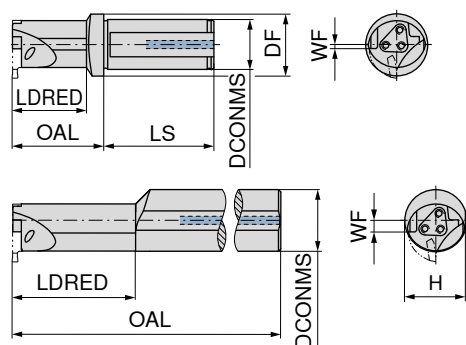
SX	FX	LX	GX09	GX16	GX24	AX
→	→	→	→	→	→	→

CoreLine – Boring bars GX – ModularClamp

▲ with through coolant

Scope of supply:

Boring bar incl. clamping screw



Illustrations show right-hand versions



	Designation	DCONMS mm	DF mm	WF mm	H mm	OAL mm	LDRED mm	LS mm	For modules	Left TO 70 861 ...	Right TO 70 860 ...
≤ 1.5xD	I16 R/L 90-1,5 D-N	20	25	1.0		32	24	50	I 16 R/L	017	017
	I20 R/L 90-1,5 D-N	20	25	1.0		37	30	50	I 20 R/L	021	021
	I25 R/L 90-1,5 D-N	25	32	1.5		46	38	56	I 25 R/L	026	026
	I32 R/L 90-1,5 D-N	32	40	2.0		59	48	60	I 32 R/L	033 ¹⁾	033 ¹⁾
	I40 R/L 90-1,5 D-N	40	50	2.5		72	60	70	I 40 R/L/N	041	041
≤ 2.5xD	I16 R/L 90-2,5 D-N	20		4.5	19.0	180	40		I 16 R/L	117	117
	I20 R/L 90-2,5 D-N	25		6.0	24.0	200	50		I 20 R/L	121	121
	I25 R/L 90-2,5 D-N	32		7.0	31.0	250	63		I 25 R/L	126	126
	I32 R/L 90-2,5 D-N	40		9.5	38.0	300	80		I 32 R/L	133 ¹⁾	133 ¹⁾
	I40 R/L 90-2,5 D-N	50		11.5	48.5	350	100		I 40 R/L/N	141	141

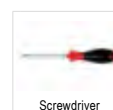
1) With 2 clamping flats



For right-hand holder → use right-hand (or neutral) module
For left-hand holder → use left-hand (or neutral) module

Spare parts For modules

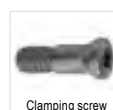
I 16 R/L	T08	110	M2,5x10	440
I 20 R/L	T10	112	M3x11	444
I 25 R/L	T15	113	M3,5x12,5	441
I 32 R/L	T20	114	M4,5x17	445
I 40 R/L/N	T20	114	M5x18	404



Screwdriver

AS

80 950 ...



Clamping screw

AS

70 950 ...

GX09

CW ≤ 1,95 mm
DMIN 20 mm (I16)
DMIN 25 mm (I20)
DMIN 32 mm (I25)



GX09

CW 2,00 - 3,75 mm
DMIN 20 mm (I16)
DMIN 25 mm (I20)
DMIN 32 mm (I25)



GX16

CW ≤ 2,75 mm
DMIN 40 mm (I32)
DMIN 50 mm (I40)



GX16

CW 2,00 - 6,50 mm
DMIN 40 mm (I32)
DMIN 50 mm (I40)



GX24

CW 2,76 - 6,50 mm
DMIN 60 mm (I40)

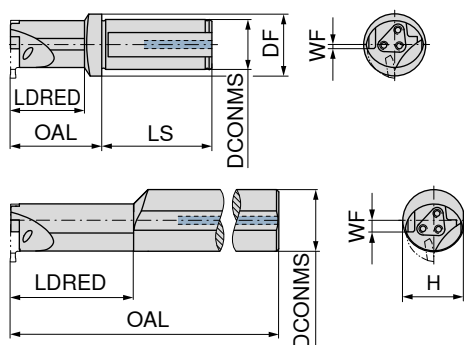


CoreLine – Boring bars GX – ModularClamp

▲ with through coolant

Scope of supply:

Boring bar incl. clamping screw



Illustrations show right-hand versions



	Designation	DCONMS inch	DF inch	WF inch	H inch	OAL inch	LDRED inch	LS inch	For modules
≤ 1,5xD	I16 R/L 90-1.5 D-E	0.750	1.000	0.039	0.728	1.260	0.945	2.000	I 16 R/L
	I20 R/L 90-1.5 D-E	0.750	1.000	0.039	0.953	1.457	1.181	2.000	I 20 R/L
	I25 R/L 90-1.5 D-E	1.000	1.260	0.059	1.216	1.811	1.496	2.250	I 25 R/L
	I32 R/L 90-1.5 D-E	1.250	1.575	0.079	1.425	2.323	1.890	2.500	I 32 R/L
	I40 R/L 90-1.5 D-E	1.500	1.969	0.098	1.941	2.835	2.362	3.000	I 40 R/L/N
≤ 2,5xD	I16 R/L 90-2.5 D-E	0.750	1.000	0.177	0.728	7.000	1.575	2.000	I 16 R/L
	I20 R/L 90-2.5 D-E	1.000	1.000	0.236	0.953	8.000	1.969	2.000	I 20 R/L
	I25 R/L 90-2.5 D-E	1.250	1.260	0.276	1.216	10.000	2.480	2.250	I 25 R/L
	I32 R/L 90-2.5 D-E	1.500	1.969	0.374	1.425	12.000	3.150	2.500	I 32 R/L
	I40 R/L 90-2.5 D-E	2.000	1.575	0.433	1.941	14.000	3.937	3.000	I 40 R/L/N

Left

Right

TO	TO
78 861 ...	78 860 ...
07500 ¹⁾	07500 ¹⁾
07600	07600 ¹⁾
10000 ¹⁾	10000 ¹⁾
12500 ¹⁾	12500
15000 ¹⁾	15000 ¹⁾
27500 ¹⁾	27500 ¹⁾
20000 ¹⁾	20000
22500 ¹⁾	22500 ¹⁾
25000 ¹⁾	25000 ¹⁾
20100 ¹⁾	20100 ¹⁾

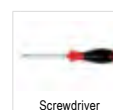
1) Not in stock



For right-hand holder → use right-hand (or neutral) module
For left-hand holder → use left-hand (or neutral) module

Spare parts For modules

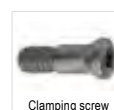
I 16 R/L	T08	110	M2,5x10	440
I 20 R/L	T10	112	M3x11	444
I 25 R/L	T15	113	M3,5x12,5	441
I 32 R/L	T20	114	M4,5x17	445
I 40 R/L/N	T20	114	M5x18	404



Screwdriver

AS

80 950 ...



Clamping screw

AS

70 950 ...

GX09

CW ≤ 1,95 mm
DMIN 20 mm (I16)
DMIN 25 mm (I20)
DMIN 32 mm (I25)



GX09

CW 2,00 - 3,75 mm
DMIN 20 mm (I16)
DMIN 25 mm (I20)
DMIN 32 mm (I25)



GX16

CW ≤ 2,75 mm
DMIN 40 mm (I32)
DMIN 50 mm (I40)



GX16

CW 2,00 - 6,50 mm
DMIN 40 mm (I32)
DMIN 50 mm (I40)



GX24

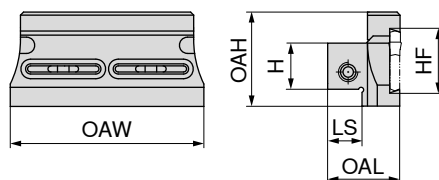
CW 2,76 - 6,50 mm
DMIN 60 mm (I40)



CoreLine – Split clamping block for blades DC

Scope of supply:

Complete clamping block, but without blade



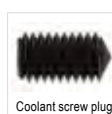
Designation	H mm	HF mm	OAH mm	LS mm	OAL mm	OAW mm	For blades	TO 70 829 ...
SBN 2020-26-DC	20	26	43.0	20	40.0	82	XLC.. 26..	020
SBN 2020-32-DC	20	32	43.0	20	40.0	95	XLC.. 32..	120
SBN 2525-32-DC	25	32	48.5	25	44.5	95	XLC.. 32..	025
SBN 3232-32-DC	32	32	52.0	32	51.0	95	XLC.. 32..	032

Spare parts for article number

		AS 70 950 ...		AS 70 950 ...		AS 70 950 ...
70 829 020	G 1/8"	294	CU70	290	M6x12	861
70 829 120	G 1/8"	294	CU85	291	M6x12	861
70 829 025	G 1/8"	294	CU85	291	M6x12	861
70 829 032	G 1/8"	294	CU85	291	M6x12	861

Spare parts for article number

		AS 70 950 ...		AS 70 950 ...		AS 70 950 ...
70 829 020	SW5	265	19x2,5	293		
70 829 120	SW5	265	19x2,5	293	23x2,5	292
70 829 025	SW5	265			23x2,5	292
70 829 032	SW5	265			23x2,5	292



Coolant screw plug



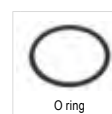
Clamping rail



Tightening screw



Key I



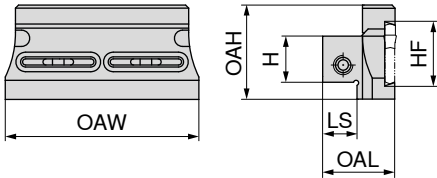
O ring



O ring

CoreLine – Split clamping block for blades DC

Scope of supply:
Complete clamping block, but without blade

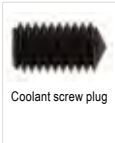


Designation	H inch	HF inch	OAH inch	LS inch	OAL inch	OAW inch	For blades
SBN 12-26-DC-E	0.750	1.024	1.690	0.700	1.487	3.230	XLC.. 26..
SBN 16-32-DC-E	1.000	1.260	1.910	0.950	1.752	3.740	XLC.. 32..
SBN 20-32-DC-E	1.250	1.260	2.037	1.200	2.000	3.740	XLC.. 32..

TO
78 829 ...
07500
10000
12500

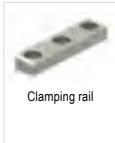
Spare parts
for article number

78 829 07500	G 1/8"	294	CU70	290	M6x12	861
78 829 10000	G 1/8"	294	CU85	291	M6x12	861
78 829 12500	G 1/8"	294	CU85	291	M6x12	861



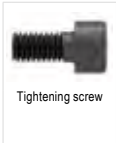
Coolant screw plug

AS
70 950 ...
294



Clamping rail

AS
70 950 ...
290
291
291



Tightening screw

AS
70 950 ...
861
861
861

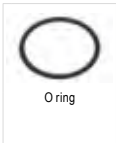
Spare parts
for article number

78 829 07500	19x2,5	293	23x2,5	292
78 829 10000			23x2,5	292
78 829 12500			23x2,5	292



O ring

AS
70 950 ...
293

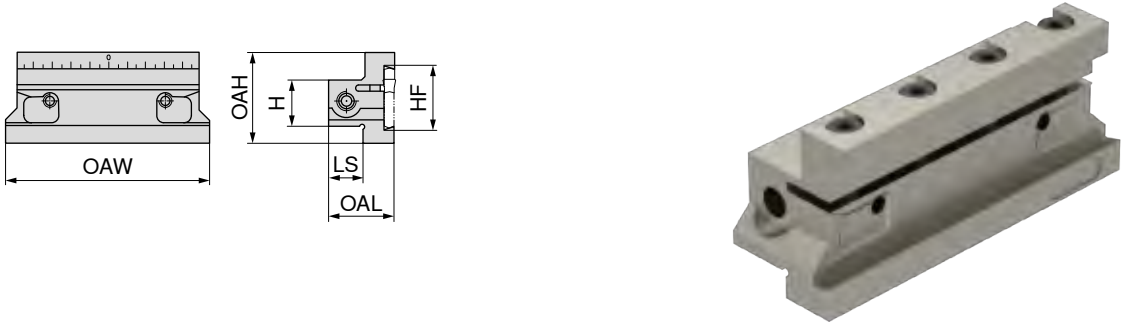


O ring

AS
70 950 ...
292
292

CoreLine – Clamping block for blades

Scope of supply:
Clamping block complete, but without blade and coolant set



Designation	H mm	HF mm	OAH mm	LS mm	OAL mm	OAW mm	For blades	TO 70 830 ...
SBN 2020-26-K	20	26	39	20	33.0	90	XLC.. 26..	020
SBN 2520-32-K	25	32	48	20	36.0	110	XLC.. 32..	025
SBN 3229-32-K	32	32	48	29	44.5	120	XLC.. 32..	032
SBN 3229-46-K	32	46	70	29	52.0	150	XLC.. 46..	132
SBN 4037-46-K	40	46	70	37	60.0	150	XLC.. 46..	140

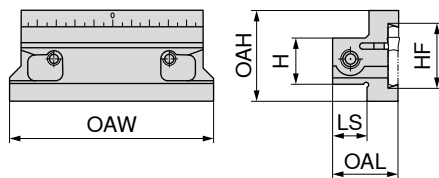
Spare parts
For blades

	Key I	Coolant set	Tightening screw
	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
XLC.. 26..	SW5 265	278	M6x25 269
XLC.. 32..	SW5 265	278	M6x25 269
XLC.. 46..	SW6 266	279	M8x35 282

CoreLine – Clamping block for blades

Scope of supply:

Clamping block complete, but without blade and coolant set



Designation	H inch	HF inch	OAH inch	LS inch	OAL inch	OAW inch	For blades	TO 78 830 ...
SBN 12-26K-E	0.750	1.024	1.535	0.700	1.369	3.540	XLC.. 26..	07500
SBN 16-32K-E	1.000	1.260	1.890	0.950	1.647	4.330	XLC.. 32..	10000
SBN 20-32K-E	1.250	1.260	1.890	1.200	1.909	4.720	XLC.. 32..	12500
SBN 20-46K-E	1.250	1.811	2.756	1.200	2.106	5.910	XLC.. 46..	12600 ¹⁾
SBN 24-46K-E	1.500	1.811	2.756	1.450	2.362	5.910	XLC.. 46..	15000

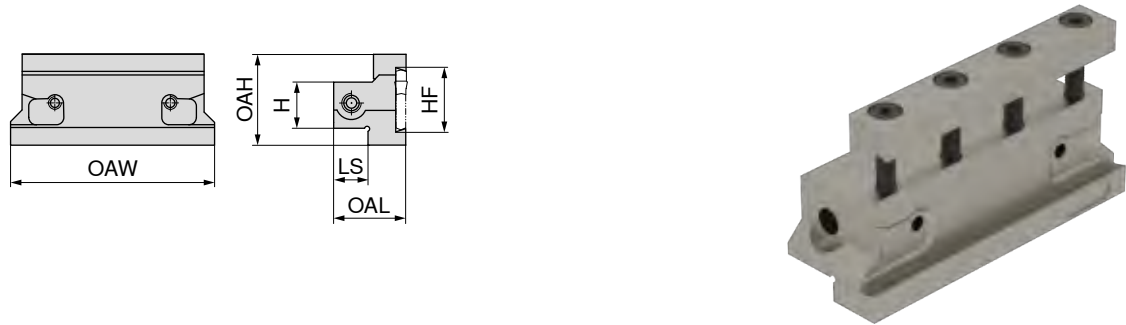
¹⁾ Not in stock

Spare parts For blades

	Key I	Coolant set	Tightening screw
	AS 70 950 ...	AS 70 950 ...	AS 70 950 ...
XLC.. 26..	SW5 265	278	M6x25 269
XLC.. 32..	SW5 265	278	M6x25 269
XLC.. 46..	SW6 266	279	M8x35 282

CoreLine – Split clamping block for blades

Scope of supply:
Clamping block complete, but without blade and coolant set

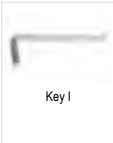


Designation	H mm	HF mm	OAH mm	LS mm	OAL mm	OAW mm	For blades
SBN 2020-26-KS	20	26	39	20	35.0	90	XLC.. 26..
SBN 2520-32-KS	25	32	48	20	38.0	110	XLC.. 32..
SBN 3229-32-KS	32	32	48	29	46.5	120	XLC.. 32..

TO
70 831 ...
020
025
032

Spare parts
For blades

XLC.. 26..	SW5	265	278	M6x25	269
XLC.. 32..	SW5	265	278	M6x25	269

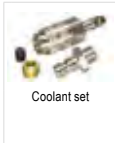


Key I

AS

70 950 ...

265



Coolant set

AS

70 950 ...

278



Tightening screw

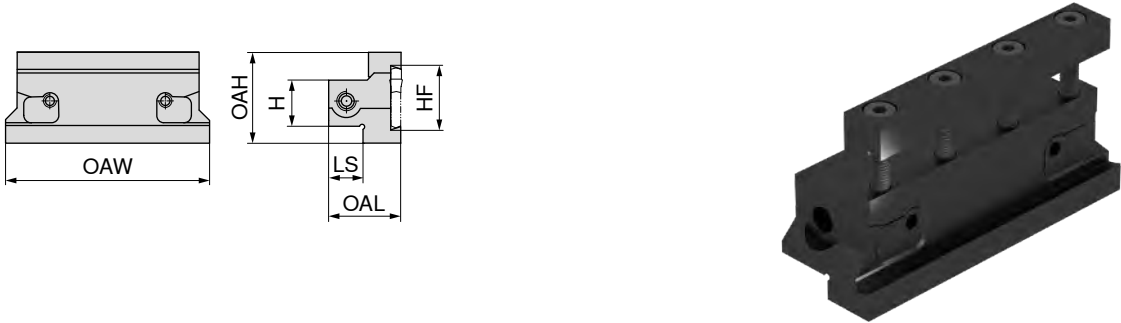
AS

70 950 ...

269

CoreLine – Split clamping block for blades

Scope of supply:
Clamping block complete, but without blade and coolant set



Designation	H inch	HF inch	OAH inch	LS inch	OAL inch	OAW inch	For blades
SBN 12-26KS-E	0.750	1.024	1.688	0.700	1.369	3.540	XLC.. 26..
SBN 16-32KS-E	1.000	1.260	1.929	0.950	1.647	4.330	XLC.. 32..
SBN 20-32KS-E	1.250	1.260	2.044	1.200	1.909	4.720	XLC.. 32..

TO
78 831 ...
07500
10000
12500

Spare parts
For blades

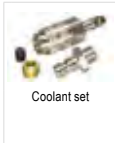
XLC.. 26..	SW5	265	278	M6x25	269
XLC.. 32..	SW5	265	278	M6x25	269



Key I

AS

70 950 ...



Coolant set

AS

70 950 ...



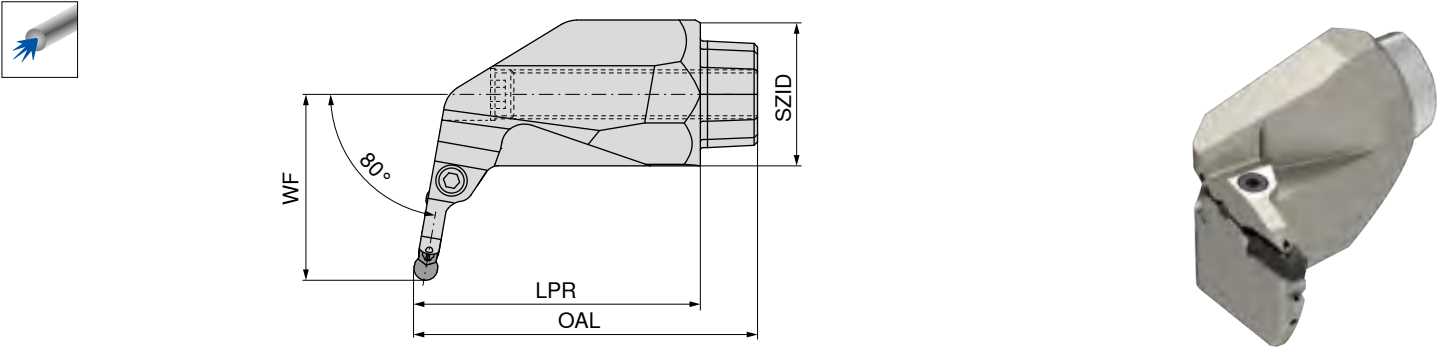
Tightening screw

AS

70 950 ...

MaxiGroove – X32-4S 80° – Reinforced tool head for axial clamping – OvalFlex

▲ Optimized for X32-R4.00... inserts



Illustrations show right-hand versions

Designation	Adapter	WF mm	OAL mm	LPR mm	SZID	Indexable insert	Left	Right
							TO 74 596 ... 08001	TO 74 596 ... 08000
OC50 X32 4S L 80H	OC50	65	120	100	50	X32.. R4..		
OC50 X32 4S R 80H	OC50	65	120	100	50	X32.. R4..		

→ Find suitable indexable inserts here.

A detailed operating manual is available for download in the online shop next to the product.

Spare parts for article number

74 596 08001	M6x20 Sw5	17600
74 596 08000	M6x20 Sw5	17600

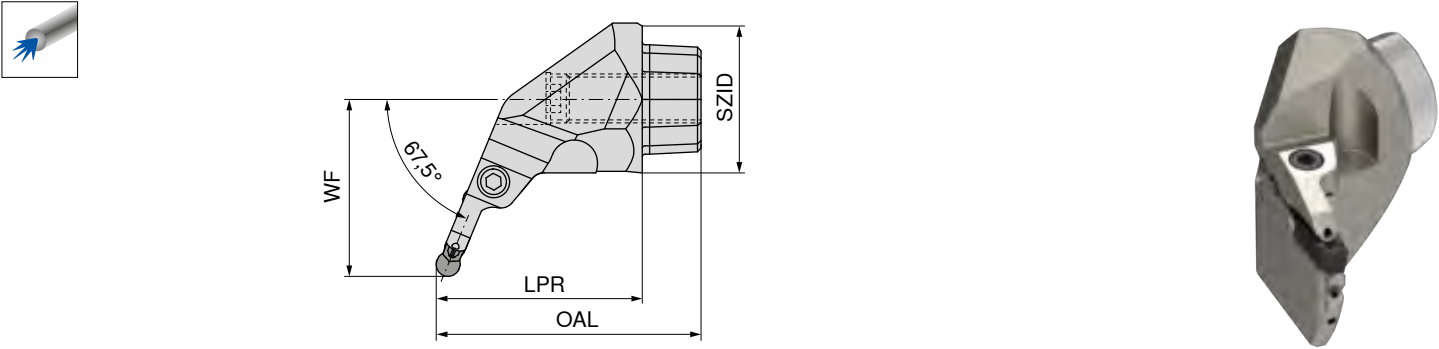


Fixing screw

FI
10 950 ...
17600

MaxiGroove – X32-4S 67.5° – Reinforced tool head for axial clamping – OvalFlex

▲ Optimized for X32-R4.00... inserts



Illustrations show right-hand versions

Designation	Adapter	WF mm	OAL mm	LPR mm	SZID	Indexable insert
OC50 X32 4S L 67.5E	OC50	60	90	70	50	X32.. R4..
OC50 X32 4S R 67.5E	OC50	60	90	70	50	X32.. R4..

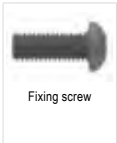
Left	Right
TO	TO
74 596 ...	74 596 ...
06701	06700

→ Find suitable indexable inserts here.

A detailed operating manual is available for download in the online shop next to the product.

Spare parts
for article number

74 596 06701	M6x20 Sw5	17600
74 596 06700	M6x20 Sw5	17600

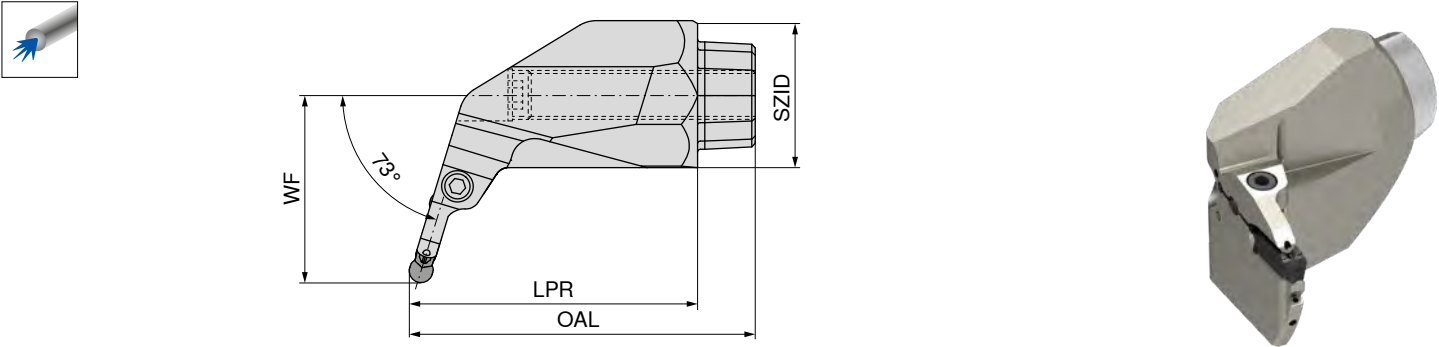


Fixing screw

FI
10 950 ...
17600

MaxiGroove – X32-4S 73° – Reinforced tool head for axial clamping – OvalFlex

▲ Optimized for X32-R4.00... inserts



Illustrations show right-hand versions

Designation	Adapter	DF mm	WF mm	OAL mm	LPR mm	SZID	Indexable insert
OC50 X32 4S L 73H	OC50	60	65	120	100	50	X32.. R4..
OC50 X32 4S R 73H	OC50	60	65	120	100	50	X32.. R4..

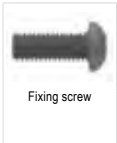
Left	Right
TO	TO
74 596 ...	74 596 ...
07301	07300

→ Find suitable indexable inserts here.

A detailed operating manual is available for download in the online shop next to the product.

Spare parts
for article number

74 596 07301	M6x20 Sw5	17600
74 596 07300	M6x20 Sw5	17600

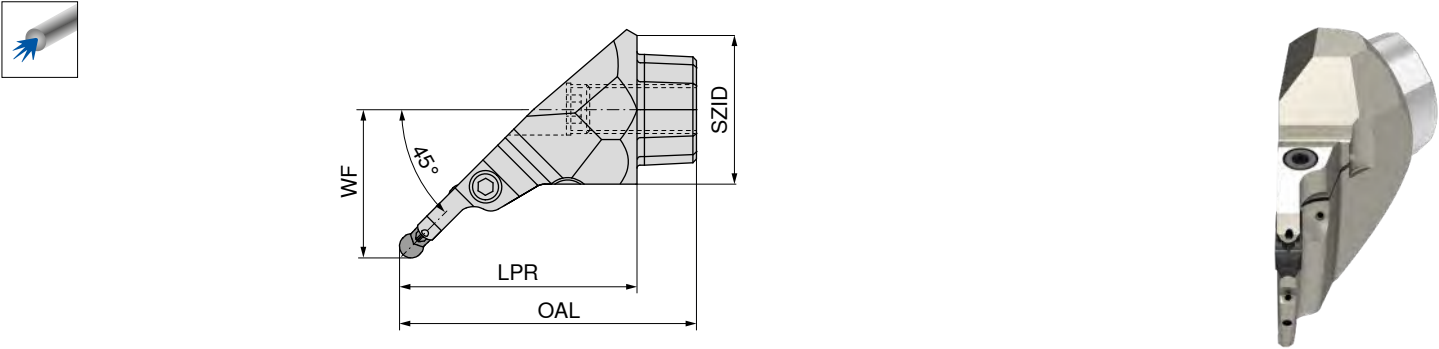


Fixing screw

FI
10 950 ...
17600

MaxiGroove – X32-4S 45° – Reinforced tool head for axial clamping – OvalFlex

▲ Optimized for X32-R4.00... inserts



Illustrations show right-hand versions

Designation	Adapter	WF mm	OAL mm	LPR mm	SZID	Indexable insert	Left	Right
							TO 74 596 ... 04501	TO 74 596 ... 04500
OC50 X32 4S L 45E	OC50	50	90	70	50	X32.. R4..		
OC50 X32 4S R 45F	OC50	50	90	70	50	X32.. R4..		

→ Find suitable indexable inserts here.

A detailed operating manual is available for download in the online shop next to the product.

Spare parts
for article number

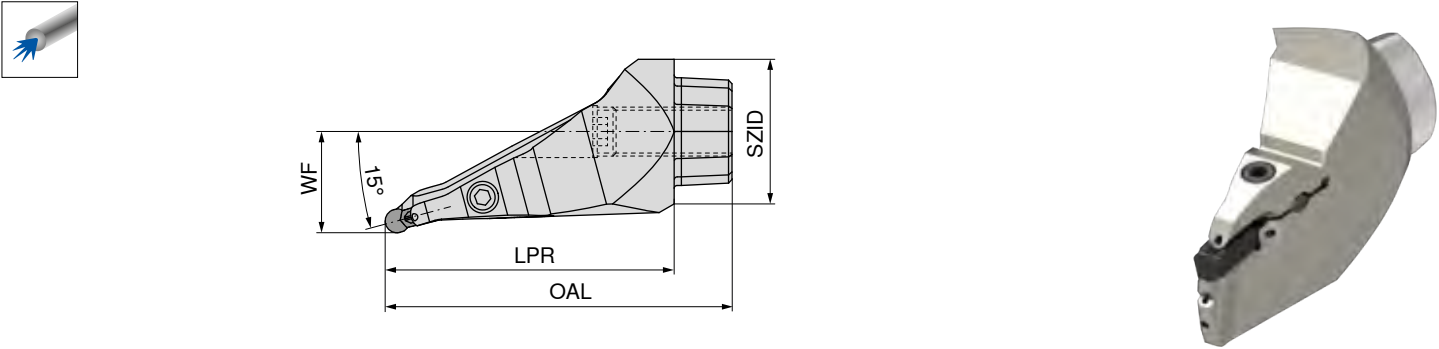
74 596 04501	M16x7,5x1,5 - SW8	AS 70 950 ... 91000	M6x20 Sw5	FI 10 950 ... 17600
74 596 04500	M16x7,5x1,5 - SW8	91000	M6x20 Sw5	17600



AS	FI
70 950 ...	10 950 ...

MaxiGroove – X32-4S 15° – Reinforced tool head for axial clamping – OvalFlex

▲ Optimized for X32-R4.00... inserts



Illustrations show right-hand versions

Designation	Adapter	WF mm	OAL mm	LPR mm	SZID	Indexable insert
OC50 X32 4S L 15H	OC50	36	120	100	50	X32.. R4..
OC50 X32 4S R 15H	OC50	36	120	100	50	X32.. R4..

Left	Right
TO	TO
74 596 ...	74 596 ...
01501	01500

→ Find suitable indexable inserts here.

A detailed operating manual is available for download in the online shop next to the product.

Spare parts
for article number

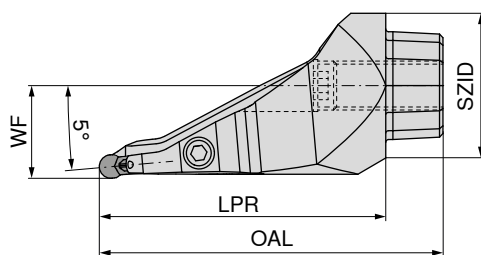
74 596 01501	M16x7,5x1,5 - SW8	AS	FI
74 596 01500		70 950 ...	10 950 ...
		91000	17600
			17600



Cap screw

Fixing screw

▲ Optimized for X32-R4.00... inserts



Illustrations show right-hand versions



Left

Right

Designation	Adapter	WF mm	OAL mm	LPR mm	SZID	Indexable insert		74 596 ...	74 596 ...
OC50 X32 4S L 05H	OC50	32	120	100	50	X32.. R4..		00501	
OC50 X32 4S R 05H	OC50	32	120	100	50	X32.. R4..			00500



→ Find suitable indexable inserts here.

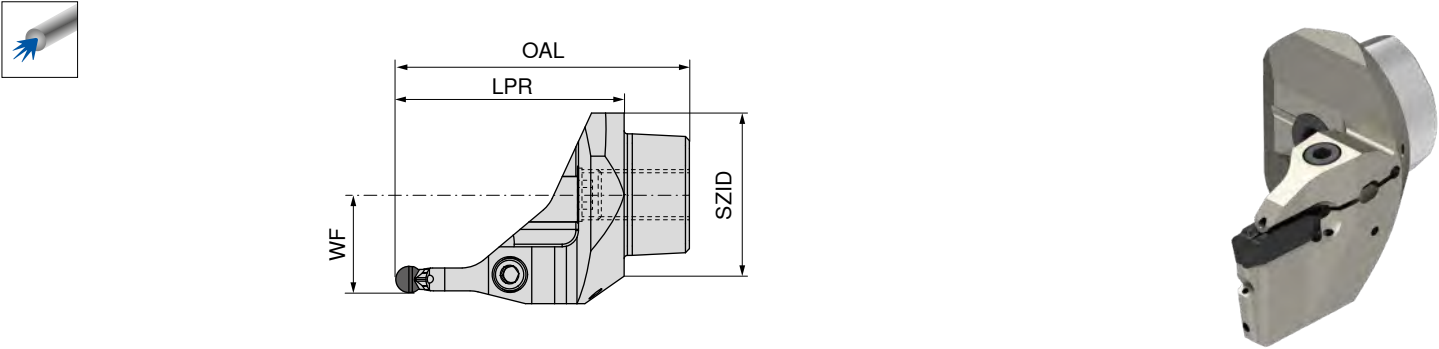


A detailed operating manual is available for download in the online shop next to the product.

Spare parts for article number	62 950 ...	70 950 ...	10 950 ...
74 596 00501		91000	17600
74 596 00500	M6X30 45700	M16x7,5x1,5 - SW8 91000	M6x20 Sw5

MaxiGroove – X32-4S 0° – Reinforced tool head for axial clamping – OvalFlex

▲ Optimized for X32-R4.00... inserts



Illustrations show right-hand versions

Designation	Adapter	WF mm	OAL mm	LPR mm	SZID	Indexable insert
OC50 X32 4S L 00E	OC50	30	90	70	50	X32.. R4..
OC50 X32 4S R 00E	OC50	30	90	70	50	X32.. R4..

Left	Right
TO	TO
74 596 ...	74 596 ...
00001	00000

→ Find suitable indexable inserts here.

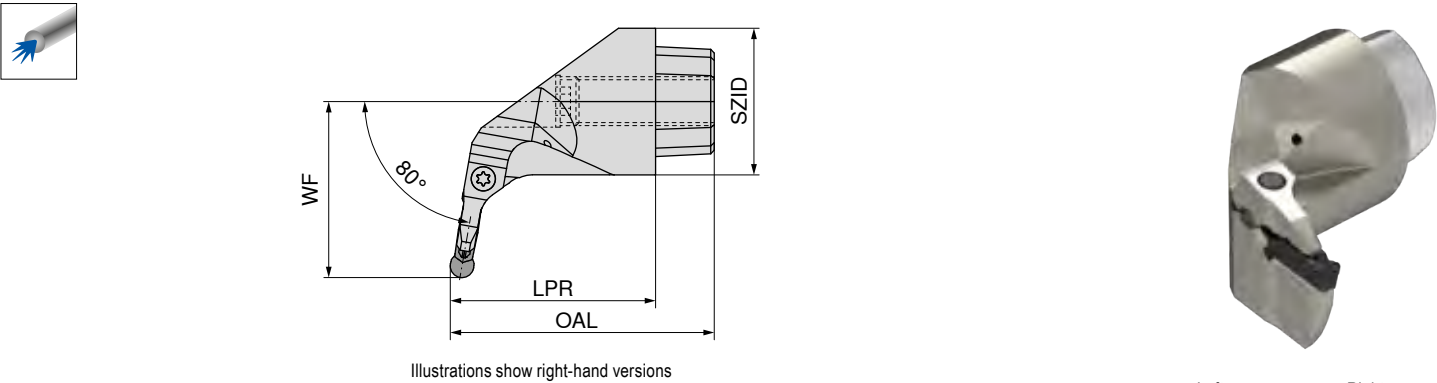
A detailed operating manual is available for download in the online shop next to the product.

Spare parts
for article number

74 596 00001	M16x7,5x1,5 - SW8	91000	M6x20 Sw5	17600
74 596 00000			M6x20 Sw5	17600

 Cap screw	 Fixing screw
AS	FI
70 950 ...	10 950 ...

MaxiGroove – X32 80° – Tool head for axial clamping – OvalFlex



Illustrations show right-hand versions

Designation	Adapter	WF mm	OAL mm	LPR mm	SZID mm	Indexable insert	Left	Right
							TO 74 597 ... 08001	TO 74 597 ... 08000
OC50 X32 L 80E	OC50	60	90	70	50	X32..		
OC50 X32 R 80E	OC50	60	90	70	50	X32..		

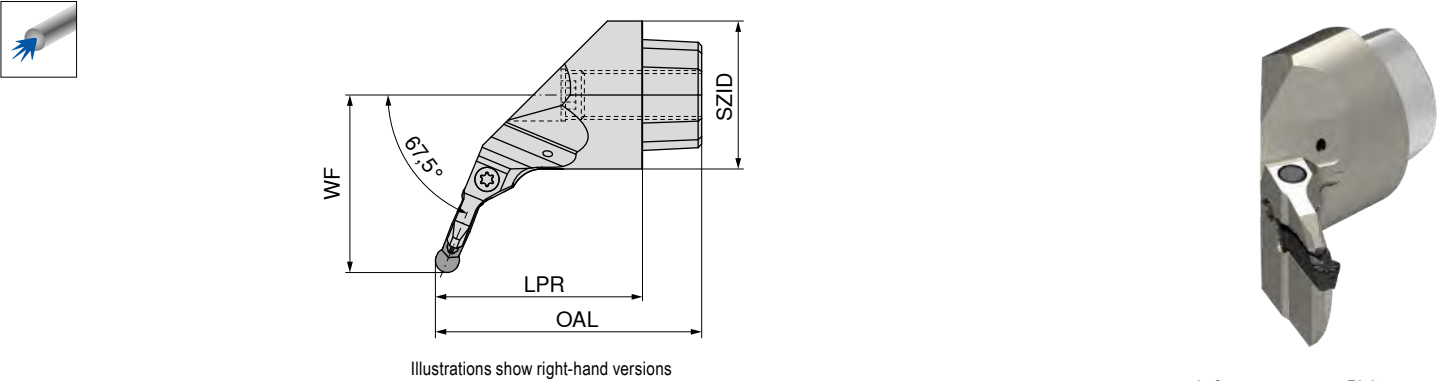
→ Find suitable indexable inserts here.

A detailed operating manual is available for download in the online shop next to the product.

Spare parts
for article number

				
			AS 70 950 ...	AS 70 950 ...
74 597 08001	T25	90500	M5x20	90600
74 597 08000	T25	90500	M5x20	90600

MaxiGroove – X32 67.5° – Tool head for axial clamping – OvalFlex



Illustrations show right-hand versions

Designation	Adapter	WF mm	OAL mm	LPR mm	SZID mm	Indexable insert	Left	Right
							TO 74 597 ... 16701	TO 74 597 ... 16700 06700 06701
OC50 X32 L 67.5C	OC50	60	70	50	50	X32..		
OC50 X32 R 67.5C	OC50	60	70	50	50	X32..		16700
OC50 X32 R 67.5E	OC50	60	90	70	50	X32..		06700
OC50 X32 L 67.5E	OC50	60	90	70	50	X32..	06701	

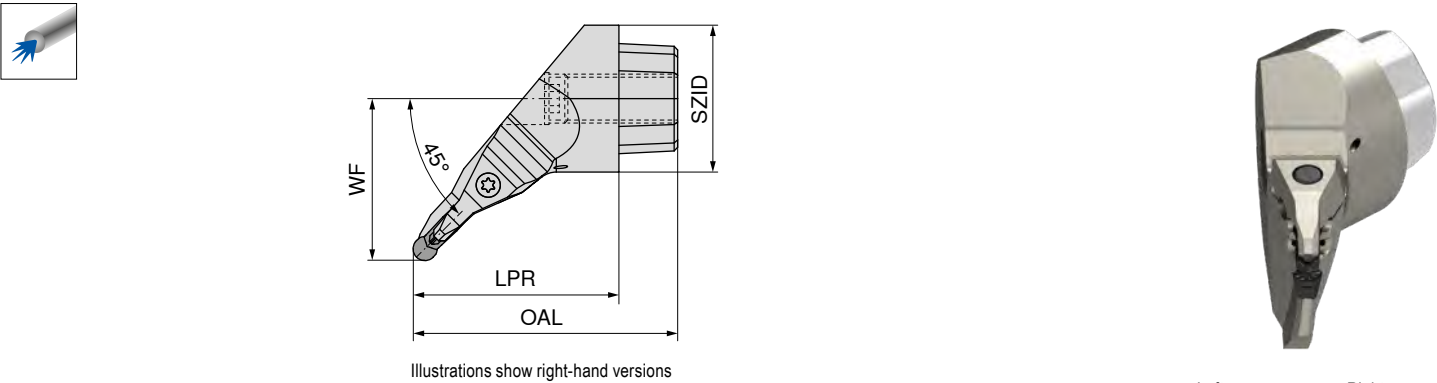
 → Find suitable indexable inserts here.

 A detailed operating manual is available for download in the online shop next to the product.

Spare parts
for article number

						
				AS 70 950 ...		AS 70 950 ...
74 597 16701	T25	90500	M5x20	90600		
74 597 16700	T25	90500	M5x20	90600		
74 597 06700	T25	90500	M5x20	90600		
74 597 06701	T25	90500	M5x20	90600		

MaxiGroove – X32 45° – Tool head for axial clamping – OvalFlex



Illustrations show right-hand versions

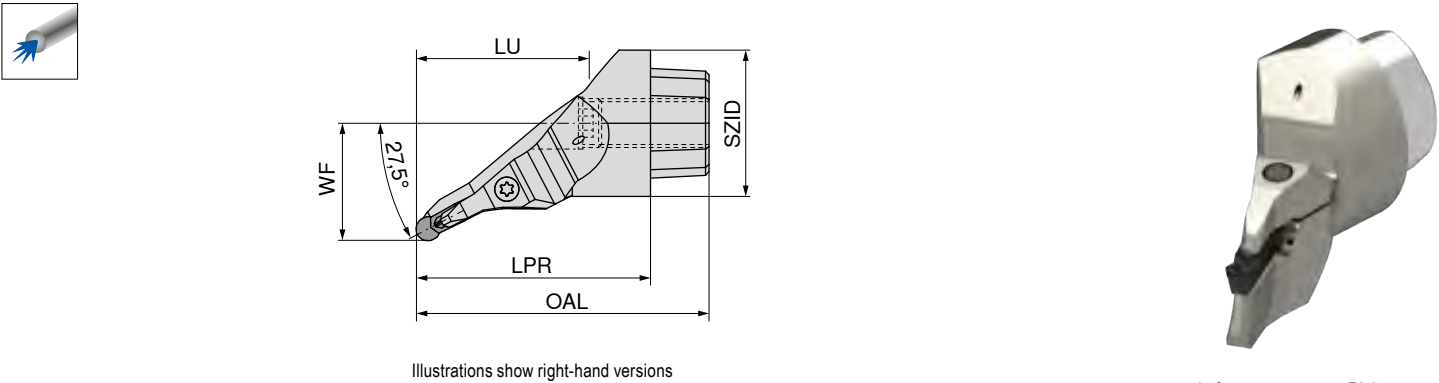
Designation	Adapter	WF mm	OAL mm	LPR mm	SZID mm	Indexable insert	Left	Right
							TO 74 597 ... 04501	TO 74 597 ... 04500
OC50 X32 L 45E	OC50	55	90	70	50	X32..		
OC50 X32 R 45E	OC50	55	90	70	50	X32..		

→ Find suitable indexable inserts here.

A detailed operating manual is available for download in the online shop next to the product.

Spare parts for article number		Cap screw		Key T		Clamping screw	
		AS 70 950 ...		AS 70 950 ...		AS 70 950 ...	
74 597 04501	M16x7,5x1,5 - SW8	91000	T25	90500	M5x20	90600	
74 597 04500	M16x7,5x1,5 - SW8	91000	T25	90500	M5x20	90600	

MaxiGroove – X32 27.5° – Tool head for axial clamping – OvalFlex



Illustrations show right-hand versions

Designation	Adapter	WF mm	LU mm	OAL mm	LPR mm	SZID mm	Indexable insert	Left	Right
								TO 74 597 ... 02701	TO 74 597 ... 02700
OC50 X32 L 27.5F	OC50	40	60	100	80	50	X32..		
OC50 X32 R 27.5F	OC50	40	60	100	80	50	X32..		



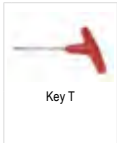
→ Find suitable indexable inserts here.



A detailed operating manual is available for download in the online shop next to the product.

Spare parts for article number

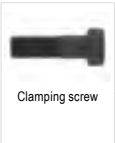
74 597 02701	T25	70 950 ... 90500	M5x20	70 950 ... 90600
74 597 02700	T25	70 950 ... 90500	M5x20	70 950 ... 90600



Key T

AS

70 950 ...

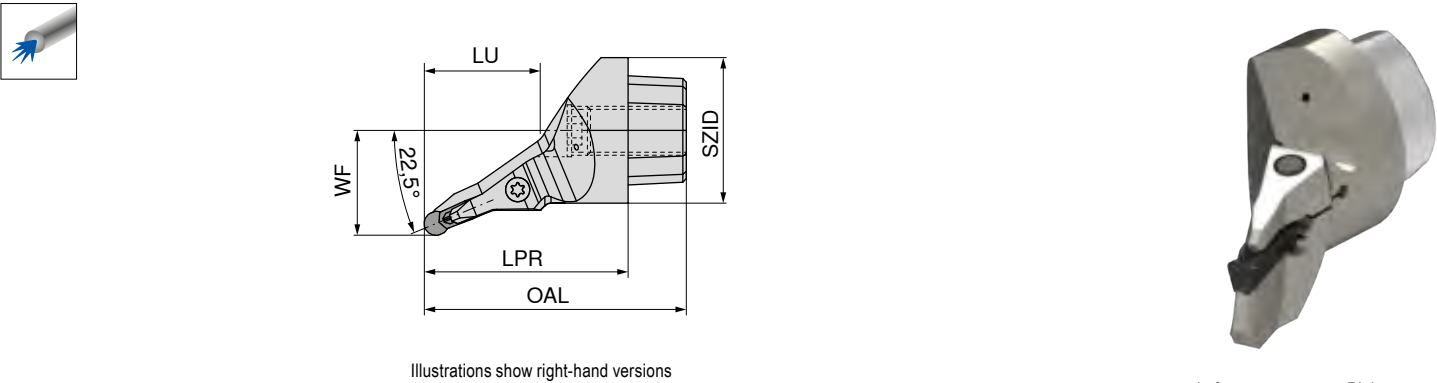


Clamping screw

AS

70 950 ...

MaxiGroove – X32 22.5° – Tool head for axial clamping – OvalFlex



Illustrations show right-hand versions

Designation	Adapter	WF mm	LU mm	OAL mm	LPR mm	SZID mm	Indexable insert	Left	Right
								TO 74 597 ... 02201	TO 74 597 ... 02200
OC50 X32 L 22.5E	OC50	36	40	90	70	50	X32..		
OC50 X32 R 22.5E	OC50	36	40	90	70	50	X32..		



→ Find suitable indexable inserts here.

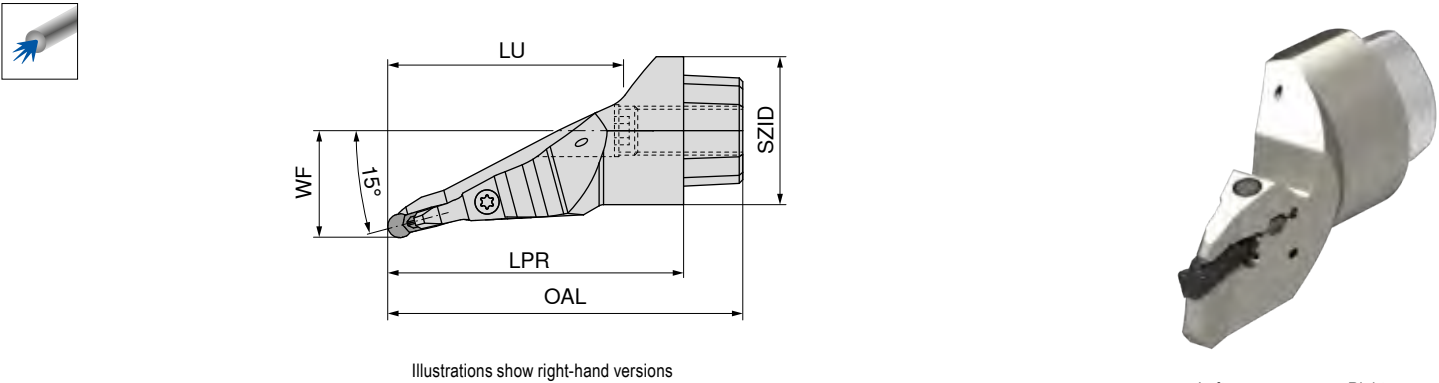


A detailed operating manual is available for download in the online shop next to the product.

Spare parts for article number

74 597 02201	T25	Key T	AS 70 950 ... 90500	M5x20	Clamping screw	AS 70 950 ... 90600
74 597 02200	T25		90500	M5x20		90600

MaxiGroove – X32 15° – Tool head for axial clamping – OvalFlex



Illustrations show right-hand versions

Designation	Adapter	WF mm	LU mm	OAL mm	LPR mm	SZID mm	Indexable insert	Left	Right
								TO 74 597 ... 01501	TO 74 597 ... 01500
OC50 X32 L 15H	OC50	36	80	120	100	50	X32..		
OC50 X32 R 15H	OC50	36	80	120	100	50	X32..		



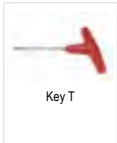
→ Find suitable indexable inserts here.



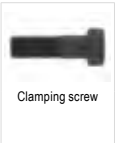
A detailed operating manual is available for download in the online shop next to the product.

Spare parts for article number

74 597 01501	T25	AS 70 950 ... 90500	M5x20	AS 70 950 ... 90600
74 597 01500	T25	90500	M5x20	90600

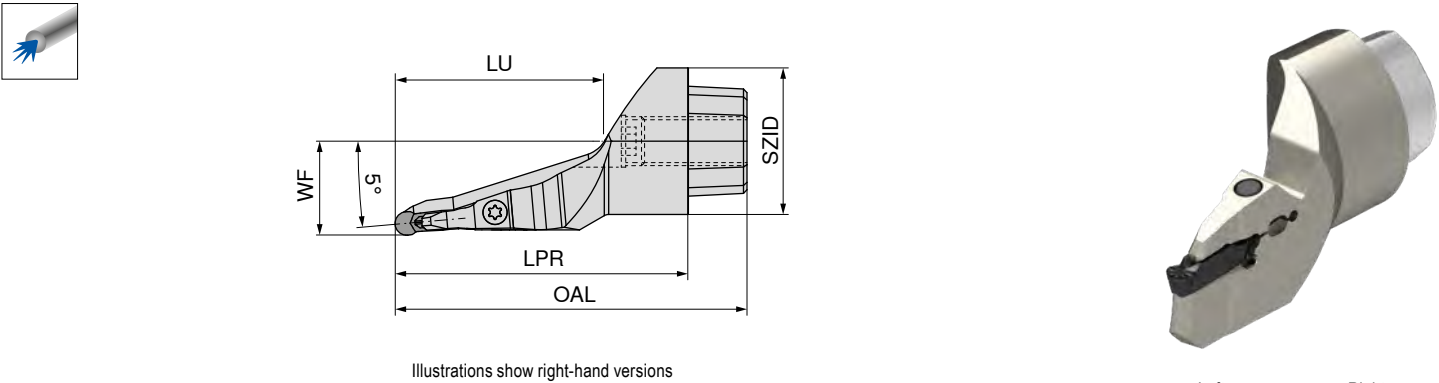


Key T



Clamping screw

MaxiGroove – X32 5° – Tool head for axial clamping – OvalFlex



Illustrations show right-hand versions

Designation	Adapter	WF mm	LU mm	OAL mm	LPR mm	SZID	Indexable insert	Left	Right
								TO 74 597 ... 00501	TO 74 597 ... 00500
OC50 X32 L 05H	OC50	32	66	120	100	50	X32..		
OC50 X32 R 05H	OC50	32	66	120	100	50	X32..		



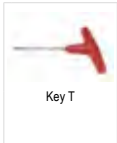
→ Find suitable indexable inserts here.



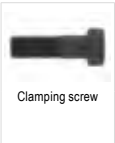
A detailed operating manual is available for download in the online shop next to the product.

Spare parts for article number

74 597 00501	T25	AS 70 950 ... 90500	M5x20	AS 70 950 ... 90600
74 597 00500	T25	90500	M5x20	90600

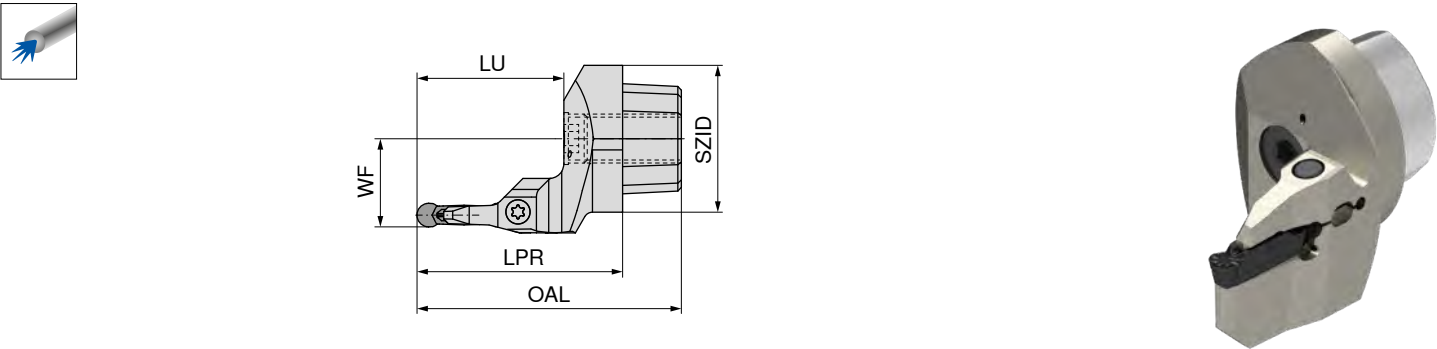


Key T



Clamping screw

MaxiGroove – X32 0° – Tool head for axial clamping – OvalFlex



Illustrations show right-hand versions

Designation	Adapter	WF mm	LU mm	OAL mm	LPR mm	SZID mm	Indexable insert	Left	Right
								TO 74 597 ... 00001	TO 74 597 ... 00000
OC50 X32 L 00E	OC50	30	50	90	70	50	X32..		
OC50 X32 R 00E	OC50	30	50	90	70	50	X32..		



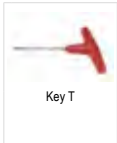
→ Find suitable indexable inserts here.



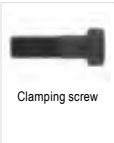
A detailed operating manual is available for download in the online shop next to the product.

Spare parts for article number

74 597 00001	T25	AS 70 950 ... 90500	M5x20	AS 70 950 ... 90600
74 597 00000	T25	90500	M5x20	90600

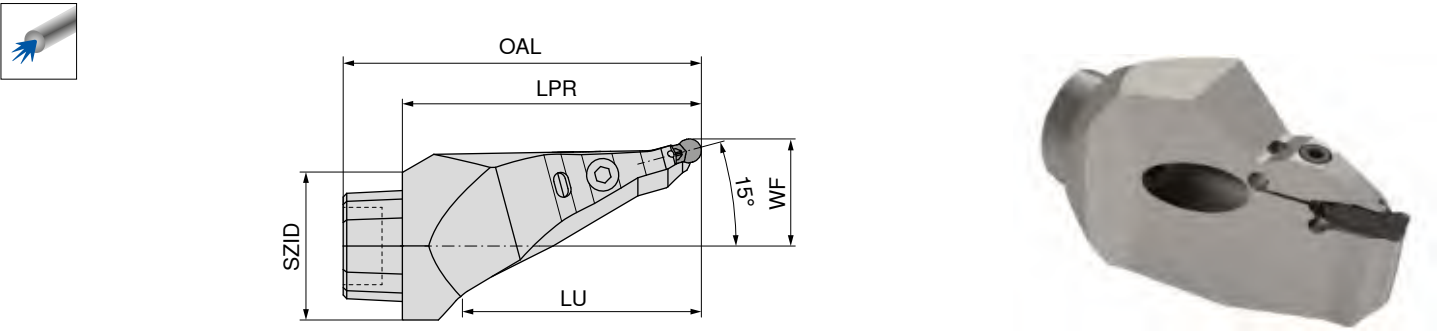


Key T



Clamping screw

MaxiGroove – X32 15° – Tool head for radial clamping – OvalFlex



Designation	Adapter	WF mm	LU mm	OAL mm	LPR mm	SZID	Indexable insert
OC50S X32 R 15H	OC50S	36	80	120	100	50	X32..

Right
TO
74 597 ...
11500

→ Find suitable indexable inserts here.

Spare parts
for article number

74 597 11500

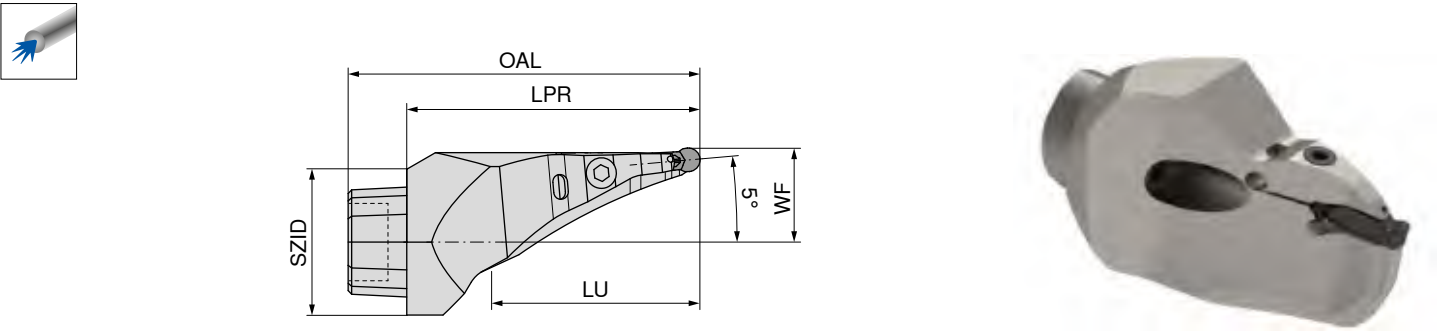
M6X30



Cylindrical screw

FI
62 950 ...
45700

MaxiGroove – X32 5° – Tool head for radial clamping – OvalFlex



Designation	Adapter	WF mm	LU mm	OAL mm	LPR mm	SZID	Indexable insert
OC50S X32 R 05H	OC50	32	66	120	100	50	X32..

Right
TO
74 597 ...
10500

→ Find suitable indexable inserts here.

Spare parts
for article number

74 597 10500

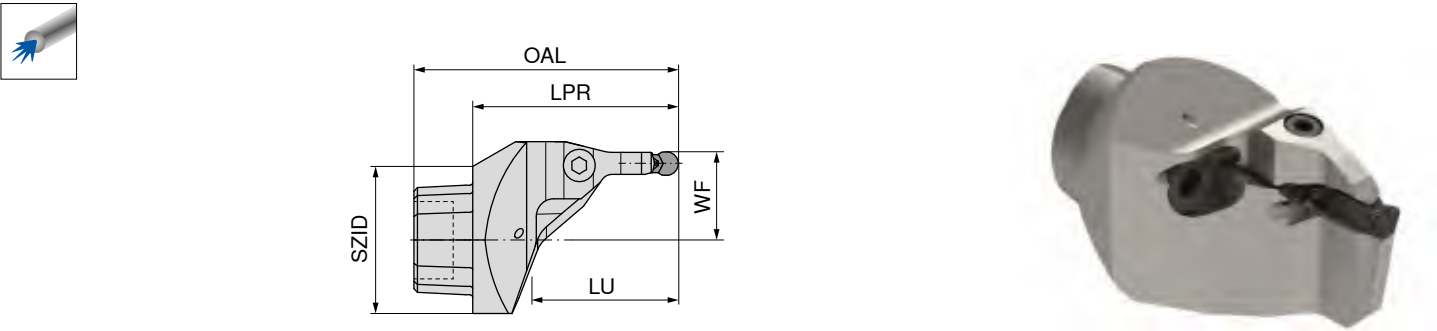
M6X30



Cylindrical screw

FI
62 950 ...
45700

MaxiGroove – X32 0° – Tool head for radial clamping – OvalFlex



Designation	Adapter	WF mm	LU mm	OAL mm	LPR mm	SZID	Indexable insert
OC50S X32 R 00E	OC50S	30	50	90	70	50	X32..

Right

TO

74 597 ...

10000

→ Find suitable indexable inserts here.

Spare parts
for article number

74 597 10000

M6X30

Cylindrical screw

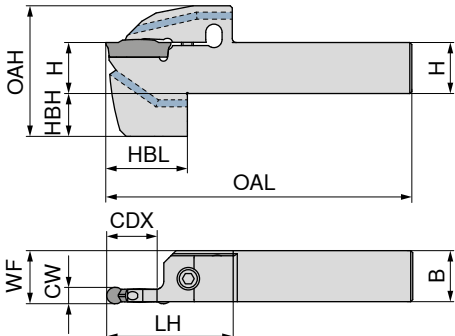
FI

62 950 ...

45700

MaxiGroove – Parting blade holder X32 0°

▲ Optimized for X32-R4.00... inserts



Illustrations show right-hand versions



Designation	B mm	H mm	WF mm	CW mm	LH mm	CDX mm	OAH mm	HBH mm	HBL mm	OAL mm	Indexable insert
E25 L 00 2525 M X32-4	25	25	26	8	70	24	64	21	40	150	X32.. R4..
E25 R 00 2525 M X32-4	25	25	26	8	70	24	64	21	40	150	X32.. R4..
E32 L 00 3232 P X32-4	32	32	33	8	62	24	71	21	40	170	X32.. R4..
E32 R 00 3232 P X32-4	32	32	33	8	62	24	71	21	40	170	X32.. R4..

Left	Right
TO	TO
74 848 ...	74 848 ...
02501	02500
03201	03200



→ Find suitable indexable inserts here.

Spare parts for article number

74 848 02501	M6x25	269
74 848 02500	M6x25	269
74 848 03201	M6x25	269
74 848 03200	M6x25	269



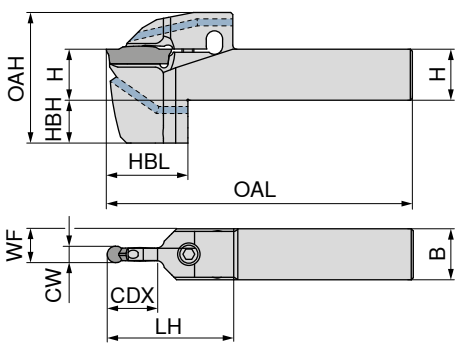
Tightening screw

AS

70 950 ...

MaxiGroove – Parting blade holder X32 0°

▲ Optimized for X32-R4.00... inserts



Neutral

Designation	B mm	H mm	WF mm	CW mm	LH mm	CDX mm	OAH mm	HBH mm	HBL mm	OAL mm	Indexable insert
E25 N 00 2525 M X32-4	25	25	0	8	70	24	64	21	40	150	X32.. R4..
E32 N 00 3232 P X32-4	32	32	0	8	62	24	71	21	40	170	X32.. R4..

TO

74 848 ...
02502
03202



→ Find suitable indexable inserts here.

Spare parts
for article number

74 848 02502	M6x25	269
74 848 03202	M6x25	269

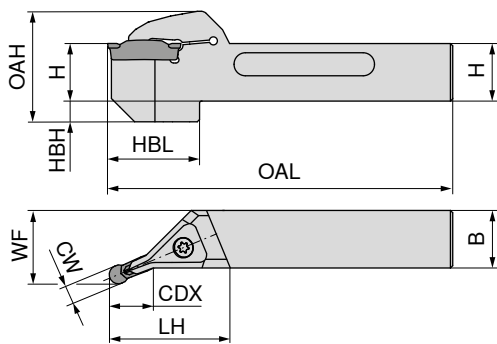


Tightening screw

AS

70 950 ...

MaxiGroove – Parting blade holder X32 22.5°



Illustrations show right-hand versions



Designation	H mm	B mm	OAL mm	LH mm	CDX mm	HBL mm	HBH mm	OAH mm	WF mm	Indexable insert	Left	Right
											TO	TO
X32 L 22.5 2525 M	25	25	150	50	24	40	9	48	32	X32..	70 849 ... 02501	70 849 ... 02500
X32 R 22.5 2525 M	25	25	150	50	24	40	9	48	32	X32..		
X32 L 22.5 3225 P	32	25	170	50	24	40	4	50	32	X32..	03201	03200
X32 R 22.5 3225 P	32	25	170	50	24	40	4	50	32	X32..		



→ Find suitable indexable inserts here.

Spare parts
for article number

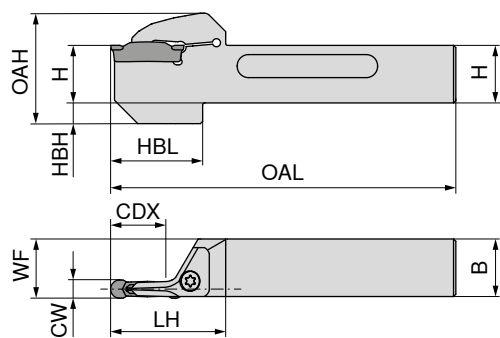
70 849 02501	M6x25	269
70 849 02500	M6x25	269
70 849 03201	M6x25	269
70 849 03200	M6x25	269



Tightening screw

AS
70 950 ...

MaxiGroove – Parting blade holder X32 0°



Illustrations show right-hand versions



Designation	H mm	B mm	OAL mm	LH mm	CDX mm	HBL mm	HBH mm	OAH mm	WF mm	Indexable insert
X32 L 00 2525 M	25	25	150	50	24	40	9	48	25.5	X32..
X32 R 00 2525 M	25	25	150	50	24	40	9	48	25.5	X32..
X32 L 00 3225 P	32	25	170	50	24	40	4	50	25.5	X32..
X32 R 00 3225 P	32	25	170	50	24	40	4	50	25.5	X32..

Left	Right
TO	TO
70 848 ...	70 848 ...
02501	02500
03201	03200



→ Find suitable indexable inserts here.

Spare parts
for article number

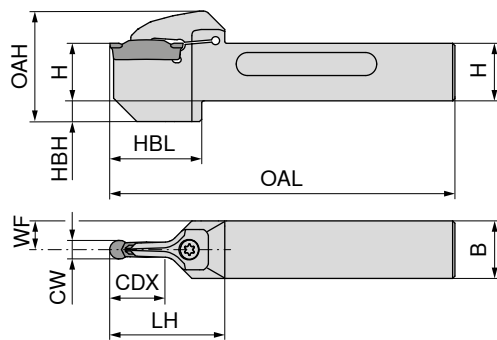
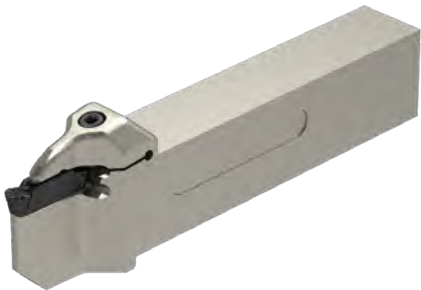
70 848 02501	M6x25	269
70 848 02500	M6x25	269
70 848 03201	M6x25	269
70 848 03200	M6x25	269



Tightening screw

AS
70 950 ...

MaxiGroove – Parting blade holder X32 0°



Designation	H	B	OAL	LH	CDX	HBL	HBH	OAH	WF	Indexable insert
	mm	mm	mm	mm	mm	mm	mm	mm	mm	
X32 N 00 2525 M	25	25	150	50	24	40	9	48	0	X32..
X32 N 00 3225 P	32	25	170	50	24	40	4	50	0	X32..

Neutral

TO

70 848 ...
02502
03202



→ Find suitable indexable inserts here.



Tightening screw

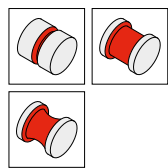
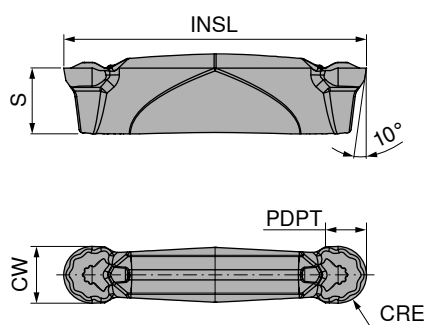
AS

70 950 ...

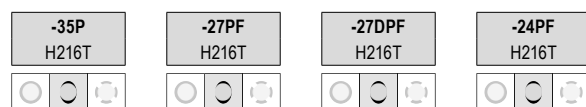
Spare parts
for article number

70 848 02502	M6x25	269
70 848 03202	M6x25	269

MaxiGroove – Carbide grooving insert – X32



Designation	INSL mm	CW mm	PDPT mm	CRE mm	S mm
X32 R3.00 N	32	6	4.5	3	6.4
X32 R4.00 EN	32	8	6.0	4	6.4
X32 R4.00 N	32	8	6.0	4	6.4



F	F	F	F
AO	AO	AO	AO
70 227 ...	70 227 ...	70 227 ...	70 227 ...
	63400	61200	60200
64200	63600	61400	60400

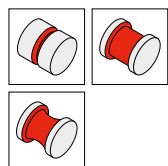
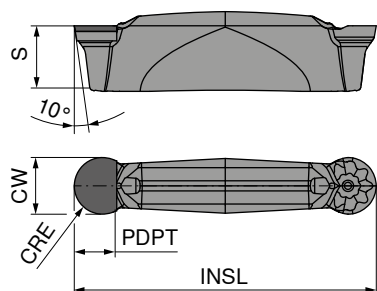
P				
M				
K				
N				
S				
H				
O				



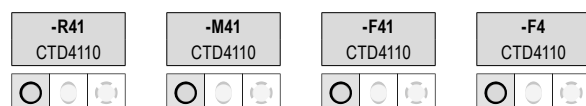
→ Find the recommended values for cutting speeds here.

MaxiGroove – PCD grooving insert – X32

▲ TCE(NOI) = Design and number of equipped cutting edge corners



Designation	INSL mm	CW mm	PDPT mm	CRE mm	S mm	TCE
X32 R3.00 TN	32	6	2	3	6.4	A
X32 R3.00 FN	32	6	2	3	6.4	A
X32 R4.00 TN	32	8	2	4	6.4	A
X32 R4.00 FN	32	8	2	4	6.4	A



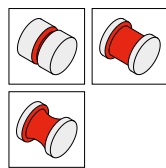
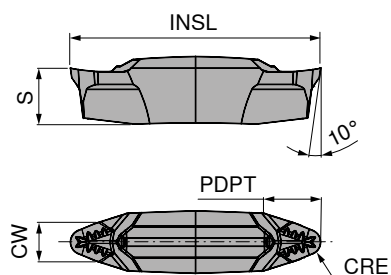
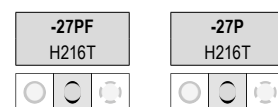
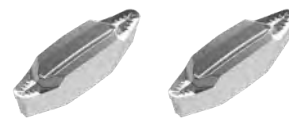
R	M	F	F
PC	PC	PC	PC
74 295 ...	74 294 ...	74 293 ...	74 292 ...
60502	60502	60502	60502
60002	60002	60002	60002
60602	60602	60602	60602
60102	60102	60102	60102

P				
M				
K				
N				
S				
H				
O				



→ Find the recommended values for cutting speeds here.

MaxiGroove – Carbide grooving insert – X32



Designation	INSL mm	CW mm	PDPT mm	CRE mm	S mm
X32 R1.60 VN	32	3.2	6	1.6	6.4
X32 R2.00 VN	32	4.0	6	2.0	6.4

F	F
AO	AO
70 227 ...	70 227 ...
63200	62200

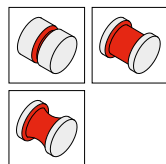
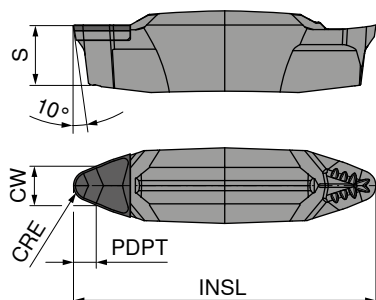
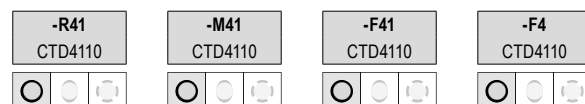
P		
M		
K		
N		
S		
H		
O		



→ Find the recommended values for cutting speeds here.

MaxiGroove – PCD grooving insert – X32

▲ TCE(NOI) = Design and number of equipped cutting edge corners



Designation	INSL mm	CW mm	PDPT mm	CRE mm	S mm	TCE
X32 R1.60 V TN	32	3.2	3	1.6	6.4	A
X32 R1.60 V FN	32	3.2	3	1.6	6.4	A
X32 R2.00 V TN	32	4.0	3	2.0	6.4	A
X32 R2.00 V FN	32	4.0	3	2.0	6.4	A

R	M	F	F
PC	PC	PC	PC
74 299 ...	74 298 ...	74 297 ...	74 296 ...
60502	60502	60502	60502
60002	60002	60002	60002
60602	60602	60602	60602
60102	60102	60102	60102

P				
M				
K				
N				
S				
H				
O				

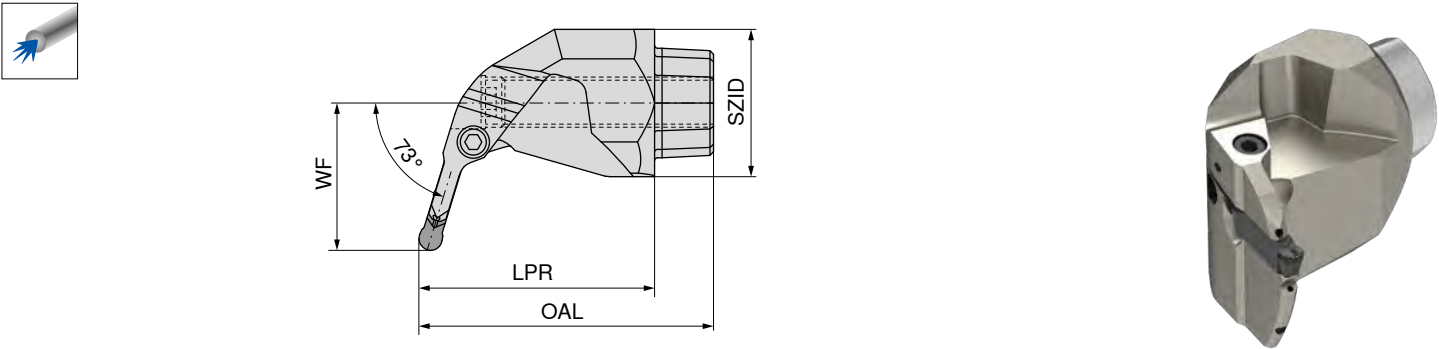


→ Find the recommended values for cutting speeds here.

MaxiGroove – GX40-4S 73° – Reinforced tool head for axial clamping – OvalFlex

▲ Optimized for GX40-R4.00... inserts

Scope of supply:
OvalFlex turning head with clamping screw and screw plug



Designation	Adapter	WF mm	OAL mm	LPR mm	SZID	Indexable insert
OC50 GX40 4S R 73F	OC50	80	100	80	50	GX40-4R4.00..

Right

TO

74 596 ...

17300

→ Find suitable indexable inserts here.

A detailed operating manual is available for download in the online shop next to the product.

Spare parts
for article number

74 596 17300


Cap screw

AS

70 950 ...

M16x7,5x1,5 - SW8

91000


Fixing screw

FI

10 950 ...

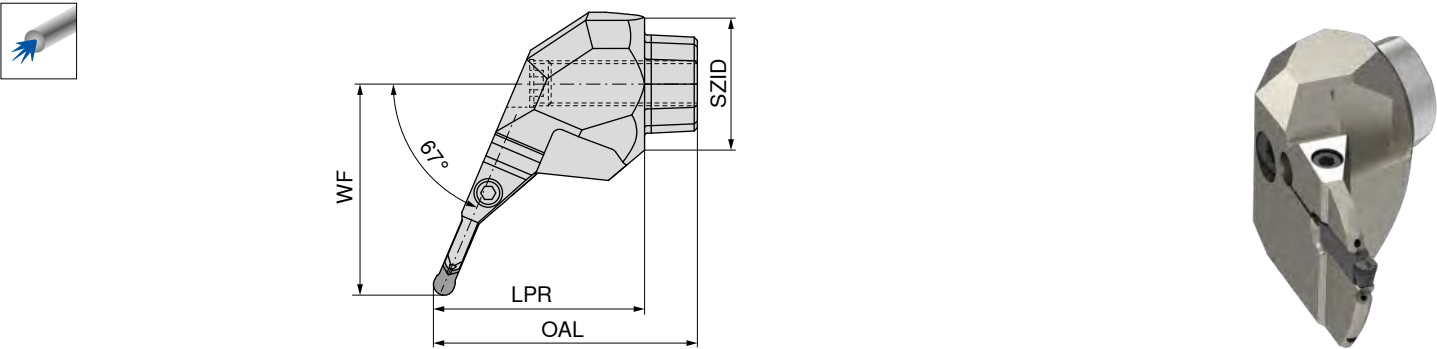
M6x20 Sw5

17600

MaxiGroove – GX40-4S 67° – Reinforced tool head for axial clamping – OvalFlex

▲ Optimized for GX40-R4.00... inserts

Scope of supply:
OvalFlex turning head with clamping screw and screw plug



Designation	Adapter	WF mm	OAL mm	LPR mm	SZID	Indexable insert
OC50 GX40 4S R 67F	OC50	80	100	80	50	GX40-4R4.00..

Right

TO

74 596 ...

16700

→ Find suitable indexable inserts here.

A detailed operating manual is available for download in the online shop next to the product.

Spare parts
for article number

74 596 16700

Cap screw

AS

70 950 ...

M16x7,5x1,5 - SW8

91000

Fixing screw

FI

10 950 ...

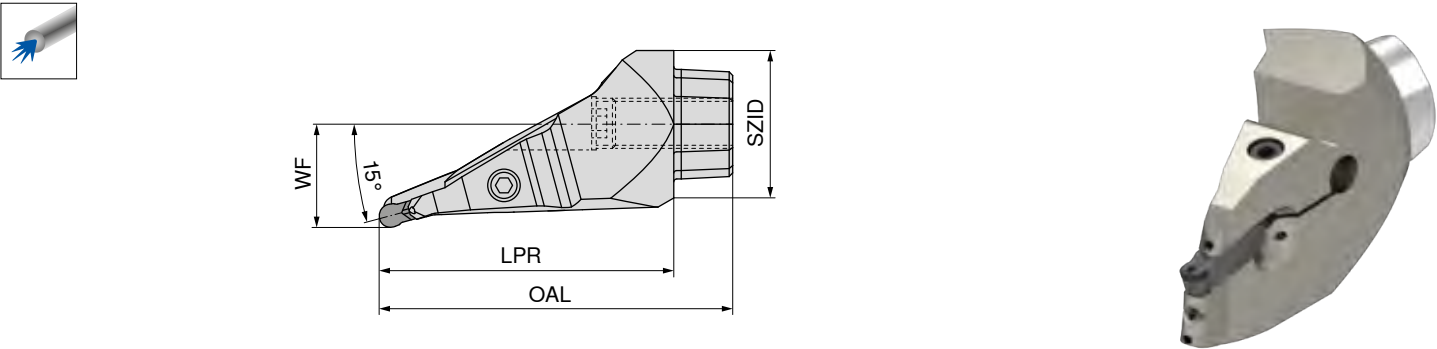
M6x20 Sw5

17600

MaxiGroove – GX40-4S 15° – Reinforced tool head for axial clamping – OvalFlex

▲ Optimized for GX40-R4.00... inserts

Scope of supply:
OvalFlex turning head with clamping screw and screw plug



Designation	Adapter	WF mm	OAL mm	LPR mm	SZID	Indexable insert
OC50 GX40 4S R 15H	OC50	35	120	100	50	GX40-4R4.00..

Right

TO

74 596 ...

11500

→ Find suitable indexable inserts here.

A detailed operating manual is available for download in the online shop next to the product.

Spare parts
for article number

74 596 11500


Cap screw

AS

70 950 ...

M16x7,5x1,5 - SW8

91000


Fixing screw

FI

10 950 ...

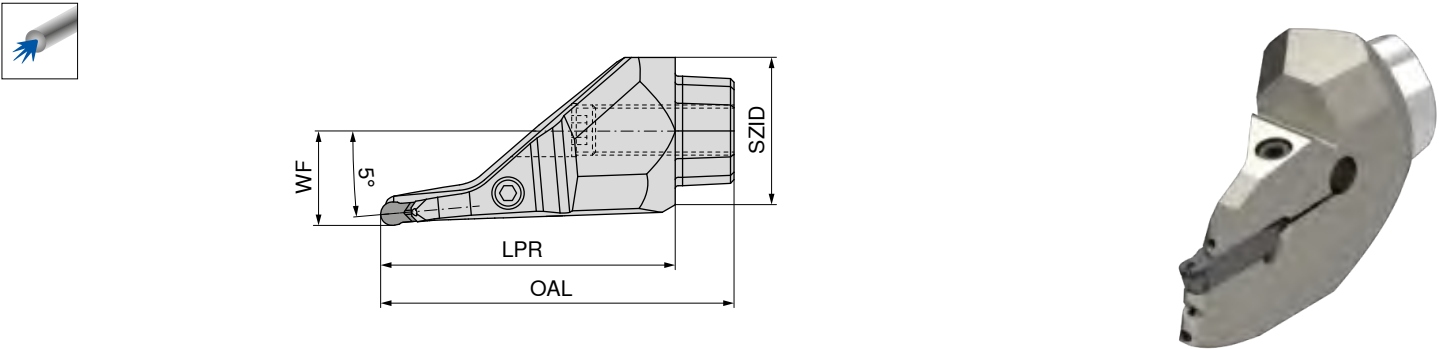
M6x20 Sw5

17600

MaxiGroove – GX40-4S 5° – Reinforced tool head for axial clamping – OvalFlex

▲ Optimized for GX40-R4.00... inserts

Scope of supply:
OvalFlex turning head with clamping screw and screw plug



Designation	Adapter	WF mm	OAL mm	LPR mm	SZID	Indexable insert
OC50 GX40 4S R 05H	OC50	32	120	100	50	GX40-4R4.00..

Right
TO
74 596 ...
10500

→ Find suitable indexable inserts here.

A detailed operating manual is available for download in the online shop next to the product.

Spare parts
for article number

74 596 10500

M16x7,5x1,5 - SW8

Cap screw
AS
70 950 ...
91000

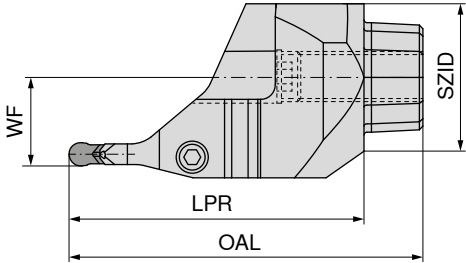
M6x20 Sw5

Fixing screw
FI
10 950 ...
17600

MaxiGroove – GX40-4S 0° – Reinforced tool head for axial clamping – OvalFlex

▲ Optimized for GX40-R4.00... inserts

Scope of supply:
OvalFlex turning head with clamping screw and screw plug



Right

Designation	Adapter	WF mm	OAL mm	LPR mm	SZID	Indexable insert
OC50 GX40 4S R 00H	OC50	30	120	100	50	GX40-4R4.00..

TO
74 596 ...
10000



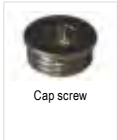
→ Find suitable indexable inserts here.



A detailed operating manual is available for download in the online shop next to the product.

Spare parts
for article number

74 596 10000



Cap screw

AS
70 950 ...

M16x7,5x1,5 - SW8

91000



Fixing screw

FI
10 950 ...

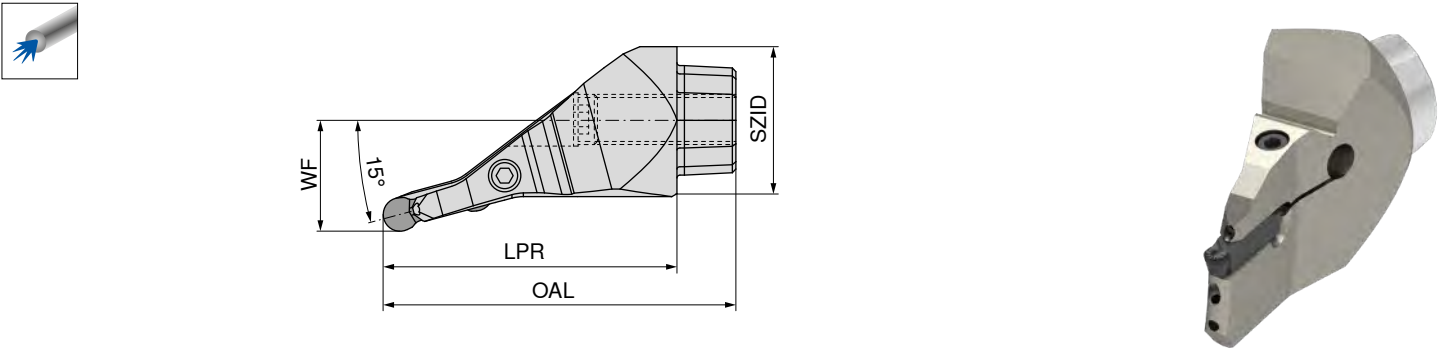
M6x20 Sw5

17600

MaxiGroove – GX40-6S 15° – Reinforced tool head for axial clamping – OvalFlex

▲ Optimized for GX40-R6.00... inserts

Scope of supply:
OvalFlex turning head with clamping screw and screw plug



Designation	Adapter	WF mm	OAL mm	LPR mm	SZID	Indexable insert
OC50 GX40 6S R 15H	OC50	38	120	100	50	GX40-6R6.00..

Right
TO
74 596 ...
21500

→ Find suitable indexable inserts here.

A detailed operating manual is available for download in the online shop next to the product.

Spare parts
for article number

74 596 21500

M16x7,5x1,5 - SW8

Cap screw

AS

70 950 ...

91000

M6x20 Sw5

Fixing screw

FI

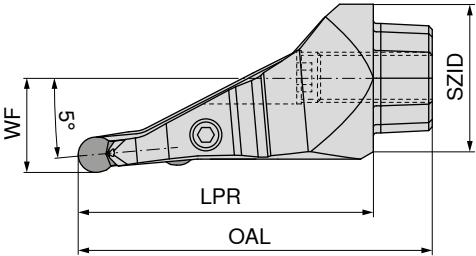
10 950 ...

17600

MaxiGroove – GX40-6S 5° – Reinforced tool head for axial clamping – OvalFlex

▲ Optimized for GX40-R6.00... inserts

Scope of supply:
OvalFlex turning head with clamping screw and screw plug



Right

Designation	Adapter	WF mm	OAL mm	LPR mm	SZID	Indexable insert
OC50 GX40 6S R 05H	OC50	32	120	100	50	GX40-6R6.00..

TO
74 596 ...
20500



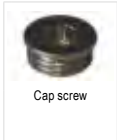
→ Find suitable indexable inserts here.



A detailed operating manual is available for download in the online shop next to the product.

Spare parts
for article number

74 596 20500



Cap screw

AS
70 950 ...

M16x7,5x1,5 - SW8

91000



Fixing screw

FI
10 950 ...

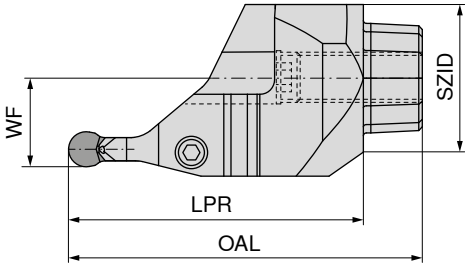
M6x20 Sw5

17600

MaxiGroove – GX40-6S 0° – Reinforced tool head for axial clamping – OvalFlex

▲ Optimized for GX40-R6.00... inserts

Scope of supply:
OvalFlex turning head with clamping screw and screw plug



Right

Designation	Adapter	WF mm	OAL mm	LPR mm	SZID	Indexable insert
OC50 GX40 6S R 00H	OC50	30	120	100	50	GX40-6R6.00..

TO
74 596 ...
20000



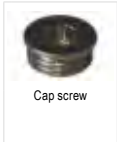
→ Find suitable indexable inserts here.



A detailed operating manual is available for download in the online shop next to the product.

Spare parts
for article number

74 596 20000



Cap screw

AS
70 950 ...

M16x7,5x1,5 - SW8

91000



Fixing screw

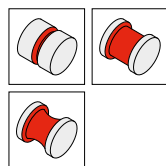
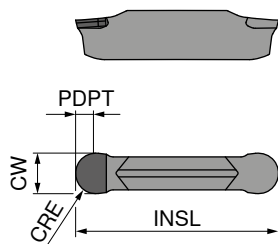
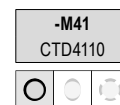
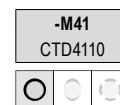
FI
10 950 ...

M6x20 Sw5

17600

MaxiGroove – PCD radius grooving insert – GX40

▲ For copy turning



Designation	INSL mm	CW mm +/-0.02	CRE mm	PDPT mm	For tool holder
GX 40-4 R4.00 FN A6	40	8	4	6	GX 40-4
GX 40-4 R4.00 TN 015D A6	40	8	4	6	GX 40-4
GX 40-6 R6.00 FN	40	12	6	8	GX 40-6
GX 40-6 R6.00 TN 015D A8	40	12	6	8	GX 40-6

PC
74 291 ...
60202
60302

PC
74 290 ...
60002
60102

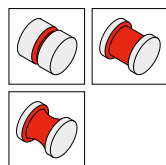
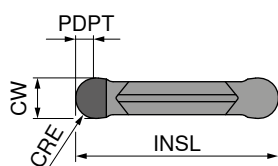
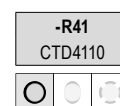
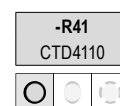
P
M
K
N
S
H
O



→ Find the recommended values for cutting speeds here.

MaxiGroove – PCD radius grooving insert – GX40

▲ For copy turning



Designation	INSL mm	CW mm +/-0.02	CRE mm	PDPT mm	For tool holder
GX 40-4 R4.00 TN 025D A6	40	8	4	6	GX 40-4
GX 40-6 R6.00 TN 025D A8	40	12	6	8	GX 40-6

PC
74 290 ...
60202

PC
74 291 ...
60102

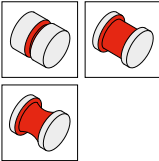
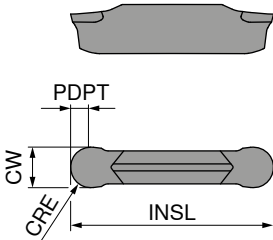
P
M
K
N
S
H
O



→ Find the recommended values for cutting speeds here.

MaxiGroove – Carbide radial grooving insert – GX40

▲ For copy turning



-28P
H216T





M

Designation	INSL mm	CW mm <small>+/-0.02</small>	CRE mm	PDPT mm	For tool holder
GX 40-4 R4.00 N	40	8	4	6	GX 40-4
GX 40-6 R6.00 N	40	12	6	8	GX 40-6

AO

70 377 ...

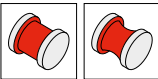
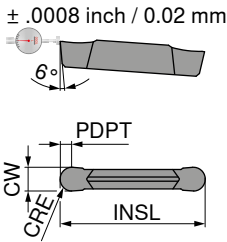
50400
50800

P	
M	
K	○
N	●
S	
H	
O	○



→ Find the recommended values for cutting speeds here.

MaxiGroove – Carbide radial grooving insert – GX24



-24PF H216T	-27DF H216T	-25PF H216T



Designation	INSL mm	CW mm <small>+/-0.02</small>	CRE mm	PDPT mm	For tool holder
GX 24-4 R3.00 N	25.4	6	3	4	GX 24-4
GX 24-5 R4.00 EN	25.4	8	4	5	GX 24-5
GX 24-5 R4.00 N	25.4	8	4	5	GX 24-5

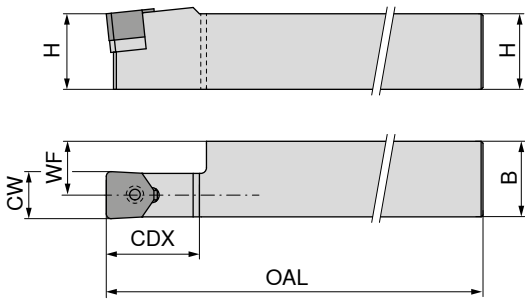
M	M	M
IG	IG	IG
70 376 ...	70 375 ...	70 374 ...
50600	60600	55800

P			
M			
K			
N			
S			
H			
O			

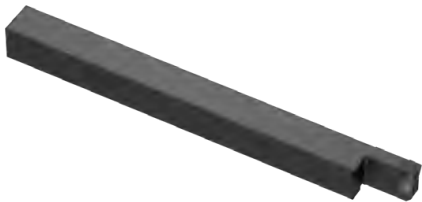


→ Find the recommended values for cutting speeds here.

MaxiGroove – Tools for HX grooving inserts – Heavy HX



Illustrations show right-hand versions



Designation	B mm	H mm	CDX mm	WF mm	OAL mm	For grooving inserts
HDHGL 4040W.HX16P-050	40	40	50	40.5	450	HX 16
HDHGR 4040W.HX16P-050	40	40	50	40.5	450	HX 16
HDHGR 4040W.HX25P-050	40	40	50	41.0	450	HX 25
HDHGL 4040W.HX25P-050	40	40	50	41.0	450	HX 25

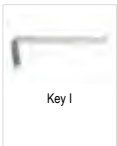
Left	Right
TO	TO
74 622 ...	74 622 ...
21600	01600 02500
22500	



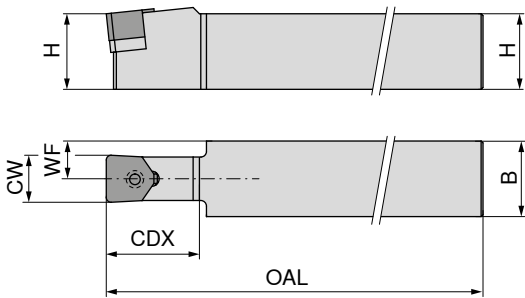
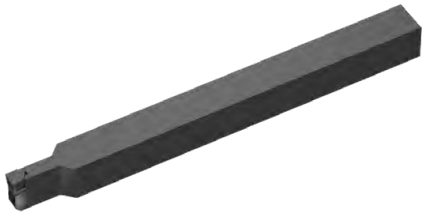
→ Find suitable indexable inserts here.

Spare parts
for article number

74 622 21600	SW3
74 622 01600	SW3
74 622 02500	SW4
74 622 22500	SW4

 Key I	 HM shim
AS	AS
70 950 ...	70 950 ...
176	74600
176	74600
396	75600
396	75600

MaxiGroove – Tools for HX grooving inserts – Heavy HX



							Neutral	
							TO	
Designation	B mm	H mm	CDX mm	WF mm	OAL mm	For grooving inserts	74 622 ...	
HDHGN 4040W.HX16P-050	40	40	50	20	450	HX 16	11600	
HDHGN 4040W.HX25P-050	40	40	50	20	450	HX 25	12500	

→ Find suitable indexable inserts here.

Spare parts
for article number

74 622 11600	SW3	176	74600
74 622 12500	SW4	396	75600



Key I

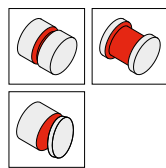
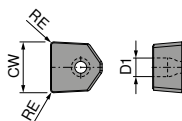


HM shim

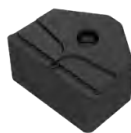
AS
70 950 ...
176
396

AS
70 950 ...
74600
75600

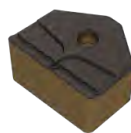
MaxiGroove – Carbide grooving insert – Heavy HX



-R70
CTCK110



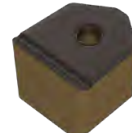
-R70
CTCP125-P



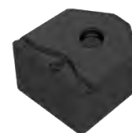
-R71
CTCK110



-R71
CTCP125-P



-R75
CTCK110



-R81
CTCP125-P



Designation	CW mm	RE mm	D1 mm
HX 16.12.60 -R71	16	1.2	6.5
HX 16.12.60 -R81	16	1.2	6.5
HX 20.16.60 -R71	20	1.6	6.5
HX 20.16.60 -R81	20	1.6	6.5
HX 25.16.90 -R71	25	1.6	9.2
HX 25.16.90 -R75	25	1.6	9.2
HX 25.16.90 -R81	25	1.6	9.2
HX 32.20.90 -R70	32	2.0	9.2
HX 32.20.90 -R81	32	2.0	9.2
HX 40.24.90 -R70	40	2.4	9.2
HX 40.24.90 -R81	40	2.4	9.2
HX 45.24.90 -R70	45	2.4	9.2
HX 45.24.90 -R81	45	2.4	9.2
HX 50.32.90 -R70	50	3.2	9.2
HX 50.32.90 -R81	50	3.2	9.2
HX 60.35.90 -R70	60	3.5	9.2
HX 60.35.90 -R81	60	3.5	9.2

R

AO

74 206 ...

R

AO

74 206 ...

R

AO

74 206 ...

00500

00600

00700

00900

00100

00300

00000

01100

01000

01000

01000

01000

01000

01000

01000

01000

01000

01000

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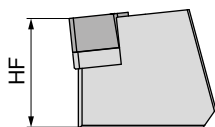
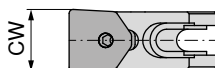
01000

P	○	●	○	●	○	●
M		○		○		○
K	●		●		●	
N						
S		●		●		●
H						
O						



→ Find the cutting data standard values here.

MaxiGroove – Grooving cartridge – Heavy HX

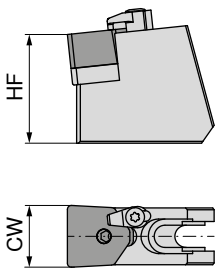


Designation	HF mm	Indexable insert	TO	
			74 620 ...	
HDCGN 1HX16P.33	33	HX 16		01600
HDCGN 1HX20P.33	33	HX 20		02000
HDCGN 1HX25P.44	44	HX 25		02500
HDCGN 1HX32P.44	44	HX 32		03200
HDCGN 1HX40P.44	44	HX 40		04000
HDCGN 1HX45P.44	44	HX 45		04500
HDCGN 1HX50P.44	44	HX 50		05000
HDCGN 1HX60P.55	55	HX 60		06000

Spare parts for article number

		AS			AS			AS	
		70 950 ...			70 950 ...			70 950 ...	
74 620 01600	PIN 65.M8	76100		Tension pin	SW3	176		74600	
74 620 02000	PIN 65.M8	76100			SW3	176		76400	
74 620 02500	PIN 90.M12	76200		Key I	SW4	396		75600	
74 620 03200	PIN 90.M12	76200			SW4	396		76500	
74 620 04000	PIN 90.M12	76200			SW4	396		76600	
74 620 04500	PIN 90.M12	76200			SW4	396		76700	
74 620 05000	PIN 90.M12	76200			SW4	396		76800	
74 620 06000	PIN 90.M12	76200		HM shim	SW4	396		74700	

MaxiGroove – Grooving cartridge – Heavy HX



Designation	HF mm	Indexable insert
HDCGN 1HX25PC.44	44	HX 25

TO
74 620 ...
12500

Spare parts
for article number

74 620 12500


Clamping claw RX
AS
70 950 ...
77200


Key I
AS
70 950 ...
SW4 396


HM shim
AS
70 950 ...
75600

Illustrations show right-hand versions

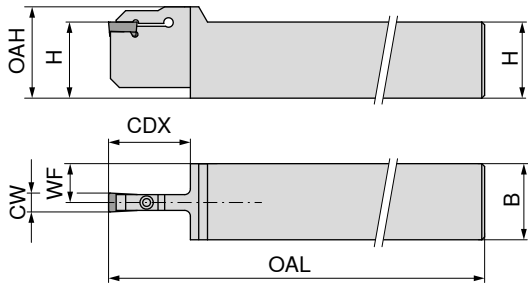
Illustrations show right-hand versions									Left	Right
									TO	TO
Designation	B mm	H mm	CDX mm	WF mm	LH mm	OAH mm	OAL mm	For grooving inserts	74 621 ...	74 621 ...
HDHGL 4040W.1MX05C-025	40	40	25	40.5	53	50	450	MX-R50 / MX-S50	20500	
HDHGR 4040W.1MX05C-025	40	40	25	40.5	53	50	450	MX-R50 / MX-S50		00500
HDHGL 4040W.1MX10C-040	40	40	40	40.5	53	48	450	MX-R10 / MX-S10	21000	
HDHGR 4040W.1MX10C-040	40	40	40	40.5	53	48	450	MX-R10 / MX-S10		01000



→ Find suitable indexable inserts here.

		Key I		Screwdriver		Clamping screw		Set Screw	
		AS		AS		AS		AS	
Spare parts for article number		70 950 ...		80 950 ...		70 950 ...		70 950 ...	
74 621 20500	SW2,5	175							M5x10 75100
74 621 00500	SW2,5	175							M5x10 75100
74 621 21000				T20 106		M4x18 204			
74 621 01000				T20 106		M4x18 204			

MaxiGroove – Tools for MX grooving inserts – Heavy MX



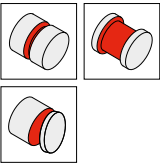
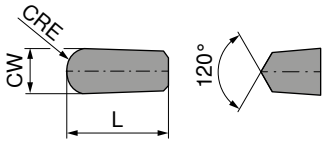
Designation	B mm	H mm	CDX mm	WF mm	LH mm	OAH mm	OAL mm	For grooving inserts	Neutral	
									TO	
HDHGN 4040W.1MX05C-025	40	40	25	20	53	50	450	MX-R50 / MX-S50	74 621 ...	10500
HDHGN 4040W.1MX10C-040	40	40	40	20	53	48	450	MX-R10 / MX-S10		11000



→ Find suitable indexable inserts here.

Spare parts for article number		Key I		Screwdriver		Clamping screw		Set Screw	
		AS		AS		AS		AS	
74 621 10500	SW2,5	70 950 ...	175	T20	80 950 ...	M4x18	70 950 ...	M5x10	70 950 ...
74 621 11000					106		204		75100

MaxiGroove – CERAMIC grooving insert – Heavy MX



CTS3105



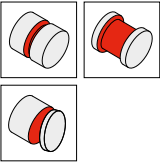
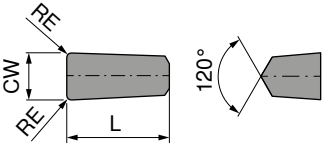
F

Designation	CW mm	RE mm
MX-R 4012 TN-020D	4	2.0
MX-R 5012 TN-020D	5	2.5
MX-R 1015 TN-020D	10	5.0

IC
74 207 ...
40200
40300
40100

P
M
K
N
S
H
O

MaxiGroove – CERAMIC grooving insert – Heavy MX



CTS3105



F

Designation	CW mm	RE mm
MX-S 501208 TN-020D	5	0.8
MX-S 101508 TN-020D	10	0.8

IC
74 207 ...
40700
40500

P
M
K
N
S
H
O

Material examples for cutting data tables

	Material sub-group	Index	Composition / Structure / Heat treatment	Hardness HB / HRC Tensile strength at rupture (Rm) lbf/in ²	Material number Material designation	Material number Material designation
P	Unalloyed steel	P.1.1	< 0.15 % C, annealed	60900 lbf/in ² / 125 HB	1.0401 1015	1.0301 1010
		P.1.2	< 0.45 % C, annealed	92800 lbf/in ² / 190 HB	1.1191 1045	1.0737 12L14
		P.1.3	< 0.45 % C, tempered	121800 lbf/in ² / 250 HB	1.1191 1045	1.0503 1043
		P.1.4	< 0.75 % C, annealed	132000 lbf/in ² / 270 HB	1.1223 1060	1.0535 1055
		P.1.5	< 0.75 % C, tempered	146500 lbf/in ² / 300 HB	1.1223 1060	1.1274 1095
	Low-alloy steel	P.2.1	Annealed	88500 lbf/in ² / 180 HB	1.7131 5115	1.6523 8620
		P.2.2	Tempered	134900 lbf/in ² / 275 HB	1.7131 5115	1.6582 4340
		P.2.3	Tempered	146500 lbf/in ² / 300 HB	1.7225 4142	1.7131 5115
		P.2.4	Tempered	174000 lbf/in ² / 375 HB	1.7225 4142	1.7223 4140
	High-alloy steel and high-alloy tool steel	P.3.1	Annealed	98600 lbf/in ² / 200 HB	1.4021 420	1.2379 D2
		P.3.2	Hardened and tempered	159500 lbf/in ² / 300 HB	1.2343 H11	1.3343 M2
		P.3.3	Hardened and tempered	188500 lbf/in ² / 400 HB	1.2343 H11	1.2363 A2
	Stainless steel	P.4.1	Ferritic / martensitic, annealed	98600 lbf/in ² / 200 HB	1.4016 430	1.4125 440C
		P.4.2	Martensitic, tempered	117500 lbf/in ² / 300 HB	1.4112 S44003	1.4021 420
M	Stainless steel	M.1.1	Austenitic / austenitic-ferritic, quenched	88500 lbf/in ² / 180 HB	1.4301 304	1.4401 316
		M.2.1	Austenitic, tempered	300 HB	1.4841 314	1.4568 17-7 PH
		M.3.1	Austenitic / ferritic (Duplex)	113100 lbf/in ² / 230 HB	1.4462 S32205	1.4410 S32750
K	Grey cast iron	K.1.1	Pearlitic / ferritic	88500 lbf/in ² / 180 HB	0.6010 A48-20B	0.6025 A48-40 B
		K.1.2	Pearlitic (martensitic)	127600 lbf/in ² / 260 HB	0.6030 A48-45B	0.6040 A48-60 B
	Spherulitic graphite cast iron	K.2.1	Ferritic	78300 lbf/in ² / 160 HB	0.7040 60-40-18	0.7050 65-45-12
		K.2.2	Pearlitic	122600 lbf/in ² / 250 HB	0.7070 100-70-03	0.7660 A439 Type D2
	Malleable iron	K.3.1	Ferritic	63800 lbf/in ² / 130 HB	0.8035 GTW-35-04	
		K.3.2	Pearlitic	113100 lbf/in ² / 230 HB	0.8170 70003	
N	Aluminium wrought alloy	N.1.1	Non-hardenable	60 HB	3.0255 A91060	3.0255 A91060
		N.1.2	Hardenable, age-hardened	49300 lbf/in ² / 100 HB	3.1355 2024	3.1355 2024
	Cast aluminium alloy	N.2.1	≤ 12 % Si, non-hardenable	36300 lbf/in ² / 75 HB	3.2581 A04130 / A413-0	3.2581 A04130 / A413-0
		N.2.2	≤ 12 % Si, hardenable, age-hardened	43500 lbf/in ² / 90 HB	3.2134 G-AISi5Cu1Mg	
		N.2.3	> 12 % Si, non-hardenable	63800 lbf/in ² / 130 HB	G-AISi17Cu4Mg	
	Copper and copper alloys (bronze/brass)	N.3.1	Free-machining alloys, Pb > 1 %	54400 lbf/in ² / 110 HB	2.0380 CuZn39Pb2 (Ms58)	2.0380 C37700
		N.3.2	CuZn, CuSnZn	43500 lbf/in ² / 90 HB	2.0331 CuZn15	2.0331 C34000
		N.3.3	CuSn, lead-free copper and electrolytic copper	49300 lbf/in ² / 100 HB	2.0060 E-Cu57	
	Magnesium alloys	N.4.1	Magnesium and magnesium alloys	70 HB	3.5612 MgAl6Zn	
S	Heat-resistant alloys	S.1.1	Fe basis, annealed	98600 lbf/in ² / 200 HB	1.4864 X12NiCrSi 36-16	1.4864 330
		S.1.2	Fe basis, age-hardened	137800 lbf/in ² / 280 HB	1.4980 X6NiCrTiMoVB25-15-2	1.4980 S66286
		S.2.1	Ni or Co basis, annealed	121800 lbf/in ² / 250 HB	2.4856 Inconel 625	2.4812 Hastelloy C
		S.2.2	Ni or Co basis, age-hardened	171100 lbf/in ² / 350 HB	2.4952 Nimonic 80A	2.4668 Inconel 718
		S.2.3	Ni or Co basis, cast	156600 lbf/in ² / 320 HB	2.4674 Nimocast PK24	2.4670 Nimocast 713
	Titanium alloys	S.3.1	Pure titanium	5800 lbf/in ²	3.7025 Ti99,8	
		S.3.2	Alpha + beta alloys, age-hardened	152300 lbf/in ² / 320 HB	3.7165 TiAl6V4	
		S.3.3	Beta alloys	203100 lbf/in ² / 410 HB	Ti555.3 Ti-5Al-5V-5Mo-3Cr	
H	Hardened steel	H.1.1	Hardened and tempered	46–55 HRC		
		H.1.2	Hardened and tempered	56–60 HRC		
		H.1.3	Hardened and tempered	61–65 HRC		
		H.1.4	Hardened and tempered	66–70 HRC		
	Chilled iron	H.2.1	Cast	400 HB		
	Hardened cast iron	H.3.1	Hardened and tempered	55 HRC		
O	Non-metal materials	O.1.1	Plastics, duroplastic	≤ 21800 lbf/in ²	EP, MF, PF, UP	
		O.1.2	Plastics, thermoplastic	≤ 14500 lbf/in ²	PA, PC, PE, PI, PMMA, POM, PP, PS, PTFE, PVC	
		O.2.1	Aramid fibre-reinforced	≤ 145000 lbf/in ²	AFK	
		O.2.2	Glass/carbon-fibre reinforced	≤ 145000 lbf/in ²	CFRP, GFRP	
		O.3.1	Graphite			

Cutting data standard values for grooving inserts

Index	System								
	AX, FX, GX, LX, SX, MaxiClick							OvalFlex, MaxiGroove GX40, X32	
	CTCP325	CTCP335	CTPP345	CTPP520	CTPP535	CTP1340	H216T	CTD4110	H216T
	DRAGONSkin								
	v _c (m/min)							v _c (m/min)	
P.1.1	220	185	135	235	180	180			
P.1.2	195	160	120	205	150	150			
P.1.3	170	140	105	175	125	125			
P.1.4	165	130	100	165	120	115			
P.1.5	150	120	95	150	105	100			
P.2.1	200	165	120	210	160	155			
P.2.2	160	130	100	160	115	110			
P.2.3	150	120	95	150	105	100			
P.2.4	120	90	75	115	75	70			
P.3.1	150	130	100	185	120	110			
P.3.2	95	90	80	130	90	75			
P.3.3	45	50	60	75	60	40			
P.4.1	150	130	100	185	120	110			
P.4.2	125	110	90	160	105	95			
M.1.1	150	130	100	185	120	110			
M.2.1	95	90	80	130	90	80			
M.3.1	135	115	95	170	110	100			
K.1.1	170	135		140	165	150	140		
K.1.2	150	115		115	150	125	115		
K.2.1	160	130		180	145	140	150		
K.2.2	145	105		115	155	120	110		
K.3.1	210	150		130	190	170	170		
K.3.2	140	115		110	145	120	140		
N.1.1						300	400	400-2800	400-2500
N.1.2						200	400	400-2800	400-2500
N.2.1						300	450	400-2800	400-2500
N.2.2						200	450	400-2800	400-2500
N.2.3						150	500	400-2800	400-2500
N.3.1						300	425	400-2800	400-2500
N.3.2						300	400	400-2800	400-2500
N.3.3						200	275	400-2800	400-2500
N.4.1						200	225	400-2800	400-2500
S.1.1	35			40	30	35	40		
S.1.2	30		30	30	25	30	30		
S.2.1	20		25	20	15	20	30		
S.2.2	15			15	15	15	25		
S.2.3	15			20	15	15	20		
S.3.1				125	85	85	90		
S.3.2				50	35	40	55		
S.3.3				35	25	30	40		
H.1.1				15					
H.1.2				15					
H.1.3									
H.1.4									
H.2.1				15					
H.3.1				40					
O.1.1						130	130		
O.1.2									
O.2.1						105	105		
O.2.2									
O.3.1									

System		● 1st choice ○ Suitable		
TX				
CWX500		Emulsion	Compressed air	MMS
v _c (m/min)	f (mm/rev)			
160	0,03–0,10	●		
140	0,03–0,10	●		
110	0,03–0,10	●		
110	0,03–0,10	●		
90	0,03–0,10	●		
110	0,03–0,10	●		
90	0,03–0,10	●		
90	0,03–0,07	●		
80	0,03–0,06	●		
80	0,03–0,07	●		
60	0,03–0,07	●		
50	0,03–0,07	●		
100	0,03–0,06	●		
90	0,03–0,06	●		
110	0,02–0,06	●		
90	0,02–0,06	●		
70	0,02–0,06	●		
140	0,03–0,10	●		
100	0,03–0,10	●		
90	0,03–0,10	●		
80	0,03–0,10	●		
140	0,03–0,10	●		
120	0,03–0,10	●		
330	0,05–0,12	●		
310	0,05–0,12	●		
270	0,05–0,12	●		
230	0,05–0,12	●		
140	0,05–0,12	●		
240	0,05–0,12	●		
200	0,05–0,12	●		
180	0,05–0,12	●		
180	0,05–0,12	●		
60	0,02–0,07	●		
50	0,02–0,08	●		
60	0,02–0,09	●		
50	0,02–0,10	●		
40	0,02–0,11	●		
60	0,02–0,12	●		
40	0,02–0,13	●		
30	0,02–0,14	●		
50	0,01–0,07	●		
180	0,05–0,12	●		
180	0,05–0,12	●		
150	0,05–0,12	●		
110	0,05–0,12	●		
170	0,03–0,10	●		



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approximately **±20%** according to the usage conditions.

Cutting data standard values for grooving inserts

Index	System								System		TX		● 1st choice ○ Suitable		
	AX, FX, GX, LX, SX, MaxiClick							OvalFlex, MaxiGroove GX40, X32		CWX500		Emulsion	Compressed air	MMS	
	CTCP325	CTCP335	CTPP345	CTPP520	CTPP535	CTP1340	H216T	CTD4110	H216T	v _c (ft/min)	f (inch/rev)				
	DRAGONSKIN														
	v _c (ft/min)							v _c (ft/min)							
P.1.1	730	620	450	780	600	600				530	0.0012–0.0039	●			
P.1.2	650	530	400	680	500	500				470	0.0012–0.0039	●			
P.1.3	570	470	350	580	420	420				370	0.0012–0.0039	●			
P.1.4	550	430	330	550	400	380				370	0.0012–0.0039	●			
P.1.5	500	400	320	500	350	330				300	0.0012–0.0039	●			
P.2.1	660	550	400	700	530	520				370	0.0012–0.0039	●			
P.2.2	530	430	330	530	380	370				300	0.0012–0.0039	●			
P.2.3	500	400	320	500	350	330				300	0.0012–0.0028	●			
P.2.4	400	300	250	380	250	240				270	0.0012–0.0024	●			
P.3.1	500	430	330	620	400	370				270	0.0012–0.0028	●			
P.3.2	320	300	270	430	300	250				200	0.0012–0.0028	●			
P.3.3	150	170	200	250	200	140				170	0.0012–0.0028	●			
P.4.1	500	430	330	620	400	370				330	0.0012–0.0024	●			
P.4.2	420	370	300	530	350	320				300	0.0012–0.0024	●			
M.1.1	500	430	330	620	400	370				370	0.0008–0.0024	●			
M.2.1	320	300	270	430	300	270				300	0.0008–0.0024	●			
M.3.1	450	380	320	570	370	330				240	0.0008–0.0024	●			
K.1.1	570	450		470	550	500	470			470	0.0012–0.0039	●			
K.1.2	500	380		380	500	420	380			330	0.0012–0.0039	●			
K.2.1	530	430		600	480	470	500			300	0.0012–0.0039	●			
K.2.2	480	350		380	520	400	370			270	0.0012–0.0039	●			
K.3.1	700	500		430	630	570	570			470	0.0012–0.0039	●			
K.3.2	470	380		370	480	400	470			400	0.0012–0.0039	●			
N.1.1						990	1320	1320-9200	1320-8200	1090	0.002–0.0047	●			
N.1.2						660	1320	1320-9200	1320-8200	1030	0.002–0.0047	●			
N.2.1						990	1490	1320-9200	1320-8200	900	0.002–0.0047	●			
N.2.2						660	1490	1320-9200	1320-8200	760	0.002–0.0047	●			
N.2.3						500	1650	1320-9200	1320-8200	470	0.002–0.0047	●			
N.3.1						990	1410	1320-9200	1320-8200	800	0.002–0.0047	●			
N.3.2						990	1320	1320-9200	1320-8200	660	0.002–0.0047	●			
N.3.3						660	910	1320-9200	1320-8200	600	0.002–0.0047	●			
N.4.1						660	750	1320-9200	1320-8200	600	0.002–0.0047	●			
S.1.1	120			140	100	120	140			200	0.0008–0.0028	●			
S.1.2	100		100	100	90	100	100			170	0.0008–0.0031	●			
S.2.1	70		90	70	50	70	100			200	0.0008–0.0035	●			
S.2.2	50			50	50	50	90			170	0.0008–0.0039	●			
S.2.3	50			70	50	50	70			140	0.0008–0.0043	●			
S.3.1				420	290	290	300			200	0.0008–0.0047	●			
S.3.2				170	120	140	190			140	0.0008–0.0051	●			
S.3.3				120	90	100	140			100	0.0008–0.0055	●			
H.1.1				50						170	0.0004–0.0028	●			
H.1.2				50											
H.1.3															
H.1.4															
H.2.1				50											
H.3.1				140											
O.1.1						430	430			600	0.002–0.0047	●			
O.1.2										600	0.002–0.0047	●			
O.2.1						350	350			500	0.002–0.0047	●			
O.2.2										370	0.002–0.0047	●			
O.3.1										570	0.0012–0.0039	●			



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approximately **±20%** according to the usage conditions.

GX – Cutting depths and feed rates

GX standard / GX-E										
Groove width CW (mm)	 Longitudinal turning							 		
	Depth of cut a_p (mm)							Grooving/Parting off		Axial grooving
	0,5	1,0	1,5	2,0	2,5	3,0	3,5	f (mm/rev)	f (mm/rev)	
2	0,10–0,15	0,05–0,15	0,05–0,12	0,05–0,10				0,05–0,20	When axial grooving, reduce feed by 40%.	
3	0,10–0,17	0,05–0,17	0,05–0,17	0,05–0,15	0,05–0,12			0,10–0,25		
4	0,10–0,20	0,07–0,20	0,07–0,20	0,07–0,20	0,07–0,17	0,07–0,15		0,10–0,25		
5	0,10–0,25	0,10–0,25	0,07–0,25	0,07–0,25	0,07–0,22	0,07–0,20		0,10–0,30		
6	0,15–0,30	0,15–0,30	0,15–0,30	0,15–0,30	0,15–0,30	0,15–0,25	0,15–0,22	0,15–0,35		

GX-M40											
Groove width CW (mm)	 Longitudinal turning								 		
	Depth of cut a_p (mm)								Grooving/Parting off		Axial grooving
	0,5	1,0	1,5	2,0	2,5	3,0	3,5	4,0	f (mm/rev)	f (mm/rev)	
	Feed f (mm/rev.)								f (mm/rev)		f (mm/rev)
2	0,10–0,20	0,05–0,20	0,05–0,17	0,05–0,15					0,05–0,15	When axial grooving, reduce feed by 40%.	
3	0,10–0,22	0,10–0,22	0,10–0,21	0,10–0,20	0,10–0,17				0,075–0,20		
4	0,10–0,25	0,10–0,25	0,10–0,25	0,10–0,25	0,10–0,22	0,10–0,17			0,10–0,25		
5	0,10–0,30	0,10–0,30	0,10–0,30	0,10–0,30	0,10–0,27	0,10–0,23	0,10–0,20		0,10–0,30		
6	0,10–0,35	0,10–0,35	0,10–0,35	0,10–0,35	0,10–0,32	0,10–0,27	0,10–0,23	0,10–0,20	0,15–0,325		

GX-F2												
Groove width CW (mm)	 Longitudinal turning									 		
	Depth of cut a_p (mm)									Grooving/Parting off		Axial grooving
	0,50	0,75	1,00	1,25	1,50	1,75	2,00	2,25	2,50	f (mm/rev)	f (mm/rev)	
	Feed f (mm/rev.)											
2	0,03–0,15	0,03–0,15	0,03–0,15	0,03–0,10						0,05–0,15	When axial grooving, reduce feed by 40%.	
3	0,04–0,17	0,04–0,17	0,04–0,17	0,04–0,15	0,04–0,13	0,04–0,12				0,075–0,20		
4	0,05–0,20	0,05–0,20	0,05–0,20	0,05–0,20	0,05–0,20	0,05–0,17	0,05–0,15			0,10–0,25		
5	0,07–0,20	0,07–0,20	0,07–0,20	0,07–0,20	0,07–0,20	0,07–0,20	0,07–0,17	0,07–0,15		0,10–0,30		
6	0,10–0,23	0,10–0,23	0,10–0,23	0,10–0,23	0,10–0,23	0,10–0,23	0,10–0,23	0,10–0,19	0,10–0,15	0,15–0,325		

GX-27P											
Groove width CW (mm)	<div> Longitudinal turning</div>								<div></div>		<div></div>
	Depth of cut a_p (mm)								Grooving/Parting off		Axial grooving
	0,5	1,0	1,5	2,0	2,5	3,0	3,5	4,0	f (mm/rev)	f (mm/rev)	
2	0,05–0,23	0,05–0,23	0,05–0,23	0,05–0,20					0,05–0,20	When axial grooving, reduce feed by 40%.	
3	0,05–0,25	0,05–0,25	0,05–0,25	0,05–0,25	0,05–0,20				0,05–0,25		
4	0,10–0,30	0,10–0,30	0,10–0,30	0,10–0,30	0,10–0,30	0,10–0,25			0,05–0,30		
5	0,10–0,35	0,10–0,35	0,10–0,35	0,10–0,35	0,10–0,35	0,10–0,32	0,10–0,30		0,10–0,35		
6	0,10–0,40	0,10–0,40	0,10–0,40	0,10–0,40	0,10–0,40	0,10–0,36	0,10–0,33	0,10–0,30	0,10–0,40		

GX-M45										
Groove width CW (mm)	 Longitudinal turning							 		
	Depth of cut a_p (mm)							Grooving/Parting off		Axial grooving
	0,5	1,0	1,5	2,0	2,5	3,0	3,5	f (mm/rev)		f (mm/rev)
	Feed f (mm/rev.)									
3	0,05	0,10	0,15	0,20	0,25			0,05–0,20		When axial grooving, reduce feed by 40%.
4	0,10	0,15	0,20	0,25	0,30			0,10–0,25		
5	0,10	0,15	0,20	0,25	0,30	0,35		0,10–0,30		
6	0,10	0,15	0,20	0,25	0,30	0,35	0,40	0,15–0,35		

GX – Cutting depths and feed rates

GX standard / GX-E

Groove width CW	<div> Longitudinal turning</div>							<div></div>		<div></div>
	Depth of Cut a_p (inch)							Grooving/Parting off		Axial grooving
	.020	.040	.060	.080	.100	.120	.140	f (inch/rev)		f (inch/rev)
2 mm (.040")	.0039–.0059	.0020–.0059	.0020–.0047	.0020–.0039				.0020–.0079		When axial grooving, reduce feed by 40%.
3 mm (.060")	.0039–.0067	.0020–.0067	.0020–.0067	.0020–.0059	.0020–.0047			.0039–.0098		
4 mm (.080")	.0039–.0079	.0028–.0079	.0028–.0079	.0028–.0079	.0028–.0067	.0028–.0059		.0039–.0098		
5 mm (.100")	.0039–.0098	.0039–.0098	.0028–.0098	.0028–.0098	.0028–.0087	.0028–.0079		.0039–.0118		
6 mm (.120")	.0059–.0118	.0059–.0118	.0059–.0118	.0059–.0118	.0059–.0118	.0059–.0098	.0059–.0087	.0059–.0138		

GX-M40

Groove width CW	 Longitudinal turning								 		
	Depth of Cut a_p (inch)								Grooving/Parting off		Axial grooving
	.020	.040	.060	.080	.100	.120	.140	.160			
	Feed rate f (inch/rev.)								f (inch/rev)		f (inch/rev)
2 mm (.040")	.0039–.0079	.0020–.0079	.0020–.0067	.0020–.0059					.0020–.0059		When axial grooving, reduce feed by 40%.
3 mm (.060")	.0039–.0087	.0039–.0087	.0039–.0083	.0039–.0079	.0039–.0067				.0028–.0079		
4 mm (.080")	.0039–.0098	.0039–.0098	.0039–.0098	.0039–.0098	.0039–.0087	.0039–.0067			.0039–.0098		
5 mm (.100")	.0039–.0118	.0039–.0118	.0039–.0118	.0039–.0118	.0039–.0106	.0039–.0091	.0039–.0079		.0039–.0118		
6 mm (.120")	.0039–.0138	.0039–.0138	.0039–.0138	.0039–.0138	.0039–.0126	.0039–.0106	.0039–.0091	.0039–.0079	.0059–.0128		

GX-F2

Groove width CW	<div> Longitudinal turning</div>									<div></div>		<div></div>
	Depth of Cut a_p (inch)									Grooving/Parting off		Axial grooving
	.020	.030	.040	.050	.060	.070	.080	.090	.100			
	Feed rate f (inch/rev.)									f (inch/rev)		f (inch/rev)
2 mm (.040")	.0012–.0059	.0012–.0059	.0012–.0059	.0012–.0039						.0020–.0059		When axial grooving, reduce feed by 40%.
3 mm (.060")	.0016–.0067	.0016–.0067	.0016–.0067	.0016–.0059	.0016–.0051	.0016–.0047				.0028–.0079		
4 mm (.080")	.0020–.0079	.0020–.0079	.0020–.0079	.0020–.0079	.0020–.0079	.0020–.0067		.0020–.0059		.0039–.0098		
5 mm (.100")	.0028–.0079	.0028–.0079	.0028–.0079	.0028–.0079		.0028–.0079		.0028–.0067		.0028–.0059		
										.0039–.0118		
6 mm (.120")	.0039–.0091	.0039–.0091	.0039–.0091	.0039–.0091	.0039–.0091	.0039–.0091	.0039–.0091	.0039–.0091	.0039–.0075	.0039–.0059		.0059–.0128

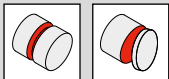
GX-27P

Groove width CW	<div> Longitudinal turning</div>								<div></div> Grooving/Parting off		<div></div> Axial grooving
	Depth of Cut a_p (inch)										
	.020	.040	.060	.080	.100	.120	.140	.160	f (inch/rev)		f (inch/rev)
	Feed rate f (inch/rev.)										
2 mm (.040")	.0020–.0091	.0020–.0091	.0020–.0091	.0020–.0079					.0020–.0079		When axial grooving, reduce feed by 40%.
3 mm (.060")	.0020–.0098	.0020–.0098	.0020–.0098	.0020–.0098	.0020–.0079				.0020–.0098		
4 mm (.080")	.0039–.0118	.0039–.0118	.0039–.0118	.0039–.0118	.0039–.0118	.0039–.0098			.0020–.0118		
5 mm (.100")	.0039–.0138	.0039–.0138	.0039–.0138	.0039–.0138	.0039–.0138	.0039–.0126	.0039–.0118		.0039–.0138		
6 mm (.120")	.0039–.0157	.0039–.0157	.0039–.0157	.0039–.0157	.0039–.0157	.0039–.0142	.0039–.0130	.0039–.0118	.0039–.0157		

GX-M45

Groove width CW	<div> Longitudinal turning</div>							<div></div>		<div></div>
	Depth of Cut a_p (inch)							Grooving/Parting off		Axial grooving
	.020	.040	.060	.080	.100	.120	.140	f (inch/rev)		f (inch/rev)
	Feed rate f (inch/rev.)							f (inch/rev)		f (inch/rev)
3 mm (.060")	.0020	.0039	.0059	.0079	.0098			.0020–.0079		When axial grooving, reduce feed by 40%.
4 mm (.080")	.0039	.0059	.0079	.0098	.0118			.0039–.0098		
5 mm (.100")	.0039	.0059	.0079	.0098	.0118	.0138		.0039–.0118		
6 mm (.120")	.0039	.0059	.0079	.0098	.0118	.0138	.0157	.0059–.0138		

GX – Cutting depths and feed rates

GX-M1		
Groove width CW (mm)	 Grooving/Parting off	
	Feed f (mm/rev.)	
2	0,05–0,15	
3	0,10–0,20	
4	0,10–0,25	

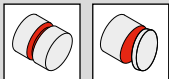
GX circlip grooving		
Groove width CW (mm)	 Grooving	
	Feed f (mm/rev.)	
0,60–1,70	0,02–0,09	
1,95–2,25	0,05–0,10	
2,75–3,25	0,05–0,12	

GX standard / GX-27P / GX-27PF									
Radius CRE (mm)	<div> Longitudinal turning</div>								<div></div> <div>Grooving/Parting off</div>
	Depth of cut a_p (mm)								
	0,5	1,0	1,5	2,0	2,5	3,0	3,5	4,0	
	Feed f (mm/rev.)								f (mm/rev)
0,8									0,05–0,10
1,0									0,05–0,15
1,2									0,05–0,15
1,5	0,10–0,45	0,05–0,45	0,05–0,40						0,05–0,15
2,0	0,15–0,50	0,10–0,50	0,10–0,50	0,10–0,40					0,075–0,20
2,5	0,15–0,60	0,10–0,60	0,10–0,60	0,10–0,50	0,10–0,45				0,10–0,25
3,0	0,25–0,70	0,20–0,70	0,15–0,70	0,15–0,70	0,15–0,65	0,15–0,60	0,15–0,55		0,10–0,30
4,0	0,25–0,80	0,20–0,80	0,15–0,80	0,15–0,80	0,15–0,80	0,15–0,80	0,15–0,75	0,15–0,70	0,15–0,35

GX-M3							
Radius CRE (mm)	 Longitudinal turning						 
	Depth of cut a_p (mm)						Grooving/Parting off
	0,5	1,0	1,5	2,0	2,5	3,0	
	Feed f (mm/rev.)						f (mm/rev)
1,5	0,15–0,35	0,15–0,35	0,15–0,30				0,05–0,20
2,0	0,15–0,40	0,15–0,40	0,15–0,40	0,15–0,30			0,10–0,25
2,5	0,15–0,50	0,15–0,50	0,15–0,50	0,15–0,40	0,15–0,35		0,10–0,25
3,0	0,20–0,70	0,20–0,70	0,20–0,70	0,20–0,60	0,20–0,50	0,20–0,40	0,10–0,35

GX-M33								
Radius CRE (mm)	 Longitudinal turning						 	
	Depth of cut a_p (mm)						Grooving/Parting off	
	0,5	1,0	1,5	2,0	2,5	3,0		
	Feed f (mm/rev.)						f (mm/rev)	
1,5	0,05–0,25	0,05–0,20	0,05–0,15				0,05–0,15	
2,0	0,05–0,35	0,05–0,30	0,05–0,25	0,05–0,20			0,05–0,20	
2,5	0,10–0,45	0,10–0,40	0,10–0,35	0,10–0,30	0,10–0,25		0,05–0,25	
3,0	0,10–0,50	0,10–0,45	0,10–0,40	0,10–0,35	0,10–0,30	0,10–0,25	0,10–0,25	

GX – Cutting depths and feed rates

GX-M1	
Groove width CW	 Grooving/Parting off
	Feed rate f (inch/rev.)
2 mm (.080")	.0020–.0059
3 mm (.120")	.0039–.0079
4 mm (.160")	.0039–.0098

GX circlip grooving	
Groove width CW	 Grooving
	Feed rate f (inch/rev.)
0,60–1,70 mm (.0240"–.0670")	.0008–.0036
1,95–2,25 mm (.0760"–.0880")	.0020–.0040
2,75–3,25 mm (.1080"–.1270")	.0020–.0050

GX standard / GX-27P / GX-27PF									
Radius CRE	 Longitudinal turning								 
	Depth of Cut a_p (inch)								Grooving/Parting off
	.020	.040	.060	.080	.100	.120	.140	.160	
	Feed rate f (inch/rev.)								f (inch/rev)
0,8 mm (.030")									.0020–.0039
1,0 mm (.040")									.0020–.0059
1,2 mm (.050")									.0020–.0059
1,5 mm (.060")	.0039–.0177	.0020–.0177	.0020–.0157						.0020–.0059
2,0 mm (.080")	.0059–.0197	.0039–.0197	.0039–.0197	.0039–.0157					.0030–.0079
2,5 mm (.100")	.0059–.0236	.0039–.0236	.0039–.0236	.0039–.0197	.0039–.0177				.0039–.0098
3,0 mm (.120")	.0098–.0276	.0079–.0276	.0059–.0276	.0059–.0276	.0059–.0256	.0059–.0236	.0059–.0217		.0039–.0118
4,0 mm (.160")	.0098–.0315	.0079–.0315	.0059–.0315	.0059–.0315	.0059–.0315	.0059–.0315	.0059–.0295	.0059–.0276	.0059–.0138

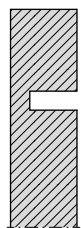
GX-M3								
Radius CRE	 Longitudinal turning						 	
	Depth of Cut a_p (inch)						Grooving/Parting off	
	.020	.040	.060	.080	.100	.120		
	Feed rate f (inch/rev.)						f (inch/rev)	
1,5 mm (.060")	.0059–.0138	.0059–.0138	.0059–.0118				.0020–.0079	
2,0 mm (.080")	.0059–.0157	.0059–.0157	.0059–.0157	.0059–.0118			.0039–.0098	
2,5 mm (.100")	.0059–.0197	.0059–.0197	.0059–.0197	.0059–.0157	.0059–.0138		.0039–.0098	
3,0 mm (.120")	.0079–.0276	.0079–.0276	.0079–.0276	.0079–.0236	.0079–.0197	.0079–.0157	.0039–.0138	

GX-M33							
Radius CRE	<div> Longitudinal turning</div>						<div></div>
	Depth of Cut a_p (inch)						Grooving/Parting off
	.020	.040	.060	.080	.100	.120	
	Feed rate f (inch/rev.)						
1,5 mm (.060")	.0020–.0098	.0020–.0078	.0020–.0059				.0020–.0059
2,0 mm (.080")	.0020–.0140	.0020–.0118	.0020–.0098	.0020–.0078			.0020–.0078
2,5 mm (.100")	.0020–.0180	.0039–.0157	.0020–.0014	.0039–.0118	.0039–.0098		.0020–.0098
3,0 mm (.120")	.0039–.0196	.0039–.0177	.0039–.0157	.0039–.0137	.0039–.0137	.0039–.0098	.0039–.0098

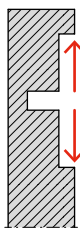
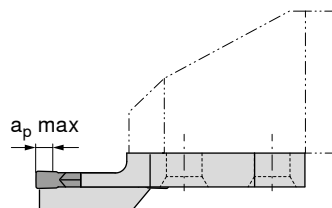
GX 24 – Axial grooving and face turning

Feedrate guide

Axial grooving



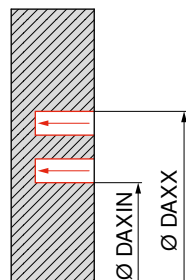
Face turning



Designation	Axial grooving Feed f (mm/rev.)	Face turning	
		f (mm/rev)	a _p max. (mm)
GX 24-2 E 3.00 ..	0,05–0,15	0,05–0,20	2,5
GX 24-3 E 4.00 ..	0,05–0,15	0,05–0,25	3,0
GX 24-3 E 5.00 ..	0,05–0,15	0,10–0,25	3,0
GX 24-4 E 6.00 ..	0,05–0,20	0,10–0,30	3,5

Machining notes

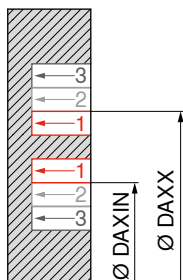
Axial grooving



It is only possible to groove within the fixed diameter range of the axial grooving module or axial monoholder (e.g., 50 – 70 mm).

Important: The indicated diameter range is always valid for the external diameter of the groove!

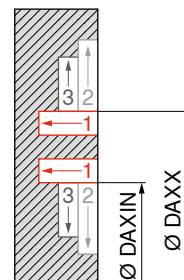
Axial grooving – groove widening



In the case of face turning, it is possible to widen the groove above and below the diameter range indicated on the axial grooving module or monoholder.

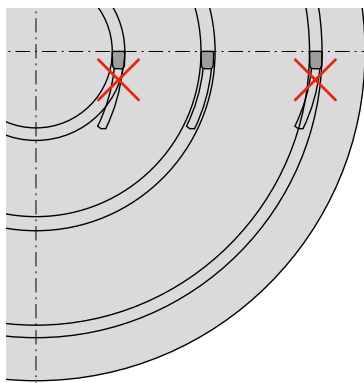
Important: Only the first groove must lie within the diameter range of the axial grooving module or axial monoholder. The depth of the widening groove must not be larger than the depth of the original groove.

Axial grooving and face turning



Groove widening by face turning in the diameter range above and below the values specified for the axial grooving module and axial monoholder is possible.

Important: Only the first groove must lie within the diameter range of the module.

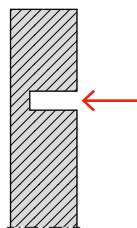


Attention: The diameter of face grooves must lie within the diameter range indicated on the axial grooving module and axial monoholder. Not following this range will result in the tool being damaged or destroyed.

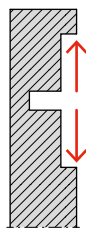
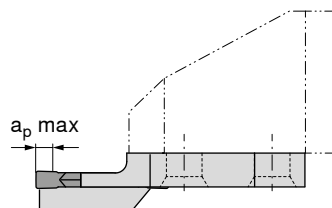
GX 24 – Axial grooving and face turning

Feedrate guide

Axial grooving



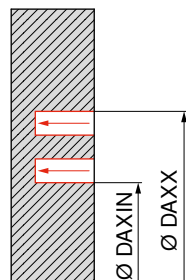
Face turning



Designation	Axial grooving		Face turning		a _p max.	
	f (mm/rev)	f (inch/rev)	f (mm/rev)	f (inch/rev)	(mm)	(inch)
GX 24-2 E 3.00 ..	0,05–0,15	.0019–.0057	0,05–0,20	.0019–.0078	2,5	0.100
GX 24-3 E 4.00 ..	0,05–0,15	.0019–.0057	0,05–0,25	.0019–.0098	3,0	0.120
GX 24-3 E 5.00 ..	0,05–0,15	.0019–.0057	0,10–0,25	.0039–.0098	3,0	0.120
GX 24-4 E 6.00 ..	0,05–0,20	.0019–.0078	0,10–0,30	.0039–.0117	3,5	0.140

Machining notes

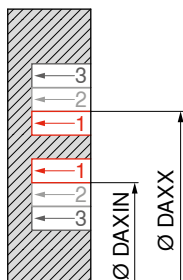
Axial grooving



It is only possible to groove within the fixed diameter range of the axial grooving module or axial monoholder (e.g., 50 – 70 mm).

Important: The indicated diameter range is always valid for the external diameter of the groove!

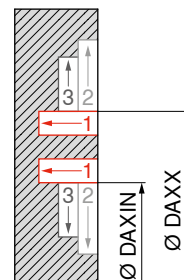
Axial grooving – groove widening



In the case of face turning, it is possible to widen the groove above and below the diameter range indicated on the axial grooving module or monoholder.

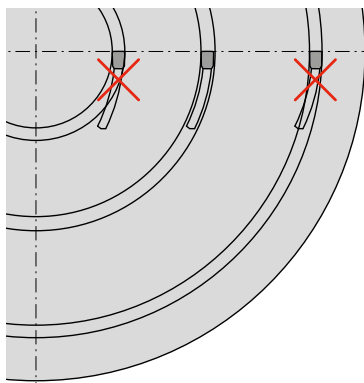
Important: Only the first groove must lie within the diameter range of the axial grooving module or axial monoholder. The depth of the widening groove must not be larger than the depth of the original groove.

Axial grooving and face turning



Groove widening by face turning in the diameter range above and below the values specified for the axial grooving module and axial monoholder is possible.

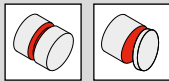
Important: Only the first groove must lie within the diameter range of the module.



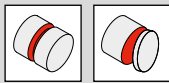
Attention: The diameter of face grooves must lie within the diameter range indicated on the axial grooving module and axial monoholder. Not following this range will result in the tool being damaged or destroyed.

SX – Cutting depths and feed rates

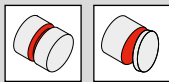
SX-F2

Groove width CW (mm)	 Longitudinal turning							 Grooving/Parting off	
	Depth of cut a_p (mm)							f (mm/rev)	
	0,50	0,75	1,00	1,25	1,50	1,75	2,00		
2	0,03–0,15	0,03–0,15	0,03–0,15	0,03–0,10				0,05–0,15	
3	0,04–0,17	0,04–0,17	0,04–0,17	0,04–0,15	0,04–0,13	0,04–0,12		0,075–0,20	
4	0,05–0,20	0,05–0,20	0,05–0,20	0,05–0,20	0,05–0,20	0,05–0,17	0,05–0,15	0,10–0,25	

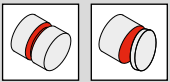
SX-27P

Groove width CW (mm)	 Longitudinal turning						 Grooving/Parting off	
	Depth of cut a_p (mm)						f (mm/rev)	
	0,5	1,0	1,5	2,0	2,5	3,0		
2	0,05–0,23	0,05–0,23	0,05–0,23	0,05–0,20			0,05–0,20	
3	0,05–0,25	0,05–0,25	0,05–0,25	0,05–0,25	0,05–0,20		0,05–0,25	
4	0,10–0,30	0,10–0,30	0,10–0,30	0,10–0,30	0,10–0,30	0,10–0,25	0,05–0,30	

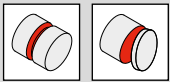
SX-M2

Groove width CW (mm)	 Longitudinal turning						 Grooving/Parting off	
	Depth of cut a_p (mm)						f (mm/rev)	
	0,5	1,0	1,5	2,0	2,5	3,0		
2	0,05–0,17	0,05–0,13	0,05–0,10				0,05–0,15	
3	0,07–0,20	0,07–0,20	0,07–0,18	0,07–0,15			0,075–0,20	
4	0,10–0,25	0,10–0,25	0,10–0,25	0,10–0,22	0,10–0,18		0,10–0,25	
5	0,12–0,27	0,12–0,27	0,12–0,27	0,12–0,25	0,12–0,22		0,10–0,30	
6	0,15–0,30	0,15–0,30	0,15–0,30	0,15–0,30	0,15–0,25	0,15–0,20	0,15–0,35	

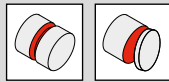
SX-M1

Groove width CW (mm)	 Grooving/Parting off	
	f (mm/rev)	
2	0,05–0,15	
3	0,10–0,20	
4	0,10–0,25	
5	0,15–0,30	
6	0,15–0,35	

SX-M7

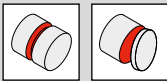
Groove width CW (mm)	 Grooving/Parting off	
	f (mm/rev)	
2	0,10–0,20	
3	0,10–0,20	
4	0,10–0,20	
5	0,15–0,25	
6	0,15–0,25	

SX-M8

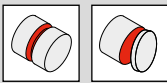
Groove width CW (mm)	 Grooving/Parting off	
	f (mm/rev)	
2	0,05–0,20	
3	0,05–0,20	
4	0,05–0,15	
5	0,05–0,15	
6	0,05–0,15	

SX – Cutting depths and feed rates

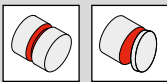
SX-F2

Groove width CW	 Longitudinal turning								
	Depth of Cut a_p (inch)							Grooving/Parting off	
	.020	.003	.040	.050	.060	.070	.080	f (inch/rev)	
2 mm (.080")	.0012–.0059	.0012–.0059	.0012–.0059	.0012–.0039				.0020–.0059	
3 mm (.120")	.0016–.0067	.0016–.0067	.0016–.0067	.0016–.0059	.0016–.0051	.0016–.0047		.0028–.0079	
4 mm (.160")	.0020–.0079	.0020–.0079	.0020–.0079	.0020–.0079	.0020–.0079	.0020–.0067	.0020–.0059	.0039–.0098	

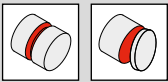
SX-27P

Groove width CW	 Longitudinal turning							
	Depth of Cut a_p (inch)						Grooving/Parting off	
	.020	.040	.060	.080	.100	.120	f (inch/rev)	
2 mm (.080")	.0029–.0091	.0020–.0091	.0020–.0091	.0020–.0079			.0020–.0079	
3 mm (.120")	.0020–.0098	.0020–.0098	.0020–.0098	.0020–.0098	.0020–.0079		.0020–.0098	
4 mm (.160")	.0039–.0118	.0039–.0118	.0039–.0118	.0039–.0118	.0039–.0118	.0039–.0098	.0020–.0118	

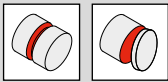
SX-M2

Groove width CW	 Longitudinal turning							
	Depth of Cut a_p (inch)						Grooving/Parting off	
	.020	.040	.060	.080	.100	.120	f (inch/rev)	
2 mm (.080")	.0020–.0067	.0020–.0051	.0020–.0039				.0020–.0059	
3 mm (.120")	.0028–.0079	.0028–.0079	.0028–.0071	.0028–.0059			.0028–.0079	
4 mm (.160")	.0039–.0098	.0039–.0098	.0039–.0098	.0039–.0087	.0039–.0071		.0039–.0098	
5 mm (.200")	.0047–.0106	.0047–.0106	.0047–.0106	.0047–.0098	.0047–.0087		.0039–.0118	
6 mm (.240")	.0059–.0118	.0059–.0118	.0059–.0118	.0059–.0118	.0059–.0098	.0059–.0079	.0059–.0138	

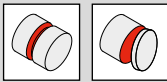
SX-M1

Groove width CW	
	f (inch/rev)
2 mm (.080")	.0020–.0059
3 mm (.120")	.0039–.0079
4 mm (.160")	.0039–.0098
5 mm (.200")	.0059–.0118
6 mm (.240")	.0059–.0138

SX-M7

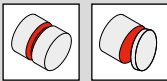
Groove width CW	
	f (inch/rev)
2 mm (.080")	.0039–.0079
3 mm (.120")	.0039–.0079
4 mm (.160")	.0039–.0079
5 mm (.200")	.0059–.0098
6 mm (.240")	.0059–.0098

SX-M8

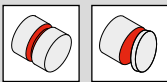
Groove width CW	
	f (inch/rev)
2 mm (.080")	.0019–.0079
3 mm (.120")	.0019–.0079
4 mm (.160")	.0019–.0059
5 mm (.200")	.0019–.0059
6 mm (.240")	.0019–.0059

SX/LX – Cutting depths and feed rates

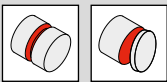
SX-M3

Radius CRE (mm)	 Longitudinal turning						 Grooving/Parting off	
	Depth of cut a_p (mm)							
	0,5	1,0	1,5	2,0	2,5	3,0	f (mm/rev)	
1,5	0,15–0,35	0,15–0,35	0,15–0,30				0,05–0,20	
2	0,15–0,40	0,15–0,40	0,15–0,40	0,15–0,30			0,10–0,25	
2,5	0,15–0,50	0,15–0,50	0,15–0,50	0,15–0,40	0,15–0,35		0,10–0,25	
3	0,20–0,70	0,20–0,70	0,20–0,70	0,20–0,60	0,20–0,50	0,20–0,40	0,10–0,35	

LX-M2

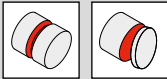
Groove width CW (mm)	 Longitudinal turning								 Grooving/Parting off	
	Depth of cut a_p (mm)									
	0,5	1,0	1,5	2,0	2,5	3,0	3,5	4,0	f (mm/rev)	
8	0,17–0,45	0,17–0,45	0,17–0,45	0,17–0,45	0,17–0,40	0,17–0,37	0,17–0,35		0,20–0,50	
10	0,20–0,50	0,20–0,50	0,20–0,50	0,20–0,50	0,20–0,46	0,20–0,42	0,20–0,38	0,20–0,35	0,20–0,50	

LX-M3

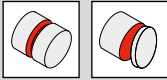
Radius CRE (mm)	 Longitudinal turning								 Grooving/Parting off	
	Depth of cut a_p (mm)									
	0,5	1,0	1,5	2,0	2,5	3,0	3,5	4,0	f (mm/rev)	
4	0,25–0,80	0,25–0,80	0,25–0,80	0,25–0,80	0,25–0,80	0,25–0,70	0,25–0,60	0,25–0,50	0,15–0,35	

SX/LX – Cutting depths and feed rates

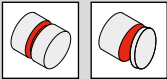
SX-M3

Radius CRE	 Longitudinal turning						 Grooving/Parting off	
	Depth of Cut a_p (inch)							
	.020	.040	.060	.080	.100	.120	f (inch/rev)	
1,5 mm (.060")	.0059–.0138	.0059–.0138	.0059–.0118				.0022–.0079	
2 mm (.080")	.0059–.0157	.0059–.0157	.0059–.0157	.0059–.0118			.0039–.0010	
2,5 mm (.100")	.0059–.0197	.0059–.0197	.0059–.0197	.0059–.0157	.0059–.0138		.0039–.0010	
3 mm (.120")	.0079–.0276	.0079–.0276	.0079–.0276	.0079–.0236	.0079–.0197	.0079–.0157	.0039–.0014	

LX-M2

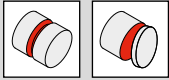
Groove width CW	 Longitudinal turning								 Grooving/Parting off	
	Depth of Cut a_p (inch)									
	.020	.040	.060	.080	.100	.120	.140	.160	f (inch/rev)	
8 mm (.320")	.0067–.0177	.0067–.0177	.0067–.0177	.0067–.0177	.0067–.0157	.0067–.0146	.0067–.0138		.0080–.0020	
10 mm (.400")	.0079–.0197	.0079–.0197	.0079–.0197	.0079–.0197	.0079–.0181	.0079–.0165	.0079–.0150	.0079–.0138	.0080–.0020	

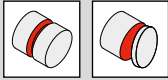
LX-M3

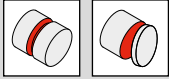
Radius CRE	 Longitudinal turning								 Grooving/Parting off	
	Depth of Cut a_p (inch)									
	.020	.040	.060	.080	.100	.120	.140	.160	f (inch/rev)	
4 mm (.160")	.0098–.0315	.0098–.0315	.0098–.0315	.0098–.0315	.0098–.0315	.0098–.0276	.0098–.0236	.0098–.0197	.0060–.0014	

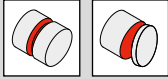
AX/FX – Cutting depths and feed rates

AX-F50						
Size	 Face turning				 Axial grooving	
	Depth of cut a_p (mm)				First groove	
	0,50	1,00	1,50	2,3	Feed f (mm/rev.)	Feed f (mm/rev.)
AX05	0,03–0,10	0,03–0,10			0,025–0,080	0,025–0,20
AX10	0,03–0,13	0,03–0,13	0,03–0,13		0,025–0,065	0,05–0,25
AX15	0,03–0,15	0,03–0,15	0,03–0,15	0,03–0,15	0,025–0,050	0,05–0,30

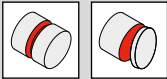
FX-F1		
Groove width CW (mm)	 Grooving/Parting off	
	Feed f (mm/rev.)	
2,2	0,025–0,10	
3,1	0,05–0,15	
4,1	0,05–0,20	

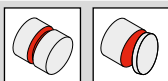
FX-M1		
Groove width CW (mm)	 Grooving/Parting off	
	Feed f (mm/rev.)	
2,2	0,05–0,15	
3,1	0,08–0,18	
4,1	0,10–0,20	
5,1	0,15–0,28	
6,5	0,15–0,33	
8,2	0,20–0,40	
9,7	0,20–0,40	

FX-27P		
Groove width CW (mm)	 Grooving/Parting off	
	Feed f (mm/rev.)	
2,2	0,01–0,10	
3,1	0,015–0,125	
4,1	0,05–0,15	

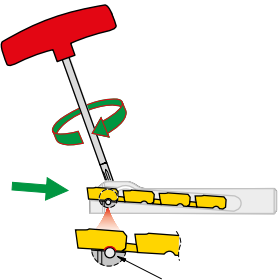
FX-R2		
Groove width CW (mm)	 Grooving/Parting off	
	Feed f (mm/rev.)	
3,1	0,10–0,275	
4,1	0,15–0,35	

MaxiClick – Cutting depths and feed rates

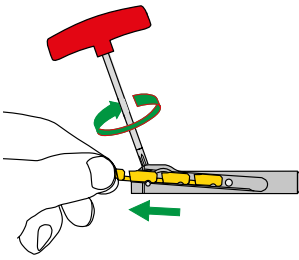
MC05					
Groove width CW (mm)	 Longitudinal turning				
	Depth of cut a_p (mm)			Grooving/Parting off	
	0,25	0,5	0,75	f (mm/rev)	
1	0,02–0,15	0,02–0,10		0,03–0,10	
1,5	0,02–0,20	0,02–0,20	0,02–0,14	0,03–0,11	

MC10						
Groove width CW (mm)	 Longitudinal turning					
	Depth of cut a_p (mm)					
	0,5	0,75	1,0	1,25	1,5	
	Feed f (mm/rev.)					f (mm/rev)
1,5	0,02–0,20	0,02–0,15	0,02–0,10			0,03–0,11
2	0,02–0,20	0,02–0,20	0,02–0,14	0,02–0,10		0,03–0,12
2,5	0,02–0,20	0,02–0,20	0,02–0,17	0,02–0,13	0,02–0,10	0,03–0,15

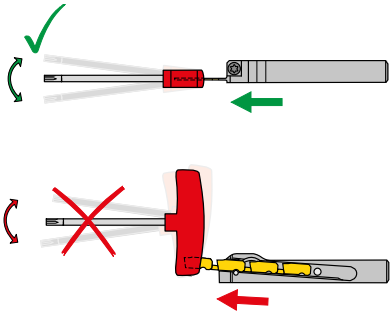
MaxiClick – System function



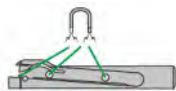
Correct cutting insert location in the seat



Withdraw cutting insert



Worn-out cutting insert is broken off towards the left or right side



Magnets prevent the cutting insert from falling out of the tool holder during positioning

HX – Cutting data standard values

HX-R70

Size	Feed f (mm/rev)	Cutting speed v _c (m/min)
	min. – Recommended – max.	min. – Recommended – max.
HX 32	0,35 - 0,55 - 0,95	30 - 70 - 100
HX 40	0,50 - 0,75 - 1,00	30 - 40 - 90
HX 45	0,50 - 0,80 - 1,10	30 - 40 - 80
HX 50	0,55 - 0,90 - 1,20	30 - 40 - 80
HX 60	0,60 - 1,00 - 1,30	30 - 40 - 70



HX-R81

Size	Feed f (mm/rev)	Cutting speed v _c (m/min)
	min. – Recommended – max.	min. – Recommended – max.
HX 16	0,20 - 0,35 - 0,70	40 - 100 - 140
HX 20	0,25 - 0,40 - 0,75	40 - 90 - 140
HX 25	0,30 - 0,45 - 0,80	40 - 70 - 120
HX 32	0,35 - 0,50 - 0,85	30 - 70 - 100
HX 40	0,50 - 0,70 - 0,95	30 - 40 - 90
HX 45	0,50 - 0,75 - 1,00	30 - 40 - 80
HX 50	0,55 - 0,80 - 1,10	30 - 40 - 80
HX 60	0,60 - 0,90 - 1,20	30 - 40 - 70



HX-R71

Size	Feed f (mm/rev)	Cutting speed v _c (m/min)
	min. – Recommended – max.	min. – Recommended – max.
HX 16	0,25 - 0,45 - 0,90	40 - 100 - 140
HX 20	0,30 - 0,50 - 0,90	40 - 90 - 140
HX 25	0,30 - 0,60 - 1,00	40 - 70 - 120

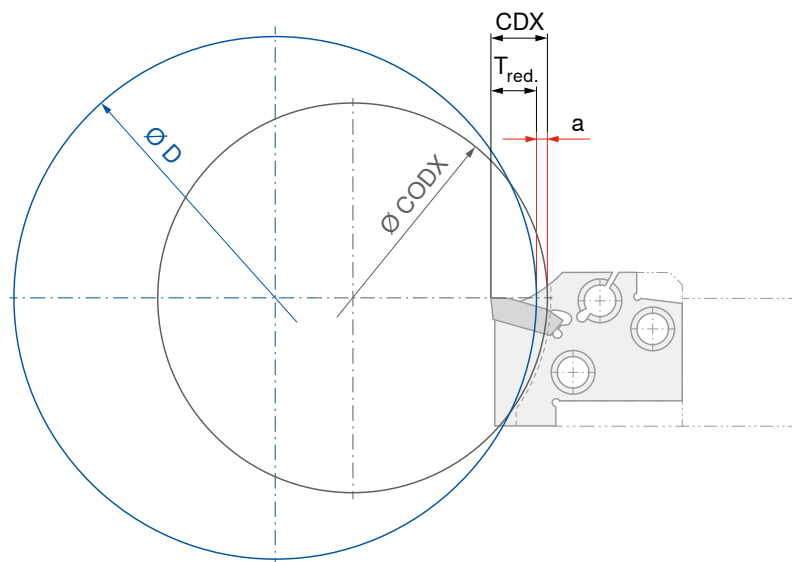


ModularClamp – Grooving depth reduction

Depending on the size, the ModularClamp grooving modules are designed for use with a specific workpiece diameter CODX. If the workpiece diameter is larger than the CODX of the grooving module, the achievable groove depth is reduced by the dimension "a". The extent of the reduction is determined using the following table.

		Reduction a (mm) of the maximum grooving depth (CDX)															
		0,5	1,0	1,5	2,0	2,5	3,0	3,5	4,0	4,5	5,0	5,5	6,0	6,5	7,0	7,5	8,0
Size	E12	35	40	45	60	75	115	> 250									
	E16	50	55	60	70	80	100	130	200	> 420							
	E20	60	65	70	75	85	95	110	130	165	220	> 330					
	E25	75	80	85	90	100	110	125	140	160	190	240	320	> 500			
	E32	95	100	105	110	120	125	135	145	160	180	200	225	270	320	400	530 > 800
		Workpiece diameter D (mm)															
		Maximum workpiece diameter (CODX) with full groove depth (CDX) in mm															

Calculation example:



CDX =
Maximum grooving depth (mm)

CODX =
Maximum workpiece Ø with full groove depth (mm)

a =
Reduction amount (mm)

$$T_{\text{red.}} = \text{CDX} - a$$

E25R21-GX24-3

CDX = 21 mm, Ø CODX = 75 mm
Size 25

Workpiece diameter
D = Ø 100 mm

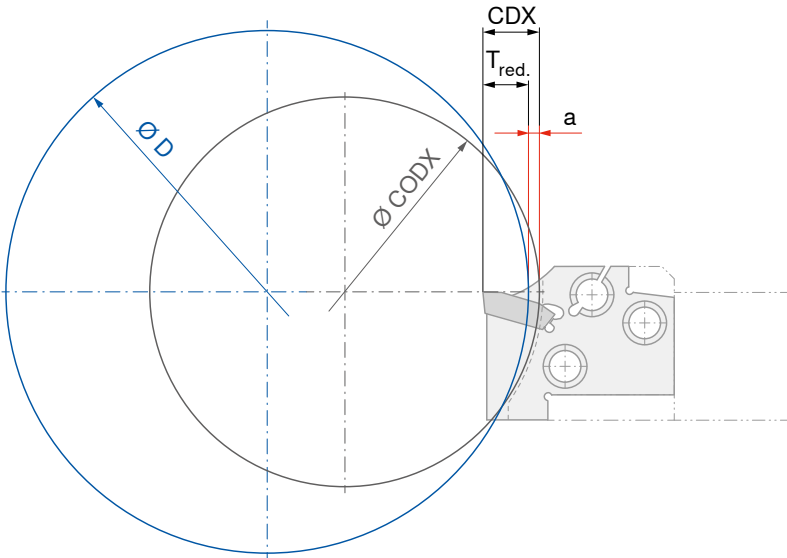
$$T_{\text{red.}} = \text{CDX} - a = 21 - 2 = 19 \text{ mm}$$

ModularClamp – Grooving depth reduction

Depending on the size, the ModularClamp grooving modules are designed for use with a specific workpiece diameter CODX. If the workpiece diameter is larger than the CODX of the grooving module, the achievable groove depth is reduced by the dimension "a". The extent of the reduction is determined using the following table.

		Reduction a (mm) of the maximum grooving depth (CDX)															
		0,5 mm (.020")	1,0 mm (.040")	1,5 mm (.060")	2,0 mm (.080")	2,5 mm (.100")	3,0 mm (.120")	3,5 mm (.140")	4,0 mm (.160")	4,5 mm (.180")	5,0 mm (.200")	5,5 mm (.220")	6,0 mm (.240")	6,5 mm (.260")	7,0 mm (.280")	7,5 mm (.300")	8,0 mm (.320")
Size	E12	35 mm (1.38")	40 mm (1.57")	45 mm (1.77")	60 mm (2.36")	75 mm (2.95")	115 mm (4.53")	> 250 mm (> 9.84")									
	E16	50 mm (1.97")	55 mm (2.17")	60 mm (2.36")	70 mm (2.76")	80 mm (3.15")	100 mm (3.94")	130 mm (5.12")	200 mm (7.87")	> 420 mm (> 16.54")							
	E20	60 mm (2.36")	65 mm (2.56")	70 mm (2.76")	75 mm (2.95")	85 mm (3.35")	95 mm (3.74")	110 mm (4.33")	130 mm (5.12")	165 mm (6.50")	220 mm (8.66")	> 330 mm (> 12.99")					
	E25	75 mm (2.95")	80 mm (3.15")	85 mm (3.35")	90 mm (3.54")	100 mm (3.94")	110 mm (4.33")	125 mm (4.92")	140 mm (5.51")	160 mm (6.30")	190 mm (7.48")	240 mm (9.45")	320 mm (12.60")	> 500 mm (> 19.69")			
	E32	95 mm (3.74")	100 mm (3.94")	105 mm (4.13")	110 mm (4.33")	120 mm (4.72")	125 mm (4.92")	135 mm (5.31")	145 mm (5.71")	160 mm (6.30")	180 mm (7.09")	200 mm (7.87")	225 mm (8.86")	270 mm (10.63")	320 mm (12.60")	400 mm (15.75")	> 800 mm (> 31.50")
		Workpiece diameter D (mm)															
		Maximum workpiece diameter (CODX) with full groove depth (CDX) in mm															

Calculation example:



CDX =
Maximum grooving depth (mm)

CODX =
Maximum workpiece Ø with full groove depth (mm)

a =
Reduction amount (mm)

$T_{red.} = CDX - a$

E25R21-GX24-3
CDX = 21 mm (.826")
Ø CODX = 75 mm (2.95")
Size 25

Workpiece diameter
D = Ø 100 mm (3.93")

$T_{red.} = CDX - a = 21\text{ mm} - 2\text{ mm} = 19\text{ mm}$

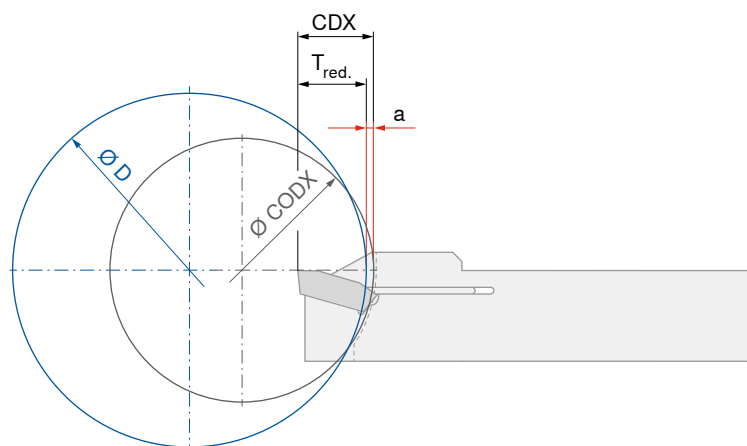
$T_{red.} = CDX - a = .826" - .080" = .746"$

MonoClamp – Grooving depth reduction

Depending on the groove width and shank size, the MonoClamp tools are designed for use with a specific workpiece diameter CODX. If the workpiece diameter is larger than the CODX of the grooving module, the achievable groove depth is reduced by the dimension "a". The extent of the reduction is determined using the following table.

		Reduction a (mm) of the maximum grooving depth (CDX)								
		0,5	1,0	1,5	2,0	2,5	3,0	3,5	4,0	4,5
Shank	E12R/L0022...	44	70	80	95	115	150	225	> 450	
	E16R/L0026...	52	90	105	125	155	210	305	> 600	
	E20R/L0026...	52	110	125	140	160	195	240	320	475
	E20R/L0033...	66	110	125	140	160	195	240	320	475
	E25R/L0026...	52	140	160	190	235	310	465	> 930	
	E25R/L0033...	66	155	175	200	230	275	340	450	675
	E25R/L0040...	80	155	175	200	230	275	340	450	675
		Workpiece diameter D (mm)								
		Maximum workpiece diameter (CODX) with full groove depth (CDX) in mm								

Calculation example:



CDX =
Maximum grooving depth (mm)

CODX =
Maximum workpiece $\varnothing$ with full groove depth (mm)

a =
Reduction amount (mm)

$$T_{red.} = CDX - a$$

E25R0033...

CDX = 33 mm, $\varnothing CODX$ = 66 mm

Workpiece diameter
D = $\varnothing$ 200 mm

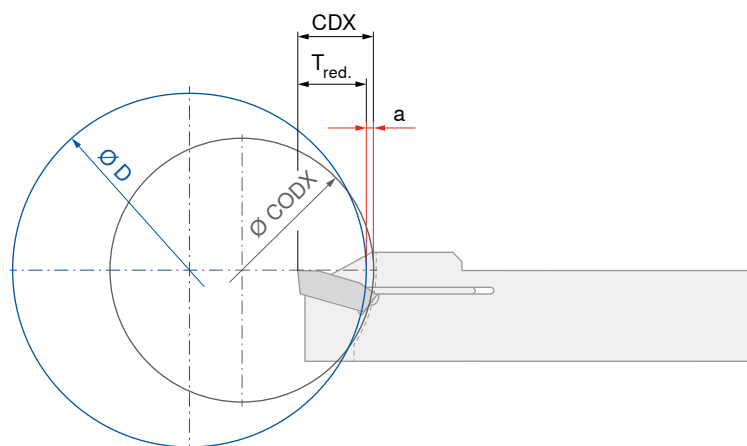
$$T_{red.} = CDX - a = 33 - 1,5 = 31,5 \text{ mm}$$

MonoClamp – Grooving depth reduction

Depending on the groove width and shank size, the MonoClamp tools are designed for use with a specific workpiece diameter CODX. If the workpiece diameter is larger than the CODX of the grooving module, the achievable groove depth is reduced by the dimension "a". The extent of the reduction is determined using the following table.

		Reduction a (mm) of the maximum grooving depth (CDX)								
		0,5 mm (.020")	1,0 mm (.040")	1,5 mm (.060")	2,0 mm (.080")	2,5 mm (.100")	3,0 mm (.120")	3,5 mm (.140")	4,0 mm (.160")	4,5 mm (.180")
Shank	E12R/L0022...	44 mm (1.73")	70 mm (2.76")	80 mm (3.15")	95 mm (3.74")	115 mm (4.53")	150 mm (5.91")	225 mm (8.86")	> 450 mm (> 17.72")	
	E16R/L0026...	52 mm (2.05")	90 mm (3.54")	105 mm (4.13")	125 mm (4.92")	155 mm (6.10")	210 mm (8.27")	305 mm (12.01")	> 600 mm (> 23.62")	
	E20R/L0026...	52 mm (2.05")	110 mm (4.33")	125 mm (4.92")	140 mm (5.51")	160 mm (6.30")	195 mm (7.68")	240 mm (9.45")	320 mm (12.60")	475 mm (18.70")
	E20R/L0033...	66 mm (2.60")	110 mm (4.33")	125 mm (4.92")	140 mm (5.51")	160 mm (6.30")	195 mm (7.68")	240 mm (9.45")	320 mm (12.60")	475 mm (18.70")
	E25R/L0026...	52 mm (2.05")	140 mm (5.51")	160 mm (6.30")	190 mm (7.48")	235 mm (9.25")	310 mm (12.20")	465 mm (18.31")	> 930 mm (> 36.61")	
	E25R/L0033...	66 mm (2.60")	155 mm (6.10")	175 mm (6.89")	200 mm (7.87")	230 mm (9.06")	275 mm (10.83")	340 mm (13.39")	450 mm (17.72")	675 mm (26.57")
	E25R/L0040...	80 mm (3.15")	155 mm (6.10")	175 mm (6.89")	200 mm (7.87")	230 mm (9.06")	275 mm (10.83")	340 mm (13.39")	450 mm (17.72")	675 mm (26.57")
		Workpiece diameter D (mm)								
		Maximum workpiece diameter (CODX) with full groove depth (CDX) in mm								

Calculation example:



CDX =
Maximum grooving depth (mm)

CODX =
Maximum workpiece Ø with full groove depth (mm)

a =
Reduction amount (mm)

$$T_{\text{red.}} = \text{CDX} - a$$

E25R0033...

CDX = 33 mm (1.30")
Ø CODX = 66 mm (2.60")

Workpiece diameter
D = Ø 200 mm (7.87")

$$T_{\text{red.}} = \text{CDX} - a = 33 \text{ mm} - 1,5 \text{ mm} = 31,5 \text{ mm}$$

$$T_{\text{red.}} = \text{CDX} - a = 1.30" - .060" = 1.24"$$

Clamping function – SX system

System function – inserting and removing the cutting inserts

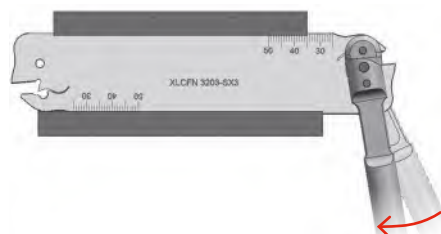
Precision system for inserting and removing the cutting inserts.

The key has been designed in such a way that it will not stress the material beyond its "elastic limit".

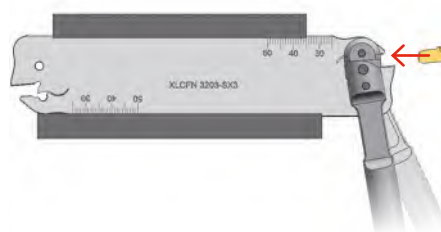
With this alternate system, the material always remains in its flexible range and provides a substantial increase in tool life.



- 1** Push the assembly key into the two recesses with the handle facing forwards.



- 2** By moving the assembly key in the direction of the arrow, the insert seat in the tool opens.



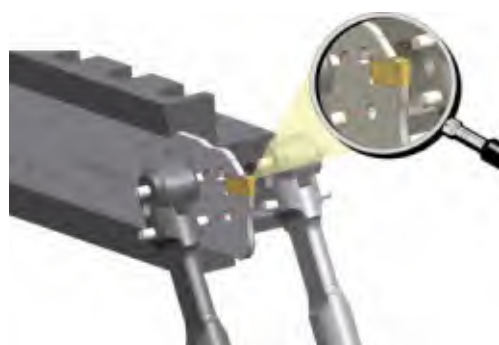
- 3** Insert the grooving insert and position it by pressing it against the stop.



- 4** Move the assembly key forwards. The insert seat closes again and the grooving insert is clamped.



When changing the indexable inserts, always maintain tension on the key!



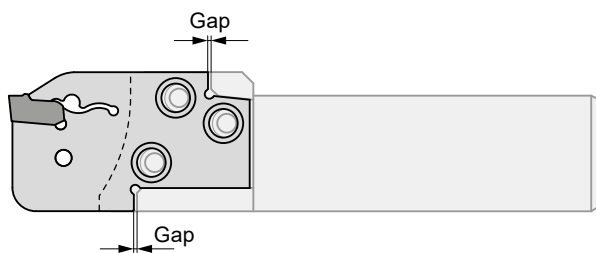
The clamp is designed so that the assembly key can be inserted from both sides of the blade according to the accessibility.



Maximum blade projection during longitudinal turning

Blade	max. overhang (mm)
SX 2 – SX 3	25
SX 4 – SX 5	30
SX 6	35

Clamping function – ModularClamp modules



Module unclamped

- ▲ Gap between module and face contact for axial clamping

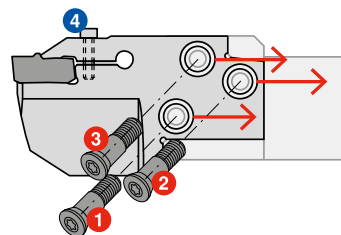


Module clamped

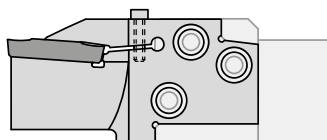
- ▲ Axial clamping with face contact
- ▲ Connection free from play, therefore maximum stability

System

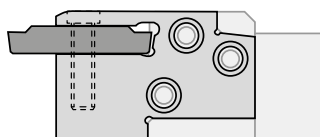
LX



GX 24



AX



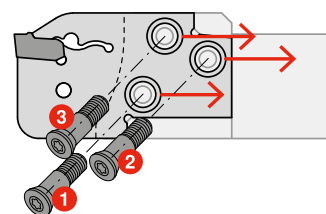
Active indexable insert clamping

Clamping screws 1, 2, and 3 are used for clamping the module.

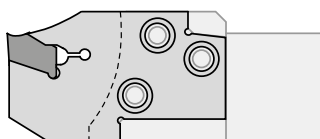
The grooving insert is retained in the module via the additional screw 4.

System

SX



FX



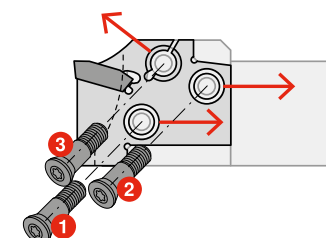
Self clamping of the indexable insert

Clamping screws 1, 2, and 3 are used for clamping the module.

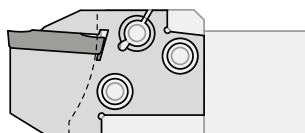
The grooving insert is self-clamping.

System

GX 09 / GX 16



GX 24



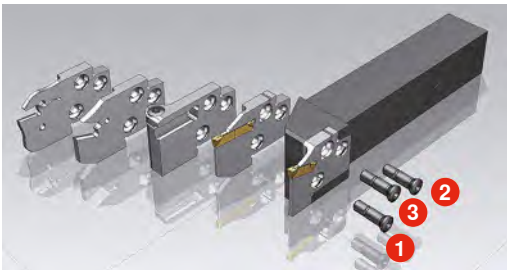
Active indexable insert clamping

Clamping screws 1 and 2 are used for clamping the module.

Important: First tighten clamping screws 1 and 2. Then clamp the grooving insert with screw 3.

Tightening torque ModularClamp module screws

Base holder



Base holder	Screw	Torx	Recommended tightening torques	
			Nm	in.lbs
E12..	M2,5x10	T08	1,2	10,6
E16..	M3,5x12,5	T15	3,2	28,3
E20..	M4x14	T15	4,0	35,4
E25..	M5x18	T20	5,0	44,3
E32..	M6x20	T25	6,0	53,1



It is important to follow the correct order for pre-tightening and tightening the screws!

Boring bar



Boring bar	Screw	Torx	Recommended tightening torques	
			Nm	in.lbs
I16..	M2,5x10	T08	1,2	10,6
I20..	M3x11	T10	2,0	17,7
I25..	M3,5x12,5	T15	3,2	28,3
I32..	M4,5x17	T20	4,0	35,4
I40..	M5x18	T20	5,0	44,3



It is important to follow the correct order for pre-tightening and tightening the screws!

Tightening torque for the insert clamping

Grooving systems	Screw	Torx	Recommended tightening torques	
			Nm	in.lbs
GX / AX / LX	M3,5	T15	3,2	28,3
	M4,0	T15/T20	4,0	35,4
	M5,0	T20	5,0	44,3

Advantages due to DirectCooling

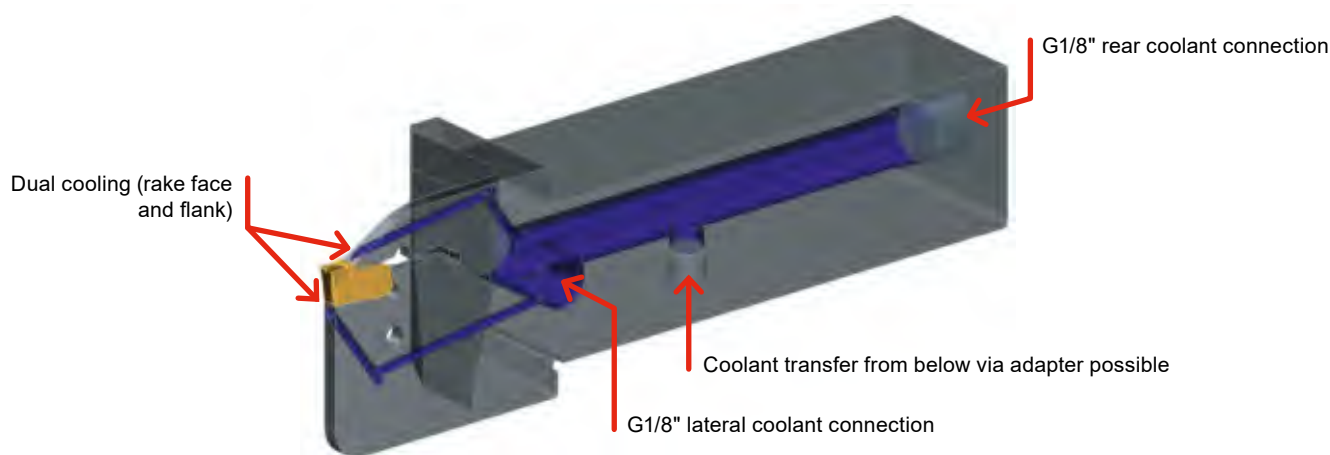
Internal coolant supply with groove machining has a decisively positive effect on your turning process.

In our CERATIZIT grooving range, the following grooving systems have an internal coolant supply:

- ▲ **SX** Grooving holder (single tool)
- ▲ **GX** grooving holder (single tool)

Advantages of DirectCooling

- ▲ Improved chip control
- ▲ Longer tool life of the insert
- ▲ Greater process security
- ▲ Application of higher cutting data

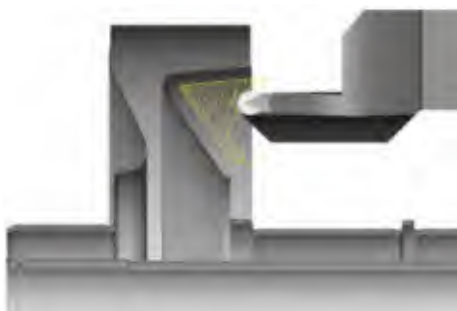
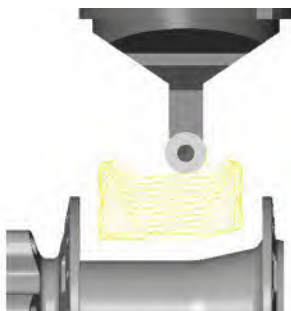


Advantages of the trochoidal turning strategy

- ▲ Less wear and longer tool life due to softer entry and exit
- ▲ Smaller angle of engagement = less vibration
- ▲ Up to 40% higher feed rate values possible
- ▲ Broad field of application in austenitic steels, heat-resistant steels, Inconel, and nickel-base alloys as well as long-chipping ductile materials
- ▲ Savings on tools

Trochoidal turning with support of the following CAM systems:

- ▲ hyperMill – High-performance turning
- ▲ Esprit CAM – ProfitTurning
- ▲ SolidCAM – Turning
- ▲ EdgeCAM – Waveform turning
- ▲ MasterCAM – Dynamic Turning

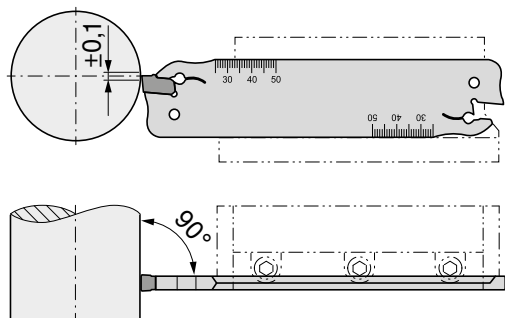


Possible applications

- ▲ Radial and axial recesses and grooves
- ▲ Rough machining – high-feed milling with button insert

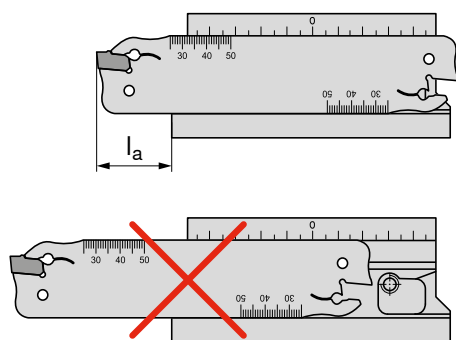
General information

Tool position

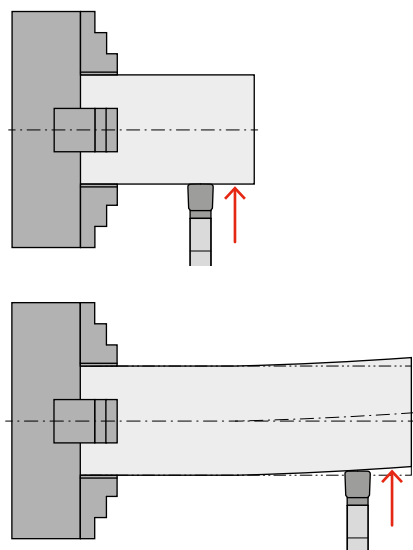


Tool overhang

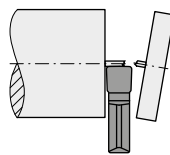
As a rule of thumb: Overhang l_a should not be greater than $8 \times CW$ (groove width).



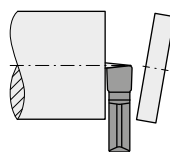
Workpiece overhang



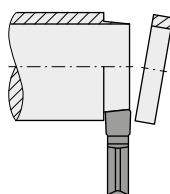
References for parting off



From $\varnothing 5$ mm on, reduce feed "f" by approximately 50 %. Do not cut across the center (risk of breakage).

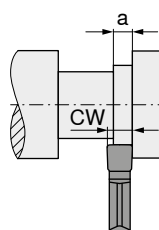


For "pip-free" parting off, use R or L inserts. To minimize lateral deflection forces, reduce the feed rate by approximately 20-50 %.

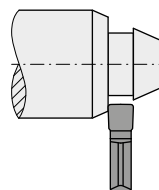


To prevent ring formation, use R or L inserts. Reduce feed "f" by approximately 20–50 % because of lateral deflection.

References for grooving



When grooving with an axial displacement, the "a" width should equal at least 70 % of the "CW" groove width.



When grooving oblique surfaces, the feed must be reduced by approx. 20–50 % until fully engaged.

Recommendation for optimum results

Task description										Solution, measures	
Type of wear				Workpiece problems				Chip control		Explanation of symbols	
Fracture	Built-up edge	Flank wear	Plastic deformation	Vibrations	Formation of pips and burrs	Chattered surface	Surface quality	Chip too long (snarl chip)	Chip too short (fragmented chip)		
										Raise, increase Large influence	↑
										Raise, increase Small influence	↑
										Avoid, reduce Large influence	↓
										Avoid, reduce Small influence	↓
										check, optimize	~
										Use	●
	↑	↓	↓	↓			↑	↓		Cutting speed	Cutting data
↓			↓	↑		↓	↓	↑	↓	Feed	
↓		↓	↓		↓	↓	↓			Feed rate at center	
↑	↓		~	~	↓	↓	↓	↓	↑	Chip breaker	Indexable insert selection
					●					R/L version	
↑		↑	↑	↓	↓	↓	↑			Corner radius	
↓		↑	↑							Cutting material	
				↓		↑	↑			Groove width	
~				~		~	~			Tool clamping	General criteria
~				~		~	~			Workpiece clamping	
~				~			↓			Overhang	
~		~		~	~		~			Tip height	
	●	●	●		●		●	●		Cooling lubricant	

Wear causes

Flank wear



Abrasion on the flank, normal wear after a certain period of operation.

Cause

- ▲ Cutting speed too high
- ▲ Carbide grade does not have enough wear resistance
- ▲ Insufficient coolant

Solution

- ▲ Reduce the cutting speed
- ▲ Choose carbide grade with greater wear resistance
- ▲ Improve coolant feed

Chipping



Increased mechanical stress on the cutting edge may result in carbide particles breaking off.

Cause

- ▲ Grade with too high a wear resistance
- ▲ Vibrations
- ▲ Feed rate or cutting depth is too high
- ▲ Chip stroke

Solution

- ▲ Use tougher grade
- ▲ Use negative cutting edge geometry with a chip breaker
- ▲ Reduce overhang; check center height
- ▲ Stabilize the cutting edge

Crater wear



The outgoing hot chip is causing cratering of the cutting insert on the clamping flat.

Cause

- ▲ Cutting speed, feed rate, or both are too high
- ▲ Rake angle too low
- ▲ Grade does not have enough wear resistance
- ▲ Incorrectly supplied cooling

Solution

- ▲ Reduce cutting speed and/or feed rate
- ▲ Increase quantity and/or pressure of coolant, check supply
- ▲ Use a more crater-resistant grade

Plastic deformation



Large mechanical load produces high machining temperatures; this can lead to plastic deformation.

Cause

- ▲ Working temperature too high, softening of the base material
- ▲ Unsuitable grade
- ▲ Inadequate coolant supply

Solution

- ▲ Reduce the cutting speed
- ▲ Choose carbide grade with greater wear resistance
- ▲ Use coolant

Built-up edge formation



Material builds up on the cutting edge if the chip does not flow correctly due to the cutting temperature being too low.

Cause

- ▲ Cutting speed too low
- ▲ Rake angle too small
- ▲ Incorrect cutting material
- ▲ Lack of cooling/lubrication

Solution

- ▲ Increase the cutting speed
- ▲ Increase rake angle
- ▲ Use TiN coating
- ▲ Use thicker emulsions

Notch wear



Contraction at maximum cutting depth.

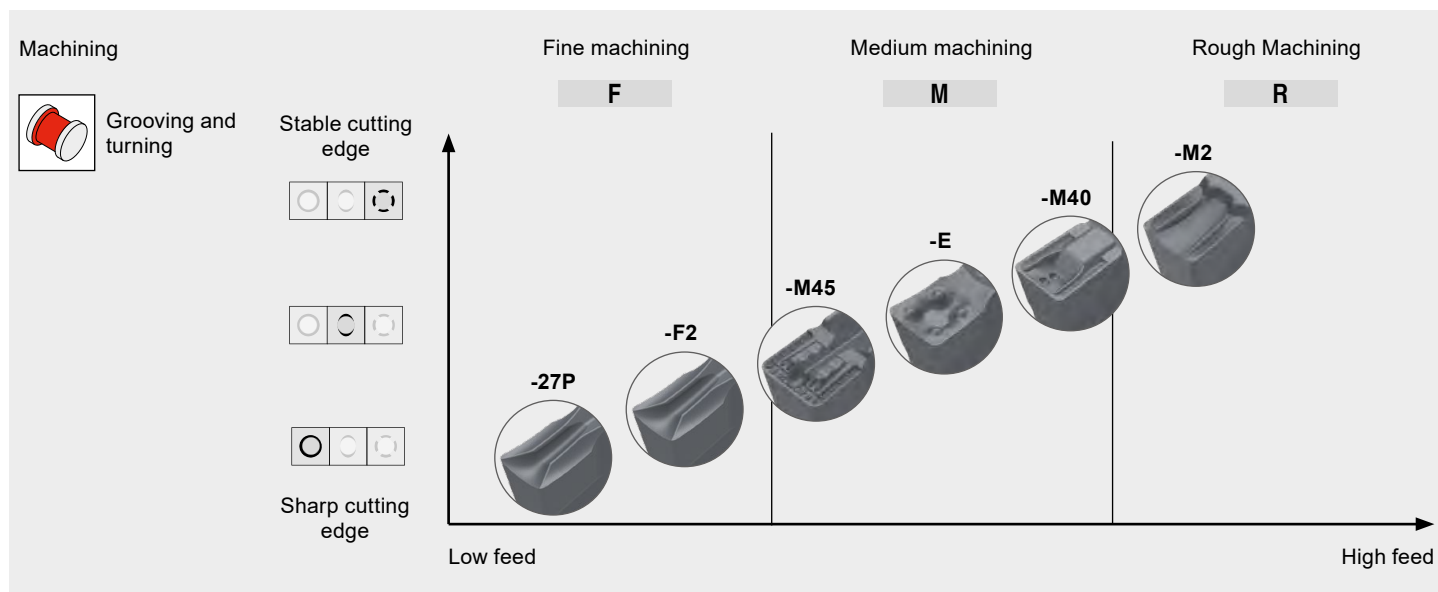
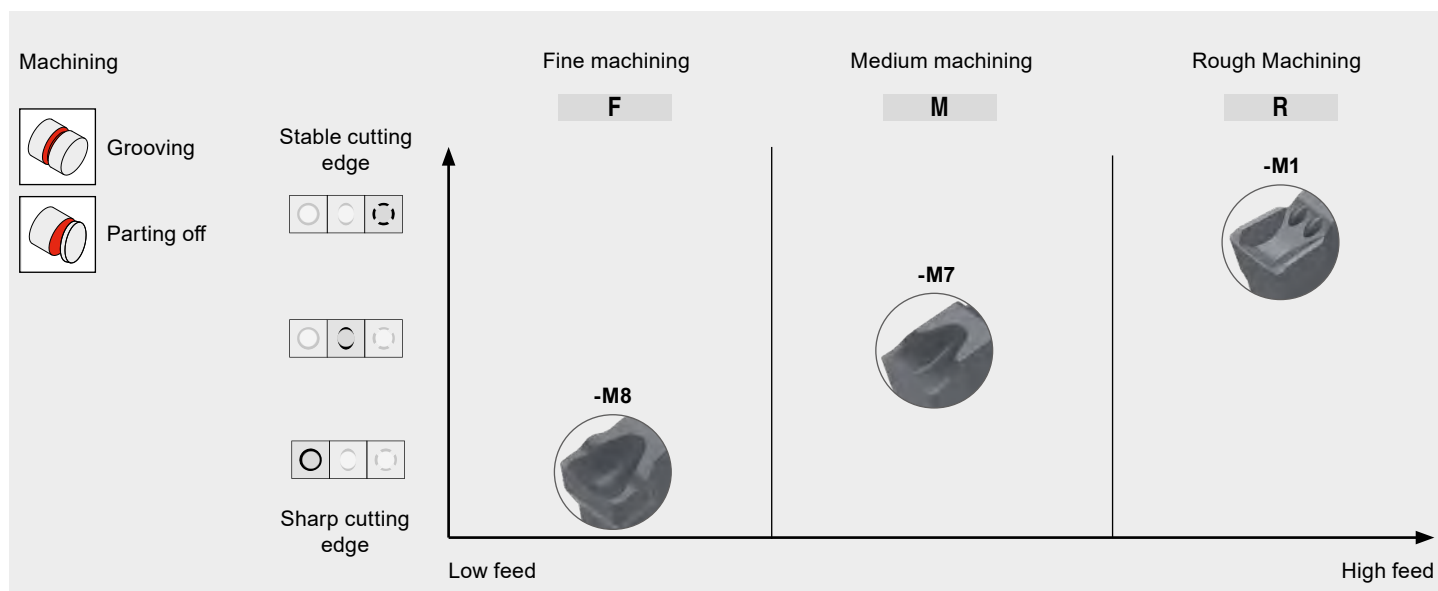
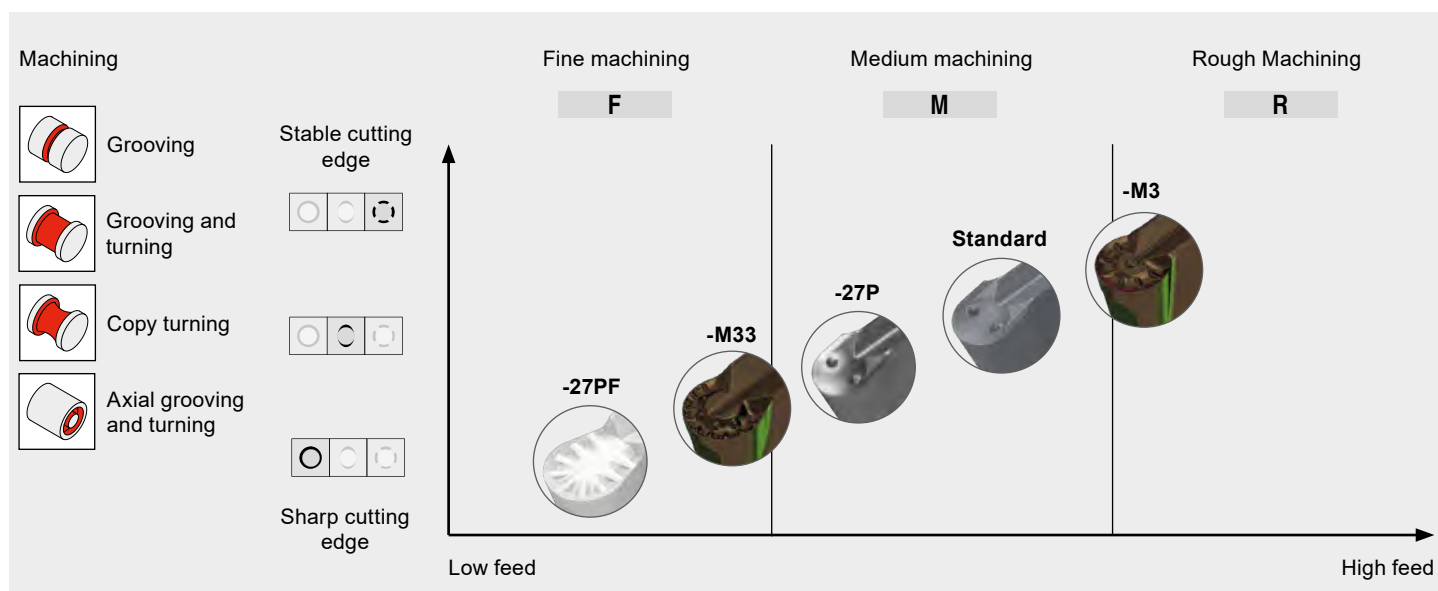
Cause

- ▲ Oxidation on the cutting edge
- ▲ Too high a temperature at the edge

Solution

- ▲ Use different cutting depths
- ▲ Reduce cutting speed
- ▲ Improve coolant feed

Chip breakers / Applications

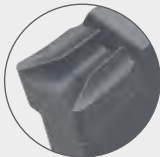
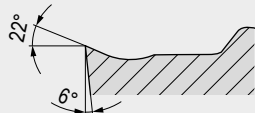
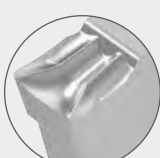
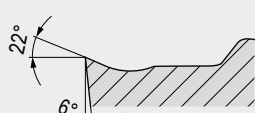
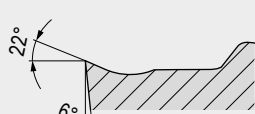
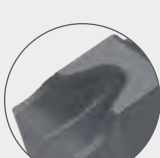


GX system	Geometry	Feed	Machining situation																												
Circlip grooving	Chip breaker	f (mm/rev.)																													
Standard <ul style="list-style-type: none"> ▲ Positive geometry ▲ Ground cutting edge ▲ Low feed rates ▲ Small corner radii ▲ Circlip grooves 		0,05–0,30	<table border="1"> <tr><td>P</td><td>●</td><td>●</td><td>○</td></tr> <tr><td>M</td><td>●</td><td>●</td><td>○</td></tr> <tr><td>K</td><td>●</td><td>●</td><td>○</td></tr> <tr><td>N</td><td>○</td><td>○</td><td>○</td></tr> <tr><td>S</td><td>●</td><td>●</td><td>○</td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td>○</td><td>○</td><td></td></tr> </table>	P	●	●	○	M	●	●	○	K	●	●	○	N	○	○	○	S	●	●	○	H				O	○	○	
P	●	●	○																												
M	●	●	○																												
K	●	●	○																												
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S	●	●	○																												
H																															
O	○	○																													
GX system	Geometry Chip breaker	Feed f (mm/rev.)	Machining situation 																												
-F2 <ul style="list-style-type: none"> ▲ Very positive geometry ▲ Ground cutting edge ▲ Low feed rates ▲ Low cutting forces ▲ First choice for stainless steel materials 		0,05–0,15	<table border="1"> <tr><td>P</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>M</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>K</td><td>●</td><td>●</td><td></td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td>●</td><td>●</td><td>○</td></tr> <tr><td>H</td><td>○</td><td></td><td></td></tr> <tr><td>O</td><td>○</td><td>○</td><td></td></tr> </table>	P	●	●	●	M	●	●	●	K	●	●		N				S	●	●	○	H	○			O	○	○	
P	●	●	●																												
M	●	●	●																												
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S	●	●	○																												
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O	○	○																													
-E / Standard <ul style="list-style-type: none"> ▲ Positive geometry ▲ Low to medium feed rates ▲ Low cutting forces ▲ Universal application ▲ First choice for axial grooving 		0,05–0,17	<table border="1"> <tr><td>P</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>M</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>K</td><td>●</td><td>●</td><td>○</td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td>●</td><td>●</td><td>○</td></tr> <tr><td>H</td><td>○</td><td></td><td></td></tr> <tr><td>O</td><td>○</td><td>○</td><td></td></tr> </table>	P	●	●	●	M	●	●	●	K	●	●	○	N				S	●	●	○	H	○			O	○	○	
P	●	●	●																												
M	●	●	●																												
K	●	●	○																												
N																															
S	●	●	○																												
H	○																														
O	○	○																													
-M40 <ul style="list-style-type: none"> ▲ Stable geometry ▲ Medium feed rates ▲ Universal application ▲ Good chip control 		0,075–0,20	<table border="1"> <tr><td>P</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>M</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>K</td><td>●</td><td>●</td><td>○</td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td>●</td><td>●</td><td>○</td></tr> <tr><td>H</td><td>○</td><td></td><td></td></tr> <tr><td>O</td><td>○</td><td>○</td><td></td></tr> </table>	P	●	●	●	M	●	●	●	K	●	●	○	N				S	●	●	○	H	○			O	○	○	
P	●	●	●																												
M	●	●	●																												
K	●	●	○																												
N																															
S	●	●	○																												
H	○																														
O	○	○																													
-M1 <ul style="list-style-type: none"> ▲ Very stable cutting edge ▲ Medium to high feed rates ▲ For interrupted cuts ▲ For high-tensile materials ▲ First choice for parting off 		0,1–0,20	<table border="1"> <tr><td>P</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>M</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>K</td><td>●</td><td>●</td><td>○</td></tr> <tr><td>N</td><td></td><td></td><td></td></tr> <tr><td>S</td><td>●</td><td>●</td><td>○</td></tr> <tr><td>H</td><td>○</td><td></td><td></td></tr> <tr><td>O</td><td>○</td><td>○</td><td></td></tr> </table>	P	●	●	●	M	●	●	●	K	●	●	○	N				S	●	●	○	H	○			O	○	○	
P	●	●	●																												
M	●	●	●																												
K	●	●	○																												
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S	●	●	○																												
H	○																														
O	○	○																													
-27P <ul style="list-style-type: none"> ▲ Very positive geometry ▲ Ground periphery ▲ Sharp cutting edge ▲ Polished clamping flat ▲ First choice for non-ferrous metals 		0,05–0,25	<table border="1"> <tr><td>P</td><td></td><td></td><td></td></tr> <tr><td>M</td><td></td><td></td><td></td></tr> <tr><td>K</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>N</td><td>●</td><td>●</td><td>●</td></tr> <tr><td>S</td><td>○</td><td>○</td><td></td></tr> <tr><td>H</td><td></td><td></td><td></td></tr> <tr><td>O</td><td>○</td><td></td><td></td></tr> </table>	P				M				K	●	●	●	N	●	●	●	S	○	○		H				O	○		
P																															
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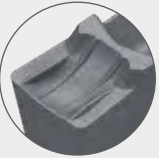
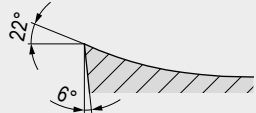
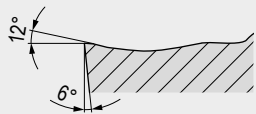
GX system	Geometry Chip breaker	Feed f (mm/rev.)	Machining situation		
			○	○	○
-M45 <ul style="list-style-type: none"> ▲ Neutral grooving insert with linear cutting edge shape ▲ First choice for ductile steels ▲ Medium to high feeds ▲ Good chip control ▲ Positive geometry 	<div data-kind="parent" data-rs="2">F</div>	0,05–0,40	P M K N S H O	● ○ ● ○ 	
Standard – Radius <ul style="list-style-type: none"> ▲ Positive geometry ▲ Ground cutting edge ▲ Low to medium feed rates ▲ Low cutting forces ▲ Radius grooving / copy turning 	<div data-kind="parent" data-rs="2">F M</div>	0,05–0,20	P M K N S H O	● ● ● ● ○ ○	○ ○ ○
-M3 – Radius <ul style="list-style-type: none"> ▲ Stable geometry ▲ Medium to high feed rates ▲ Excellent surface qualities ▲ Radius grooving / copy turning 	<div data-kind="parent" data-rs="2">M R</div>	0,07–0,20	P M K N S H O	● ○ ● ○ ○	● ●
-27P / -27PF – Radius <ul style="list-style-type: none"> ▲ Very positive geometry ▲ Ground periphery ▲ Sharp cutting edge ▲ Polished clamping flat ▲ First choice for non-ferrous metals 	<div data-kind="parent" data-rs="2">F F M</div>	0,05–0,30	P M K N S H O	 ● ● ○ ○	 ● ●
-M33 – Radius <ul style="list-style-type: none"> ▲ Radius grooving & copy turning ▲ Finishing geometry ▲ Specially for tough and ductile steels ▲ Low to medium feed rates ▲ High surface quality 	<div data-kind="parent" data-rs="2">F M</div>	0,05–0,20	P M K N S H O	● ○ ● 	○ ○ ○

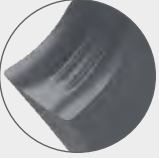
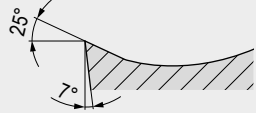
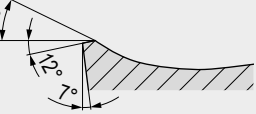
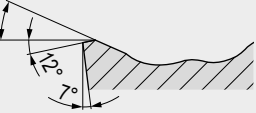
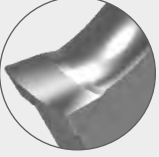
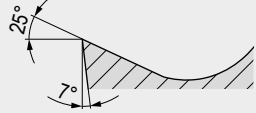
AX system	Geometry Chip breaker	Feed f (mm/rev.)	Machining situation		
-F50 ▲ Positive geometry ▲ Ground cutting edge ▲ Low feed rates ▲ Low cutting forces ▲ For axial grooving		0,025–0,125	P ● M ● K ● N ○ S ● H O ○	● ● ● ○ ● ○	○ ○ ○ ○ ○

Chip breakers / Applications

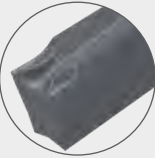
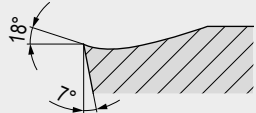
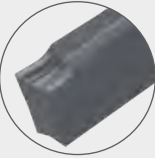
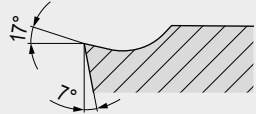
SX system	Geometry Chip breaker	Feed f (mm/rev.)	Machining situation			
						
-F2 ▲ Very positive geometry ▲ Ground cutting edge ▲ Low feed rates ▲ Low cutting forces ▲ First choice for stainless steel materials	F  	0,05–0,15	P	●	●	●
			M	●	●	●
			K	●	●	●
			N			
			S	●	●	○
			H	○		
			O	○	○	
-M1 ▲ Very stable cutting edge ▲ Medium to high feed rates ▲ For interrupted cuts ▲ For high-tensile materials ▲ First choice for parting off	M  	0,10–0,20	P	○	○	○
			M	●	●	●
			K	●	●	○
			N			
			S	●	●	○
			H	○		
			O	○	○	
-M2 ▲ Stable geometry ▲ Medium feed rates ▲ Universal application ▲ Good chip control	M  	0,075–0,20	P	○	○	○
			M	●	●	●
			K	●	●	○
			N			
			S	●	●	○
			H	○		
			O	○	○	
-27P ▲ Very positive geometry ▲ Ground periphery ▲ Sharp cutting edge ▲ Polished clamping flat ▲ First choice for non-ferrous metals	M  	0,05–0,25	P			
			M			
			K	●	●	●
			N	●	●	●
			S	○	○	
			H			
			O	○		
-M3 – Radius ▲ Stable geometry ▲ Medium to high feed rates ▲ Excellent surface qualities ▲ Radius grooving & copy turning	M  	0,05–0,20	P	●	●	●
			M	●	●	●
			K	●	●	●
			N			
			S	●	●	●
			H			
			O	○	○	
-M7 ▲ Grooving & parting off ▲ First choice for steel ▲ Medium to high feed rates ▲ Good chip control ▲ Positive geometry	M  	0,10–0,20	P	●	●	
			M	●	●	
			K	●	●	
			N	○	○	
			S	●	○	
			H			
			O	○	○	
-M8 ▲ Grooving & parting off ▲ Ground cutting edge ▲ Good chip control ▲ First choice for stainless steel materials ▲ Low feed rates	F  	0,03–0,15	P	●	●	
			M	●	●	
			K	●	●	
			N	○	○	
			S	●	●	
			H			
			O	○	○	

Chip breakers / Applications

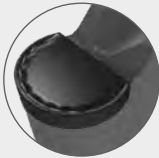
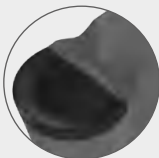
LX system	Geometry Chip breaker	Feed f (mm/rev.)	Machining situation		
-M2			P	●	●
▲ Stable geometry	 	0,20–0,50	M	○	●
▲ Medium feed rates			K	●	●
▲ Universal application			N	●	●
▲ Good chip control			S	●	○
			H	○	
			O	○	
-M3 – Radius			P	●	●
▲ Stable geometry	 	0,15–0,35	M	○	●
▲ Medium to high feed rates			K	●	●
▲ Excellent surface qualities			N	●	●
▲ Radius grooving / copy turning			S	●	○
			H	○	
			O	○	

FX system	Geometry Chip breaker	Feed f (mm/rev.)	Machining situation		
-F1			P	●	●
▲ Very positive geometry	 	0,05–0,15	M	●	●
▲ Low to medium feed rates			K	●	○
▲ Low cutting forces			N	●	●
▲ Good chip control			S	●	○
▲ Low built-up edge formation			H	○	
			O	○	
-M1			P	●	●
▲ Very stable cutting edge	 	0,08–0,20	M	●	●
▲ Medium to high feed rates			K	●	○
▲ For interrupted cuts			N	●	●
▲ For high-tensile materials			S	●	○
▲ First choice for parting off			H	○	
			O	○	
-R2			P	●	●
▲ Very stable cutting edge	 	0,10–0,27	M	●	●
▲ High feeds			K	●	○
▲ Good chip control			N	●	●
			S	●	○
			H	○	
			O	○	
-27P			P		
▲ Very positive geometry	 	0,03–0,13	M		
▲ Ground periphery			K	●	●
▲ Sharp cutting edge			N	●	●
▲ Polished clamping flat			S	○	○
▲ First choice for non-ferrous metals			H		
			O	○	

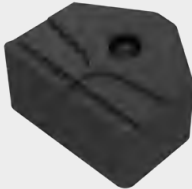
Chip breakers / Applications

MaxiClick	Geometry Chip breaker	Feed f (mm/rev.)	Machining situation		
				○	○
-F2					
<ul style="list-style-type: none"> ▲ Very positive geometry ▲ Ground cutting edge ▲ Low feed rates ▲ Low cutting forces ▲ First choice for stainless steel materials 	 	0,05–0,10	P ● ● ● M ● ● ● K ● ● ● N ○ ○ ○ S ● ● ● H O ○ ○		
-F3					
<ul style="list-style-type: none"> ▲ very positive geometry ▲ honed cutting edge ▲ low feed rates ▲ low cutting forces ▲ reduced burrs / edge build up 	 	0,02–0,06	P ● ● ● M ● ● ● K ● ● ● N ○ ○ ○ S ● ● ● H O ○ ○		

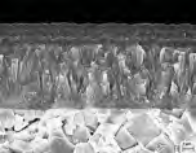
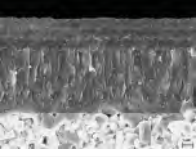
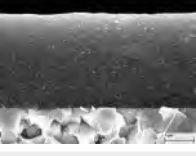
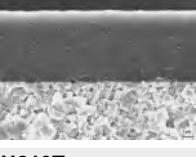
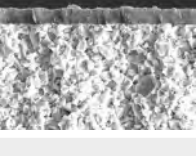
Chip breakers / Applications

OvalFlex, MaxiGroove X32, GX40	Geometry Chip breaker	Machining situation		
				
-28P <ul style="list-style-type: none">▲ The universal aluminum geometry▲ Sharp cutting edge▲ Extremely positive rake angle▲ Low adhesion▲ High feeds	M 	P		
		M		
		K		
		N	●	●
		S		
		H		
		O		
-F4 <ul style="list-style-type: none">▲ PCD segment without chip breaker▲ Predominantly used with interrupted cut▲ Cutting edge finish available: sharp (F), rounded (E), chamfered (T) in line with ISO designation system	F 	P		
		M		
		K		
		N	●	●
		S		
		H		
		O		
-F41 <ul style="list-style-type: none">▲ PCD segment▲ Chip-breakage optimized chip breaker for small cutting depths▲ Cutting edge finish available: sharp (F), rounded (E), chamfered (T) in line with ISO designation system	F 	P		
		M		
		K		
		N	●	●
		S		
		H		
		O		
-M41 <ul style="list-style-type: none">▲ PCD segment with tried-and-tested M41 chip breaker▲ Optimized chip breaker for low cutting pressure and ideal chip shape▲ Cutting edge finish available: sharp (F), rounded (E), chamfered (T) in line with ISO designation system	M 	P		
		M		
		K		
		N	●	●
		S		
		H		
		O		
-R41 <ul style="list-style-type: none">▲ PCD segment with R41 chip breaker▲ Roughing stage for pre-machining with up to 4 mm depth of cut▲ Cutting edge finish available: sharp (F), rounded (E), chamfered (T) in line with ISO designation system	R 	P		
		M		
		K		
		N	●	●
		S		
		H		
		O		

Chip breakers / Applications

MaxiGroove HX	Geometry Chip breaker	Machining situation		
				
-R70 ▲ Suitable for steels, stainless materials, and cast iron materials ▲ Stable cutting edge also for interrupted cuts ▲ Preferred for undercutting and copying operations ▲ Optimal usage conditions with high feed rates		P	●	●
		M		
		K	●	●
		N		
		S	●	●
		H		
		O		
-R71 ▲ Very positive rake angle with small negative chamfer ▲ Suitable for grooves and undercuts ▲ Suitable for steels, stainless materials, and cast iron materials ▲ Minimal cutting force		P	●	●
		M		
		K	●	●
		N		
		S	●	●
		H		
		O		
-R75 ▲ Suitable for steels, stainless materials, and cast iron materials ▲ Stable cutting edge also for interrupted cuts ▲ Suitable for grooving, undercutting, and copying operations		P	●	●
		M		
		K	●	●
		N		
		S	●	●
		H		
		O		
-R81 ▲ First choice for grooving into solid material, ideal for overhead machining ▲ Chip breaker prevents chip jams, maximum process security ▲ Suitable for steel and stainless steels ▲ Very soft cutting with high cutting edge stability, minimizes vibrations		P	●	●
		M		
		K	●	●
		N		
		S	●	●
		H		
		O		

Grade description

Grades		ISO application range																	Grade description	
Main application ● Secondary application ○		○ V _C + Wear-resistant V _C - Tough																	Specification / Application recommendation	
		01 05 10 15 20 25 30 35 40 45 50																		
CTCP325 DRAGONSKIN 	P	●																	Specification: Composition: Co 7.0%, mixed carbides 8.1%, WC balance Grain size: 1–2 μm Hardness: HV ₃₀ 1470 Layer system: CVD TiCN-Al ₂ O ₃ Multilayer Recommended use: The wear-resistant solution for steel and cast iron materials at high cutting speeds.	
	M	○																		
	K	●																		
	N	○																		
	S	○																		
	H	○																		
	O	○																		
CTCP335 DRAGONSKIN 	P	●																	Specification: Composition: Co 7.0%, mixed carbides 1.9%, WC balance Grain size: 1 μm Hardness: HV ₃₀ 1370 Layer system: CVD TiCN-Al ₂ O ₃ Multilayer Recommended use: The reliable choice for machining steel and cast iron materials.	
	M	○																		
	K	●																		
	N	○																		
	S	○																		
	H	○																		
	O	○																		
CTP1340 DRAGONSKIN 	P	●																	Specification: Composition: Co 9.0%, mixed carbides 0.75%, WC balance Grain size: 0.7–1 μm Hardness: HV ₃₀ 1590 Layer system: PVD TiAlTaN Recommended use: The universal high-performance grade for steel materials, austenitic steel, cast iron materials, and heat-resistant alloys.	
	M	●																		
	K	●																		
	N	○																		
	S	○																		
	H	○																		
	O	○																		
CTPP345 DRAGONSKIN 	P	●																	Specification: Composition: Co 12.5%, mixed carbides 2.0%, WC balance Grain size: 1–1.5 μm Hardness: HV ₃₀ 1350 Layer system: PVD TiAlTaN Recommended use: The reliable solution for steel and austenitic steels in unstable conditions.	
	M	●																		
	K	○																		
	N	○																		
	S	○																		
	H	○																		
	O	○																		
H216T 	P	○																	Specification: Composition: Co 6.0%; WC balance Grain size: 1 μm Hardness: HV ₃₀ 1630 Recommended application: The uncoated carbide grade for the machining of aluminium and other non-ferrous metals	
	M	○																		
	K	○																		
	N	○																		
	S	○																		
	H	○																		
	O	○																		
CWX500 	P	●																	Specification: Composition: Co 10.0%; others 0.7%; WC balance Grain size: 1 μm Hardness: HV ₃₀ 1660 Recommended use: The universal carbide grade for almost all materials	
	M	●																		
	K	●																		
	N	○																		
	S	○																		
	H	○																		
	O	○																		

CCTCP325-P

CT CERATIZIT

CT

C

P

3

2

5

-P

(Example)

-P (Performance)

Coating
W Carbide, uncoated
C CVD-coated carbide
P PVD-coated carbide
T Cermet, uncoated
E Cermet, coated
N Silicon nitride, uncoated
M Silicon nitride, coated

Main application - material
P Steel
M Stainless steel
K Cast iron
N Non-ferrous metals
S Heat-resistant
H Hardened steel
O Non-metal materials
X Universal application

Process
1 Turning
2 Milling
3 Grooving
4 Drilling
5 Thread turning
6 Other
7 Several processes

Degree of hardness
05 ISO 05
10 ISO 10
15 ISO 15
20 ISO 20
25 ISO 25
30 ISO 30
35 ISO 35
40 ISO 40

↑

↓

Grade description

Grades		ISO application range		Grade description	
OvalFlex, MaxiGroove		○ V _c + Wear-resistant		V _c - ○ Tough	
Main application ● Secondary application ○		01 05 10 15 20 25 30 35 40 45 50			
H216T	P				
	M				
	K	●			
	N	●			
	S				
	H				
	O				
CTD4110	P				
	M				
	K				
	N	●			
	S				
	H				
	O				
CTCK110	P	●			
	M				
	K	●			
	N				
	S				
	H				
	O				
CTCP125-P DRAGONSKIN	P	●			
	M				
	K	○			
	N				
	S				
	H				
	O				
CTS3105	P				
	M				
	K	●			
	N				
	S				
	H	●			
	O				
		01 05 10 15 20 25 30 35 40 45 50			
				Specification: Composition: Co 6.0%; WC balance Grain size: 1 μm Hardness: HV ₃₀ 1630	
				Recommended application: The uncoated carbide grade for the machining of aluminium and other non-ferrous metals	
				Specification: Composition: Polycrystalline diamond (PCD) Grain size: ~ 5 μm	
				Recommended use: Polycrystalline diamond grade for the machining of non-ferrous metals and non-metallic materials.	
				Specification: Composition: Co 5.0%, mixed carbides 2.0%, WC balance Grain size: 1–2 μm Hardness: HV ₃₀ 1730 Layer system: CVD TiCN-Al ₂ O ₃	
				Recommended use: The wear-resistant grade for machining cast iron materials and steels at high cutting speeds with a continuous cut.	
				Specification: Composition: Co 7.0%, mixed carbides 6.0%, WC balance Grain size: 1-2 μm Hardness: HV ₃₀ 1500 Layer system: CVD TiCN-Al ₂ O ₃	
				Usage recommendation: The first choice for the universal machining of steels.	
				Specification: Composition: Al ₂ O ₃ ; TiC Grain size: > 1 μm Hardness: HV ₃₀ 2100	
				Recommended use: This mixed ceramic grade is suitable for hard precision turning of steel and the turning of steel and cast iron or chilled iron rolls.	

Example of coding grooving tools

Grooving inserts

GX	16	2	E	3.00	N	0.50
Grooving system (GX)	Insert length (16 mm / 0.630")	Width class of the holder, module, or seating surface (2 mm / 0.079")	Type of insert, application	Groove width (3.00 mm / 0.012")	Insert seat N = Neutral L = Left R = Right	Corner radius size (0.5 mm / 0.020")

Modules

E	25	R	12	GX	16	2
Application E = External I = Internal	Size (25 mm / 0.984")	Module version R = Right L = Left	Maximum groove depth (12 mm / 0.472")	Grooving system (GX)	Insert size (16 mm / 0.630")	Width class 2

Base holder

E	25	R	00	2525	L
Application E = External I = Internal	Size (25 mm / 0.984")	Holder version R = Right L = Left	Approach angle 0°	Shank version 25x25 mm / 0.984"x0.984"	Shank length L = (see ISO)

Monoholders

E	25	R	00	13	S3	2525	X	S	DC	GX16
Application E = External I = Internal	Size (25 mm / 0.984")	Holder version R = Right L = Left	Approach angle 0°	Groove depth (13 mm / 0.512")	Groove width (3.00 mm / 0.012")	Shank version 25x25 mm / 0.984"x0.984"	Shank length X = (see ISO)	Insert clamping S = Key	Cooling system DC = DirectCooling	Grooving system/width (3 mm / 0.012")

» Summary

Grooving inserts

GX 16-2 E3.00 N 0.50



Modules

E25 R 12- **GX 16-2**



Base holder

E25 R 00 - 2525L



Monoholders

E25 R 0013S3-2525X-S-DC- **GX16**

Example of coding grooving tools

Grooving inserts

GX	24	2	E	3.00	N	0.30
Grooving system (GX)	Insert length (24 mm / 0.945")	Width class of the holder, module, or seating surface (2 mm / 0.079")	Type of insert, application	Groove width (3.00 mm / 0.012")	Insert seat N = Neutral L = Left R = Right	Corner radius size (0.3 mm / 0.012")

Modules

E	25	R	21	GX	24	2
Application E = External I = Internal	Size (25 mm / 0.984")	Module version R = Right L = Left	Maximum groove depth (21 mm / 0.827")	Grooving system (GX)	Insert size (24 mm / 0.945")	Width class 2

Base holder

E	25	R	00	16	E
Application E = External I = Internal	Size (25 mm / 0.984")	Holder version R = Right L = Left	Approach angle 0°	Shank height 16/16's or 1.00 inch	Combination metric-inch E = end F = front EF = end+front

Monoholders

E	25	R	00	21	16	D	GX24	2	E
Application E = External I = Internal	Size (25 mm / 0.984")	Holder version R = Right L = Left	Approach angle 0°	Groove depth (21 mm / 0.827")	Shank height 16/16's or 1.00 inch	Tool length D = 6.000"	Grooving system (GX)	Width class 2	Combination metric-inch E = end F = front EF = end+front

» Summary



Grooving inserts
GX 24-2 E3.00 N 0.30

Modules
E25 R 21- **GX 24-2**

Base holder
E25 R 00 - 16 - E

Monoholders
E25 R 0021 - 16D - **GX24** - 2 - E

Example of coding grooving tools

OvalFlex – Holders

OC	50	X32	4	S	R	0	E
Interface	Size	Grooving system	Groove width	S = Strong Reinforced insert seat	Holder version R = Right L = Left	Approach angle	Tool length

X32 – Square holders

X32	R	0	25	25	M
Grooving system	Holder version R = Right L = Left	Approach angle	Shank height	Shank width	Tool length

X32 – Grooving insert

X32	R	3.00	N	24PF	H216T
Grooving system	Full radius	Radius	Insert seat N = Neutral L = Left R = Right	Chip breaker	Grade

GX40 – Grooving insert

GX40	6	R	6.00	F	N	M41	CTD4110
Grooving system	Groove width	Full radius	Radius	Type of cutting edge	Insert seat N = Neutral L = Left R = Right	Chip breaker	Grade



OvalFlex – Holders



X32 – Square holders



X32 – Grooving insert



GX40 – Grooving insert

Example of coding grooving tools

HD tools

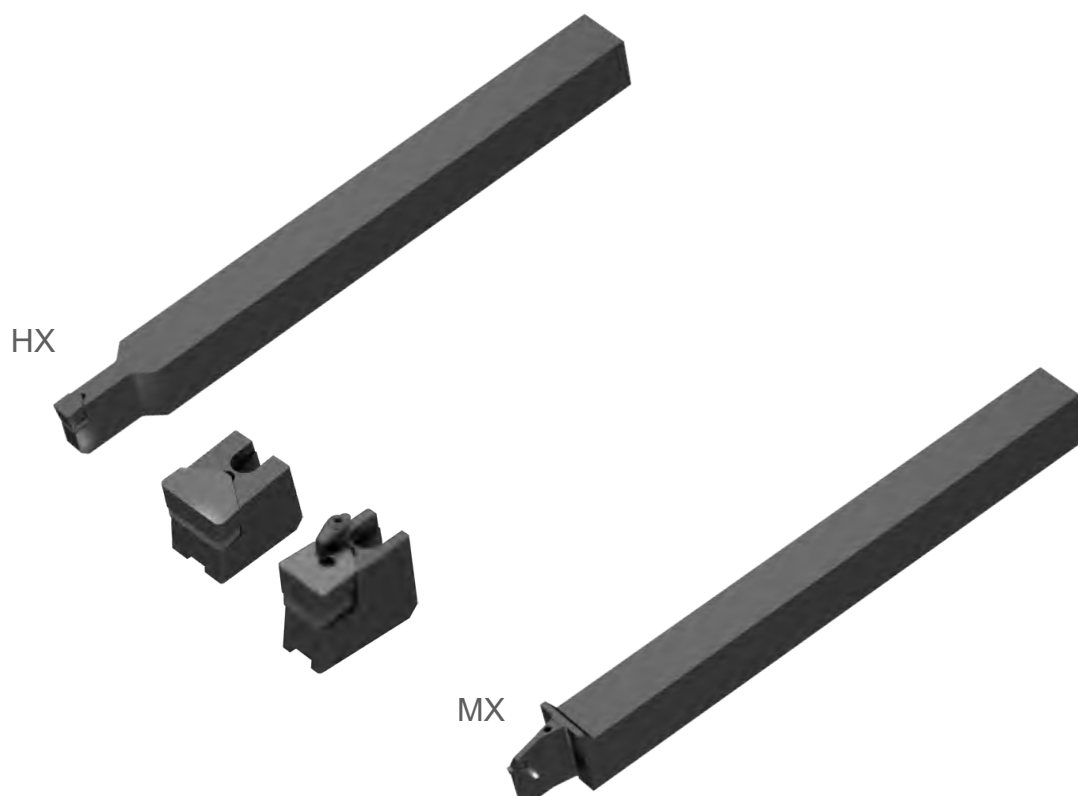
HD	H	G	L	40	40	W	1	MX	05	C	025
Heavy Duty Heavy duty machining	H = Holder C = Cartridge	G = Grooving T = Turning	R = Right L = Left N = Neutral	Shank height	Shank width	Length W = 450 mm X = 275 mm	Number of inserts	Insert type	Insert size	Clamping P = Pin C = Claw S = Screw	Maximum groove depth

HX – indexable inserts

HX	40	24	90	-R81	/ PN	150	CE
Grooving system	Groove width	Corner radius	Bore diameter	Chip breaker	Cutting edge	Chamfer width	Chamfer angle

MX – ceramic indexable inserts

MX	-S	10	15	08	TN	-020	D
Grooving system	Cutting edge S = Straight R = Radius	Groove width		Corner radius	Cutting edge	Chamfer width	Chamfer angle





Miniature turning tools



Contents

→ **System overview**

→ **Toolfinder**

Product program

→ UltraMini

→ MiniCut

→ UltraMini + MiniCut hard turning

→ SlotCut – Broaching

Technical information

→ Cutting data

→ Broaching – Recommendations for correct use

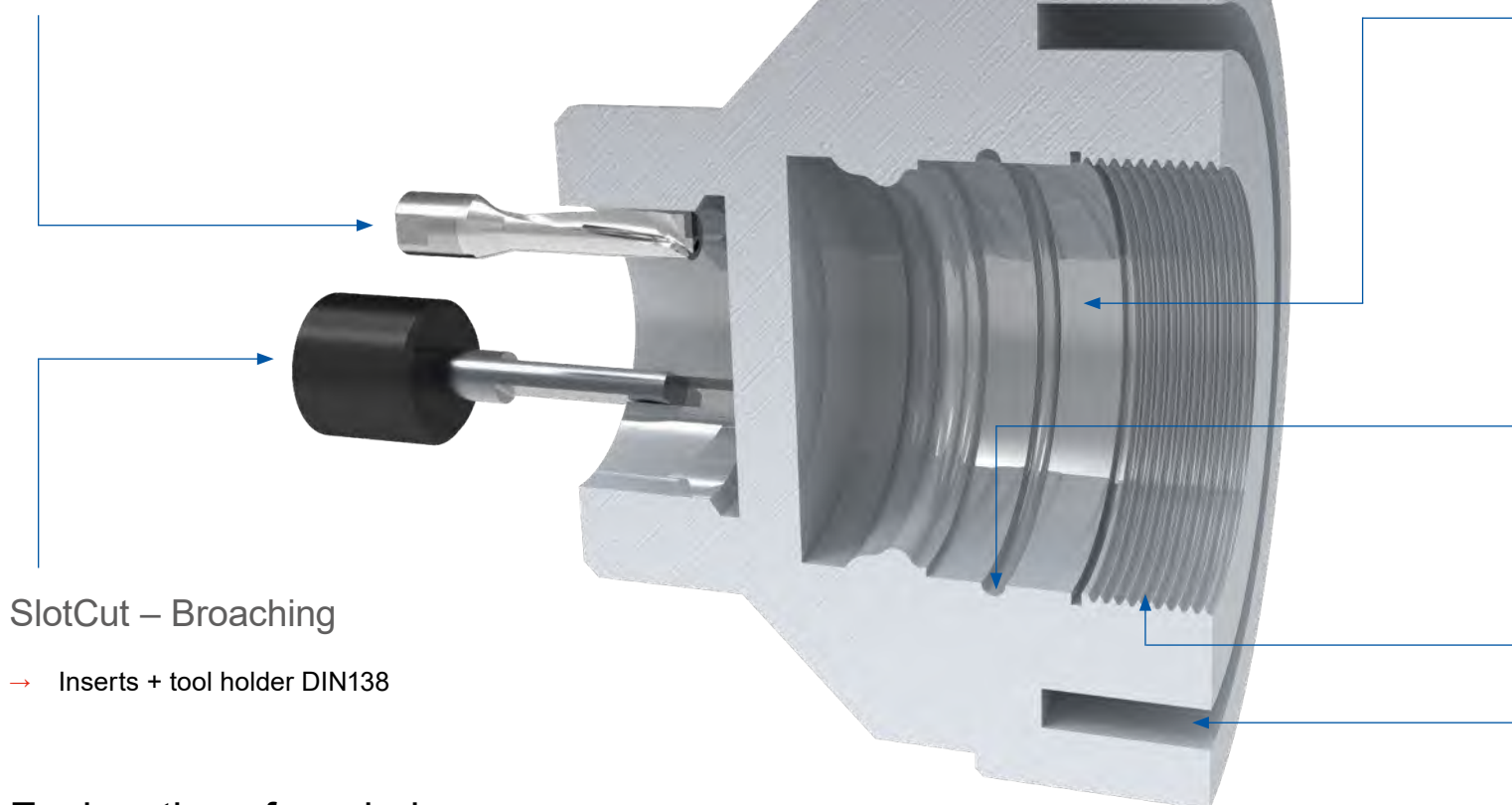
→ Explanation of symbols, coatings, and thread types

Toolfinder

EcoCut Mini

From Ø 2 mm

Inserts and tool holders can be found in the **Multi-function tools** section



SlotCut – Broaching

→ Inserts + tool holder DIN138

Explanation of symbols



Internal machining



Internal grooving



Internal thread turning



Axial machining



Broaching

System overview

UltraMini



- ▲ From Ø 0.5 mm
- ▲ Flexible system
- ▲ Ground inserts
- ▲ High repeatability
- ▲ Coolant supply to the cutting edge

MiniCut



- ▲ From Ø 7.8 mm
- ▲ Stable three-rib interface
- ▲ Easy handling
- ▲ Coolant supply to the cutting edge
- ▲ Precise cutting edge position

SlotCut



- ▲ Broaching directly on the machine
- ▲ Usable from Ø 6 mm
- ▲ Low machine load
- ▲ Variety of tolerance classes

Hole diameter in mm

Internal turning and profile turning

Internal turning and profiling – hard turning

High-feed internal turning

Internal turning

Back boring

Internal turning and chamfering

Pregrooving and chamfering

Internal undercuts

Groove turning

Groove and profile turning

Internal thread turning

Axial grooving

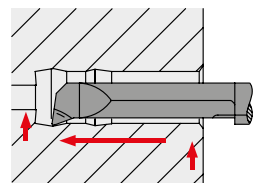
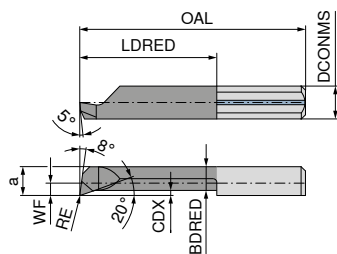
Suitable holders

Sets

UltraMini										MiniCut				
≥ 0,5	≥ 2	≥ 2,4	≥ 2,8	≥ 3	≥ 4	≥ 5	≥ 6	≥ 8	≥ 16	≥ 8	≥ 9	≥ 11	≥ 14	≥ 16
→	→	→	→		→	→	→			→	→	→	→	→
	→		→		→	→	→			→		→	→	→
	→			→	→	→	→							
			→		→	→				→	→	→	→	→
				→	→	→	→			→	→	→	→	
						→	→			→	→	→	→	
					→	→	→			→	→	→	→	→
	→		→		→	→	→			→	→	→	→	→
	→			→	→	→	→			→	→	→	→	→
		→			→	→	→			→	→	→	→	→
						→	→	→	→	→	→	→	→	→
→										→				
→										→				

CoreLine – Inserts for internal turning and profiling – UltraMini

▲ CDX = maximum radial infeed for outward turning



Illustrations show right-hand versions

Designation	DCONMS ₁₆ mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm
R/L 050.05-2	4		0.5	0.4	20	2	0.03	0.32	0.02
R/L 050.06-2	4		0.6	0.5	20	2	0.05	0.40	0.04
R/L 050.06-3	4		0.6	0.5	20	3	0.05	0.40	0.04
R/L 050.08-4	4		0.8	0.7	20	4	0.05	0.60	0.04
R/L 050.1-8	4		1.0	0.9	22	8	0.10	0.75	0.05
R/L 050.15-5	4		1.5	1.3	19	5	0.10	1.15	0.05
R/L 050.15-10	4		1.5	1.3	24	10	0.10	1.15	0.05
R/L 050.15-12	4		1.5	1.3	26	12	0.10	1.15	0.05
R/L 050.2-5	4		2.0	1.7	19	5	0.10	1.50	0.05
R/L 050.2-10	4		2.0	1.7	24	10	0.10	1.50	0.05
R/L 050.2-15	4		2.0	1.7	29	15	0.10	1.50	0.05
R/L 050.3-10	4	0.6	2.8	2.6	24	10	0.20	2.30	0.10
R/L 050.3-16	4	0.6	2.8	2.6	30	16	0.20	2.30	0.10
R/L 050.3-20	4	0.6	2.8	2.6	34	20	0.20	2.30	0.10
R/L 050.35-10	4	1.1	3.5	3.1	24	10	0.25	2.80	0.10
R/L 050.35-16	4	1.1	3.5	3.1	30	16	0.25	2.80	0.10
R/L 050.35-20	4	1.1	3.5	3.1	34	20	0.25	2.80	0.10
R/L 050.35-24	4	1.1	3.5	3.1	38	24	0.25	2.80	0.10
R/L 050.4-10	4	1.5	4.0	3.5	24	10	0.30	3.00	0.10
R/L 050.4-16	4	1.5	4.0	3.5	30	16	0.30	3.00	0.10
R/L 050.4-20	4	1.5	4.0	3.5	34	20	0.30	3.00	0.10
R/L 050.4-24	4	1.5	4.0	3.5	38	24	0.30	3.00	0.10
R/L 050.4-28	4	1.5	4.0	3.5	42	28	0.30	3.00	0.10
R/L 050.5-10	5	1.9	5.0	4.4	25	10	0.50	3.80	0.15
R/L 050.5-15	5	1.9	5.0	4.4	30	15	0.50	3.80	0.15
R/L 050.5-20	5	1.9	5.0	4.4	35	20	0.50	3.80	0.15
R/L 050.5-25	5	1.9	5.0	4.4	40	25	0.50	3.80	0.15
R/L 050.5-30	5	1.9	5.0	4.4	45	30	0.50	3.80	0.15
R/L 050.5-35	5	1.9	5.0	4.4	50	35	0.50	3.80	0.15
R/L 050.5-40	5	1.9	5.0	4.4	55	40	0.50	3.80	0.15
R/L 050.6-15	6	2.3	6.0	5.3	30	15	0.50	4.50	0.15
R/L 050.6-22	6	2.3	6.0	5.3	37	22	0.50	4.50	0.15
R/L 050.6-25	6	2.3	6.0	5.3	40	25	0.50	4.50	0.15
R/L 050.6-30	6	2.3	6.0	5.3	45	30	0.50	4.50	0.15
R/L 050.6-35	6	2.3	6.0	5.3	50	35	0.50	4.50	0.15
R/L 050.6-42	6	2.3	6.0	5.3	57	42	0.50	4.50	0.15
R/L 050.7-20	7	2.8	6.8	6.3	35	20	0.60	5.50	0.15
R/L 050.7-25	7	2.8	6.8	6.3	40	25	0.60	5.50	0.15
R/L 050.7-30	7	2.8	6.8	6.3	45	30	0.60	5.50	0.15
R/L 050.7-35	7	2.8	7.0	6.3	50	35	0.60	5.50	0.15
R/L 050.7-40	7	2.8	7.0	6.3	55	40	0.60	5.50	0.15
R/L 050.7-45	7	2.8	7.0	6.3	60	45	0.60	5.50	0.15
R/L 050.7-50	7	2.8	7.0	6.3	65	50	0.60	5.50	0.15

P	●	●	●	●
M	●	●	●	●
K	●	●	●	●
N	●	●	●	●
S	○	○	●	●
H	○	○	●	●
O	●	●	●	●



Left Right Left Right

ST	ST	ST	ST
73 005 ...	73 004 ...	73 005 ...	73 004 ...
500	500		
510	510		
511	511		
		812	812
		813	813
515	515		
516	516		
		818	818
520	520		
521	521		
522	522		
531	531		
530	530		
532	532		
		835	835
		836	836
		837	837
		838	838
541	541	841	841
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546	546	846	846
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554	554	854	854
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		857	857
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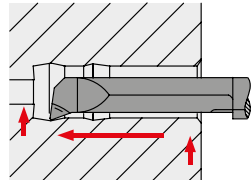
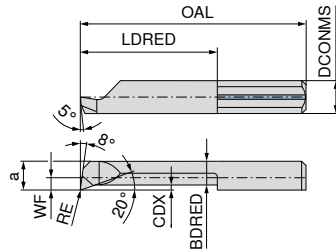


→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for internal turning and profiling – UltraMini

▲ CDX = maximum radial infeed for outward turning



Illustrations show right-hand versions

K10F

K10F



Left

Right

Designation	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm
R/L 050.2-5	4		2.0	1.7	19	5	0.1	1.5	0.05
R/L 050.2-10	4		2.0	1.7	24	10	0.1	1.5	0.05
R/L 050.2-15	4		2.0	1.7	29	15	0.1	1.5	0.05
R/L 050.3-10	4	0.6	2.8	2.6	24	10	0.2	2.3	0.10
R/L 050.3-16	4	0.6	2.8	2.6	30	16	0.2	2.3	0.10
R/L 050.3-20	4	0.6	2.8	2.6	34	20	0.2	2.3	0.10
R/L 050.4-10	4	1.5	4.0	3.5	24	10	0.3	3.0	0.10
R/L 050.4-16	4	1.5	4.0	3.5	30	16	0.3	3.0	0.10
R/L 050.4-20	4	1.5	4.0	3.5	34	20	0.3	3.0	0.10
R/L 050.5-10	5	1.9	5.0	4.4	25	10	0.5	3.8	0.15
R/L 050.5-15	5	1.9	5.0	4.4	30	15	0.5	3.8	0.15
R/L 050.5-20	5	1.9	5.0	4.4	35	20	0.5	3.8	0.15
R/L 050.5-25	5	1.9	5.0	4.4	40	25	0.5	3.8	0.15
R 050.5-30	5	1.9	5.0	4.4	45	30	0.5	3.8	0.05
L 050.5-30	5	1.9	5.0	4.4	45	30	0.5	3.8	0.15
R/L 050.6-15	6	2.3	6.0	5.3	30	15	0.5	4.5	0.15
R/L 050.6-22	6	2.3	6.0	5.3	37	22	0.5	4.5	0.15
R/L 050.6-25	6	2.3	6.0	5.3	40	25	0.5	4.5	0.15
R/L 050.6-30	6	2.3	6.0	5.3	45	30	0.5	4.5	0.15
R/L 050.7-20	7	2.8	6.8	6.3	35	20	0.6	5.5	0.15
R/L 050.7-25	7	2.8	6.8	6.3	40	25	0.6	5.5	0.15
R/L 050.7-30	7	2.8	6.8	6.3	45	30	0.6	5.5	0.15

ST	ST
73 005 ...	73 004 ...
020	020
021	021
022	022
031	031
030	030
032	032
041	041
040	040
042	042
051	051
052	052
050	050
053	053
054	054
061	061
060	060
062	062
063	063
072	072
073	073
074	074

P		
M		
K		
N	○	○
S		
H		
O	●	●



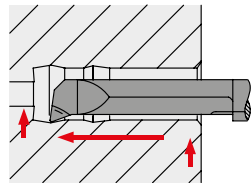
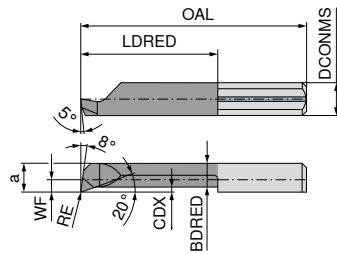
→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for internal turning and profiling – UltraMini

▲ With corner radius ≤ 0.05 mm

▲ CDX = maximum radial infeed for outward turning



Illustrations show right-hand versions

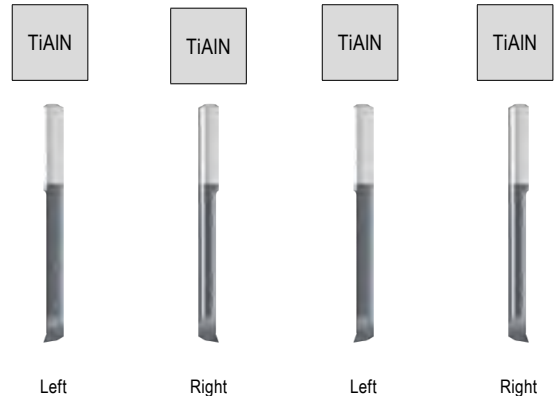
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R/L 053.3-10	4	0.6	2.8	2.6	24	10	0.2	2.3	0.03
R/L 053.3-16	4	0.6	2.8	2.6	30	16	0.2	2.3	0.03
R/L 053.3-20	4	0.6	2.8	2.6	34	20	0.2	2.3	0.03
R/L 053.4-10	4	1.5	4.0	3.5	24	10	0.3	3.0	0.03
R/L 053.4-16	4	1.5	4.0	3.5	30	16	0.3	3.0	0.03
R/L 053.4-20	4	1.5	4.0	3.5	34	20	0.3	3.0	0.03
R/L 053.4-24	4	1.5	4.0	3.5	38	24	0.3	3.0	0.03
R/L 053.4-28	4	1.5	4.0	3.5	42	28	0.3	3.0	0.03
R/L 055.2-10	4		2.0	1.7	24	10	0.1	1.5	0.05
R/L 055.2-15	4		2.0	1.7	29	15	0.1	1.5	0.05
R/L 055.2-5	4		2.0	1.7	19	5	0.1	1.5	0.05
R/L 055.3-10	4	0.6	2.8	2.6	24	10	0.2	2.3	0.05
R/L 055.3-16	4	0.6	2.8	2.6	30	16	0.2	2.3	0.05
R/L 055.3-20	4	0.6	2.8	2.6	34	20	0.2	2.3	0.05
R/L 055.4-10	4	1.5	4.0	3.5	24	10	0.3	3.0	0.05
R/L 055.4-16	4	1.5	4.0	3.5	30	16	0.3	3.0	0.05
R/L 055.4-20	4	1.5	4.0	3.5	34	20	0.3	3.0	0.05
R/L 055.4-24	4	1.5	4.0	3.5	38	24	0.3	3.0	0.05
R/L 055.4-28	4	1.5	4.0	3.5	42	28	0.3	3.0	0.05
R/L 055.5-10	5	1.9	5.0	4.4	25	10	0.5	3.8	0.05
R/L 055.5-15	5	1.9	5.0	4.4	30	15	0.5	3.8	0.05
R/L 055.5-20	5	1.9	5.0	4.4	35	20	0.5	3.8	0.05
R/L 055.5-25	5	1.9	5.0	4.4	40	25	0.5	3.8	0.05
R/L 055.5-30	5	1.9	5.0	4.4	45	30	0.5	3.8	0.05
R/L 055.5-35	5	1.9	5.0	4.4	50	35	0.5	3.8	0.05
R/L 055.6-15	6	2.3	6.0	5.3	30	15	0.5	4.5	0.05
R/L 055.6-22	6	2.3	6.0	5.3	37	22	0.5	4.5	0.05
R/L 055.6-25	6	2.3	6.0	5.3	40	25	0.5	4.5	0.05
R/L 055.6-30	6	2.3	6.0	5.3	45	30	0.5	4.5	0.05
R/L 055.6-35	6	2.3	6.0	5.3	50	35	0.5	4.5	0.05
R/L 055.6-42	6	2.3	6.0	5.3	57	42	0.5	4.5	0.05

P	•	•	•	•
M	•	•	•	•
K	•	•	•	•
N	•	•	•	•
S	•	•	•	•
H	•	•	•	•
O	•	•	•	•



→ Find the cutting data standard values here.

→ Here you will find suitable holders.

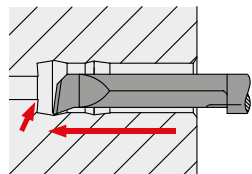
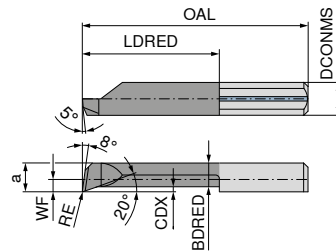


ST	ST	ST	ST
73 021 ...	73 020 ...	73 023 ...	73 022 ...
310	310		
316	316		
320	320		
410	410		
416	416		
420	420		
424	424		
428	428		
		210	210
		215	215
		205	205
		310	310
		316	316
		320	320
		410	410
		416	416
		420	420
		424	424
		428	428
		510	510
		515	515
		520	520
		525	525
		530	530
		535	535
		615	615
		622	622
		625	625
		630	630
		635	635
		642	642

CoreLine – Inserts for internal turning and profiling – UltraMini

▲ With chip former

▲ CDX = maximum radial infeed for outward turning



Illustrations show right-hand versions

TiAlN

TiAlN



Left



Right

Designation	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm	ST 73 017 ...	ST 73 016 ...
R/L 050.4-10C	4	1.5	4	3.5	24	10	0.3	3.0	0.2	410	410
R/L 050.4-16C	4	1.5	4	3.5	30	16	0.3	3.0	0.2	416	416
R/L 050.4-20C	4	1.5	4	3.5	34	20	0.3	3.0	0.2	420	420
R/L 050.4-24C	4	1.5	4	3.5	38	24	0.3	3.0	0.2	424	424
R/L 050.4-28C	4	1.5	4	3.5	42	28	0.3	3.0	0.2	428	428
R/L 050.5-10C	5	1.9	5	4.4	25	10	0.5	3.8	0.2	510	510
R/L 050.5-15C	5	1.9	5	4.4	30	15	0.5	3.8	0.2	515	515
R/L 050.5-20C	5	1.9	5	4.4	35	20	0.5	3.8	0.2	520	520
R/L 050.5-25C	5	1.9	5	4.4	40	25	0.5	3.8	0.2	525	525
R/L 050.5-30C	5	1.9	5	4.4	45	30	0.5	3.8	0.2	530	530
R/L 050.5-35C	5	1.9	5	4.4	50	35	0.5	3.8	0.2	535	535
R/L 050.6-15C	6	2.3	6	5.3	30	15	0.5	4.5	0.2	615	615
R/L 050.6-22C	6	2.3	6	5.3	37	22	0.5	4.5	0.2	622	622
R/L 050.6-25C	6	2.3	6	5.3	40	25	0.5	4.5	0.2	625	625
R/L 050.6-30C	6	2.3	6	5.3	45	30	0.5	4.5	0.2	630	630
R/L 050.6-35C	6	2.3	6	5.3	50	35	0.5	4.5	0.2	635	635
R/L 050.6-42C	6	2.3	6	5.3	57	42	0.5	4.5	0.2	642	642
R/L 050.7-20C	7	2.8	7	6.3	35	20	0.6	5.5	0.2	720	720
R/L 050.7-25C	7	2.8	7	6.3	40	25	0.6	5.5	0.2	725	725
R/L 050.7-30C	7	2.8	7	6.3	45	30	0.6	5.5	0.2	730	730
R/L 050.7-35C	7	2.8	7	6.3	50	35	0.6	5.5	0.2	735	735
R/L 050.7-40C	7	2.8	7	6.3	55	40	0.6	5.5	0.2	740	740
R/L 050.7-45C	7	2.8	7	6.3	60	45	0.6	5.5	0.2	745	745
R/L 050.7-50C	7	2.8	7	6.3	65	50	0.6	5.5	0.2	750	750
P										•	•
M										•	•
K										•	•
N										•	•
S										•	•
H										•	•
O										•	•



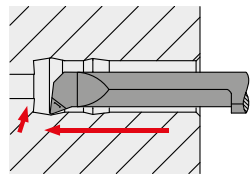
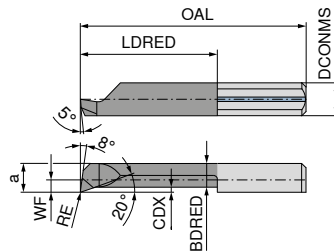
→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for internal turning and profiling – Hard turning – UltraMini

▲ 46 to 65 HRC

▲ CDX = maximum radial infeed for outward turning



Illustrations show right-hand versions

TiAlN+

TiAlN+



Left

Right

Designation	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm	ST 73 025 ...	ST 73 024 ...
R/L 050.2-5	4		2.0	1.7	19	5	0.1	1.5	0.05	920	920
R/L 050.2-10	4		2.0	1.7	24	10	0.1	1.5	0.05	921	921
R/L 050.2-15	4		2.0	1.7	29	15	0.1	1.5	0.05	922	922
R/L 050.3-10	4	0.6	2.8	2.6	24	10	0.2	2.3	0.10	931	931
R/L 050.3-16	4	0.6	2.8	2.6	30	16	0.2	2.3	0.10	930	930
R/L 050.3-20	4	0.6	2.8	2.6	34	20	0.2	2.3	0.10	932	932
R/L 050.4-10	4	1.5	4.0	3.5	24	10	0.3	3.0	0.10	941	941
R/L 050.4-16	4	1.5	4.0	3.5	30	16	0.3	3.0	0.10	940	940
R/L 050.4-20	4	1.5	4.0	3.5	34	20	0.3	3.0	0.10	942	942
R/L 050.4-24	4	1.5	4.0	3.5	38	24	0.3	3.0	0.10	945	945
R/L 050.4-28	4	1.5	4.0	3.5	42	28	0.3	3.0	0.10	946	946
R/L 050.5-10	5	1.9	5.0	4.4	25	10	0.5	3.8	0.15	951	951
R/L 050.5-15	5	1.9	5.0	4.4	30	15	0.5	3.8	0.15	952	952
R/L 050.5-20	5	1.9	5.0	4.4	35	20	0.5	3.8	0.15	950	950
R/L 050.5-25	5	1.9	5.0	4.4	40	25	0.5	3.8	0.15	953	953
R/L 050.5-30	5	1.9	5.0	4.4	45	30	0.5	3.8	0.15	954	954
R/L 050.5-35	5	1.9	5.0	4.4	50	35	0.5	3.8	0.15	956	956
R/L 050.6-15	6	2.3	6.0	5.3	30	15	0.5	4.5	0.15	961	961
R/L 050.6-22	6	2.3	6.0	5.3	37	22	0.5	4.5	0.15	960	960
R/L 050.6-25	6	2.3	6.0	5.3	40	25	0.5	4.5	0.15	962	962
R/L 050.6-30	6	2.3	6.0	5.3	45	30	0.5	4.5	0.15	963	963
R/L 050.6-35	6	2.3	6.0	5.3	50	35	0.5	4.5	0.15	964	964
R/L 050.6-42	6	2.3	6.0	5.3	57	42	0.5	4.5	0.15	965	965
R/L 050.7-20	7	2.8	6.8	6.3	35	20	0.6	5.5	0.15	972	972
R/L 050.7-25	7	2.8	6.8	6.3	40	25	0.6	5.5	0.15	973	973
R/L 050.7-30	7	2.8	6.8	6.3	45	30	0.6	5.5	0.15	974	974
R/L 050.7-35	7	2.8	6.8	6.3	50	35	0.6	5.5	0.15	975	975
R/L 050.7-40	7	2.8	6.8	6.3	55	40	0.6	5.5	0.15	976	976
R/L 050.7-45	7	2.8	6.8	6.3	60	45	0.6	5.5	0.15	977	977
R/L 050.7-50	7	2.8	6.8	6.3	65	50	0.6	5.5	0.15	978	978
P										○	○
M										○	○
K										○	○
N										○	○
S										○	○
H										●	●
O										○	○



→ Find the cutting data standard values here.

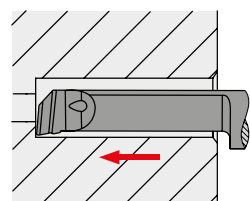
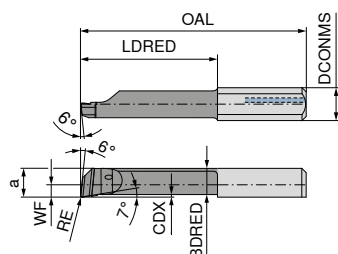


Machining with cooling is recommended.

→ Here you will find suitable holders.

CoreLine – Inserts for internal turning – UltraMini

- ▲ With chip former
- ▲ High-feed internal turning
- ▲ CDX = maximum radial infeed for outward turning



Illustrations show right-hand versions



Designation	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm	ST 73 001 ...	ST 73 000 ...
R/L X050.1-5	4		1.0	0.90	20	5	0.03	0.85	0.05	121	121
R/L X050.15-7	4		1.5	1.35	22	7	0.05	1.25	0.10	233	233
R/L X050.2-5	4		2.0	1.80	19	5	0.10	1.60	0.15	245	245
R/L X050.2-10	4		2.0	1.80	24	10	0.10	1.60	0.05	215	215
R/L X050.2-10	4		2.0	1.80	24	10	0.10	1.60	0.15	241	241
R/L X050.3-10	4	0.7	3.0	2.70	24	10	0.15	2.55	0.05	341	341
R/L X050.3-10	4	0.7	3.0	2.70	24	10	0.15	2.55	0.20	347	347
R/L X050.3-16	4	0.7	3.0	2.70	30	16	0.15	2.55	0.05	371	371
R/L X050.3-16	4	0.7	3.0	2.70	30	16	0.15	2.55	0.10	373	373
R/L X050.3-16	4	0.7	3.0	2.70	30	16	0.15	2.55	0.20	377	377
R/L X050.4-10	4	1.6	4.0	3.60	24	10	0.20	3.20	0.10	403	403
R/L X050.4-10	4	1.6	4.0	3.60	24	10	0.20	3.20	0.20	407	407
R/L X050.4-16	4	1.6	4.0	3.60	30	16	0.20	3.20	0.05	431	431
R/L X050.4-16	4	1.6	4.0	3.60	30	16	0.20	3.20	0.10	433	433
R/L X050.4-16	4	1.6	4.0	3.60	30	16	0.20	3.20	0.20	437	437
R/L X050.4-24	4	1.6	4.0	3.60	38	24	0.20	3.20	0.10	463	463
R/L X050.4-24	4	1.6	4.0	3.60	38	24	0.20	3.20	0.20	467	467
R/L X050.5-15	5	2.1	5.0	4.60	30	15	0.30	4.05	0.05	511	511
R/L X050.5-15	5	2.1	5.0	4.60	30	15	0.30	4.05	0.10	513	513
R/L X050.5-15	5	2.1	5.0	4.60	30	15	0.30	4.05	0.20	517	517
R/L X050.5-25	5	2.1	5.0	4.60	40	25	0.30	4.05	0.10	543	543
R/L X050.5-25	5	2.1	5.0	4.60	40	25	0.30	4.05	0.20	547	547
R/L X050.5-30	5	2.1	5.0	4.60	45	30	0.30	4.05	0.10	553	553
R/L X050.5-30	5	2.1	5.0	4.60	45	30	0.30	4.05	0.20	557	557
R/L X050.6-15	6	2.5	6.0	5.50	30	15	0.40	4.90	0.05	611	611
R/L X050.6-15	6	2.5	6.0	5.50	30	15	0.40	4.90	0.10	613	613
R/L X050.6-15	6	2.5	6.0	5.50	30	15	0.40	4.90	0.20	617	617
R/L X050.6-22	6	2.5	6.0	5.50	37	22	0.40	4.90	0.20	637	637
R/L X050.6-30	6	2.5	6.0	5.50	45	30	0.40	4.90	0.20	657	657
R/L X050.6-35	6	2.5	6.0	5.50	50	35	0.40	4.90	0.20	667	667
R/L X050.6-50	6	2.5	6.0	5.50	65	50	0.40	4.90	0.20	697	697
R/L X050.7-25	7	3.0	7.0	6.50	40	25	0.50	5.90	0.20	747	747
R/L X050.7-30	7	3.0	7.0	6.50	45	30	0.50	5.90	0.20	757	757
P										●	●
M										●	●
K										●	●
N										○	○
S										○	○
H										○	○
O										○	○

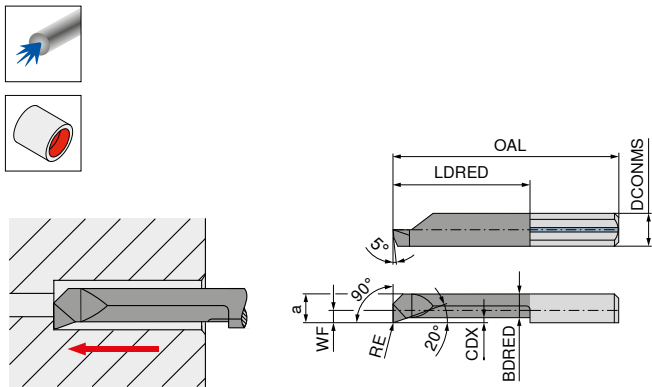


→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for internal turning – UltraMini

▲ CDX = maximum radial infeed for outward turning



Illustrations show right-hand versions



Designation	DCONMS mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm
R/L 090.3-10	4	0.6	2.8	2.6	24	10	0.2	2.3	0.2
R/L 090.3-16	4	0.6	2.8	2.6	30	16	0.2	2.3	0.2
R/L 090.4-10	4	1.5	4.0	3.5	24	10	0.3	3.0	0.2
R/L 090.4-16	4	1.5	4.0	3.5	30	16	0.3	3.0	0.2
R/L 090.5-10	5	1.9	5.0	4.4	25	10	0.5	3.8	0.2
R/L 090.5-15	5	1.9	5.0	4.4	30	15	0.5	3.8	0.2
R/L 090.5-20	5	1.9	5.0	4.4	35	20	0.5	3.8	0.2

ST	ST
73 015 ...	73 014 ...
541	541
542	542
545	545
546	546
550	550
551	551
552	552

P	●	●
M	●	●
K	●	●
N	●	●
S	○	○
H	○	○
O	●	●

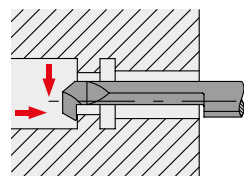
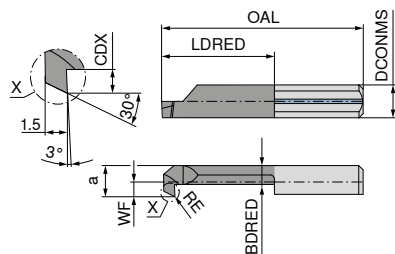


→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for back boring – UltraMini

▲ CDX = maximum radial infeed for outward turning



Illustrations show right-hand versions



Left

Right

Designation	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm
R/L 080.0003-15	4	0.6	3	2.6	29	15	0.5	2.0	0.10
R/L 080.0003-20	4	0.6	3	2.6	34	20	0.5	2.0	0.10
R/L 080.0004-15	4	1.5	4	3.5	29	15	0.8	2.4	0.15
R/L 080.0004-25	4	1.5	4	3.5	39	25	0.8	2.4	0.15
R/L 080.0005-20	5	1.9	5	4.4	35	20	1.0	3.3	0.20
R/L 080.0005-30	5	1.9	5	4.4	45	30	1.0	3.3	0.20
R/L 080.0006-20	6	2.3	6	5.3	35	20	1.8	3.4	0.20
R/L 080.0006-30	6	2.3	6	5.3	45	30	1.8	3.4	0.20
R/L 080.0007-20	7	2.7	7	6.3	35	20	2.5	3.8	0.20
R/L 080.0007-30	7	2.7	7	6.3	45	30	2.5	3.8	0.20

ST	ST
73 013 ...	73 012 ...
542	542
544	544
546	546
548	548
554	554
558	558
564	564
568	568
574	574
578	578

P	●	●
M	●	●
K	●	●
N	●	●
S	○	○
H	○	○
O	●	●

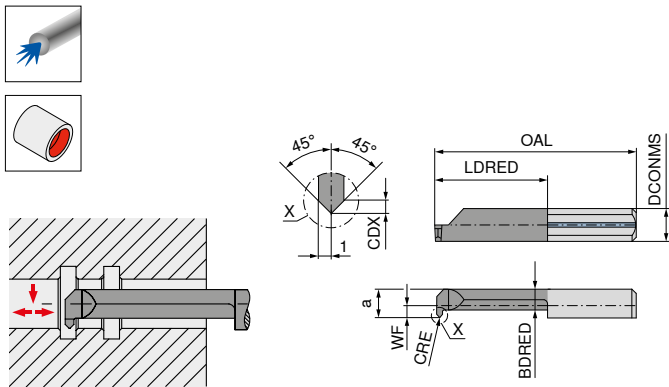


→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for internal turning and chamfering – UltraMini

▲ CDX = maximum radial infeed for outward turning



Illustrations show right-hand versions



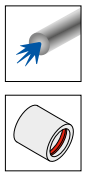
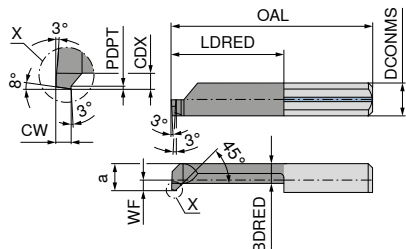
Designation	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	CRE mm	ST	ST
R/L 060.5-15	5	1.9	5.0	4.4	30	15	0.7	3.3	0.2	73 007 ...	73 006 ...
R/L 060.5-20	5	1.9	5.0	4.4	35	20	0.7	3.3	0.2	551	551
										550	550
R/L 060.7-20	7	2.7	6.8	6.3	35	20	0.7	3.8	0.2	570	570
P										●	●
M										●	●
K										●	●
N										●	●
S										○	○
H										○	○
O										●	●



→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for pregrooving and chamfering – UltraMini



Illustrations show right-hand versions

TiN

TiN



LeftRight

Designation	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	CW mm	PDPT mm
R/L 070.4-10	4	1.5	4	3.5	25	10	0.8	2.4	1	0.2
R/L 070.4-16	4	1.5	4	3.5	30	16	0.8	2.4	1	0.2
R/L 070.5-15	5	1.9	5	4.4	30	15	1.0	3.3	1	0.2
R/L 070.5-20	5	1.9	5	4.4	35	20	1.0	3.3	1	0.2
R/L 070.5-30	5	1.9	5	4.4	45	30	1.0	3.3	1	0.2
R/L 070.6-30	6	2.3	6	5.3	45	30	1.0	4.2	1	0.2
R/L 070.6-42	6	2.3	6	5.3	57	42	1.0	4.2	1	0.2

ST

73 009 ...

410

416

ST

73 008 ...

410

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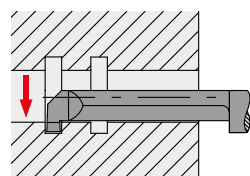
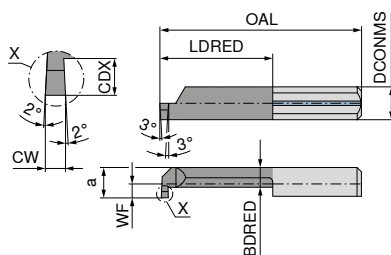
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 → Find the cutting data standard values here.

CoreLine – Inserts for internal grooving – UltraMini



Illustrations show right-hand versions



Left

Right

Designation	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	CW mm
R/L 004.0100-10	4	1.5	4.0	3.5	24	10	0.8	2.4	1.0
R/L 004.0100-16	4	1.5	4.0	3.5	30	16	0.8	2.4	1.0
R/L 004.0100-20	4	1.5	4.0	3.5	34	20	0.8	2.4	1.0
R/L 005.0100-10	5	1.9	5.0	4.4	25	10	1.0	3.3	1.0
R/L 005.0150-10	5	1.9	5.0	4.4	25	10	1.0	3.3	1.5
R/L 005.0200-10	5	1.9	5.0	4.4	25	10	1.0	3.3	2.0
R/L 005.0100-15	5	1.9	5.0	4.4	30	15	1.0	3.3	1.0
R/L 005.0150-15	5	1.9	5.0	4.4	30	15	1.0	3.3	1.5
R/L 005.0200-15	5	1.9	5.0	4.4	30	15	1.0	3.3	2.0
R/L 005.0100-20	5	1.9	5.0	4.4	35	20	1.0	3.3	1.0
R/L 005.0150-20	5	1.9	5.0	4.4	35	20	1.0	3.3	1.5
R/L 005.0200-20	5	1.9	5.0	4.4	35	20	1.0	3.3	2.0
R/L 005.0100-25	5	1.9	5.0	4.4	40	25	1.0	3.3	1.0
R/L 005.0150-25	5	1.9	5.0	4.4	40	25	1.0	3.3	1.5
R/L 005.0200-25	5	1.9	5.0	4.4	40	25	1.0	3.3	2.0
R/L 005.0100-30	5	1.9	5.0	4.4	45	30	1.0	3.3	1.0
R/L 005.0150-30	5	1.9	5.0	4.4	45	30	1.0	3.3	1.5
R/L 005.0200-30	5	1.9	5.0	4.4	45	30	1.0	3.3	2.0
R/L 005.0100-35	5	1.9	5.0	4.4	50	35	1.0	3.3	1.0
R/L 006.0100-10	6	2.3	6.0	5.3	25	10	1.8	3.4	1.0
R/L 006.0150-10	6	2.3	6.0	5.3	25	10	1.8	3.4	1.5
R/L 006.0200-10	6	2.3	6.0	5.3	25	10	1.8	3.4	2.0
R/L 006.0100-15	6	2.3	6.0	5.3	30	15	1.8	3.4	1.0
R/L 006.0150-15	6	2.3	6.0	5.3	30	15	1.8	3.4	1.5
R/L 006.0200-15	6	2.3	6.0	5.3	30	15	1.8	3.4	2.0
R/L 006.0100-22	6	2.3	6.0	5.3	37	22	1.8	3.4	1.0
R/L 006.0150-22	6	2.3	6.0	5.3	37	22	1.8	3.4	1.5
R/L 006.0200-22	6	2.3	6.0	5.3	37	22	1.8	3.4	2.0
R/L 006.0100-25	6	2.3	6.0	5.3	40	25	1.8	3.4	1.0
R/L 006.0150-25	6	2.3	6.0	5.3	40	25	1.8	3.4	1.5
R/L 006.0200-25	6	2.3	6.0	5.3	40	25	1.8	3.4	2.0
R/L 006.0100-30	6	2.3	6.0	5.3	45	30	1.8	3.4	1.0
R/L 006.0150-30	6	2.3	6.0	5.3	45	30	1.8	3.4	1.5
R/L 006.0200-30	6	2.3	6.0	5.3	45	30	1.8	3.4	2.0
R/L 006.0100-35	6	2.3	6.0	5.3	50	35	1.8	3.4	1.0
R/L 006.0150-35	6	2.3	6.0	5.3	50	35	1.8	3.4	1.5
R/L 006.0100-42	6	2.3	6.0	5.3	57	42	1.8	3.4	1.0
R/L 007.0100-10	7	2.7	6.8	6.3	25	10	2.5	3.8	1.0
R/L 007.0150-10	7	2.7	6.8	6.3	25	10	2.5	3.8	1.5
R/L 007.0200-10	7	2.7	6.8	6.3	25	10	2.5	3.8	2.0
R/L 007.0100-15	7	2.7	6.8	6.3	30	15	2.5	3.8	1.0

ST	ST
73 003 ...	73 002 ...
540	540
541	541
542	542
650	650
654	654
658	658
651	651
655	655
659	659
551	551
552	552
553	553
652	652
656	656
750	750
653	653
657	657
751	751
680	680
660	660
664	664
668	668
661	661
665	665
669	669
561	561
562	562
563	563
662	662
666	666
760	760
663	663
667	667
761	761
682	682
684	684
685	685
570	570
575	575
670	670
571	571

P	●	●
M	●	●
K	●	●
N	●	●
S	○	○
H	○	○
O	●	●

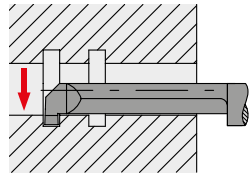
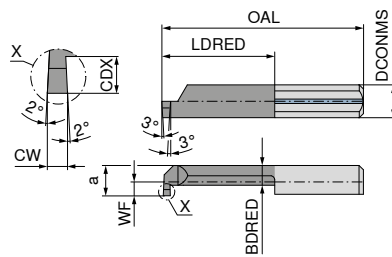


→ Find the cutting data standard values here.

→ Here you will find suitable holders.

Continued on next page

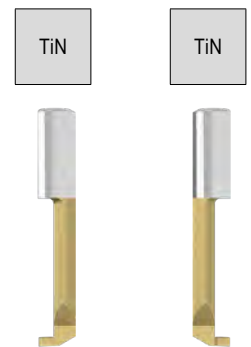
CoreLine – Inserts for internal grooving – UltraMini



Illustrations show right-hand versions

Designation	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	CW mm
R/L 007.0150-15	7	2.7	6.8	6.3	30	15	2.5	3.8	1.5
R/L 007.0200-15	7	2.7	6.8	6.3	30	15	2.5	3.8	2.0
R/L 007.0100-22	7	2.7	6.8	6.3	37	22	2.5	3.8	1.0
R/L 007.0150-22	7	2.7	6.8	6.3	37	22	2.5	3.8	1.5
R/L 007.0200-22	7	2.7	6.8	6.3	37	22	2.5	3.8	2.0
R/L 007.0100-25	7	2.7	6.8	6.3	40	25	2.5	3.8	1.0
R/L 007.0150-25	7	2.7	6.8	6.3	40	25	2.5	3.8	1.5
R/L 007.0200-25	7	2.7	6.8	6.3	40	25	2.5	3.8	2.0
R/L 007.0100-30	7	2.7	6.8	6.3	45	30	2.5	3.8	1.0
R/L 007.0150-30	7	2.7	6.8	6.3	45	30	2.5	3.8	1.5
R/L 007.0200-30	7	2.7	6.8	6.3	45	30	2.5	3.8	2.0
R/L 007.0100-35	7	2.7	7.0	6.3	50	35	2.5	3.8	1.0
R/L 007.0150-35	7	2.7	7.0	6.3	50	35	2.5	3.8	1.5
R/L 007.0200-35	7	2.7	7.0	6.3	50	35	2.5	3.8	2.0
R/L 007.0100-40	7	2.7	7.0	6.3	55	40	2.5	3.8	1.0
R/L 007.0150-40	7	2.7	7.0	6.3	55	40	2.5	3.8	1.5
R/L 007.0100-45	7	2.7	7.0	6.3	60	45	2.5	3.8	1.0
R/L 007.0100-50	7	2.7	7.0	6.3	65	50	2.5	3.8	1.0

P	●	●
M	●	●
K	●	●
N	●	●
S	○	○
H	○	○
O	●	●



Left

Right

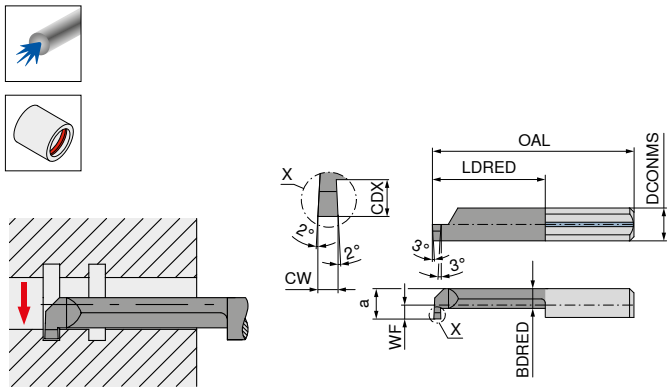
ST	ST
73 003 ...	73 002 ...
576	576
671	671
572	572
577	577
672	672
573	573
578	578
673	673
574	574
579	579
674	674
688	688
690	690
692	692
700	700
702	702
712	712
714	714



→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for internal grooving – UltraMini



Illustrations show right-hand versions



Designation	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	CW mm	ST 73 003 ...	ST 73 002 ...
R/L 002.0050-5	4		2	1.8	19	5	0.4	1.2	0.5	820	820
R/L 002.0050-10	4		2	1.8	24	10	0.4	1.2	0.5	821	821
R/L 002.0050-15	4		2	1.8	29	15	0.4	1.2	0.5	822	822
R/L 003.0070-5	4	0.7	3	2.7	19	5	0.6	1.9	0.7	830	830
R/L 003.0070-10	4	0.7	3	2.7	24	10	0.6	1.9	0.7	831	831
R/L 003.0070-16	4	0.7	3	2.7	30	16	0.6	1.9	0.7	832	832
P										•	•
M										•	•
K										•	•
N										•	•
S										•	•
H										•	•
O										•	•

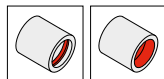
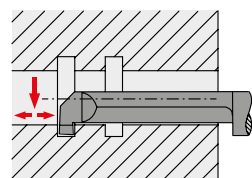
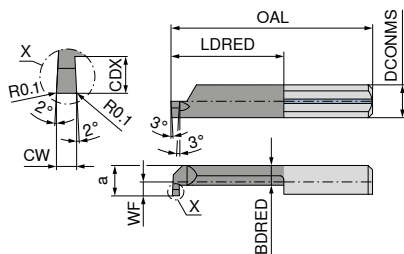
→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for internal grooving – UltraMini

▲ With corner radius

▲ CDX = maximum radial infeed for outward turning



Illustrations show right-hand versions

TiAlN

TiAlN



Left



Right

Designation	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	CW mm	ST 73 203 ...	ST 73 202 ...
R/L 004M0100-10	4	1.5	4.0	3.5	24	10	0.8	2.4	1.0	800	800
R/L 004M0100-16	4	1.5	4.0	3.5	30	16	0.8	2.4	1.0	802	802
R/L 004M0100-20	4	1.5	4.0	3.5	34	20	0.8	2.4	1.0	804	804
R/L 005M0100-10	5	1.9	5.0	4.4	25	10	1.0	3.3	1.0	806	806
R/L 005M0150-10	5	1.9	5.0	4.4	25	10	1.0	3.3	1.5	816	816
R/L 005M0200-10	5	1.9	5.0	4.4	25	10	1.0	3.3	2.0	826	826
R/L 005M0100-15	5	1.9	5.0	4.4	30	15	1.0	3.3	1.0	808	808
R/L 005M0150-15	5	1.9	5.0	4.4	30	15	1.0	3.3	1.5	818	818
R/L 005M0200-15	5	1.9	5.0	4.4	30	15	1.0	3.3	2.0	828	828
R/L 005M0100-20	5	1.9	5.0	4.4	35	20	1.0	3.3	1.0	810	810
R/L 005M0150-20	5	1.9	5.0	4.4	35	20	1.0	3.3	1.5	820	820
R/L 005M0200-20	5	1.9	5.0	4.4	35	20	1.0	3.3	2.0	830	830
R/L 005M0100-25	5	1.9	5.0	4.4	40	25	1.0	3.3	1.0	812	812
R/L 005M0150-25	5	1.9	5.0	4.4	40	25	1.0	3.3	1.5	822	822
R/L 005M0200-25	5	1.9	5.0	4.4	40	25	1.0	3.3	2.0	832	832
R/L 005M0100-30	5	1.9	5.0	4.4	45	30	1.0	3.3	1.0	814	814
R/L 005M0150-30	5	1.9	5.0	4.4	45	30	1.0	3.3	1.5	824	824
R/L 005M0200-30	5	1.9	5.0	4.4	45	30	1.0	3.3	2.0	834	834
R/L 006M0100-10	6	2.3	6.0	5.3	25	10	1.8	3.4	1.0	836	836
R/L 006M0150-10	6	2.3	6.0	5.3	25	10	1.8	3.4	1.5	846	846
R/L 006M0200-10	6	2.3	6.0	5.3	25	10	1.8	3.4	2.0	856	856
R/L 006M0100-15	6	2.3	6.0	5.3	30	15	1.8	3.4	1.0	838	838
R/L 006M0150-15	6	2.3	6.0	5.3	30	15	1.8	3.4	1.5	848	848
R/L 006M0200-15	6	2.3	6.0	5.3	30	15	1.8	3.4	2.0	858	858
R/L 006M0100-20	6	2.3	6.0	5.3	35	22	1.8	3.4	1.0	840	840
R/L 006M0150-20	6	2.3	6.0	5.3	37	22	1.8	3.4	1.5	850	850
R/L 006M0200-20	6	2.3	6.0	5.3	37	22	1.8	3.4	2.0	860	860
R/L 006M0100-25	6	2.3	6.0	5.3	40	25	1.8	3.4	1.0	842	842
R/L 006M0150-25	6	2.3	6.0	5.3	40	25	1.8	3.4	1.5	852	852
R/L 006M0200-25	6	2.3	6.0	5.3	40	25	1.8	3.4	2.0	862	862
R/L 006M0100-30	6	2.3	6.0	5.3	45	30	1.8	3.4	1.0	844	844
R/L 006M0150-30	6	2.3	6.0	5.3	45	30	1.8	3.4	1.5	854	854
R/L 006M0200-30	6	2.3	6.0	5.3	45	30	1.8	3.4	2.0	864	864
R/L 007M0100-10	7	2.7	6.8	6.3	25	10	2.5	3.7	1.0	866	866
R/L 007M0150-10	7	2.7	6.8	6.3	25	10	2.5	3.7	1.5	876	876
R/L 007M0200-10	7	2.7	6.8	6.3	25	10	2.5	3.7	2.0	886	886
R/L 007M0100-15	7	2.7	6.8	6.3	30	15	2.5	3.7	1.0	868	868
R/L 007M0150-15	7	2.7	6.8	6.3	30	15	2.5	3.7	1.5	878	878
R/L 007M0200-15	7	2.7	6.8	6.3	30	15	2.5	3.7	2.0	888	888
R/L 007M0100-22	7	2.7	6.8	6.3	37	22	2.5	3.7	1.0	870	870
R/L 007M0150-22	7	2.7	6.8	6.3	37	22	2.5	3.7	1.5	880	880

P	●	●
M	●	●
K	●	●
N	●	●
S	●	●
H	●	●
O	●	●



→ Find the cutting data standard values here.

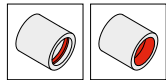
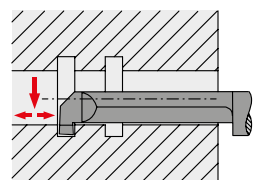
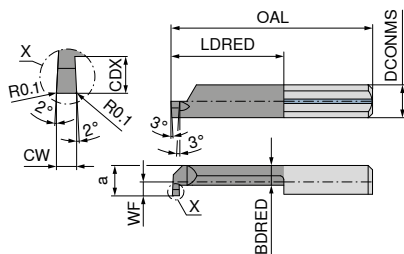
→ Here you will find suitable holders.

Continued on next page

CoreLine – Inserts for internal grooving – UltraMini

▲ With corner radius

▲ CDX = maximum radial infeed for outward turning



Illustrations show right-hand versions

TiAlN

TiAlN



Left



Right

Designation	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	CW mm
R/L 007M0200-22	7	2.7	6.8	6.3	37	22	2.5	3.7	2.0
R/L 007M0100-25	7	2.7	6.8	6.3	40	25	2.5	3.7	1.0
R/L 007M0150-25	7	2.7	6.8	6.3	40	25	2.5	3.7	1.5
R/L 007M0200-25	7	2.7	6.8	6.3	40	25	2.5	3.7	2.0
R/L 007M0100-30	7	2.7	6.8	6.3	45	30	2.5	3.7	1.0
R/L 007M0150-30	7	2.7	6.8	6.3	45	30	2.5	3.7	1.5
R/L 007M0200-30	7	2.7	6.8	6.3	45	30	2.5	3.7	2.0

ST

73 203 ...

890

872

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892

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894

ST

73 202 ...

890

872

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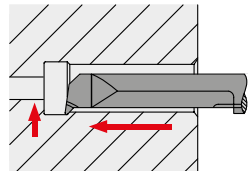
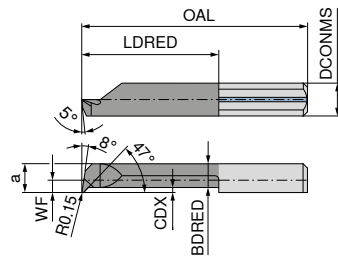


→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for internal undercuts – UltraMini

▲ CDX = maximum radial infeed for outward turning



Illustrations show right-hand versions

Designation	DCONMS _{h6} mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm
R/L 047.2-10	4		2.0	1.7	24	10	0.4	1.2
R/L 047.3-15	4	0.6	3.0	2.6	29	15	0.6	1.9
R/L 047.4-10	4	1.5	4.0	3.5	24	10	0.6	2.8
R/L 047.T4-20	4	1.5	4.0	3.5	34	20	0.6	2.8
R/L 047.4-20	4	1.5	4.0	3.5	34	20	0.3	3.0
R/L 047.5-15	5	1.9	5.0	4.4	30	15	0.8	3.5
R/L 047.T5-25	5	1.9	5.0	4.4	40	25	0.8	3.5
R/L 047.5-25	5	1.9	5.0	4.4	40	25	0.5	3.8
R/L 047.T6-22	6	2.3	6.0	5.3	37	22	1.8	3.4
R/L 047.T6-30	6	2.3	6.0	5.3	45	30	1.8	3.4
R/L 047.6-30	6	2.3	6.0	5.3	45	30	0.5	4.5



Left

ST
73 011 ...
542
552
562



Right

ST
73 010 ...
542
552
562



Left

ST
73 011 ...
221 231 241 242
251 252
262 263



Right

ST
73 010 ...
221 231 241 242
251 252
262 263

P	●	●	●	●
M	●	●	●	●
K	●	●	●	●
N	●	●	●	●
S	○	○	●	●
H	○	○	●	●
O	●	●	●	●

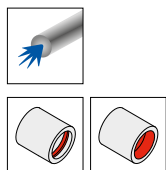
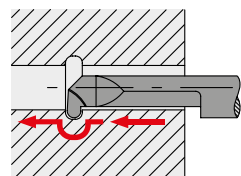
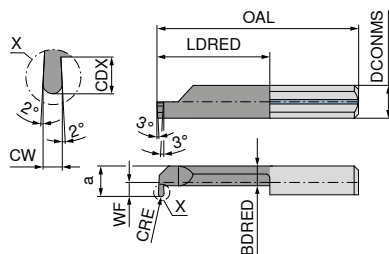


→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for groove and profile turning – UltraMini

▲ CDX = maximum radial infeed for outward turning



Illustrations show right-hand versions



Left

Right

Designation	DCONMS ₁₆ mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	CW mm	CRE mm
R/L 006-0.75-25	6	2.3	6.0	5.3	40	25	1.8	3.4	1.5	0.75
R/L 004-0.50-16	4	1.5	4.0	3.5	30	16	0.8	2.4	1.0	0.50
R/L 005-0.50-20	5	1.9	5.0	4.4	35	20	1.0	3.3	1.0	0.50
R/L 005-0.75-20	5	1.9	5.0	4.4	35	20	1.0	3.3	1.5	0.75
R/L 005-1.00-20	5	1.9	5.0	4.4	35	20	1.0	3.3	2.0	1.00
R/L 006-0.50-25	6	2.3	6.0	5.3	40	25	1.8	3.4	1.0	0.50
R/L 006-1.00-25	6	2.3	6.0	5.3	40	25	1.8	3.4	2.0	1.00
R/L 007-0.50-30	7	2.7	6.8	6.3	45	30	2.5	3.8	1.0	0.50
R/L 007-0.75-30	7	2.7	6.8	6.3	45	30	2.5	3.8	1.5	0.75
R/L 007-1.00-30	7	2.7	6.8	6.3	45	30	2.5	3.8	2.0	1.00

ST	ST
73 019 ...	73 018 ...
564	564
541	541
552	552
554	554
556	556
562	562
566	566
572	572
574	574
576	576

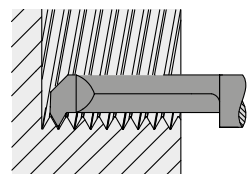
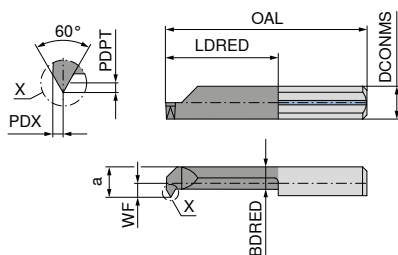
P	●	●
M	●	●
K	●	●
N	●	●
S	○	○
H	○	○
O	●	●



→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for internal thread turning (partial profile) – UltraMini



Illustrations show right-hand versions

Designation	DCONMS _{h6} mm	TP mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	BDRED mm	PDPT mm	PDX mm
R/L 003.0105-8	4	0,5 - 0,7	0.30	2.4	2.3	22	8	1.8	0.27	0.33
R/L 004.0408-15	4	0,8 - 1,0	1.75	4.0	3.5	30	15	2.4	0.43	0.45
R/L 005.0510-20	5	1,0 - 1,25	1.90	4.8	4.4	35	20	3.3	0.55	0.55
R/L 005.0510-15	5	1,0 - 1,25	1.90	4.8	4.4	30	15	3.3	0.55	0.55
R/L 006.0612-22	6	1,25 - 1,5	2.30	6.0	5.3	37	22	3.4	0.68	0.65
R/L 006.0612-15	6	1,25 - 1,5	2.30	6.0	5.3	30	15	3.4	0.68	0.65
R/L 006.0815-15	6	1,5 - 1,75	2.30	6.0	5.3	30	15	3.4	0.81	0.75
R/L 006.0815-22	6	1,5 - 1,75	2.30	6.0	5.3	37	22	3.4	0.81	0.75
R/L 007.0815-15	7	1,5 - 1,75	2.70	7.0	6.3	30	15	3.8	0.81	0.75

P	•	•	•	•
M	•	•	•	•
K	•	•	•	•
N	•	•	•	•
S	○	○	•	•
H	○	○	•	•
O	•	•	•	•



→ Find the cutting data standard values here.



Left

Right

Left

Right

ST

ST

ST

ST

73 101 ...

73 100 ...

73 101 ...

73 100 ...

551
552

551
552

544
545

544
545

546
547
549
548

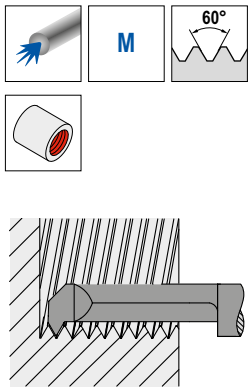
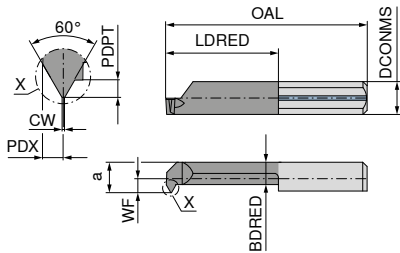
546
547
549
548

550

550

→ Here you will find suitable holders.

CoreLine – Inserts for internal thread turning (full profile) – UltraMini



Illustrations show right-hand versions

TiAIN

TiAIN



Left

Right

Designation	DCONMS _{HS} mm	TP mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	BDRED mm	PDPT mm	PDX mm	CW mm
R/L 105.0408-15	5	0.80	1.9	4.8	4.4	30	15	3.3	0.43	0.50	0.10
R/L 105.510-15	5	1.00	1.9	4.8	4.4	30	15	3.3	0.54	0.55	0.12
R/L 106.612-15	6	1.25	2.3	6.0	5.3	30	15	3.4	0.67	0.65	0.15
R/L 106.815-15	6	1.50	2.3	6.0	5.3	30	15	3.4	0.81	0.75	0.18
R/L 106.815-15	7	1.50	2.7	7.0	6.3	30	15	3.8	0.81	0.75	0.18

ST
73 209 ...
799
800
802
804
806

ST
73 208 ...
799
800
802
804
806

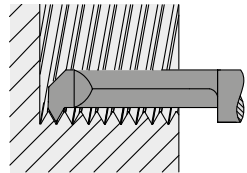
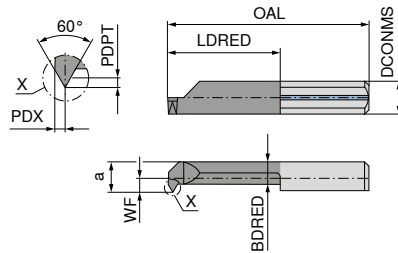
P	●	●
M	●	●
K	●	●
N	●	●
S	●	●
H	●	●
O	●	●



→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for internal thread turning (partial profile) – UltraMini



Illustrations show right-hand versions

Designation	DCONMS _{h6} mm	TP mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	BDRED mm	PDPT mm	PDX mm
R/L 004.0205-15	4	0,5 - 0,75	1,5	4,0	3,5	30	15	2,4	0,27	0,35
R/L 004.0105-10	4	0,5 - 0,75	1,0	3,2	3,0	24	10	2,3	0,27	0,44
R/L 005.0205-15	5	0,5 - 0,75	1,9	5,0	4,4	30	15	3,3	0,27	0,35
R/L 005.0205-20	5	0,5 - 0,75	1,9	5,0	4,4	35	20	3,3	0,27	0,35
L 005.0407-15	5	0,75 - 1,0	1,9	5,0	4,4	30	15	3,3	0,40	0,45
R 005.0407-15	5	0,75 - 1,0	1,9	5,0	4,4	30	15	3,3	0,40	0,45
R/L 005.0407-20	5	0,75 - 1,0	1,9	5,0	4,4	35	20	3,3	0,40	0,45
R/L 006.0510-22	6	1,0 - 1,25	2,3	6,0	5,3	37	22	3,4	0,55	0,55
R/L 006.0510-15	6	1,0 - 1,25	2,3	6,0	5,3	30	15	3,4	0,55	0,55

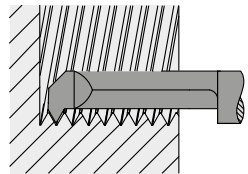
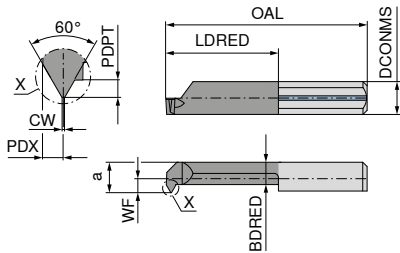
	ST	ST	ST	ST
73 103 ...	510	510	509	509
539	539	539		
540	540	540		
541	541	541		
542	542	542		
544	544	544		
543	543	543		
P	●	●	●	●
M	●	●	●	●
K	●	●	●	●
N	●	●	●	●
S	○	○	●	●
H	○	○	●	●
O	●	●	●	●



→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for internal thread turning (full profile) – UltraMini



Illustrations show right-hand versions



Left

Right

Designation	DCONMS _{h6} mm	TP mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	BDRED mm	PDPT mm	PDX mm	CW mm
R/L 104.0205-15	5	0.50	1.5	4	3.5	30	15	2.4	0.27	0.35	0.06
R/L 105.0205-15	5	0.50	1.9	5	4.4	30	15	3.3	0.27	0.35	0.06
R/L 105.0407-15	5	0.75	1.9	5	4.4	30	15	3.3	0.40	0.45	0.09
R/L 106.0510-15	6	1.00	2.3	6	5.3	30	15	3.4	0.54	0.55	0.12

ST
73 207 ...
800
802
804
806

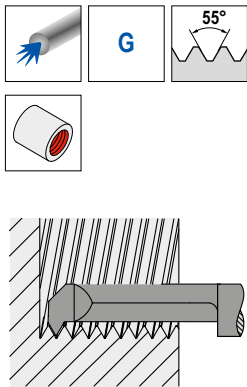
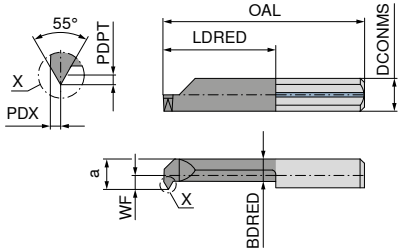
ST
73 206 ...
800
802
804
806

P	•	•
M	•	•
K	•	•
N	•	•
S	•	•
H	•	•
O	•	•



→ Find the cutting data standard values here.

CoreLine – Inserts for internal thread turning (partial profile) – UltraMini



Illustrations show right-hand versions



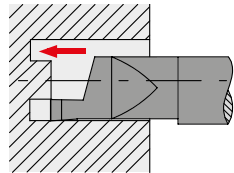
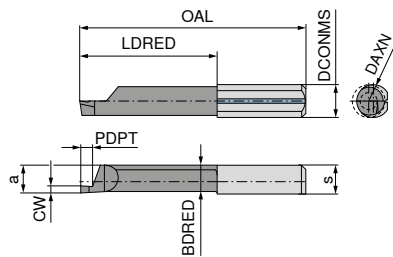
Designation	DCONMS _{HS} mm	TPI 1/"	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	BDRED mm	PDPT mm	PDX mm	ST 73 105 ...	ST 73 104 ...
R/L 005.5548-15	5	48 - 24	1.9	4.8	4.4	30	15	3.3	0.40	0.45	552	552
R/L 006.5548-15	6	48 - 24	2.3	6.0	5.3	30	15	3.4	0.40	0.45	562	562
R/L 006.5524-15	6	24 - 16	2.3	6.0	5.3	30	15	3.4	0.81	0.75	563	563
R/L 007.5524-15	7	24 - 16	2.7	7.0	6.3	30	15	3.8	0.81	0.75	572	572
P											●	●
M											●	●
K											●	●
N											●	●
S											○	○
H											○	○
O											●	●



→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for axial grooving – UltraMini



Illustrations show right-hand versions



Left

Right

Designation	DCONMS _{h6} mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	BDRED mm	CW mm	ST	ST
R/L 010.1006-10	6	5.2	6	5.3	26	11	1.5	4.9	1.0	73 053 ...	73 052 ...
R/L 010.1506-10	6	5.2	6	5.3	26	11	2.0	4.9	1.5	561	561
										563	563
R/L 010.1008-10	7	5.9	8	6.3	26	11	1.5	5.6	1.0	571	571
R/L 010.1008-20	7	5.9	8	6.3	35	20	1.5	5.6	1.0	671	671
R/L 010.1008-30	7	5.9	8	6.3	45	30	1.5	5.6	1.0	771	771
R/L 010.1508-10	7	5.9	8	6.3	26	11	2.5	5.6	1.5	573	573
R/L 010.1508-20	7	5.9	8	6.3	35	20	2.5	5.6	1.5	673	673
R/L 010.1508-30	7	5.9	8	6.3	45	30	2.5	5.6	1.5	773	773
R/L 010.2008-10	7	5.9	8	6.3	26	11	3.0	5.6	2.0	575	575
R/L 010.2008-20	7	5.9	8	6.3	35	20	3.0	5.6	2.0	675	675
R/L 010.2008-30	7	5.9	8	6.3	45	30	3.0	5.6	2.0	775	775
R/L 010.2508-10	7	5.9	8	6.3	26	11	3.5	5.6	2.5	577	577
R/L 010.2508-20	7	5.9	8	6.3	35	20	3.5	5.6	2.5	677	677
R/L 010.2508-30	7	5.9	8	6.3	45	30	3.5	5.6	2.5	777	777
R/L 010.3008-10	7	5.9	8	6.3	26	11	3.5	5.6	3.0	579	579
R/L 010.3008-20	7	5.9	8	6.3	35	20	3.5	5.6	3.0	679	679
R/L 010.3008-30	7	5.9	8	6.3	45	30	3.5	5.6	3.0	779	779
P										●	●
M										●	●
K										●	●
N										●	●
S										●	●
H										●	●
O										●	●

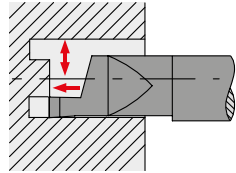
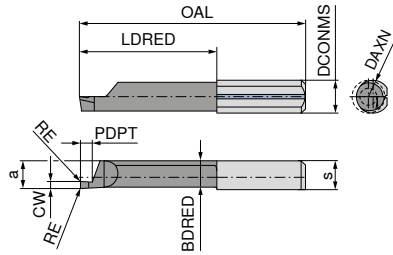


→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for axial grooving – UltraMini

▲ With corner radius



Illustrations show right-hand versions



Left



Right

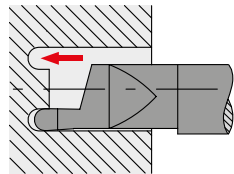
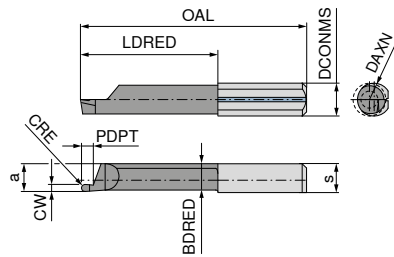
Designation	DCONMS _{h6} mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	BDRED mm	CW mm	RE mm	ST 73 253 ...	ST 73 252 ...
R/L 510M1008-10	5	4.3	5	6.3	26	11	2	4.0	1.0	0.05	510	510
R/L 510M1008-20	5	4.3	5	6.3	35	20	2	4.0	1.0	0.05	610	610
R/L 510M1508-10	5	4.3	5	6.3	26	11	3	4.0	1.5	0.05	515	515
R/L 510M1508-20	5	4.3	5	6.3	35	20	3	4.0	1.5	0.05	615	615
R/L 510M2008-10	5	4.3	5	6.3	26	11	4	4.0	2.0	0.05	520	520
R/L 510M2008-20	5	4.3	5	6.3	35	20	4	4.0	2.0	0.05	620	620
R/L 010M1008-10	7	5.9	8	6.3	26	11	2	5.6	1.0	0.10	800	800
R/L 010M1008-20	7	5.9	8	6.3	35	20	2	5.6	1.0	0.10	810	810
R/L 010M1008-30	7	5.9	8	6.3	45	30	2	5.6	1.0	0.10	820	820
R/L 010M1508-10	7	5.9	8	6.3	26	11	3	5.6	1.5	0.10	802	802
R/L 010M1508-20	7	5.9	8	6.3	35	20	3	5.6	1.5	0.10	812	812
R/L 010M1508-30	7	5.9	8	6.3	45	30	3	5.6	1.5	0.10	822	822
R/L 010M2008-10	7	5.9	8	6.3	26	11	4	5.6	2.0	0.10	804	804
R/L 010M2008-20	7	5.9	8	6.3	35	20	4	5.6	2.0	0.10	814	814
R/L 010M2008-30	7	5.9	8	6.3	45	30	4	5.6	2.0	0.10	824	824
R/L 010M2508-10	7	5.9	8	6.3	26	11	5	5.6	2.5	0.10	806	806
R/L 010M2508-20	7	5.9	8	6.3	35	20	5	5.6	2.5	0.10	816	816
R/L 010M2508-30	7	5.9	8	6.3	45	30	5	5.6	2.5	0.10	826	826
R/L 010M3008-10	7	5.9	8	6.3	26	11	6	5.6	3.0	0.10	808	808
R/L 010M3008-20	7	5.9	8	6.3	35	20	6	5.6	3.0	0.10	818	818
R/L 010M3008-30	7	5.9	8	6.3	45	30	6	5.6	3.0	0.10	828	828
P											•	•
M											•	•
K											•	•
N											•	•
S											•	•
H											•	•
O											•	•



→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for axial grooving (full radius) – UltraMini



Illustrations show right-hand versions

TiAlN

TiAlN



Left



Right

Designation	DCONMS _{HS} mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	BDRD mm	CW mm	CRE mm
R/L 610.1005-10	6	5.2	6	5.3	26	11	2	4.9	1.0	0.50
R/L 610.1005-20	6	5.2	6	5.3	35	20	2	4.9	1.0	0.50
R/L 610.1608-10	6	5.2	6	5.3	26	11	3	4.9	1.6	0.80
R/L 610.1608-20	6	5.2	6	5.3	35	20	3	4.9	1.6	0.80
R/L 610.2010-10	6	5.2	6	5.3	26	11	4	4.9	2.0	1.00
R/L 610.2010-20	6	5.2	6	5.3	35	20	4	4.9	2.0	1.00
R/L 610.2512-10	6	5.2	6	5.3	26	11	5	4.9	2.5	1.25
R/L 610.2512-20	6	5.2	6	5.3	35	20	5	4.9	2.5	1.25
R/L 610.3015-10	6	5.2	6	5.3	26	11	6	4.9	3.0	1.50
R/L 610.3015-20	6	5.2	6	5.3	35	20	6	4.9	3.0	1.50
R/L 010.1005-10	7	5.9	8	6.3	26	11	2	5.6	1.0	0.50
R/L 010.1005-20	7	5.9	8	6.3	35	20	2	5.6	1.0	0.50
R/L 010.1608-10	7	5.9	8	6.3	26	11	3	5.6	1.6	0.80
R/L 010.1608-20	7	5.9	8	6.3	35	20	3	5.6	1.6	0.80
R/L 010.2010-10	7	5.9	8	6.3	26	11	4	5.6	2.0	1.00
R/L 010.2010-20	7	5.9	8	6.3	35	20	4	5.6	2.0	1.00
R/L 010.2512-10	7	5.9	8	6.3	26	11	5	5.6	2.5	1.25
R/L 010.2512-20	7	5.9	8	6.3	35	20	5	5.6	2.5	1.25
R/L 010.3015-10	7	5.9	8	6.3	26	11	6	5.6	3.0	1.50
R/L 010.3015-20	7	5.9	8	6.3	35	20	6	5.6	3.0	1.50

ST

73 059 ...

ST

73 058 ...

071	071
171	171
073	073
173	173
075	075
175	175
077	077
177	177
079	079
179	179

571	571
671	671
573	573
673	673
575	575
675	675
577	577
677	677
579	579
679	679

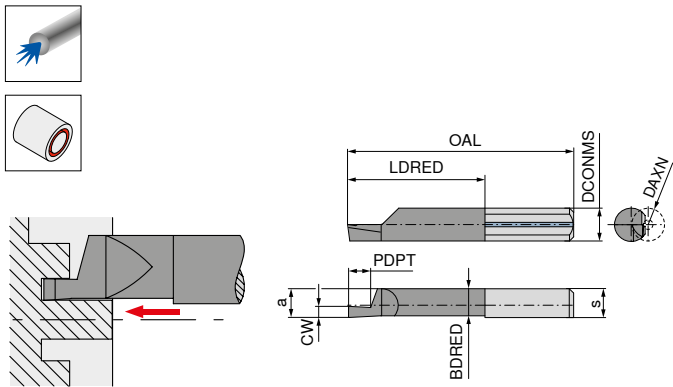
P	•	•
M	•	•
K	•	•
N	•	•
S	•	•
H	•	•
O	•	•



→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for axial grooving over a spigot – UltraMini



Illustrations show right-hand versions



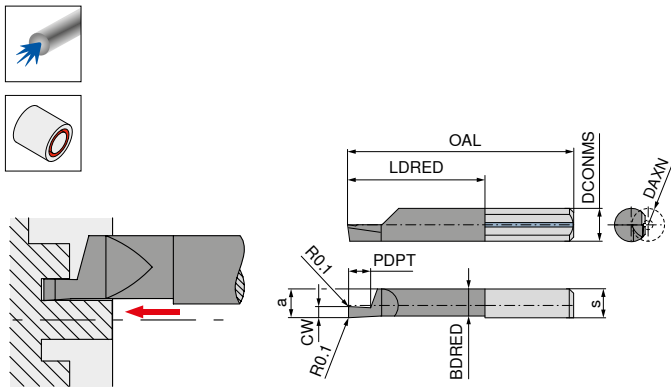
Designation	DCONMS _{HS} mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	BDRED mm	CW mm	ST	ST
R/L 620.1006-20	6	5.2	6	5.3	35	20	2	4.9	1.0	73 061 ...	73 060 ...
R/L 620.1506-20	6	5.2	6	5.3	35	20	3	4.9	1.5	561	561
R/L 620.2006-20	6	5.2	6	5.3	35	20	4	4.9	2.0	563	563
R/L 620.2506-20	6	5.2	6	5.3	35	20	5	4.9	2.5	565	565
R/L 620.3006-20	6	5.2	6	5.3	35	20	6	4.9	3.0	567	567
										569	569
P										•	•
M										•	•
K										•	•
N										•	•
S										•	•
H										•	•
O										•	•

→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for axial grooving over a spigot – UltraMini

▲ With corner radius



Illustrations show right-hand versions



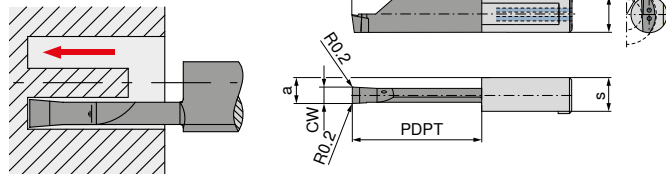
Designation	DCONMS _{h6} mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	BDRED mm	CW mm	ST 73 261 ...	ST 73 260 ...
R/L 620M1006-20	6	5.2	6	5.3	35	20	2	4.9	1.0	800	800
R/L 620M1506-20	6	5.2	6	5.3	35	20	3	4.9	1.5	802	802
R/L 620M2006-20	6	5.2	6	5.3	35	20	4	4.9	2.0	804	804
R/L 620M2506-20	6	5.2	6	5.3	35	20	5	4.9	2.5	806	806
R/L 620M3006-20	6	5.2	6	5.3	35	20	6	4.9	3.0	808	808
P										●	●
M										●	●
K										●	●
N										●	●
S										●	●
H										●	●
O										●	●

 → Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for axial grooving – UltraMini

- ▲ Up to 70 bar
- ▲ Dual coolant channel



Illustrations show right-hand versions

TiAlN

TiAlN



Left

Right

Designation	DCONMS _{HS} mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	CW mm
R/L 012.0200-10	8	5.00	12	7.3	30	10	10	2.0
R/L 012.0200-15	8	5.00	12	7.3	35	15	15	2.0
R/L 012.0250-10	8	5.25	12	7.3	30	10	10	2.5
R/L 012.0250-20	8	5.25	12	7.3	40	20	20	2.5
R/L 016.0300-10	8	5.50	16	7.3	30	10	10	3.0
R/L 016.0300-20	8	5.50	16	7.3	40	20	20	3.0
R/L 020.0300-25	8	5.50	20	7.3	45	25	25	3.0
R/L 020.0300-30	8	5.50	20	7.3	50	30	30	3.0
R/L 020.0300-35	8	5.50	20	7.3	55	35	35	3.0
R/L 020.0300-40	8	5.50	20	7.3	60	40	40	3.0
R/L 016.0400-10	8	6.00	16	7.3	30	10	10	4.0
R/L 016.0400-20	8	6.00	16	7.3	40	20	20	4.0
R/L 020.0400-25	8	6.00	20	7.3	45	25	25	4.0
R/L 020.0400-30	8	6.00	20	7.3	50	30	30	4.0
R/L 020.0400-35	8	6.00	20	7.3	55	35	35	4.0
R/L 020.0400-40	8	6.00	20	7.3	60	40	40	4.0
R/L 020.0500.20	8	6.50	20	7.3	40	20	20	5.0
R/L 020.0500.25	8	6.50	20	7.3	45	25	25	5.0
R/L 020.0500.30	8	6.50	20	7.3	50	30	30	5.0
R/L 020.0500.35	8	6.50	20	7.3	55	35	35	5.0
R/L 020.0500.40	8	6.50	20	7.3	60	40	40	5.0

ST	ST
73 263 ...	73 262 ...
700	700
702	702
704	704
706	706
800	800
802	802
804	804
806	806
808	808
810	810
812	812
814	814
816	816
818	818
820	820
822	822
824	824
826	826
828	828
830	830
832	832

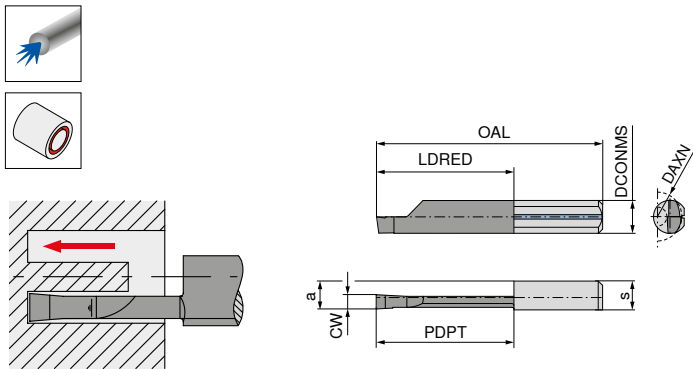
P	•	•
M	•	•
K	•	•
N	•	•
S	•	•
H	•	•
O	•	•



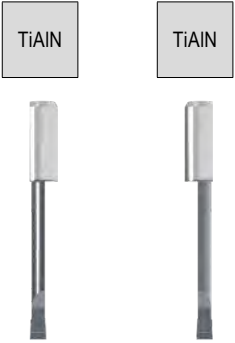
→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for axial grooving – UltraMini



Illustrations show right-hand versions



Left

Right

Designation	DCONMS _{h6} mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	CW mm
R/L 015.2515-20	7	5.9	15	6.3	35	20	20	2.5
R/L 015.3015-20	7	5.9	15	6.3	35	20	20	3.0
R/L 015.3015-30	7	5.9	15	6.3	45	30	30	3.0

ST	ST
73 057 ...	73 056 ...
572	572
574	574
674	674

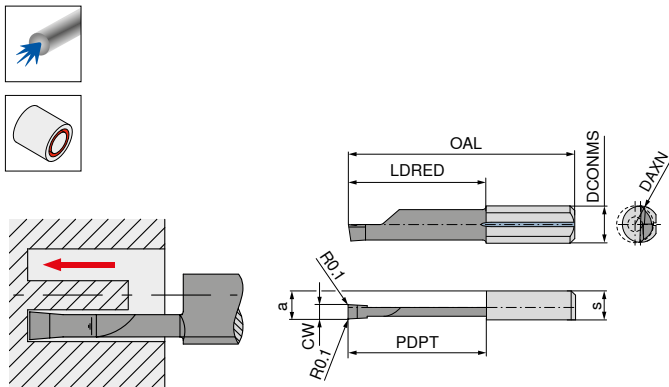
P	●	●
M	●	●
K	●	●
N	●	●
S	●	●
H	●	●
O	●	●



→ Find the cutting data standard values here.

CoreLine – Inserts for axial grooving – UltraMini

▲ With corner radius



Illustrations show right-hand versions



Designation	DCONMS _{h6} mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	CW mm
R/L 015M2515-20	7	5.9	8	6.3	35	20	20	2.5
R/L 015M3015-20	7	5.9	8	6.3	35	20	20	3.0
R/L 015M3015-30	7	5.9	8	6.3	45	30	30	3.0

ST	ST
73 257 ...	73 256 ...
800	800
802	802
804	804

P	●	●
M	●	●
K	●	●
N	●	●
S	●	●
H	●	●
O	●	●

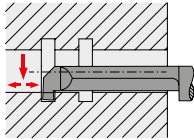


→ Find the cutting data standard values here.

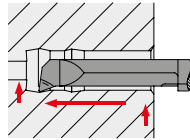
→ Here you will find suitable holders.

CoreLine – Set: Internal turning, grooving, and chamfering, right hand – UltraMini

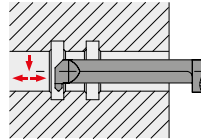
- ▲ Extensive range of right-hand tools
- ▲ K10F – TiN



Grooving (E)



Internal turning (A)



Chamfering (F)



Tool	Designation	Article no.	Hole Ø mm	Hole depth mm	Groove depth mm	Groove width mm	Piece	Fig.
Cutting insert	R 004.0100-16	73 002 541	4	16	0,8	1,0	1	E
Cutting insert	R 005.0150-20	73 002 552	5	20	1,0	1,5	1	E
Cutting insert	R 005.0200-20	73 002 553	5	20	1,0	2,0	1	E
Cutting insert	R 006.0150-22	73 002 562	6	22	1,8	1,5	1	E
Cutting insert	R 006.0200-22	73 002 563	6	22	1,8	2,0	1	E
Cutting insert	R 050.3-16	73 004 530	3	16			1	A
Cutting insert	R 050.4-16	73 004 540	4	16			1	A
Cutting insert	R 050.5-20	73 004 550	5	20			1	A
Cutting insert	R 050.6-22	73 004 560	6	22			1	A
Cutting insert	R 060.5-20	73 006 550	5	20			1	F
Holders	645.0016-D	73 080 164					1	
Holders	676.0016-D	73 080 166					1	
Clamping key	110.645	70 950 175					1	

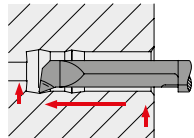
ST

73 085 ...

999

CoreLine – Set: Internal turning – UltraMini

- ▲ Extensive range of right-hand tools
- ▲ K10F – TiN



Tool	Designation	Article no.	Hole Ø mm	Hole depth mm	Piece
Cutting insert	R 050.3-16	73 004 530	3	16	1
Cutting insert	R 050.4-16	73 004 540	4	16	1
Cutting insert	R 050.5-20	73 004 550	5	20	1
Cutting insert	R 050.6-22	73 004 560	6	22	1
Holders	645.0016-D	73 080 164			1
Holders	676.0016-D	73 080 166			1
Clamping key	110.645	70 950 175			1

ST

73 085 ...

994

CoreLine – Set: Holder – UltraMini



Tool	Designation	Article no.	For insert Ø mm	Piece
Holders	645.0016-D	73 080 164	3 / 4 / 5	1
Holders	676.0016-D	73 080 166	6 / 7	1
Clamping key	110.645	70 950 175		1

TO

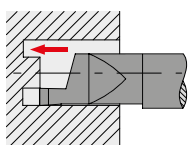
73 085 ...

990

CoreLine – Set: Axial grooving – UltraMini

▲ Extensive range of right-hand tools

▲ K10F – TiN



Tool	Designation	Article no.	Hole Ø mm	Hole depth mm	Groove depth mm	Groove width mm	Piece
Cutting insert	R 010.1008-10	73 050 571	8	10	1,5	1,0	1
Cutting insert	R 010.1508-10	73 050 573	8	10	2,5	1,5	1
Cutting insert	R 010.2008-10	73 050 575	8	10	3,0	2,0	1
Cutting insert	R 010.2508-20	73 050 677	8	20	3,5	2,5	1
Cutting insert	R 010.3008-20	73 050 679	8	20	3,5	3,0	1
Holders	676.0016-D	73 080 166					1
Clamping key	110.645	70 950 175					1

ST

73 085 ...

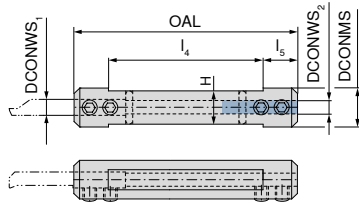
996

CoreLine – Standard tool holder for inserts – UltraMini

- ▲ Double ended
- ▲ Machining diameter from Ø 0.5 mm

Scope of supply:

Tool holder with Allen key



Designation	DCONWS ₁ mm	DCONWS ₂ mm	DCONMS mm	OAL mm	l ₄ mm	l ₅ mm	H mm
645.0012-D	4	5	12.00	75	55	10	10.3
645.0016-D	4	5	16.00	75	55	10	14.0
645.001905-D	4	5	19.05	90	70	10	17.2
645.0020-D	4	5	20.00	90	70	10	18.0
645.0022-D	4	5	22.00	90	70	10	20.0
645.00254-D	4	5	25.40	95	75	10	23.4
676.0016-D	6	7	16.00	75	55	10	14.0
676.001905-D	6	7	19.05	90	70	10	17.2
676.0020-D	6	7	20.00	90	70	10	18.0
676.0022-D	6	7	22.00	90	70	10	20.0
676.00254-D	6	7	25.40	95	75	10	23.4
687.0016-D	7	8	16.00	75	55	10	14.0
687.0020-D	7	8	20.00	90	70	10	18.0

TO

73 080 ...

163

164

170

165

171

172

166

173

167

174

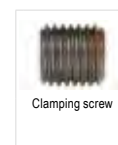
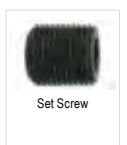
175

168

169

Spare parts for article number

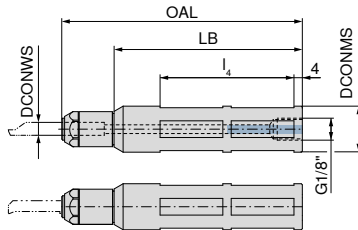
		AS		AS		AS
		70 950 ...		73 082 ...		70 950 ...
73 080 163	SW2,5	175	M5x4	013		
73 080 164	SW2,5	175	M5x6	001		
73 080 170	SW2,5	175	M5x6	001		
73 080 165	SW2,5	175	M5x8	008		
73 080 171	SW2,5	175	M5x8	008		
73 080 172	SW2,5	175	M5x8	008		
73 080 166	SW2,5	175	M5x6	001		
73 080 173	SW2,5	175	M5x6	001		
73 080 167	SW2,5	175	M5x8	008		
73 080 174	SW2,5	175	M5x8	008		
73 080 175	SW2,5	175	M5x8	008		
73 080 168	SW2,5	175			M6x5,5	031
73 080 169	SW2,5	175			M6x5,5	031



CoreLine – Quick change tool holder for inserts – UltraMini

Scope of supply:

Tool holder, lock nut, and clamping wedge



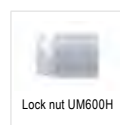
Designation	DCONWS mm	DCONMS _{g6} mm	OAL mm	LB mm	l ₄ mm	TO 73 089 ...
UM600H.0012.4	4	12.00	115	90	64	124
UM600H.0016.4	4	16.00	115	90	64	164
UM600H.001905.4	4	19.05	115	90	64	194
UM600H.0020.4	4	20.00	115	90	64	204
UM600H.0022.4	4	22.00	115	90	64	224
UM600H.0025.4	4	25.00	115	90	64	254
UM600H.00254.4	4	25.40	115	90	64	264
UM600H.0028.4	4	28.00	115	90	64	284
UM600H.0012.5	5	12.00	115	90	64	125
UM600H.0016.5	5	16.00	115	90	64	165
UM600H.001905.5	5	19.05	115	90	64	195
UM600H.0020.5	5	20.00	115	90	64	205
UM600H.0022.5	5	22.00	115	90	64	225
UM600H.0025.5	5	25.00	115	90	64	255
UM600H.00254.5	5	25.40	115	90	64	265
UM600H.0028.5	5	28.00	115	90	64	285
UM600H.0012.6	6	12.00	115	90	64	126
UM600H.0016.6	6	16.00	115	90	64	166
UM600H.001905.6	6	19.05	115	90	64	196
UM600H.0020.6	6	20.00	115	90	64	206
UM600H.0022.6	6	22.00	115	90	64	226
UM600H.0025.6	6	25.00	115	90	64	256
UM600H.00254.6	6	25.40	115	90	64	266
UM600H.0028.6	6	28.00	115	90	64	286
UM600H.0012.7	7	12.00	115	90	64	127
UM600H.0016.7	7	16.00	115	90	64	167
UM600H.001905.7	7	19.05	115	90	64	197
UM600H.0020.7	7	20.00	115	90	64	207
UM600H.0022.7	7	22.00	115	90	64	227
UM600H.0025.7	7	25.00	115	90	64	257
UM600H.00254.7	7	25.40	115	90	64	267
UM600H.0028.7	7	28.00	115	90	64	287



Avoid pulling cuts. Ensure a suitable clamping force is applied when using through coolant supply. Can be tightened using a key.

Spare parts DCONWS

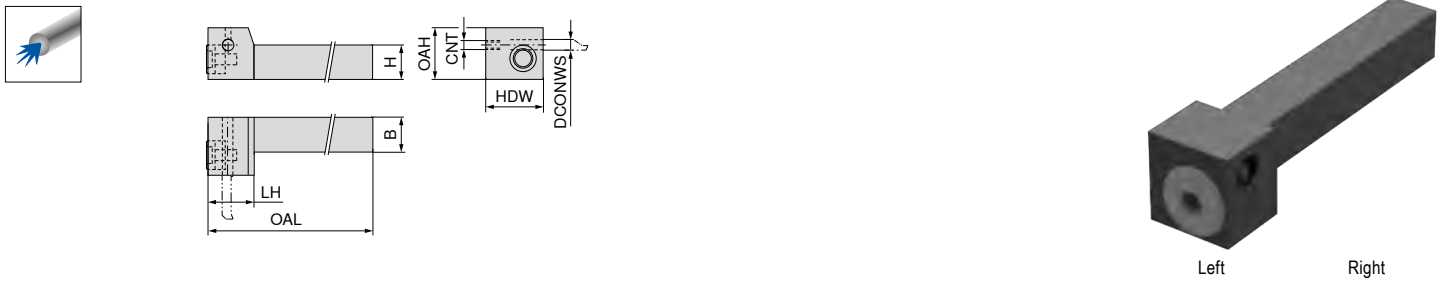
		AS 73 950 ...	AS 73 950 ...
4	M4	104	111
5	M5	105	111
6	M6	106	111
7	M7	107	111



Spare parts		70 950 ...	73 082 ...
DCONWS			
4	SW2,5	175	M5x0,5x6 010
5	SW2,5	175	M5x0,5x6 010
6	SW2,5	175	M5x0,5x6 010
7	SW2,5	175	M5x0,5x6 010
8	SW2,5	175	M5x0,5x6 010

CoreLine – Tool holders for inserts – UltraMini

Scope of supply:
Tool holder with Allen key



Illustrations show right-hand versions

Designation	DCONWS mm	OAL mm	LH mm	B mm	HDW mm	H mm	OAH mm	CNT	TO	
									73 083 ...	73 084 ...
R/L .JK.UHCM.1212.4	4	90	17	12	20	12	18	M5	124	124
R/L .JK.UHCM.1212.5	5	90	17	12	20	12	18	M5	125	125
R/L .JK.UHCM.1212.6	6	90	17	12	20	12	21	M5	126	126
R/L .JK.UHCM.1212.7	7	90	17	12	20	12	21	M5	127	127

 See the indexable insert turning tools section for suitable coolant connections.

Spare parts
DCONWS

4	SW5	050	UM 12	011
5	SW5	050	UM 12	011
6	SW5	050	UM 16	012
7	SW5	050	UM 16	012



Clamping key T

AS

80 397 ...



Clamping screw

AS

73 082 ...

CoreLine – Tool holders for inserts – UltraMini

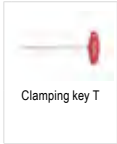
Scope of supply:
Tool holder with Allen key



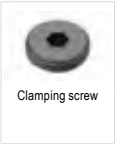
Designation	DCONWS mm	OAL mm	l ₄ mm	B mm	H mm	OAH mm	TO 73 086 ...
UM.1010.4	4	100	75	10	10	20	104
UM.1010.5	5	100	75	10	10	20	105
UM.1212.4	4	100	75	12	12	22	124
UM.1212.5	5	100	75	12	12	22	125
UM.1212.6	6	100	75	12	12	22	126

Spare parts
DCONWS

4	SW5	050	UM 12	011
5	SW5	050	UM 12	011
6	SW5	050	UM 16	012



Clamping key T



Clamping screw

CoreLine – Tool holders for inserts – UltraMini

Scope of supply:
Tool holder with Allen key

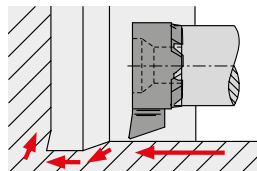
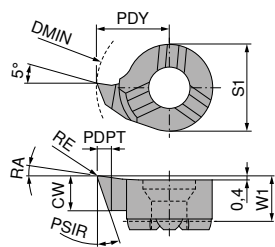


Illustrations show right-hand versions

Designation	DCONWS mm	OAL mm	B mm	HDW mm	H mm	OAH mm	TO 73 091 ...	TO 73 090 ...
R/L UM.18.1010.4	4	99	10	38	10	16	104	104
R/L UM.28.1010.4	4	99	10	48	10	16	204	204
R/L UM.18.1212.4	4	99	12	38	12	18	124	124
R/L UM.28.1212.4	4	99	12	48	12	18	224	224
R/L UM.18.1010.5	5	99	10	38	10	16	105	105
R/L UM.28.1010.5	5	99	10	48	10	16	205	205
R/L UM.18.1212.5	5	99	12	38	12	18	125	125
R/L UM.28.1212.5	5	99	12	48	12	18	225	225
R/L UM.18.1010.6	6	99	10	38	10	16	106	106
R/L UM.28.1010.6	6	99	10	48	10	16	206	206
R/L UM.18.1212.6	6	99	12	38	12	18	126	126
R/L UM.28.1212.6	6	99	12	48	12	18	226	226
R/L UM.18.1010.7	7	99	10	38	10	16	107	107
R/L UM.28.1010.7	7	99	10	48	10	16	207	207
R/L UM.18.1212.7	7	99	12	38	12	18	127	127
R/L UM.28.1212.7	7	99	12	48	12	18	227	227

DCONWS	AS 70 950 ...	AS 73 082 ...
4	SW2,5 175	M5x8 008
5	SW2,5 175	M5x8 008
6	SW2,5 175	M5x8 008
7	SW2,5 175	M5x8 008

CoreLine – Inserts for turning and profiling – MiniCut



Illustrations show right-hand versions

CWX500

CWX500



Size	Designation	DMIN mm	CW mm	W1 mm	PDY mm	S1 mm	RE mm	PDPT mm	PSIR °	RA °	Left	Right
											EH 73 324 ...	EH 73 322 ...
08	8,00. R/L .3,30.18°	7.8	3.3	3.5	4.65	6.0	0.20	0.6	18	8	033	033
	8,00. R/L .3,50.18°	7.8	3.5	3.5	4.65	6.0	0.05	0.6	18	8	035	035
	8,00. R/L .3,50.20°	7.8	3.5	3.5	4.65	6.0	0.20	0.6	20	20	135	135
09	9,00. R/L .3,60.18°	9.0	3.6	3.6	5.50	6.2	0.20	0.8	18	8	136	136
	9,00. R/L .3,60.20°	9.0	3.6	3.6	5.50	6.2	0.20	0.8	20	20	236	236
11	9,80. R/L .3,90.18°	9.8	3.9	4.2	5.50	8.0	0.20	1.0	18	8	139	139
	11,00. R/L .3,90.18°	11.0	3.9	4.2	6.70	8.0	0.20	1.0	18	8	339	339
	11,00. R/L .4,20.20°	11.0	4.2	4.2	6.70	8.0	0.20	1.0	20	20	342	342
14	14,00. R/L .5,00.18°	13.8	5.0	5.1	8.70	9.0	0.20	1.5	18	8	550	550
	14,00. R/L .5,30.20°	14.0	5.3	5.3	8.70	9.0	0.20	1.5	20	20	553	553
16	15,50. R/L .5,00.18°	15.5	5.0	5.4	9.70	11.0	0.20	1.5	18	8	750	750
P											●	●
M											●	●
K											●	●
N											●	●
S											●	●
H											●	●
O											●	●

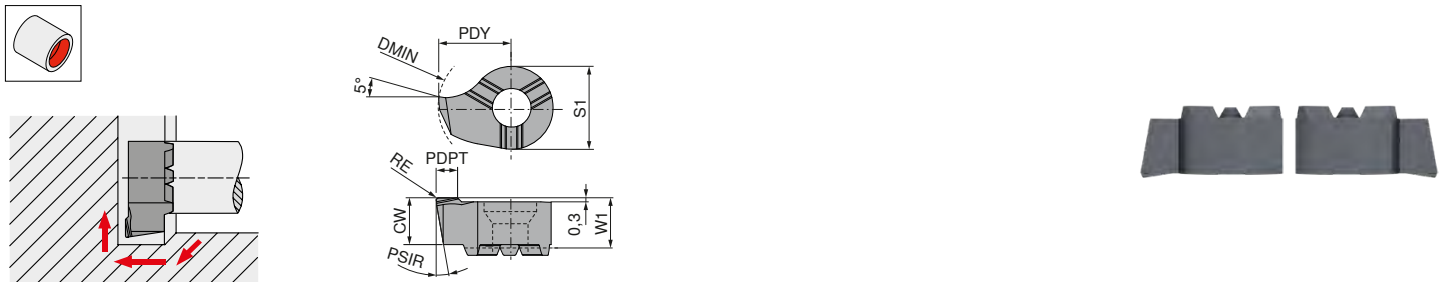


→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Cutting inserts for copy turning – MiniCut

▲ With chip former



Illustrations show right-hand versions

Size	Designation	DMIN mm	CW mm	W1 mm	PDY mm	S1 mm	RE mm	PDPT mm	PSIR °	Left	Right
										EH	EH
08	8,00. R/L .3,40.10°	8	3.4	3.5	4.65	6.0	0.2	0.5	10	73 388 ... 13400	73 386 ... 13400
09	9,00. R/L .3,50.10°	9	3.5	3.6	5.50	6.2	0.2	0.5	10	136	136
11	11,00. R .4,10.10°	11	4.1	4.2	6.70	8.0	0.2	0.5	10	14100	14100
P										●	●
M										●	●
K										●	●
N										●	●
S										●	●
H										●	●
O										●	●

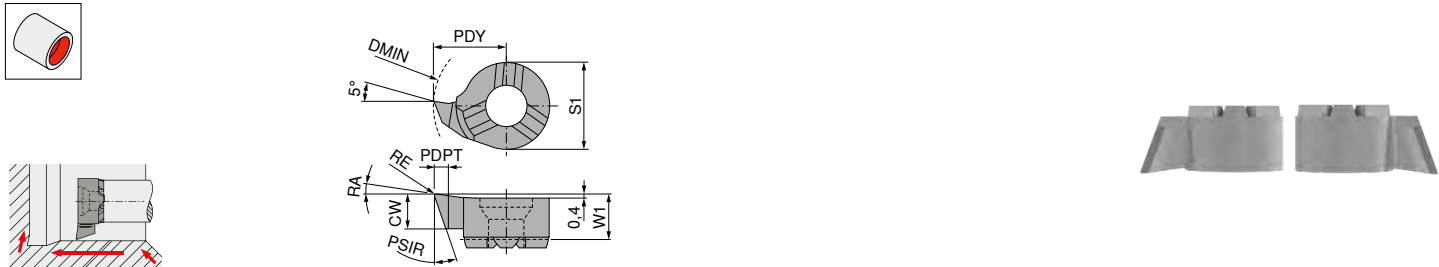


→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – CBN cutting inserts for copy turning – Hard turning – MiniCut

▲ 56 to 65 HRC



Illustrations show right-hand versions

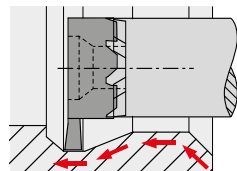
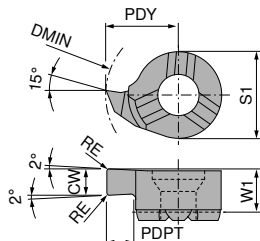
Size	Designation	DMIN mm	CW mm	W1 mm	PDY mm	S1 mm	RE mm	PDPT mm	PSIR °	RA °	Left CBN	Right CBN
											PC	PC
08	8,00. R/L .3,30.18°	7.8	3.3	3.5	4.65	6	0.2	0.39	18	8	73 368 ...	73 366 ...
											033	033
11	11,00. R/L .3,90.18°	11.0	3.9	4.2	6.70	8	0.2	0.55	18	8	139	139
14	14,00. R/L .5,00.18°	13.8	5.0	5.3	8.70	9	0.2	0.69	18	8	550	550
16	16,00. R/L .5,00.18°	15.5	5.0	5.4	9.70	11	0.2	0.77	18	8	750	750
P												
M												
K												
N												
S											○	○
H											●	●
O												

→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for turning – MiniCut

▲ CDX = $a_{p\max}$



Illustrations show right-hand versions

CWX500

CWX500



Size	Designation	DMIN mm	CW mm +0.05	PDPT mm	W1 mm	PDY mm	S1 mm	RE mm	CDX mm	Left	Right
										EH 73 316 ...	EH 73 314 ...
08	8,00. R/L .1,50.1,0	8	1.5	1.0	3.3	4.8	6.0	0.2	0.2	015	015
	8,00. R/L .2,00.1,0	8	2.0	1.0	3.3	4.8	6.0	0.2	0.2	020	020
09	9,00. R/L .1,50.2,0	9	1.5	2.0	3.6	5.5	6.2	0.2	0.2	115	115
	9,00. R/L .1,50.3,0	10	1.5	3.0	3.6	6.5	6.2	0.2	0.2	121	121
	9,00. R/L .2,00.2,0	9	2.0	2.0	3.6	5.5	6.2	0.2	0.2	120	120
	9,00. R/L .2,00.3,0	10	2.0	3.0	3.6	6.5	6.2	0.2	0.2	122	122
11	11,00. R/L .1,50.2,3	11	1.5	2.3	4.2	6.7	8.0	0.2	0.2	315	315
	11,00. R/L .2,00.2,3	11	2.0	2.3	4.2	6.7	8.0	0.2	0.2	320	320
14	14,00. R/L .1,50.4,0	14	1.5	4.0	5.3	9.0	9.0	0.2	0.2	515	515
	14,00. R/L .1,50.5,5	16	1.5	5.5	5.2	10.5	9.0	0.2	0.2	516	516
	14,00. R/L .1,50.6,5	17	1.5	6.5	5.2	11.5	9.0	0.2	0.2	517	517
	14,00. R/L .2,00.4,0	14	2.0	4.0	5.3	9.0	9.0	0.2	0.2	520	520
	14,00. R/L .2,00.5,5	16	2.0	5.5	5.2	10.5	9.0	0.2	0.2	521	521
	14,00. R/L .2,00.6,5	17	2.0	6.5	5.2	11.5	9.0	0.2	0.2	522	522
	14,00. R/L .2,50.5,5	16	2.5	5.5	5.2	10.5	9.0	0.2	0.2	525	525
	14,00. R/L .2,50.6,5	17	2.5	6.5	5.2	11.5	9.0	0.2	0.2	526	526
	14,00. R/L .3,00.5,5	16	3.0	5.5	5.2	10.5	9.0	0.2	0.2	530	530
	14,00. R/L .3,00.6,5	17	3.0	6.5	5.2	11.5	9.0	0.2	0.2	531	531
16	16,00. R/L .2,00.4,3	16	2.0	4.3	5.4	10.2	11.0	0.2	0.2	720	720
P										●	●
M										●	●
K										●	●
N										●	●
S										●	●
H										●	●
O										●	●

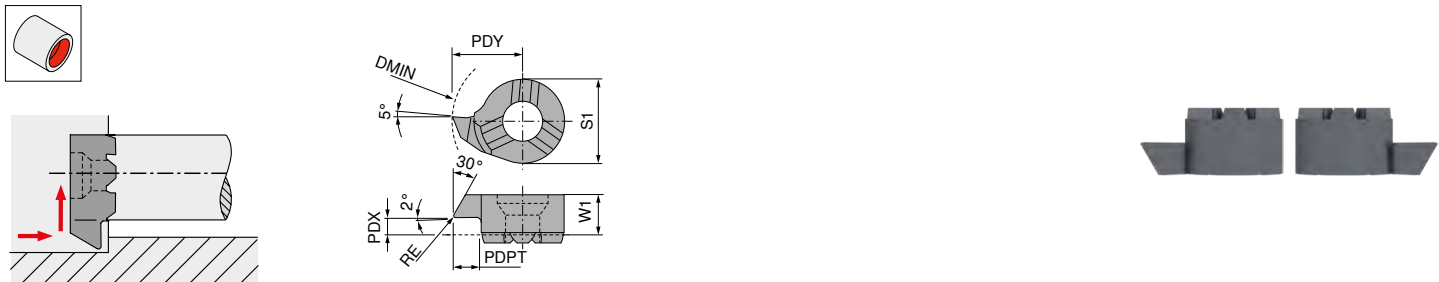


→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Cutting inserts for back boring – MiniCut

▲ CDX = ap_{max}



Illustrations show right-hand versions

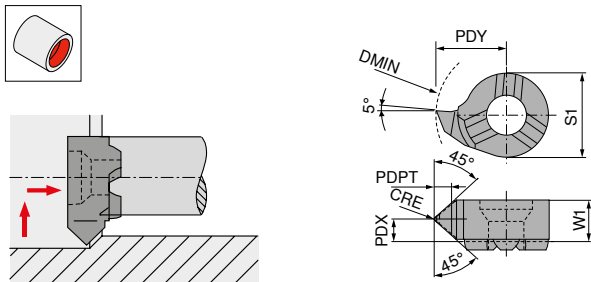
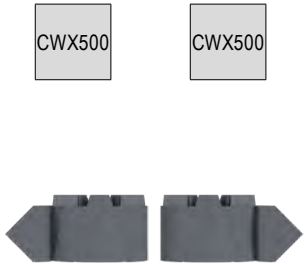
Size	Designation	DMIN mm	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm	RE mm	CDX mm	Left	Right
										EH	EH
08	8,00. R/L .30°.1,3	7.8	1.3	3.50	1.0	4.65	6.0	0.2	0.6	73 332 ...	73 330 ...
										013	013
09	9,00. R/L .30°.1,7	9.0	1.7	3.55	1.2	5.50	6.2	0.2	0.8	117	117
	9,00. R/L .30°.2,3	10.0	2.3	3.55	1.2	6.50	6.2	0.2	0.8	123	123
11	11,00. R/L .30°.2,3	11.0	2.3	4.30	1.6	6.70	8.0	0.2	1.0	323	323
14	14,00. R/L .30°.3,5	13.8	3.5	5.40	2.4	8.70	9.0	0.2	1.5	535	535
P										●	●
M										●	●
K										●	●
N										●	●
S										●	●
H										●	●
O										●	●

→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Inserts for turning and chamfering – MiniCut

▲ CDX = a_{pmax}



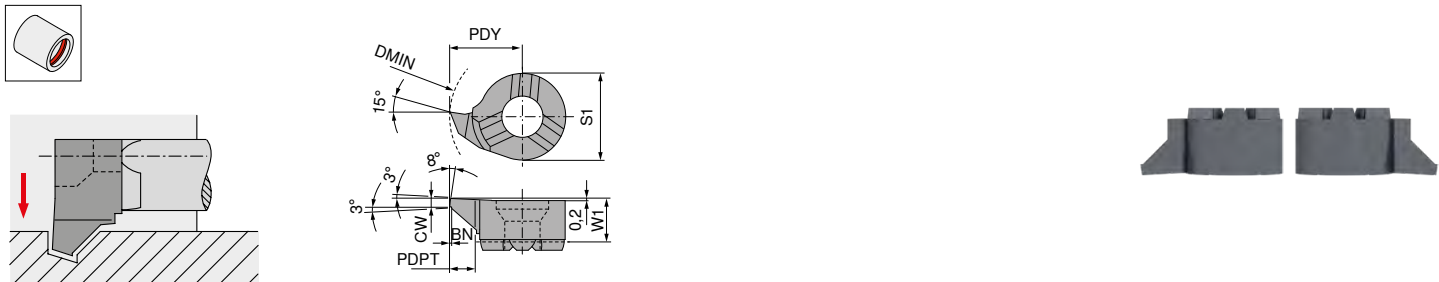
Illustrations show right-hand versions

Size	Designation	DMIN mm	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm	CRE mm	CDX mm	Left	Right
										EH	EH
08	8,00. R/L .45°.1,4	8	1.4	3.50	1.8	4.8	6.0	0.2	0.6	73 336 ...	73 334 ...
										010	010
09	9,00. R/L .45°.1,3	9	1.3	3.55	1.8	5.5	6.2	0.2	0.8	110	110
11	11,00. R/L .45°.1,5	11	1.5	4.30	2.2	6.7	8.0	0.2	1.0	310	310
14	14,00. R/L .45°.1,5	14	1.5	5.40	2.8	9.0	9.0	0.2	1.2	510	510
P										●	●
M										●	●
K										●	●
N										●	●
S										●	●
H										●	●
O										●	●

 → Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Cutting inserts for pre-parting and chamfering – MiniCut



Illustrations show right-hand versions

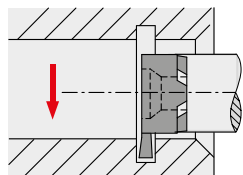
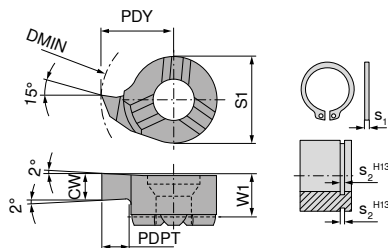
Size	Designation	DMIN mm	CW mm	PDPT mm	W1 mm	PDY mm	S1 mm	BN mm	Left	Right
									EH	EH
08	8,00. R/L .1,00.45°	8	1	1.0	3.3	4.8	6.0	0.2	73 340 ...	73 338 ...
									100	100
09	9,00. R/L .1,00.45°	9	1	1.5	3.6	5.5	6.2	0.2	215	215
									315	315
11	11,00. R/L .1,00.45°	11	1	1.5	4.2	6.7	8.0	0.2	515	515
									715	715
14	14,00. R/L .1,00.45°	14	1	1.5	5.3	9.0	9.0	0.2		
16	16,00. R/L .1,00.45°	16	1	1.5	5.4	10.2	11.0	0.2		
P									•	•
M									•	•
K									•	•
N									•	•
S									•	•
H									•	•
O									•	•



→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Cutting inserts for grooving – MiniCut



Illustrations show right-hand versions

CWX500

CWX500



Size	Designation	DMIN mm	CW mm	PDPT mm	W1 mm	s ₁ mm	s ₂ H13 mm	PDY mm	S1 mm
08	8,00. R/L .0,73.1,0	8	0.73	1.0	3.3	0.6	0.7	4.8	6.0
	8,00. R/L .0,83.1,0	8	0.83	1.0	3.3	0.7	0.8	4.8	6.0
	8,00. R/L .0,93.1,0	8	0.93	1.0	3.3	0.8	0.9	4.8	6.0
	8,00. R/L .1,00.1,0	8	1.00	1.0	3.3			4.8	6.0
	8,00. R/L .1,20.1,0	8	1.20	1.0	3.3	1.0	1.1	4.8	6.0
	8,00. R/L .1,40.1,0	8	1.40	1.0	3.3	1.2	1.3	4.8	6.0
	8,00. R/L .1,50.1,0	8	1.50	1.0	3.3			4.8	6.0
	8,00. R/L .1,70.1,0	8	1.70	1.0	3.3	1.5	1.6	4.8	6.0
	8,00. R/L .2,00.1,0	8	2.00	1.0	3.3			4.8	6.0
09	9,00. R/L .0,73.1,2	9	0.73	1.2	3.6	0.6	0.7	5.5	6.2
	9,00. R/L .0,83.1,3	9	0.83	1.3	3.6	0.7	0.8	5.5	6.2
	9,00. R/L .0,93.1,5	9	0.93	1.5	3.6	0.8	0.9	5.5	6.2
	9,00. R/L .1,00.1,8	9	1.00	1.8	3.6			5.5	6.2
	9,00. R/L .1,20.1,8	9	1.20	1.8	3.6	1.0	1.1	5.5	6.2
	9,00. R/L .1,40.1,8	9	1.40	1.8	3.6	1.2	1.3	5.5	6.2
	9,00. R/L .1,50.1,8	9	1.50	1.8	3.6			5.5	6.2
	9,00. R/L .1,70.1,8	9	1.70	1.8	3.6	1.5	1.6	5.5	6.2
	9,00. R/L .2,00.1,8	9	2.00	1.8	3.6			5.5	6.2
	9,00. R/L .2,50.1,8	9	2.50	1.8	3.6			5.5	6.2
11	11,00. R/L .0,73.1,2	11	0.73	1.2	4.2	0.6	0.7	6.7	8.0
	11,00. R/L .0,83.1,3	11	0.83	1.3	4.2	0.7	0.8	6.7	8.0
	11,00. R .0,93.1,5	11	0.93	1.5	4.2	0.9	0.9	6.7	8.0
	11,00. L .0,93.1,5	11	0.93	1.5	4.2	0.8	0.9	6.7	8.0
	11,00. R/L .1,00.2,3	11	1.00	2.3	4.2			6.7	8.0
	11,00. R/L .1,20.2,3	11	1.20	2.3	4.2	1.0	1.1	6.7	8.0
	11,00. R/L .1,40.2,3	11	1.40	2.3	4.2	1.2	1.3	6.7	8.0
	11,00. R/L .1,50.2,3	11	1.50	2.3	4.2			6.7	8.0
	11,00. R/L .1,70.2,3	11	1.70	2.3	4.2	1.5	1.6	6.7	8.0
	11,00. R/L .2,00.2,3	11	2.00	2.3	4.2			6.7	8.0
	11,00. R/L .2,50.2,3	11	2.50	2.3	4.2			6.7	8.0
	11,00. R/L .3,00.2,3	11	3.00	2.3	4.2			6.7	8.0

Left

Right

EH

EH

73 312 ...

73 310 ...

073

073

083

083

093

093

110

110

112

112

114

114

115

115

117

117

120

120

173

173

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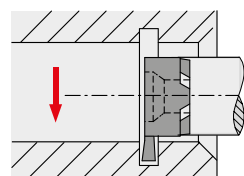
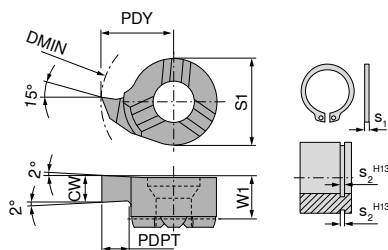
330

P	•	•
M	•	•
K	•	•
N	•	•
S	•	•
H	•	•
O	•	•



→ Find the cutting data standard values here.

CoreLine – Cutting inserts for grooving – MiniCut



Illustrations show right-hand versions

CWX500

CWX500



Size	Designation	DMIN mm	CW mm	PDPT mm	W1 mm	s ₁ mm	s ₂ H13 mm	PDY mm	S1 mm	Left	Right
										EH 73 312 ...	EH 73 310 ...
14	14,00. R/L .0,73.1,2	14	0.73	1.2	5.3	0.6	0.7	9.0	9.0	573	573
	14,00. R/L .0,83.1,3	14	0.83	1.3	5.3	0.7	0.8	9.0	9.0	583	583
	14,00. R/L .0,93.1,5	14	0.93	1.5	5.3	0.8	0.9	9.0	9.0	593	593
	14,00. R/L .1,20.4,0	14	1.20	4.0	5.3	1.0	1.1	9.0	9.0	512	512
	14,00. R/L .1,40.4,0	14	1.40	4.0	5.3	1.2	1.3	9.0	9.0	514	514
	14,00. R/L .1,50.4,0	14	1.50	4.0	5.3			9.0	9.0	515	515
	14,00. R/L .1,70.4,0	14	1.70	4.0	5.3	1.5	1.6	9.0	9.0	517	517
	14,00. R/L .2,00.4,0	14	2.00	4.0	5.3			9.0	9.0	520	520
	14,00. R/L .2,50.4,0	14	2.50	4.0	5.3			9.0	9.0	525	525
	14,00. R/L .3,00.4,0	14	3.00	4.0	5.3			9.0	9.0	530	530
16	16,00. R/L .0,73.1,2	16	0.73	1.2	5.4	0.6	0.7	10.2	11.0	773	773
	16,00. R/L .0,83.1,3	16	0.83	1.3	5.4	0.7	0.8	10.2	11.0	783	783
	16,00. R/L .0,93.1,5	16	0.93	1.5	5.4	0.8	0.9	10.2	11.0	793	793
	16,00. R/L .1,20.4,3	16	1.20	4.3	5.4	1.0	1.1	10.2	11.0	712	712
	16,00. R/L .1,40.4,3	16	1.40	4.3	5.4	1.2	1.3	10.2	11.0	714	714
	16,00. R/L .1,50.4,3	16	1.50	4.3	5.4			10.2	11.0	715	715
	16,00. R/L .1,70.4,3	16	1.70	4.3	5.4	1.5	1.6	10.2	11.0	717	717
	16,00. R/L .2,00.4,3	16	2.00	4.3	5.4			10.2	11.0	720	720
	16,00. R/L .2,50.4,3	16	2.50	4.3	5.4			10.2	11.0	725	725
	16,00. R/L .3,00.4,3	16	3.00	4.3	5.4			10.2	11.0	730	730
	16,00. R/L .3,50.4,3	16	3.50	4.3	5.4			10.2	11.0	735	735
	16,00. R/L .4,00.4,3	16	4.00	4.3	5.4			10.2	11.0	740	740
P										●	●
M										●	●
K										●	●
N										●	●
S										●	●
H										●	●
O										●	●

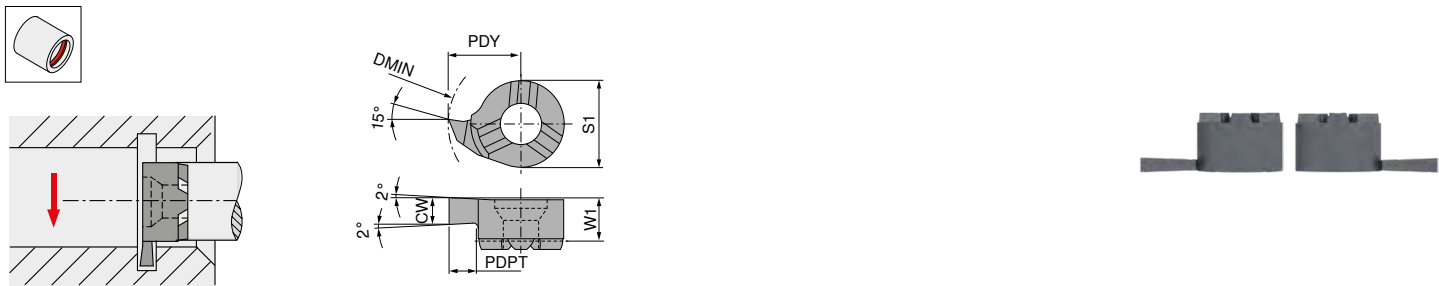


→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Cutting inserts for grooving – MiniCut

▲ Large groove depth (T_{max.} 5.5 mm)



Illustrations show right-hand versions

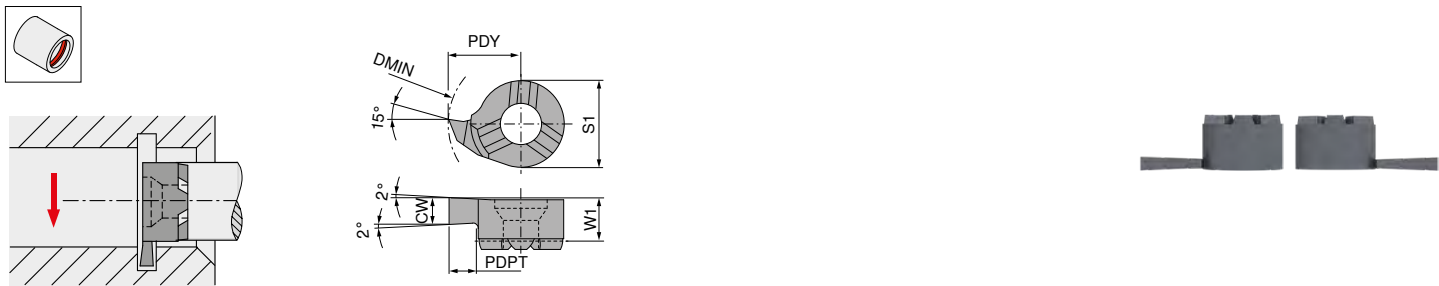
Size	Designation	DMIN mm	CW _{+0,03} mm	PDPT mm	W1 mm	PDY mm	S1 mm	Left	Right
								EH 73 372 ...	EH 73 370 ...
14	14,00. R/L .1,50.5,5	16	1.5	5.5	5.2	10.5	9	715	715
	14,00. R/L .2,00.5,5	16	2.0	5.5	5.2	10.5	9	720	720
	14,00. R/L .2,50.5,5	16	2.5	5.5	5.2	10.5	9	725	725
	14,00. R/L .3,00.5,5	16	3.0	5.5	5.2	10.5	9	730	730
P								●	●
M								●	●
K								●	●
N								●	●
S								●	●
H								●	●
O								●	●

 → Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Cutting inserts for grooving – MiniCut

▲ Large groove depth (T_{max} 6.5 mm)



Illustrations show right-hand versions

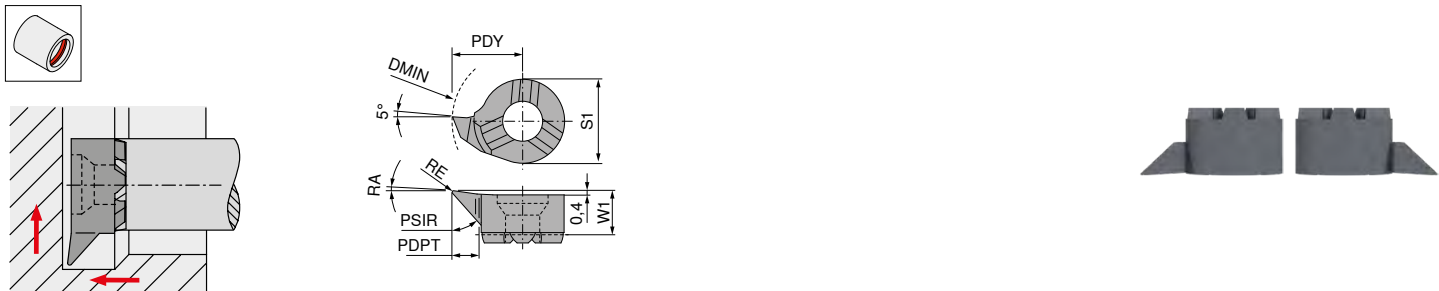
Size	Designation	DMIN mm	CW +0,03 mm	PDPT mm	W1 mm	PDY mm	S1 mm	Left	Right
								EH 73 384 ...	EH 73 382 ...
14	14,00. R/L .1,50.6,5	17	1.5	6.5	5.2	11.5	9	515	515
	14,00. R/L .2,00.6,5	17	2.0	6.5	5.2	11.5	9	520	520
	14,00. R/L .2,50.6,5	17	2.5	6.5	5.2	11.5	9	525	525
	14,00. R/L .3,00.6,5	17	3.0	6.5	5.2	11.5	9	530	530
P								●	●
M								●	●
K								●	●
N								●	●
S								●	●
H								●	●
O								●	●

 → Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Cutting inserts for internal undercuts – MiniCut

▲ CDX = ap_{max}



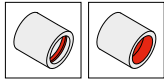
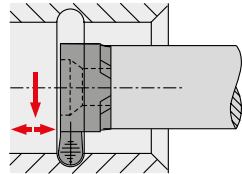
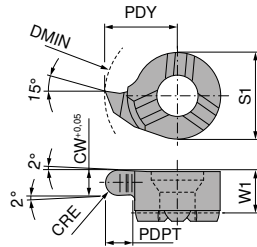
Illustrations show right-hand versions

Size	Designation	DMIN mm	PDPT mm	W1 mm	PDY mm	S1 mm	RE mm	CDX mm	PSIR °	RA °	Left	Right
											EH	EH
08	8,00. R/L .30°1,0	7.8	1.0	3.5	4.65	6.0	0.2	0.4	30	3	73 328 ...	73 326 ...
	8,00. R/L .47°1,2	7.8	1.2	3.5	4.65	6.0	0.2	0.4	47	3	010 012	010 012
09	9,00. R/L .47°1,5	9.0	1.5	3.6	5.50	6.2	0.2	0.5	47	3	115	115
11	11,00. R/L .30°2,3	11.0	2.3	4.2	6.70	8.0	0.2	0.6	30	3	423	423
	11,00. R/L .47°2,3	11.0	2.3	4.2	6.70	8.0	0.2	0.6	47	3	323	323
14	13,70. R/L .47°3,0	13.7	3.0	5.3	8.70	9.0	0.2	0.8	47	3	530	530
	13,70. R/L .30°4,0	13.7	4.0	5.3	8.70	9.0	0.2	0.8	30	3	540	540
16	15,80. R/L .30°4,3	15.8	4.3	5.4	10.20	11.0	0.2	1.0	30	3	744	744
P											●	●
M											●	●
K											●	●
N											●	●
S											●	●
H											●	●
O											●	●

→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Full-radius cutting inserts for groove and profile turning – MiniCut



Illustrations show right-hand versions

CWX500

CWX500



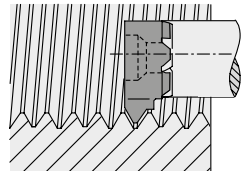
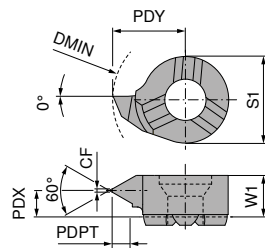
Size	Designation	DMIN mm	CW mm	PDPT mm	W1 mm	PDY mm	S1 mm	CRE mm	Left	Right
									EH 73 320 ...	EH 73 318 ...
08	8,00. R/L .0,80.1,0	8	0.8	1.0	3.3	4.8	6.0	0.4	008	008
	8,00. R/L .1,20.1,0	8	1.2	1.0	3.3	4.8	6.0	0.6	012	012
	8,00. R/L .1,80.1,0	8	1.8	1.0	3.3	4.8	6.0	0.9	018	018
	8,00. R/L .2,00.1,0	8	2.0	1.0	3.3	4.8	6.0	1.0	020	020
09	9,00. R/L .0,80.1,6	9	0.8	1.6	3.6	5.5	6.2	0.4	108	108
	9,00. R/L .1,20.1,6	9	1.2	1.6	3.6	5.5	6.2	0.6	112	112
	9,00. R/L .1,80.1,6	9	1.8	1.6	3.6	5.5	6.2	0.9	118	118
	9,00. R/L .2,00.1,6	9	2.0	1.6	3.6	5.5	6.2	1.0	120	120
11	11,00. R/L .0,80.2,3	11	0.8	2.3	4.2	6.7	8.0	0.4	308	308
	11,00. R/L .1,20.2,3	11	1.2	2.3	4.2	6.7	8.0	0.6	312	312
	11,00. R/L .1,60.2,3	11	1.6	2.3	4.2	6.7	8.0	0.8	316	316
	11,00. R/L .1,80.2,3	11	1.8	2.3	4.2	6.7	8.0	0.9	318	318
	11,00. R/L .2,00.2,3	11	2.0	2.3	4.2	6.7	8.0	1.0	320	320
	11,00. R/L .2,40.2,3	11	2.4	2.3	4.2	6.7	8.0	1.2	324	324
	11,00. R/L .3,00.2,3	11	3.0	2.3	4.2	6.7	8.0	1.5	330	330
14	14,00. R/L .0,80.4,0	14	0.8	4.0	5.3	9.0	9.0	0.4	508	508
	14,00. R/L .1,20.4,0	14	1.2	4.0	5.3	9.0	9.0	0.6	512	512
	14,00. R/L .1,80.4,0	14	1.8	4.0	5.3	9.0	9.0	0.9	518	518
	14,00. R/L .2,00.4,0	14	2.0	4.0	5.3	9.0	9.0	1.0	520	520
	14,00. R/L .2,20.4,0	14	2.2	4.0	5.3	9.0	9.0	1.1	522	522
	14,00. R/L .3,00.4,0	14	3.0	4.0	5.3	9.0	9.0	1.5	530	530
16	16,00. R/L .1,60.4,3	16	1.6	4.3	5.4	10.2	11.0	0.8	716	716
	16,00. R/L .1,80.4,3	16	1.8	4.3	5.4	10.2	11.0	0.9	718	718
	16,00. R/L .2,00.4,3	16	2.0	4.3	5.4	10.2	11.0	1.0	720	720
	16,00. R/L .2,20.4,3	16	2.2	4.3	5.4	10.2	11.0	1.1	722	722
	16,00. R/L .2,40.4,3	16	2.4	4.3	5.4	10.2	11.0	1.2	724	724
	16,00. R/L .3,00.4,3	16	3.0	4.3	5.4	10.2	11.0	1.5	730	730
	16,00. R/L .3,20.4,3	16	3.2	4.3	5.4	10.2	11.0	1.6	732	732
	16,00. R/L .4,00.4,3	16	4.0	4.3	5.4	10.2	11.0	2.0	740	740
P									●	●
M									●	●
K									●	●
N									●	●
S									●	●
H									●	●
O									●	●



→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Cutting inserts for thread turning (partial profile) – MiniCut



Illustrations show right-hand versions

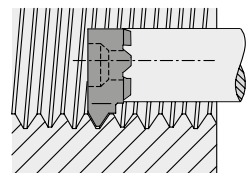
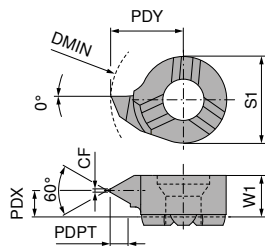
Size	Designation	DMIN mm	TP mm	CF mm	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm	Left	Right
										EH 73 344 ...	EH 73 342 ...
08	8,00. R/L .0,5/0,75.60°	8	0,5 - 0,75	0.06	0.43	3.50	2.7	4.8	6.0	012	012
	8,00. R/L .1,0/1,25.60°	8	1,0 - 1,25	0.12	0.70	3.50	2.7	4.8	6.0	014	014
	8,00. R/L .1,5/1,75.60°	8	1,5 - 1,75	0.18	0.95	3.50	2.5	4.8	6.0	010	010
09	9,00. R/L .0,5/0,75.60°	9	0,5 - 0,75	0.06	0.27	3.55	3.2	5.5	6.2	112	112
	9,00. R/L .1,0/1,25.60°	9	1,0 - 1,25	0.12	0.54	3.55	3.0	5.5	6.2	114	114
	9,00. R/L .1,5/1,75.60°	9	1,5 - 1,75	0.18	0.81	3.55	2.8	5.5	6.2	116	116
	9,00. R/L .1,75/2,0.60°	9	1,75 - 2,0	0.20	0.95	3.55	2.6	5.5	6.2	118	118
	9,00. R/L .2,0/2,5.60°	9	2,0 - 2,5	0.25	1.08	3.55	2.5	5.5	6.2	120	120
	9,00. R/L .2,5/3,0.60°	9	2,5 - 3,0	0.31	1.35	3.55	2.1	5.5	6.2	122	122
	9,00. R/L .3,0/3,5.60°	9	3,0 - 3,5	0.37	1.62	3.55	1.9	5.5	6.2	124	124
11	11,00. R/L .0,5/0,75.60°	11	0,5 - 0,75	0.06	0.75	4.30	3.5	6.7	8.0	312	312
	11,00. R/L .1,0/1,25.60°	11	1,0 - 1,25	0.12	0.55	4.30	3.5	6.7	8.0	314	314
	11,00. R/L .1,5/1,75.60°	11	1,5 - 1,75	0.18	0.81	4.30	3.5	6.7	8.0	316	316
	11,00. R/L .2,0/2,5.60°	11	2,0 - 2,5	0.25	1.08	4.30	3.0	6.7	8.0	310	310
	11,00. R/L .2,5/3,0.60°	11	2,5 - 3,0	0.31	1.35	4.30	3.0	6.7	8.0	320	320
14	14,00. R/L .1,0/1,25.60°	14	1,0 - 1,25	0.12	0.55	5.40	4.7	9.0	9.0	512	512
	14,00. R/L .1,5/1,75.60°	14	1,5 - 1,75	0.18	0.81	5.40	4.5	9.0	9.0	514	514
	14,00. R/L .2,0/2,5.60°	14	2,0 - 2,5	0.25	1.08	5.40	4.2	9.0	9.0	510	510
	14,00. R/L .2,5/3,0.60°	14	2,5 - 3,0	0.31	1.35	5.40	4.7	9.0	9.0	520	520
16	16,00. R/L .1,0/1,25.60°	16	1,0 - 1,25	0.12	0.55	5.50	4.7	10.2	11.0	712	712
	16,00. R/L .1,5/1,75.60°	16	1,5 - 1,75	0.18	0.81	5.50	4.5	10.2	11.0	714	714
	16,00. R/L .2,0/2,5.60°	16	2,0 - 2,5	0.25	1.08	5.50	4.2	10.2	11.0	716	716
	16,00. R/L .2,5/3,0.60°	16	2,5 - 3,0	0.31	1.35	5.50	4.2	10.2	11.0	710	710
P										●	●
M										●	●
K										●	●
N										●	●
S										●	●
H										●	●
O										●	●



→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Cutting inserts for thread turning (full profile) – MiniCut



CWX500

CWX500



Illustrations show right-hand versions

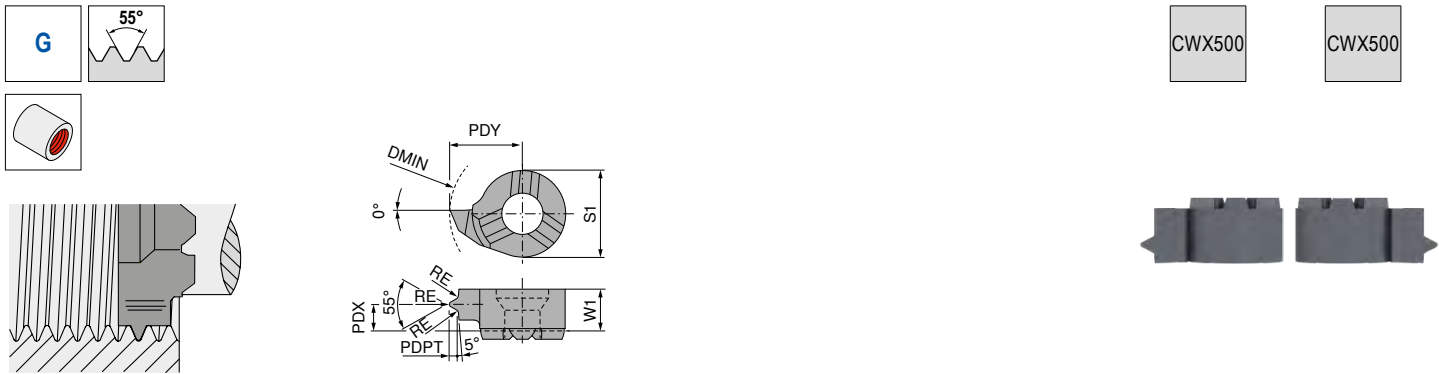
Size	Designation	DMIN mm	TP mm	CF mm	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm	Left	Right
										EH 73 348 ...	EH 73 346 ...
09	9,00. R/L .0,5.60°	9	0.50	0.06	0.27	3.55	3.25	5.5	6.2	405	405
	9,00. R/L .1,0.60°	9	1.00	0.12	0.54	3.55	3.00	5.5	6.2	410	410
	9,00. R/L .1,5.60°	9	1.50	0.18	0.81	3.55	2.80	5.5	6.2	415	415
	9,00. R/L .1,75.60°	9	1.75	0.20	0.95	3.55	2.70	5.5	6.2	418	418
	9,00. R/L .2,0.60°	9	2.00	0.25	1.08	3.55	2.60	5.5	6.2	420	420
	9,00. R/L .2,5.60°	9	2.50	0.31	1.35	3.55	2.50	5.5	6.2	425	425
	9,00. R/L .3,0.60°	9	3.00	0.37	1.62	3.55	2.20	5.5	6.2	430	430
11	11,00. R/L .1,0.60°	11	1.00	0.12	0.54	4.30	3.50	6.7	8.0	314	314
	11,00. R/L .1,5.60°	11	1.50	0.18	0.81	4.30	3.50	6.7	8.0	316	316
	11,00. R/L .2,0.60°	11	2.00	0.25	1.08	4.30	3.20	6.7	8.0	310	310
	11,00. R/L .2,5.60°	11	2.50	0.31	1.35	4.30	3.00	6.7	8.0	320	320
	11,00. R/L .3,0.60°	11	3.00	0.37	1.62	4.30	2.90	6.7	8.0	330	330
14	14,00. R/L .0,5.60°	14	0.50	0.06	0.27	5.40	3.50	9.0	9.0	510	510
	14,00. R/L .1,0.60°	14	1.00	0.12	0.54	5.40	3.50	9.0	9.0	512	512
	14,00. R/L .1,5.60°	14	1.50	0.18	0.81	5.40	3.30	9.0	9.0	514	514
	14,00. R/L .2,0.60°	14	2.00	0.25	1.08	5.40	4.20	9.0	9.0	610	610
	14,00. R/L .2,5.60°	14	2.50	0.31	1.35	5.40	4.70	9.0	9.0	520	520
16	16,00. R/L .1,0.60°	16	1.00	0.12	0.54	5.50	4.70	10.2	11.0	712	712
	16,00. R/L .1,5.60°	16	1.50	0.18	0.81	5.50	4.50	10.2	11.0	714	714
	16,00. R/L .2,0.60°	16	2.00	0.25	1.08	5.50	4.20	10.2	11.0	716	716
	16,00. R/L .2,5.60°	16	2.50	0.31	1.35	5.50	4.20	10.2	11.0	710	710
	16,00. R/L .3,0.60°	16	3.00	0.37	1.62	5.50	4.00	10.2	11.0	720	720
	16,00. R/L .3,5.60°	16	3.50	0.43	1.89	5.50	3.80	10.2	11.0	730	730
	16,00. R/L .4,0.60°	16	4.00	0.50	2.16	5.50	3.60	10.2	11.0	740	740
P										●	●
M										●	●
K										●	●
N										●	●
S										●	●
H										●	●
O										●	●



→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Cutting inserts for thread turning (full profile) – MiniCut



Illustrations show right-hand versions

Size	Designation	DMIN mm	TP mm	TPI 1/"	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm	RE mm	Left	Right
											EH	EH
11	11,00. R/L .1,814.55°	11	1.814	14	1.16	4.30	3.0	6.7	8	0.24	73 352 ...	73 350 ...
	11,00. R/L .1,337.55°	11	1.337	19	0.85	4.30	2.7	6.7	8	0.18	306	306
											304	304
14	14,00. R/L .1,814.55°	14	1.814	14	1.16	5.35	3.6	9.0	9	0.24	506	506
	14,00. R/L .1,337.55°	14	1.337	19	0.85	5.35	3.8	9.0	9	0.18	504	504
16	16,00. R/L .2,309.55°	16	2.309	11	1.48	5.50	3.5	10.2	11	0.31	708	708
	16,00. R/L .1,814.55°	16	1.814	14	1.16	5.50	3.9	10.2	11	0.24	706	706
P											●	●
M											●	●
K											●	●
N											●	●
S											●	●
H											●	●
O											●	●

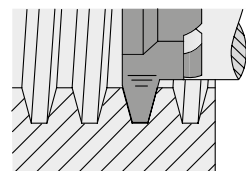
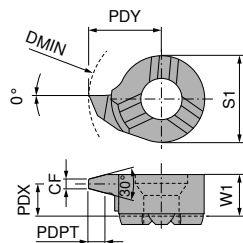


→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Cutting inserts for thread turning (partial profile) – MiniCut

▲ Trapezoidal thread DIN 103



Illustrations show right-hand versions

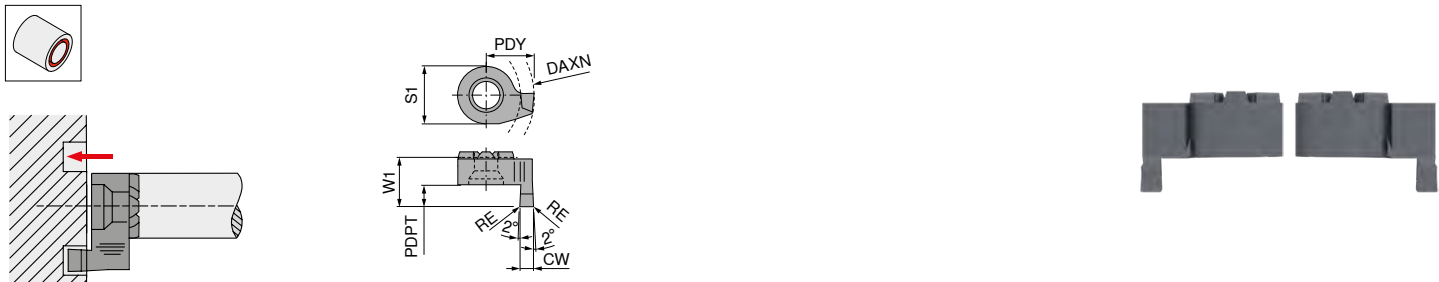
Size	Designation	DMIN mm	TP mm	CF mm	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm	Left	Right
										EH 73 356 ...	EH 73 354 ...
09	9,00. R/L .1,5.30°	9	1.5	0.47	0.90	3.55	3.00	5.5	6.2	415	415
	9,00. R/L .2,0.30°	9	2.0	0.60	1.25	3.55	2.85	5.5	6.2	420	420
	9,00. R/L .3,0.30°	9	3.0	0.96	1.75	3.55	2.25	5.5	6.2	430	430
	9,00. R/L .4,0.30°	10	4.0	1.33	2.25	3.55	2.25	5.5	6.2	440	440
11	11,00. R/L .1,5.30°	11	1.5	0.47	0.90	4.30	3.70	6.7	8.0	315	315
	11,00. R/L .2,0.30°	11	2.0	0.60	1.25	4.30	3.50	6.7	8.0	320	320
	11,00. R/L .3,0.30°	11	3.0	0.96	1.75	4.30	3.20	6.7	8.0	330	330
	11,00. R/L .4,0.30°	11	4.0	1.33	2.25	3.95	2.60	6.7	8.0	340	340
14	14,00. R/L .2,0.30°	14	2.0	0.60	1.25	5.30	4.30	9.0	9.0	520	520
	14,00. R/L .3,0.30°	14	3.0	0.96	1.75	5.30	4.00	9.0	9.0	530	530
	14,00. R/L .4,0.30°	14	4.0	1.33	2.25	5.30	3.60	9.0	9.0	540	540
	14,00. R/L .5,0.30°	14	5.0	1.69	2.75	5.30	3.30	9.0	9.0	550	550
16	16,00. R/L .2,0.30°	16	2.0	0.60	1.25	5.50	4.50	9.7	11.0	720	720
	16,00. R/L .3,0.30°	16	3.0	0.96	1.75	5.50	4.30	9.7	11.0	730	730
	16,00. R/L .4,0.30°	16	4.0	1.33	2.25	5.50	4.00	9.7	11.0	740	740
	16,00. R/L .5,0.30°	16	5.0	1.69	2.75	5.50	3.55	9.7	11.0	750	750
	16,00. R/L .6,0.30°	16	6.0	1.92	3.50	5.50	3.30	10.2	11.0	760	760
P										●	●
M										●	●
K										●	●
N										●	●
S										●	●
H										●	●
O										●	●



→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Axial grooving inserts – MiniCut



Illustrations show right-hand versions

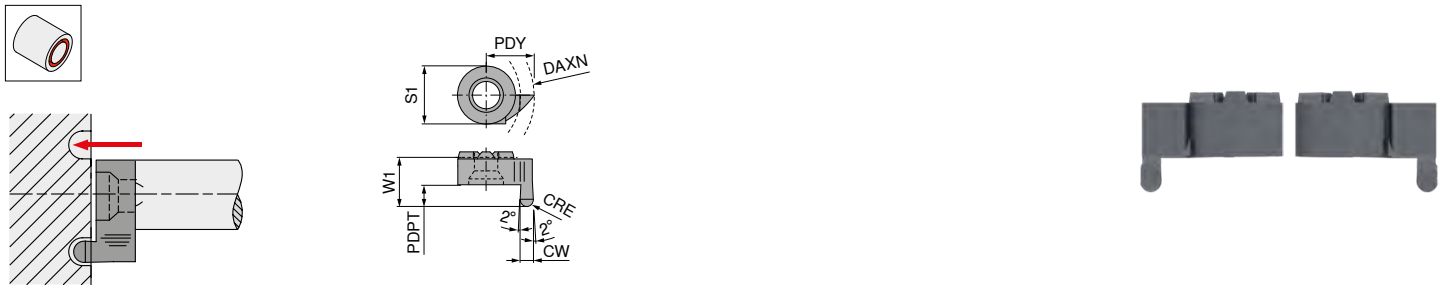
Size	Designation	DAXN mm	CW mm	PDPT mm	W1 mm	PDY mm	RE mm	S1 mm	Left		Right	
									EH	EH	EH	EH
14	14,00. R/L .1,0,1,5	14	1.0	1.5	8.3	9		9	73 364 ...		73 362 ...	
	14,00. R/L .1,5,2,5	14	1.5	2.5	8.3	9	0.2	9	510		510	
	14,00. R/L .2,0,3,0	14	2.0	3.0	8.3	9	0.2	9	515		515	
	14,00. R/L .2,0,5,0	14	2.0	5.0	10.3	9	0.2	9	520		520	
	14,00. R/L .2,5,3,0	14	2.5	3.0	8.3	9	0.2	9	620		620	
	14,00. R/L .2,5,3,0	14	2.5	3.0	8.3	9	0.2	9	525		525	
	14,00. R/L .2,5,5,0	14	2.5	5.0	10.3	9	0.2	9	625		625	
	14,00. R/L .3,0,3,0	14	3.0	3.0	8.3	9	0.2	9	530		530	
	14,00. R/L .3,0,5,0	14	3.0	5.0	10.3	9	0.2	9	630		630	
P									●		●	
M									●		●	
K									●		●	
N									●		●	
S									●		●	
H									●		●	
O									●		●	



→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Full-radius axial grooving inserts – MiniCut



Illustrations show right-hand versions

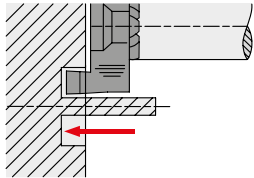
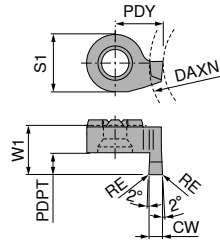
Size	Designation	DAXN mm	CW mm	PDPT mm	W1 mm	PDY mm	CRE mm	S1 mm	Left		Right	
									EH	EH	EH	EH
14	14,00. R/L . 1,0,1,5	14	1.0	1.5	8.3	9	0.5	9	73 376 ...	73 374 ...	510	510
	14,00. R/L . 1,6,2,5	14	1.6	2.5	8.3	9	0.8	9	516	516	516	516
	14,00. R/L . 2,0,3,0	14	2.0	3.0	8.3	9	1.0	9	520	520	520	520
	14,00. R/L . 2,5,3,0	14	2.5	3.0	8.3	9	1.2	9	525	525	525	525
	14,00. R/L . 3,0,3,0	14	3.0	3.0	8.3	9	1.5	9	530	530	530	530
P									•	•	•	•
M									•	•	•	•
K									•	•	•	•
N									•	•	•	•
S									•	•	•	•
H									•	•	•	•
O									•	•	•	•



→ Find the cutting data standard values here.

→ Here you will find suitable holders.

CoreLine – Axial grooving inserts for over a spigot – MiniCut



CWX500

CWX500



Illustrations show right-hand versions

Size	Designation	DAXN mm	CW mm	PDPT mm	W1 mm	PDY mm	RE mm	S1 mm	Left	Right
									EH 73 360 ...	EH 73 358 ...
14	14/12. R/L .1,0,1,5	12	1.0	1.5	8.3	7.0		9	310	310
	14/12. R/L .1,5,2,5	12	1.5	2.5	8.3	7.5	0.2	9	315	315
	14/12. R/L .2,0,3,0	12	2.0	3.0	8.3	8.0	0.2	9	320	320
	14/12. R/L .2,0,5,0	12	2.0	5.0	10.3	8.0	0.2	9	420	420
	14/12. R/L .2,5,3,0	12	2.5	3.0	8.3	8.5	0.2	9	325	325
	14/12. R/L .2,5,5,0	12	2.5	5.0	10.3	8.5	0.2	9	425	425
	14/12. R/L .3,0,3,0	12	3.0	3.0	8.3	9.0	0.2	9	330	330
	14/12. R/L .3,0,5,0	12	3.0	5.0	10.3	9.0	0.2	9	430	430
P									•	•
M									•	•
K									•	•
N									•	•
S									•	•
H									•	•
O									•	•

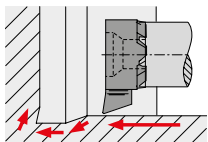


→ Find the cutting data standard values here.

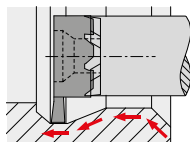
CoreLine – Set: MiniCut size 9

▲ Extensive range of size 9 inserts

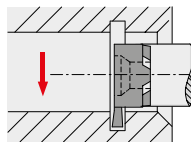
▲ CWX 500



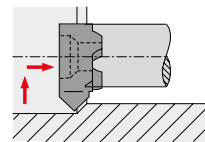
Copy turning (K)



Internal turning (A)



Grooving (E)



Chamfering (F)



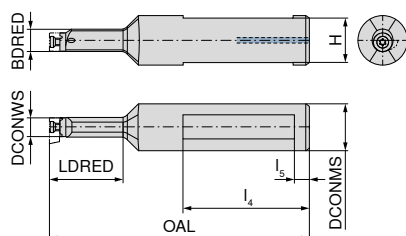
Size	Tool	Designation	Article no.	Hole Ø mm	Width mm	Groove depth mm	Piece	Fig.	TO 73 528 ...
									125
09	Grooving insert	9,00. R .1,00,1,8	73 310 210	9	1,00	1,8	1	E	
	NC fine turning insert	9,00. R .2,00,2,0	73 314 120	9	2,0 +0,05	2,0	1	A	
	Profiling insert	9,00. R .3,60,10°	73 386 136	9	3,6		1	K	
	Profiling insert	9,00. R .3,60,20°	73 322 236	9	3,6		1	K	
	Chamfering and profiling insert	9,00. R .45°,1,3	73 334 110	9		1,3	1	F	
	Tool holders	9,00/16.N.25,1,0	73 522 125				1		
	Clamping key		70 950 105				1		

→ Here you will find suitable holders.

CoreLine – Steel tool holder – MiniCut

Scope of supply:

Holder with clamping screw



Size	Designation	a mm	DCONMS ₁₇ mm	OAL mm	I ₄ mm	LDRED mm	BDRED mm	H mm	I ₅ mm	TO 73 522 ...
08	8,00/16.N.12.1,0	7.8	16	80	60	12		15.0	5	012
	8,00/16.N.22.1,0	7.8	16	90	60	22	7.0	15.0	5	122
09	9,00/16.N.14.1,8	8.6	16	95	60	14	7.4	15.0	5	014
	9,00/16.N.25.1,8	8.6	16	105	60	25	7.4	15.0	5	125
11	11,00/16.N.16.2,3	10.7	16	97	60	16		14.5	5	016
	11,00/16.N.29.2,3	10.7	16	110	60	29	9.5	14.5	5	129
14	14,00/16.N.18.4,0	13.8	16	100	60	18	11.0	14.5	5	018
	14,00/16.N.38.4,0	13.8	16	120	60	38	11.0	14.5	5	138
16	16,00/16.N.22.4,3	15.7	16	100	60	22		14.5	5	022
	16,00/16.N.42.4,3	15.7	16	120	60	42	13.5	14.5	5	142

Spare parts

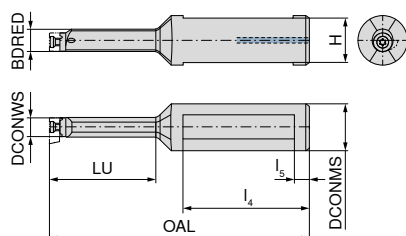
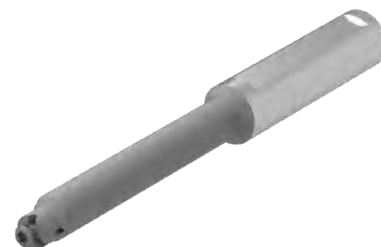
Size

Size	Screwdriver	AS 80 950 ...	Clamping screw	AS 73 082 ...
08	T08	110	M2,6	002
09	T08	110	M2,6	002
11	T10	112	M3,5	003
14	T15	113	M4	004
16	T20	114	M5	005

CoreLine – Carbide tool holder – Vibration-damped – MiniCut

Scope of supply:

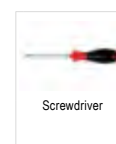
Holder with clamping screw



Size	Designation	a mm	DCONMS _{r7} mm	OAL mm	I ₄ mm	LU mm	BDRED mm	H mm	I ₅ mm	TO 73 520 ...
08	8,00/12.N.21.1,0 HM	7.8	12	80	50	22.60		11.0	5	021
	8,00/12.N.30.1,0 HM	7.8	12	90	54	30.80		11.0	5	030
	8,00/12.N.42.1,0 HM	7.8	12	100	54	42.80		11.0	5	042
	8,00/12.N.50.1,0 HM	7.8	12	115	48	51.60	7.2	11.0	5	050
09	9,00/12.N.22.1,0 HM	8.6	12	90	60	23.60	7.4	11.0	5	222
	9,00/12.N.30.2,0 HM	8.6	12	98	60	30.54	7.4	11.0	5	230
	9,00/12.N.42.3,0 HM	8.6	12	110	60	43.60	7.4	11.0	5	242
	9,00/12.N.56.4,0 HM	8.6	12	122	56	57.60	7.4	11.0	5	256
11	11,00/12.N.29.2,3 HM	10.7	12	95	60	26.40		10.5	5	129
	11,00/12.N.42.2,3 HM	10.7	12	110	56	42.50		10.5	5	142
	11,00/12.N.56.2,3 HM	10.7	12	120	56	57.60		10.5	5	156
	11,00/12.N.64.2,3 HM	10.7	12	130	56	65.60	9.5	10.5	5	164
14	14,00/12.N.34.4,0 HM	13.8	12	100	59	35.00	11.0	10.5	5	234
	14,00/12.N.45.4,0 HM	13.8	12	110	59	46.25	11.0	10.5	5	245
	14,00/12.N.64.4,0 HM	13.8	12	130	60	65.25	11.0	10.5	5	264
	14,00/16.N.34.4,0 HM	13.8	16	100	59	35.60	11.0	14.5	5	334
	14,00/16.N.45.4,0 HM	13.8	16	110	56	46.60	11.0	14.5	5	345
	14,00/16.N.64.4,0 HM	13.8	16	130	59	65.40	11.0	14.5	5	364
	14,00/16.N.75.4,0 HM	13.8	16	145	56	81.60	11.0	14.5	5	375
16	16,00/12.N.40.4,3 HM	15.7	12	130	60	41.25		10.5	5	440
	16,00/12.N.56.4,3 HM	15.7	12	130	60	57.25		10.5	5	456
	16,00/12.N.80.4,3 HM	15.7	12	150	60	81.06		10.5	5	480
	16,00/16.N.56.4,3 HM	15.7	16	130	60	57.60		14.5	5	556
	16,00/16.N.40.4,3 HM	15.7	16	130	60	41.60		14.5	5	540
	16,00/16.N.80.4,3 HM	15.7	16	150	60	81.60		14.5	5	580

Spare parts Size

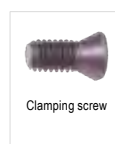
08	T08	AS 80 950 ...	110	M2,6	002
09	T08	AS 80 950 ...	110	M2,6	002
11	T10	AS 80 950 ...	112	M3,5	003
14	T15	AS 80 950 ...	113	M4	004
16	T20	AS 80 950 ...	114	M5	005



Screwdriver

AS

80 950 ...



Clamping screw

AS

73 082 ...

CoreLine – Carbide Flexoholder – MiniCut

Scope of supply:
Holder with clamping screw



Size	Designation	DCONMS mm	OAL mm	LU mm	a mm		
08	8,0/6.N16/2	6	65	18	8		
	8,0/6.N40/4	6	103	40	8		
11	11,0/8.N20/2	8	79	20	11		
	11,0/8.N50/4	8	129	50	11		

TO

73 525 ...

818

840

120 ¹⁾

150 ¹⁾

1) With through coolant

Spare parts
Size

08	T08	110	M2,6	002
11	T10	112	M3,5	003



Screwdriver

AS

80 950 ...



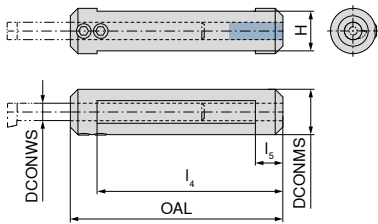
Clamping screw

AS

73 082 ...

CoreLine – Base holder for carbide Flexoholder – MiniCut

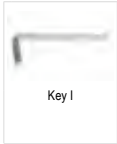
Scope of supply:
Holder with clamping screw



Size	Designation							TO
		DCONWS mm	DCONMS mm	H mm	OAL mm	l ₄ mm	l ₅ mm	
08	8/16.75	6	16	14	75	55	10	73 526 ...
	8/20.75	6	20	18	75	70	10	816 820
11	11/16.75	8	16	14	75	55	10	116
	11/20.75	8	20	18	75	70	10	120

Spare parts
for article number

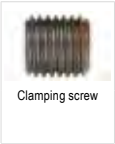
73 526 816	SW2,5	70 950 ...	175	M5x0,5x6	010
73 526 820	SW2,5		175	M5x0,5x6	010
73 526 116	SW2,5		175	M5x0,5x4	009
73 526 120	SW2,5		175	M5x0,5x6	010



Key I

AS

70 950 ...



Clamping screw

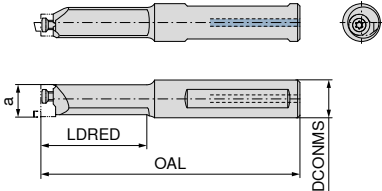
AS

73 082 ...

CoreLine – Steel tool holder – MiniCut

▲ For axial machining

Scope of supply:
Holder with clamping screw



Illustrations show right-hand versions



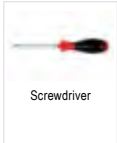
Left Right

Size	Designation	a mm	DCONMS mm	OAL mm	LDRED mm
14	14,0/16. L .25.1,0	13.5	16	90	25
	14,0/16. R .25.1,0	13.5	16	90	25
	14,0/16. L .45.1,0	13.5	16	110	45
	14,0/16. R .45.1,0	13.5	16	110	45

TO	TO
73 523 ...	73 524 ...
025	025
145	145

Spare parts
Size

14

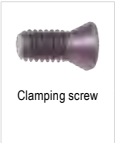


Screwdriver

AS

80 950 ...

T15 113



Clamping screw

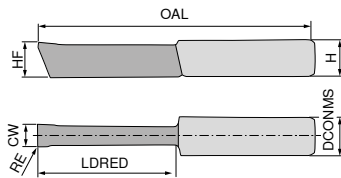
AS

73 082 ...

M4 004

CoreLine – Inserts – DIN 138 – SlotCut

▲ b_1 = groove width



Designation	b_1 P 9/US 9 mm	CW mm	HF mm	RE mm	OAL mm	LDRED mm	DMIN mm	DCONMS _{h6} mm	H mm
NPU.0198.01.1	2	1.98	5.5	0.1	38	12.5	6	7	6.3
NPU.0200.01.1	2	2.01	5.5	0.1	38	12.5	6	7	6.3
NPU.0298.01.1	3	2.98	6.2	0.1	38	12.5	7	7	6.3
NPU.0300.01.1	3	3.01	6.2	0.1	38	12.5	7	7	6.3
NPU.0398.01.1	4	3.98	6.2	0.1	40	15.0	7	7	6.3
NPU.0398.02.2	4	3.98	6.2	0.2	50	25.0	7	7	6.3
NPU.0400.01.1	4	4.01	6.2	0.1	40	15.0	7	7	6.3
NPU.0400.02.1	4	4.01	6.2	0.2	40	15.0	7	7	6.3
NPU.0400.02.2	4	4.01	6.2	0.2	50	25.0	7	7	6.3
NPU.0498.02.2	5	4.98	5.8	0.2	50	25.0	7	7	6.3
NPU.0500.02.2	5	5.01	5.8	0.2	50	25.0	8	7	6.3

TR	TR
73 601 ...	73 602 ...
099	099
100	100
101	101
102	102
103	103
104	103

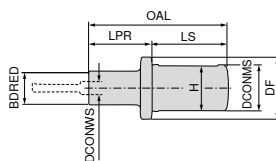


Tolerance **JS 9** for 73 601 ..., tolerance **P 9** for 73 602 ...

CoreLine – Tool holders for inserts – SlotCut

Scope of supply:

Tool holder with clamping screw, without insert



Designation	DCONWS mm	BDRED mm	DCONMS _{g6} mm	DF mm	OAL mm	LS mm	LPR mm	H mm
NHU.25	7	18	25	33	73	40	33	23
NHU.32	7	20	32	40	73	40	33	30

TO
73 610 ...
025
032

Spare parts

DCONMS_{g6}

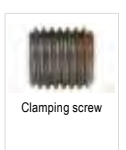
25	SW2,5	175	M5x6	001
32	SW2,5	175	M5x6	001



Key I

AS

70 950 ...



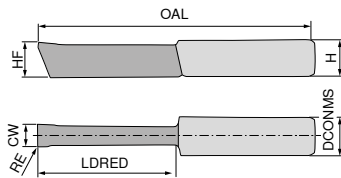
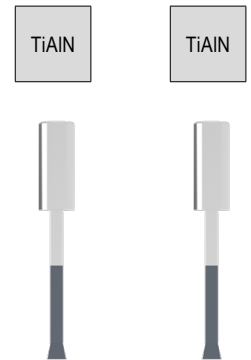
Clamping screw

AS

73 082 ...

CoreLine – Inserts – DIN 138 – SlotCut

▲ b_1 = groove width



Designation	b_1 JS 9/P 9 mm	CW mm	HF mm	RE mm	OAL mm	LDRED mm	DMIN mm	DCONMS _{g6} mm	H mm
NP10.398.02.2	4	3.98	9	0.2	50	25	10	10	9.2
NP10.398.02.3	4	3.98	9	0.2	66	41	10	10	9.2
NP10.400.02.2	4	4.01	9	0.2	50	25	10	10	9.2
NP10.400.02.3	4	4.01	9	0.2	66	41	10	10	9.2
NP10.498.02.2	5	4.98	9	0.2	50	25	10	10	9.2
NP10.498.02.3	5	4.98	9	0.2	66	41	10	10	9.2
NP10.500.02.2	5	5.01	9	0.2	50	25	10	10	9.2
NP10.500.02.3	5	5.01	9	0.2	66	41	10	10	9.2

TR	TR
73 607 ...	73 608 ...
101	
102	
	101
	102
103	
104	
	103
	104

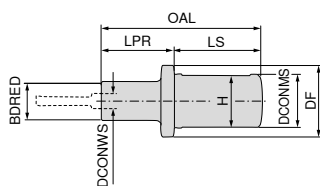


Tolerance **P 9** for 73 607 ..., tolerance **JS 9** for 73 608 ...

CoreLine – Tool holders for inserts – SlotCut

Scope of supply:

Tool holder with clamping screw, without insert

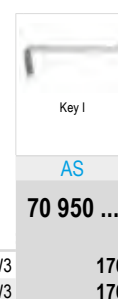
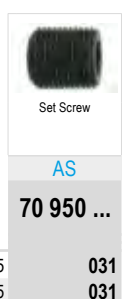


Designation	DCONWS mm	BDRED mm	DCONMS _{g6} mm	DF mm	OAL mm	LS mm	LPR mm	H mm
NH10.0025.1	10	20	25	33	73	40	33	23
NH10.0032.1	10	20	32	40	73	40	33	30

TO
73 612 ...
025
032

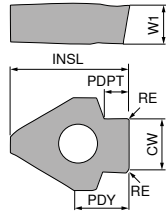
Spare parts DCONMS_{g6}

25	SW3	176	M6x5,5	031
32	SW3	176	M6x5,5	031



CoreLine – Inserts – DIN 138 – SlotCut

▲ b_1 = groove width



TiAlN

TiAlN

TiAlN



Designation	b_1 P 9/US 9/IC 11 mm	CW mm	RE mm	PDY mm	INSL mm	PDPT mm	DMIN mm	W1 mm	Tool holder
NV15.0398.02	4	3.98	0.20	6.5	13.0	2.3	15	3.2	NHV 15
NV15.0401.02	4	4.01	0.20	6.5	13.0	2.3	15	3.2	NHV 15
NV15.0410.050	4	4.10	0.50	6.5	13.0	2.2	15	3.2	NHV 15
NV15.0498.02	5	4.98	0.20	6.5	13.0	2.8	15	3.2	NHV 15
NV15.0501.02	5	5.01	0.20	6.5	13.0	2.8	15	3.2	NHV 15
NV15.0510.050	5	5.10	0.50	6.5	13.0	2.5	15	3.2	NHV 15
NV15.0598.02	6	5.98	0.20	6.5	13.0	3.3	15	3.2	NHV 15
NV15.0601.02	6	6.01	0.20	6.5	13.0	3.3	15	3.2	NHV 15
NV15.0612.085	6	6.12	0.85	6.5	13.0	2.6	15	3.2	NHV 15
NPV.0498.02	5	4.98	0.20	8.0	17.3	2.7	22	5.3	NHV 22
NPV.0501.02	5	5.01	0.20	8.0	17.3	2.7	22	5.3	NHV 22
NPV.0598.02	6	5.98	0.20	8.0	17.3	3.4	22	5.3	NHV 22
NPV.0601.02	6	6.01	0.20	8.0	17.3	3.4	22	5.3	NHV 22
NPV.0612.085	6	6.12	0.85	8.0	17.3	2.6	22	5.3	NHV 22
NPV.0713.085	7	7.13	0.85	8.0	17.3	3.3	22	5.3	NHV 22
NPV.0798.02	8	7.98	0.20	8.0	17.3	4.1	22	5.3	NHV 22/30
NPV.0801.02	8	8.01	0.20	8.0	17.3	4.1	22	5.3	NHV 22/30
NPV.0813.105	8	8.13	1.05	8.0	17.3	3.4	22	5.3	NHV 22/30
NPV.0998.03	10	9.98	0.30	8.0	17.3	4.2	30	5.3	NHV 30
NPV.1001.03	10	10.01	0.30	8.0	17.3	4.2	30	5.3	NHV 30
NPV.1013.105	10	10.13	1.05	10.9	20.2	4.2	40	5.3	NHV 38
NPV.1197.03	12	11.97	0.30	10.9	20.2	5.7	40	5.3	NHV 38
NPV.1202.03	12	12.02	0.30	10.9	20.2	5.7	40	5.3	NHV 38
NPV.1202.05	20	12.02	0.50	10.9	20.2	8.5	40	5.3	NHV 38
NPV.1215.135	12	12.15	1.35	10.9	20.2	5.1	40	5.3	NHV 38
NPV.1215.175	16	12.15	1.75	10.9	20.2	6.6	40	5.3	NHV 38
NPV.1215.225	24	12.15	2.25	10.9	20.2	8.5	40	5.3	NHV 38
NPV.1397.03	14	13.97	0.30	10.9	20.1	7.5	45	5.3	NHV 45
NPV.1402.03	14	14.02	0.30	10.9	20.1	7.5	45	5.3	NHV 45
NPV.1597.03	16	15.97	0.30	10.9	20.1	7.5	45	5.3	NHV 45
NPV.1602.03	16	16.02	0.30	10.9	20.1	7.5	45	5.3	NHV 45
NPV.1797.05	18	17.97	0.50	10.9	20.1	9.5	45	5.3	NHV 45
NPV.1802.05	18	18.02	0.50	10.9	20.1	9.5	45	5.3	NHV 45
NPV.1997.05	20	19.97	0.50	10.9	20.1	10.0	45	5.3	NHV 45
NPV.2002.05	20	20.02	0.50	10.9	20.1	10.0	45	5.3	NHV 45

TR

73 603 ...

108

109

110

101

102

103

104

105

106

107

TR

73 604 ...

110

111

112

100

101

102

103

104

105

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107

TR

73 605 ...

110

111

112

100

101

102

103

104

106

107

108

109

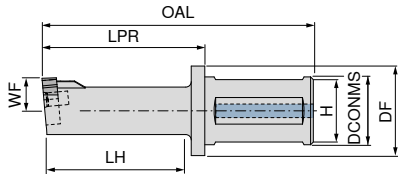


Tolerance **C 11** for 73 603 ..., tolerance **JS 9** for 73 604 ..., tolerance **P 9** for 73 605 ...

CoreLine – Tool holders for inserts – SlotCut

Scope of supply:

Tool holder with clamping screw, without insert

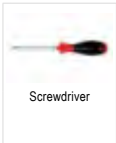


Designation	DCONMS _{g6} mm	DMIN mm	DF mm	OAL mm	LH mm	LPR mm	H mm	WF mm
NHV.15.1	25	15	33	75	25	35	23	8.4
NHV.15.2	25	15	33	90	40	50	23	8.4
NHV.15.3	25	15	33	110	60	70	23	8.4

TO
73 613 ...
025
125
225

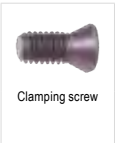
Spare parts
DCONMS_{g6}

25



Screwdriver

AS
80 950 ...
113



Clamping screw

AS
73 950 ...
029

CoreLine – Tool holders for inserts – SlotCut

Scope of supply:
Tool holder with clamping screw, without insert



Designation	DCONMS _{g6} mm	DMIN mm	DF mm	OAL mm	LH mm	LPR mm	H mm	WF mm	TO 73 611 ... 025 032 532 132 632 140 040 240
NHV.22	25	22	33	100	50	60	23	12.0	
NHV.30	32	30	45	100	50	60	30	16.5	
NHV.30	32	30	45	125	75	85	30	16.5	
NHV.38	32	38	45	100	50	60	30	22.0	
NHV.38	32	38	45	125	75	85	30	22.0	
NHV.45	40	45	55	175	105	115	38	24.0	
NHV.45	40	45	55	120	50	60	38	24.0	
NHV.45	40	45	55	225	155	165	38	24.0	

Spare parts
DCONMS_{g6}

25	T20	114	M5x13	007
32	T20	114	M5x13	007
40	T20	114	M5x13	007



Screwdriver

AS

80 950 ...



Clamping screw

AS

73 082 ...

Material examples for cutting data tables

	Material sub-group	Index	Composition / Structure / Heat treatment	Hardness HB / HRC Tensile strength at rupture (Rm) lbf/in ²	Material number Material designation	Material number Material designation
P	Unalloyed steel	P.1.1	< 0.15 % C, annealed	60900 lbf/in ² / 125 HB	1.0401 1015	1.0301 1010
		P.1.2	< 0.45 % C, annealed	92800 lbf/in ² / 190 HB	1.1191 1045	1.0737 12L14
		P.1.3	< 0.45 % C, tempered	121800 lbf/in ² / 250 HB	1.1191 1045	1.0503 1043
		P.1.4	< 0.75 % C, annealed	132000 lbf/in ² / 270 HB	1.1223 1060	1.0535 1055
		P.1.5	< 0.75 % C, tempered	146500 lbf/in ² / 300 HB	1.1223 1060	1.1274 1095
	Low-alloy steel	P.2.1	Annealed	88500 lbf/in ² / 180 HB	1.7131 5115	1.6523 8620
		P.2.2	Tempered	134900 lbf/in ² / 275 HB	1.7131 5115	1.6582 4340
		P.2.3	Tempered	146500 lbf/in ² / 300 HB	1.7225 4142	1.7131 5115
		P.2.4	Tempered	174000 lbf/in ² / 375 HB	1.7225 4142	1.7223 4140
	High-alloy steel and high-alloy tool steel	P.3.1	Annealed	98600 lbf/in ² / 200 HB	1.4021 420	1.2379 D2
		P.3.2	Hardened and tempered	159500 lbf/in ² / 300 HB	1.2343 H11	1.3343 M2
		P.3.3	Hardened and tempered	188500 lbf/in ² / 400 HB	1.2343 H11	1.2363 A2
	Stainless steel	P.4.1	Ferritic / martensitic, annealed	98600 lbf/in ² / 200 HB	1.4016 430	1.4125 440C
		P.4.2	Martensitic, tempered	117500 lbf/in ² / 300 HB	1.4112 S44003	1.4021 420
M	Stainless steel	M.1.1	Austenitic / austenitic-ferritic, quenched	88500 lbf/in ² / 180 HB	1.4301 304	1.4401 316
		M.2.1	Austenitic, tempered	300 HB	1.4841 314	1.4568 17-7 PH
		M.3.1	Austenitic / ferritic (Duplex)	113100 lbf/in ² / 230 HB	1.4462 S32205	1.4410 S32750
K	Grey cast iron	K.1.1	Pearlitic / ferritic	88500 lbf/in ² / 180 HB	0.6010 A48-20B	0.6025 A48-40 B
		K.1.2	Pearlitic (martensitic)	127600 lbf/in ² / 260 HB	0.6030 A48-45B	0.6040 A48-60 B
	Spherulitic graphite cast iron	K.2.1	Ferritic	78300 lbf/in ² / 160 HB	0.7040 60-40-18	0.7050 65-45-12
		K.2.2	Pearlitic	122600 lbf/in ² / 250 HB	0.7070 100-70-03	0.7660 A439 Type D2
	Malleable iron	K.3.1	Ferritic	63800 lbf/in ² / 130 HB	0.8035 GTW-35-04	
		K.3.2	Pearlitic	113100 lbf/in ² / 230 HB	0.8170 70003	
N	Aluminium wrought alloy	N.1.1	Non-hardenable	60 HB	3.0255 A91060	3.0255 A91060
		N.1.2	Hardenable, age-hardened	49300 lbf/in ² / 100 HB	3.1355 2024	3.1355 2024
	Cast aluminium alloy	N.2.1	≤ 12 % Si, non-hardenable	36300 lbf/in ² / 75 HB	3.2581 A04130 / A413-0	3.2581 A04130 / A413-0
		N.2.2	≤ 12 % Si, hardenable, age-hardened	43500 lbf/in ² / 90 HB	3.2134 G-AISi5Cu1Mg	
		N.2.3	> 12 % Si, non-hardenable	63800 lbf/in ² / 130 HB	G-AISi17Cu4Mg	
	Copper and copper alloys (bronze/brass)	N.3.1	Free-machining alloys, Pb > 1 %	54400 lbf/in ² / 110 HB	2.0380 CuZn39Pb2 (Ms58)	2.0380 C37700
		N.3.2	CuZn, CuSnZn	43500 lbf/in ² / 90 HB	2.0331 CuZn15	2.0331 C34000
		N.3.3	CuSn, lead-free copper and electrolytic copper	49300 lbf/in ² / 100 HB	2.0060 E-Cu57	
	Magnesium alloys	N.4.1	Magnesium and magnesium alloys	70 HB	3.5612 MgAl6Zn	
S	Heat-resistant alloys	S.1.1	Fe basis, annealed	98600 lbf/in ² / 200 HB	1.4864 X12NiCrSi 36-16	1.4864 330
		S.1.2	Fe basis, age-hardened	137800 lbf/in ² / 280 HB	1.4980 X6NiCrTiMoVB25-15-2	1.4980 S66286
		S.2.1	Ni or Co basis, annealed	121800 lbf/in ² / 250 HB	2.4856 Inconel 625	2.4812 Hastelloy C
		S.2.2	Ni or Co basis, age-hardened	171100 lbf/in ² / 350 HB	2.4952 Nimonic 80A	2.4668 Inconel 718
		S.2.3	Ni or Co basis, cast	156600 lbf/in ² / 320 HB	2.4674 Nimocast PK24	2.4670 Nimocast 713
	Titanium alloys	S.3.1	Pure titanium	5800 lbf/in ²	3.7025 Ti99,8	
		S.3.2	Alpha + beta alloys, age-hardened	152300 lbf/in ² / 320 HB	3.7165 TiAl6V4	
		S.3.3	Beta alloys	203100 lbf/in ² / 410 HB	Ti555.3 Ti-5Al-5V-5Mo-3Cr	
H	Hardened steel	H.1.1	Hardened and tempered	46–55 HRC		
		H.1.2	Hardened and tempered	56–60 HRC		
		H.1.3	Hardened and tempered	61–65 HRC		
		H.1.4	Hardened and tempered	66–70 HRC		
	Chilled iron	H.2.1	Cast	400 HB		
	Hardened cast iron	H.3.1	Hardened and tempered	55 HRC		
O	Non-metal materials	O.1.1	Plastics, duroplastic	≤ 21800 lbf/in ²	EP, MF, PF, UP	
		O.1.2	Plastics, thermoplastic	≤ 14500 lbf/in ²	PA, PC, PE, PI, PMMA, POM, PP, PS, PTFE, PVC	
		O.2.1	Aramid fibre-reinforced	≤ 145000 lbf/in ²	AFK	
		O.2.2	Glass/carbon-fibre reinforced	≤ 145000 lbf/in ²	CFRP, GFRP	
		O.3.1	Graphite			

Cutting data standard values

	UltraMini K10F uncoated	UltraMini TiN	UltraMini TiAlN	UltraMini DPX77S	UltraMini TiAlN+	MiniCut CWX500	MiniCut CBN
Index	v _c in ft/min						
P.1.1		90	110	110	110	160	
P.1.2		80	100	100	100	140	
P.1.3		60	80	80	80	140	
P.1.4		60	80	80	80	110	
P.1.5		60	60	60	60	100	
P.2.1		60	80	80	80	110	
P.2.2		60	60	60	60	100	
P.2.3		50	60	60	60	90	
P.2.4		50	60	60	60	80	
P.3.1		50	60	60	60	80	
P.3.2		30	50	50	50	70	
P.3.3		30	30	30	30	50	
P.4.1		60	70	70	70	100	
P.4.2		50	60	60	60	90	
M.1.1		60	80	80	80	80	
M.2.1		50	60	60	60	70	
M.3.1		40	50	50	50	60	
K.1.1		80	100	100	100	90	
K.1.2		60	70	70	70	100	
K.2.1		60	60	60	60	80	
K.2.2		50	60	60	60	70	
K.3.1		80	100	100	100	120	
K.3.2		70	80	80	80	100	
N.1.1	100	200	230	230	230	290	
N.1.2	100	180	220	220	220	280	
N.2.1	90	160	190	190	190	240	
N.2.2	70	140	170	170	170	200	
N.2.3	50	80	100	100	100	120	
N.3.1	80	140	170	170	170	210	
N.3.2	70	120	140	140	140	180	
N.3.3	50	100	120	120	120	130	
N.4.1	50	100	120	120	120	100	
S.1.1		30	50	50	50	50	
S.1.2		30	30	30	30	30	30
S.2.1		30	50	50	50	50	50
S.2.2		30	30	30	30	40	30
S.2.3			30	30	30	30	30
S.3.1		30	50	50	50	50	
S.3.2		20	30	30	30	40	
S.3.3			20	20	20	30	20
H.1.1		30	40	40	40	50	40
H.1.2			30	30	30	40	30
H.1.3					30		30
H.1.4							
H.2.1				30			
H.3.1		20	30	30	30	40	30
O.1.1	50	90	110	110	110	150	
O.1.2	50	100	120	120	120	150	
O.2.1		90	110	110	110	130	
O.2.2		60	80	80	80	100	
O.3.1	50	100	120	120	120	150	

	UltraMini	MiniCut
	f in mm/rev.	
Internal turning and profile turning	0,02–0,05	0,03–0,10
Internal turning and profiling – hard turning	0,02–0,06	0,03–0,10
Internal turning and profiling – super alloys	0,02–0,08	
Internal turning	0,02–0,05	0,01–0,03
Back boring	0,02–0,04	0,03–0,10
Internal turning and chamfering	0,01–0,03	0,03–0,10
Pregrooving and chamfering	0,01–0,02	0,01–0,03
Groove turning	0,01–0,02	0,01–0,03
Internal undercuts	0,01–0,03	0,03–0,08
Groove and profile turning	0,01–0,02	0,01–0,03
Axial grooving	0,02–0,05	0,02–0,05



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material, and type of machine. The specified values represent guideline cutting data that can be adjusted by approximately **±20%** according to the usage conditions.

Cutting data standard values – 73 000 ... / 73 001 ...

		Roughing										
Index	UltraMini DPX77S v _c in ft/min	Ø ≤ 2 mm Corner radius in mm			Ø 2,5–4 mm Corner radius in mm				Ø ≥ 5 mm Corner radius in mm			
		0,05	0,1	0,15	0,05	0,1	0,15	0,2 / 0,4	0,05	0,1	0,15	0,2 / 0,4
		f in mm/rev.			f in mm/rev.				f in mm/rev.			
P.1.1	110	0,026–0,076	0,029–0,082	0,031–0,088	0,053–0,151	0,058–0,165	0,062–0,176	0,064–0,184	0,099–0,284	0,108–0,309	0,116–0,33	0,121–0,345
P.1.2	100	0,026–0,076	0,029–0,082	0,031–0,088	0,053–0,151	0,058–0,165	0,062–0,176	0,064–0,184	0,099–0,284	0,108–0,309	0,116–0,33	0,121–0,345
P.1.3	80	0,026–0,076	0,029–0,082	0,031–0,088	0,053–0,151	0,058–0,165	0,062–0,176	0,064–0,184	0,099–0,284	0,108–0,309	0,116–0,33	0,121–0,345
P.1.4	80	0,023–0,065	0,025–0,071	0,026–0,076	0,046–0,13	0,05–0,142	0,053–0,151	0,055–0,158	0,085–0,244	0,093–0,266	0,099–0,284	0,104–0,297
P.1.5	60	0,024–0,068	0,026–0,074	0,028–0,079	0,048–0,136	0,052–0,148	0,055–0,158	0,058–0,166	0,089–0,255	0,097–0,278	0,104–0,297	0,109–0,311
P.2.1	80	0,024–0,068	0,026–0,074	0,028–0,079	0,048–0,136	0,052–0,148	0,055–0,158	0,058–0,166	0,089–0,255	0,097–0,278	0,104–0,297	0,109–0,311
P.2.2	60	0,021–0,06	0,023–0,066	0,025–0,07	0,042–0,121	0,046–0,132	0,049–0,141	0,052–0,147	0,079–0,227	0,087–0,247	0,092–0,264	0,097–0,276
P.2.3	60	0,019–0,054	0,021–0,059	0,022–0,063	0,038–0,109	0,042–0,119	0,044–0,127	0,046–0,132	0,071–0,204	0,078–0,222	0,083–0,238	0,087–0,248
P.2.4	60	0,018–0,051	0,02–0,056	0,021–0,06	0,036–0,103	0,039–0,112	0,042–0,12	0,044–0,125	0,067–0,193	0,074–0,21	0,079–0,224	0,082–0,235
P.3.1	60	0,021–0,06	0,023–0,066	0,025–0,07	0,042–0,121	0,046–0,132	0,049–0,141	0,052–0,147	0,079–0,227	0,087–0,247	0,092–0,264	0,097–0,276
P.3.2	50	0,02–0,057	0,022–0,063	0,023–0,067	0,04–0,115	0,044–0,125	0,047–0,134	0,049–0,14	0,075–0,215	0,082–0,235	0,088–0,251	0,092–0,262
P.3.3	30	0,016–0,045	0,017–0,049	0,018–0,053	0,032–0,091	0,035–0,099	0,037–0,106	0,039–0,11	0,06–0,17	0,065–0,185	0,069–0,198	0,072–0,207
P.4.1	70	0,022–0,064	0,024–0,069	0,026–0,074	0,044–0,127	0,048–0,138	0,052–0,148	0,054–0,155	0,083–0,238	0,091–0,26	0,097–0,277	0,101–0,29
P.4.2	60	0,021–0,06	0,023–0,066	0,025–0,07	0,042–0,121	0,046–0,132	0,049–0,141	0,052–0,147	0,079–0,227	0,087–0,247	0,092–0,264	0,097–0,276
M.1.1	80	0,015–0,042	0,016–0,046	0,017–0,049	0,03–0,085	0,032–0,092	0,034–0,099	0,036–0,103	0,056–0,159	0,061–0,173	0,065–0,185	0,068–0,193
M.2.1	60	0,013–0,038	0,014–0,041	0,015–0,044	0,026–0,076	0,029–0,082	0,031–0,088	0,032–0,092	0,05–0,142	0,054–0,155	0,058–0,165	0,06–0,173
M.3.1	50	0,014–0,039	0,015–0,043	0,016–0,046	0,028–0,079	0,03–0,086	0,032–0,092	0,033–0,096	0,052–0,147	0,056–0,161	0,06–0,172	0,063–0,179
K.1.1	100	0,026–0,076	0,029–0,082	0,031–0,088	0,053–0,151	0,058–0,165	0,062–0,176	0,064–0,184	0,099–0,284	0,108–0,309	0,116–0,33	0,121–0,345
K.1.2	70	0,024–0,068	0,026–0,074	0,028–0,079	0,048–0,136	0,052–0,148	0,055–0,158	0,058–0,166	0,089–0,255	0,097–0,278	0,104–0,297	0,109–0,311
K.2.1	60	0,024–0,068	0,026–0,074	0,028–0,079	0,048–0,136	0,052–0,148	0,055–0,158	0,058–0,166	0,089–0,255	0,097–0,278	0,104–0,297	0,109–0,311
K.2.2	60	0,021–0,059	0,022–0,064	0,024–0,069	0,041–0,118	0,045–0,129	0,048–0,137	0,05–0,144	0,077–0,221	0,084–0,241	0,09–0,257	0,094–0,269
K.3.1	100	0,025–0,073	0,028–0,079	0,03–0,084	0,051–0,145	0,055–0,158	0,059–0,169	0,062–0,177	0,095–0,272	0,104–0,297	0,111–0,317	0,116–0,331
K.3.2	80	0,021–0,06	0,023–0,066	0,025–0,07	0,042–0,121	0,046–0,132	0,049–0,141	0,052–0,147	0,079–0,227	0,087–0,247	0,092–0,264	0,097–0,276
N.1.1	230	0,032–0,091	0,035–0,099	0,037–0,106	0,064–0,181	0,069–0,198	0,074–0,211	0,077–0,221	0,119–0,34	0,13–0,371	0,139–0,396	0,145–0,414
N.1.2	220	0,031–0,089	0,034–0,097	0,036–0,104	0,062–0,178	0,068–0,194	0,073–0,208	0,076–0,217	0,117–0,335	0,128–0,365	0,136–0,389	0,142–0,407
N.2.1	190	0,03–0,085	0,032–0,092	0,034–0,099	0,059–0,169	0,065–0,185	0,069–0,197	0,072–0,206	0,111–0,318	0,121–0,346	0,129–0,37	0,135–0,386
N.2.2	170	0,029–0,083	0,032–0,091	0,034–0,097	0,058–0,166	0,063–0,181	0,068–0,194	0,071–0,202	0,109–0,312	0,119–0,34	0,127–0,363	0,133–0,38
N.2.3	100	0,029–0,082	0,031–0,089	0,033–0,095	0,057–0,163	0,062–0,178	0,067–0,19	0,07–0,199	0,107–0,306	0,117–0,334	0,125–0,356	0,13–0,373
N.3.1	170	0,03–0,085	0,032–0,092	0,034–0,099	0,059–0,169	0,065–0,185	0,069–0,197	0,072–0,206	0,111–0,318	0,121–0,346	0,129–0,37	0,135–0,386
N.3.2	140	0,028–0,08	0,031–0,087	0,033–0,093	0,056–0,16	0,061–0,175	0,065–0,187	0,068–0,195	0,105–0,301	0,115–0,328	0,122–0,35	0,128–0,366
N.3.3	120	0,027–0,077	0,029–0,084	0,031–0,09	0,054–0,154	0,059–0,168	0,063–0,18	0,066–0,188	0,101–0,289	0,11–0,315	0,118–0,337	0,123–0,352
N.4.1	120	0,027–0,077	0,029–0,084	0,031–0,09	0,054–0,154	0,059–0,168	0,063–0,18	0,066–0,188	0,101–0,289	0,11–0,315	0,118–0,337	0,123–0,352
S.1.1	50	0,024–0,068	0,026–0,074	0,028–0,079	0,048–0,136	0,052–0,148	0,055–0,158	0,058–0,166	0,089–0,255	0,097–0,278	0,104–0,297	0,109–0,311
S.1.2	30	0,019–0,053	0,02–0,058	0,022–0,062	0,037–0,106	0,04–0,115	0,043–0,123	0,045–0,129	0,069–0,198	0,076–0,216	0,081–0,231	0,085–0,242
S.2.1	50	0,018–0,051	0,02–0,056	0,021–0,06	0,036–0,103	0,039–0,112	0,042–0,12	0,044–0,125	0,067–0,193	0,074–0,21	0,079–0,224	0,082–0,235
S.2.2	30	0,014–0,039	0,015–0,043	0,016–0,046	0,028–0,079	0,03–0,086	0,032–0,092	0,033–0,096	0,052–0,147	0,056–0,161	0,06–0,172	0,063–0,179
S.2.3	30	0,015–0,042	0,016–0,046	0,017–0,049	0,03–0,085	0,032–0,092	0,034–0,099	0,036–0,103	0,056–0,159	0,061–0,173	0,065–0,185	0,068–0,193
S.3.1	50	0,024–0,068	0,026–0,074	0,028–0,079	0,048–0,136	0,052–0,148	0,055–0,158	0,058–0,166	0,089–0,255	0,097–0,278	0,104–0,297	0,109–0,311
S.3.2	30	0,019–0,054	0,021–0,059	0,022–0,063	0,038–0,109	0,042–0,119	0,044–0,127	0,046–0,132	0,071–0,204	0,078–0,222	0,083–0,238	0,087–0,248
S.3.3	20	0,013–0,038	0,014–0,041	0,015–0,044	0,026–0,076	0,029–0,082	0,031–0,088	0,032–0,092	0,05–0,142	0,054–0,155	0,058–0,165	0,06–0,173
H.1.1	40	0,013–0,038	0,014–0,041	0,015–0,044	0,026–0,076	0,029–0,082	0,031–0,088	0,032–0,092	0,05–0,142	0,054–0,155	0,058–0,165	0,06–0,173
H.1.2	30	0,011–0,03	0,012–0,033	0,012–0,035	0,021–0,06	0,023–0,066	0,025–0,07	0,026–0,074	0,036–0,102	0,039–0,111	0,042–0,119	0,043–0,124
H.1.3												
H.1.4												
H.2.1	30	0,014–0,041	0,016–0,044	0,017–0,048	0,029–0,082	0,031–0,089	0,033–0,095	0,035–0,099	0,054–0,153	0,058–0,167	0,062–0,178	0,065–0,186
H.3.1	30	0,013–0,036	0,014–0,04	0,015–0,042	0,025–0,073	0,028–0,079	0,03–0,084	0,031–0,088	0,048–0,136	0,052–0,148	0,055–0,158	0,058–0,166
O.1.1	110	0,031–0,089	0,034–0,097	0,036–0,104	0,062–0,178	0,068–0,194	0,073–0,208	0,076–0,217	0,117–0,335	0,128–0,365	0,136–0,389	0,142–0,407
O.1.2	120	0,028–0,079	0,03–0,086	0,032–0,092	0,055–0,157	0,06–0,171	0,064–0,183	0,067–0,191	0,103–0,295	0,112–0,321	0,12–0,343	0,126–0,359
O.2.1	110	0,017–0,05	0,019–0,054	0,02–0,058	0,035–0,1	0,038–0,109	0,041–0,116	0,043–0,121	0,065–0,187	0,071–0,204	0,076–0,218	0,08–0,228
O.2.2	80	0,017–0,048	0,018–0,053	0,02–0,056	0,034–0,097	0,037–0,105	0,039–0,113	0,041–0,118	0,064–0,181	0,069–0,198	0,074–0,211	0,077–0,221
O.3.1	120											



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material, and type of machine. The specified values represent guideline cutting data that can be adjusted by approximately **±20%** according to the usage conditions.

	Finishing												
	Ø ≤ 2 mm Corner radius in mm			Ø 2,5–4 mm Corner radius in mm					Ø ≥ 5 mm Corner radius in mm				
Index	0,05	0,1	0,15	0,05	0,1	0,15	0,2	0,4	0,05	0,1	0,15	0,2	0,4
	f in mm/rev.			f in mm/rev.					f in mm/rev.				
P.1.1	0,007–0,019	0,008–0,022	0,009–0,025	0,017–0,049	0,02–0,058	0,023–0,065	0,025–0,072	0,032–0,092	0,027–0,076	0,031–0,089	0,035–0,1	0,039–0,11	0,05–0,142
P.1.2	0,007–0,019	0,008–0,022	0,009–0,025	0,017–0,049	0,02–0,058	0,023–0,065	0,025–0,072	0,032–0,092	0,027–0,076	0,031–0,089	0,035–0,1	0,039–0,11	0,05–0,142
P.1.3	0,007–0,019	0,008–0,022	0,009–0,025	0,017–0,049	0,02–0,058	0,023–0,065	0,025–0,072	0,032–0,092	0,027–0,076	0,031–0,089	0,035–0,1	0,039–0,11	0,05–0,142
P.1.4	0,006–0,016	0,007–0,019	0,008–0,022	0,015–0,042	0,017–0,05	0,02–0,056	0,022–0,061	0,028–0,079	0,023–0,065	0,027–0,077	0,03–0,086	0,033–0,095	0,043–0,122
P.1.5	0,006–0,017	0,007–0,02	0,008–0,023	0,016–0,044	0,018–0,052	0,02–0,059	0,023–0,064	0,029–0,083	0,024–0,068	0,028–0,08	0,032–0,09	0,035–0,099	0,045–0,128
P.2.1	0,006–0,017	0,007–0,02	0,008–0,023	0,016–0,044	0,018–0,052	0,02–0,059	0,023–0,064	0,029–0,083	0,024–0,068	0,028–0,08	0,032–0,09	0,035–0,099	0,045–0,128
P.2.2	0,005–0,015	0,006–0,018	0,007–0,02	0,014–0,04	0,016–0,046	0,018–0,052	0,02–0,057	0,026–0,074	0,021–0,061	0,025–0,071	0,028–0,08	0,031–0,088	0,04–0,114
P.2.3	0,005–0,014	0,006–0,016	0,006–0,018	0,012–0,036	0,015–0,042	0,016–0,047	0,018–0,051	0,023–0,066	0,019–0,055	0,022–0,064	0,025–0,072	0,028–0,079	0,036–0,102
P.2.4	0,005–0,013	0,005–0,015	0,006–0,017	0,012–0,034	0,014–0,039	0,015–0,044	0,017–0,049	0,022–0,063	0,018–0,052	0,021–0,061	0,024–0,068	0,026–0,075	0,034–0,097
P.3.1	0,005–0,015	0,006–0,018	0,007–0,02	0,014–0,04	0,016–0,046	0,018–0,052	0,02–0,057	0,026–0,074	0,021–0,061	0,025–0,071	0,028–0,08	0,031–0,088	0,04–0,114
P.3.2	0,005–0,014	0,006–0,017	0,007–0,019	0,013–0,038	0,015–0,044	0,017–0,049	0,019–0,054	0,025–0,07	0,02–0,058	0,024–0,068	0,027–0,076	0,029–0,084	0,038–0,108
P.3.3	0,004–0,011	0,005–0,013	0,005–0,015	0,01–0,03	0,012–0,035	0,014–0,039	0,015–0,043	0,019–0,055	0,016–0,046	0,019–0,053	0,021–0,06	0,023–0,066	0,03–0,085
P.4.1	0,006–0,016	0,007–0,019	0,007–0,021	0,015–0,041	0,017–0,049	0,019–0,055	0,021–0,06	0,027–0,078	0,022–0,064	0,026–0,075	0,029–0,084	0,032–0,092	0,042–0,119
P.4.2	0,005–0,015	0,006–0,018	0,007–0,02	0,014–0,04	0,016–0,046	0,018–0,052	0,02–0,057	0,026–0,074	0,021–0,061	0,025–0,071	0,028–0,08	0,031–0,088	0,04–0,114
M.1.1	0,004–0,011	0,004–0,012	0,005–0,014	0,01–0,028	0,011–0,032	0,013–0,036	0,014–0,04	0,018–0,052	0,015–0,043	0,017–0,05	0,02–0,056	0,022–0,062	0,028–0,08
M.2.1	0,003–0,01	0,004–0,011	0,004–0,013	0,009–0,025	0,01–0,029	0,011–0,033	0,013–0,036	0,016–0,046	0,013–0,038	0,016–0,045	0,018–0,05	0,019–0,055	0,025–0,071
M.3.1	0,003–0,01	0,004–0,012	0,005–0,013	0,009–0,026	0,011–0,03	0,012–0,034	0,013–0,037	0,017–0,048	0,014–0,04	0,016–0,046	0,018–0,052	0,02–0,057	0,026–0,074
K.1.1	0,007–0,019	0,008–0,022	0,009–0,025	0,017–0,049	0,02–0,058	0,023–0,065	0,025–0,072	0,032–0,092	0,027–0,076	0,031–0,089	0,035–0,1	0,039–0,11	0,05–0,142
K.1.2	0,006–0,017	0,007–0,02	0,008–0,023	0,016–0,044	0,018–0,052	0,02–0,059	0,023–0,064	0,029–0,083	0,024–0,068	0,028–0,08	0,032–0,09	0,035–0,099	0,045–0,128
K.2.1	0,006–0,017	0,007–0,02	0,008–0,023	0,016–0,044	0,018–0,052	0,02–0,059	0,023–0,064	0,029–0,083	0,024–0,068	0,028–0,08	0,032–0,09	0,035–0,099	0,045–0,128
K.2.2	0,005–0,015	0,006–0,017	0,007–0,02	0,013–0,039	0,016–0,045	0,018–0,051	0,02–0,056	0,025–0,072	0,021–0,059	0,024–0,069	0,027–0,078	0,03–0,086	0,039–0,111
K.3.1	0,006–0,018	0,007–0,021	0,008–0,024	0,017–0,047	0,019–0,056	0,022–0,062	0,024–0,069	0,031–0,089	0,026–0,073	0,03–0,085	0,034–0,096	0,037–0,106	0,048–0,136
K.3.2	0,005–0,015	0,006–0,018	0,007–0,02	0,014–0,04	0,016–0,046	0,018–0,052	0,02–0,057	0,026–0,074	0,021–0,061	0,025–0,071	0,028–0,08	0,031–0,088	0,04–0,114
N.1.1	0,008–0,023	0,009–0,027	0,011–0,03	0,02–0,058	0,024–0,068	0,027–0,077	0,03–0,084	0,038–0,109	0,027–0,076	0,031–0,089	0,035–0,1	0,039–0,11	0,05–0,142
N.1.2	0,008–0,022	0,009–0,026	0,01–0,03	0,02–0,058	0,024–0,068	0,027–0,077	0,03–0,084	0,038–0,109	0,027–0,076	0,031–0,089	0,035–0,1	0,039–0,11	0,05–0,142
N.2.1	0,007–0,021	0,009–0,025	0,01–0,028	0,019–0,055	0,023–0,065	0,025–0,073	0,028–0,08	0,036–0,103	0,027–0,076	0,031–0,089	0,035–0,1	0,039–0,11	0,05–0,142
N.2.2	0,007–0,021	0,009–0,024	0,01–0,028	0,019–0,054	0,022–0,064	0,025–0,072	0,028–0,079	0,036–0,102	0,027–0,076	0,031–0,089	0,035–0,1	0,039–0,11	0,05–0,142
N.2.3	0,007–0,021	0,008–0,024	0,009–0,027	0,019–0,053	0,022–0,062	0,025–0,07	0,027–0,077	0,035–0,1	0,027–0,076	0,031–0,089	0,035–0,1	0,039–0,11	0,05–0,142
N.3.1	0,007–0,021	0,009–0,025	0,01–0,028	0,019–0,055	0,023–0,065	0,025–0,073	0,028–0,08	0,036–0,103	0,027–0,076	0,031–0,089	0,035–0,1	0,039–0,11	0,05–0,142
N.3.2	0,007–0,02	0,008–0,024	0,009–0,027	0,018–0,052	0,021–0,061	0,024–0,069	0,027–0,076	0,034–0,098	0,027–0,076	0,031–0,089	0,035–0,1	0,039–0,11	0,05–0,142
N.3.3	0,007–0,019	0,008–0,023	0,009–0,026	0,018–0,05	0,021–0,059	0,023–0,066	0,026–0,073	0,033–0,094	0,027–0,076	0,031–0,089	0,035–0,1	0,039–0,11	0,05–0,142
N.4.1	0,007–0,019	0,008–0,023	0,009–0,026	0,018–0,05	0,021–0,059	0,023–0,066	0,026–0,073	0,033–0,094	0,027–0,078	0,032–0,091	0,036–0,102	0,039–0,112	0,051–0,145
S.1.1	0,006–0,017	0,007–0,02	0,008–0,023	0,016–0,044	0,018–0,052	0,02–0,059	0,023–0,064	0,029–0,083	0,024–0,068	0,028–0,08	0,032–0,09	0,035–0,099	0,045–0,128
S.1.2	0,005–0,013	0,005–0,016	0,006–0,018	0,012–0,035	0,014–0,04	0,016–0,046	0,018–0,05	0,023–0,065	0,019–0,053	0,022–0,062	0,025–0,07	0,027–0,077	0,035–0,099
S.2.1	0,005–0,013	0,005–0,015	0,006–0,017	0,012–0,034	0,014–0,039	0,015–0,044	0,017–0,049	0,022–0,063	0,018–0,052	0,021–0,061	0,024–0,068	0,026–0,075	0,034–0,097
S.2.2	0,003–0,01	0,004–0,012	0,005–0,013	0,009–0,026	0,011–0,03	0,012–0,034	0,013–0,037	0,017–0,048	0,014–0,04	0,016–0,046	0,018–0,052	0,02–0,057	0,026–0,074
S.2.3	0,004–0,011	0,004–0,012	0,005–0,014	0,01–0,028	0,011–0,032	0,013–0,036	0,014–0,04	0,018–0,052	0,015–0,043	0,017–0,05	0,02–0,056	0,022–0,062	0,028–0,08
S.3.1	0,006–0,017	0,007–0,02	0,008–0,023	0,016–0,044	0,018–0,052	0,02–0,059	0,023–0,064	0,029–0,083	0,024–0,068	0,028–0,08	0,032–0,09	0,035–0,099	0,045–0,128
S.3.2	0,005–0,014	0,006–0,016	0,006–0,018	0,012–0,036	0,015–0,042	0,016–0,047	0,018–0,051	0,023–0,066	0,019–0,055	0,022–0,064	0,025–0,072	0,028–0,079	0,036–0,102
S.3.3	0,003–0,01	0,004–0,011	0,004–0,013	0,009–0,025	0,01–0,029	0,011–0,033	0,013–0,036	0,016–0,046	0,013–0,038	0,016–0,045	0,018–0,05	0,019–0,055	0,025–0,071
H.1.1	0,003–0,01	0,004–0,011	0,004–0,013	0,009–0,025	0,01–0,029	0,011–0,033	0,013–0,036	0,016–0,046	0,013–0,038	0,016–0,045	0,018–0,05	0,019–0,055	0,025–0,071
H.1.2	0,003–0,008	0,003–0,009	0,004–0,01	0,007–0,02	0,008–0,023	0,009–0,026	0,01–0,029	0,013–0,037	0,011–0,03	0,012–0,036	0,014–0,04	0,015–0,044	0,02–0,057
H.1.3													
H.1.4													
H.2.1	0,004–0,01	0,004–0,012	0,005–0,014	0,009–0,027	0,011–0,031	0,012–0,035	0,014–0,039	0,017–0,05	0,014–0,041	0,017–0,048	0,019–0,054	0,021–0,059	0,027–0,077
H.3.1	0,003–0,009	0,004–0,011	0,004–0,012	0,008–0,024	0,01–0,028	0,011–0,031	0,012–0,034	0,016–0,044	0,013–0,036	0,015–0,043	0,017–0,048	0,018–0,053	0,024–0,068
O.1.1	0,008–0,022	0,009–0,026	0,01–0,03	0,02–0,058	0,024–0,068	0,027–0,077	0,03–0,084	0,038–0,109	0,027–0,076	0,031–0,089	0,035–0,1	0,039–0,11	0,05–0,142
O.1.2	0,007–0,02	0,008–0,023	0,009–0,026	0,018–0,051	0,021–0,06	0,024–0,068	0,026–0,074	0,034–0,096	0,028–0,079	0,032–0,093	0,036–0,104	0,04–0,114	0,052–0,148
O.2.1	0,004–0,013	0,005–0,015	0,006–0,017	0,011–0,033	0,013–0,038	0,015–0,043	0,017–0,047	0,021–0,061	0,018–0,05	0,021–0,059	0,023–0,066	0,025–0,073	0,033–0,094
O.2.2	0,004–0,012	0,005–0,014	0,006–0,016	0,011–0,032	0,013–0,037	0,015–0,042	0,016–0,046	0,021–0,059	0,017–0,049	0,02–0,057	0,022–0,064	0,025–0,07	0,032–0,091
O.3.1													

Broaching – Recommendations for correct use

SlotCut

An increasing number of single parts or small and mid-sized series require high-precision slots.

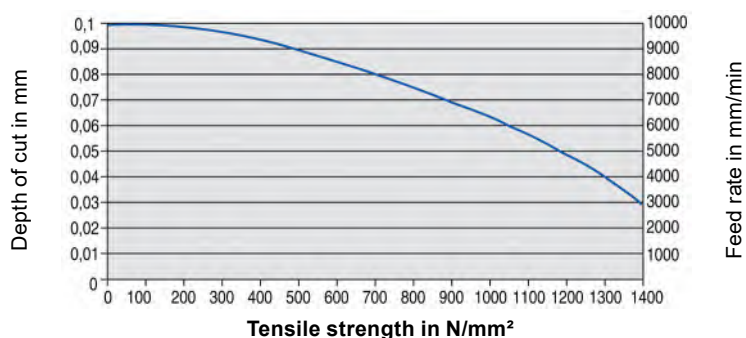
A tool system that is specially designed for broaching is required in order to machine these slots directly in one clamping set-up on the respective machine.

The SlotCut system can be used to machine slots in the most common slot tolerances and offers four ways of doing this. Two of these are based on a complete carbide solution that works especially well with small diameters.

The versions with bolted inserts are ideal for larger diameters.

This makes broaching a cost-effective process on both turning machines and machining centers, delivering high-precision results in next to no time.

Approximate broaching values



The data is strongly influenced by the external conditions and is only intended as a guideline that will need to be adjusted up or down depending on the stability of the machine, application, and material.



Tips for the user

- ▲ Avoid interrupted cuts.
- ▲ If possible, broach the slot at the top of the component so the chips drop down.
- ▲ Make sure that the tool is not impeded at the end of the slot.
- ▲ Lift the tool out of the slot as you retract it from the material.
- ▲ Use coolant to increase the tool life and surface quality.
- ▲ Adjusting the tool is essential, so take note of the tool diameter.



Coatings

TiAlN+	<ul style="list-style-type: none"> ▲ TiAlN multilayer coating ▲ Maximum application temperature: 1000 °C or 1832 °F 	CWX500	<ul style="list-style-type: none"> ▲ Carbide, TiAlN-coated ▲ The universal carbide grade for almost all materials
TiN	<ul style="list-style-type: none"> ▲ TiN coating ▲ Maximum application temperature: 450 °C or 842 °F 	DPX77S	<ul style="list-style-type: none"> ▲ TiAlN+X coating ▲ Maximum application temperature: 900 °C or 1652 °F
TiAlN	<ul style="list-style-type: none"> ▲ TiAlN multilayer coating ▲ Maximum application temperature: 900 °C or 1652 °F 		

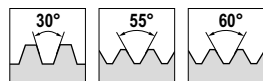
Grade description

K10F	<ul style="list-style-type: none"> ▲ Carbide, uncoated ▲ ISO K10 ▲ Uncoated carbide grade for machining grey cast iron or non-ferrous metals, depending on the cutting edge geometry
------	--

Thread types

M	ISO metric coarse thread	MF	ISO metric fine thread	G	Whitworth thread
Tr	ISO metric trapezoidal thread				

Thread flank angle



Cooling



With through coolant supply



Taps and thread formers



Contents

- Explanation of symbols
- Tool types
- Thread types/chamfer forms/cutting materials
- Application areas/special features
- Toolfinder – Taps for universal application
- Toolfinder – taps for P / M
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- Toolfinder – Thread formers for cold-forming materials
- Overview of machine taps – M / EG M
- Overview of machine taps – MF
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- Overview of machine thread formers – M / MF / G / UNC / UNF
- Overview of hand taps – M / MF / G / UNC
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- Shank extensions for taps
- Thread cutting oil, chlorine-free
- Thread-cutting paste, chlorine-free
- Technical information
 - Thread core hole diameter for tapered threads
 - Tapped pilot hole diameter
 - Thread forming pilot hole diameter
 - Thread tolerances and recommended manufacturing tolerances
 - Thread formers – further information
 - Troubleshooting
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Explanation of symbols

 → Tool types	 Coolant supply	 → Colored ring
 → Thread type	 Through hole thread	HSS-E → Cutting material
 → Application area → Special feature	 Blind hole thread	FHA 42° Helix angle
 → Chamfer form	 Through hole thread and blind hole thread	≤ 1100 N/mm ² Tensile strength to be machined
 → Tolerance	 The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material, and type of machine. The specified values represent guideline cutting data that must be corrected according to the usage conditions.	
 → Coating		

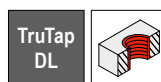
Tool types



TruTap through hole taps



- ▲ For through hole threads to 4xD
- ▲ Chamfer form B: 3.5–5 pitch lead with spiral point
- ▲ Straight flute
- ▲ Suitable for synchronized machining and other applications, with Weldon flat and in extra long version
- ▲ The special geometry of the chip flutes ensures that chips are removed in the cutting direction



TruTap DL through hole taps



- ▲ For through hole threads to 4xD
- ▲ Chamfer form D: 3.5–5 pitch lead without spiral point
- ▲ 15° left-hand flutes
- ▲ Suitable for steel, titanium, titanium alloys, and Inconel 718
- ▲ Chips are removed in the cutting direction



CavTap blind hole taps



- ▲ For blind hole threads up to 3xD
- ▲ Chamfer form C: 2–3 pitch lead without spiral point
- ▲ Chamfer form E: 1.5–2 pitch lead without spiral point
- ▲ (35°, 42°, 45°, 50°) right-hand flutes with helix
- ▲ Suitable for synchronized machining and other applications, with Weldon flat, in extra long version and with through coolant
- ▲ Spiral flutes with helix reliably remove chips in the opposite direction to the cutting direction



CavTap SL blind hole taps



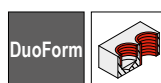
- ▲ For blind hole threads up to 2xD
- ▲ Chamfer form C: 2–3 pitch lead without spiral point
- ▲ Chamfer form E: 1.5–2 pitch lead without spiral point
- ▲ (15°, 25°, 30°) right-hand flutes with helix
- ▲ Suitable for steel, titanium, titanium alloys, and Inconel 718
- ▲ Suitable for synchronized machining and other applications, in extra-long version and with through coolant
- ▲ Can also be used for more challenging applications such as transverse holes



DuoTap through and blind hole taps



- ▲ For blind hole and through hole threads to 2xD
- ▲ Chamfer form C: 2–3 pitch lead without spiral point
- ▲ Chamfer form D: 3.5–5 pitch lead without spiral point
- ▲ Chamfer form E: 1.5–2 pitch lead without spiral point
- ▲ Straight flute
- ▲ For steel, short-chipping, and hardened materials up to 55 (62) HRC
- ▲ In versions including extra-long and with through coolant



DuoForm thread formers



- ▲ For blind hole and through hole threads to 3xD
- ▲ Chamfer form C: 2–3 pitch lead without spiral point
- ▲ For cold-forming materials up to 1400N/mm²
- ▲ Suitable for synchronized machining, with oil grooves and through coolant

Thread types

M	ISO metric coarse thread DIN 13
MF	ISO metric fine thread DIN 13
G	Whitworth pipe thread DIN EN ISO 228
UNC	Unified coarse thread ASME B1.15 and ISO 3161
UNF	Unified fine thread ASME B1.1
EG M	ISO metric coarse thread for wire thread inserts DIN 8140-2
EG UNC	EG unified coarse thread for wire thread inserts ASME B18.29.1
EG UNF	EG unified fine thread for wire thread inserts ASME B18.29.1

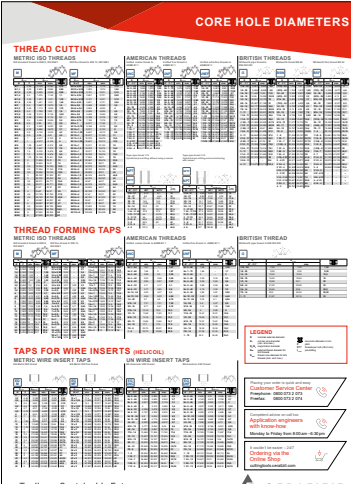
UNJC	Unified coarse thread ASME B1.15 and ISO 3161
UNJF	Unified extra fine thread ASME B1.15 and ISO 3161
BSW	Whitworth thread BS84
NPT	American taper pipe thread with sealing (1:16) ANSI/ASME B1.20.1
NPTF	American taper pipe thread with sealing (1:16) ANSI/ASME B1.20.3
Rc	Tapered Whitworth pipe thread (1:16) DIN EN 10226-2 (ISO7-1)
Rp	Cylindrical Whitworth pipe thread DIN EN 10226-1 (ISO7-1)

Chamfer forms

	Form B (with spiral point, 4–5 pitch lead)
	Form C (without spiral point, 2–3 pitch lead)
	Form D (without spiral point, 4–5 pitch lead)
	Form E (without spiral point, 1.5–2 pitch lead)

Cutting materials

HSS	High-speed steel
HSS-PM	High-speed steel powdered metal
HSS-E	High-performance high speed steel
HSS-E-PM	High-performance high-speed steel powdered metal
HSS-E / HM	HSS-E base support material Cutting/forming medium: HM
Solid carbide	Solid carbide

CORE HOLE DIAMETERS	
	

A must-have for your production processes.

Thread core hole diameters at a glance as seen on the the CERATIZIT workshop poster.

For availability, please contact your local technical sales engineer.

Application areas

UNI-HP		For universal application up to 1400 N/mm ²
UNI		For universal application up to 1100 N/mm ²
HR		For high-tensile steels < 1400 N/mm ²
ST		Coated tap for steels up to 1100 N/mm ²
ST		Uncoated tap for steels up to 750 N/mm ²
VG		For tempered and heat-resistant steels < 1100 N/mm ²
VA		For corrosion and acid-resistant steels
GG		For cast iron
NW		For aluminum and aluminum alloys
Soft		For soft materials
Ms		For short-chipping brass
AMPCO		For Ampco alloys
Ti		For titanium and titanium alloys
Ni		Specifically for Inconel 718
HT		For hardened steel and chilled iron up to 55 HRC
ERGO		Hand tap with guide chamfer on the taper tap for stainless, heat-resistant, and tempered steels up to 1100 N/mm ²
ERGO F.T.		Hand tap for steels up to 1400 N/mm ² , tungsten, chilled iron
ST		Hand tap for steels
FE		Dies for steel

UNI	For universal application up to 1000 N/mm ²	
FE	For steels to 850 N/mm ²	
FE-HF	For high-tensile steels up to 1100 N/mm ²	
VA	For corrosion and acid-resistant steels	
GG	For cast iron	
AL	For aluminum and aluminum alloys	
G-AL	for cast aluminum alloys	
NW	For aluminum	
EC	NEO	For universal application

Special features

AUT	Short version for automatic use
AZ	With intermittent teeth, reduces friction
CNC	For synchronized CNC machining with minimum length compensation chuck
DRY	For dry machining or minimum quantity lubrication (MQL)
EL	Extra long, with double overall length
ES	Extra short
HML	With soldered-in carbide strips for a higher cutting speed
LH	For left-hand threads
MMB	Nut tap
NC	For synchronized CNC machining with minimum length compensation chuck
NCW	With Weldon flat for synchronized CNC machining without length compensation chuck
R _Z =1	Lapped dies
S	With separate conical lead, for deep threads
SN	Thread former with oil grooves
TS	For high-speed machining, up to 100 m/min

Toolfinder – Taps for universal application

 Through hole thread	 Blind hole thread	 Through hole thread and blind hole thread
UNI Taps for universal application		
M → UNI → UNI-HP TruTap	M → UNI → UNI-HP CavTap	
MF → UNI → UNI-HP TruTap	MF → UNI → UNI-HP CavTap	
G → UNI → UNI TruTap	G → UNI → UNI-HP CavTap	
UNC → UNI → UNI TruTap	UNC → UNI → UNI-HP CavTap	
UNF → UNI → UNI TruTap	UNF → UNI → UNI-HP CavTap	
EG M → UNI TruTap	EG M → UNI CavTap	
EG UNC → UNI TruTap	EG UNC → UNI CavTap	
EG UNF → UNI TruTap	EG UNF → UNI CavTap	
BSW → UNI TruTap	BSW → UNI CavTap	

Toolfinder – taps for P / M



Through hole thread



Blind hole thread



Through hole thread and blind hole thread

P Taps for steels: FE ≤ 850 N/mm², ST ≤ 750 N/mm², ≤ 1100 N/mm²

M → FE → ST TruTap	M → FE → ST CavTap	M → ST DuoTap
MF → FE	MF → FE → ST CavTap SL	MF → ST DuoTap
G → FE	G → FE → ST CavTap	NPT → ST ES DuoTap
UNF → ST TruTap	UNF → FE	NPTF → ST DuoTap
UNC → ST TruTap		Rp → ST DuoTap
		Rc → ST DuoTap

P Taps for high-tensile steels: FE-HF ≤ 1100 N/mm², HR ≤ 1400 N/mm²

M → FE-HF → HR TruTap	M → FE-HF → HR CavTap	M → HR DuoTap
MF → FE-HF	MF → FE-HF	MF → HR DuoTap
UNC → FE-HF	UNC → FE-HF	G → HR DuoTap

M Taps for corrosion and acid-resistant steels

M → VA → VA TruTap	M → VA → VA CavTap	
MF → VA	MF → VA	
G → VA TruTap	G → VA CavTap	
UNC → VA → VA TruTap	UNC → VA → VA CavTap	
	UNF → VA → VA CavTap	
	NPT → VA CavTap	

Toolfinder – taps for K / N / S / H



Through hole thread



Blind hole thread



Through hole thread and blind hole thread

K Taps for cast iron materials

		M → GG → GG DuoTap
		G → GG DuoTap
		UNF → GG DuoTap

N Taps for aluminum and non-ferrous metals

M → AL → NW TruTap	M → AL → NW CavTap	M → AMPCO DuoTap
	G → NW CavTap	
	EG M → Soft CavTap	

S Taps for heat-resistant materials

M → Ti TruTap	M → Ti CavTap SL	
UNC → Ti TruTap	UNC → Ti CavTap SL	
	UNJC → Ti CavTap SL	
	UNF → Ti CavTap SL	
UNJF → Ti TruTap DL	UNJF → Ti CavTap SL	

H Taps for hard machining

		M → HT DuoTap
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Toolfinder – Thread formers for cold-forming materials

<div>Through hole thread and blind hole thread</div>					
UNI Thread formers for universal usage					
M	MF	G	UNC	UNF	
→UNI-HP SN	→UNI-HP SN	→EC SN	→EC SN	→EC SN	DuoForm
→UNI	→UNI SN				

N Thread formers for aluminum and aluminum alloys					
M	MF	G	UNC	UNF	
→AL SN					DuoForm

N Thread formers for cast aluminum alloys					
M	MF	G	UNC	UNF	
→G-AL SN					DuoForm

Overview of machine taps – M

M ISO metric coarse thread									
UNI Through hole thread									
UNI-HP	TruTap		ISO 2X 6HX	AITINH	HSS-E-PM	→ 22 862 ...	22 863 ...		
UNI-HP	TruTap		ISO 3X 6GX	AITINH	HSS-E-PM	→ 22 866 ...	22 867 ...		
UNI	TruTap		ISO 2 6H	AITINH	HSS-E	→ 22 658 ...			
UNI	TruTap		ISO 2 6H	nit. + vap.	HSS-E	→ 22 501 ...	22 502 ...		
UNI	TruTap		ISO 2 6H	TiN	HSS-E	→ 22 503 ...	22 504 ...		
UNI	TruTap		ISO 3 6G	nit. + vap.	HSS-E	→ 22 508 ...	22 509 ...		
UNI	TruTap		7G	nit. + vap.	HSS-E	→ 22 510 ...	22 511 ...		
UNI EL	TruTap		ISO 2 6H	nit. + vap.	HSS-E	→ 22 514 ...	22 515 ...		
UNI NCW	TruTap		ISO 2 6H	TiN	HSS-PM	→ 22 148 ...			
UNI CNC	TruTap		ISO 2X 6HX	TiN GS	HSS-E	→ 22 542 ...	22 543 ...		
UNI CNC	TruTap		ISO 3X 6GX	TiN GS	HSS-E	→ 22 596 ...			
UNI CNC	TruTap		7GX	TiN GS	HSS-E	→ 22 592 ...	22 593 ...		
UNI			ISO 2 6H	nit. + vap.	HSS-E	→ 23 110 ...	23 111 ...		
UNI			ISO 2 6H	TiN	HSS-E	→ 23 112 ...	23 113 ...		
UNI			ISO 2 6H	TiN	HSS-PM	→ 23 010 ...	23 021 ...		
UNI NC			ISO 2 6H	TiN GS	HSS-E	→ 23 114 ...	23 115 ...		
UNI NCW			ISO 2 6H	TiCN	HSS-PM	→ 23 116 ...	23 117 ...		
UNI Blind hole thread									
UNI-HP	CavTap		ISO 2X 6HX	AITINH	HSS-E-PM	→ 22 829 ...	22 830 ...		
UNI-HP	CavTap		ISO 2X 6HX	AITINH	HSS-E-PM	→ 22 840 ...	22 841 ...		
UNI-HP	CavTap		ISO 3X 6GX	AITINH	HSS-E-PM	→ 22 833 ...	22 834 ...		
UNI-HP	CavTap		ISO 3X 6GX	AITINH	HSS-E-PM	→ 22 843 ...	22 844 ...		

M ISO metric coarse thread									
UNI Blind hole thread									
UNI-HP	CavTap		ISO 2X 6HX	AITINH	HSS-E-PM	→ 22 820 ...	22 821 ...		
UNI-HP	CavTap		ISO 2X 6HX	AITINH	HSS-E-PM	→ 22 835 ...	22 836 ...		
UNI-HP	CavTap		ISO 3X 6GX	AITINH	HSS-E-PM	→ 22 827 ...	22 828 ...		
UNI-HP	CavTap		ISO 3X 6GX	AITINH	HSS-E-PM	→ 22 838 ...	22 839 ...		
UNI	CavTap		ISO 2 6H	TiN	HSS-E	→ 22 526 ...	22 527 ...		
UNI	CavTap		ISO 2 6H	vap.	HSS-E	→ 22 524 ...	22 525 ...		
UNI	CavTap		ISO 2 6H	vap.	HSS-E	→ 22 534 ...	22 535 ...		
UNI	CavTap		ISO 3 6G	vap.	HSS-E	→ 22 530 ...			
UNI	CavTap		ISO 2 6H	AITINH	HSS-E	→ 22 690 ...			
UNI	CavTap		ISO 2 6H	vap.	HSS-E	→ 22 688 ...	22 689 ...		
UNI	CavTap		ISO 2 6H	TiN	HSS-E	→ 22 520 ...	22 521 ...		
UNI	CavTap		ISO 2 6H	TiCN	HSS-E	→ 22 522 ...			
UNI	CavTap		ISO 2 6H	vap.	HSS-E	→ 22 518 ...	22 519 ...		
UNI	CavTap		7G	vap.	HSS-E	→ 22 691 ...			
UNI	CavTap SL		ISO 2 6H		HSS-E	→ 22 516 ...			
UNI NCW	CavTap		ISO 2 6H	TiN	HSS-PM	→ 22 149 ...			
UNI CNC	CavTap		ISO 2 6H	TiN GS	HSS-E	→ 22 546 ...			
UNI CNC	CavTap		ISO 2 6H	TiN GS	HSS-E	→ 22 544 ...	22 545 ...		
UNI CNC	CavTap		ISO 2X 6HX	TiN	HSS-E	→ 22 416 ...	22 417 ...		
UNI CNC	CavTap		ISO 3 6G	TiN GS	HSS-E	→ 22 588 ...	22 589 ...		
UNI CNC	CavTap		7G	TiN GS	HSS-E	→ 22 594 ...	22 595 ...		
UNI ES	CavTap		ISO 2 6H	vap.	HSS-E	→ 22 500 ...			

Overview of machine taps – M

M ISO metric coarse thread									
UNI Blind hole thread									
UNI EL	CavTap		ISO 2 6H	vap.		HSS-E	→ 22 538 ..., 22 539 ...		
UNI DRY	CavTap		ISO 2 6H	TiN		HSS-E	→ 22 654 ...		
UNI			ISO 2 6H	vap.		HSS-E	→ 23 118 ... → 23 119 ...		
UNI			ISO 2 6H	TiN		HSS-E	→ 23 120 ... → 23 121 ...		
UNI			ISO 2 6H	TiN		HSS-PM	→ 23 026 ... → 23 027 ...		
UNI			ISO 2 6H	TiCN		HSS-E	→ 23 122 ... → 23 123 ...		
UNI NC			ISO 2 6H	TiN GS		HSS-E	→ 23 124 ..., 23 125 ...		
UNI NCW			ISO 2 6H	TiCN		HSS-PM	→ 23 126 ..., 23 127 ...		

P Through hole thread									
HR	TruTap		ISO 2X 6HX	AlTiNHD		HSS-PM	→ 22 468 ...		
ST	TruTap		ISO 1 4H			HSS-E	→ 22 002 ..., 22 003 ...		
ST	TruTap		ISO 2 6H			HSS-E	→ 22 020 ..., 22 021 ...		
ST	TruTap		ISO 3 6G			HSS-E	→ 22 004 ...		
ST EL	TruTap		ISO 2 6H			HSS-E	→ 22 233 ..., 22 234 ...		
ST LH	TruTap		ISO 2 6H			HSS-E	→ 22 127 ..., 22 147 ...		
ST MMB	TruTap		ISO 2 6H			HSS-E	→ 22 098 ...		
FE			ISO 2 6H			HSS-E	→ 23 212 ..., 23 213 ...		
FE-HF			ISO 2 6H	TiCN		HSS-E	→ 23 310 ..., 23 311 ...		
FE ES			ISO 2 6H			HSS-E	→ 23 210 ...		

M ISO metric coarse thread									
P Blind hole thread									
HR	CavTap		ISO 2 6H			HSS-PM	→ 22 498 ...		
HR	CavTap		ISO 2 6H	OSM		HSS-PM	→ 22 499 ...		
ST	CavTap		ISO 2 6H	TiN		HSS-E	→ 22 084 ..., 22 085 ...		
ST	CavTap		ISO 2 6H	vap.		HSS-E	→ 22 086 ...		
ST	CavTap		ISO 2 6H			HSS-E	→ 22 082 ..., 22 083 ...		
ST	CavTap		ISO 3 6G			HSS-E	→ 22 649 ...		
ST CNC	CavTap SL		ISO 2X 6HX	TiN		HSS-E	→ 22 328 ..., 22 329 ...		
ST CNC	CavTap SL		ISO 2X 6HX	TiN		HSS-E	→ 22 443 ...		
ST TS	CavTap SL		ISO 2 6H	TiN		HSS-PM	→ 22 094 ...		
ST ES	CavTap SL		ISO 2 6H			HSS-E	→ 22 016 ...		
ST ES	CavTap		ISO 2 6H			HSS-E	→ 22 529 ...		
ST EL	CavTap SL		ISO 2 6H			HSS-E	→ 22 078 ..., 22 080 ...		
ST EL	CavTap		ISO 2 6H			HSS-E	→ 22 422 ...		
ST LH	CavTap		ISO 2 6H			HSS-E	→ 22 650 ..., 22 651 ...		
FE			ISO 2 6H			HSS-E	→ 23 214 ..., 23 215 ...		
FE			ISO 2 6H			HSS-E	→ 23 216 ..., 23 217 ...		
FE-HF			ISO 2 6H	TiCN		HSS-E	→ 23 312 ..., 23 313 ...		

Overview of machine taps – M

M ISO metric coarse thread						
P Through hole thread and blind hole thread						
HR	DuoTap		ISO 2X 6HX	TiCN	HSS-E	→ 22 126 ..., 22 141 ...
HR	DuoTap		ISO 2X 6HX	nitr.	HSS-E	→ 22 006 ..., 22 007 ...
HR EL	DuoTap		ISO 2X 6HX	nitr.	HSS-E	→ 22 122 ..., 22 123 ...
ST	DuoTap		ISO 2X 6HX		HSS-E	→ 22 028 ... → 22 029 ...
ST ES	DuoTap		ISO 2X 6HX		HSS-E	→ 22 018 ...
ST LH/ES	DuoTap		ISO 2X 6HX		HSS-E	→ 22 019 ...

M Through hole thread						
VA	TruTap		ISO 2 6H	nitr.	HSS-E	→ 22 056 ..., 22 057 ...
VA	TruTap		ISO 2 6H	TiN GS	HSS-E	→ 22 038 ..., 22 039 ...
VA			ISO 2 6H	TiN	HSS-E	→ 23 412 ..., 23 413 ...
VA			ISO 2 6H	nitr.	HSS-PM	→ 23 450 ..., 23 451 ...
VA			ISO 2 6H	nitr.	HSS-E	→ 23 410 ..., 23 411 ...

M Blind hole thread						
VA	CavTap		ISO 2 6H	TiN GS		HSS-E → 22 042 ...
VA	CavTap		ISO 2 6H	TiN GS		HSS-E → 22 040 ..., 22 041 ...
VA	CavTap		ISO 2 6H	vap.		HSS-E → 22 090 ..., 22 091 ...
VA			ISO 2 6H			HSS-E → 23 414 ..., 23 415 ...
VA			ISO 2 6H	TiN		HSS-E → 23 416 ..., 23 417 ...
VA			ISO 2 6H			HSS-PM → 23 426 ..., 23 427 ...
VA			ISO 2 6H	TiN		HSS-PM → 23 456 ..., 23 457 ...

M ISO metric coarse thread						
K Through hole thread and blind hole thread						
GG HML	DuoTap		ISO 2 6H	AlCrN		HSS-E → 22 472 ...
GG HML	DuoTap		ISO 2X 6HX			HSS-E → 22 471 ...
GG	DuoTap		ISO 2X 6HX	nitr.		HSS-E → 22 036 ...
GG	DuoTap		ISO 2X 6HX	nitr.		HSS-E → 22 032 ..., 22 033 ...
GG			ISO 2X 6HX	nitr.		HSS-E → 23 510 ..., 23 511 ...
GG			ISO 2X 6HX	TiCN		HSS-E → 23 512 ..., 23 513 ...

N Through hole thread						
NW	TruTap		ISO 2 6H	DLC		HSS-E → 22 657 ...
Soft	TruTap		ISO 2 6H	DLC		HSS-E → 22 648 ...
AL			ISO 2 6H	CrN		HSS-E → 23 612 ...
AL			ISO 2 6H			HSS-E → 23 610 ...

N Blind hole thread						
NW	CavTap		ISO 2 6H	DLC		HSS-E → 22 655 ...
Soft	CavTap		ISO 2 6H	DLC		HSS-E → 22 653 ...
Soft	CavTap		ISO 2 6H			HSS-E → 22 326 ...
AL			ISO 2 6H			HSS-E → 23 616 ...
AL			ISO 2 6H	CrN		HSS-E → 23 614 ..., 23 615 ...

N Through hole thread and blind hole thread						
Ms	DuoTap		ISO 2X 6HX			HSS-E → 22 119 ...
AMPCO	DuoTap		ISO 2X 6HX			HSS-PM → 22 030 ...

Overview of machine taps – M / EG M

M ISO metric coarse thread						
S Through hole thread						
Ti	TruTap	B 4-5	ISO 1X 4HX	TiN.	HSS-PM	→ 22 081 ...
Ti	TruTap	B 4-5	ISO 2X 6HX	TiN	HSS-PM	→ 22 077 ..., 22 142 ...
Ti	TruTap	B 4-5	ISO 2X 6HX	vap.	HSS-PM	→ 22 075 ...
Ti AZ	TruTap	B 4-5	ISO 2X 6HX	vap.	HSS-PM	→ 22 140 ...
Ti	TruTap DL	D 4-5	ISO 2X 6HX	TiCN	HSS-E	→ 22 159 ..., 22 160 ...
Ni	TruTap DL	D 4-5	ISO 2X 6HX	TiCN	HSS-E	→ 22 297 ..., 22 298 ...
S Blind hole thread						
Ti	CavTap SL	C 2-3	ISO 2X 6HX	TiN	HSS-PM	→ 22 076 ...
Ti	CavTap SL	C 2-3	ISO 2X 6HX	TiCN	HSS-PM	→ 22 163 ..., 22 164 ...
Ti	CavTap SL	C 2-3	ISO 2X 6HX	vap.	HSS-PM	→ 22 074 ...
Ni	CavTap SL	C 2-3	ISO 2X 6HX	TiCN	HSS-PM	→ 22 424 ..., 22 425 ...
H Through hole thread and blind hole thread						
HT	DuoTap	C 2-3	ISO 2X 6HX	TiCN	HSS-PM	→ 22 227 ..., 22 228 ...
HT	DuoTap	D 4-5	ISO 2X 6HX	OSM	VHM	→ 22 806 ...

EG M ISO metric coarse thread for wire inserts						
UNI Through hole thread						
UNI	TruTap	B 4-5	6H mod	nitr. + vap.	HSS-E	→ 22 662 ..., 22 663 ...
UNI Blind hole thread						
UNI	CavTap	C 2-3	6H mod	vap.	HSS-E	→ 22 664 ..., 22 665 ...
N Blind hole thread						
Soft	CavTap	C 2-3	6H mod	DLC	HSS-E	→ 22 647 ...

Overview of machine taps – MF

MF ISO metric fine thread						
UNI Through hole thread						
UNI-HP	TruTap		ISO 2X 6HX	AlTiNHD	HSS-E-PM	→ 22 864 ..., 22 865 ...
UNI	TruTap		ISO 2 6H	TiN	HSS-E	→ 22 550 ... → 22 552 ...
UNI	TruTap		ISO 2 6H	nitr. + vap.	HSS-E	→ 22 551 ...
UNI	TruTap		ISO 3 6G	nitr. + vap.	HSS-E	→ 22 599 ...
UNI			ISO 2 6H	nitr. + vap.	HSS-E	→ 23 140 ... → 23 141 ...
UNI			ISO 2 6H	TiN	HSS-E	→ 23 142 ... → 23 143 ...
UNI			ISO 2 6H	TiN	HSS-PM	→ 23 041 ...
UNI Blind hole thread						
UNI-HP	CavTap		ISO 2X 6HX	AlTiNHD	HSS-E-PM	→ 22 831 ...
UNI-HP	CavTap		ISO 2X 6HX	AlTiNHD	HSS-E-PM	→ 22 822 ...
UNI-HP	CavTap		ISO 2X 6HX	AlTiNHD		HSS-E-PM → 22 837 ...
UNI	CavTap		ISO 2 6H	TiN	HSS-E	→ 22 556 ...
UNI	CavTap		ISO 2 6H	vap.	HSS-E	→ 22 555 ...
UNI	CavTap		ISO 3 6G	vap.	HSS-E	→ 22 441 ..., 22 490 ...
UNI	CavTap		ISO 2 6H	TiN	HSS-E	→ 22 554 ...
UNI	CavTap		ISO 2 6H	vap.	HSS-E	→ 22 553 ...
UNI	CavTap		ISO 2 6H	vap.	HSS-E	→ 22 646 ..., 22 659 ...
UNI CNC	CavTap		ISO 2 6H	TiN GS	HSS-E	→ 22 548 ..., 22 549 ...
UNI CNC	CavTap		ISO 3 6G	TiN GS	HSS-E	→ 22 561 ...
UNI CNC	CavTap		7G	TiN GS	HSS-E	→ 22 563 ...
UNI			ISO 2 6H	vap.	HSS-E	→ 23 144 ... → 23 145 ...
UNI			ISO 2 6H	TiN	HSS-E	→ 23 146 ... → 23 147 ...
UNI			ISO 2 6H	TiN	HSS-PM	→ 23 047 ...

MF ISO metric fine thread						
UNI Blind hole thread						
UNI NC		ISO 2 6H	TiN GS	HSS-E	→ 23 149 ...	
P Through hole thread						
FE		ISO 2 6H		HSS-E	→ 23 241 ...	
FE-HF		ISO 2 6H	TiCN	HSS-E	→ 23 340 ..., 23 341 ...	
P Blind hole thread						
ST	CavTap SL		ISO 2 6H	HSS-E	→ 22 182 ...	
FE			ISO 2 6H	HSS-E	→ 23 243 ...	
FE-HF			ISO 2 6H	TiCN	HSS-E → 23 342 ..., 23 343 ...	
P Through hole thread and blind hole thread						
HR	DuoTap		ISO 2X 6HX	nitr.	HSS-E → 22 146 ..., 22 209 ...	
ST	DuoTap		ISO 2X 6HX	HSS-E	→ 22 171 ...	
ST ES	DuoTap		ISO 2X 6HX	HSS-E	→ 22 179 ...	
ST LH/ES	DuoTap		ISO 2X 6HX	HSS-E	→ 22 200 ...	
M Through hole thread						
VA			ISO 2 6H	TiN	HSS-E → 23 440 ..., 23 441 ...	
M Blind hole thread						
VA	CavTap		ISO 2 6H	vap.	HSS-E → 22 189 ...	
VA	CavTap		ISO 2 6H	TiN GS	HSS-E → 22 176 ..., 22 177 ...	
VA			ISO 2 6H	TiN	HSS-E → 23 442 ..., 23 443 ...	
VA			ISO 2 6H		HSS-PM → 23 447 ...	

Overview of machine taps – G

G Whitworth pipe thread						
UNI Through hole thread						
UNI	TruTap		ISO 228	TiN	HSS-E	→ 22 630 ...
UNI			ISO 228	TiN	HSS-E	→ 23 160 ...
UNI			ISO 228	nitr. + vap.	HSS-E	→ 23 161 ...
UNI Blind hole thread						
UNI-HP	CavTap		ISO 228 X	AlTiNHD	HSS-E-PM	→ 22 832 ...
UNI-HP	CavTap		ISO 228 X	AlTiNHD	HSS-E-PM	→ 22 842 ...
UNI-HP	CavTap		ISO 228 X	AlTiNHD	HSS-E-PM	→ 22 823 ...
UNI	CavTap		ISO 228	TiN	HSS-E	→ 22 636 ...
UNI	CavTap		ISO 228	vap.	HSS-E	→ 22 635 ...
UNI	CavTap		ISO 228 +0,05	vap.	HSS-E	→ 22 639 ...
UNI	CavTap		ISO 228	TiN	HSS-E	→ 22 634 ...
UNI	CavTap		ISO 228	vap.	HSS-E	→ 22 633 ...
UNI CNC	CavTap		ISO 228	TiN GS	HSS-E	→ 22 624 ...
UNI			ISO 228	vap.	HSS-E	→ 23 163 ...
UNI			ISO 228	TiN	HSS-E	→ 23 162 ...

G Whitworth pipe thread						
P Through hole thread						
FE			ISO 228		HSS-E	→ 23 260 ...
P Blind hole thread						
ST	CavTap		ISO 228		HSS-E	→ 22 354 ...
ST	CavTap SL		ISO 228		HSS-E	→ 22 353 ...
FE			ISO 228		HSS-E	→ 23 261 ...
P Through hole thread and blind hole thread						
HR	DuoTap		ISO 228 X	nitr.	HSS-E	→ 22 339 ...
M Through hole thread						
VA	TruTap		ISO 228	nitr.	HSS-E	→ 22 352 ...
M Blind hole thread						
VA	CavTap		ISO 228	vap.	HSS-E	→ 22 355 ...
VA	CavTap		ISO 228	TiN GS	HSS-E	→ 22 358 ...
K Through hole thread and blind hole thread						
GG	DuoTap		ISO 228 X	nitr.	HSS-E	→ 22 348 ...
N Blind hole thread						
NW	CavTap		ISO 228	DLC	HSS-E	→ 22 656 ...

Overview of machine taps – UNC / EG UNC / UNJC

UNC Unified coarse thread									
UNI Through hole thread									
UNI	TruTap	B 4-5	2B	nitr. + vap.	HSS-E	→	22 572 ...	22 573 ...	
UNI	TruTap	B 4-5	3B	nitr. + vap.	HSS-E	→	22 574 ...		
UNI		B 4-5	2B	TiN	HSS-E	→	23 170 ...	23 171 ...	
UNI Blind hole thread									
UNI-HP	CavTap	C 2-3	2BX	AlTiNHD	HSS-E- PM	→	22 824 ...	22 825 ...	
UNI	CavTap	C 2-3	2B	vap.	HSS-E	→	22 582 ...	22 583 ...	
UNI	CavTap	C 2-3	2B	vap.	HSS-E	→	22 669 ...		
UNI	CavTap	C 2-3	2B +0,05	vap.	HSS-E	→	22 277 ...		
UNI		C 2-3	2B	TiN	HSS-E	→	23 172 ...	23 173 ...	

P Through hole thread									
ST	TruTap	B 4-5	2B		HSS-E	→	22 240 ...		
FE-HF		B 4-5	2B	TiCN	HSS-E	→	23 370 ...		
P Blind hole thread									
ST	CavTap	C 2-3	2B		HSS-E	→	22 264 ...		
FE-HF		C 2-3	2B	TiCN	HSS-E	→	23 372 ...		

M Through hole thread									
VA	TruTap	B 4-5	2B	nitr.	HSS-E	→	22 250 ...	22 251 ...	
VA		B 4-5	2B	nitr.	HSS-E	→	23 470 ...		
M Blind hole thread									
VA	CavTap	C 2-3	2B	vap.	HSS-E	→	22 266 ...	22 267 ...	
VA		C 2-3	2B		HSS-E	→	23 472 ...		

UNC Unified coarse thread									
S Through hole thread									
Ti	TruTap	B 4-5	2BX	TiN	HSS-PM	→	22 269 ...		
S Blind hole thread									
Ti	CavTap SL	C 2-3	2BX	vap.	HSS-PM	→	22 262 ...		

EG UNC Unified coarse thread for wire inserts									
UNI Through hole thread									
UNI	TruTap	B 4-5	2B mod	nitr. + vap.	HSS-E	→	22 668 ...		
UNI Blind hole thread									
UNI	CavTap	E 1,5-2	2B mod	vap.	HSS-E	→	22 672 ...		

UNJC Unified coarse thread									
S Blind hole thread									
Ti	CavTap SL	C 2-3	3BX	TiCN	HSS-E	→	22 166 ...		

Overview of machine taps – UNF / EG UNF / UNJF

UNF Unified fine thread									
 UNI Through hole thread									
UNI	TruTap		2B	nitr. + vap.	HSS-E	→	22 602 ...	22 603 ...	
UNI			2B	TiN	HSS-E	→	23 180 ...	23 181 ...	
 UNI Blind hole thread									
UNI-HP	CavTap		2BX	AlTiNHD	HSS-E-PM	→	22 826 ...		
UNI	CavTap		2B +0,05	vap.	HSS-E	→	22 307 ...	22 409 ...	
UNI	CavTap		2B	vap.	HSS-E	→	22 606 ...	22 607 ...	
UNI			2B	TiN	HSS-E	→	23 182 ...	23 183 ...	
 P Through hole thread									
ST	TruTap		2B		HSS-E	→	22 288 ...	22 289 ...	
 P Blind hole thread									
FE			2B		HSS-E	→	23 282 ...	23 283 ...	

 M Blind hole thread									
VA	CavTap		2B	vap.	HSS-E	→	22 308 ...		
VA			2B		HSS-E	→	23 482 ...	23 483 ...	

 K Through hole thread and blind hole thread									
GG	DuoTap		2BX	nitr.	HSS-E	→	22 295 ...		

 S Blind hole thread									
Ti	CavTap SL		2BX	vap.	HSS-PM	→	22 302 ...		
Ti	CavTap SL		3BX	vap.	HSS-PM	→	22 303 ...		

EG UNF Unified fine thread for wire inserts									
 UNI Through hole thread									
UNI	TruTap		2B	nitr. + vap.	HSS-E	→	22 676 ...		
 UNI Blind hole thread									
UNI	CavTap		2B	vap.	HSS-E	→	22 680 ...		
UNJF Unified extra-fine thread									
 S Through hole thread									
Ti	TruTap DL		3BX	TiCN	HSS-E	→	22 167 ...		
 S Blind hole thread									
Ti	CavTap SL		3BX	TiCN	HSS-E	→	22 168 ...		

Overview of machine taps – NPT / NPTF / BSW / Rp / Rc

NPT American taper pipe thread				
P Through hole thread and blind hole thread				
ST ES	DuoTap		HSS-E	→ 22 361 ...
VG	DuoTap		HSS-E	→ 22 374 ..., 22 375 ...
VG AZ	DuoTap		HSS-E	→ 22 377 ..., 22 378 ...

M Blind hole thread				
VA	CavTap		TiN	HSS-E → 22 365 ..., 22 372 ...
VA	CavTap		vap.	HSS-E → 22 364 ..., 22 371 ...

NPTF American taper pipe thread				
P Through hole thread and blind hole thread				
ST	DuoTap		HSS-E	→ 22 382 ..., 22 383 ...
ST ES	DuoTap		HSS-E	→ 22 367 ...
VG	DuoTap		HSS-E	→ 22 380 ...

BSW Whitworth thread				
UNI Through hole thread				
UNI	TruTap		med. nitr. + vap.	HSS-E → 22 626 ..., 22 627 ...
UNI Blind hole thread				
UNI	CavTap		med. vap.	HSS-E → 22 686 ..., 22 687 ...

Rp Cylindrical Whitworth thread				
P Through hole thread and blind hole thread				
ST	DuoTap		X	HSS-E → 22 381 ...

Rc Tapered Whitworth thread				
P Through hole thread and blind hole thread				
ST	DuoTap		HSS-E	→ 22 389 ...

Overview of machine thread formers – M / MF / G / UNC / UNF

M ISO metric coarse thread						
UNI Through hole thread and blind hole thread						
UNI-HP SN	DuoForm	E 1,5-2	ISO 2X 6HX	TiN	HSS-E-PM	→ 22 860 ..., 22 861 ...
UNI-HP SN	DuoForm	C 2-3	ISO 2X 6HX	TiN	HSS-E-PM	→ 22 853 ..., 22 854 ...
UNI-HP SN	DuoForm	C 2-3	ISO 2X 6HX	TiN	HSS-E-PM	→ 22 857 ..., 22 858 ...
UNI		C 2-3	ISO 2X 6HX	TiN	HSS-E	→ 23 810 ..., 23 811 ...
UNI		C 2-3	ISO 2X 6HX	CrN	HSS-E	→ 23 812 ..., 23 813 ...
UNI SN		C 2-3	ISO 2X 6HX	TiN	HSS-E	→ 23 814 ..., 23 815 ...
UNI SN		C 2-3	ISO 2X 6HX	CrN	HSS-E	→ 23 816 ..., 23 817 ...
EC	DuoForm	C 2-3	ISO 2X 6HX	TiN	HSS-E	→ 22 100 ..., 22 101 ...
EC SN	DuoForm	C 2-3	ISO 2X 6HX	nitr.	HSS-E	→ 22 104 ...
EC SN	DuoForm	C 2-3	ISO 2X 6HX	TiN GS	HSS-E	→ 22 154 ...
EC SN	DuoForm	C 2-3	ISO 2X 6HX	TiN	HSS-E	→ 22 105 ..., 22 106 ...
EC SN	DuoForm	C 2-3	ISO 3X 6GX	TiN	HSS-E	→ 22 108 ...
NEO SN	DuoForm	C 2-3	ISO 2X 6HX	TiN	HSS-PM	→ 22 452 ...
NEO SN	DuoForm	C 2-3	ISO 2X 6HX	TiN	HSS-PM	→ 22 453 ..., 22 454 ...
N Through hole thread and blind hole thread						
AL SN	DuoForm	E 1,5-2	ISO 2X 6HX	DLC	HSS-E-PM	→ 22 846 ...
AL SN	DuoForm	E 1,5-2	ISO 2X 6HX	DLC	HSS-E-PM	→ 22 848 ...
AL SN	DuoForm	C 2-3	ISO 2X 6HX	DLC	HSS-E-PM	→ 22 845 ...
AL SN	DuoForm	C 2-3	ISO 2X 6HX	DLC	HSS-E-PM	→ 22 847 ...
G-AL SN	DuoForm	E 1,5-2	ISO 2X 6HX	TiCN	HSS-E-PM	→ 22 850 ...
G-AL SN	DuoForm	E 1,5-2	ISO 2X 6HX	TiCN	HSS-E-PM	→ 22 852 ...
G-AL SN	DuoForm	C 2-3	ISO 2X 6HX	TiCN	HSS-E-PM	→ 22 849 ...
G-AL SN	DuoForm	C 2-3	ISO 2X 6HX	TiCN	HSS-E-PM	→ 22 851 ...

M ISO metric coarse thread						
N Through hole thread and blind hole thread						
NW HML	DuoForm	C 2-3	ISO 2X 6HX		HSS-E / HM	→ 22 473 ...
MF ISO metric fine thread						
UNI Through hole thread and blind hole thread						
UNI-HP SN	DuoForm	E 1,5-2	ISO 2X 6HX	TiN	HSS-E-PM	→ 22 868 ...
UNI-HP SN	DuoForm	C 2-3	ISO 2X 6HX	TiN	HSS-E-PM	→ 22 855 ..., 22 856 ...
UNI-HP SN	DuoForm	C 2-3	ISO 2X 6HX	TiN	HSS-E-PM	→ 22 859 ...
UNI SN		C 2-3	ISO 2X 6HX	TiN	HSS-E	→ 23 842 ..., 23 843 ...
EC SN	DuoForm	C 2-3	ISO 2X 6HX	TiN	HSS-E	→ 22 205 ..., 22 197 ...
EC HML	DuoForm	C 2-3	ISO 2X 6HX	TiN	HSS-E / HM	→ 22 474 ...
EC HML	DuoForm	C 2-3	ISO 2X 6HX	TiN	HSS-E / HM	→ 22 474 ...
G Whitworth pipe thread						
UNI Through hole thread and blind hole thread						
EC SN	DuoForm	C 2-3	ISO 228	TiN	HSS-E	→ 22 359 ...
UNC Unified coarse thread						
UNI Through hole thread and blind hole thread						
EC	DuoForm	C 2-3	2BX	TiN	HSS-E	→ 22 270 ...
EC SN	DuoForm	C 2-3	2BX	TiN	HSS-E	→ 22 271 ...
UNF Unified fine thread						
UNI Through hole thread and blind hole thread						
EC SN	DuoForm	C 2-3	2BX	TiN	HSS-E	→ 22 312 ..., 22 313 ...

Overview of hand taps – M / MF / G / UNC

M ISO metric coarse thread					
ST		ISO 2X 6HX	VHM	→ 22 800 ...	
ST		ISO 2X 6HX	HSS-E	→ 22 010 ...	
ERGO		ISO 2X 6HX	HSS-E	→ 22 012 ...	
ERGO F.T.		ISO 2X 6HX	nitr.	HSS-E	→ 22 013 ...

MF ISO metric fine thread					
ST		ISO 2X 6HX	HSS-E	→ 22 151 ...	

G Whitworth pipe thread					
ERGO		ISO 228	HSS-E	→ 22 342 ...	

UNC Unified coarse thread					
ERGO		2BX	HSS-E	→ 22 237 ...	

Overview of dies – M / MF / G / UNC / UNF / NPT

M ISO metric coarse thread			
FE		ISO 6e	HSS → 22 701 ...
FE		ISO 6g	HSS → 22 700 ...
FE		ISO 6g	HSS → 23 910 ...
FE R _z =1		ISO 6g	HSS → 22 703 ...
FE LH		ISO 6g	HSS → 22 702 ...
VA		ISO 6g	HSS-E → 22 704 ...
VA R _z =1		ISO 6g	HSS-E → 22 705 ...
Ms R _z =1		ISO 6g	HSS-E → 22 706 ...

MF ISO metric fine thread			
FE		ISO 6g	HSS → 23 940 ...
FE		ISO 6g	HSS → 22 711 ...
FE LH		ISO 6g	HSS → 22 712 ...
VA		ISO 6g	HSS-E → 22 714 ...

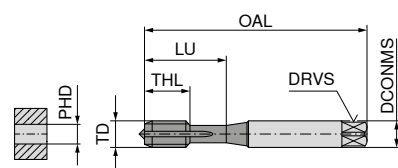
G Whitworth pipe thread			
FE		ISO 228 A	HSS → 22 741 ...

UNC Unified coarse thread			
FE		2A	HSS → 22 721 ...

UNF Unified fine thread			
FE		2A	HSS → 22 726 ...

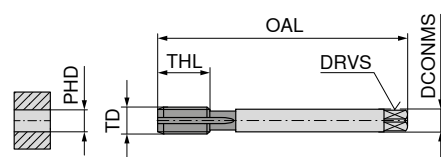
NPT American taper pipe thread			
FE			HSS → 22 747 ...

CoreLine – Through hole – machine taps, right-hand – TruTap



DIN 371 With reinforced shank

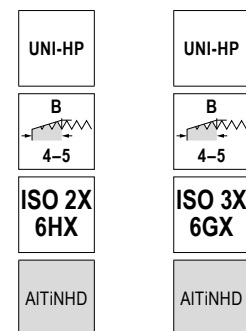
TD mm	TP mm	OAL mm	DCONMS _{h9} mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M2	0.40	45	2.8	2.1	1.60	4	12	2
M2,5	0.45	50	2.8	2.1	2.05	5	15	2
M3	0.50	56	3.5	2.7	2.50	6	18	3
M3,5	0.60	56	4.0	3.0	2.90	7	20	3
M4	0.70	63	4.5	3.4	3.30	7	21	3
M5	0.80	70	6.0	4.9	4.20	8	25	3
M6	1.00	80	6.0	4.9	5.00	10	30	3
M8	1.25	90	8.0	6.2	6.80	14	35	4
M10	1.50	100	10.0	8.0	8.50	16	39	4



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS _{h9} mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7.0	10.2	18	4
M14	2.00	110	11	9.0	12.0	20	4
M16	2.00	110	12	9.0	14.0	22	4
M20	2.50	140	16	12.0	17.5	25	4
M24	3.00	160	18	14.5	21.0	30	4
M30	3.50	180	22	18.0	26.5	35	4

P	2-18	2-18
M	2-10	2-10
K	10-20	10-20
N	15-30	15-30
S		
H		
O		



HSS-E-PM
FHA 0°
≤ 1400 N/mm²
≤ 4xD



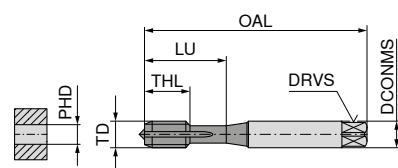
HSS-E-PM
FHA 0°
≤ 1400 N/mm²
≤ 4xD

NEW TP	NEW TP
22 862 ...	22 866 ...
02000	02000
02500	02500
03000	03000
03500	
04000	04000
05000	05000
06000	06000
08000	08000
10000	10000

TP	TP
22 863 ...	22 867 ...
12000	12000
14000	
16000	16000
20000	20000
24000	24000
30000	

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand – TruTap



DIN 371 With reinforced shank

TD	TP	OAL	DCONMS ₁₉	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
M1	0.25	40	2.5	2.1	0.75	5	5	2
M1,2	0.25	40	2.5	2.1	0.95	5	5	2
M1,4	0.30	40	2.5	2.1	1.10	7	7	3
M1,6	0.35	40	2.5	2.1	1.25	8	11	3
M1,7	0.35	40	2.5	2.1	1.35	6	11	2
M1,8	0.35	40	2.5	2.1	1.45	6	11	2
M2	0.40	45	2.8	2.1	1.60	7	12	2
M2	0.40	45	2.8	2.1	1.60	7	12	3
M2,2	0.45	45	2.8	2.1	1.75	7	12	2
M2,5	0.45	50	2.8	2.1	2.05	9	14	2
M3	0.50	56	3.5	2.7	2.50	11	18	3
M3,5	0.60	56	4.0	3.0	2.90	12	20	3
M4	0.70	63	4.5	3.4	3.30	13	21	3
M5	0.80	70	6.0	4.9	4.20	15	25	3
M6	1.00	80	6.0	4.9	5.00	17	30	3
M7	1.00	80	7.0	5.5	6.00	17	30	3
M8	1.25	90	8.0	6.2	6.80	20	35	3
M10	1.50	100	10.0	8.0	8.50	22	39	3
M12	1.75	110	12.0	9.0	10.20	24	44	3

P	2-18	12	15	12	12
M	2-10	7	9	7	7
K	10-20	12	18	12	12
N	15-30		12		
S					
H					
O					

1) Tol. ISO 14H ≤ M1.4

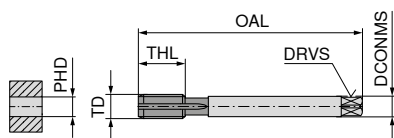
Cutting speed v_c (m/min)



See next page for DIN 376.

UNI	UNI	UNI	UNI	UNI
B 4-5	B 4-5	B 4-5	B 4-5	B 4-5
ISO 2 6H	ISO 2 6H	ISO 2 6H	ISO 3 6G	7G
AlTiNHD	nitr. + vap.	TiN	nitr. + vap.	nitr. + vap.
HSS-E FHA 0° ≤ 1100 N/mm² ≤ 4xD	HSS-E FHA 0° ≤ 1100 N/mm² ≤ 4xD	HSS-E FHA 0° ≤ 1100 N/mm² ≤ 4xD	HSS-E FHA 0° ≤ 1100 N/mm² ≤ 4xD	HSS-E FHA 0° ≤ 1100 N/mm² ≤ 4xD
TP 22 658 ...	TP 22 501 ...	TP 22 503 ...	TP 22 508 ...	TP 22 510 ...
	010 ¹⁾			
	012 ¹⁾			
	014 ¹⁾			
	016			
	017			
	018			
	020	020		020
	022			
	025		025	025
03000	030	030	030	030
	035			
04000	040	040	040	040
05000	050	050	050	050
06000	060	060	060	060
	070			
08000	080	080	080	080
10000	100	100	100	100
	120			

CoreLine – Through hole – machine taps, right-hand – TruTap



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M3	0.50	56	2.2		2.5	11	3
M4	0.70	63	2.8	2.1	3.3	13	3
M5	0.80	70	3.5	2.7	4.2	15	3
M6	1.00	80	4.5	3.4	5.0	17	3
M8	1.25	90	6.0	4.9	6.8	20	3
M10	1.50	100	7.0	5.5	8.5	22	3
M12	1.75	110	9.0	7.0	10.2	24	3
M14	2.00	110	11.0	9.0	12.0	26	3
M16	2.00	110	12.0	9.0	14.0	27	3
M18	2.50	125	14.0	11.0	15.5	30	3
M20	2.50	140	16.0	12.0	17.5	32	3
M22	2.50	140	18.0	14.5	19.5	32	3
M24	3.00	160	18.0	14.5	21.0	34	3
M27	3.00	160	20.0	16.0	24.0	36	3
M30	3.50	180	22.0	18.0	26.5	40	4

P	12	15	12	12
M	7	9	7	7
K	12	18	12	12
N		12		
S				
H				
O				

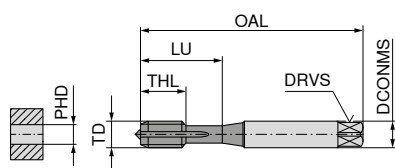
Cutting speed v_c (m/min)

UNI	UNI	UNI	UNI
B 4-5	B 4-5	B 4-5	B 4-5
ISO 2 6H	ISO 2 6H	ISO 3 6G	7G
nit. + vap.	TiN	nit. + vap.	nit. + vap.
HSS-E FHA 0° ≤ 1100 N/mm² ≤ 4xD	HSS-E FHA 0° ≤ 1100 N/mm² ≤ 4xD	HSS-E FHA 0° ≤ 1100 N/mm² ≤ 4xD	HSS-E FHA 0° ≤ 1100 N/mm² ≤ 4xD

TP	TP	TP	TP
22 502 ...	22 504 ...	22 509 ...	22 511 ...
030			
040			
050			
060			
080			
100			
120	120	120	120
140	140		
160	160	160	160
180	180		
200	200	200	
220	220		
240	240		
270			
300			

CoreLine – Through hole – machine taps, right-hand

M



DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M2	0.40	45	2.8	2.1	1.60	4	13.5	2
M2	0.40	45	2.8	2.1	1.60	7	12.0	2
M2,5	0.45	50	2.8	2.1	2.05	9	14.0	2
M3	0.50	56	3.5	2.7	2.50	11	18.0	3
M4	0.70	63	4.5	3.4	3.30	13	21.0	3
M5	0.80	70	6.0	4.9	4.20	15	25.0	3
M6	1.00	80	6.0	4.9	5.00	17	30.0	3
M8	1.25	90	8.0	6.2	6.80	20	35.0	3
M10	1.50	100	10.0	8.0	8.50	22	39.0	3

P	12	15	15
M	7	9	9
K	12	18	18
N		12	12
S			
H			
O			

Cutting speed v_c (m/min)

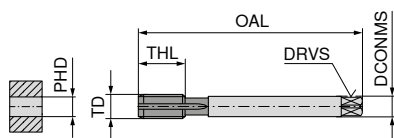
UNI	UNI	UNI
B 4-5	B 4-5	B 4-5
ISO 2 6H	ISO 2 6H	ISO 2 6H
nit. + vap.	TiN	TiN
HSS-E FHA 0° ≤ 1000 N/mm² ≤ 3xD	HSS-E FHA 0° ≤ 1000 N/mm² ≤ 3xD	HSS-PM FHA 0° ≤ 1000 N/mm² ≤ 3xD
CX 23 110 ...	CX 23 112 ...	CX 23 010 ...
020	020	020
025	025	
030	030	030
040	040	040
050	050	050
060	060	060
080	080	080
100	100	100



See next page for DIN 376.

CoreLine – Through hole – machine taps, right-hand

M



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M3	0.50	56	2.2		2.5	11	3
M4	0.70	63	2.8	2.1	3.3	13	3
M5	0.80	70	3.5	2.7	4.2	15	3
M6	1.00	80	4.5	3.4	5.0	17	3
M8	1.25	90	6.0	4.9	6.8	20	3
M10	1.50	100	7.0	5.5	8.5	22	3
M12	1.75	110	9.0	7.0	10.2	24	3
M14	2.00	110	11.0	9.0	12.0	20	4
M16	2.00	110	11.0	9.0	12.0	26	3
M16	2.00	110	12.0	9.0	14.0	27	3
M18	2.50	125	14.0	11.0	15.5	25	4
M18	2.50	125	14.0	11.0	15.5	30	3
M20	2.50	140	16.0	12.0	17.5	32	3
M22	2.50	140	18.0	14.5	19.5	32	3
M24	3.00	160	18.0	14.5	21.0	34	3
M27	3.00	160	20.0	16.0	24.0	36	3
M30	3.50	180	22.0	18.0	26.5	40	4
M33	3.50	180	25.0	20.0	29.5	40	4
M36	4.00	200	28.0	22.0	32.0	50	4

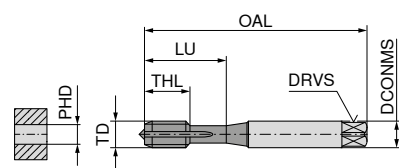
P	12	15	15
M	7	9	9
K	12	18	18
N		12	12
S			
H			
O			

Cutting speed v_c (m/min)

UNI	UNI	UNI
B 4-5	B 4-5	B 4-5
ISO 2 6H	ISO 2 6H	ISO 2 6H
nitr. + vap.	TiN	TiN
HSS-E FHA 0° ≤ 1000 N/mm² ≤ 3xD	HSS-E FHA 0° ≤ 1000 N/mm² ≤ 3xD	HSS-PM FHA 0° ≤ 1000 N/mm² ≤ 3xD
CX 23 111 ...	CX 23 113 ...	CX 23 021 ...
030		
040		
050		
060		
080		
100		
120	120	120
		140
140	14000	
160	160	160
	18000	180
200	200	200
	22000	
	240	
	27000	
	30000	
	33000	
	36000	

CoreLine – Through hole – machine taps, right-hand – TruTap

▲ EL = Extra long, with double overall length



DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M3	0.50	100	3.5	2.7	2.5	11	18	3
M4	0.70	125	4.5	3.4	3.3	13	21	3
M5	0.80	140	6.0	4.9	4.2	15	25	3
M6	1.00	160	6.0	4.9	5.0	17	30	3
M8	1.25	180	8.0	6.2	6.8	20	35	3



HSS-E
FHA 0°
≤ 1100 N/mm²
≤ 4xD

TP

22 514 ...

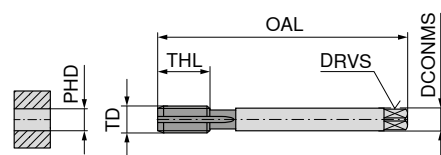
030

040

050

060

080



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M6	1.00	160	4.5	3.4	5.0	17	3
M8	1.25	180	6.0	4.9	6.8	20	3
M10	1.50	200	7.0	5.5	8.5	22	3
M12	1.75	224	9.0	7.0	10.2	24	3
M14	2.00	224	11.0	9.0	12.0	26	3
M16	2.00	224	12.0	9.0	14.0	27	3
M18	2.50	250	14.0	11.0	15.5	30	3
M20	2.50	280	16.0	12.0	17.5	32	3

TP

22 515 ...

060

080

100

120

140

160

180

200

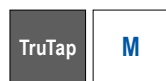
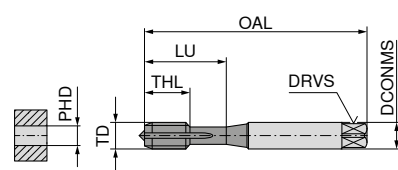
P	12
M	7
K	12
N	
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand – TruTap

▲ CNC = For synchronized CNC machining with minimum length compensation chuck

▲ NCW = With Weldon flat for synchronized CNC machining without length compensation chuck



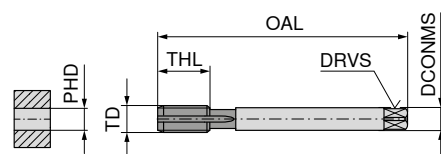
DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M3	0.50	56	3.5	2.7	2.5	6	18	3
M3	0.50	70	6.0	4.9	2.5	6	18	3
M4	0.70	63	4.5	3.4	3.3	7	21	3
M4	0.70	70	6.0	4.9	3.3	7	21	3
M5	0.80	70	6.0	4.9	4.2	8	25	3
M6	1.00	80	6.0	4.9	5.0	10	30	3
M8	1.25	90	8.0	6.2	6.8	14	35	3
M8	1.25	90	8.0	6.2	6.8	14	35	4
M10	1.50	100	10.0	8.0	8.5	16	39	3
M10	1.50	100	10.0	8.0	8.5	16	39	4
M12	1.75	110	10.0	8.0	10.2	18	41	3
M16	2.00	110	12.0	9.0	14.0	22	44	3

UNI NCW	UNI CNC	UNI CNC	UNI CNC
B 4-5	B 4-5	B 4-5	B 4-5
ISO 2 6H	ISO 2X 6HX	ISO 3X 6GX	7GX
TiN	TiN GS	TiN GS	TiN GS

HSS-PM FHA 0° ≤ 1100 N/mm² ≤ 4xD	HSS-E FHA 0° ≤ 1100 N/mm² ≤ 4xD	HSS-E FHA 0° ≤ 1100 N/mm² ≤ 4xD	HSS-E FHA 0° ≤ 1100 N/mm² ≤ 4xD

TP	TP	TP	TP
22 148 ...	22 542 ...	22 596 ...	22 592 ...
030	030		
040	040	040	040
050	050	050	050
060	060	060	060
080	080	080	080
100	100	100	100
120			
160			



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7	10.2	18	4
M14	2.00	110	11	9	12.0	20	4
M16	2.00	110	12	9	14.0	22	4
M20	2.50	140	16	12	17.5	25	4

TP	TP
22 543 ...	22 593 ...
120	120
140	
160	
200	

P	15	15	15	15
M	8	9	9	9
K	15	18	18	18
N	22	12	12	12
S				
H				
O				

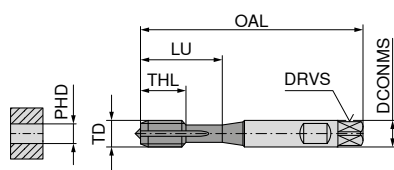
Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand

▲ NCW = With Weldon flat for synchronized CNC machining without length compensation chuck

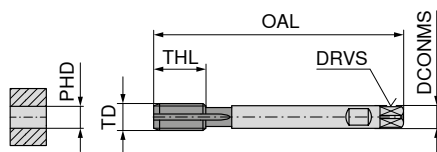
▲ NC = For synchronized CNC machining with minimum length compensation chuck

M



DIN 371 With reinforced shank

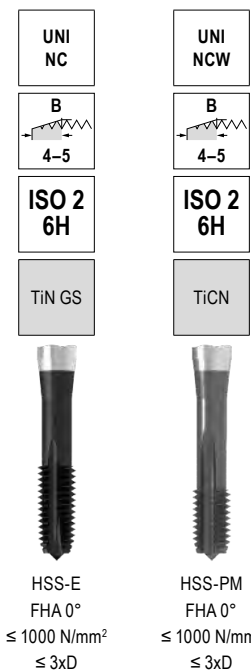
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M3	0.50	56	3.5	2.7	2.5	11	18	3
M3	0.50	70	6.0	4.9	2.5	6	18	3
M4	0.70	63	4.5	3.4	3.3	13	21	3
M4	0.70	70	6.0	4.9	3.3	7	21	3
M5	0.80	70	6.0	4.9	4.2	8	25	3
M5	0.80	70	6.0	4.9	4.2	15	25	3
M6	1.00	80	6.0	4.9	5.0	10	30	3
M6	1.00	80	6.0	4.9	5.0	17	30	3
M8	1.25	90	8.0	6.2	6.8	14	35	3
M8	1.25	90	8.0	6.2	6.8	20	35	3
M10	1.50	100	10.0	8.0	8.5	16	39	3
M10	1.50	100	10.0	8.0	8.5	22	39	3



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7	10.2	24	3
M12	1.75	110	10	8	10.2	18	3
M16	2.00	110	12	9	14.0	27	3
M16	2.00	110	12	9	14.0	22	3
M20	2.50	140	16	12	17.5	32	3

P	15	15
M	9	8
K	18	15
N	12	22
S		
H		
O		



CX	CX
23 114 ...	23 116 ...
030	030
040	040
050	050
060	060
080	080
100	100

CX	CX
23 115 ...	23 117 ...
120	120
160	160
200	

CoreLine – Through hole – machine taps, right-hand – TruTap

TruTap

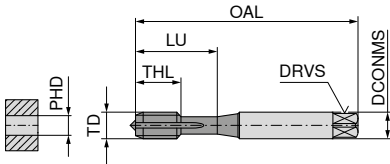
M

HR



ISO 2X
6HX

AlTiNHD



DIN 371 With reinforced shank



HSS-PM
FHA 0°
≤ 1400 N/mm²
≤ 4xD

TD	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
M2	0.40	45	2.8	2.1	1.60	7	12	2
M2,5	0.45	50	2.8	2.1	2.05	9	14	2
M3	0.50	56	3.5	2.7	2.50	11	18	2
M4	0.70	63	4.5	3.4	3.30	13	21	2
M5	0.80	70	6.0	4.9	4.20	15	25	2
M6	1.00	80	6.0	4.9	5.00	17	30	3
M8	1.25	90	8.0	6.2	6.80	20	35	3
M10	1.50	100	10.0	8.0	8.50	22	39	3

TP

22 468 ...

02000

02500

03000

04000

05000

06000

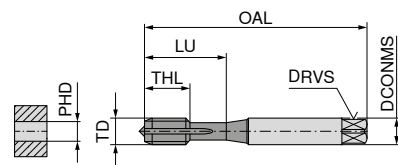
08000

10000

P	8
M	8
K	
N	10
S	4
H	
O	

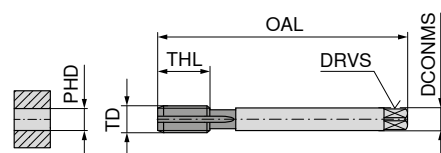
Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand – TruTap



DIN 371 With reinforced shank

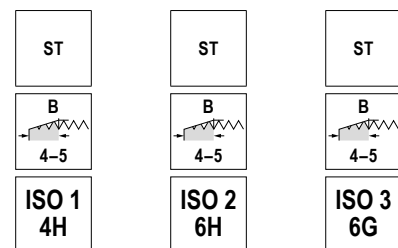
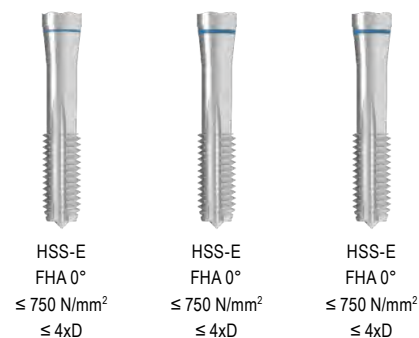
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M2	0.40	45	2.8	2.1	1.60	7	12	2
M2,3	0.40	45	2.8	2.1	1.90	7	12	2
M2,5	0.45	50	2.8	2.1	2.05	9	14	2
M2,6	0.45	50	2.8	2.1	2.15	9	14	2
M3	0.50	56	3.5	2.7	2.50	11	18	3
M3,5	0.60	56	4.0	3.0	2.90	12	20	3
M4	0.70	63	4.5	3.4	3.30	13	21	3
M5	0.80	70	6.0	4.9	4.20	15	25	3
M6	1.00	80	6.0	4.9	5.00	17	30	3
M8	1.25	90	8.0	6.2	6.80	20	35	3
M10	1.50	100	10.0	8.0	8.50	22	39	3



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M5	0.80	70	3.5	2.7	4.2	15	3
M6	1.00	80	4.5	3.4	5.0	17	3
M8	1.25	90	6.0	4.9	6.8	20	3
M10	1.50	100	7.0	5.5	8.5	22	3
M12	1.75	110	9.0	7.0	10.2	24	3
M14	2.00	110	11.0	9.0	12.0	26	3
M16	2.00	110	12.0	9.0	14.0	27	3
M18	2.50	125	14.0	11.0	15.5	30	3
M20	2.50	140	16.0	12.0	17.5	32	3

P	12	12	12
M			
K	12	12	12
N	12	12	12
S			
H			
O			

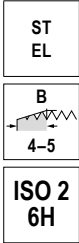
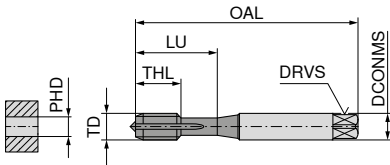


TP	TP	TP
22 002 ...	22 020 ...	22 004 ...
	020	
	023	
025	025	025
	026	
030	030	030
	035	
040	040	040
050	050	050
060	060	060
080	080	080
100	100	100

TP	TP
22 003 ...	22 021 ...
	050
	060
	080
	100
120	120
	140
160	160
	180
200	200

CoreLine – Through hole – machine taps, right-hand – TruTap

▲ EL = Extra long, with double overall length



DIN 371 With reinforced shank

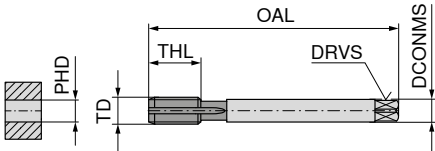


HSS-E
FHA 0°
≤ 950 N/mm²
≤ 4xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M3	0.50	100	3.5	2.7	2.5	11	18	3
M4	0.70	125	4.5	3.4	3.3	13	21	3
M5	0.80	140	6.0	4.9	4.2	15	25	3
M6	1.00	160	6.0	4.9	5.0	17	30	3
M8	1.25	180	8.0	6.2	6.8	20	35	3

TP

22 233 ...
030
040
050
060
080



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M6	1.00	160	4.5	3.4	5.0	17	3
M8	1.25	180	6.0	4.9	6.8	20	3
M10	1.50	200	7.0	5.5	8.5	22	3
M12	1.75	224	9.0	7.0	10.2	24	3
M14	2.00	224	11.0	9.0	12.0	26	3
M16	2.00	224	12.0	9.0	14.0	27	3
M18	2.50	250	14.0	11.0	15.5	30	3
M20	2.50	280	16.0	12.0	17.5	32	3

TP

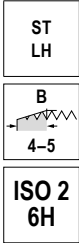
22 234 ...
060
080
100
120
140
160
180
200

P	12
M	
K	12
N	22
S	
H	
O	

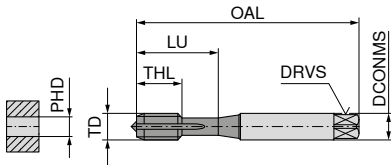
Cutting speed *v_c* (m/min)

CoreLine – Through hole – machine taps, left-hand – TruTap

▲ LH = For left-hand threads



HSS-E
FHA 0°
≤ 750 N/mm²
≤ 4xD

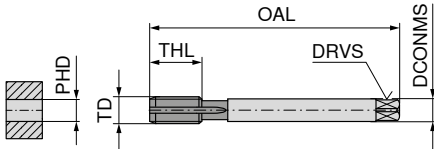


DIN 371 With reinforced shank

TD	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
M3	0.50	56	3.5	2.7	2.5	11	18	3
M4	0.70	63	4.5	3.4	3.3	13	21	3
M5	0.80	70	6.0	4.9	4.2	15	25	3
M6	1.00	80	6.0	4.9	5.0	17	30	3
M8	1.25	90	8.0	6.2	6.8	20	35	3
M10	1.50	100	10.0	8.0	8.5	22	39	3

TP

22 127 ...
030
040
050
060
080
100



DIN 376 With reduced shank

TD	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
M12	1.75	110	9	7	10.2	24	3
M16	2.00	110	12	9	14.0	27	3
M20	2.50	140	16	12	17.5	32	3

TP

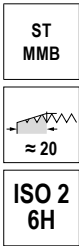
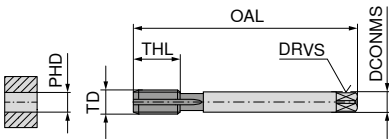
22 147 ...
120
160
200

P	12
M	
K	12
N	22
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand – TruTap

▲ MMB = Nut tap



DIN 357 With reduced shank



HSS-E
FHA 0°
≤ 850 N/mm²
≤ 1xD

TD	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
M3	0.50	70	2.2		2.5	16	3
M4	0.70	90	2.8	2.1	3.3	22	3
M5	0.80	100	3.5	2.7	4.2	24	3
M6	1.00	110	4.5	3.4	5.0	30	3
M8	1.25	125	6.0	4.9	6.8	38	3
M10	1.50	140	7.0	5.5	8.5	45	3
M12	1.75	180	9.0	7.0	10.2	50	3
M16	2.00	200	12.0	9.0	14.0	63	3

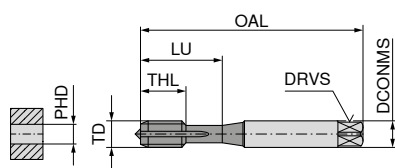
TP
22 098 ...
030
040
050
060
080
100
120
160

P	15
M	
K	
N	
S	
H	
O	

Cutting speed v_c (m/min)

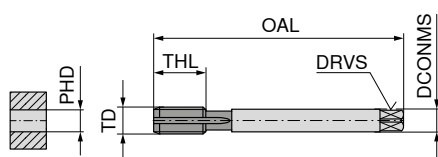
CoreLine – Through hole – machine taps, right-hand

M



DIN 371 With reinforced shank

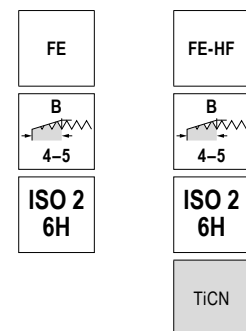
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M1,6	0.35	40	2.5	2.1	1.25	6	11	2
M2	0.40	45	2.8	2.1	1.60	7	12	2
M2,5	0.45	50	2.8	2.1	2.05	9	14	2
M3	0.50	56	3.5	2.7	2.50	11	18	3
M3,5	0.60	56	4.0	3.0	2.90	12	20	3
M4	0.70	63	4.5	3.4	3.30	13	21	3
M5	0.80	70	6.0	4.9	4.20	15	25	3
M6	1.00	80	6.0	4.9	5.00	17	30	3
M8	1.25	90	8.0	6.2	6.80	20	35	3
M10	1.50	100	10.0	8.0	8.50	22	39	3



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7	10.2	24	3
M14	2.00	110	11	9	12.0	26	3
M16	2.00	110	12	9	14.0	27	3
M20	2.50	140	16	12	17.5	32	3

P	12	15
M	12	15
K	12	15
N	12	15
S	12	15
H	12	15
O	12	15

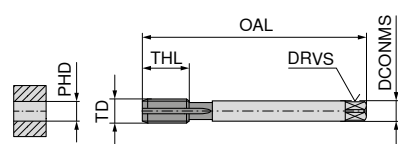


CX	CX
23 212 ...	23 310 ...
016	
020	
025	
030	030
035	
040	040
050	050
060	060
080	080
100	100

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand

▲ ES = Extra short



DIN 376 With reduced shank



HSS-E
FHA 0°
≤ 850 N/mm²
≤ 3xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M2	0.40	36	2.8	2.1	1.60	8	2
M2,5	0.45	40	2.8	2.1	2.05	9	2
M3	0.50	40	3.5	2.7	2.50	10	3
M4	0.70	45	4.5	3.4	3.30	12	3
M5	0.80	50	6.0	4.9	4.20	14	3
M6	1.00	56	6.0	4.9	5.00	16	3
M8	1.25	63	6.0	4.9	6.80	20	3
M10	1.50	70	7.0	5.5	8.50	22	3
M12	1.75	75	9.0	7.0	10.20	24	3
M16	2.00	80	12.0	9.0	14.00	27	3

CX

23 210 ...

020

025

030

040

050

060

080

100

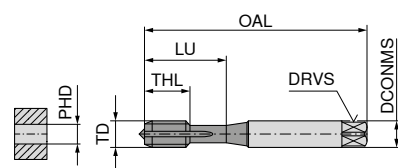
120

160

P	12
M	
K	12
N	12
S	
H	
O	

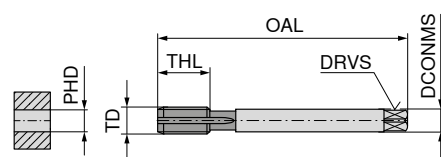
Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand – TruTap



DIN 371 With reinforced shank

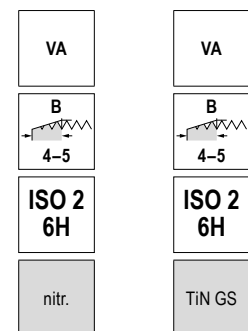
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M1,6	0.35	40	2.5	2.1	1.25	6	11	2
M2	0.40	45	2.8	2.1	1.60	7	12	2
M2,5	0.45	50	2.8	2.1	2.05	9	14	2
M3	0.50	56	3.5	2.7	2.50	11	18	3
M3,5	0.60	56	4.0	3.0	2.90	12	20	3
M4	0.70	63	4.5	3.4	3.30	13	21	3
M5	0.80	70	6.0	4.9	4.20	15	25	3
M6	1.00	80	6.0	4.9	5.00	17	30	3
M8	1.25	90	8.0	6.2	6.80	20	35	3
M10	1.50	100	10.0	8.0	8.50	22	39	3



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7	10.2	24	3
M14	2.00	110	11	9	12.0	26	3
M16	2.00	110	12	9	14.0	27	3
M18	2.50	125	14	11	15.5	30	3
M20	2.50	140	16	12	17.5	32	3

P	8	10
M	6	8
K		
N		
S		
H		
O		

HSS-E
FHA 0°
≤ 900 N/mm²
≤ 4xDHSS-E
FHA 0°
≤ 900 N/mm²
≤ 4xD

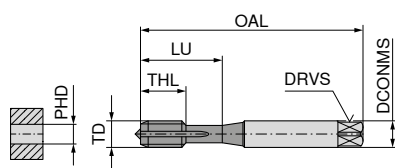
TP	TP
22 056 ...	22 038 ...
	016
020	020
025	025
030	030
035	
040	040
050	050
060	060
080	080
100	100

TP	TP
22 057 ...	22 039 ...
120	120
140	140
160	160
180	
200	200

Cutting speed v_c (m/min)

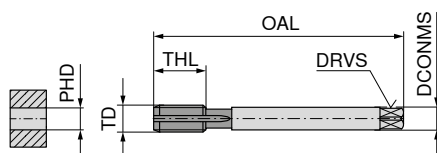
CoreLine – Through hole – machine taps, right-hand

M



DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M2	0.40	45	2.8	2.1	1.60	7	12	2
M2,5	0.45	50	2.8	2.1	2.05	9	14	2
M3	0.50	56	3.5	2.7	2.50	11	18	3
M4	0.70	63	4.5	3.4	3.30	13	21	3
M5	0.80	70	6.0	4.9	4.20	15	25	3
M6	1.00	80	6.0	4.9	5.00	17	30	3
M8	1.25	90	8.0	6.2	6.80	20	35	3
M10	1.50	100	10.0	8.0	8.50	22	39	3



DIN 376 With reduced shank

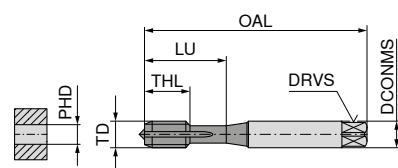
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7.0	10.2	24	3
M14	2.00	110	11	9.0	12.0	26	3
M16	2.00	110	12	9.0	14.0	27	3
M20	2.50	140	16	12.0	17.5	32	3
M24	3.00	160	18	14.5	21.0	34	3

P	10	8	8
M	8	6	6
K			
N	24	22	22
S			
H			
O			

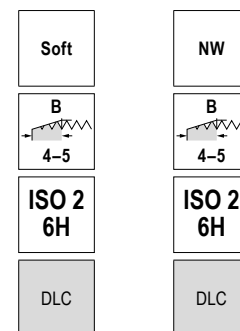
Cutting speed v_c (m/min)

VA	VA	VA
B 4-5	B 4-5	B 4-5
ISO 2 6H	ISO 2 6H	ISO 2 6H
TiN	nitr.	nitr.
HSS-E FHA 0° ≤ 1200 N/mm² ≤ 3xD	HSS-PM FHA 0° ≤ 1200 N/mm² ≤ 3xD	HSS-E FHA 0° ≤ 1200 N/mm² ≤ 3xD
CX 23 412 ...	CX 23 450 ...	CX 23 410 ...
020		020
025		025
030	030	030
040	040	040
050	050	050
060	060	060
080	080	080
100	100	100

CoreLine – Through hole – machine taps, right-hand – TruTap



DIN 371 With reinforced shank



HSS-E
FHA 0°
≤ 500 N/mm²
≤ 4xD

HSS-E
FHA 0°
≤ 880 N/mm²
≤ 4xD

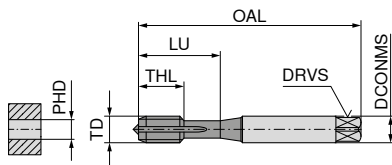
TD	TP	OAL	DCONMS ₁₉	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
M2	0.40	45	2.8	2.1	1.60	7	12	2
M2,5	0.45	50	2.8	2.1	2.05	9	14	2
M3	0.50	56	3.5	2.7	2.50	11	18	2
M3	0.50	56	3.5	2.7	2.50	11	18	3
M4	0.70	63	4.5	3.4	3.30	13	21	2
M4	0.70	63	4.5	3.4	3.30	13	21	3
M5	0.80	70	6.0	4.9	4.20	15	25	2
M5	0.80	70	6.0	4.9	4.20	15	25	3
M6	1.00	80	6.0	4.9	5.00	17	30	2
M6	1.00	80	6.0	4.9	5.00	17	30	3
M8	1.25	90	8.0	6.2	6.80	20	35	2
M8	1.25	90	8.0	6.2	6.80	20	35	3
M10	1.50	100	10.0	8.0	8.50	22	39	2
M10	1.50	100	10.0	8.0	8.50	22	39	3

TP	TP
22 648 ...	22 657 ...
02000	02000
02500	02500
03000	03000
04000	04000
05000	05000
06000	06000
08000	08000
10000	10000

P	
M	
K	
N	20-30
S	
H	
O	15-20

Cutting speed v_c (m/min)

M



AL	AL
	
ISO 2 6H	ISO 2 6H
	CrN



HSS-E
FHA 0°
≤ 500 N/mm²
≤ 3xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M3	0.50	56	3.5	2.7	2.5	11	18	3
M4	0.70	63	4.5	3.4	3.3	13	21	3
M5	0.80	70	6.0	4.9	4.2	15	25	3
M6	1.00	80	6.0	4.9	5.0	17	30	3
M8	1.25	90	8.0	6.2	6.8	20	35	3
M10	1.50	100	10.0	8.0	8.5	22	39	3

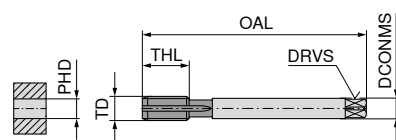
CX	CX
23 610 ...	23 612 ...
030	030
040	040
050	050
060	060
080	080
100	100

Letter	Count
P	1
M	1
K	1
N	15
S	20
H	1
O	1

Cutting speed v_c (m/min)

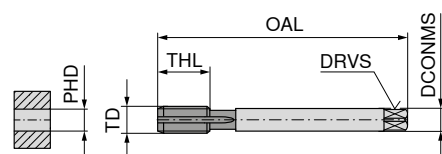
CoreLine – Through hole – machine taps, right-hand – TruTap

▲ AZ = With intermittent teeth, reduces friction



DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M1,6	0.35	40	2.5	2.1	1.25	8	9.5	3
M2	0.40	45	2.8	2.1	1.60	8	9.5	3
M2,5	0.45	50	2.8	2.1	2.05	9	14.0	3
M3	0.50	56	3.5	2.7	2.50	11	18.0	3
M3,5	0.60	56	4.0	3.0	2.90	12	20.0	3
M4	0.70	63	4.5	3.4	3.30	13	21.0	3
M5	0.80	70	6.0	4.9	4.20	15	25.0	3
M6	1.00	80	6.0	4.9	5.00	17	30.0	3
M8	1.25	90	8.0	6.2	6.80	20	35.0	3
M10	1.50	100	10.0	8.0	8.50	22	39.0	3

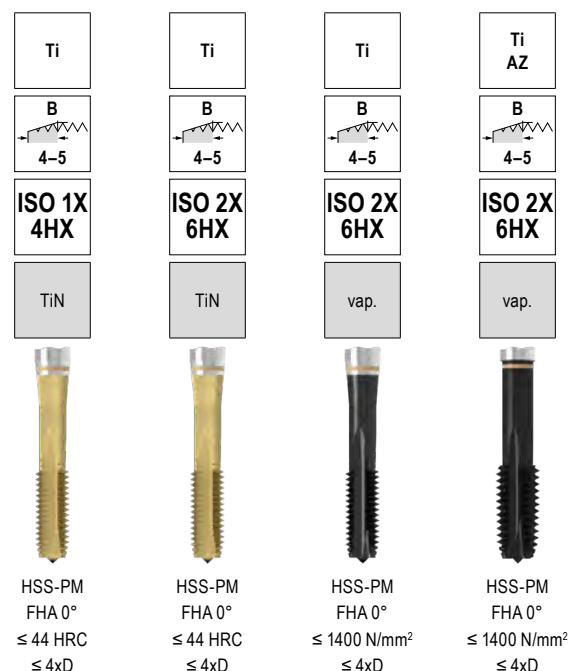


DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7	10.2	24	3

P	7	7	5	5
M	7	7	5	5
K				
N				
S	5	5	3	3
H				
O				

Cutting speed v_c (m/min)

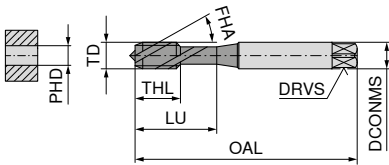


TP	TP	TP
22 081 ...	22 077 ...	22 075 ...
020		016
		020
030	030	025
		030
040	040	035
050	050	040
060	060	050
080	080	060
	100	080
		100

CoreLine – Through hole – machine taps, right-hand – TruTap DL

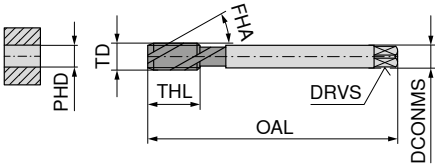
TruTap
DL

M



DIN 371 With reinforced shank

TD	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
M3	0.50	56	3.5	2.7	2.5	11	18	2
M4	0.70	63	4.5	3.4	3.3	13	21	3
M5	0.80	70	6.0	4.9	4.2	15	25	3
M6	1.00	80	6.0	4.9	5.0	17	30	3
M8	1.25	90	8.0	6.2	6.8	20	35	3
M10	1.50	100	10.0	8.0	8.5	22	39	3



DIN 376 With reduced shank

TD	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
M12	1.75	110	9	7	10.2	24	3
M16	2.00	110	12	9	14.0	27	3

P	7	
M	7	
K		
N	22	22
S	5	2
H		
O		

Ti

ISO 2X
6HX

TiCN

Ni

ISO 2X
6HX

TiCN



HSS-E
FHA 15°
≤ 1200 N/mm²
≤ 4xD



HSS-E
FHA 15°
≤ 1600 N/mm²
≤ 4xD

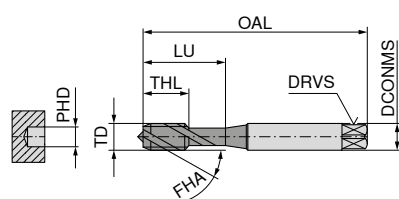
TP	TP
22 159 ...	22 297 ...
030	030
040	040
050	050
060	060
080	080
100	100

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap

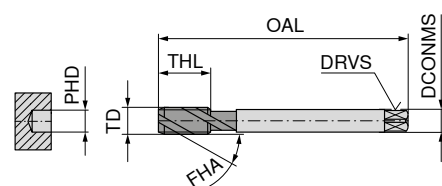
CavTap

M



DIN 371 With reinforced shank

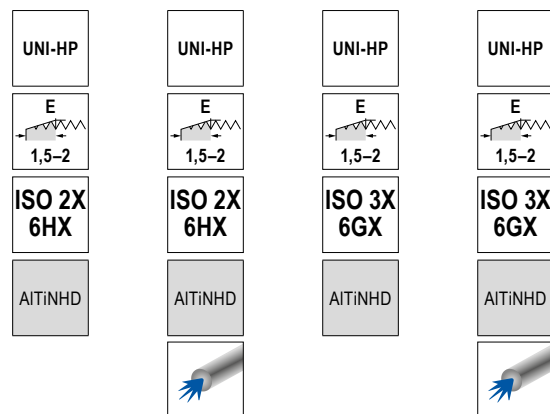
TD mm	TP mm	OAL mm	DCONMS _{h9} mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M3	0.50	56	3.5	2.7	2.5	6	18	3
M4	0.70	63	4.5	3.4	3.3	7	21	3
M5	0.80	70	6.0	4.9	4.2	8	25	3
M6	1.00	80	6.0	4.9	5.0	10	30	3
M8	1.25	90	8.0	6.2	6.8	14	35	3
M10	1.50	100	10.0	8.0	8.5	16	39	3



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS _{h9} mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7.0	10.2	18	4
M14	2.00	110	11	9.0	12.0	20	4
M16	2.00	110	12	9.0	14.0	22	4
M20	2.50	140	16	12.0	17.5	25	4
M24	3.00	160	18	14.5	21.0	30	5
M30	3.50	180	22	18.0	26.5	35	5

P	2-18	2-18	2-18	2-18
M	2-10	2-10	2-10	2-10
K	10-20	10-20	10-20	10-20
N	15-30	15-30	15-30	15-30
S				
H				
O				



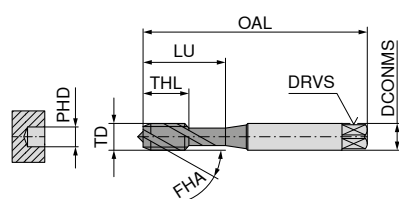
HSS-E-PM FHA 45° ≤ 1400 N/mm² ≤ 3xD	HSS-E-PM FHA 45° ≤ 1400 N/mm² ≤ 3xD	HSS-E-PM FHA 45° ≤ 1400 N/mm² ≤ 3xD	HSS-E-PM FHA 45° ≤ 1400 N/mm² ≤ 3xD
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NEW TP	NEW TP	NEW TP	NEW TP
22 829 ...	22 840 ...	22 833 ...	22 843 ...
03000		03000	
04000	04000	04000	04000
05000	05000	05000	05000
06000	06000	06000	06000
08000	08000	08000	08000
10000	10000	10000	10000

TP	TP	TP	TP
22 830 ...	22 841 ...	22 834 ...	22 844 ...
12000	12000	12000	12000
14000	14000		
16000	16000	16000	16000
20000	20000	20000	20000
24000	24000	24000	24000
30000	30000	30000	30000

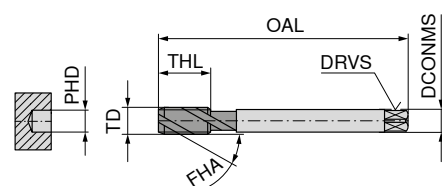
Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap



DIN 371 With reinforced shank

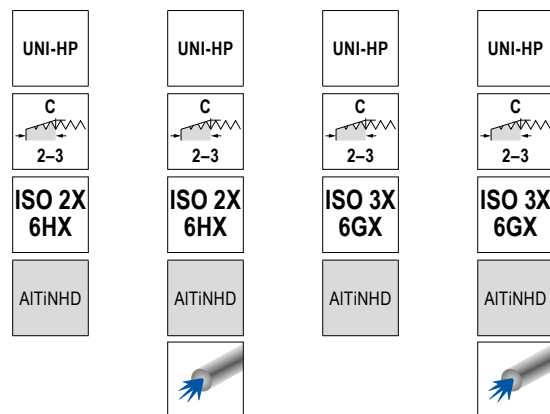
TD mm	TP mm	OAL mm	DCONMS _{h9} mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M3	0.50	56	3.5	2.7	2.5	6	18	3
M4	0.70	63	4.5	3.4	3.3	7	21	3
M5	0.80	70	6.0	4.9	4.2	8	25	3
M6	1.00	80	6.0	4.9	5.0	10	30	3
M8	1.25	90	8.0	6.2	6.8	14	35	3
M10	1.50	100	10.0	8.0	8.5	16	39	3



DIN 376 With reduced shank

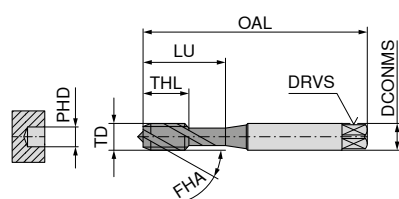
TD mm	TP mm	OAL mm	DCONMS _{h9} mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7.0	10.2	18	4
M14	2.00	110	11	9.0	12.0	20	4
M16	2.00	110	12	9.0	14.0	22	4
M20	2.50	140	16	12.0	17.5	25	4
M24	3.00	160	18	14.5	21.0	30	5
M30	3.50	180	22	18.0	26.5	35	5

P	2-18	2-18	2-18	2-18
M	2-10	2-10	2-10	2-10
K	10-20	10-20	10-20	10-20
N	15-30	15-30	15-30	15-30
S				
H				
O				



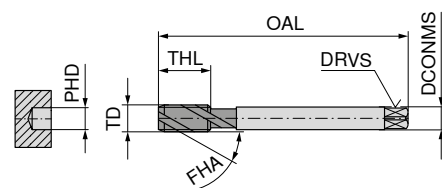
NEW TP	NEW TP	NEW TP	NEW TP
22 820 ...	22 835 ...	22 827 ...	22 838 ...
03000		03000	
04000	04000	04000	04000
05000	05000	05000	05000
06000	06000	06000	06000
08000	08000	08000	08000
10000	10000	10000	10000

CoreLine – Blind hole – machine taps, right-hand – CavTap



DIN 371 With reinforced shank

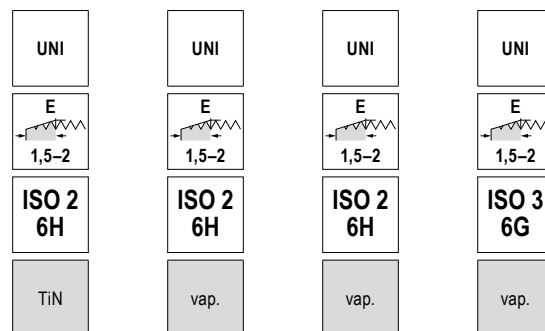
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M2,5	0.45	50	2.8	2.1	2.05	5	15	2
M3	0.50	56	3.5	2.7	2.50	6	18	3
M4	0.70	63	4.5	3.4	3.30	7	21	3
M5	0.80	70	6.0	4.9	4.20	8	25	3
M6	1.00	80	6.0	4.9	5.00	10	30	3
M8	1.25	90	8.0	6.2	6.80	14	35	3
M10	1.50	100	10.0	8.0	8.50	16	39	3



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7.0	10.2	18	4
M14	2.00	110	11	9.0	12.0	20	4
M16	2.00	110	12	9.0	14.0	22	4
M18	2.50	125	14	11.0	15.5	25	4
M20	2.50	140	16	12.0	17.5	25	4
M22	2.50	140	18	14.5	19.5	27	5
M24	3.00	160	18	14.5	21.0	30	5

P	15	12	12	12
M	9	7	7	7
K	18	12	12	12
N	12			
S				
H				
O				

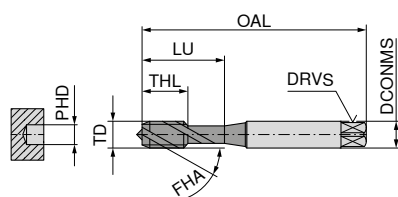


TP	TP	TP	TP
22 526 ...	22 524 ...	22 534 ...	22 530 ...
030	030		025
040	040		030
050	050	050	040
060	060	060	050
080	080	080	060
100	100	100	080
			100

CoreLine – Blind hole – machine taps, right-hand – CavTap

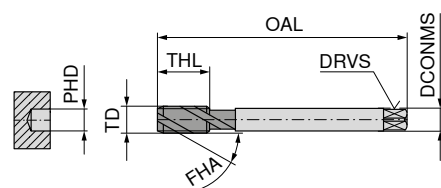
CavTap

M



DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS _{h9} mm	DRV mm	PHD mm	THL mm	LU mm	Flutes
M2,2	0.45	45	2.8	2.1	1.75	4.5	12	2
M2,3	0.40	45	2.8	2.1	1.90	4.5	12	2
M2,6	0.45	50	2.8	2.1	2.15	5.0	15	2
M3	0.50	56	3.5	2.7	2.50	6.0	18	3
M3,5	0.60	56	4.0	3.0	2.90	7.0	20	3
M4	0.70	63	4.5	3.4	3.35	7.0	21	3
M5	0.80	70	6.0	4.9	4.25	8.0	25	3
M6	1.00	80	6.0	4.9	5.05	10.0	30	3
M7	1.00	80	7.0	5.5	6.00	10.0	30	3
M8	1.25	90	8.0	6.2	6.85	14.0	35	3
M10	1.50	100	10.0	8.0	8.55	16.0	39	3
M12	1.75	110	12.0	9.0	10.20	18.0	44	4



DIN 376 With reduced shank

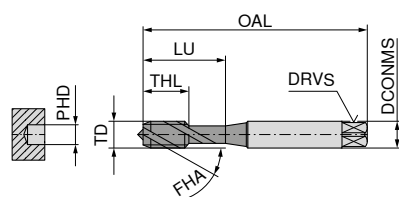
TD mm	TP mm	OAL mm	DCONMS _{h9} mm	DRV mm	PHD mm	THL mm	Flutes
M3	0.50	56	2.2		2.50	6	3
M4	0.70	63	2.8	2.1	3.30	7	3
M5	0.80	70	3.5	2.7	4.20	8	3
M6	1.00	80	4.5	3.4	5.00	10	3
M8	1.25	90	6.0	4.9	6.80	14	3
M10	1.50	100	7.0	5.5	8.50	16	3
M12	1.75	110	9.0	7.0	10.25	18	4
M16	2.00	110	12.0	9.0	14.10	22	4
M20	2.50	140	16.0	12.0	17.60	25	4
M27	3.00	160	20.0	16.0	24.00	30	5

P	2-18	2-15	2-15
M	2-10	4-8	4-8
K	10-20		
N	15-30		
S			
H			
O			

UNI	UNI	UNI
C 2-3	C 2-3	C 2-3
ISO 2 6H	ISO 2 6H	7G
AlTiNHD	vap.	vap.
HSS-E FHA 45° ≤ 1100 N/mm² ≤ 3xD	HSS-E FHA 45° ≤ 1100 N/mm² ≤ 3xD	HSS-E FHA 45° ≤ 1100 N/mm² ≤ 3xD

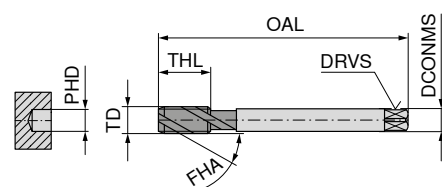
TP	TP	TP
22 690 ...	22 688 ...	22 691 ...
	02200	
	02300	
	02600	
		03000
	03500	
		04000
		05000
		06000
	07000	
		08000
		10000
12000	12000	

CoreLine – Blind hole – machine taps, right-hand – CavTap



DIN 371 With reinforced shank

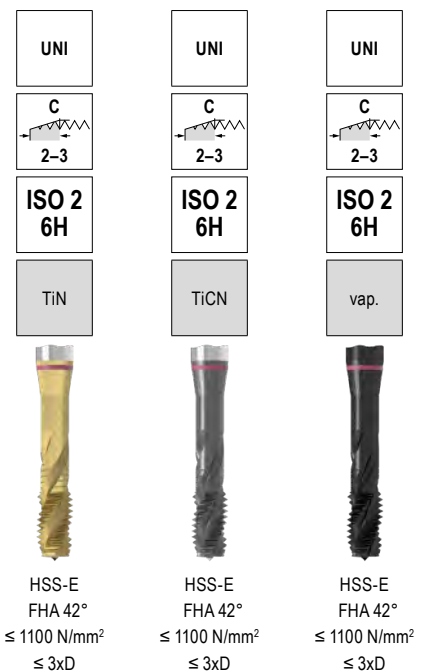
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M2	0.40	45	2.8	2.1	1.60	4	12	2
M2,5	0.45	50	2.8	2.1	2.05	5	15	2
M3	0.50	56	3.5	2.7	2.50	6	18	3
M4	0.70	63	4.5	3.4	3.30	7	21	3
M5	0.80	70	6.0	4.9	4.20	8	25	3
M6	1.00	80	6.0	4.9	5.00	10	30	3
M8	1.25	90	8.0	6.2	6.80	14	35	3
M10	1.50	100	10.0	8.0	8.50	16	39	3



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7.0	10.2	18	3
M14	2.00	110	11	9.0	12.0	20	3
M16	2.00	110	12	9.0	14.0	22	3
M18	2.50	125	14	11.0	15.5	25	3
M20	2.50	140	16	12.0	17.5	25	3
M22	2.50	140	18	14.5	19.5	27	4
M24	3.00	160	18	14.5	21.0	30	4
M30	3.50	180	22	18.0	26.5	35	4
M33	3.50	180	25	20.0	29.5	35	4
M36	4.00	200	28	22.0	32.0	40	4

	TP	TP	TP
P	15	15	12
M	9	9	7
K	18	18	12
N	12	12	
S			
H			
O			



TP	TP	TP
22 520 ...	22 522 ...	22 518 ...
020		020
030	030	025
040	040	030
050	050	040
060	060	050
080	080	060
100	100	080
		100

TP	TP
22 521 ...	22 519 ...
120	120
140	140
160	160
180	180
200	200
220	220
240	240
	300
	330
	360

CoreLine – Blind hole – machine taps, right-hand – CavTap SL

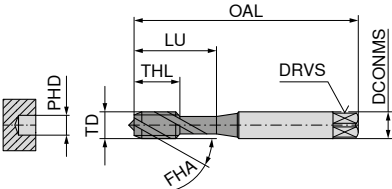
CavTap
SL

M

UNI



ISO 2
6H



DIN 371 With reinforced shank



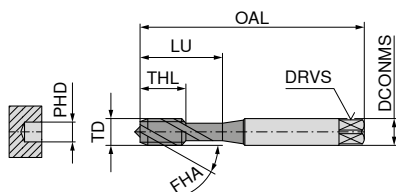
HSS-E
FHA 15°
≤ 750 N/mm²
≤ 2xD

TD	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes	TP	
mm	mm	mm	mm	mm	mm	mm	mm		22 516 ...	
M3	0.50	56	3.5	2.7	2.5	6	18	3		030
M4	0.70	63	4.5	3.4	3.3	7	21	3		040
M5	0.80	70	6.0	4.9	4.2	8	25	3		050
M6	1.00	80	6.0	4.9	5.0	10	30	3		060
M8	1.25	90	8.0	6.2	6.8	14	35	3		080
M10	1.50	100	10.0	8.0	8.5	16	39	4		100
P										12
M										
K										15
N										12
S										
H										
O										

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand

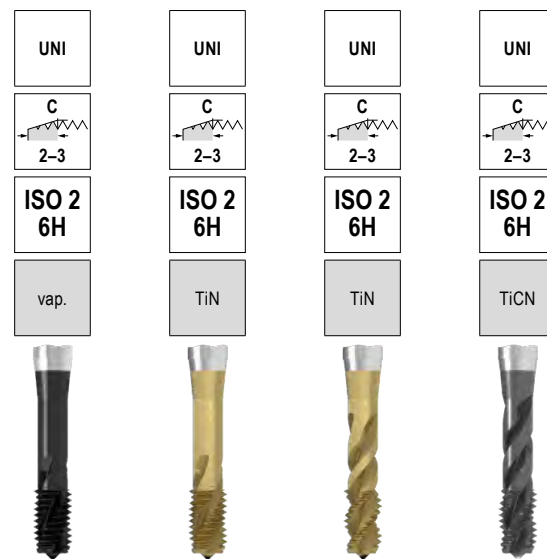
M



DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M2	0.40	45	2.8	2.1	1.60	4	12	2
M2,5	0.45	50	2.8	2.1	2.05	5	14	2
M3	0.50	56	3.5	2.7	2.50	6	18	3
M4	0.70	63	4.5	3.4	3.30	7	21	3
M5	0.80	70	6.0	4.9	4.20	8	25	3
M6	1.00	80	6.0	4.9	5.00	10	30	3
M8	1.25	90	8.0	6.2	6.80	14	35	3
M10	1.50	100	10.0	8.0	8.50	16	39	3

	P	M	K	N	S	H	O
23 118 ...	12	7	12				
23 120 ...	15	9	18	12			
23 026 ...	15	9	18	12			
23 122 ...	15	9	18	12			

Cutting speed v_c (m/min)

HSS-E FHA 35° ≤ 1000 N/mm² ≤ 2,5xD	HSS-E FHA 35° ≤ 1000 N/mm² ≤ 2,5xD	HSS-PM FHA 50° ≤ 1000 N/mm² ≤ 2,5xD	HSS-E FHA 45° ≤ 1000 N/mm² ≤ 3xD
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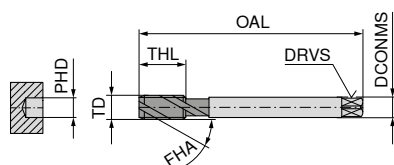
CX	CX	CX	CX
23 118 ...	23 120 ...	23 026 ...	23 122 ...
020	020		
025	025		
030	030	030	030
040	040	040	040
050	050	050	050
060	060	060	060
080	080	080	080
100	100	100	100



See next page for DIN 376.

CoreLine – Blind hole – machine taps, right-hand

M



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M3	0.50	56	2.2		2.5	6	3
M4	0.70	63	2.8	2.1	3.3	7	3
M5	0.80	70	3.5	2.7	4.2	8	3
M6	1.00	80	4.5	3.4	5.0	10	3
M8	1.25	90	6.0	4.9	6.8	14	3
M10	1.50	100	7.0	5.5	8.5	16	3
M12	1.75	110	9.0	7.0	10.2	18	3
M12	1.75	110	9.0	7.0	10.2	18	4
M14	2.00	110	11.0	9.0	12.0	20	3
M14	2.00	110	11.0	9.0	12.0	20	4
M16	2.00	110	12.0	9.0	14.0	22	3
M16	2.00	110	12.0	9.0	14.0	22	4
M18	2.50	125	14.0	11.0	15.5	25	3
M20	2.50	140	16.0	12.0	17.5	25	3
M20	2.50	140	16.0	12.0	17.5	25	4
M22	2.50	140	18.0	14.5	19.5	27	4
M24	3.00	160	18.0	14.5	21.0	34	4
M27	3.00	160	20.0	16.0	24.0	30	4
M30	3.50	180	22.0	18.0	26.5	35	4
M33	3.50	180	25.0	20.0	29.5	35	4
M36	4.00	200	28.0	22.0	32.0	40	4

P	12	15	15	15
M	7	9	9	9
K	12	18	18	18
N		12	12	12
S				
H				
O				

Cutting speed v_c (m/min)

UNI	UNI	UNI	UNI
C 2-3	C 2-3	C 2-3	C 2-3
ISO 2 6H	ISO 2 6H	ISO 2 6H	ISO 2 6H
vap.	TiN	TiN	TiCN
HSS-E FHA 35° $\leq 1000 \text{ N/mm}^2$ $\leq 2,5xD$	HSS-E FHA 35° $\leq 1000 \text{ N/mm}^2$ $\leq 2,5xD$	HSS-PM FHA 50° $\leq 1000 \text{ N/mm}^2$ $\leq 2,5xD$	HSS-E FHA 45° $\leq 1000 \text{ N/mm}^2$ $\leq 3xD$

CX	CX	CX	CX
23 119 ...	23 121 ...	23 027 ...	23 123 ...
030			
040			
050			
060			
080			
100			
120	120		
		120	120
	14000		
		140	
160	160	160	160
	18000		
200	200	200	200
	22000		
	240		
	27000		
	30000		
	33000		
	36000		

CoreLine – Blind hole – machine taps, right-hand – CavTap

▲ NCW = With Weldon flat for synchronized CNC machining without length compensation chuck

CavTap

M

UNI
NCW

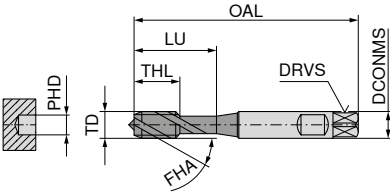

C
2-3

ISO 2
6H

TiN



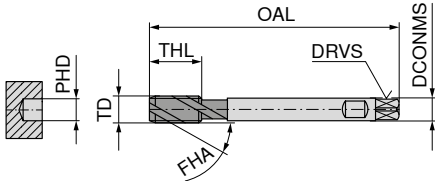
HSS-PM
FHA 42°
≤ 1100 N/mm²
≤ 3xD



DIN 371 With reinforced shank

TD	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
M3	0.50	70	6	4.9	2.5	6	18	3
M4	0.70	70	6	4.9	3.3	7	21	3
M5	0.80	70	6	4.9	4.2	8	25	3
M6	1.00	80	6	4.9	5.0	10	30	3
M8	1.25	90	8	6.2	6.8	14	35	3
M10	1.50	100	10	8.0	8.5	16	39	3

TP
22 149 ...
030
040
050
060
080
100



DIN 376 With reduced shank

TD	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
M12	1.75	110	10	8	10.2	18	3
M16	2.00	110	12	9	14.0	22	3

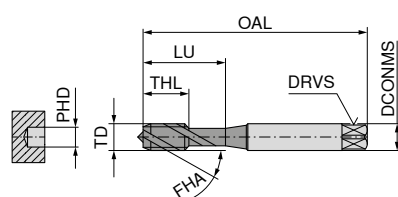
TP
22 149 ...
120
160

P	15
M	8
K	15
N	22
S	
H	
O	

Cutting speed v_c (m/min)

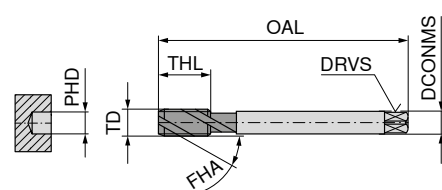
CoreLine – Blind hole – machine taps, right-hand – CavTap

▲ CNC = For synchronized CNC machining with minimum length compensation chuck



DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M3	0.50	56	3.5	2.7	2.5	6	18	3
M4	0.70	63	4.5	3.4	3.3	7	21	3
M5	0.80	70	6.0	4.9	4.2	8	25	3
M6	1.00	80	6.0	4.9	5.0	10	30	3
M8	1.25	90	8.0	6.2	6.8	14	35	3
M10	1.50	100	10.0	8.0	8.5	16	39	3



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7	10.2	18	3
M12	1.75	110	9	7	10.2	18	4
M14	2.00	110	11	9	12.0	20	3
M14	2.00	110	11	9	12.0	20	4
M16	2.00	110	12	9	14.0	22	3
M16	2.00	110	12	9	14.0	22	4
M20	2.50	140	16	12	17.5	25	3
M20	2.50	140	16	12	17.5	25	4

P	15	15	15	15	15
M	9	9	9	9	9
K	18	18	18	18	18
N	12	12	22	12	12
S					
H					
O					

UNI CNC	UNI CNC	UNI CNC	UNI CNC	UNI CNC
E 1,5-2	C 2-3	C 2-3	C 2-3	C 2-3
ISO 2 6H	ISO 2 6H	ISO 2X 6HX	ISO 3 6G	7G
TiN GS	TiN GS	TiN	TiN GS	TiN GS
HSS-E FHA 45° ≤ 1100 N/mm² ≤ 3xD	HSS-E FHA 45° ≤ 1100 N/mm² ≤ 3xD	HSS-E FHA 50° ≤ 1100 N/mm² ≤ 3xD	HSS-E FHA 45° ≤ 1100 N/mm² ≤ 3xD	HSS-E FHA 45° ≤ 1100 N/mm² ≤ 3xD

TP	TP	TP	TP	TP
22 546 ...	22 544 ...	22 416 ...	22 588 ...	22 594 ...
	030	030	030	030
	040	040	040	040
050	050	050	050	050
060	060	060	060	060
080	080	080	080	080
100	100	100	100	100

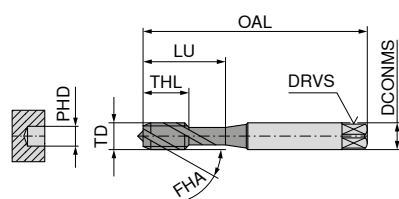
TP	TP	TP	TP
22 545 ...	22 417 ...	22 589 ...	22 595 ...
120	120	120	120
140	140	140	140
160	160	160	160
200	200	200	200

CoreLine – Blind hole – machine taps, right-hand

▲ NCW = With Weldon flat for synchronized CNC machining without length compensation chuck

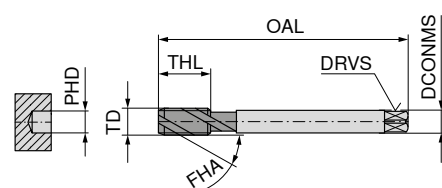
▲ NC = For synchronized CNC machining with minimum length compensation chuck

M



DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M3	0.50	70	6.0	4.9	2.5	6	18	3
M3	0.50	56	3.5	2.7	2.5	6	18	3
M4	0.70	70	6.0	4.9	3.3	7	21	3
M4	0.70	63	4.5	3.4	3.3	7	21	3
M5	0.80	70	6.0	4.9	4.2	8	25	3
M6	1.00	80	6.0	4.9	5.0	10	30	3
M8	1.25	90	8.0	6.2	6.8	14	35	3
M10	1.50	100	10.0	8.0	8.5	16	39	3



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	10	8	10.2	18	3
M12	1.75	110	9	7	10.2	18	4
M16	2.00	110	12	9	14.0	22	3
M16	2.00	110	12	9	14.0	22	4
M20	2.50	140	16	12	17.5	25	4

P	15	15
M	8	9
K	15	18
N	22	12
S		
H		
O		

Cutting speed v_c (m/min)

UNI NCW	UNI NC
C 2-3	C 2-3
ISO 2 6H	ISO 2 6H
TiCN	TiN GS
HSS-PM FHA 35° ≤ 1000 N/mm² ≤ 2,5xD	HSS-E FHA 45° ≤ 1000 N/mm² ≤ 3xD
CX 23 126 ... 030 040 050 060 080 100	CX 23 124 ... 030 040 050 060 080 100

CoreLine – Blind hole – machine taps, right-hand – CavTap

▲ ES = Extra short

CavTap

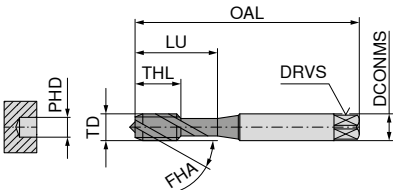
M

UNI
ES

E
1,5-2

ISO 2
6H

vap.



DIN 352 With reinforced shank



HSS-E
FHA 42°
≤ 1100 N/mm²
≤ 3xD

TD	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
M3	0.50	40	3.5	2.7	2.5	6	18	3
M4	0.70	45	4.5	3.4	3.3	7	22	3
M5	0.80	50	6.0	4.9	4.2	9	25	3
M6	1.00	56	6.0	4.9	5.0	10	28	3
M8	1.25	63	6.0	4.9	6.8	14		3
M10	1.50	70	7.0	5.5	8.5	16		3
M12	1.75	75	9.0	7.0	10.2	18		4
M16	2.00	80	12.0	9.0	14.0	22		4

TP

22 500 ...

030

040

050

060

080

100

120

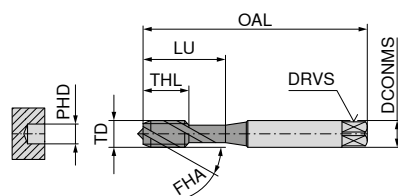
160

P	12
M	7
K	12
N	
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap

▲ EL = Extra long, with double overall length



DIN 371 With reinforced shank



HSS-E
FHA 42°
≤ 1100 N/mm²
≤ 3xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M3	0.50	100	3.5	2.7	2.5	6	18	3
M4	0.70	125	4.5	3.4	3.3	7	21	3
M5	0.80	140	6.0	4.9	4.2	8	25	3
M6	1.00	160	6.0	4.9	5.0	10	30	3
M8	1.25	180	8.0	6.2	6.8	14	35	3

TP

22 538 ...

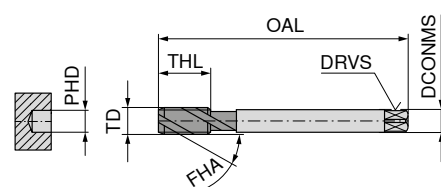
030

040

050

060

080



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M6	1.00	160	4.5	3.4	5.0	10	3
M8	1.25	180	6.0	4.9	6.8	14	3
M10	1.50	200	7.0	5.5	8.5	16	3
M12	1.75	224	9.0	7.0	10.2	18	3
M14	2.00	224	11.0	9.0	12.0	20	3
M16	2.00	224	12.0	9.0	14.0	22	3
M18	2.50	250	14.0	11.0	15.5	25	3
M20	2.50	280	16.0	12.0	17.5	25	3

TP

22 539 ...

060

080

100

120

140

160

180

200

P	12
M	7
K	12
N	
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap

▲ DRY = For dry machining or minimum quantity lubrication (MQL)

CavTap

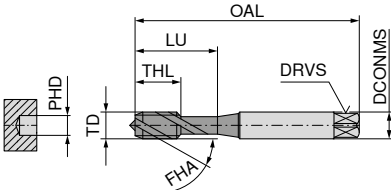
M

UNI
DRY

C
2-3

ISO 2
6H

TiN



DIN 371 With reinforced shank

HSS-E
FHA 45°
≤ 1100 N/mm²
≤ 3xD

TD	TP	OAL	DCONMS _{h9}	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
M5	0.80	70	6	4.9	4.2	8	25	3
M6	1.00	80	6	4.9	5.0	10	30	3
M8	1.25	90	8	6.2	6.8	14	35	3
M10	1.50	100	10	8.0	8.5	16	39	3

TP

22 654 ...

05000

06000

08000

10000

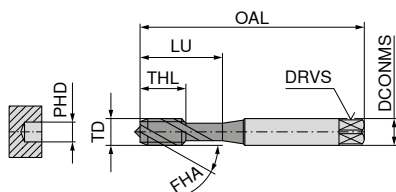
P	2-18
M	2-10
K	10-20
N	15-30
S	
H	
O	

Cutting speed v_c (m/min)

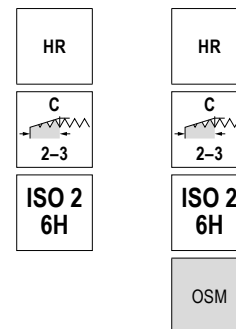
CoreLine – Blind hole – machine taps, right-hand – CavTap

CavTap

M



DIN 371 With reinforced shank



HSS-PM
FHA 42°
≤ 1400 N/mm²
≤ 3xD



HSS-PM
FHA 42°
≤ 1400 N/mm²
≤ 3xD

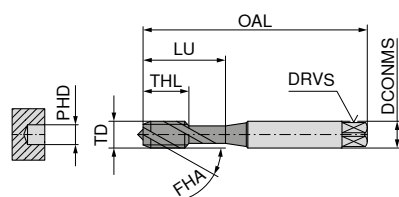
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M3	0.50	56	3.5	2.7	2.5	6	18	3
M4	0.70	63	4.5	3.4	3.3	7	21	3
M5	0.80	70	6.0	4.9	4.2	8	25	3
M6	1.00	80	6.0	4.9	5.0	10	30	3
M8	1.25	90	8.0	6.2	6.8	14	35	3
M10	1.50	100	10.0	8.0	8.5	16	39	3

TP	TP
22 498 ...	22 499 ...
030	030
040	040
050	050
060	060
080	080
100	100

P	6	8
M	6	8
K		
N	8	12
S		
H		
O		

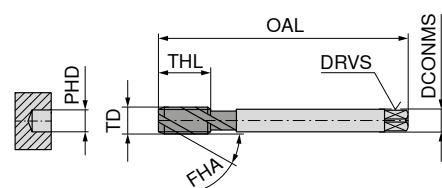
Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap



DIN 371 With reinforced shank

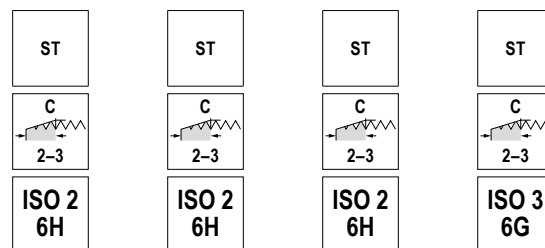
TD mm	TP mm	OAL mm	DCONMS _{H9} mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M2	0.40	45	2.8	2.1	1.60	4	12	2
M2	0.40	45	2.8	2.1	1.62	4	12	2
M2,5	0.45	50	2.8	2.1	2.05	5	15	2
M2,5	0.45	50	2.8	2.1	2.08	5	15	2
M3	0.50	56	3.5	2.7	2.50	6	18	3
M3	0.50	56	3.5	2.7	2.53	6	18	3
M4	0.70	63	4.5	3.4	3.30	7	21	3
M4	0.70	63	4.5	3.4	3.35	7	21	3
M5	0.80	70	6.0	4.9	4.20	8	25	3
M5	0.80	70	6.0	4.9	4.25	8	25	3
M6	1.00	80	6.0	4.9	5.00	10	30	3
M6	1.00	80	6.0	4.9	5.05	10	30	3
M8	1.25	90	8.0	6.2	6.80	14	35	3
M8	1.25	90	8.0	6.2	6.85	14	35	3
M10	1.50	100	10.0	8.0	8.50	16	39	3
M10	1.50	100	10.0	8.0	8.55	16	39	3



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS _{H9} mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7	10.2	18	3
M14	2.00	110	11	9	12.0	20	3
M16	2.00	110	12	9	14.0	22	3
M18	2.50	125	14	11	15.5	25	3
M20	2.50	140	16	12	17.5	25	3

P	12	15	15	2-15
M				
K	12	15		
N	12	15		8-20
S				
H				
O				



HSS-E
FHA 42°
≤ 750 N/mm²
≤ 3xD

HSS-E
FHA 42°
≤ 750 N/mm²
≤ 3xD

HSS-E
FHA 38°
≤ 500 N/mm²
≤ 3xD

HSS-E
FHA 45°
≤ 750 N/mm²
≤ 3xD

TP	TP	TP	TP
22 082 ...	22 084 ...	22 086 ...	22 649 ...
020	020	020	02000
025		025	02500
030	030	030	03000
040	040	040	04000
050	050	050	05000
060	060	060	06000
080	080	080	08000
100	100	100	10000

TP	TP
22 083 ...	22 085 ...
120	120
140	
160	160
180	
200	200

CoreLine – Blind hole – machine taps, right-hand – CavTap SL

▲ CNC = For synchronized CNC machining with minimum length compensation chuck

CavTap
SL

M

ST
CNC

ST
CNC


C
2-3


C
2-3

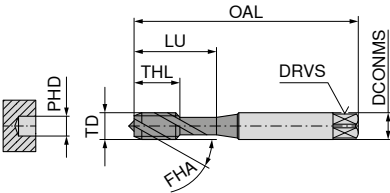
ISO 2X
6HX

ISO 2X
6HX

TiN

TiN





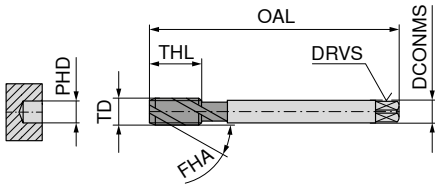
DIN 371 With reinforced shank


HSS-E
FHA 15°
≤ 1100 N/mm²
≤ 2xD


HSS-E
FHA 15°
≤ 1100 N/mm²
≤ 2xD

TD	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
M3	0.50	56	3.5	2.7	2.5	6	18	2
M4	0.70	63	4.5	3.4	3.3	7	21	3
M5	0.80	70	6.0	4.9	4.2	8	25	3
M6	1.00	80	6.0	4.9	5.0	10	30	3
M8	1.25	90	8.0	6.2	6.8	14	35	3
M10	1.50	100	10.0	8.0	8.5	16	39	3

TP	TP
22 443 ...	22 328 ...
	030
	040
050	050
060	060
080	080
100	100



DIN 376 With reduced shank

TD	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
M12	1.75	110	9	7	10.2	18	3
M16	2.00	110	12	9	14.0	22	3
M20	2.50	140	16	12	17.5	25	3

TP
22 329 ...
120
160
200

P	12	12
M	8	8
K	20	20
N	22	22
S		
H		
O		

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap SL

▲ TS = For high-speed machining, up to 100 m/min

CavTap
SL

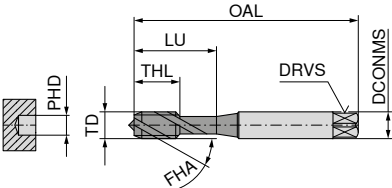
M

ST
TS


C
2-3

ISO 2
6H

TiN



DIN 371 With reinforced shank



HSS-PM
FHA 15°
≤ 1100 N/mm²
≤ 1,5xD

TD	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
M4	0.70	63	4.5	3.4	3.3	13	21	3
M5	0.80	70	6.0	4.9	4.2	15	25	3
M6	1.00	80	6.0	4.9	5.0	17	30	3
M8	1.25	90	8.0	6.2	6.8	20	35	4

TP

22 094 ...

040

050

060

080

P	65
M	
K	65
N	75
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap

▲ ES = Extra short

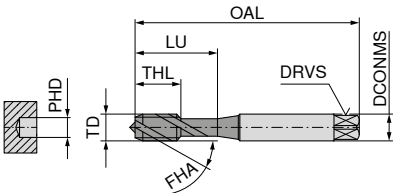
CavTap

M

ST
ES


C
2-3

ISO 2
6H



DIN 352 With reinforced shank



HSS-E
FHA 42°
≤ 750 N/mm²
≤ 3xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M3	0.50	40	3.5	2.7	2.5	6	18	3
M4	0.70	45	4.5	3.4	3.3	7	22	3
M5	0.80	50	6.0	4.9	4.2	9	25	3
M6	1.00	56	6.0	4.9	5.0	10	28	3
M8	1.25	63	6.0	4.9	6.8	14		3
M10	1.50	70	7.0	5.5	8.5	16		3
M12	1.75	75	9.0	7.0	10.2	18		3

TP

22 529 ...

030

040

050

060

080

100

120

P	12
M	
K	12
N	12
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap SL

▲ ES = Extra short

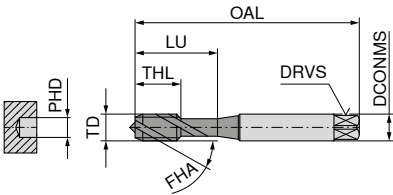
CavTap
SL

M

ST
ES

C
2-3

ISO 2
6H



DIN 352 With reinforced shank



HSS-E
FHA 15°
≤ 750 N/mm²
≤ 2xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M3	0.50	40	3.5	2.7	2.5	10	18	2
M4	0.70	45	4.5	3.4	3.3	12	22	3
M5	0.80	50	6.0	4.9	4.2	14	25	3
M6	1.00	56	6.0	4.9	5.0	16	28	3
M8	1.25	63	6.0	4.9	6.8	20		3
M10	1.50	70	7.0	5.5	8.5	22		3
M12	1.75	75	9.0	7.0	10.2	24		3

TP

22 016 ...

030

040

050

060

080

100

120

P	12
M	
K	12
N	12
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap

▲ EL = Extra long, with double overall length

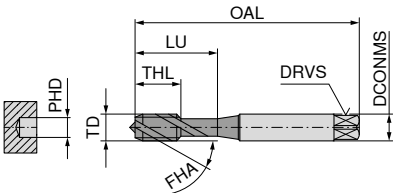
CavTap

M

ST
EL

C
2-3

ISO 2
6H



DIN 371 With reinforced shank



HSS-E
FHA 42°
≤ 750 N/mm²
≤ 3xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M3	0.50	100	3.5	2.7	2.5	6	18	3
M4	0.70	125	4.5	3.4	3.3	7	21	3
M5	0.80	140	6.0	4.9	4.2	8	25	3
M6	1.00	160	6.0	4.9	5.0	10	30	3
M8	1.25	180	8.0	6.2	6.8	14	35	3

TP

22 422 ...

030

040

050

060

080

P	12
M	
K	12
N	22
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap SL

▲ EL = Extra long, with double overall length

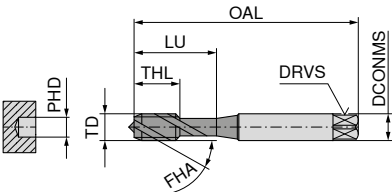
CavTap
SL

M

ST
EL

E
1,5–2

ISO 2
6H



DIN 371 With reinforced shank



HSS-E
FHA 15°
≤ 750 N/mm²
≤ 2xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M3	0.50	100	3.5	2.7	2.5	11	18	2
M4	0.70	125	4.5	3.4	3.3	13	21	3
M5	0.80	140	6.0	4.9	4.2	15	25	3
M6	1.00	160	6.0	4.9	5.0	17	30	3
M8	1.25	180	8.0	6.2	6.8	20	35	3

TP

22 078 ...

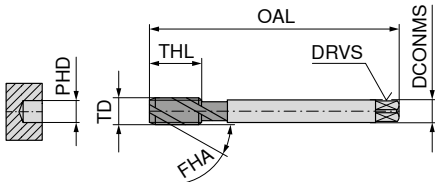
030

040

050

060

080



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M6	1.00	160	4.5	3.4	5.0	17	3
M8	1.25	180	6.0	4.9	6.8	20	3
M10	1.50	200	7.0	5.5	8.5	22	3
M12	1.75	224	9.0	7.0	10.2	24	3
M14	2.00	224	11.0	9.0	12.0	26	3
M16	2.00	224	12.0	9.0	14.0	27	3
M20	2.50	280	16.0	12.0	17.5	32	3

TP

22 080 ...

060

080

100

120

140

160

200

P	12
M	
K	12
N	12
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, left-hand – CavTap

▲ LH = For left-hand threads

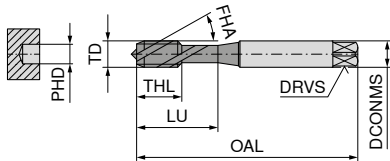
CavTap

M

ST
LH

C
2-3

ISO 2
6H



DIN 371 With reinforced shank



HSS-E
FHA 45°
≤ 750 N/mm²
≤ 3xD

TD mm	TP mm	OAL mm	DCONMS _{H9} mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M3	0.50	56	3.5	2.7	2.5	6	18	3
M4	0.70	63	4.5	3.4	3.3	7	21	3
M5	0.80	70	6.0	4.9	4.2	8	25	3
M6	1.00	80	6.0	4.9	5.0	10	30	3
M8	1.25	90	8.0	6.2	6.8	14	35	3
M10	1.50	100	10.0	8.0	8.5	16	39	3

TP

22 650 ...

03000

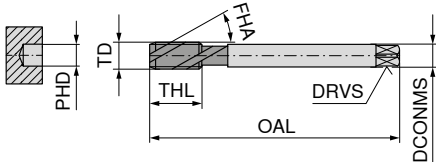
04000

05000

06000

08000

10000



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS _{H9} mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7	10.2	18	4
M16	2.00	110	12	9	14.0	22	4
M20	2.50	140	16	12	17.5	25	4

TP

22 651 ...

12000

16000

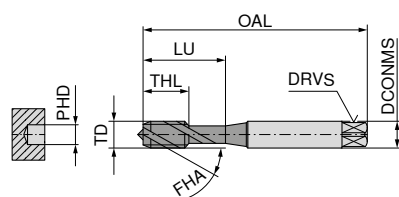
20000

P	2-15
M	
K	
N	8-20
S	
H	
O	

Cutting speed v_c (m/min)

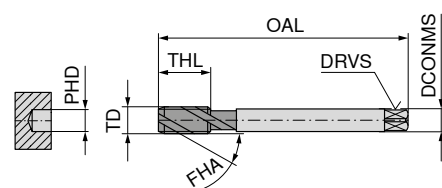
CoreLine – Blind hole – machine taps, right-hand

M



DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRV mm	PHD mm	THL mm	LU mm	Flutes
M2	0.40	45	2.8	2.1	1.60	4	12	2
M2	0.40	45	2.8	2.1	1.60	7	12	2
M2,5	0.45	50	2.8	2.1	2.05	5	14	2
M2,5	0.45	50	2.8	2.1	2.05	9	14	2
M3	0.50	56	3.5	2.7	2.50	11	18	2
M3	0.50	56	3.5	2.7	2.50	6	18	3
M4	0.70	63	4.5	3.4	3.30	7	21	3
M4	0.70	63	4.5	3.4	3.30	13	21	3
M5	0.80	70	6.0	4.9	4.20	8	25	3
M5	0.80	70	6.0	4.9	4.20	15	25	3
M6	1.00	80	6.0	4.9	5.00	10	30	3
M6	1.00	80	6.0	4.9	5.00	17	30	3
M8	1.25	90	8.0	6.2	6.80	14	35	3
M8	1.25	90	8.0	6.2	6.80	20	35	3
M10	1.50	100	10.0	8.0	8.50	16	39	3
M10	1.50	100	10.0	8.0	8.50	22	39	3



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRV mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7	10.2	18	3
M12	1.75	110	9	7	10.2	24	3
M14	2.00	110	11	9	12.0	20	3
M14	2.00	110	11	9	12.0	26	3
M16	2.00	110	12	9	14.0	22	3
M16	2.00	110	12	9	14.0	27	3
M20	2.50	140	16	12	17.5	25	3
M20	2.50	140	16	12	17.5	32	3

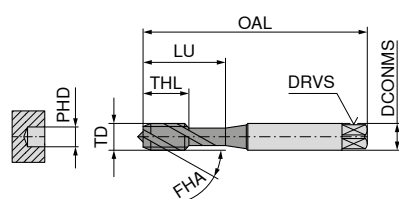
P	12	12	15
M			
K	12	12	15
N	22	22	24
S			
H			
O			

FE	FE	FE-HF
C 2-3	C 2-3	C 2-3
ISO 2 6H	ISO 2 6H	ISO 2 6H
		TiCN
HSS-E FHA 15° ≤ 850 N/mm² ≤ 2xD	HSS-E FHA 35° ≤ 850 N/mm² ≤ 2,5xD	HSS-E FHA 35° ≤ 1100 N/mm² ≤ 2,5xD

CX	CX	CX
23 214 ...	23 216 ...	23 312 ...
	020	
020	025	
025		
030		
	030	030
	040	040
040		
	050	050
050		
	060	060
060		
	080	080
080		
	100	100
100		

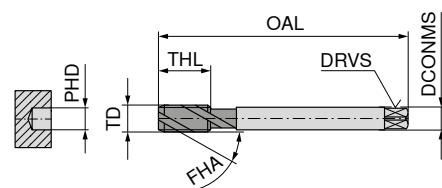
CX	CX	CX
23 215 ...	23 217 ...	23 313 ...
	120	120
120	140	
140		
	160	160
160		
	200	200
200		

CavTap M



DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M1,6	0.35	40	2.5	2.1	1.25	4	11	2
M2	0.40	45	2.8	2.1	1.60	4	12	2
M2,5	0.45	50	2.8	2.1	2.05	5	15	2
M2,5	0.45	50	2.8	2.1	2.05	5	15	3
M3	0.50	56	3.5	2.7	2.50	6	18	3
M4	0.70	63	4.5	3.4	3.30	7	21	3
M5	0.80	70	6.0	4.9	4.20	8	25	3
M6	1.00	80	6.0	4.9	5.00	10	30	3
M8	1.25	90	8.0	6.2	6.80	14	35	3
M10	1.50	100	10.0	8.0	8.50	16	39	3



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7.0	10.2	18	4
M14	2.00	110	11	9.0	12.0	20	4
M16	2.00	110	12	9.0	14.0	22	4
M20	2.50	140	16	12.0	17.5	25	4
M22	2.50	140	18	14.5	19.5	27	5
M24	3.00	160	18	14.5	21.0	30	5
M30	3.50	180	22	18.0	26.5	35	5

P	10	10	8
M	8	8	6
K			
N			
S			
H			
O			

VA	VA	VA
		
ISO 2 6H	ISO 2 6H	ISO 2 6H
TIN GS	TIN GS	vap.
		



HSS-E
FHA 45°
≤ 900 N/mm²
≤ 3xD

HSS-E
FHA 45°
≤ 900 N/mm²
≤ 3xD

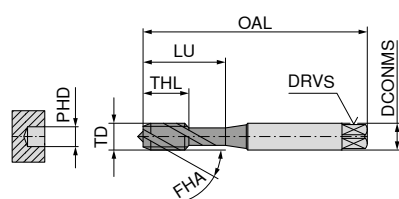
HSS-E
FHA 42°
≤ 900 N/mm²
≤ 3xD

TP	TP	TP
22 042 ...	22 040 ...	22 090 ...
	016	
	020	020
		025
	025	
	030	030
	040	040
050	050	050
060	060	060
080	080	080
100	100	100

Cutting speed v_c (m/min)

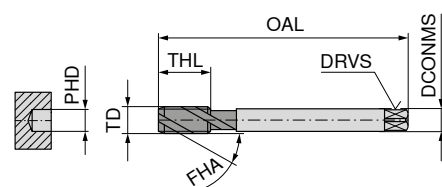
CoreLine – Blind hole – machine taps, right-hand

M



DIN 371 With reinforced shank

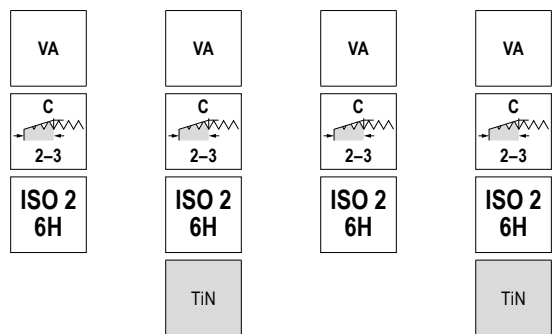
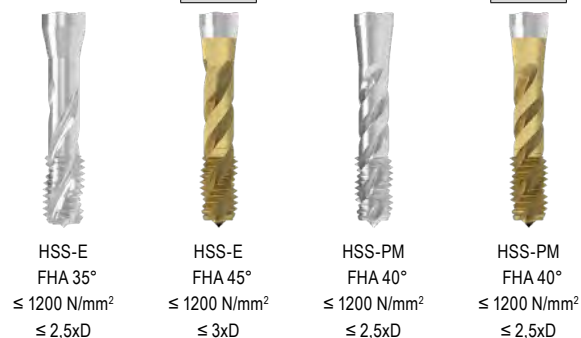
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M2	0.40	45	2.8	2.1	1.60	4	12	2
M2,5	0.45	50	2.8	2.1	2.05	5	14	2
M3	0.50	56	3.5	2.7	2.50	6	18	3
M4	0.70	63	4.5	3.4	3.30	7	21	3
M5	0.80	70	6.0	4.9	4.20	8	25	3
M6	1.00	80	6.0	4.9	5.00	10	30	3
M8	1.25	90	8.0	6.2	6.80	14	35	3
M10	1.50	100	10.0	8.0	8.50	16	39	3



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7.0	10.2	18	3
M12	1.75	110	9	7.0	10.2	18	4
M14	2.00	110	11	9.0	12.0	20	4
M16	2.00	110	12	9.0	14.0	22	3
M16	2.00	110	12	9.0	14.0	22	4
M20	2.50	140	16	12.0	17.5	25	3
M20	2.50	140	16	12.0	17.5	25	4
M24	3.00	160	18	14.5	21.0	30	4

P	8	10	8	10
M	6	8	6	8
K				
N	22	24	22	24
S				
H				
O				



HSS-E
FHA 35°
≤ 1200 N/mm²
≤ 2,5xD

HSS-E
FHA 45°
≤ 1200 N/mm²
≤ 3xD

HSS-PM
FHA 40°
≤ 1200 N/mm²
≤ 2,5xD

HSS-PM
FHA 40°
≤ 1200 N/mm²
≤ 2,5xD

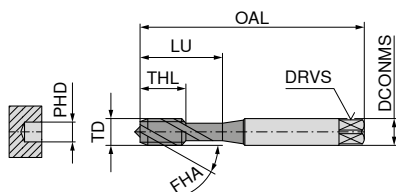
CX	CX	CX	CX
23 414 ...	23 416 ...	23 426 ...	23 456 ...
020	020		
025	025		
030	030	030	030
040	040	040	040
050	050	050	050
060	060	060	060
080	080	080	080
100	100	100	100

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap

CavTap

M



DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS _{h9} mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M2	0.40	45	2.8	2.1	1.60	4	12	2
M2,5	0.45	50	2.8	2.1	2.05	5	15	2
M3	0.50	56	3.5	2.7	2.50	6	18	2
M3	0.50	56	3.5	2.7	2.50	6	18	3
M4	0.70	63	4.5	3.4	3.30	7	21	2
M4	0.70	63	4.5	3.4	3.30	7	21	3
M5	0.80	70	6.0	4.9	4.20	8	25	2
M5	0.80	70	6.0	4.9	4.20	8	25	3
M6	1.00	80	6.0	4.9	5.00	10	30	2
M6	1.00	80	6.0	4.9	5.00	10	30	3
M8	1.25	90	8.0	6.2	6.80	14	35	2
M8	1.25	90	8.0	6.2	6.80	14	35	3
M10	1.50	100	10.0	8.0	8.50	16	39	2
M10	1.50	100	10.0	8.0	8.50	16	39	3

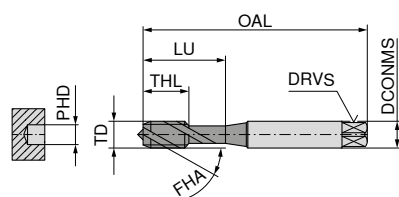
P			15
M			
K			
N	15-30	20-30	22
S			
H			
O		15-20	

Cutting speed v_c (m/min)

NW	Soft	Soft
C 2-3	C 2-3	C 2-3
ISO 2 6H	ISO 2 6H	ISO 2 6H
DLC	DLC	
HSS-E FHA 45° $\leq 880 \text{ N/mm}^2$ $\leq 3xD$	HSS-E FHA 45° $\leq 500 \text{ N/mm}^2$ $\leq 3xD$	HSS-E FHA 42° $\leq 500 \text{ N/mm}^2$ $\leq 3xD$

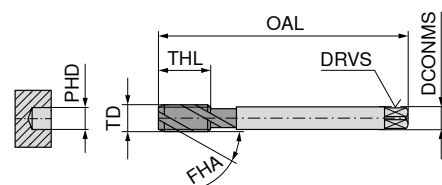
TP	TP	TP
22 655 ...	22 653 ...	22 326 ...
02000	02000	020
02500	02500	025
	03000	030
03000		
	04000	040
04000		
	05000	050
05000		
	06000	060
06000		
	08000	080
08000		
	10000	100
10000		

M



DIN 371 With reinforced shank

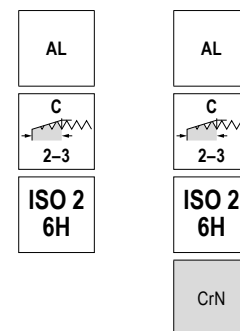
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M3	0.50	56	3.5	2.7	2.5	6	18	3
M4	0.70	63	4.5	3.4	3.3	7	21	3
M5	0.80	70	6.0	4.9	4.2	8	25	3
M6	1.00	80	6.0	4.9	5.0	10	30	3
M8	1.25	90	8.0	6.2	6.8	14	35	3
M10	1.50	100	10.0	8.0	8.5	16	39	3



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7	10.2	18	3

	15	20
P		
M		
K		
N		
S		
H		
O		

Cutting speed v_c (m/min)

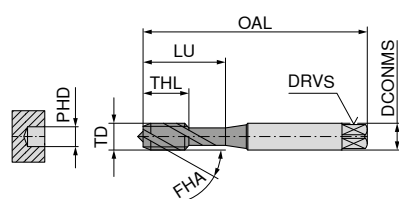
HSS-E
FHA 35°
≤ 500 N/mm²
≤ 2.5xD



HSS-E
FHA 35°
≤ 500 N/mm²
≤ 2.5xD

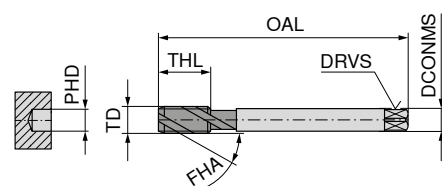
CX	CX
23 616 ...	23 614 ...
030	030
040	040
050	050
060	060
080	080
100	100

CoreLine – Blind hole – machine taps, right-hand – CavTap SL



DIN 371 With reinforced shank

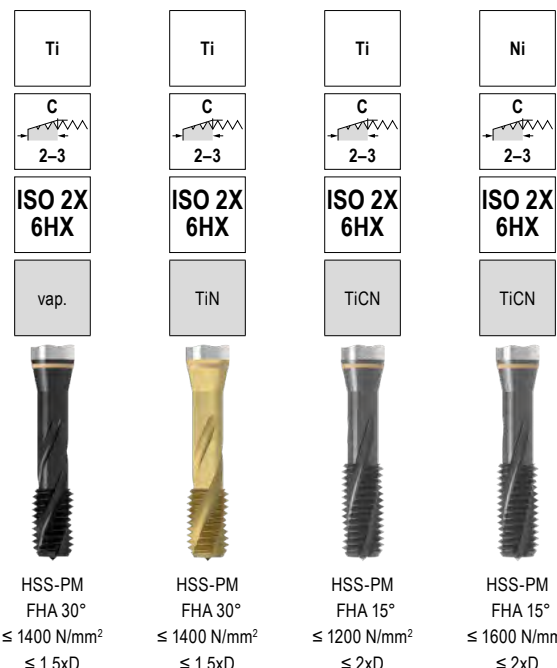
TD mm	TP mm	OAL mm	DCONMS mm	DRV mm	PHD mm	THL mm	LU mm	Flutes
M3	0.50	56	3.5	2.7	2.5	11	18	2
M3	0.50	56	3.5	2.7	2.5	6	18	3
M3,5	0.60	56	4.0	3.0	2.9	12	20	3
M4	0.70	63	4.5	3.4	3.3	7	21	3
M4	0.70	63	4.5	3.4	3.3	13	21	3
M5	0.80	70	6.0	4.9	4.2	8	25	3
M5	0.80	70	6.0	4.9	4.2	15	25	3
M6	1.00	80	6.0	4.9	5.0	10	30	3
M6	1.00	80	6.0	4.9	5.0	17	30	3
M8	1.25	90	8.0	6.2	6.8	14	35	3
M8	1.25	90	8.0	6.2	6.8	20	35	3
M10	1.50	100	10.0	8.0	8.5	16	39	3
M10	1.50	100	10.0	8.0	8.5	22	39	3
M12	1.75	110	12.0	9.0	10.2	18	44	3



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRV mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7.0	10.2	24	3
M14	2.00	110	11	9.0	12.0	26	3
M16	2.00	110	12	9.0	14.0	27	3
M20	2.50	140	16	12.0	17.5	32	3
M24	3.00	160	18	14.5	21.0	34	3

P	5	7	7
M	5	7	7
K			
N			22
S	3	5	5
H			
O			

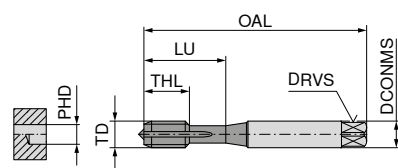


TP	TP	TP	TP
22 074 ...	22 076 ...	22 163 ...	22 424 ...
030	030	030	030
040	040	035	
050	050	040	040
060	060	050	050
080	080	060	060
100	100	080	080
120	120	100	100

TP	TP
22 164 ...	22 425 ...
120	120
140	140
160	160
200	200
240	

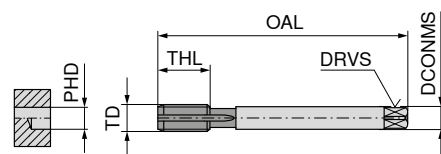
CoreLine – Through hole-blind hole – machine taps, right-hand – DuoTap

▲ EL = Extra long, with double overall length



DIN 371 With reinforced shank

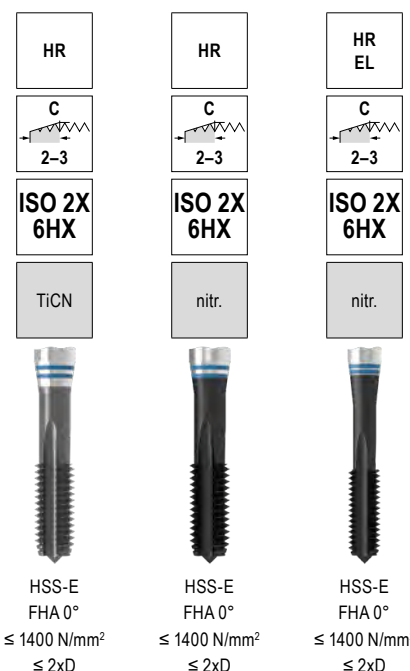
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M3	0.50	56	3.5	2.7	2.5	11	18	3
M3	0.50	100	3.5	2.7	2.5	11	18	3
M4	0.70	63	4.5	3.4	3.3	13	21	3
M4	0.70	125	4.5	3.4	3.3	13	21	3
M5	0.80	70	6.0	4.9	4.2	15	25	3
M5	0.80	140	6.0	4.9	4.2	15	25	3
M6	1.00	80	6.0	4.9	5.0	17	30	3
M6	1.00	160	6.0	4.9	5.0	17	30	3
M8	1.25	90	8.0	6.2	6.8	20	35	3
M8	1.25	180	8.0	6.2	6.8	20	35	3
M10	1.50	100	10.0	8.0	8.5	22	39	3



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M10	1.50	200	7	5.5	8.5	22	3
M12	1.75	110	9	7.0	10.2	24	3
M12	1.75	224	9	7.0	10.2	24	3
M16	2.00	110	12	9.0	14.0	27	3
M16	2.00	224	12	9.0	14.0	27	3
M20	2.50	280	16	12.0	17.5	32	4

	TP	TP	TP
P	22 141 ...	22 007 ...	22 123 ...
M			
K	120	120	100
N	160	160	120
S			160
H			200
O			



TP	TP	TP
22 126 ...	22 006 ...	22 122 ...
	030	
040	040	030
050	050	040
060	060	050
080	080	060
100	100	080

CoreLine – Through hole-blind hole – machine taps, right-hand – DuoTap

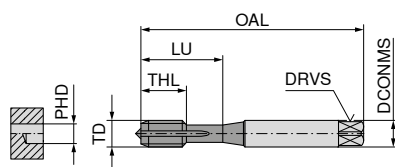
DuoTap

M

ST

ISO 2X
6HX

HSS-E
FHA 0°
≤ 750 N/mm²
≤ 2xD



DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M1,2	0.25	40	2.5	2.1	0.95	5	5	2
M1,4	0.30	40	2.5	2.1	1.10	6	6	2
M1,6	0.35	40	2.5	2.1	1.25	6	11	2
M1,7	0.35	40	2.5	2.1	1.35	6	11	2
M1,8	0.35	40	2.5	2.1	1.45	6	11	2
M2	0.40	45	2.8	2.1	1.60	7	12	3
M2,2	0.45	45	2.8	2.1	1.75	7	12	3
M2,3	0.40	45	2.8	2.1	1.90	7	12	3
M2,5	0.45	50	2.8	2.1	2.05	9	14	3
M2,6	0.45	50	2.8	2.1	2.15	9	14	3
M3	0.50	56	3.5	2.7	2.50	11	18	3
M3,5	0.60	56	4.0	3.0	2.90	12	20	3
M4	0.70	63	4.5	3.4	3.30	13	21	3
M5	0.80	70	6.0	4.9	4.20	15	25	3
M6	1.00	80	6.0	4.9	5.00	17	30	3
M7	1.00	80	7.0	5.5	6.00	17	30	3
M8	1.25	90	8.0	6.2	6.80	20	35	3
M10	1.50	100	10.0	8.0	8.50	22	39	3

TP

22 028 ...

012 ¹⁾014 ¹⁾

016

017

018

020

022

023

025

026

030

035

040

050

060

070

080

100

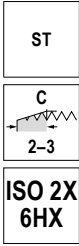
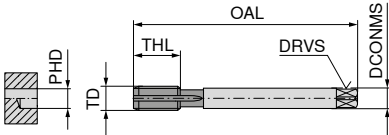
P	12
M	
K	12
N	
S	
H	
O	

1) Tol. 4H/5H ≤ M1.4

Cutting speed v_c (m/min)

See next page for DIN 376.

CoreLine – Through hole-blind hole – machine taps, right-hand – DuoTap



DIN 376 With reduced shank



HSS-E
FHA 0°
≤ 750 N/mm²
≤ 2xD

TD	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
M4	0.70	63	2.8	2.1	3.3	13	3
M5	0.80	70	3.5	2.7	4.2	15	3
M6	1.00	80	4.5	3.4	5.0	17	3
M8	1.25	90	6.0	4.9	6.8	20	3
M10	1.50	100	7.0	5.5	8.5	22	3
M12	1.75	110	9.0	7.0	10.2	24	3
M14	2.00	110	11.0	9.0	12.0	26	3
M16	2.00	110	12.0	9.0	14.0	27	3

TP
22 029 ...
040
050
060
080
100
120
140
160

P	12
M	
K	12
N	
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine

– Through hole-blind hole – machine taps, right-hand – DuoTap

▲ ES = Extra short

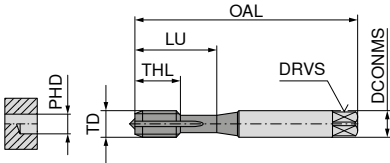
DuoTap

M

ST
ES

C
2-3

ISO 2X
6HX



DIN 352 With reinforced shank



HSS-E
FHA 0°
≤ 750 N/mm²
≤ 2xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M2	0.40	36	2.8	2.1	1.60	8	3
M2,5	0.45	40	2.8	2.1	2.05	9	3
M3	0.50	40	3.5	2.7	2.50	10	3
M4	0.70	45	4.5	3.4	3.30	12	3
M5	0.80	50	6.0	4.9	4.20	14	3
M6	1.00	56	6.0	4.9	5.00	16	3
M8	1.25	63	6.0	4.9	6.80	20	3
M10	1.50	70	7.0	5.5	8.50	22	3
M12	1.75	75	9.0	7.0	10.20	24	3

TP

22 018 ...

020

025

030

040

050

060

080

100

120

P	12
M	
K	12
N	
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine

– Through hole-blind hole – machine taps, left-hand – DuoTap

▲ LH = For left-hand threads; ES = Extra short

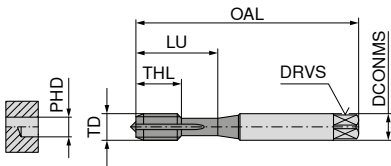
DuoTap

M

ST
LH/ES

C
2-3

ISO 2X
6HX



DIN 352 With reinforced shank



HSS-E
FHA 0°
≤ 750 N/mm²
≤ 2xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M3	0.50	40	3.5	2.7	2.5	10	3
M4	0.70	45	4.5	3.4	3.3	12	3
M5	0.80	50	6.0	4.9	4.2	14	3
M6	1.00	56	6.0	4.9	5.0	16	3
M8	1.25	63	6.0	4.9	6.8	20	3
M10	1.50	70	7.0	5.5	8.5	22	3
M12	1.75	75	9.0	7.0	10.2	24	3

TP

22 019 ...

030

040

050

060

080

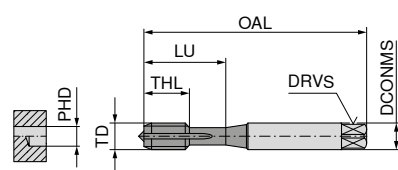
100

120

P	12
M	
K	12
N	
S	
H	
O	

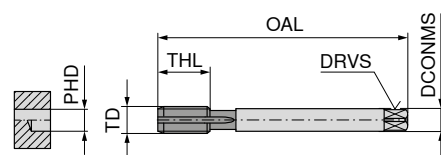
Cutting speed v_c (m/min)

CoreLine – Through hole-blind hole – machine taps, right-hand – DuoTap



DIN 371 With reinforced shank

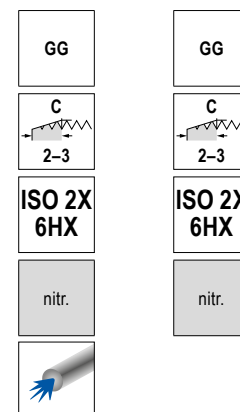
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M2	0.40	45	2.8	2.1	1.60	7	12	3
M2,5	0.45	50	2.8	2.1	2.05	9	14	3
M3	0.50	56	3.5	2.7	2.50	11	18	3
M3,5	0.60	56	4.0	3.0	2.90	12	20	3
M4	0.70	63	4.5	3.4	3.30	13	21	3
M5	0.80	70	6.0	4.9	4.20	15	25	3
M6	1.00	80	6.0	4.9	5.00	17	30	3
M8	1.25	90	8.0	6.2	6.80	20	35	3
M10	1.50	100	10.0	8.0	8.50	22	39	3



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M6	1.00	80	4.5	3.4	5.0	17	3
M8	1.25	90	6.0	4.9	6.8	20	3
M10	1.50	100	7.0	5.5	8.5	22	3
M12	1.75	110	9.0	7.0	10.2	24	3
M14	2.00	110	11.0	9.0	12.0	26	3
M16	2.00	110	12.0	9.0	14.0	27	3

P		
M		
K	16	16
N	12	12
S		
H		
O		



HSS-E
FHA 0°
≤ 1050 N/mm²
≤ 2xD

HSS-E
FHA 0°
≤ 1050 N/mm²
≤ 2xD

TP	TP
22 036 ...	22 032 ...
	020
	025
	030
	035
	040
050	050
060	060
080	080
100	100

CoreLine – Through hole-blind hole – machine taps, right-hand

M

DIN 371 With reinforced shank

TD	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
M3	0.50	56	3.5	2.7	2.5	11	18	3
M4	0.70	63	4.5	3.4	3.3	13	21	3
M5	0.80	70	6.0	4.9	4.2	15	25	3
M6	1.00	80	6.0	4.9	5.0	17	30	3
M8	1.25	90	8.0	6.2	6.8	20	35	3
M10	1.50	100	10.0	8.0	8.5	22	39	3

DIN 376 With reduced shank

TD	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
M12	1.75	110	9	7	10.2	24	3

GG

ISO 2X 6HX

nitr.

HSS-E
FHA 0°
≤ 900 N/mm²
≤ 2xD

GG

ISO 2X 6HX

TiCN

HSS-E
FHA 0°
≤ 900 N/mm²
≤ 2xD

CX

23 510 ...

030

040

050

060

080

100

CX

23 512 ...

050

060

080

100

CX

23 511 ...

120

CX

23 513 ...

120

P

M

K

N

S

H

O

10

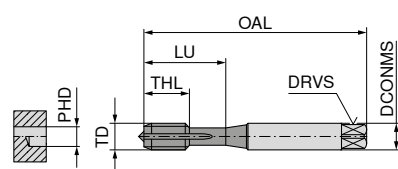
20

24

Cutting speed v_c (m/min)

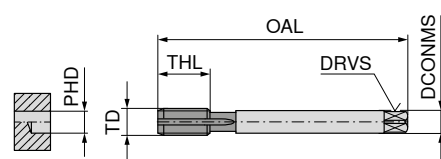
MonoThread – Through hole-blind hole - machine taps, right-hand with carbide strips – DuoTap

- ▲ Specially designed for ductile iron
- ▲ Flexible HSS shank and hard cutting edge in one tool
- ▲ HML = With soldered-in carbide strips for a higher cutting speed



DIN 371 With reinforced shank

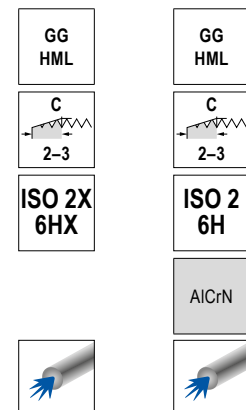
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm
M6	1.00	80	6	4.9	5.0	18	30
M8	1.25	90	8	5.5	6.8	18	35
M10	1.50	100	10	6.2	8.5	21	39
M10	1.50	100	10	8.0	8.5	21	39



DIN 376 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm
M12	1.75	110	9	6.2	10.2	24
M16	2.00	110	12	9.0	14.0	27

P		
M		
K	30	30
N		
S		
H		
O		



HSS-E
FHA 0°
≤ 1050 N/mm²
≤ 2xD

HSS-E / HM
FHA 0°
≤ 1050 N/mm²
≤ 2xD

TP
22 471 ...
06000
10000

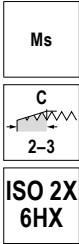
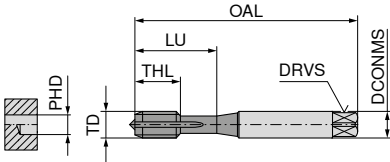
TP
22 472 ...
08000
10000

TP
22 472 ...
12000
16000

Cutting speed v_c (m/min)

CoreLine

– Through hole-blind hole – machine taps, right-hand – DuoTap



DIN 371 With reinforced shank



TD	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
M2	0.40	45	2.8	2.1	1.60	7	12	3
M2,5	0.45	50	2.8	2.1	2.05	9	14	3
M3	0.50	56	3.5	2.7	2.50	11	18	3
M4	0.70	63	4.5	3.4	3.30	13	21	3
M5	0.80	70	6.0	4.9	4.20	15	25	3
M6	1.00	80	6.0	4.9	5.00	17	30	3
M8	1.25	90	8.0	6.2	6.80	20	35	3
M10	1.50	100	10.0	8.0	8.50	22	39	3

TP
22 119 ...
020
025
030
040
050
060
080
100

P
M
K
N
S
H
O

Cutting speed v_c (m/min)

CoreLine

– Through hole-blind hole – machine taps, right-hand – DuoTap

DuoTap

M

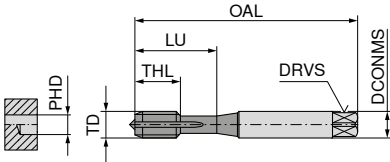
AMPCO



ISO 2X
6HX



HSS-PM
FHA 0°
≤ 800 N/mm²
≤ 2xD



DIN 371 With reinforced shank

TD	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
M3	0.50	56	3.5	2.7	2.5	11	18	3
M4	0.70	63	4.5	3.4	3.3	13	21	3
M5	0.80	70	6.0	4.9	4.2	15	25	3
M6	1.00	80	6.0	4.9	5.0	17	30	3
M8	1.25	90	8.0	6.2	6.8	20	35	3
M10	1.50	100	10.0	8.0	8.5	22	39	3

TP

22 030 ...

030

040

050

060

080

100

P
M
K
N
S
H
O

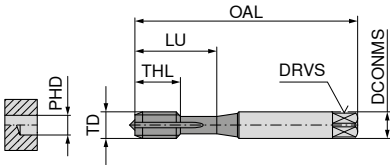
Cutting speed v_c (m/min)

CoreLine

– Through hole-blind hole – machine taps, right-hand – DuoTap

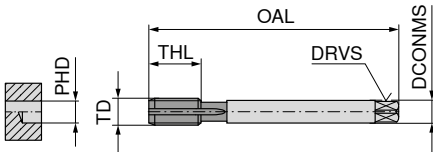
DuoTap

M



DIN 371 With reinforced shank

TD	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
M3	0.50	63	4.5	3.4	2.55	6	18	4
M4	0.70	63	4.5	3.4	3.40	8	20	4
M5	0.80	70	6.0	4.9	4.30	10	26	4
M6	1.00	80	6.0	4.9	5.00	10	30	4
M6	1.00	80	6.0	4.9	5.10	12	28	4
M8	1.25	90	8.0	6.2	6.80	14	35	5
M8	1.25	90	8.0	6.2	6.90	15	35	5
M10	1.50	100	10.0	8.0	8.50	18	38	5
M10	1.50	100	10.0	8.0	8.50	16	39	5
M12	1.75	110	12.0	9.0	10.40	21	41	5
M16	2.00	110	16.0	12.0	14.20	24	44	6



DIN 376 With reduced shank

TD	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
M12	1.75	110	9	7	10.4	18	5
M16	2.00	110	12	9	14.2	22	6

HT

ISO 2X 6HX

TiCN

HSS-PM
FHA 0°
44 - 52 HRC
≤ 1,5xD

HT

ISO 2X 6HX

OSM

Solid carbide
FHA 0°
≤ 63 HRC
≤ 1,5xD

TP

22 227 ...

TP

22 806 ...

030

040

050

060

060

080

080

100

100

120

160

P		
M		
K		
N	22	
S		
H	2	2
O		

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps for wire thread inserts, right hand – TruTap

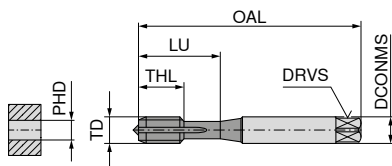
TruTap

EG M

UNI

B
4-56H
modnitr. +
vap.

HSS-E
FHA 0°
≤ 1100 N/mm²
≤ 4xD



DIN 40435 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
EG-M2,5	0.45	56	3.5	2.7	2.65	11	18	3
EG-M3	0.50	63	4.5	3.4	3.15	10	21	3
EG-M4	0.70	70	6.0	4.9	4.20	12	25	3
EG-M5	0.80	80	6.0	4.9	5.25	13	30	3
EG-M6	1.00	90	8.0	6.2	6.30	17	35	3
EG-M8	1.25	100	10.0	8.0	8.40	18	39	3

TP

22 662 ...

025

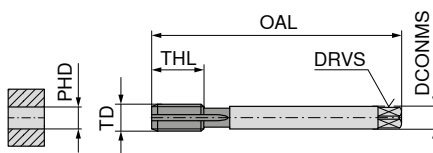
030

040

050

060

080



DIN 40435 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
EG-M10	1.50	100	9	7.0	10.50	22	3
EG-M12	1.75	110	11	9.0	12.50	26	3
EG-M16	2.00	125	14	11.0	16.50	27	3
EG-M20	2.50	160	18	14.5	20.75	34	3

TP

22 663 ...

100

120

160

200

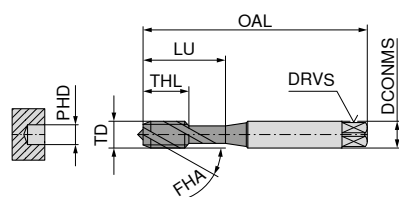
P	12
M	7
K	12
N	
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps for wire thread inserts, right hand – CavTap

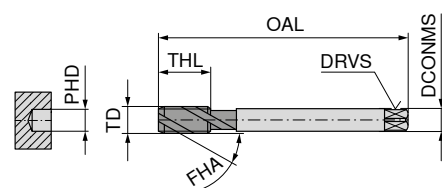
CavTap

EG M



DIN 40435 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS _{h9} mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
EG-M2,5	0.45	56	3.5	2.7	2.65	5	18	2
EG-M2,5	0.45	56	3.5	2.7	2.65	5	18	3
EG-M3	0.50	63	4.5	3.4	3.15	5	21	2
EG-M3	0.50	63	4.5	3.4	3.15	5	21	3
EG-M4	0.70	70	6.0	4.9	4.20	8	25	2
EG-M4	0.70	70	6.0	4.9	4.20	8	25	3
EG-M5	0.80	80	6.0	4.9	5.25	8	30	2
EG-M5	0.80	80	6.0	4.9	5.25	8	30	3
EG-M6	1.00	90	8.0	6.2	6.30	10	35	2
EG-M6	1.00	90	8.0	6.2	6.30	10	35	3
EG-M8	1.25	100	10.0	8.0	8.40	16	39	2
EG-M8	1.25	100	10.0	8.0	8.40	16	39	3



DIN 40435 With reduced shank

TD mm	TP mm	OAL mm	DCONMS _{h9} mm	DRVS mm	PHD mm	THL mm	Flutes
EG-M10	1.50	100	9	7.0	10.50	15	5
EG-M12	1.75	110	11	9.0	12.50	20	4
EG-M16	2.00	125	14	11.0	16.50	20	5
EG-M20	2.50	160	18	14.5	20.75	30	4

P	12
M	7
K	12
N	20-30
S	
H	
O	15-20

UNI	Soft
C 2-3	C 2-3
6H mod	6H mod
vap.	DLC



HSS-E
FHA 42°
≤ 1100 N/mm²
≤ 3xD

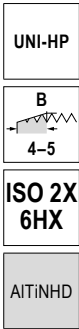


HSS-E
FHA 45°
≤ 500 N/mm²
≤ 3xD

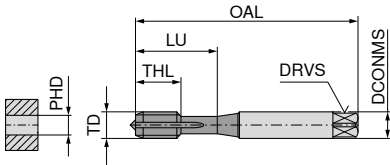
TP	TP
22 664 ...	22 647 ...
025	02500
030	03000
040	04000
050	05000
060	06000
080	08000

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand – TruTap



HSS-E-PM
FHA 0°
≤ 1400 N/mm²
≤ 4xD



DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS _{h9} mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M4x0,5	0.5	63	4.5	3.4	3.5	5	21	3
M5x0,5	0.5	70	6.0	4.9	4.5	5	25	3

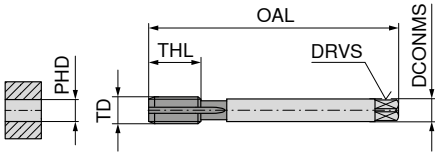
NEW

TP

22 864 ...

04000

05000



DIN 374 With reduced shank

TD mm	TP mm	OAL mm	DCONMS _{h9} mm	DRVS mm	PHD mm	THL mm	Flutes
M8x1	1.00	90	6	4.9	7.0	10	4
M10x1	1.00	90	7	5.5	9.0	10	4
M10x1,25	1.25	100	7	5.5	8.8	16	4
M12x1	1.00	100	9	7.0	11.0	11	4
M12x1,25	1.25	100	9	7.0	10.8	15	4
M12x1,5	1.50	100	9	7.0	10.5	15	4
M14x1,5	1.50	100	11	9.0	12.5	15	4
M16x1,5	1.50	100	12	9.0	14.5	15	4
M18x1,5	1.50	110	14	11.0	16.5	17	4
M20x1,5	1.50	125	16	12.0	18.5	17	4

TP

22 865 ...

08100

10200

10400

12000

12200

12100

14400

16200

18200

20200

P	2-18
M	2-10
K	10-20
N	15-30
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand – TruTap

TruTap

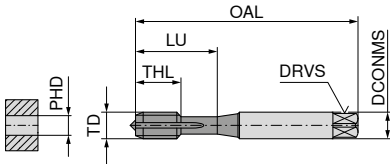
MF

UNI


B
4-5

ISO 2
6H

TiN



DIN 371 With reinforced shank



HSS-E
FHA 0°
≤ 1100 N/mm²
≤ 4xD

TD	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
M5x0,5	0.50	70	6	4.9	4.5	11	25	3
M6x0,5	0.50	80	6	4.9	5.5	13	30	3
M6x0,75	0.75	80	6	4.9	5.2	13	30	3
M8x1	1.00	90	8	6.2	7.0	17	35	3
M10x1	1.00	90	10	8.0	9.0	18	35	4

TP

22 550 ...

050

060

062

080

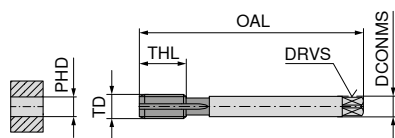
100

P	15
M	9
K	18
N	12
S	
H	
O	

Cutting speed v_c (m/min)

See next page for DIN 374.

CoreLine – Through hole – machine taps, right-hand – TruTap



DIN 374 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M8x0,75	0.75	80	6	4.9	7.2	14	3
M8x1	1.00	90	6	4.9	7.0	17	3
M10x0,75	0.75	90	7	5.5	9.2	18	4
M10x1	1.00	90	7	5.5	9.0	18	4
M10x1,25	1.25	100	7	5.5	8.8	22	3
M12x1	1.00	100	9	7.0	11.0	18	4
M12x1,25	1.25	100	9	7.0	10.8	22	3
M12x1,5	1.50	100	9	7.0	10.5	22	3
M14x1	1.00	100	11	9.0	13.0	18	4
M14x1,5	1.50	100	11	9.0	12.5	22	3
M16x1,5	1.50	100	12	9.0	14.5	22	3
M18x1	1.00	110	14	11.0	17.0	20	5
M18x1,5	1.50	110	14	11.0	16.5	25	4
M18x2	2.00	125	14	11.0	16.0	26	3
M20x1	1.00	125	16	12.0	19.0	20	5
M20x1,5	1.50	125	16	12.0	18.5	25	4
M22x1,5	1.50	125	18	14.5	20.5	25	4
M24x1,5	1.50	140	18	14.5	22.5	27	4
M24x2	2.00	140	18	14.5	22.0	27	4
M25x1,5	1.50	140	18	14.5	23.5	28	4
M26x1,5	1.50	140	18	14.5	24.5	28	4
M27x2	2.00	140	20	16.0	25.0	28	4
M28x1,5	1.50	140	20	16.0	26.5	28	5
M30x1,5	1.50	150	22	18.0	28.5	28	5

P	12	12	15
M	7	7	9
K	12	12	18
N			12
S			
H			
O			

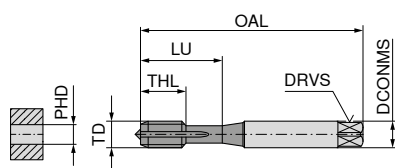
UNI	UNI	UNI
B 4-5	B 4-5	B 4-5
ISO 2 6H	ISO 3 6G	ISO 2 6H
nit. + vap.	nit. + vap.	TiN
HSS-E FHA 0° ≤ 1100 N/mm² ≤ 4xD	HSS-E FHA 0° ≤ 1100 N/mm² ≤ 4xD	HSS-E FHA 0° ≤ 1100 N/mm² ≤ 4xD

TP	TP	TP
22 551 ...	22 599 ...	22 552 ...
082		
084	082	080
100		
102	102	100
104		
120	120	121
122		
124	124	120
140		
144	144	140
162	162	160
180		
182	182	
184		
200		
202	202	200
222		220
242		
244		
250		
260		
272		
280		
302		

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand

MF



DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M4x0,5	0.50	63	4.5	3.4	3.5	10	21	3
M6x0,5	0.50	80	6.0	4.9	5.5	13	30	3
M5x0,5	0.50	70	6.0	4.9	4.5	11	25	3
M6x0,75	0.75	80	6.0	4.9	5.2	13	30	3

P	12	15
M	7	9
K	12	18
N		12
S		
H		
O		

Cutting speed v_c (m/min)

UNI	UNI
B 4-5	B 4-5
ISO 2 6H	ISO 2 6H
nitr. + vap.	TiN

HSS-E
FHA 0°
≤ 1000 N/mm²
≤ 3xDHSS-E
FHA 0°
≤ 1000 N/mm²
≤ 3xD

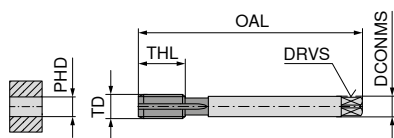
CX	CX
23 140 ...	23 142 ...
040	040
060	060
050	050
062	062

i

See next page for DIN 374.

CoreLine – Through hole – machine taps, right-hand

MF



DIN 374 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M8x0,75	0.75	80	6	4.9	7.2	14	3
M8x1	1.00	90	6	4.9	7.0	17	4
M8x1	1.00	90	6	4.9	7.0	17	3
M10x0,75	0.75	90	7	5.5	9.2	18	4
M10x1	1.00	90	7	5.5	9.0	18	4
M10x1,25	1.25	100	7	5.5	8.8	22	3
M12x1	1.00	100	9	7.0	11.0	18	4
M12x1,25	1.25	100	9	7.0	10.8	22	3
M12x1,5	1.50	100	9	7.0	10.5	22	3
M14x1	1.00	100	11	9.0	13.0	18	4
M14x1,25	1.25	100	11	9.0	12.8	22	3
M14x1,5	1.50	100	11	9.0	12.5	22	3
M16x1	1.00	100	12	9.0	15.0	18	4
M16x1,5	1.50	100	12	9.0	14.5	22	3
M18x1,5	1.50	110	14	11.0	16.5	17	4
M18x1,5	1.50	110	14	11.0	16.5	25	4
M20x1,5	1.50	125	16	12.0	18.5	17	4
M20x1,5	1.50	125	16	12.0	18.5	25	4
M22x1,5	1.50	125	18	14.5	20.5	25	4
M24x1,5	1.50	140	18	14.5	22.5	27	4
M24x2	2.00	140	18	14.5	22.0	27	4

P	15	12	15
M	9	7	9
K	18	12	18
N	12		12
S			
H			
O			

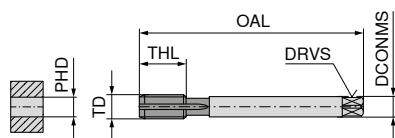
Cutting speed v_c (m/min)

UNI	UNI	UNI
B 4-5	B 4-5	B 4-5
ISO 2 6H	ISO 2 6H	ISO 2 6H
TiN	nitr. + vap.	TiN
HSS-PM FHA 0° ≤ 1000 N/mm² ≤ 3xD	HSS-E FHA 0° ≤ 1000 N/mm² ≤ 3xD	HSS-E FHA 0° ≤ 1000 N/mm² ≤ 3xD
CX 23 041 ...	CX 23 141 ...	CX 23 143 ...
	082	082
		084
081	084	
	100	100
102	102	102
104	104	104
120	120	120
122	122	122
121	124	124
	140	140
142		
144	144	144
	160	160
162	162	162
182		
	182	182
202		
	202	202
222	222	222
242	242	242
244		

CoreLine – Through hole – machine taps, right-hand

MF

FE

ISO 2
6HHSS-E
FHA 0°
 $\leq 850 \text{ N/mm}^2$
 $\leq 3xD$


DIN 374 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	CX 23 241 ...
M8x0,5	0.50	80	6	4.9	7.5	14	3	080
M8x0,75	0.75	80	6	4.9	7.2	14	3	082
M8x1	1.00	90	6	4.9	7.0	17	3	084
M10x0,75	0.75	90	7	5.5	9.2	18	4	100
M10x1	1.00	90	7	5.5	9.0	18	4	102
M10x1,25	1.25	100	7	5.5	8.8	22	3	104
M12x1	1.00	100	9	7.0	11.0	18	4	120
M12x1,25	1.25	100	9	7.0	10.8	22	3	122
M12x1,5	1.50	100	9	7.0	10.5	22	3	124
M14x1	1.00	100	11	9.0	13.0	18	4	140
M14x1,5	1.50	100	11	9.0	12.5	22	3	144
M16x1	1.00	100	12	9.0	15.0	18	4	160
M16x1,5	1.50	100	12	9.0	14.5	22	3	162
M18x1	1.00	110	14	11.0	17.0	20	5	180
M18x1,5	1.50	110	14	11.0	16.5	25	4	182
M20x1	1.00	125	16	12.0	19.0	20	5	200
M20x1,5	1.50	125	16	12.0	18.5	25	4	202
M22x1,5	1.50	125	18	14.5	20.5	25	4	222
M24x1,5	1.50	140	18	14.5	22.5	27	4	242
M26x1,5	1.50	140	18	14.5	24.5	28	4	260
M28x1,5	1.50	140	20	16.0	26.5	28	5	280
M30x1,5	1.50	150	22	18.0	28.5	28	5	300
P								12
M								
K								12
N								12
S								
H								
O								

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand

MF

FE-HF

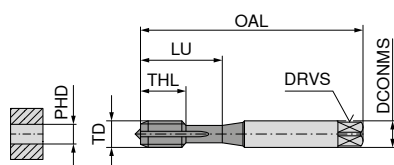


B
4-5
ISO 2
6H

TiCN



HSS-E
FHA 0°
≤ 1100 N/mm²
≤ 4xD



DIN 371 With reinforced shank

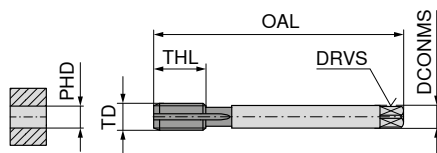
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M5x0,5	0.50	70	6	4.9	4.5	11	25	3
M6x0,75	0.75	80	6	4.9	5.2	13	30	3

CX

23 340 ...

050

062



DIN 374 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M8x0,75	0.75	80	6	4.9	7.0	14	3
M8x1	1.00	90	6	4.9	7.0	17	3
M10x1	1.00	90	7	5.5	9.0	18	4
M12x1	1.00	100	9	7.0	11.0	18	4
M12x1,5	1.50	100	9	7.0	10.5	22	3
M14x1,5	1.50	100	11	9.0	12.5	22	3
M16x1,5	1.50	100	12	9.0	14.5	22	3

CX

23 341 ...

082

084

102

120

124

144

162

P	15
M	
K	15
N	15
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand

MF

VA

B

4-5

ISO 2 6H

TiN

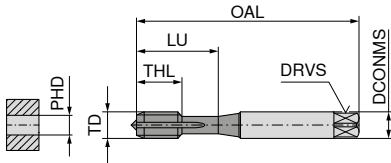


HSS-E

FHA 0°

≤ 1200 N/mm²

≤ 4xD



DIN 371 With reinforced shank

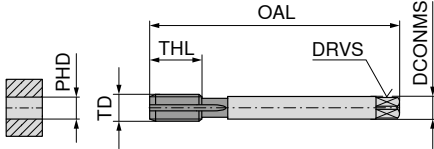
TD	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
M5x0,5	0.50	70	6	4.9	4.5	11	25	3
M6x0,75	0.75	80	6	4.9	5.2	13	30	3

CX

23 440 ...

050

062



DIN 374 With reduced shank

TD	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
M8x0,75	0.75	80	6	4.9	7.2	14	3
M8x1	1.00	90	6	4.9	7.0	17	3
M10x1	1.00	90	7	5.5	9.0	18	4
M12x1	1.00	100	9	7.0	11.0	18	4
M12x1,5	1.50	100	9	7.0	10.5	22	3
M14x1,5	1.50	100	11	9.0	12.5	22	3
M16x1,5	1.50	100	12	9.0	14.5	22	3

CX

23 441 ...

082

084

102

120

124

144

162

P

M

K

N

S

H

O

10

8

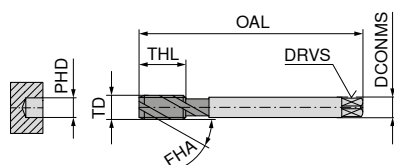
24

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap

CavTap

MF



DIN 376 With reduced shank

UNI-HP

ISO 2X
6HX

AITiNHD



HSS-E-PM
FHA 45°
≤ 1400 N/mm²
≤ 3xD

TD mm	TP mm	OAL mm	DCONMS _{H9} mm	DRVS mm	PHD mm	THL mm	Flutes
M6x0,75	0.75	80	4.5	3.4	5.2	8	3
M8x1	1.00	90	6.0	4.9	7.0	10	3
M10x1	1.00	90	7.0	5.5	9.0	10	4
M10x1,25	1.25	100	7.0	5.5	8.8	16	4
M12x1	1.00	100	9.0	7.0	11.0	11	4
M12x1,25	1.25	100	9.0	7.0	10.8	15	5
M12x1,5	1.50	100	9.0	7.0	10.5	15	5
M14x1,5	1.50	100	11.0	9.0	12.5	15	5
M16x1,5	1.50	100	12.0	9.0	14.5	15	5
M18x1,5	1.50	110	14.0	11.0	16.5	17	5
M20x1,5	1.50	125	16.0	12.0	18.5	17	5
M22x1,5	1.50	125	18.0	14.5	20.5	17	5
M24x1,5	1.50	140	18.0	14.5	22.5	20	5

NEW
TP

22 831 ...

06200
08100
10200
10400
12000
12200
12100
14400
16200
18200
20200
22200
24200

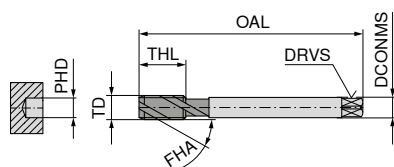
P	2-18
M	2-10
K	10-20
N	15-30
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap

CavTap

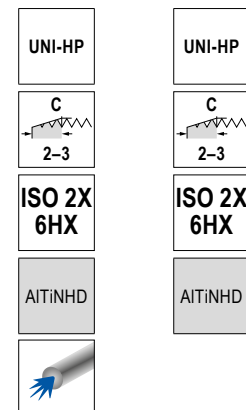
MF



DIN 374 With reduced shank

TD mm	TP mm	OAL mm	DCONMS _{h8} mm	DRVS mm	PHD mm	THL mm	Flutes
M6x0,75	0.75	80	4.5	3.4	5.2	8	3
M8x1	1.00	90	6.0	4.9	7.0	10	3
M10x1	1.00	90	7.0	5.5	9.0	10	4
M10x1,25	1.25	100	7.0	5.5	8.8	16	4
M12x1	1.00	100	9.0	7.0	11.0	11	4
M12x1,25	1.25	100	9.0	7.0	10.8	15	5
M12x1,5	1.50	100	9.0	7.0	10.5	15	5
M14x1,5	1.50	100	11.0	9.0	12.5	15	5
M16x1,5	1.50	100	12.0	9.0	14.5	15	5
M18x1,5	1.50	110	14.0	11.0	16.5	17	5
M20x1,5	1.50	125	16.0	12.0	18.5	17	5
M22x1,5	1.50	125	18.0	14.5	20.5	17	5
M24x1,5	1.50	140	18.0	14.5	22.5	20	5

P	2-18	2-18
M	2-10	2-10
K	10-20	10-20
N	15-30	15-30
S		
H		
O		



HSS-E-PM
FHA 45°
≤ 1400 N/mm²
≤ 3xD



HSS-E-PM
FHA 45°
≤ 1400 N/mm²
≤ 3xD

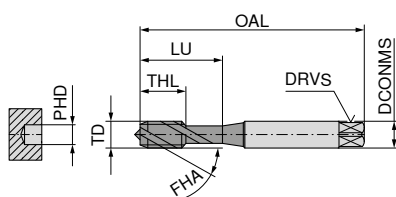
NEW TP	NEW TP
22 837 ...	22 822 ...
06200	06200
08100	08100
10200	10200
10400	10400
12000	12000
12200	12200
12100	12600
14400	14400
16200	16200
18200	18200
20200	20200
22200	22200
24200	24200

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap

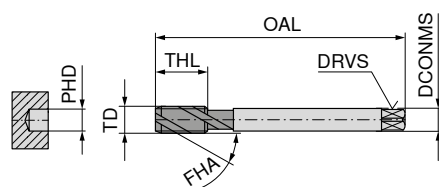
CavTap

MF



DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRV mm	PHD mm	THL mm	LU mm	Flutes
M4x0,5	0.50	63	4.5	3.4	3.50	5	21	3
M5x0,5	0.50	70	6.0	4.9	4.50	5	25	3
M6x0,75	0.75	80	6.0	4.9	5.25	8	30	3



DIN 374 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRV mm	PHD mm	THL mm	Flutes
M8x1	1.0	90	6	4.9	7.0	10	3
M10x1	1.0	90	7	5.5	9.0	10	4
M12x1,5	1.5	100	9	7.0	10.5	15	5
M14x1,5	1.5	100	11	9.0	12.5	15	5
M16x1,5	1.5	100	12	9.0	14.5	15	5
M18x1,5	1.5	110	14	11.0	16.5	17	5
M20x1,5	1.5	125	16	12.0	18.5	17	5

P	15	12	12
M	9	7	7
K	18	12	12
N	12		
S			
H			
O			

Cutting speed v_c (m/min)

UNI	UNI	UNI
E 1,5-2	E 1,5-2	E 1,5-2
ISO 2 6H	ISO 2 6H	ISO 3 6G
TiN	vap.	vap.
HSS-E FHA 42° $\leq 1100 \text{ N/mm}^2$ $\leq 3xD$	HSS-E FHA 42° $\leq 1100 \text{ N/mm}^2$ $\leq 3xD$	HSS-E FHA 42° $\leq 1100 \text{ N/mm}^2$ $\leq 3xD$

TP

22 441 ...

040

050

062

TP

22 556 ...

080

100

120

140

160

TP

22 555 ...

080

100

120

140

160

TP

22 490 ...

080

100

120

140

160

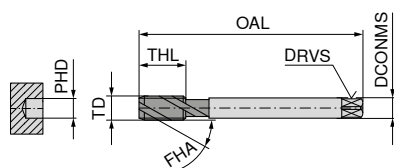
180

200

CoreLine – Blind hole – machine taps, right-hand – CavTap

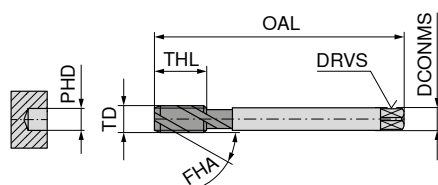
CavTap

MF



DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS _{h9} mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M4x0,5	0.50	63	4.5	3.4	3.5	5	21	3
M5x0,5	0.50	70	6.0	4.9	4.5	5	25	3
M6x0,5	0.50	80	6.0	4.9	5.5	5	30	3
M6x0,75	0.75	80	6.0	4.9	5.2	8	30	3



DIN 374 With reduced shank

TD mm	TP mm	OAL mm	DCONMS _{h9} mm	DRVS mm	PHD mm	THL mm	Flutes
M6x0,75	0.75	80	4.5	3.4	5.2	8	3
M8x0,75	0.75	80	6.0	4.9	7.2	8	3
M8x1	1.00	90	6.0	4.9	7.0	10	3
M10x0,75	0.75	90	7.0	5.5	9.2	10	4
M10x1	1.00	90	7.0	5.5	9.0	10	3
M10x1,25	1.25	100	7.0	5.5	8.8	16	4
M12x1	1.00	100	9.0	7.0	11.0	11	4
M12x1,25	1.25	100	9.0	7.0	10.8	15	5
M12x1,5	1.50	100	9.0	7.0	10.5	15	4
M14x1,5	1.50	100	11.0	9.0	12.5	15	4
M16x1,5	1.50	100	12.0	9.0	14.5	15	4
M18x1,5	1.50	110	14.0	11.0	16.5	17	4
M20x1,5	1.50	125	16.0	12.0	18.5	17	4
M22x1,5	1.50	125	18.0	14.5	20.5	17	4
M24x1,5	1.50	140	18.0	14.5	22.5	20	5
M26x1,5	1.50	140	18.0	14.5	24.5	20	6
M28x1,5	1.50	140	20.0	16.0	26.5	20	6
M30x1,5	1.50	150	22.0	18.0	28.5	22	6

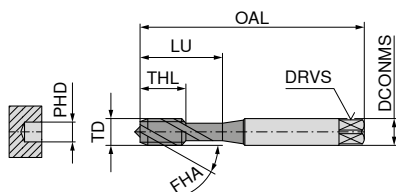
P	2-15	12	15
M	4-8	7	9
K		12	18
N			12
S			
H			
O			

UNI	UNI	UNI
C 2-3	C 2-3	C 2-3
ISO 2 6H	ISO 2 6H	ISO 2 6H
vap.	vap.	TiN
HSS-E FHA 45° ≤ 1100 N/mm ² ≤ 3xD	HSS-E FHA 42° ≤ 1100 N/mm ² ≤ 3xD	HSS-E FHA 42° ≤ 1100 N/mm ² ≤ 3xD

TP	TP	TP
22 646 ...	22 553 ...	22 554 ...
04000	062	
05000	082	080
06000	100	100
06200	120	121
	124	120
	140	140
	160	160
	180	182
	200	202
	220	
	240	
26000		
28000		
	300	

CoreLine – Blind hole – machine taps, right-hand

MF



DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M4x0,5	0.50	63	4.5	3.4	3.5	5	21	3
M6x0,5	0.50	80	6.0	4.9	5.5	5	30	3
M5x0,5	0.50	70	6.0	4.9	4.5	5	25	3
M6x0,75	0.75	80	6.0	4.9	5.2	8	30	3

P	12	15
M	7	9
K	12	18
N		12
S		
H		
O		

Cutting speed v_c (m/min)

UNI	UNI
C 2-3	C 2-3
ISO 2 6H	ISO 2 6H
vap.	TiN



HSS-E
FHA 35°
≤ 1000 N/mm²
≤ 2,5xD



HSS-E
FHA 35°
≤ 1000 N/mm²
≤ 2,5xD

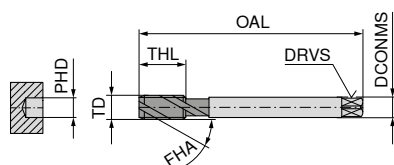
CX	CX
23 144 ...	23 146 ...
040	040
060	060
050	050
062	062

i

See next page for DIN 374.

CoreLine – Blind hole – machine taps, right-hand

MF



DIN 374 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M4x0,5	0.50	63	2.8	2.1	3.5	5	3
M5x0,5	0.50	70	3.5	2.7	4.5	5	3
M6x0,75	0.75	80	4.5	3.4	5.2	8	3
M8x0,75	0.75	80	6.0	4.9	7.2	8	3
M8x1	1.00	90	6.0	4.9	7.0	10	3
M10x0,75	0.75	90	7.0	5.5	9.2	10	4
M10x1	1.00	90	7.0	5.5	9.0	10	3
M10x1	1.00	90	7.0	5.5	9.0	10	4
M10x1,25	1.25	100	7.0	5.5	8.8	16	3
M10x1,25	1.25	100	7.0	5.5	8.8	16	4
M12x1	1.00	100	9.0	7.0	11.0	11	4
M12x1,25	1.25	100	9.0	7.0	10.8	15	4
M12x1,25	1.25	100	9.0	7.0	10.8	15	5
M12x1,5	1.50	100	9.0	7.0	10.5	15	4
M12x1,5	1.50	100	9.0	7.0	10.5	15	5
M14x1	1.00	100	11.0	9.0	13.0	11	4
M14x1	1.00	100	11.0	9.0	12.8	11	4
M14x1,5	1.50	100	11.0	9.0	12.5	15	4
M14x1,5	1.50	100	11.0	9.0	12.5	15	5
M16x1	1.00	100	12.0	9.0	15.0	12	4
M16x1,5	1.50	100	12.0	9.0	14.5	15	4
M16x1,5	1.50	100	12.0	9.0	14.5	15	5
M18x1,5	1.50	110	14.0	11.0	16.5	17	4
M18x1,5	1.50	110	14.0	11.0	16.5	17	5
M20x1,5	1.50	125	16.0	12.0	18.5	17	4
M20x1,5	1.50	125	16.0	12.0	18.5	17	5
M22x1,5	1.50	125	18.0	14.5	20.5	17	4
M22x1,5	1.50	125	18.0	14.5	20.5	17	5
M24x1,5	1.50	140	18.0	14.5	22.5	20	5
M24x2	2.00	140	18.0	14.5	22.0	20	5

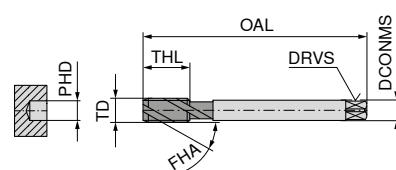
P	15	12	15
M	9	7	9
K	18	12	18
N	12		12
S			
H			
O			

Cutting speed v_c (m/min)

UNI	UNI	UNI
C 2-3	C 2-3	C 2-3
ISO 2 6H	ISO 2 6H	ISO 2 6H
TiN	vap.	TiN
HSS-PM FHA 40° $\leq 1000 \text{ N/mm}^2$ $\leq 2,5xD$	HSS-E FHA 35° $\leq 1000 \text{ N/mm}^2$ $\leq 2,5xD$	HSS-E FHA 35° $\leq 1000 \text{ N/mm}^2$ $\leq 2,5xD$
CX 23 047 ...	CX 23 145 ...	CX 23 147 ...
	040	
	050	
	062	
	082	082
081	084	084
	100	100
	102	102
102		
	104	104
104		
120	120	120
	122	122
122		
	124	124
121		
	140	140
140		
	144	144
144		
	160	160
	162	162
162		
	182	182
182		
	202	202
202		
	222	222
222		
242	242	242
244		

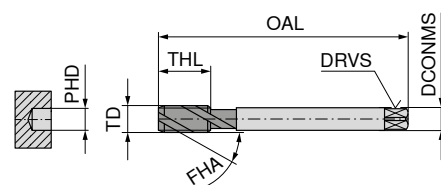
CoreLine – Blind hole – machine taps, right-hand – CavTap

▲ CNC = For synchronized CNC machining with minimum length compensation chuck



DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M5x0,5	0.50	70	6	4.9	4.5	5	25	3
M6x0,5	0.50	80	6	4.9	5.5	5	30	3
M6x0,75	0.75	80	6	4.9	5.2	8	30	3



DIN 374 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M8x0,75	0.75	80	6	4.9	7.2	8	3
M8x1	1.00	90	6	4.9	7.0	10	3
M10x1	1.00	90	7	5.5	9.0	10	4
M12x1	1.00	100	9	7.0	11.0	11	4
M12x1,5	1.50	100	9	7.0	10.5	15	5
M14x1,5	1.50	100	11	9.0	12.5	15	5
M16x1,5	1.50	100	12	9.0	14.5	15	5
M18x1,5	1.50	110	14	11.0	16.5	17	5
M20x1,5	1.50	125	16	12.0	18.5	17	5

P	15	15	15
M	9	9	9
K	18	18	18
N	12	12	12
S			
H			
O			

Cutting speed v_c (m/min)



TP
22 548 ...
050
060
062

TP	TP	TP
22 549 ...	22 561 ...	22 563 ...
082	082	
084	084	084
102	102	102
120	120	
124	124	124
144	144	144
162	162	162
182		
202		202

CoreLine – Blind hole – machine taps, right-hand

▲ NC = For synchronized CNC machining with minimum length compensation chuck

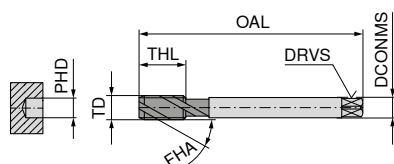
MF

UNI
NC

E
1,5-2

ISO 2
6H

TiN GS



DIN 374 With reduced shank



HSS-E
FHA 45°
≤ 1000 N/mm²
≤ 3xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M8x0,75	0.75	80	6	4.9	7.2	8	3
M8x1	1.00	90	6	4.9	7.0	10	3
M10x1	1.00	90	7	5.5	9.0	10	4
M12x1	1.00	100	9	7.0	11.0	11	4
M12x1,5	1.50	100	9	7.0	10.5	15	5
M14x1,5	1.50	100	11	9.0	12.5	15	5
M16x1,5	1.50	100	12	9.0	14.5	15	5
M18x1,5	1.50	110	14	11.0	16.5	17	5
M20x1,5	1.50	125	16	12.0	18.5	17	5

CX

23 149 ...

082

084

102

120

124

144

162

182

202

P	15
M	9
K	18
N	12
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap SL

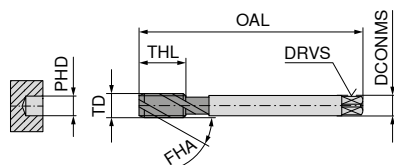
CavTap
SL

MF

ST

ISO 2
6H

HSS-E
FHA 15°
≤ 750 N/mm²
≤ 2xD



DIN 374 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M6x0,75	0.75	80	4.5	3.4	5.2	13	3
M8x0,75	0.75	80	6.0	4.9	7.2	14	3
M8x1	1.00	90	6.0	4.9	7.0	17	3
M9x1	1.00	90	7.0	5.5	8.0	17	3
M10x1	1.00	90	7.0	5.5	9.0	18	3
M10x1,25	1.25	100	7.0	5.5	8.8	22	3
M11x1	1.00	90	8.0	6.2	10.0	18	3
M12x1	1.00	100	9.0	7.0	11.0	18	3
M12x1,25	1.25	100	9.0	7.0	10.8	22	3
M12x1,5	1.50	100	9.0	7.0	10.5	22	3
M14x1	1.00	100	11.0	9.0	13.0	18	4
M14x1,5	1.50	100	11.0	9.0	12.5	22	3
M15x1	1.00	100	12.0	9.0	14.0	18	4
M16x1	1.00	100	12.0	9.0	15.0	18	4
M16x1,5	1.50	100	12.0	9.0	14.5	22	3
M18x1	1.00	110	14.0	11.0	17.0	20	4

TP

22 182 ...

062

082

084

090

102

104

110

120

122

124

140

144

150

160

162

180

P

12

M

K

12

N

22

S

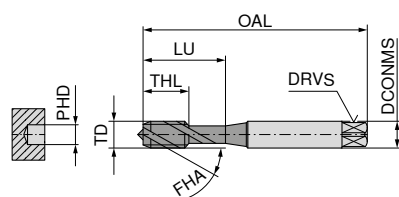
H

O

Cutting speed v_c (m/min)

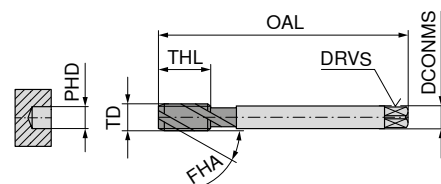
CoreLine – Blind hole – machine taps, right-hand

MF



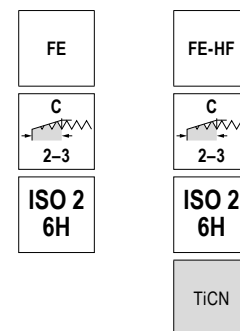
DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M5x0,5	0.50	70	6	4.9	4.5	5	25	3
M6x0,75	0.75	80	6	4.9	5.2	8	30	3



DIN 374 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M8x0,5	0.50	80	6	8.0	7.5	6	3
M8x0,75	0.75	80	6	4.9	7.2	8	3
M8x0,75	0.75	80	6	4.9	7.0	8	3
M8x1	1.00	90	6	4.9	7.0	10	3
M10x0,75	0.75	90	7	5.5	9.2	10	4
M10x1	1.00	90	7	5.5	9.0	10	3
M10x1,25	1.25	100	7	5.5	8.8	16	3
M12x1	1.00	100	9	7.0	11.0	11	4
M12x1,25	1.25	100	9	7.0	10.8	15	4
M12x1,5	1.50	100	9	7.0	10.5	15	4
M14x1	1.00	100	11	9.0	13.0	11	4
M14x1,5	1.50	100	11	9.0	12.5	15	4
M16x1	1.00	100	12	9.0	15.0	12	4
M16x1,5	1.50	100	12	9.0	14.5	15	4
M18x1,5	1.50	110	14	11.0	16.5	17	4
M20x1,5	1.50	125	16	12.0	18.5	17	4
M22x1,5	1.50	125	18	14.5	20.5	17	4
M24x1,5	1.50	140	18	14.5	22.5	20	5



HSS-E
FHA 35°
≤ 850 N/mm²
≤ 2,5xD

HSS-E
FHA 35°
≤ 1100 N/mm²
≤ 2,5xD

CX

23 342 ...
050
062

CX	CX
23 243 ...	23 343 ...
080	
082	
	082
084	084
100	
102	102
104	
120	120
122	
124	124
140	
144	144
160	
162	162
182	
202	
222	
242	

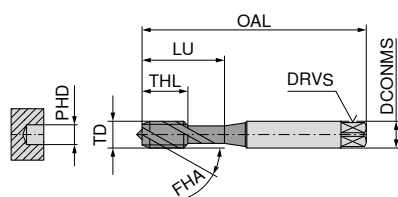
P	12	15
M		
K	12	15
N	22	24
S		
H		
O		

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap

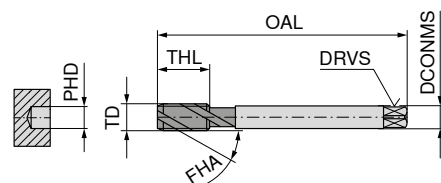
CavTap

MF



DIN 371 With reinforced shank

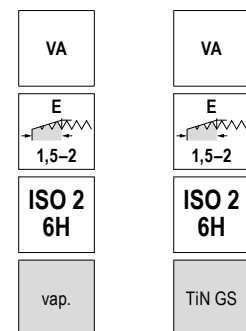
TD mm	TP mm	OAL mm	DCONMS mm	DRV mm	PHD mm	THL mm	LU mm	Flutes
M4x0,5	0.50	63	4.5	3.4	3.5	5	21	3
M5x0,5	0.50	70	6.0	4.9	4.5	5	25	3
M6x0,5	0.50	80	6.0	4.9	5.5	5	30	3
M6x0,75	0.75	80	6.0	4.9	5.2	8	30	3



DIN 374 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRV mm	PHD mm	THL mm	Flutes
M8x0,75	0.75	80	6	4.9	7.2	8	3
M8x1	1.00	90	6	4.9	7.0	10	3
M10x1	1.00	90	7	5.5	9.0	10	4
M12x1	1.00	100	9	7.0	11.0	11	4
M12x1,5	1.50	100	9	7.0	10.5	15	5
M14x1,5	1.50	100	11	9.0	12.5	15	5
M16x1,5	1.50	100	12	9.0	14.5	15	5
M20x1,5	1.50	125	16	12.0	18.5	17	5
M26x1,5	1.50	140	18	14.5	24.5	20	6
M28x1,5	1.50	140	20	16.0	26.5	20	6
M30x1,5	1.50	150	22	18.0	28.5	22	6

P	8	10
M	6	8
K		
N	22	22
S		
H		
O		

HSS-E
FHA 42°
≤ 750 N/mm²
≤ 3xDHSS-E
FHA 45°
≤ 900 N/mm²
≤ 3xD

TP

22 176 ...

040

050

060

062

TP

22 189 ...

TP

22 177 ...

082

084

102

120

124

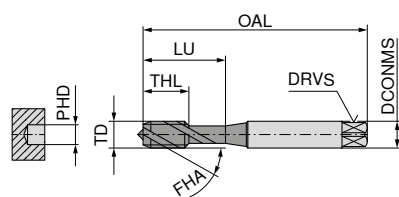
144

162

Cutting speed v_c (m/min)

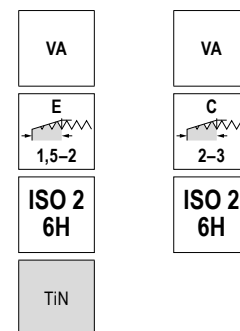
CoreLine – Blind hole – machine taps, right-hand

MF



DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M5x0,5	0.50	70	6	4.9	4.5	5	25	3
M6x0,75	0.75	80	6	4.9	5.2	8	30	3



HSS-E
FHA 45°
≤ 1200 N/mm²
≤ 3xD



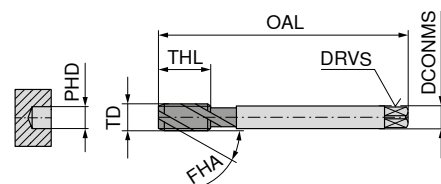
HSS-PM
FHA 40°
≤ 1200 N/mm²
≤ 2,5xD

CX

23 442 ...

050

062



DIN 374 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M8x0,75	0.75	80	6	4.9	7.2	8	3
M8x1	1.00	90	6	4.9	7.0	10	3
M10x1	1.00	90	7	5.5	9.0	10	4
M12x1	1.00	100	9	7.0	11.0	11	4
M12x1,5	1.50	100	9	7.0	10.5	15	5
M14x1,5	1.50	100	11	9.0	12.5	15	5
M16x1,5	1.50	100	12	9.0	14.5	15	5
M18x1,5	1.50	110	14	11.0	16.5	17	5
M20x1,5	1.50	125	16	12.0	18.5	17	5

CX

23 443 ...

082

084

102

120

124

144

162

CX

23 447 ...

084

102

120

124

144

162

182

202

P	10	8
M	8	6
K		
N	24	22
S		
H		
O		

Cutting speed v_c (m/min)

CoreLine – Through hole-blind hole – machine taps, right-hand – DuoTap

DuoTap

MF

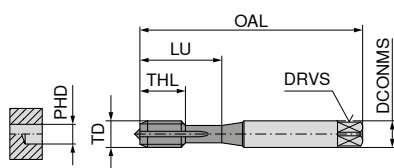
HR

ISO 2X
6HX

nitr.



HSS-E
FHA 0°
≤ 1400 N/mm²
≤ 2xD



DIN 371 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M4x0,5	0.50	63	4.5	3.4	3.5	10	21	3
M5x0,5	0.50	70	6.0	4.9	4.5	11	25	3
M6x0,5	0.50	80	6.0	4.9	5.5	13	30	3
M6x0,75	0.75	80	6.0	4.9	5.2	13	30	3

TP

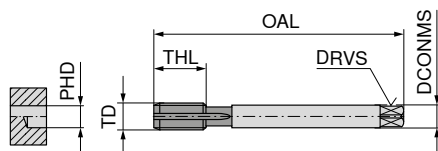
22 146 ...

040

050

060

062



DIN 374 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M8x1	1.0	90	6	4.9	7.0	17	3
M10x1	1.0	90	7	5.5	9.0	18	4
M12x1,5	1.5	100	9	7.0	10.5	22	4
M14x1,5	1.5	100	11	9.0	12.5	22	4
M16x1,5	1.5	100	12	9.0	14.5	22	4
M18x1,5	1.5	110	14	11.0	16.5	25	4
M20x1,5	1.5	125	16	12.0	18.5	25	4

TP

22 209 ...

082

100

120

140

160

180

200

P

6

M

K

16

N

22

S

H

O

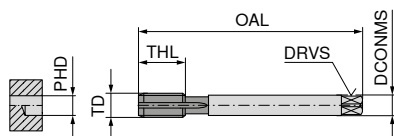
Cutting speed v_c (m/min)

CoreLine – Through hole-blind hole – machine taps, right-hand – DuoTap

DuoTap

MF

ST

ISO 2X
6HXHSS-E
FHA 0°≤ 750 N/mm²
≤ 2xD

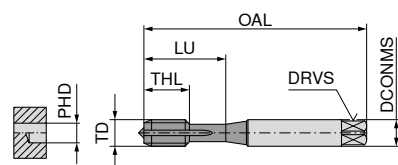
DIN 374 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes	TP 22 171 ...
M4x0,5	0.50	63	2.8	2.1	3.5	10	3	042
M5x0,5	0.50	70	3.5	2.7	4.5	11	3	050
M6x0,5	0.50	80	4.5	3.4	5.5	13	3	060
M6x0,75	0.75	80	4.5	3.4	5.2	13	3	062
M8x0,75	0.75	80	6.0	4.9	7.2	14	3	082
M8x1	1.00	90	6.0	4.9	7.0	17	3	084
M10x0,75	0.75	90	7.0	5.5	9.2	18	4	102
M10x1	1.00	90	7.0	5.5	9.0	18	4	104
M10x1,25	1.25	100	7.0	5.5	8.8	22	3	106
M11x1	1.00	90	8.0	6.2	10.0	18	4	110
M12x1	1.00	100	9.0	7.0	11.0	18	4	122
M12x1,25	1.25	100	9.0	7.0	10.8	22	4	124
M12x1,5	1.50	100	9.0	7.0	10.5	22	4	126
M14x1	1.00	100	11.0	9.0	13.0	18	4	140
M14x1,25	1.25	100	11.0	9.0	12.8	22	4	142
M14x1,5	1.50	100	11.0	9.0	12.5	22	4	144
M16x1	1.00	100	12.0	9.0	15.0	18	5	160
M16x1,5	1.50	100	12.0	9.0	14.5	22	4	162
M18x1	1.00	110	14.0	11.0	17.0	20	5	180
M18x1,5	1.50	110	14.0	11.0	16.5	25	4	182
M18x2	2.00	125	14.0	11.0	16.0	26	4	184
M20x1	1.00	125	16.0	12.0	19.0	20	5	200
M20x1,5	1.50	125	16.0	12.0	18.5	25	4	202
M20x2	2.00	140	16.0	12.0	18.0	27	4	204
M22x1	1.00	125	18.0	14.5	21.0	20	5	220
M22x1,5	1.50	125	18.0	14.5	20.5	25	4	222
M22x2	2.00	140	18.0	14.5	20.0	27	4	224
M24x1	1.00	140	18.0	14.5	23.0	20	6	240
M24x1,5	1.50	140	18.0	14.5	22.5	27	4	242
M24x2	2.00	140	18.0	14.5	22.0	27	4	244
M25x1,5	1.50	140	18.0	14.5	23.5	28	4	250
M26x1,5	1.50	140	18.0	14.5	24.5	28	4	260
M27x1,5	1.50	140	20.0	16.0	25.5	28	5	272
M27x2	2.00	140	20.0	16.0	25.0	28	4	274
M30x1,5	1.50	150	22.0	18.0	28.5	28	5	300
M30x2	2.00	150	22.0	18.0	28.0	28	4	302
P								12
M								
K								12
N								22
S								
H								
O								

Cutting speed v_c (m/min)

CoreLine – Through hole-blind hole – machine taps, right-hand – DuoTap

▲ ES = Extra short



DIN 2181 With reinforced shank



HSS-E
FHA 0°
≤ 750 N/mm²
≤ 2xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M3x0,35	0.35	40	3.5	2.7	2.65	8	18	3
M4x0,35	0.35	45	4.5	3.4	3.65	9	22	3
M4,5x0,5	0.50	50	6.0	4.9	4.00	10	24	3
M4x0,5	0.50	45	4.5	3.4	3.50	9	22	3
M5x0,5	0.50	50	6.0	4.9	4.50	11	25	3
M6x0,5	0.50	56	6.0	4.9	5.50	12	27	3
M6x0,75	0.75	56	6.0	4.9	5.20	12	27	3
M7x0,75	0.75	56	6.0	4.9	6.20	14		3
M8x0,5	0.50	56	6.0	4.9	7.50	14		4
M8x0,75	0.75	56	6.0	4.9	7.20	14		3
M8x1	1.00	63	6.0	4.9	7.00	17		3
M9x1	1.00	63	7.0	5.5	8.00	17		4
M10x0,75	0.75	63	7.0	5.5	9.20	18		4
M10x1	1.00	63	7.0	5.5	9.00	18		4
M10x1,25	1.25	70	7.0	5.5	8.80	22		3
M11x1	1.00	63	8.0	6.2	10.00	18		4
M12x1	1.00	70	9.0	7.0	11.00	18		4
M12x1,25	1.25	70	9.0	7.0	10.80	20		4
M12x1,5	1.50	70	9.0	7.0	10.50	20		4
M13x1	1.00	70	11.0	9.0	12.00	18		4
M14x1	1.00	70	11.0	9.0	13.00	18		4
M14x1,25	1.25	70	11.0	9.0	12.80	20		4
M14x1,5	1.50	70	11.0	9.0	12.50	20		4
M15x1	1.00	70	12.0	9.0	14.00	18		5
M16x1	1.00	70	12.0	9.0	15.00	18		5
M16x1,5	1.50	70	12.0	9.0	14.50	20		4
M18x1	1.00	80	14.0	11.0	17.00	18		5
M18x1,5	1.50	80	14.0	11.0	16.50	22		4
M18x2	2.00	80	14.0	11.0	16.00	22		4
M20x1,5	1.50	80	16.0	12.0	18.50	22		4
M20x2	2.00	80	16.0	12.0	18.00	22		4

TP

22 179 ...

030

040

045

042

050

060

062

070

080

082

084

090

100

102

104

110

120

122

124

130

140

142

144

150

160

162

180

182

184

202

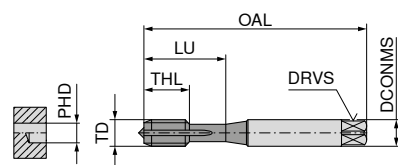
204

P	12
M	
K	12
N	22
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Through hole-blind hole – machine taps, left-hand – DuoTap

▲ LH = For left-hand threads; ES = Extra short



DIN 2181 With reinforced shank



HSS-E
FHA 0°
≤ 750 N/mm²
≤ 2xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M6x0,75	0.75	56	6	4.9	5.2	12	27	3
M8x1	1.00	63	6	4.9	7.0	17		3
M10x1	1.00	63	7	5.5	9.0	18		4
M12x1	1.00	70	9	7.0	11.0	18		4
M12x1,5	1.50	70	9	7.0	10.5	20		4
M14x1,5	1.50	70	11	9.0	12.5	20		4
M16x1,5	1.50	70	12	9.0	14.5	20		4
M18x1,5	1.50	80	14	11.0	16.5	22		4
M20x1,5	1.50	80	16	12.0	18.5	22		4

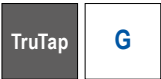
TP

22 200 ...
062
084
102
120
124
144
162
182
202

P	12
M	
K	12
N	22
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand – TruTap

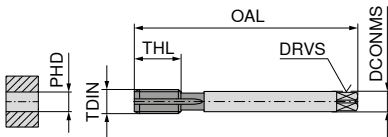


UNI


B
4-5

ISO 228

TiN



DIN 5156 With reduced shank



HSS-E
FHA 0°
≤ 1100 N/mm²
≤ 4xD

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
	mm	mm	mm	mm	mm	mm	
1/8-28	0.907	90	7	5.5	8.80	18	3
1/4-19	1.337	100	11	9.0	11.80	22	3
3/8-19	1.337	100	12	9.0	15.25	22	3
1/2-14	1.814	125	16	12.0	19.00	25	4

TP

22 630 ...

012

025

037

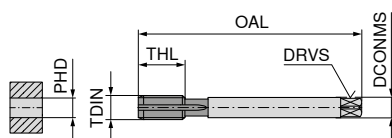
050

P	15
M	9
K	18
N	12
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand

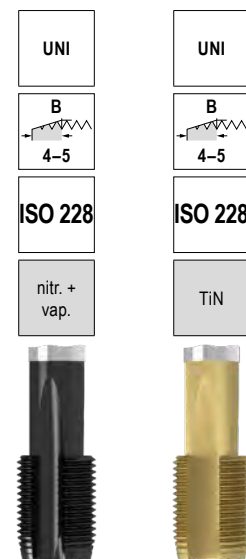
G



DIN 5156 With reduced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
1/8-28	0.907	90	7	5.5	8.80	18	3
1/4-19	1.337	100	11	9.0	11.80	22	3
3/8-19	1.337	100	12	9.0	15.25	22	3
1/2-14	1.814	125	16	12.0	19.00	25	4
3/4-14	1.814	140	20	16.0	24.50	28	4
1-11	2.309	160	25	20.0	30.75	30	4

P	12	15
M	7	9
K	12	18
N		12
S		
H		
O		



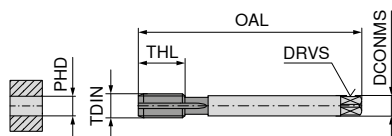
HSS-E
FHA 0°
≤ 1100 N/mm²
≤ 3xD

HSS-E
FHA 0°
≤ 1100 N/mm²
≤ 3xD

CX	CX
23 161 ...	23 160 ...
012	012
025	025
037	037
050	050
075	075
100	100

Cutting speed v_c (m/min)

G



DIN 5156 With reduced shank



ISO 228



HSS-E
FHA 0°
≤ 850 N/mm²
≤ 3xD

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
1/8-28	0.907	90	7	5.5	8.80	18	3
1/4-19	1.337	100	11	9.0	11.80	22	3
3/8-19	1.337	100	12	9.0	15.25	22	3
1/2-14	1.814	125	16	12.0	19.00	25	4
3/4-14	1.814	140	20	16.0	24.50	28	4
1-11	2.309	160	25	20.0	30.75	30	4

CX

23 260 ...

012

025

037

050

075

P	12
M	
K	12
N	12
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand – TruTap

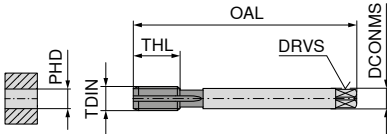


VA

B
4-5

ISO 228

nitr.



DIN 5156 With reduced shank



HSS-E
FHA 0°
≤ 900 N/mm²
≤ 4xD

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
	mm	mm	mm	mm	mm	mm	
1/8-28	0.907	90	7	5.5	8.80	18	3
1/4-19	1.337	100	11	9.0	11.80	22	3
3/8-19	1.337	100	12	9.0	15.25	22	3
1/2-14	1.814	125	16	12.0	19.00	25	4
3/4-14	1.814	140	20	16.0	24.50	28	4
1-11	2.309	160	25	20.0	30.75	30	4

TP

22 352 ...

012

025

037

050

075

100

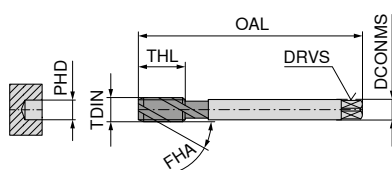
P	8
M	6
K	
N	22
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap

CavTap

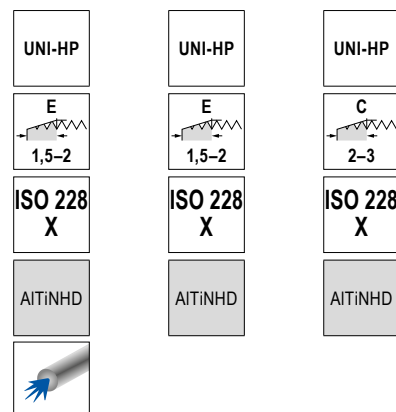
G



DIN 5156 With reduced shank

TDIN	TP	OAL	DCONMS _{h8}	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
1/8-28	0.907	90	7	5.5	8.80	10	4
1/4-19	1.337	100	11	9.0	11.80	15	5
3/8-19	1.337	100	12	9.0	15.25	15	5
1/2-14	1.814	125	16	12.0	19.00	17	5
3/4-14	1.814	140	20	16.0	24.50	20	5
1-11	2.309	160	25	20.0	30.75	24	6

P	2-18	2-18	2-18
M	2-10	2-10	2-10
K	10-20	10-20	10-20
N	15-30	15-30	15-30
S			
H			
O			

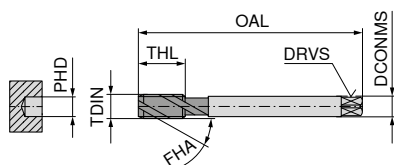
Cutting speed v_c (m/min)

NEW TP	NEW TP	NEW TP
22 842 ...	22 832 ...	22 823 ...
01200	01200	01200
02500	02500	02500
03700	03700	03700
05000	05000	05000
07500	07500	07500
10000	10000	10000

CoreLine – Blind hole – machine taps, right-hand – CavTap

CavTap

G



DIN 5156 With reduced shank



HSS-E
FHA 42°
≤ 1100 N/mm²
≤ 3xD

HSS-E
FHA 42°
≤ 1100 N/mm²
≤ 3xD

HSS-E
FHA 42°
≤ 1100 N/mm²
≤ 3xD

HSS-E
FHA 42°
≤ 1100 N/mm²
≤ 3xD

HSS-E
FHA 42°
≤ 1100 N/mm²
≤ 3xD

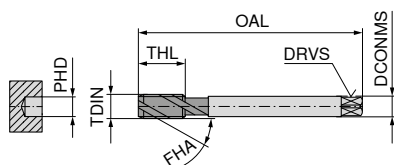
TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
1/8-28	0.907	90	7	5.5	8.80	10	3
1/8-28	0.907	90	7	5.5	8.80	10	4
1/4-19	1.337	100	11	9.0	11.80	15	4
1/4-19	1.337	100	11	9.0	11.80	15	5
3/8-19	1.337	100	12	9.0	15.25	15	4
3/8-19	1.337	100	12	9.0	15.25	15	5
1/2-14	1.814	125	16	12.0	19.00	17	4
1/2-14	1.814	125	16	12.0	19.00	17	5
3/4-14	1.814	140	20	16.0	24.50	20	4
3/4-14	1.814	140	20	16.0	24.50	20	5
1-11	2.309	160	25	20.0	30.75	24	6

TP	TP	TP	TP	TP
22 636 ...	22 635 ...	22 639 ...	22 634 ...	22 633 ...
012	012	012	012	012
025	025	025	025	025
037	037	037	037	037
050	050	050	050	050
		075		075
		100		
15	12	12	15	12
9	7	7	9	7
18	12	12	18	12
12			12	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand

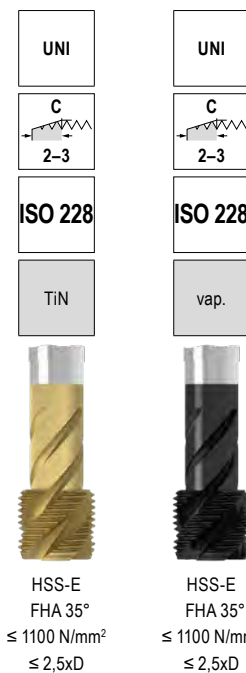
G



DIN 5156 With reduced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
1/8-28	0.907	90	7	5.5	8.80	10	3
1/4-19	1.337	100	11	9.0	11.80	15	4
3/8-19	1.337	100	12	9.0	15.25	15	4
1/2-14	1.814	125	16	12.0	19.00	17	4
3/4-14	1.814	140	20	16.0	24.50	20	4
1-11	2.309	160	25	20.0	30.75	24	5

P	15	12
M	9	7
K	18	12
N	12	
S		
H		
O		

Cutting speed v_c (m/min)

HSS-E
FHA 35°
≤ 1100 N/mm²
≤ 2,5xD

HSS-E
FHA 35°
≤ 1100 N/mm²
≤ 2,5xD

CX	CX
23 162 ...	23 163 ...
012	012
025	025
037	037
050	050
075	075
100	100

CoreLine – Blind hole – machine taps, right-hand – CavTap

▲ CNC = For synchronized CNC machining with minimum length compensation chuck

CavTap

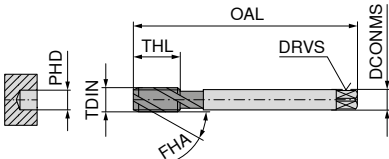
G

UNI
CNC

E
1,5-2

ISO 228

TiN GS



DIN 5156 With reduced shank



HSS-E
FHA 45°
≤ 1100 N/mm²
≤ 3xD

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
1/8-28	0.907	90	7	5.5	8.80	10	4
1/4-19	1.337	100	11	9.0	11.80	15	5
3/8-19	1.337	100	12	9.0	15.25	15	5
1/2-14	1.814	125	16	12.0	19.00	17	5

TP

22 624 ...

012

025

037

050

P	15
M	9
K	18
N	12
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap

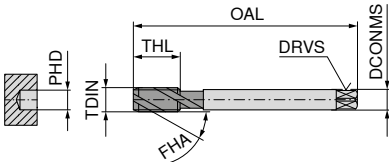
CavTap

G

ST


C
2-3

ISO 228



DIN 5156 With reduced shank



HSS-E
FHA 42°
≤ 750 N/mm²
≤ 3xD

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
1/8-28	0.907	90	7	5.5	8.80	10	3
1/4-19	1.337	100	11	9.0	11.80	15	4
3/8-19	1.337	100	12	9.0	15.25	15	4
1/2-14	1.814	125	16	12.0	19.00	17	4
3/4-14	1.814	140	20	16.0	24.50	20	4
1-11	2.309	160	25	20.0	30.75	24	5

TP

22 354 ...

012

025

037

050

075

100

P	12
M	
K	12
N	22
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap SL

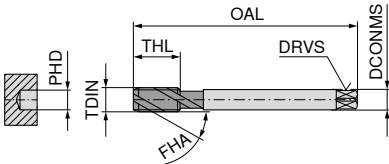
CavTap
SL

G

ST



ISO 228



DIN 5156 With reduced shank



HSS-E
FHA 15°
≤ 750 N/mm²
≤ 2xD

TDIN	TP	OAL	DCONMS	DRV	PHD	THL	Flutes
	mm	mm	mm	mm	mm	mm	
1/8-28	0.907	90	7	5.5	8.80	18	3
1/4-19	1.337	100	11	9.0	11.80	22	3
3/8-19	1.337	100	12	9.0	15.25	22	3
1/2-14	1.814	125	16	12.0	19.00	25	4
3/4-14	1.814	140	20	16.0	24.50	28	4

TP

22 353 ...

012

025

037

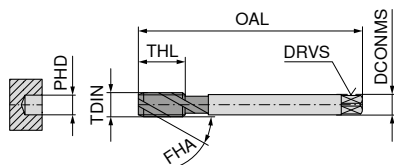
050

075

P	12
M	
K	12
N	22
S	
H	
O	

Cutting speed v_c (m/min)

G



DIN 5156 With reduced shank



ISO 228



HSS-E
FHA 35°
≤ 850 N/mm²
≤ 2,5xD

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
1/8-28	0.907	90	7	5.5	8.80	10	3
1/4-19	1.337	100	11	9.0	11.80	15	4
3/8-19	1.337	100	12	9.0	15.25	15	4
1/2-14	1.814	125	16	12.0	19.00	17	4
3/4-14	1.814	140	20	16.0	24.50	20	4
1-11	2.309	160	25	20.0	30.75	24	5

CX

23 261 ...

012

025

037

050

075

100

P 12

K	12
N	22

N	22
S	

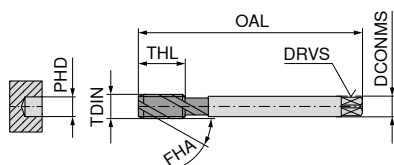
0

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap

CavTap

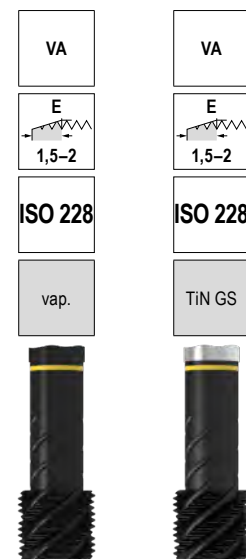
G



DIN 5156 With reduced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
1/8-28	0.907	90	7	5.5	8.80	10	3
1/8-28	0.907	90	7	5.5	8.80	10	4
1/4-19	1.337	100	11	9.0	11.80	15	5
3/8-19	1.337	100	12	9.0	15.25	15	5
1/2-14	1.814	125	16	12.0	19.00	17	5
5/8-14	1.814	125	18	14.5	21.00	17	5
3/4-14	1.814	140	20	16.0	24.50	20	5
1-11	2.309	160	25	20.0	30.75	24	6

P	8	10
M	6	8
K		
N	22	22
S		
H		
O		



HSS-E
FHA 42°
≤ 900 N/mm²
≤ 3xD

HSS-E
FHA 45°
≤ 900 N/mm²
≤ 3xD

TP	TP
22 355 ...	22 358 ...
012	012
025	025
037	037
050	050
062	
075	
100	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap

CavTap

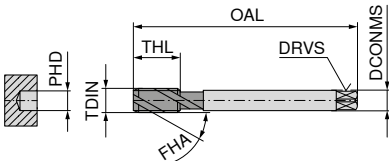
G

NW


C
2-3

ISO 228

DLC



DIN 5156 With reduced shank



HSS-E
FHA 45°
≤ 880 N/mm²
≤ 3xD

TDIN	TP	OAL	DCONMS _{h9}	DRVS	PHD	THL	Flutes
	mm	mm	mm	mm	mm	mm	
1/8-28	0.907	90	7	5.5	8.80	10	4
1/4-19	1.337	100	11	9.0	11.80	15	5
3/8-19	1.337	100	12	9.0	15.25	15	5
1/2-14	1.814	125	16	12.0	19.00	17	5
3/4-14	1.814	140	20	16.0	24.50	20	5

TP

22 656 ...

01200

02500

03700

05000

07500

P
M
K
N
S
H
O

15-30

Cutting speed v_c (m/min)

CoreLine – Through hole-blind hole – machine taps, right-hand – DuoTap

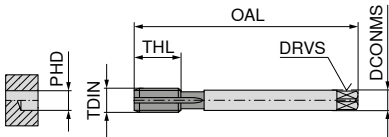


HR


C
2-3

ISO 228
X

nitr.



DIN 5156 With reduced shank



HSS-E
FHA 0°
≤ 1400 N/mm²
≤ 2xD

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
1/8-28	0.907	90	7	5.5	8.80	18	4
1/4-19	1.337	100	11	9.0	11.80	22	4
3/8-19	1.337	100	12	9.0	15.25	22	4
1/2-14	1.814	125	16	12.0	19.00	25	4

TP
22 339 ...
012
025
037
050

P	6
M	
K	16
N	22
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Through hole-blind hole – machine taps, right-hand – DuoTap

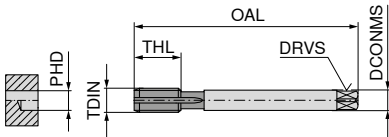


GG


C
2-3

ISO 228
X

nitr.



DIN 5156 With reduced shank



HSS-E
FHA 0°
≤ 1050 N/mm²
≤ 2xD

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
1/8-28	0.907	90	7	5.5	8.80	18	4
1/4-19	1.337	100	11	9.0	11.80	22	4
3/8-19	1.337	100	12	9.0	15.25	22	4
1/2-14	1.814	125	16	12.0	19.00	25	4
3/4-14	1.814	140	20	16.0	24.50	28	4
1-11	2.309	160	25	20.0	30.75	30	5
1 1/4-11	2.309	170	32	24.0	39.50	30	6
1 1/2-11	2.309	190	36	29.0	45.25	32	6

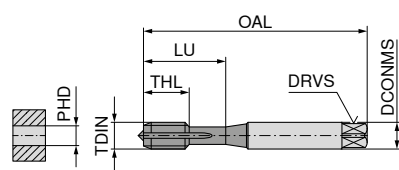
TP
22 348 ...
012
025
037
050
075
100
125
150

P
M
K
N
S
H
O

16
24

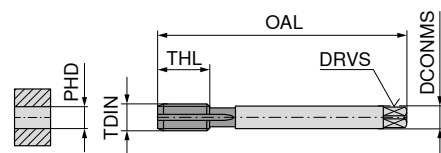
Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand – TruTap



DIN 371 With reinforced shank

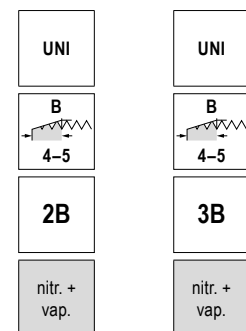
TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
Nr. 2-56	0.454	45	2.8	2.1	1.85	7	12	2
Nr. 4-40	0.635	56	3.5	2.7	2.35	11	18	2
Nr. 6-32	0.794	56	4.0	3.0	2.85	12	20	3
Nr. 8-32	0.794	63	4.5	3.4	3.50	13	21	3
Nr. 10-24	1.058	70	6.0	4.9	3.90	15	25	3
Nr. 12-24	1.058	80	6.0	4.9	4.50	16	30	3
1/4-20	1.270	80	7.0	5.5	5.10	17	30	3
5/16-18	1.411	90	8.0	6.2	6.60	20	35	3
3/8-16	1.588	100	10.0	8.0	8.00	22	39	3



DIN 376 With reduced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
1/2-13	1.954	110	9	7.0	10.80	25	3
5/8-11	2.309	110	12	9.0	13.50	27	3
3/4-10	2.540	125	14	11.0	16.50	30	3
7/8-9	2.822	140	18	14.5	19.50	32	3
1-8	3.175	160	18	14.5	22.25	36	3

P	12	12
M	7	7
K	12	12
N		
S		
H		
O		



HSS-E
FHA 0°
≤ 1100 N/mm²
≤ 4xD

HSS-E
FHA 0°
≤ 1100 N/mm²
≤ 4xD

TP	TP
22 572 ...	22 574 ...
002	
004	
006	006
008	008
010	
012	
025	025
031	
037	

TP
22 573 ...
050
062
075
087
100

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand

UNC

UNI

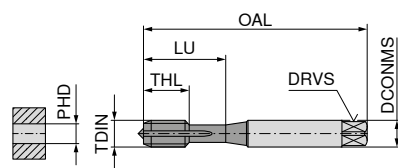


2B

TiN



HSS-E
FHA 0°
≤ 1000 N/mm²
≤ 3xD



DIN 371 With reinforced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
Nr. 4-40	0.635	56	3.5	2.7	2.30	11	18	2
Nr. 6-32	0.794	56	4.0	3.0	2.85	12	20	3
Nr. 8-32	0.794	63	4.5	3.4	3.50	13	21	3
Nr. 10-24	1.058	70	6.0	4.9	3.90	15	25	3
1/4-20	1.270	80	7.0	5.5	5.10	17	30	3
5/16-18	1.411	90	8.0	6.2	6.60	20	35	3
3/8-16	1.588	100	10.0	8.0	8.00	22	39	3

CX

23 170 ...

004

006

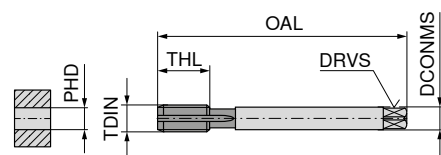
008

010

025

031

037



DIN 376 With reduced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
7/16-14	1.814	100	8	6.2	9.40	22	3
1/2-13	1.954	110	9	7.0	10.75	25	3
5/8-11	2.309	110	12	9.0	13.50	27	3
3/4-10	2.540	125	14	11.0	16.50	30	3

CX

23 171 ...

043

050

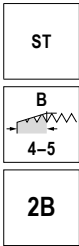
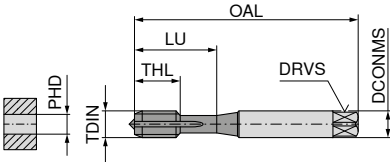
062

075

P	15
M	9
K	18
N	12
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand – TruTap



DIN 371 With reinforced shank



HSS-E
FHA 0°
≤ 750 N/mm²
≤ 4xD

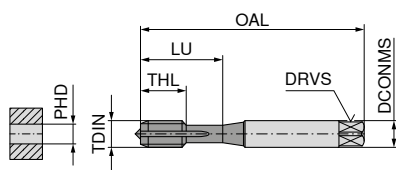
TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
	mm	mm	mm	mm	mm	mm	mm	
Nr. 8-32	0.794	63	4.5	3.4	3.5	13	21	3
Nr. 10-24	1.058	70	6.0	4.9	3.9	15	25	3
1/4-20	1.270	80	7.0	5.5	5.1	17	30	3
5/16-18	1.411	90	8.0	6.2	6.6	20	35	3
3/8-16	1.588	100	10.0	8.0	8.0	22	39	3

TP
22 240 ...
008
010
025
031
037

P	4
M	
K	
N	12
S	
H	
O	

Cutting speed v_c (m/min)

UNC



DIN 371 With reinforced shank

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
Nr. 4-40	0.635	56	3.5	2.7	2.30	11	18	2
Nr. 6-32	0.794	56	4.0	3.0	2.85	12	20	3
Nr. 8-32	0.794	63	4.5	3.4	3.50	13	21	3
Nr. 10-24	1.058	70	6.0	4.9	3.90	15	25	3
1/4-20	1.270	80	7.0	5.5	5.10	17	30	3
5/16-18	1.411	90	8.0	6.2	6.60	20	35	3
3/8-16	1.588	100	10.0	8.0	8.00	22	39	3

Category	Count
P	15
M	
K	15
N	15
S	
H	
O	

Cutting speed v_c (m/min)

B

4-5

2B

TiCN



HSS-E
FHA 0°
≤ 1100 N/mm²
≤ 3xD

CX

23 370 ...

004

006

008

010
005025
031

037

4E

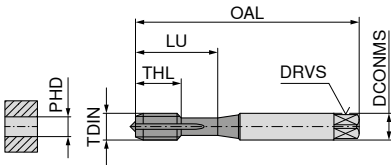
13

15

15

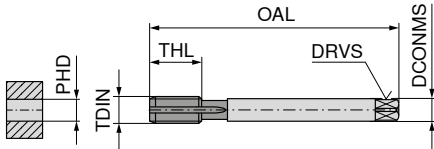
10

CoreLine – Through hole – machine taps, right-hand – TruTap



DIN 371 With reinforced shank

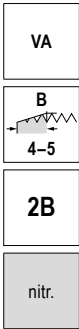
TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
Nr. 6-32	0.794	56	4.0	3.0	2.85	12	20	3
Nr. 8-32	0.794	63	4.5	3.4	3.50	13	21	3
Nr. 10-24	1.058	70	6.0	4.9	3.90	15	25	3
1/4-20	1.270	80	7.0	5.5	5.10	17	30	3
5/16-18	1.411	90	8.0	6.2	6.60	20	35	3
3/8-16	1.588	100	10.0	8.0	8.00	22	39	3



DIN 376 With reduced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
7/16-14	1.814	100	8	6.2	9.40	22	3
1/2-13	1.954	110	9	7.0	10.80	25	3
5/8-11	2.309	110	12	9.0	13.50	27	3
3/4-10	2.540	125	14	11.0	16.50	30	3
7/8-9	2.822	140	18	14.5	19.50	32	3
1-8	3.175	160	18	14.5	22.25	36	3

P	8
M	6
K	
N	22
S	
H	
O	



TP
22 250 ...
006
008
010
025
031
037

TP
22 251 ...
043
050
062
075
087
100

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand

UNC

DIN 371 With reinforced shank

VA

B
4-5

2B

nitr.

HSS-E
FHA 0°
≤ 1000 N/mm²
≤ 3xD

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
Nr. 4-40	0.635	56	3.5	2.7	2.30	11	18	2
Nr. 6-32	0.794	56	4.0	3.0	2.85	12	20	3
Nr. 8-32	0.794	63	4.5	3.4	3.50	13	21	3
Nr. 10-24	1.058	70	6.0	4.9	3.90	15	25	3
1/4-20	1.270	80	7.0	5.5	5.10	17	30	3
5/16-18	1.411	90	8.0	6.2	6.60	20	35	3
3/8-16	1.588	100	10.0	8.0	8.00	22	39	3

CX

23 470 ...

004

006

008

010

025

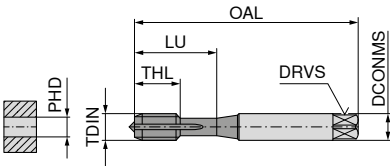
031

037

P	8
M	6
K	
N	22
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand – TruTap



DIN 371 With reinforced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
Nr. 4-40	0.635	56	3.5	2.7	2.35	11	18	3
Nr. 6-32	0.794	56	4.0	3.0	2.85	12	20	3
Nr. 8-32	0.794	63	4.5	3.4	3.50	13	21	3
Nr. 10-24	1.058	70	6.0	4.9	3.90	15	25	3
1/4-20	1.270	80	7.0	5.5	5.10	17	30	3
5/16-18	1.411	90	8.0	6.2	6.60	20	35	3
3/8-16	1.588	100	10.0	8.0	8.00	22	39	3

P	7
M	7
K	
N	
S	5
H	
O	

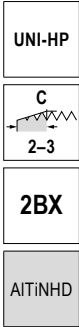
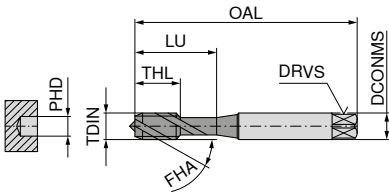


HSS-PM
FHA 0°
≤ 44 HRC
≤ 4xD

TP
22 269 ...
004
006
008
010
025
031
037

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap



DIN 371 With reinforced shank



HSS-E-PM
FHA 45°
≤ 1400 N/mm²
≤ 3xD

TDIN	TP mm	OAL mm	DCONMS _{h8} mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
Nr. 4-40	0.635	56	3.5	2.7	2.30	6	18	2
Nr. 6-32	0.794	56	4.0	3.0	2.85	7	20	3
Nr. 8-32	0.794	63	4.5	3.4	3.50	8	21	3
Nr. 10-24	1.058	70	6.0	4.9	3.90	10	25	3
1/4-20	1.270	80	7.0	5.5	5.10	13	30	3
5/16-18	1.411	90	8.0	6.2	6.60	14	35	3
3/8-16	1.588	100	10.0	8.0	8.00	16	39	3

NEW

TP

22 824 ...

00400

00600

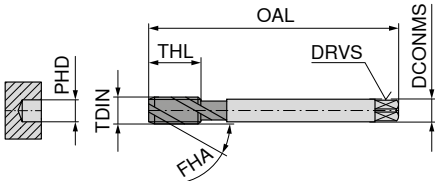
00800

01000

02500

03100

03700



DIN 376 With reduced shank

TDIN	TP mm	OAL mm	DCONMS _{h8} mm	DRVS mm	PHD mm	THL mm	Flutes
7/16-14	1.814	100	8	6.2	9.4	18	4
1/2-13	1.954	110	9	7.0	10.8	20	4
5/8-11	2.309	110	12	9.0	13.5	22	4
3/4-10	2.540	125	14	11.0	16.5	25	4
1-8	3.175	160	18	14.5	22.2	30	5

TP

22 825 ...

04300

05000

06200

07500

10000

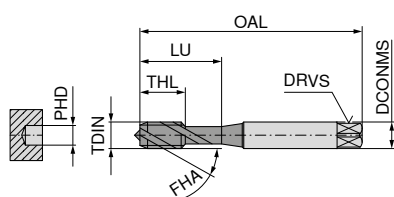
P	2-18
M	2-10
K	10-20
N	15-30
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap

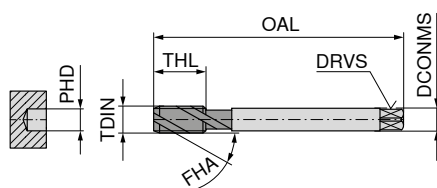
CavTap

UNC



DIN 371 With reinforced shank

TDIN	TP	OAL	DCONMS _{h9}	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
Nr.2-56	0.454	45	2.8	2.1	1.80	4.5	12	2
Nr. 4-40	0.635	56	3.5	2.7	2.35	6.0	18	2
Nr. 6-32	0.794	56	4.0	3.0	2.85	7.0	20	3
Nr. 6-32	0.794	56	4.0	3.0	2.90	7.0	20	3
Nr. 8-32	0.794	63	4.5	3.4	3.50	8.0	21	3
Nr. 8-32	0.794	63	4.5	3.4	3.55	8.0	21	3
Nr. 10-24	1.058	70	6.0	4.9	3.90	10.0	25	3
Nr. 10-24	1.058	70	6.0	4.9	3.95	10.0	25	3
1/4-20	1.270	80	7.0	5.5	5.10	13.0	30	3
1/4-20	1.270	80	7.0	5.5	5.15	13.0	30	3
5/16-18	1.411	90	8.0	6.2	6.60	14.0	35	3
5/16-18	1.411	90	8.0	6.2	6.65	14.0	35	3
3/8-16	1.588	100	10.0	8.0	8.00	16.0	39	3
3/8-16	1.588	100	10.0	8.0	8.05	16.0	39	3



DIN 376 With reduced shank

TDIN	TP	OAL	DCONMS _{h9}	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
7/16-14	1.814	100	8	6.2	9.40	18	3
1/2-13	1.954	110	9	7.0	10.80	20	3
9/16-12	2.117	110	11	9.0	12.25	20	3
5/8-11	2.309	110	12	9.0	13.50	22	3
3/4-10	2.540	125	14	11.0	16.50	25	3
1-8	3.175	160	18	14.5	22.25	30	4

UNI



2B

vap.



HSS-E
FHA 45°
≤ 1100 N/mm²
≤ 3xD

UNI



2B

vap.



HSS-E
FHA 42°
≤ 1100 N/mm²
≤ 3xD

UNI

2B
+0,05

vap.



HSS-E
FHA 42°
≤ 1100 N/mm²
≤ 3xD

TP

22 669 ...
00200

TP

22 582 ...
004
006

TP

22 277 ...
006
008
010
025
031
037

TP

22 583 ...
043
050
056
062
075
100

P	2-15	12	12
M	4-8	7	7
K		12	12
N			22
S			
H			
O			

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand

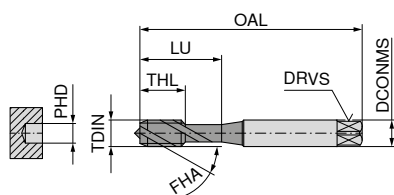
UNC

UNI

C
2-3

2B

TiN



DIN 371 With reinforced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
Nr. 4-40	0.635	56	3.5	2.7	2.30	6	18	2
Nr. 6-32	0.794	56	4.0	3.0	2.85	7	20	3
Nr. 8-32	0.794	63	4.5	3.4	3.50	8	21	3
Nr. 10-24	1.058	70	6.0	4.9	3.90	10	25	3
1/4-20	1.270	80	7.0	5.5	5.20	13	30	3
5/16-18	1.411	90	8.0	6.2	6.60	14	35	3
3/8-16	1.588	100	10.0	8.0	8.00	16	39	3

HSS-E
FHA 35°
≤ 1000 N/mm²
≤ 2,5xD

CX

23 172 ...

004

006

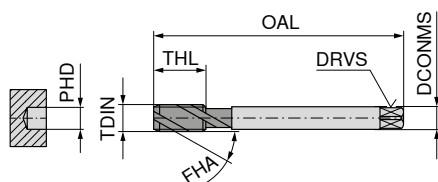
008

010

025

031

037



DIN 376 With reduced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
7/16-14	1.814	100	8	6.2	9.40	18	3
1/2-13	1.954	110	9	7.0	10.75	20	3
5/8-11	2.309	110	12	9.0	13.50	22	3
3/4-10	2.540	125	14	11.0	16.50	25	3

CX

23 173 ...

043

050

062

075

P	15
M	9
K	18
N	12
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap

CavTap

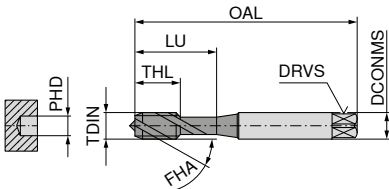
UNC

ST

C

2-3

2B



DIN 371 With reinforced shank



HSS-E
FHA 42°
≤ 750 N/mm²
≤ 3xD

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
1/4-20	1.270	80	7	5.5	5.1	13	30	3
5/16-18	1.411	90	8	6.2	6.6	14	35	3
3/8-16	1.588	100	10	8.0	8.0	16	39	3

TP

22 264 ...

025

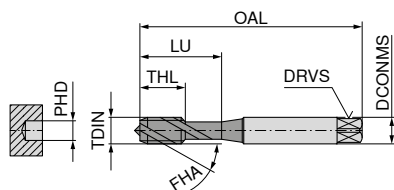
031

037

P	12
M	
K	12
N	22
S	
H	
O	

Cutting speed v_c (m/min)

UNC



DIN 371 With reinforced shank



HSS-E
FHA 35°
≤ 1100 N/mm²
≤ 2,5xD

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
Nr. 4-40	0.635	56	3.5	2.7	2.30	11	18	2
Nr. 6-32	0.794	56	4.0	3.0	2.85	12	20	3
Nr. 8-32	0.794	63	4.5	3.4	3.50	13	21	3
Nr. 10-24	1.058	70	6.0	4.9	3.90	15	25	3
1/4-20	1.270	80	7.0	5.5	5.20	17	30	3
5/16-18	1.411	90	8.0	6.2	6.60	20	35	3
3/8-16	1.588	100	10.0	8.0	8.00	22	39	3

Letter	Count
P	15
M	15
K	15
N	24
S	15
H	15
O	15

Cutting speed v_c (m/min)

CX

23 372 ...

004

006

008

010

025

031

037

15

15

15
24

1

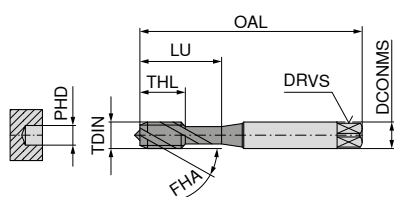
100

 V_c (m/m)

CoreLine – Blind hole – machine taps, right-hand – CavTap

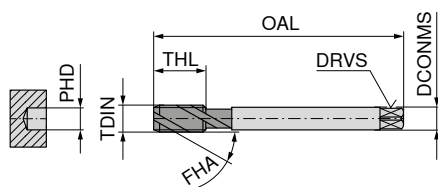
CavTap

UNC



DIN 371 With reinforced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
Nr. 6-32	0.794	56	4.0	3.0	2.85	7	20	3
Nr. 8-32	0.794	63	4.5	3.4	3.50	8	21	3
Nr. 10-24	1.058	70	6.0	4.9	3.90	10	25	3
1/4-20	1.270	80	7.0	5.5	5.10	13	30	3
5/16-18	1.411	90	8.0	6.2	6.60	14	35	3
3/8-16	1.588	100	10.0	8.0	8.00	16	39	3



DIN 376 With reduced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
7/16-14	1.814	100	8	6.2	9.40	18	4
1/2-13	1.954	110	9	7.0	10.80	20	4
5/8-11	2.309	110	12	9.0	13.50	22	4
3/4-10	2.540	125	14	11.0	16.50	25	4
1-8	3.175	160	18	14.5	22.25	30	5

VA



2B

vap.



HSS-E
FHA 42°
≤ 900 N/mm²
≤ 3xD

TP

22 266 ...

006

008

010

025

031

037

TP

22 267 ...

043

050

062

075

100

P	8
M	6
K	
N	22
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand

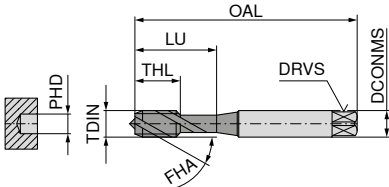
UNC

VA

C

2-3

2B



DIN 371 With reinforced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
	mm	mm	mm	mm	mm	mm	mm	
Nr. 4-40	0.635	56	3.5	2.7	2.30	6	18	2
Nr. 6-32	0.794	56	4.0	3.0	2.85	7	20	3
Nr. 8-32	0.794	63	4.5	3.4	3.50	8	21	3
Nr. 10-24	1.058	70	6.0	4.9	3.90	10	25	3
1/4-20	1.270	80	7.0	5.5	5.20	13	30	3
5/16-18	1.411	90	8.0	6.2	6.60	14	35	3
3/8-16	1.588	100	10.0	8.0	8.00	16	39	3

CX

23 472 ...

004

006

008

010

025

031

037

P

M

K

N

S

H

O

8

6

22

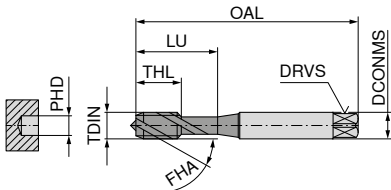
HSS-E
FHA 35°
≤ 1000 N/mm²
≤ 2,5xD

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap SL

CavTap
SL

UNC



DIN 371 With reinforced shank

Ti

C
2-3

2BX

vap.

HSS-PM
FHA 30°
≤ 1400 N/mm²
≤ 1,5xD

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
	mm	mm	mm	mm	mm	mm	mm	
Nr. 4-40	0.635	56	3.5	2.7	2.35	6	18	3
Nr. 6-32	0.794	56	4.0	3.0	2.85	7	20	3
Nr. 8-32	0.794	63	4.5	3.4	3.50	8	21	3
Nr. 10-24	1.058	70	6.0	4.9	3.90	10	25	3
1/4-20	1.270	80	7.0	5.5	5.10	13	30	3
5/16-18	1.411	90	8.0	6.2	6.60	14	35	3

TP
22 262 ...
004
006
008
010
025
031

P	5
M	5
K	
N	22
S	3
H	
O	

Cutting speed v_c (m/min)

CoreLine

– Through hole – machine taps for wire thread inserts, right hand

– TruTap



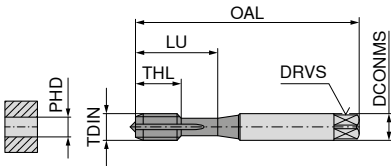
UNI

B

4-5

2B mod

nitr. + vap.



DIN 371 With reinforced shank



HSS-E
FHA 0°
≤ 1100 N/mm²
≤ 4xD

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
EG Nr. 4-40	0.635	63	4.5	3.4	3.1	13	21	3
EG Nr. 6-32	0.794	70	6.0	4.9	3.8	14	25	3
EG Nr. 8-32	0.794	80	6.0	4.9	4.4	16	30	3
EG Nr. 10-24	1.058	80	7.0	5.5	5.2	17	30	3

TP

22 668 ...

004

006

008

010

P	12
M	7
K	12
N	
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps for wire thread inserts, right hand – CavTap



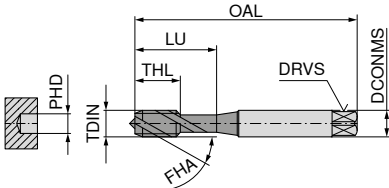
UNI

E

1,5-2

2B mod

vap.



DIN 371 With reinforced shank



HSS-E
FHA 42°
≤ 1100 N/mm²
≤ 3xD

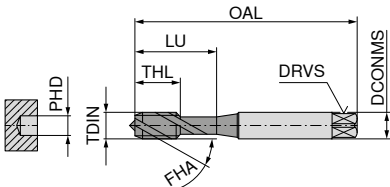
TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
EG Nr. 4-40	0.635	63	4.5	3.4	3.1	7	21	3
EG Nr. 6-32	0.794	70	6.0	4.9	3.8	8	25	3
EG Nr. 8-32	0.794	80	6.0	4.9	4.4	8	30	3
EG Nr. 10-24	1.058	80	7.0	5.5	5.2	10	30	3

TP
22 672 ...
004
006
008
010

P	12
M	7
K	12
N	
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap SL



DIN 371 With reinforced shank

Ti

C
2-3

3BX

TiCN

HSS-E
FHA 15°
≤ 1200 N/mm²
≤ 2xD

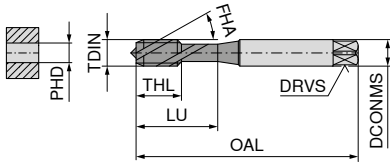
TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
Nr. 4-40	0.635	56	3.5	2.7	2.30	11	18	2
Nr. 6-32	0.794	56	4.0	3.0	2.85	12	20	3
Nr. 8-32	0.794	63	4.5	3.4	3.50	13	21	3
Nr. 10-24	1.058	70	6.0	4.9	3.90	15	25	3
1/4-20	1.270	80	7.0	5.5	5.25	17	30	3
3/8-16	1.588	100	10.0	8.0	8.10	22	39	3

TP
22 166 ...
004
006
008
010
025
037

P	7
M	7
K	
N	22
S	5
H	
O	

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand – TruTap DL



DIN 371 With reinforced shank

Ti

D
4-5

3BX

TiCN

HSS-E
FHA 15°
≤ 1200 N/mm²
≤ 4xD

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
Nr. 4-48	0.529	56	3.5	2.7	2.40	11	18	2
Nr. 6-40	0.635	56	4.0	3.0	3.00	12	20	3
Nr. 8-36	0.705	63	4.5	3.4	3.55	13	21	3
Nr. 10-32	0.794	70	6.0	4.9	4.15	15	25	3
1/4-28	0.907	80	7.0	5.5	5.55	17	30	3
5/16-24	1.058	90	8.0	6.2	7.00	17	35	3
3/8-24	1.058	90	10.0	8.0	8.60	18	35	3

TP

22 167 ...

004

006

008

010

025

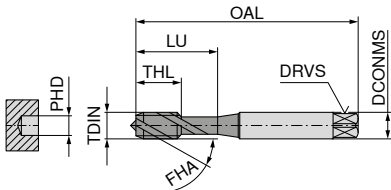
031

037

P	7
M	7
K	
N	22
S	5
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap SL



DIN 371 With reinforced shank

Ti

C
2-3

3BX

TiCN



HSS-E
FHA 15°
≤ 1200 N/mm²
≤ 2xD

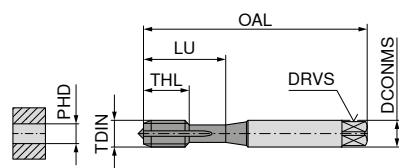
TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
Nr. 4-48	0.529	56	3.5	2.7	2.40	11	18	2
Nr. 6-40	0.635	56	4.0	3.0	3.00	12	20	3
Nr. 8-36	0.705	63	4.5	3.4	3.55	13	21	3
Nr. 10-32	0.794	70	6.0	4.9	4.15	15	25	3
1/4-28	0.907	80	7.0	5.5	5.55	17	30	3
5/16-24	1.058	90	8.0	6.2	7.00	17	35	3
3/8-24	1.058	90	10.0	8.0	8.60	18	35	3

TP
22 168 ...
004
006
008
010
025
031
037

P	7
M	7
K	
N	22
S	5
H	
O	

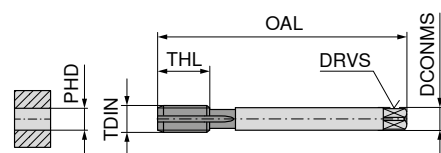
Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand – TruTap



DIN 371 With reinforced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
Nr. 4-48	0.529	56	3.5	2.7	2.40	11	18	2
Nr. 6-40	0.635	56	4.0	3.0	2.95	12	20	3
Nr. 8-36	0.706	63	4.5	3.4	3.50	13	21	3
Nr. 10-32	0.794	70	6.0	4.9	4.10	15	25	3
1/4-28	0.907	80	7.0	5.5	5.50	17	30	3
5/16-24	1.058	90	8.0	6.2	6.90	17	35	3



DIN 374 With reduced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
7/16-20	1.270	100	8	6.2	9.90	22	3
1/2-20	1.270	100	9	7.0	11.50	22	3
9/16-18	1.411	100	11	9.0	12.90	22	3
5/8-18	1.411	100	12	9.0	14.50	22	3
3/4-16	1.588	110	14	11.0	17.50	25	4
7/8-14	1.814	125	18	14.5	20.50	25	4
1-12	2.117	140	18	14.5	23.25	28	4
1 1/8-12	2.117	150	22	18.0	26.50	28	4
1 1/4-12	2.117	150	22	18.0	29.75	28	4
1 3/8-12	2.117	170	28	22.0	33.00	30	5

P	12
M	7
K	12
N	
S	
H	
O	



HSS-E
FHA 0°
≤ 1100 N/mm²
≤ 4xD

TP

22 602 ...

004

006

008

010

025

031

TP

22 603 ...

043

050

056

062

075

087

100

112

125

137

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand

UNI

B

4-5

2B

TiN

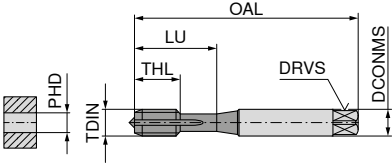


HSS-E

FHA 0°

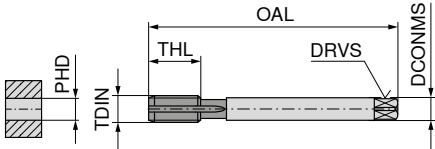
≤ 1100 N/mm²

≤ 3xD



DIN 371 With reinforced shank

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
Nr. 10-32	0.794	70	6	4.9	4.1	15	25	3
1/4-28	0.907	80	7	5.5	5.5	17	30	3
5/16-24	1.058	90	8	6.2	6.9	17	35	3
3/8-24	1.058	90	10	8.0	8.5	18	35	4



DIN 374 With reduced shank

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
7/16-20	1.270	100	8	6.2	9.9	22	3
1/2-20	1.270	100	9	7.0	11.5	22	3
9/16-18	1.411	100	11	9.0	12.9	22	3
5/8-18	1.411	100	12	9.0	14.5	22	3
3/4-16	1.588	110	14	11.0	17.5	25	4

CX

23 180 ...

010

025

031

037

P	15
M	9
K	18
N	12
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand – TruTap

TruTap

UNF

ST

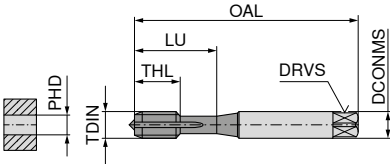
B

4-5

2B



HSS-E
FHA 0°
≤ 750 N/mm²
≤ 4xD



DIN 371 With reinforced shank

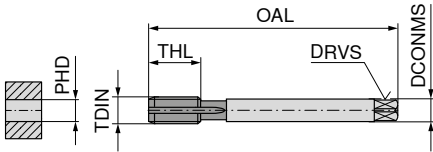
TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
	mm	mm	mm	mm	mm	mm	mm	
Nr. 10-32	0.794	70	6	4.9	4.1	15	25	3
1/4-28	0.907	80	7	5.5	5.5	17	30	3

TP

22 288 ...

010

025



DIN 374 With reduced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
	mm	mm	mm	mm	mm	mm	
5/16-24	1.058	90	6	4.9	6.90	17	3
3/8-24	1.058	90	7	5.5	8.50	18	4
7/16-20	1.270	100	8	6.2	9.90	22	3
1/2-20	1.270	100	9	7.0	11.50	22	3
5/8-18	1.411	100	12	9.0	14.50	22	3
3/4-16	1.588	110	14	11.0	17.50	25	4
7/8-14	1.814	125	18	14.5	20.50	25	4
1-12	2.117	140	18	14.5	23.25	28	4

TP

22 289 ...

031

037

043

050

062

075

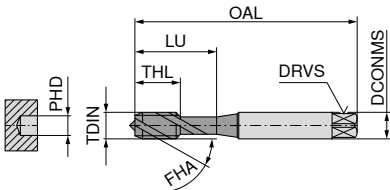
087

100

P	12
M	
K	12
N	22
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap



DIN 371 With reinforced shank

UNI-HP

C

2-3

2BX

AlTiNHD



HSS-E-PM
FHA 45°
≤ 1400 N/mm²
≤ 3xD

TDIN	TP mm	OAL mm	DCONMS _{h9} mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
Nr. 10-32	0.794	70	6	4.9	4.1	10	25	3
1/4-28	0.907	80	7	5.5	5.5	10	30	3
5/16-24	1.058	90	8	6.2	6.9	10	35	3
3/8-24	1.058	90	10	8.0	8.5	10	35	3

P	2-18
M	2-10
K	10-20
N	15-30
S	
H	
O	

Cutting speed v_c (m/min)

NEW

TP

22 826 ...

01100

02500

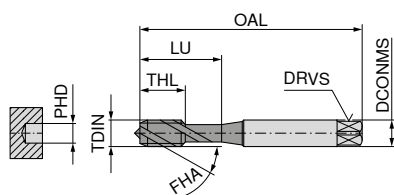
03100

03700

CoreLine – Blind hole – machine taps, right-hand – CavTap

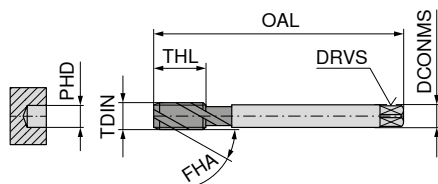
CavTap

UNF



DIN 371 With reinforced shank

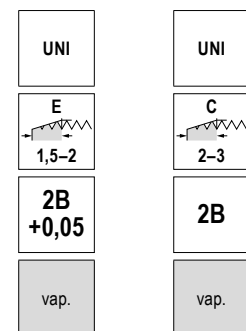
TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
Nr. 6-40	0.635	56	4	3.0	3.0	7	20	3
Nr. 10-32	0.794	70	6	4.9	4.1	10	25	3
1/4-28	0.907	80	7	5.5	5.5	10	30	3
5/16-24	1.058	90	8	6.2	6.9	10	35	3
3/8-24	1.058	90	10	8.0	8.5	10	35	3



DIN 374 With reduced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
7/16-20	1.270	100	8	6.2	9.9	13	4
7/16-20	1.270	100	8	6.2	9.9	13	3
1/2-20	1.270	100	9	7.0	11.5	13	5
1/2-20	1.270	100	9	7.0	11.5	13	4
9/16-18	1.411	100	11	9.0	12.9	15	5
9/16-18	1.411	100	11	9.0	12.9	15	4
5/8-18	1.411	100	12	9.0	14.5	15	5
5/8-18	1.411	100	12	9.0	14.5	15	4
3/4-16	1.588	110	14	11.0	17.5	17	5
3/4-16	1.588	110	14	11.0	17.5	17	4
1-12	2.117	140	18	14.5	23.3	20	5

P	12	12
M	7	7
K	12	12
N	22	
S		
H		
O		



HSS-E
FHA 42°
≤ 1100 N/mm²
≤ 3xD

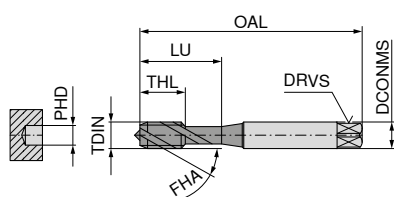
HSS-E
FHA 42°
≤ 1100 N/mm²
≤ 3xD

TP	TP
22 307 ...	22 606 ...
006	
010	010
025	025
031	031
037	

Cutting speed v_c (m/min)

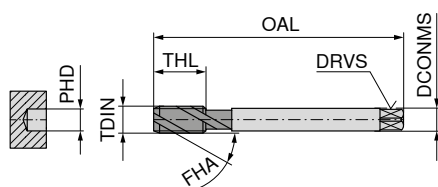
CoreLine – Blind hole – machine taps, right-hand

UNF



DIN 371 With reinforced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
Nr. 10-32	0.794	70	6	4.9	4.1	10	25	3
1/4-28	0.907	80	7	5.5	5.5	10	30	3
5/16-24	1.058	90	8	6.2	6.9	10	35	3
3/8-24	1.058	90	10	8.0	8.5	10	35	3



DIN 374 With reduced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
7/16-20	1.270	100	8	6.2	9.9	13	3
1/2-20	1.270	100	9	7.0	11.5	13	4
9/16-18	1.411	100	11	9.0	12.9	15	4
5/8-18	1.411	100	12	9.0	14.5	15	4
3/4-16	1.588	110	14	11.0	17.5	17	4

P	15
M	9
K	18
N	12
S	
H	
O	

UNI



2B

TiN



HSS-E
FHA 35°
≤ 1100 N/mm²
≤ 2,5xD

CX

23 182 ...

010

025

031

037

CX

23 183 ...

043

050

056

062

075

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand

UNF

FE

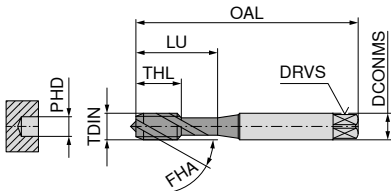
C

2-3

2B



HSS-E
FHA 35°
≤ 850 N/mm²
≤ 2,5xD



DIN 371 With reinforced shank

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
Nr. 10-32	0.794	70	6	4.9	4.1	10	25	3
1/4-28	0.907	80	7	5.5	5.5	10	30	3
5/16-24	1.058	90	8	6.2	6.9	10	35	3
3/8-24	1.058	90	10	8.0	8.5	10	35	3

CX

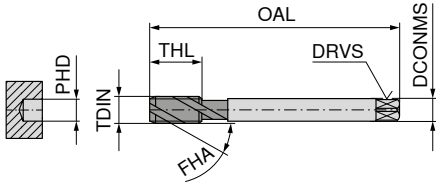
23 282 ...

010

025

031

037



DIN 374 With reduced shank

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
7/16-20	1.270	100	8	6.2	9.9	13	3
1/2-20	1.270	100	9	7.0	11.5	13	4
9/16-18	1.411	100	11	9.0	12.9	15	4
5/8-18	1.411	100	12	9.0	14.5	15	4
3/4-16	1.588	110	14	11.0	17.5	17	4

CX

23 283 ...

043

050

056

062

075

P

M

K

N

S

H

O

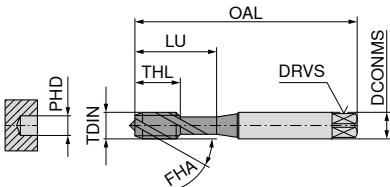
12

12

22

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap



DIN 371 With reinforced shank

VA

E
1,5-2

2B

vap.

HSS-E
FHA 42°
≤ 900 N/mm²
≤ 3xD

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes	TP	
mm	mm	mm	mm	mm	mm	mm	mm		22 308 ...	
Nr. 2-64	0.397	45	2.8	2.1	1.85	4.5	12	2		002
Nr. 4-48	0.529	56	3.5	2.7	2.40	6.0	18	2		004
Nr. 6-40	0.635	56	4.0	3.0	3.00	7.0	20	3		006
Nr. 8-36	0.706	63	4.5	3.4	3.50	8.0	21	3		008
Nr. 10-32	0.794	70	6.0	4.9	4.10	10.0	25	3		010
1/4-28	0.907	80	7.0	5.5	5.50	10.0	30	3		025
5/16-24	1.058	90	8.0	6.2	6.90	10.0	35	3		031
3/8-24	1.058	90	10.0	8.0	8.50	10.0	35	3		037
P										8
M										6
K										
N										22
S										
H										
O										

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand

UNF

VA

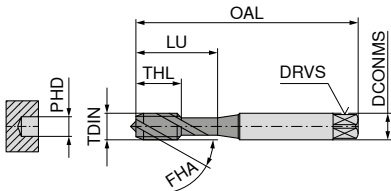
C

2-3

2B



HSS-E
FHA 35°
≤ 1100 N/mm²
≤ 2,5xD



DIN 371 With reinforced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
Nr. 10-32	0.794	70	6	4.9	4.1	10	25	3
1/4-28	0.907	80	7	5.5	5.5	10	30	3
5/16-24	1.058	90	8	6.2	6.9	10	35	3
3/8-24	1.058	90	10	8.0	8.5	10	35	3

CX

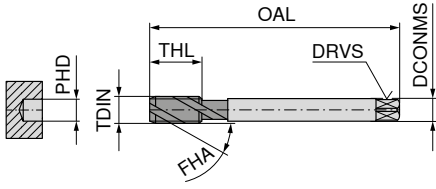
23 482 ...

010

025

031

037



DIN 374 With reduced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
7/16-20	1.270	100	8	6.2	9.9	13	3
1/2-20	1.270	100	9	7.0	11.5	13	4
9/16-18	1.411	100	11	9.0	12.9	15	4
5/8-18	1.411	100	12	9.0	14.5	15	4
3/4-16	1.588	110	14	11.0	17.5	17	4

CX

23 483 ...

043

050

056

062

075

P8

M6

K

N22

S

H

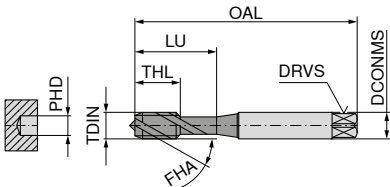
O

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap SL

CavTap
SL

UNF



DIN 371 With reinforced shank

Ti

2BX

vap.

HSS-PM
FHA 30°
≤ 1400 N/mm²
≤ 1,5xD

Ti

3BX

vap.

HSS-PM
FHA 30°
≤ 1400 N/mm²
≤ 1,5xD

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
Nr. 10-32	0.794	70	6	4.9	4.1	10	25	3
1/4-28	0.907	80	7	5.5	5.5	10	30	3
5/16-24	1.058	90	8	6.2	6.9	10	35	3
3/8-24	1.058	90	10	8.0	8.5	10	35	3

TP	TP
22 302 ...	22 303 ...
010	010
025	025
031	031
037	037

P	5	5
M	5	5
K		
N	22	22
S	3	3
H		
O		

Cutting speed v_c (m/min)

CoreLine

– Through hole-blind hole – machine taps, right-hand – DuoTap



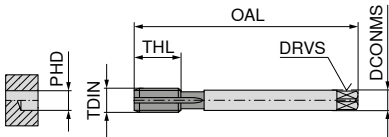
GG

C

2-3

2BX

nitr.



DIN 374 With reduced shank



HSS-E
FHA 0°
≤ 1050 N/mm²
≤ 2xD

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
7/16-20	1.270	100	8	6.2	9.9	22	4
1/2-20	1.270	100	9	7.0	11.5	22	4
3/4-16	1.588	110	14	11.0	17.5	25	4
7/8-14	1.814	125	18	14.5	20.5	25	4

TP

22 295 ...

043

050

075

087

P	
M	
K	16
N	24
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps for wire thread inserts, right hand – TruTap

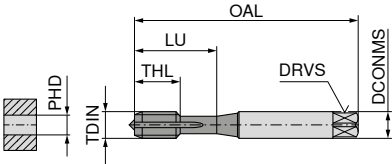


UNI


B
4-5

2B

nitr. + vap.



DIN 371 With reinforced shank



HSS-E
FHA 0°
≤ 1100 N/mm²
≤ 4xD

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
	mm	mm	mm	mm	mm	mm	mm	
EG Nr. 4-48	0.529	56	4	3.0	3.0	9	20	3
EG Nr. 6-40	0.635	70	6	4.9	3.7	11	25	3
EG Nr. 8-36	0.706	80	6	4.9	4.4	13	30	3
EG Nr. 10-32	0.794	80	6	4.9	5.1	13	30	3
EG 1/4-28	0.907	90	8	6.2	6.6	17	35	3

TP

22 676 ...

004

006

008

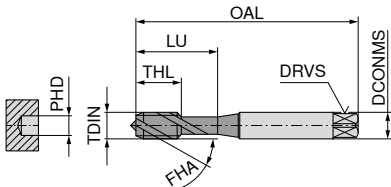
010

025

P	12
M	7
K	12
N	
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps for wire thread inserts, right hand – CavTap



DIN 371 With reinforced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
EG Nr. 4-48	0.529	56	4	3.0	3.0	7	20	3
EG Nr. 6-40	0.635	70	6	4.9	3.7	8	25	3
EG Nr. 8-36	0.706	80	6	4.9	4.4	8	30	3
EG Nr. 10-32	0.794	80	6	4.9	5.1	8	30	3
EG 1/4-28	0.907	90	8	6.2	6.6	10	35	3

P	12
M	7
K	12
N	
S	
H	
O	

UNI

E
1,5-2

2B

vap.

HSS-E
FHA 42°
≤ 1100 N/mm²
≤ 3xD

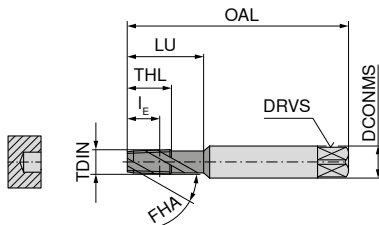
TP
22 680 ...
004
006
008
010
025

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap

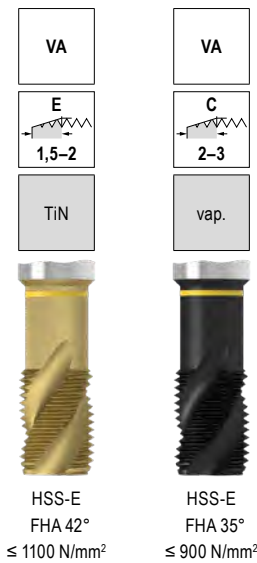
CavTap

NPT



DIN 371 With reinforced shank

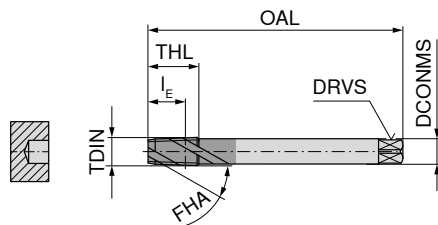
TDIN	TP	OAL	DCONMS	DRVS	IE	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
1/16-27	0.941	90	8	6.2	9.24	13.0	26.0	3
1/8-27	0.941	90	10	8.0	9.28	13.0	26.0	3
1/8-27	0.941	90	10	8.0	9.28	12.0	26.0	4
1/4-18	1.411	100	14	11.0	13.55	19.5	34.5	3
1/4-18	1.411	100	14	11.0	13.55	18.0	34.5	4



HSS-E
FHA 42°
≤ 1100 N/mm²

HSS-E
FHA 35°
≤ 900 N/mm²

TP	TP
22 365 ...	22 364 ...
	006
012	012
025	025



DIN 374 With reduced shank

TDIN	TP	OAL	DCONMS	DRVS	IE	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
3/8-18	1.411	110	14	11	13.86	18.0	5
3/8-18	1.411	110	14	11	13.86	19.5	3
1/2-14	1.814	140	16	12	18.11	23.0	5
1/2-14	1.814	140	16	12	18.11	25.0	5
3/4-14	1.814	150	20	16	18.59	26.0	5

TP	TP
22 372 ...	22 371 ...
037	
050	037
	050
	075

P	5	4
M	4	3
K		
N	22	22
S		
H		
O		

Cutting speed v_c (m/min)

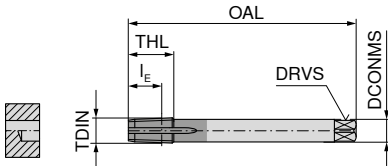
CoreLine

– Through hole-blind hole – machine taps, right-hand – DuoTap

▲ ES = Extra short

DuoTap

NPT



DIN 2181 With reduced shank

ST
ES

C
2-3



HSS-E
FHA 0°
≤ 750 N/mm²

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	I _E mm	THL mm	Flutes
1/16-27	0.941	63	6	4.9	9.24	13.0	4
1/8-27	0.941	63	7	5.5	9.28	13.0	5
1/4-18	1.411	63	11	9.0	13.55	19.5	5
3/8-18	1.411	70	12	9.0	13.86	19.5	5
1/2-14	1.814	80	16	12.0	18.11	23.0	5
3/4-14	1.814	100	20	16.0	18.59	26.0	6
1-11,5	2.209	110	25	20.0	22.31	32.0	6

TP

22 361 ...

006

012

025

037

050

075

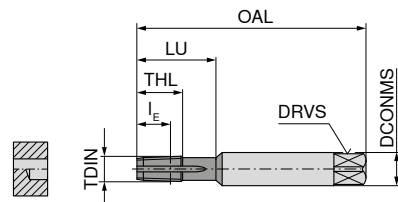
100

P	6
M	
K	6
N	22
S	
H	
O	

Cutting speed v_c (m/min)

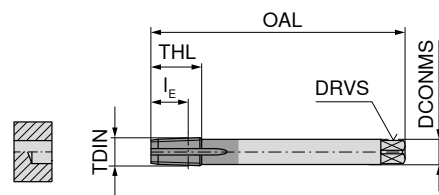
CoreLine – Through hole-blind hole – machine taps, right-hand – DuoTap

▲ AZ = With intermittent teeth, reduces friction



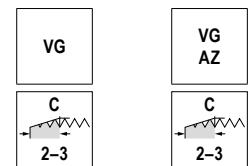
DIN 371 With reinforced shank

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	I _E mm	THL mm	LU mm	Flutes
1/16-27	0.941	90	8	6.2	9.24	13.0	26.0	3
1/8-27	0.941	90	10	8.0	9.28	13.0	26.0	3
1/4-18	1.411	100	14	11.0	13.55	19.5	34.5	3



DIN 374 With reduced shank

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	I _E mm	THL mm	Flutes
3/8-18	1.411	110	14	11	13.86	19.5	3
1/2-14	1.814	140	16	12	18.11	25.0	5
3/4-14	1.814	150	20	16	18.59	26.0	5
1-11,5	2.209	170	25	20	22.31	30.0	5
1-11,5	2.209	170	25	20	22.31	32.0	5



HSS-E
FHA 0°
≤ 1100 N/mm²

HSS-E
FHA 0°
≤ 1100 N/mm²

TP	TP
22 374 ...	22 377 ...
006	006
012	012
025	025

TP	TP
22 375 ...	22 378 ...
037	037
050	050
075	075
100	100

P	4	4
M		4
K	6	6
N	22	22
S		
H		
O		

Cutting speed v_c (m/min)

CoreLine

– Through hole-blind hole – machine taps, right-hand – DuoTap

DuoTap

NPTF

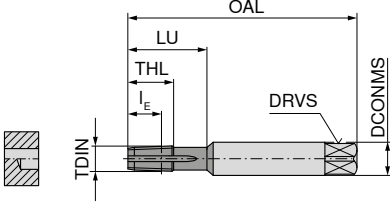
ST

C

2-3

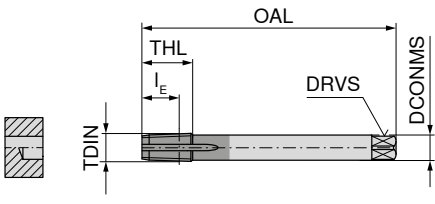


HSS-E
FHA 0°
≤ 750 N/mm²



DIN 371 With reinforced shank

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	lE mm	THL mm	LU mm	Flutes
1/16-27	0.941	90	8	6.2	10.58	13.0	26.0	4
1/8-27	0.941	90	10	8.0	10.62	13.0	26.0	5
1/4-18	1.411	100	14	11.0	15.32	19.5	34.5	5



DIN 374 With reduced shank

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	lE mm	THL mm	Flutes
3/8-18	1.411	110	14	11	15.51	19.5	5
1/2-14	1.814	140	16	12	20.11	25.0	5
3/4-14	1.814	150	20	16	20.24	26.0	6
1-11,5	2.209	170	25	20	24.07	32.0	6

TP

22 382 ...

006

012

025

TP

22 383 ...

037

050

075

100

P

M

K

N

S

H

O

6

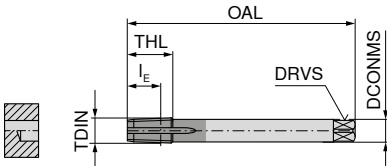
6

22

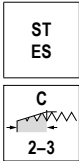
Cutting speed v_c (m/min)

CoreLine – Through hole-blind hole – machine taps, right-hand – DuoTap

▲ ES = Extra short



DIN 2181 With reduced shank



HSS-E
FHA 0°
≤ 750 N/mm²

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	I _E mm	THL mm	Flutes
1/16-27	0.941	63	6	4.9	10.58	13.0	4
1/8-27	0.941	63	7	5.5	10.62	13.0	5
1/4-18	1.411	63	11	9.0	15.32	19.5	5
3/8-18	1.411	70	12	9.0	15.51	19.5	5
1/2-14	1.814	80	16	12.0	20.11	25.0	5
3/4-14	1.814	100	20	16.0	20.24	26.0	6

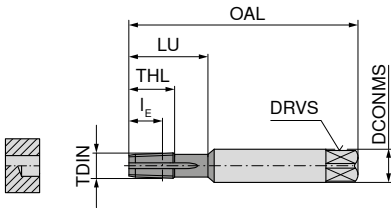
TP
22 367 ...
006
012
025
037
050
075

P	6
M	
K	6
N	22
S	
H	
O	

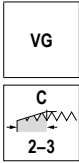
Cutting speed v_c (m/min)

CoreLine

– Through hole-blind hole – machine taps, right-hand – DuoTap



DIN 2181 With reinforced shank



HSS-E
FHA 3.5778°
≤ 1100 N/mm²

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	LE mm	THL mm	Flutes
1/16-27	0.941	90	8	6.2	10.58	13.0	3
1/8-27	0.941	90	10	8.0	10.62	13.0	3
1/4-18	1.411	100	14	11.0	15.32	19.5	3

TP

22 380 ...
006
012
025

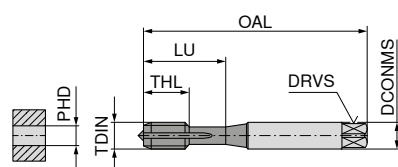
P	4
M	
K	6
N	22
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Through hole – machine taps, right-hand – TruTap



HSS-E
FHA 0°
≤ 1100 N/mm²
≤ 4xD



DIN 371 With reinforced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
1/8-40	0.635	56	3.5	2.7	2.55	11	18	3
3/16-24	1.058	70	6.0	4.9	3.70	15	25	3
1/4-20	1.270	80	7.0	5.5	5.10	17	30	3
5/16-18	1.411	90	8.0	6.2	6.50	20	35	3
3/8-16	1.588	100	10.0	8.0	7.90	22	39	3

TP

22 626 ...

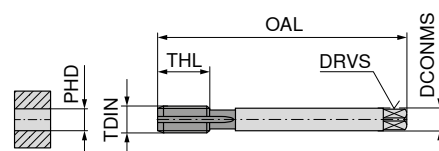
012

018

025

031

037



DIN 374 With reduced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
1/2-12	2.117	110	9	7.0	10.5	25	3
5/8-11	2.309	110	12	9.0	13.5	27	3
3/4-10	2.540	125	14	11.0	16.4	30	3
1-8	3.175	160	18	14.5	22.0	36	3

TP

22 627 ...

050

062

075

100

P	12
M	7
K	12
N	
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Blind hole – machine taps, right-hand – CavTap

CavTap

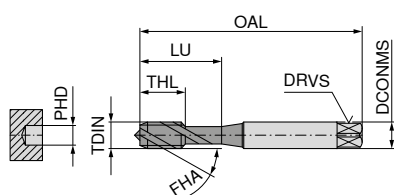
BSW

UNI



med.

vap.



DIN 371 With reinforced shank

HSS-E
FHA 45°
≤ 1100 N/mm²
≤ 3xD

TP

22 686 ...

01200

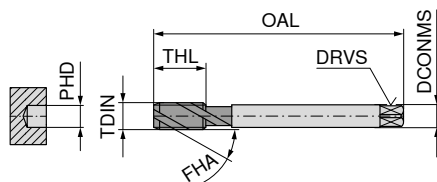
01800

02500

03100

03700

TDIN	TP	OAL	DCONMS _{h9}	DRVS	PHD	THL	LU	Flutes
1/8-40	0.635	56	3.5	2.7	2.55	7	18	3
3/16-24	1.058	70	6.0	4.9	3.70	10	25	3
1/4-20	1.270	80	7.0	5.5	5.10	13	30	3
5/16-18	1.411	90	8.0	6.2	6.50	14	35	3
3/8-16	1.588	100	10.0	8.0	7.90	16	39	3



DIN 374 With reduced shank

TP

22 687 ...

05000

06200

07500

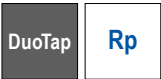
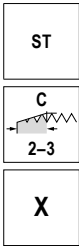
10000

TDIN	TP	OAL	DCONMS _{h9}	DRVS	PHD	THL	Flutes
1/2-12	2.117	110	9	7.0	10.5	20	4
5/8-11	2.309	110	12	9.0	13.5	22	4
3/4-10	2.540	125	14	11.0	16.4	25	4
1-8	3.175	160	18	14.5	22.0	30	5

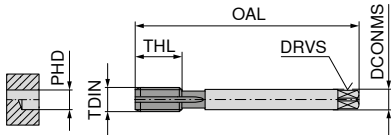
P	2-15
M	4-8
K	
N	
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Through hole-blind hole – machine taps, right-hand – DuoTap



HSS-E
FHA 0°
≤ 750 N/mm²
≤ 2xD



DIN 5156 With reduced shank

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
	mm	mm	mm	mm	mm	mm	
1/8-28	0.907	90	7	5.5	8.60	18	4
1/4-19	1.337	100	11	9.0	11.50	22	4
3/8-19	1.337	100	12	9.0	15.00	22	4
1/2-14	1.814	125	16	12.0	18.50	25	4
3/4-14	1.814	140	20	16.0	24.00	28	4
1-11	2.309	160	25	20.0	30.25	30	5

TP

22 381 ...
012
025
037
050
075
100

P	6
M	
K	6
N	22
S	
H	
O	

Cutting speed v_c (m/min)

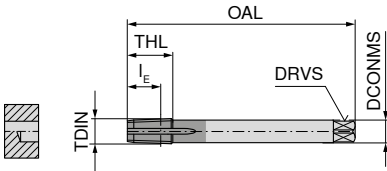
CoreLine – Through hole-blind hole – machine taps, right-hand – DuoTap

DuoTap

Rc

ST

C
2-3



DIN 374 With reduced shank



HSS-E
≤ 1100 N/mm²

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	THL mm	Flutes
1/4-19	1.337	100	11	9	18	3
3/8-19	1.337	110	14	11	18	3
1/2-14	1.814	140	16	12	23	5

TP

22 389 ...

02500

03700

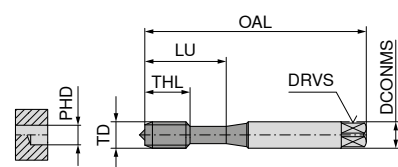
05000

P	4
M	
K	6
N	22
S	
H	
O	

Cutting speed v_c (m/min)

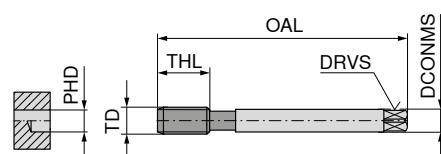
CoreLine – Through hole-blind hole – machine thread formers, right-hand – DuoForm

▲ SN = Thread former with oil grooves



DIN 2174 With reinforced shank

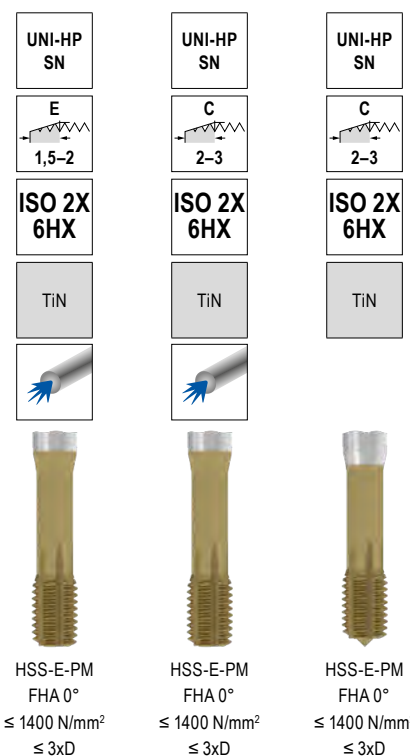
TD mm	TP mm	OAL mm	DCONMS _{h9} mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M3	0.50	56	3.5	2.7	2.80	6	18	3
M4	0.70	63	4.5	3.4	3.70	7	21	4
M5	0.80	70	6.0	4.9	4.65	8	25	5
M6	1.00	80	6.0	4.9	5.60	10	30	6
M8	1.25	90	8.0	6.2	7.45	14	35	7
M10	1.50	100	10.0	8.0	9.35	16	39	9



DIN 2174 With reduced shank

TD mm	TP mm	OAL mm	DCONMS _{h9} mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7	11.25	18	11
M14	2.00	110	11	9	13.10	20	11
M16	2.00	110	12	9	15.10	22	11

P	8-50	8-50	8-50
M	2-12	2-12	2-12
K	20-60	20-60	20-60
N	30-80	30-80	30-80
S			
H			
O			



NEW TP	NEW TP	NEW TP
22 860 ...	22 857 ...	22 853 ...
04000	04000	03000
05000	05000	05000
06000	06000	06000
08000	08000	08000
10000	10000	10000

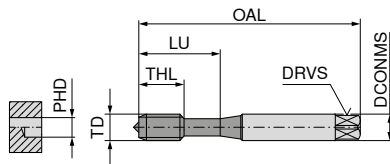
TP	TP	TP
22 861 ...	22 858 ...	22 854 ...
12000	12000	12000
16000	16000	16000

Cutting speed v_c (m/min)

CoreLine – Through hole-blind hole – machine thread formers, right-hand

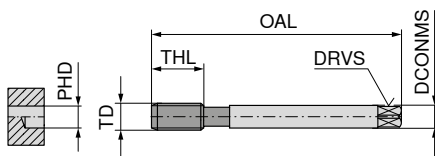
▲ SN = Thread former with oil grooves

M



DIN 2174 With reinforced shank

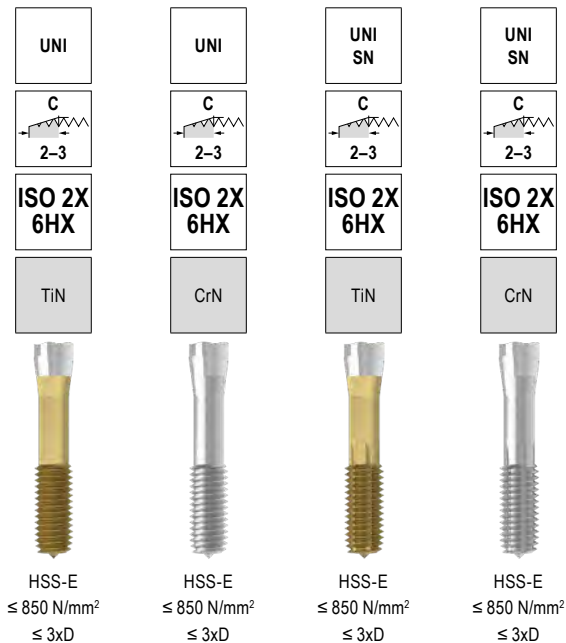
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M2	0.40	45	2.8	2.1	1.85	7	12	
M2	0.40	45	2.8	2.1	1.85	7	12	3
M2,5	0.45	50	2.8	2.1	2.33	9	14	
M2,5	0.45	50	2.8	2.1	2.33	9	14	3
M3	0.50	56	3.5	2.7	2.80	11	18	
M3	0.50	56	3.5	2.7	2.80	11	18	3
M4	0.70	63	4.5	3.4	3.70	13	21	
M4	0.70	63	4.5	3.4	3.70	13	21	4
M5	0.80	70	6.0	4.9	4.65	15	25	
M5	0.80	70	6.0	4.9	4.65	15	25	4
M6	1.00	80	6.0	4.9	5.60	17	30	
M6	1.00	80	6.0	4.9	5.60	17	30	4
M8	1.25	90	8.0	6.2	7.45	20	35	
M8	1.25	90	8.0	6.2	7.45	20	35	5
M10	1.50	100	10.0	8.0	9.35	22	39	
M10	1.50	100	10.0	8.0	9.35	22	39	5



DIN 2174 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7.0	11.25	24	
M12	1.75	110	9	7.0	11.25	24	5
M16	2.00	110	12	9.0	15.10	27	
M16	2.00	110	12	9.0	15.10	27	6
M18	2.50	125	14	11.0	16.80	30	6
M20	2.50	140	16	12.0	18.80	32	6
M24	3.00	160	18	14.5	22.60	34	6

P	18	18	18	18
M	10	10	10	10
K	10		10	
N	22	18	22	18
S				
H				
O				



HSS-E
≤ 850 N/mm²
≤ 3xD

HSS-E
≤ 850 N/mm²
≤ 3xD

HSS-E
≤ 850 N/mm²
≤ 3xD

HSS-E
≤ 850 N/mm²
≤ 3xD

CX	CX	CX	CX
23 810 ...	23 812 ...	23 814 ...	23 816 ...
020	020	020	020
025	025	025	025
030	030	030	030
040	040	040	040
050	050	050	050
060	060	060	060
080	080	080	080
100	100	100	100

CX	CX	CX	CX
23 811 ...	23 813 ...	23 815 ...	23 817 ...
120	120	120	120
160	160	160	160
		18000	
		20000	
		24000	

MonoThread

Through hole-blind hole – machine thread formers, right-hand with carbide strips – DuoForm

▲ HML = With soldered-in carbide strips for a higher cutting speed

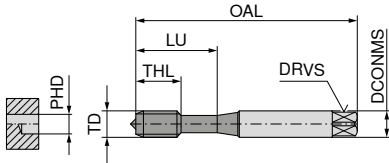
DuoForm

M

NW
HML

C
2-3

ISO 2X
6HX



DIN 2174 With reinforced shank



HSS-E / HM
≤ 880 N/mm²
≤ 3xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm
M6	1.00	80	6	5	5.60	18	30
M8	1.25	90	8	6	7.45	18	35

TP

22 473 ...

06000

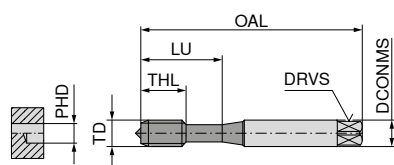
08000

P	
M	
K	
N	30
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Through hole-blind hole – machine thread formers, right-hand – DuoForm

▲ SN = Thread former with oil grooves



DIN 2174 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS _{h9} mm	DRVS mm	PHD mm	THL mm	LU mm
M2	0.40	45	2.8	2.1	1.85	4	12
M3	0.50	56	3.5	2.7	2.80	6	18
M4	0.70	63	4.5	3.4	3.70	7	21
M5	0.80	70	6.0	4.9	4.65	8	25
M6	1.00	80	6.0	4.9	5.60	10	30
M8	1.25	90	8.0	6.2	7.45	14	35
M10	1.50	100	10.0	8.0	9.35	16	39

P				
M				
K				
N	20-60	20-60	20-60	20-60
S				
H				
O				

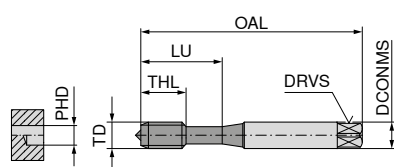
Cutting speed v_c (m/min)

AL SN	AL SN	AL SN	AL SN
E 1,5-2	E 1,5-2	C 2-3	C 2-3
ISO 2X 6HX	ISO 2X 6HX	ISO 2X 6HX	ISO 2X 6HX
DLC	DLC	DLC	DLC
HSS-E-PM FHA 0° ≤ 500 N/mm² ≤ 3xD	HSS-E-PM FHA 0° ≤ 500 N/mm² ≤ 3xD	HSS-E-PM FHA 0° ≤ 500 N/mm² ≤ 3xD	HSS-E-PM FHA 0° ≤ 500 N/mm² ≤ 3xD

NEW TP	NEW TP	NEW TP	NEW TP
22 848 ...	22 846 ...	22 847 ...	22 845 ...
	02000		02000
	03000		03000
04000	04000	04000	04000
05000	05000	05000	05000
06000	06000	06000	06000
08000	08000	08000	08000
10000	10000	10000	10000

CoreLine – Through hole-blind hole – machine thread formers, right-hand – DuoForm

▲ SN = Thread former with oil grooves



DIN 2174 With reinforced shank

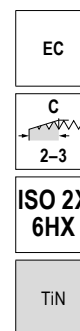
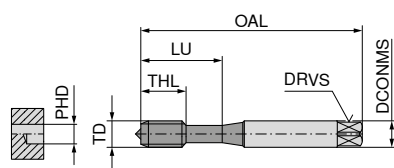
TD mm	TP mm	OAL mm	DCONMS _{h9} mm	DRVS mm	PHD mm	THL mm	LU mm
M5	0.80	70	6	4.9	4.65	8	25
M6	1.00	80	6	4.9	5.60	10	30
M8	1.25	90	8	6.2	7.45	14	35
M10	1.50	100	10	8.0	9.35	16	39

P				
M				
K				
N	20-60	20-60	20-60	20-60
S				
H				
O				

Cutting speed v_c (m/min)

G-AL SN	G-AL SN	G-AL SN	G-AL SN
E 1,5-2	E 1,5-2	C 2-3	C 2-3
ISO 2X 6HX	ISO 2X 6HX	ISO 2X 6HX	ISO 2X 6HX
TiCN	TiCN	TiCN	TiCN
HSS-E-PM FHA 0° ≤ 500 N/mm² ≤ 3xD	HSS-E-PM FHA 0° ≤ 500 N/mm² ≤ 3xD	HSS-E-PM FHA 0° ≤ 500 N/mm² ≤ 3xD	HSS-E-PM FHA 0° ≤ 500 N/mm² ≤ 3xD
NEW TP	NEW TP	NEW TP	NEW TP
22 852 ...	22 850 ...	22 851 ...	22 849 ...
05000	05000	05000	05000
06000	06000	06000	06000
08000	08000	08000	08000
10000	10000		10000

CoreLine – Through hole-blind hole – machine thread formers, right-hand – DuoForm



DIN 2174 With reinforced shank



HSS-E
 $\leq 1100 \text{ N/mm}^2$
 $\leq 1,5xD$

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm
M1	0.25	40	2.5	2.1	0.90	5	6.5
M1,2	0.25	40	2.5	2.1	1.10	5	6.5
M1,4	0.30	40	2.5	2.1	1.28	6	9.0
M1,6	0.35	40	2.5	2.1	1.47	6	9.0
M1,7	0.35	40	2.5	2.1	1.57	6	9.0
M2	0.40	45	2.8	2.1	1.85	7	10.0
M2,5	0.45	50	2.8	2.1	2.33	9	14.0
M2,6	0.45	50	2.8	2.1	2.43	9	14.0
M3	0.50	56	3.5	2.7	2.80	11	18.0
M3,5	0.60	56	4.0	3.0	3.25	12	20.0
M4	0.70	63	4.5	3.4	3.70	13	21.0
M5	0.80	70	6.0	4.9	4.65	15	25.0
M6	1.00	80	6.0	4.9	5.60	17	30.0
M8	1.25	90	8.0	6.2	7.40	20	35.0
M10	1.50	100	10.0	8.0	9.35	22	39.0

TP

22 100 ...

010 ¹⁾012 ¹⁾014 ¹⁾

016

017

020

025

026

030

035

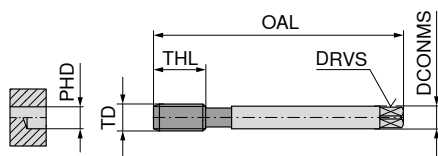
040

050

060

080

100

1) Tol. ISO 1X 4HX $\leq$ M1.4

DIN 2174 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm
M12	1.75	110	9	7	11.25	24
M16	2.00	110	12	9	15.10	27

TP

22 101 ...

120

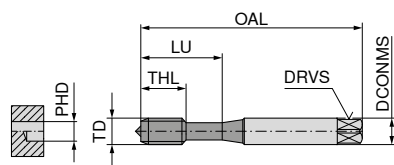
160

P	18
M	10
K	10
N	22
S	
H	
O	

Cutting speed v_c (m/min)

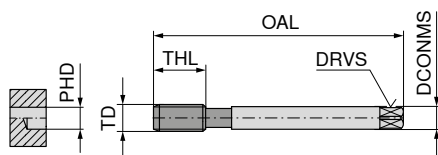
CoreLine – Through hole-blind hole – machine thread formers, right-hand – DuoForm

▲ SN = Thread former with oil grooves



DIN 2174 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M2	0.40	45	2.8	2.1	1.85	7	10	3
M2,5	0.45	50	2.8	2.1	2.33	9	14	3
M3	0.50	56	3.5	2.7	2.80	11	18	3
M3,5	0.60	56	4.0	3.0	3.25	12	20	3
M4	0.70	63	4.5	3.4	3.70	13	21	4
M5	0.80	70	6.0	4.9	4.65	15	25	4
M6	1.00	80	6.0	4.9	5.60	17	30	4
M8	1.25	90	8.0	6.2	7.45	20	35	5
M10	1.50	100	10.0	8.0	9.35	22	39	6



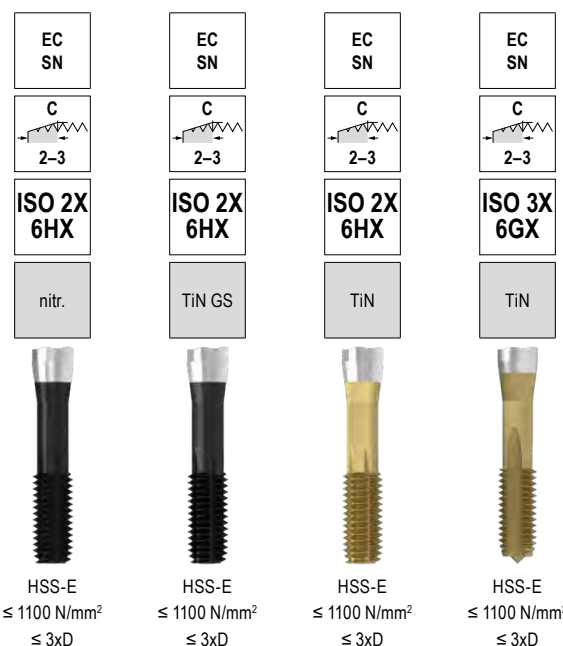
DIN 2174 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7	11.25	24	6
M14	2.00	110	11	9	13.10	26	5
M16	2.00	110	12	9	15.10	27	6

TP
22 106 ...
120
140
160

P	12	18	18	18
M		10	10	10
K	8	10	10	10
N	12	22	22	22
S				
H				
O				

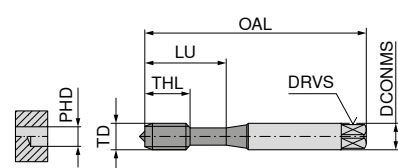
Cutting speed v_c (m/min)



TP	TP	TP	TP
22 104 ...	22 154 ...	22 105 ...	22 108 ...
		020	
		025	
030	030	030	030
		035	
040	040	040	040
050	050	050	050
060	060	060	060
080	080	080	080
100	100	100	100

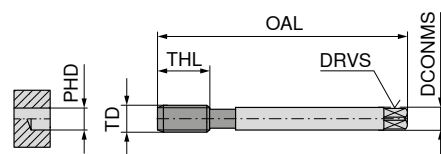
CoreLine – Through hole-blind hole – machine thread formers, right-hand – DuoForm

▲ SN = Thread former with oil grooves



DIN 2174 With reinforced shank

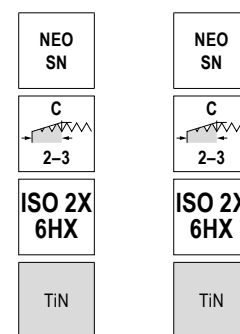
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M3	0.50	56	3.5	2.7	2.80	11	18	4
M4	0.70	63	4.5	3.4	3.70	13	21	4
M5	0.80	70	6.0	4.9	4.65	15	25	4
M6	1.00	80	6.0	4.9	5.60	17	30	5
M8	1.25	90	8.0	6.2	7.45	20	35	5
M10	1.50	100	10.0	8.0	9.35	22	39	5



DIN 2174 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M12	1.75	110	9	7	11.25	24	6
M16	2.00	110	12	9	15.10	27	6

P	18	18
M	10	10
K	10	10
N	22	22
S		
H		
O		



HSS-PM
≤ 1100 N/mm²
≤ 3xD



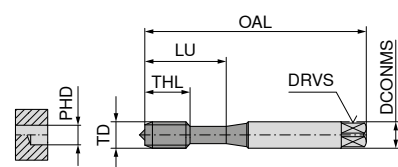
HSS-PM
≤ 1100 N/mm²
≤ 3xD

TP	TP
22 452 ...	22 453 ...
030	
040	
050	050
060	060
080	080
100	100

Cutting speed v_c (m/min)

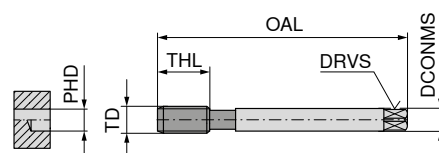
CoreLine – Through hole-blind hole – machine thread formers, right-hand – DuoForm

▲ SN = Thread former with oil grooves



DIN 2174 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS _{h9} mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M8x1	1	90	8	6.2	7.6	10	35	7
M10x1	1	90	10	8.0	9.6	10	35	9



DIN 2174 With reduced shank

TD mm	TP mm	OAL mm	DCONMS _{h9} mm	DRVS mm	PHD mm	THL mm	Flutes
M12x1,5	1.5	100	9	7	11.35	15	11
M14x1,5	1.5	100	11	9	13.35	15	11
M16x1,5	1.5	100	12	9	15.35	15	11

P	8-50	8-50	8-50
M	2-12	2-12	2-12
K	20-60	20-60	20-60
N	30-80	30-80	30-80
S			
H			
O			

UNI-HP SN	UNI-HP SN	UNI-HP SN
E 1,5-2	C 2-3	C 2-3
ISO 2X 6HX	ISO 2X 6HX	ISO 2X 6HX
TiN	TiN	TiN
HSS-E-PM FHA 0° ≤ 1400 N/mm² ≤ 3xD	HSS-E-PM FHA 0° ≤ 1400 N/mm² ≤ 3xD	HSS-E-PM FHA 0° ≤ 1400 N/mm² ≤ 3xD

NEW	NEW	NEW TP
		22 855 ...
		08100
		10200

TP	TP	TP
22 868 ...	22 859 ...	22 856 ...
12100	12100	12100
14400	14400	14400
16200	16200	16200

Cutting speed v_c (m/min)

CoreLine – Through hole-blind hole – machine thread formers, right-hand

▲ SN = Thread former with oil grooves

MF

UNI
SN

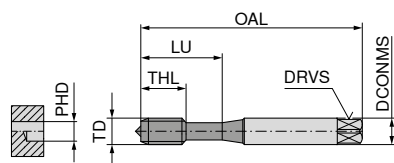


ISO 2X
6HX

TiN



HSS-E
≤ 850 N/mm²
≤ 3xD



DIN 2174 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRV mm	PHD mm	THL mm	LU mm	Flutes
M4x0,5	0.50	63	4.5	3.4	3.80	10	21	4
M5x0,5	0.50	70	6.0	4.9	4.80	11	25	4
M6x0,5	0.50	80	6.0	4.9	5.80	13	30	5
M8x1	1.00	90	8.0	6.2	7.60	17	35	5
M10x1	1.00	90	10.0	8.0	9.60	18	35	5
M10x1,25	1.25	100	10.0	8.0	9.45	18	39	5

CX

23 842 ...

040

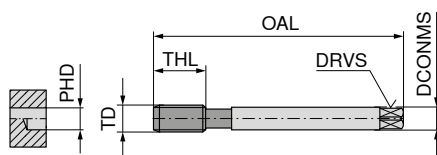
050

060

084

102

104



DIN 2174 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRV mm	PHD mm	THL mm	Flutes
M12x1,25	1.25	100	9	7	11.45	22	6
M12x1,5	1.50	100	9	7	11.35	22	6
M14x1,5	1.50	100	11	9	13.35	22	6
M16x1,5	1.50	100	12	9	15.35	22	6

CX

23 843 ...

122

124

144

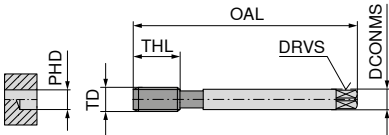
162

P	18
M	10
K	10
N	22
S	
H	
O	

Cutting speed v_c (m/min)

MonoThread – Through hole-blind hole – machine thread formers, right-hand with carbide strips – DuoForm

▲ HML = With soldered-in carbide strips for a higher cutting speed



DIN 2174 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm
M12x1,5	1.5	100	9	7	11.35	13
M16x1,5	1.5	100	12	9	15.35	18

EC
HML

ISO 2X
6HX

TiN

HSS-E / HM
≤ 1100 N/mm²
≤ 3xD

EC
HML

ISO 2X
6HX

TiN

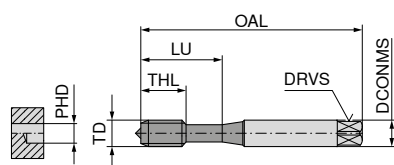
HSS-E / HM
≤ 1100 N/mm²
≤ 3xD

P	30	30
M	20	20
K	30	30
N	40	40
S		
H		
O		

Cutting speed v_c (m/min)

CoreLine – Through hole-blind hole – machine thread formers, right-hand – DuoForm

▲ SN = Thread former with oil grooves



DIN 2174 With reinforced shank



HSS-E
 $\leq 1100 \text{ N/mm}^2$
 $\leq 3 \times D$

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M4x0,5	0.50	63	4.5	3.4	3.8	10	21	4
M5x0,5	0.50	70	6.0	4.9	4.8	11	25	4
M6x0,5	0.50	80	6.0	4.9	5.8	13	30	5
M6x0,75	0.75	80	6.0	4.9	5.7	13	30	4
M8x0,75	0.75	80	8.0	6.2	7.7	14	30	5
M8x1	1.00	90	8.0	6.2	7.6	17	35	5
M10x1	1.00	90	10.0	8.0	9.6	18	35	5

TP

22 205 ...

040

050

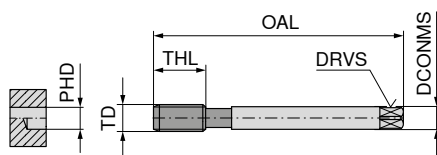
060

062

080

082

100



DIN 2174 With reduced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
M12x1	1.0	100	9	7	11.60	18	6
M12x1,5	1.5	100	9	7	11.35	22	6
M14x1,5	1.5	100	11	9	13.35	22	6
M16x1,5	1.5	100	12	9	15.35	22	6
M20x1,5	1.5	125	16	12	19.35	25	6

TP

22 197 ...

120

124

140

160

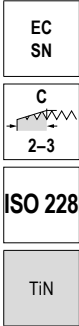
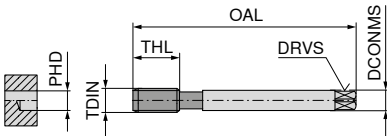
200

P	18
M	10
K	10
N	22
S	
H	
O	

Cutting speed v_c (m/min)

CoreLine – Through hole-blind hole – machine thread formers, right-hand – DuoForm

▲ SN = Thread former with oil grooves



DIN 2189 With reduced shank



HSS-E
≤ 1100 N/mm²
≤ 3xD

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	Flutes
1/8-28	0.907	90	7	5.5	9.25	18	5
1/4-19	1.337	100	11	9.0	12.55	22	6
3/8-19	1.337	100	12	9.0	16.05	22	6
1/2-14	1.814	125	16	12.0	20.10	25	6

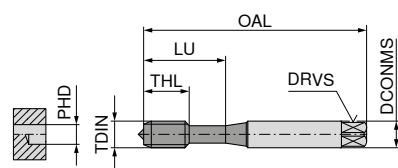
TP
22 359 ...
012
025
037
050

P	18
M	10
K	10
N	22
S	
H	
O	

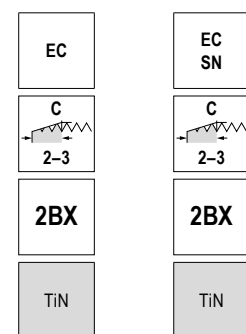
Cutting speed v_c (m/min)

CoreLine – Through hole-blind hole – machine thread formers, right-hand – DuoForm

▲ SN = Thread former with oil grooves



DIN 2174 With reinforced shank



HSS-E
 $\leq 1100 \text{ N/mm}^2$
 $\leq 1,5 \times D$



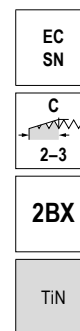
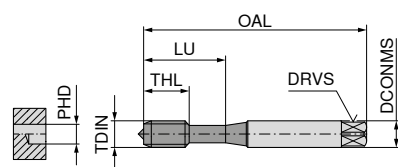
HSS-E
 $\leq 1100 \text{ N/mm}^2$
 $\leq 3 \times D$

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes	TP	TP
mm	mm	mm	mm	mm	mm	mm	mm		22 270 ...	22 271 ...
Nr. 4-40	0.635	56	3.5	2.7	2.55	11	18		004	
Nr. 4-40	0.635	56	3.5	2.7	2.55	11	18	3		004
Nr. 6-32	0.794	56	4.0	3.0	3.15	12	20		006	
Nr. 6-32	0.794	56	4.0	3.0	3.15	12	20	3		006
Nr. 8-32	0.794	63	4.5	3.4	3.80	13	21		008	
Nr. 8-32	0.794	63	4.5	3.4	3.80	13	21	4		008
Nr. 10-24	1.058	70	6.0	4.9	4.35	15	25		010	
Nr. 10-24	1.058	70	6.0	4.9	4.35	15	25	4		010
1/4-20	1.270	80	7.0	5.5	5.75	17	30		025	
1/4-20	1.270	80	7.0	5.5	5.75	17	30	4		025
5/16-18	1.411	90	8.0	6.2	7.30	20	35		031	
5/16-18	1.411	90	8.0	6.2	7.30	20	35	5		031
3/8-16	1.588	100	10.0	8.0	8.80	22	39		037	
3/8-16	1.588	100	10.0	8.0	8.80	22	39	5		037
P									18	18
M									10	10
K									10	10
N									22	22
S										
H										
O										

Cutting speed v_c (m/min)

CoreLine – Through hole-blind hole – machine thread formers, right-hand – DuoForm

▲ SN = Thread former with oil grooves



DIN 2174 With reinforced shank

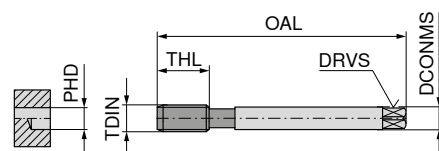


HSS-E
 $\leq 1100 \text{ N/mm}^2$
 $\leq 3xD$

TDIN	TP	OAL	DCONMS	DRV	PHD	THL	LU	Flutes
mm	mm	mm	mm	mm	mm	mm	mm	
Nr. 4-48	0.529	56	3.5	2.7	2.62	11	18	3
Nr. 6-40	0.635	56	4.0	3.0	3.22	12	20	3
Nr. 8-36	0.706	63	4.5	3.4	3.85	13	21	4
Nr. 10-32	0.794	70	6.0	4.9	4.45	15	25	4
1/4-28	0.907	80	7.0	5.5	5.95	17	30	4

TP

22 312 ...
 004
 006
 008
 010
 025



DIN 2174 With reduced shank

TDIN	TP	OAL	DCONMS	DRV	PHD	THL	Flutes
mm	mm	mm	mm	mm	mm	mm	
7/16-20	1.27	100	8	6.2	10.55	22	5
1/2-20	1.27	100	9	7.0	12.15	22	6

TP

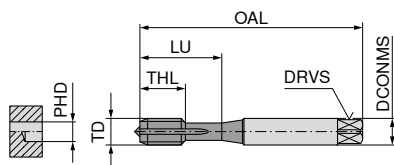
22 313 ...
 043
 050

P	18
M	10
K	10
N	22
S	
H	
O	

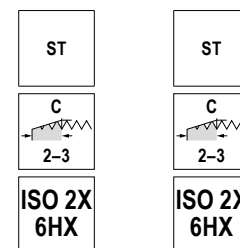
Cutting speed v_c (m/min)

CoreLine – Set of hand taps, right-hand

M



DIN 352 With reinforced shank



Solid carbide
FHA 0°
≤ 63 HRC
≤ 2xD

HSS-E
FHA 0°
≤ 750 N/mm²
≤ 2xD

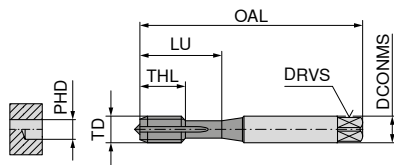
TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M1	0.25	32	2.5	2.1	0.75	5		2
M1,4	0.30	32	2.5	2.1	1.10	7		2
M1,6	0.35	32	2.5	2.1	1.25	8		2
M2	0.40	36	2.8	2.1	1.60	8		3
M2,5	0.45	40	2.8	2.1	2.05	9		3
M3	0.50	40	3.5	2.7	2.50	6	18	3
M3	0.50	40	3.5	2.7	2.50	10	18	3
M3,5	0.60	45	4.0	3.0	2.90	11	20	3
M4	0.70	45	4.5	3.4	3.30	12	22	3
M4	0.70	45	4.5	3.4	3.30	7	23	3
M5	0.80	50	6.0	4.9	4.20	9	28	3
M5	0.80	50	6.0	4.9	4.20	14	25	3
M6	1.00	56	6.0	4.9	5.00	10	26	3
M6	1.00	56	6.0	4.9	5.00	16	28	3
M7	1.00	56	6.0	4.9	6.00	18		3
M8	1.25	63	6.0	4.9	6.80	14		3
M8	1.25	63	6.0	4.9	6.80	20		3
M10	1.50	70	7.0	5.5	8.50	16		3
M10	1.50	70	7.0	5.5	8.50	22		3
M11	1.50	70	8.0	6.2	9.50	22		4
M12	1.75	75	9.0	7.0	10.20	24		3
M12	1.75	75	9.0	7.0	10.20	18		3
M14	2.00	80	11.0	9.0	12.00	26		3
M14	2.00	80	11.0	9.0	12.00	20		4
M16	2.00	80	12.0	9.0	14.00	27		3
M16	2.00	80	12.0	9.0	14.00	22		4
M20	2.50	95	16.0	12.0	17.50	25		4
M20	2.50	95	16.0	12.0	17.50	32		4
M24	3.00	110	18.0	14.5	21.00	34		4

TP	TP
22 800 ...	22 010 ...
	010 ¹⁾
	014 ¹⁾
	016
	020
	025
030	
	030
	035
	040
040	
050	
	050
060	
	060
	070
080	
	080
100	
	100
	110
	120
120	
	140
140	
	160
160	
200	
	200
	240

P	●
M	
K	
N	
S	
H	●
O	

1) Tol. ISO 1X 4HX ≤ M1.4

M



ERGO	ERGO F.T.
 <p>C 2-3</p>	 <p>C 2-3</p>
ISO 2X 6HX	ISO 2X 6HX
	nitr.



HSS-E
FHA 0°
≤ 1400 N/mm²
≤ 2xD

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M2	0.40	36	2.8	2.1	1.60	8		3
M2,5	0.45	40	2.8	2.1	2.05	9		3
M3	0.50	40	3.5	2.7	2.50	10	18	3
M3,5	0.60	45	4.0	3.0	2.90	11	20	3
M4	0.70	45	4.5	3.4	3.30	12	22	3
M5	0.80	50	6.0	4.9	4.20	14	25	3
M6	1.00	56	6.0	4.9	5.00	16	28	3
M8	1.25	63	6.0	4.9	6.80	20		4
M10	1.50	70	7.0	5.5	8.50	22		4
M12	1.75	75	9.0	7.0	10.20	24		4
M14	2.00	80	11.0	9.0	12.00	26		4
M16	2.00	80	12.0	9.0	14.00	27		4
M20	2.50	95	16.0	12.0	17.50	32		4
M24	3.00	110	18.0	14.5	21.00	34		4

TP	TP
22 012 ...	22 013 ...
020	
025	
030	030
035	
040	040
050	050
060	060
080	080
100	100
120	120
140	
160	160
200	200
240	

	P	M	K	N	S	H	O
P							
M							
K							
N							
S							
H							
O							

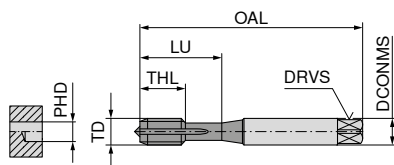
CoreLine – Set of hand taps, right-hand

MF

ST

ISO 2X
6HX

HSS-E
FHA 0°
≤ 750 N/mm²
≤ 2xD



DIN 2181 With reinforced shank

TD mm	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
M4x0,35	0.35	45	4.5	3.4	3.65	9	22	3
M4x0,5	0.50	45	4.5	3.4	3.50	9	22	3
M5x0,5	0.50	50	6.0	4.9	4.50	11	25	3
M6x0,5	0.50	56	6.0	4.9	5.50	12	27	3
M6x0,75	0.75	56	6.0	4.9	5.20	12	27	3
M8x0,5	0.50	56	6.0	4.9	7.50	14		4
M8x0,75	0.75	56	6.0	4.9	7.20	14		3
M8x1	1.00	63	6.0	4.9	7.00	17		3
M10x0,75	0.75	63	7.0	5.5	9.20	18		4
M14x1	1.00	70	11.0	9.0	13.00	18		4
M10x1	1.00	63	7.0	5.5	9.00	18		4
M12x1	1.00	70	9.0	7.0	11.00	18		4
M16x1	1.00	70	12.0	9.0	15.00	18		5
M18x1	1.00	80	14.0	11.0	17.00	18		5
M20x1	1.00	80	16.0	12.0	19.00	18		5
M22x1	1.00	80	18.0	14.5	21.00	18		5
M24x1	1.00	90	18.0	14.5	23.00	18		6
M14x1,25	1.25	70	11.0	9.0	12.80	20		4
M12x1,25	1.25	70	9.0	7.0	10.80	20		4
M14x1,5	1.50	70	11.0	9.0	12.50	20		4
M12x1,5	1.50	70	9.0	7.0	10.50	20		4
M16x1,5	1.50	70	12.0	9.0	14.50	20		4
M10x1,25	1.25	70	7.0	5.5	8.80	22		3
M18x1,5	1.50	80	14.0	11.0	16.50	22		4
M20x1,5	1.50	80	16.0	12.0	18.50	22		4
M22x1,5	1.50	80	18.0	14.5	20.50	22		4
M20x2	2.00	80	16.0	12.0	18.00	22		4
M18x2	2.00	80	14.0	11.0	16.00	22		4
M22x2	2.00	80	18.0	14.5	20.00	22		4

TP

22 151 ...

040

042

050

060

062

080

082

084

102

142

104

122

160

180

200

220

240

144

124

146

126

162

106

182

202

222

204

184

224

P

M

K

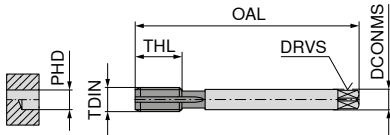
N

S

H

O

CoreLine – Set of hand taps, right-hand



DIN 5157 With reduced shank



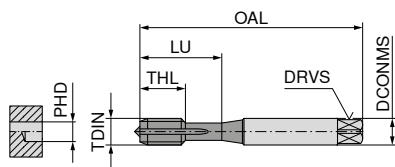
HSS-E
FHA 0°
≤ 1100 N/mm²
≤ 2xD

TDIN	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes
	mm	mm	mm	mm	mm	mm	
1/8-28	0.907	63	7	5.5	8.80	18	4
1/4-19	1.337	70	11	9.0	11.80	20	4
3/8-19	1.337	70	12	9.0	15.25	20	4
1/2-14	1.814	80	16	12.0	19.00	22	4
3/4-14	1.814	90	20	16.0	24.50	22	4

TP
22 342 ...
012
025
037
050
075

P	●
M	●
K	●
N	●
S	●
H	
O	

UNC



ERGO



TP

025

031

037

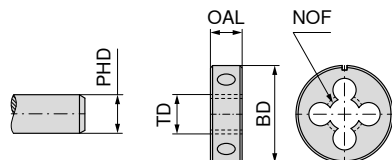
050

TDIN	TP mm	OAL mm	DCONMS mm	DRVS mm	PHD mm	THL mm	LU mm	Flutes
1/4-20	1.270	56	6	4.9	5.1	16	28	3
5/16-18	1.411	63	6	4.9	6.6	20		4
3/8-16	1.588	70	7	5.5	8.0	22		4
1/2-13	1.954	75	9	7.0	10.8	25		4

Category	Value
P	0.000000
M	0.000000
K	0.000000
N	0.000000
S	0.000000
H	0.000000
O	0.000000

CoreLine – Dies, right-hand

▲ $R_z=1$ = Lapped dies



TD mm	TP mm	OAL mm	BD mm	PHD mm	NOF
M1	0.25	5	16	0.97	3
M1,2	0.25	5	16	1.17	3
M1,4	0.30	5	16	1.36	3
M1,6	0.35	5	16	1.54	3
M1,8	0.35	5	16	1.74	3
M2	0.40	5	16	1.94	3
M2,2	0.45	5	16	2.13	3
M2,3	0.40	5	16	2.24	3
M2,5	0.45	5	16	2.43	3
M2,6	0.45	5	16	2.53	3
M3	0.50	5	20	2.89	4
M3	0.50	5	20	2.92	3
M3,5	0.60	5	20	3.41	3
M4	0.70	5	20	3.87	4
M4	0.70	5	20	3.90	3
M4,5	0.75	7	20	4.40	4
M5	0.80	7	20	4.86	4
M5	0.80	7	20	4.90	4
M6	1.00	7	20	5.85	4
M6	1.00	7	20	5.88	4
M7	1.00	9	25	6.88	4
M8	1.25	9	25	7.83	4
M8	1.25	9	25	7.86	4
M9	1.25	9	25	8.86	4
M10	1.50	11	30	9.81	4
M10	1.50	11	30	9.85	4
M11	1.50	11	30	10.85	4
M12	1.75	14	38	11.81	4
M12	1.75	14	38	11.83	4
M14	2.00	14	38	13.82	4
M14	2.00	14	38	13.82	5
M16	2.00	18	45	15.82	5
M18	2.50	18	45	17.79	5
M20	2.50	18	45	19.79	5
M22	2.50	22	55	21.79	5
M24	3.00	22	55	23.76	5
M30	3.50	25	65	29.73	6

FE



ISO 6e

HSS
≤ 750 N/mm²

FE



ISO 6g

HSS
≤ 750 N/mm²

FE



ISO 6g

HSS
≤ 750 N/mm²FE
 $R_z=1$ 

ISO 6g

HSS
≤ 750 N/mm²

TP	TP	CX	TP
22 701 ...	22 700 ...	23 910 ...	22 703 ...
	010 ¹⁾		
	012 ¹⁾		
	014 ¹⁾		
	016		
	018		
	020		020
	022		
	023		
	025		025
	026		026
030			
	030	030	030
	035		035
040			
	040	040	040
	045		
050			
	050	050	050
060			
	060	060	060
	070		
080			
	080	080	080
	090		
100			
	100	100	100
	110		
120			
	120	120	120
	140		
		140	140
	160	160	160
	180	180	180
	200	200	200
	220	220	
	240	240	
	300		

P	5	5	5	5
M				
K				
N	15	15		15
S				
H				
O	7	7		7

1) Tol. ISO 6h ≤ M1.4

Cutting speed v_c (m/min)

CoreLine – Dies, left-hand

▲ LH = For left-hand threads

M

FE
LH

1,5-2

ISO 6g

HSS
≤ 750 N/mm²

TD mm	TP mm	OAL mm	BD mm	PHD mm	NOF
M2	0.40	5	16	1.94	3
M3	0.50	5	20	2.92	3
M4	0.70	5	20	3.90	4
M5	0.80	7	20	4.90	4
M6	1.00	7	20	5.88	4
M8	1.25	9	25	7.86	4
M10	1.50	11	30	9.85	4
M12	1.75	14	38	11.83	4
M14	2.00	14	38	13.82	4
M16	2.00	18	45	15.82	5
M20	2.50	18	45	19.79	5
M24	3.00	22	55	23.76	5

TP

22 702 ...

020

030

040

050

060

080

100

120

140

160

200

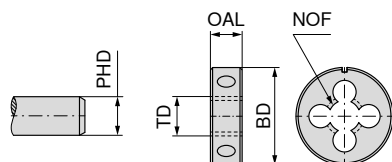
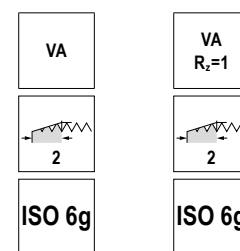
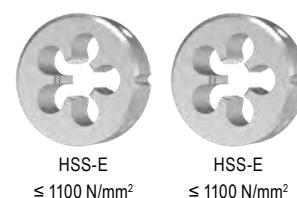
240

P	5
M	
K	
N	15
S	
H	
O	7

Cutting speed v_c (m/min)

CoreLine – Dies, right-hand

▲ $R_z=1$ = Lapped dies



TD mm	TP mm	OAL mm	BD mm	PHD mm	NOF
M2	0.40	5	16	1.94	4
M2,5	0.45	5	16	2.43	4
M3	0.50	5	20	2.92	4
M3,5	0.60	5	20	2.92	4
M4	0.70	5	20	3.90	4
M5	0.80	7	20	4.90	4
M6	1.00	7	20	5.88	4
M8	1.25	9	25	7.86	4
M8	1.25	9	25	7.86	5
M10	1.50	11	30	9.85	5
M12	1.75	14	38	11.83	5
M14	2.00	14	38	13.82	5
M16	2.00	18	45	15.82	5
M18	2.50	18	45	17.79	5
M20	2.50	18	45	19.79	5
M22	2.50	22	55	21.79	5
M24	3.00	22	55	23.76	5

TP	TP
22 704 ...	22 705 ...
020	
025	
030	030
035	
040	040
050	050
060	060
	080
080	
100	100
120	120
140	140
160	160
180	180
200	200
220	
240	

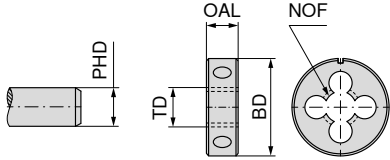
P	5	5
M	3	3
K		
N	15	15
S		
H		
O	7	7

Cutting speed v_c (m/min)

CoreLine – Dies, right-hand

▲ R_z=1 = Lapped dies

M



Ms
R_z=1


1

ISO 6g


HSS
≤ 500 N/mm²

TP

22 706 ...

025

030

035

040

050

060

080

100

TD mm	TP mm	OAL mm	BD mm	PHD mm	NOF
M2,5	0.45	5	16	2.43	3
M3	0.50	5	20	2.92	4
M3,5	0.60	5	20	3.41	4
M4	0.70	5	20	3.90	4
M5	0.80	7	20	4.90	4
M6	1.00	7	20	5.88	4
M8	1.25	9	25	7.86	4
M10	1.50	11	30	9.85	5

P

M

K

N

S

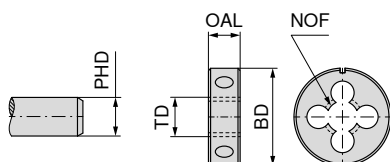
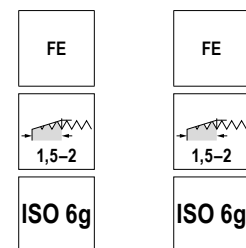
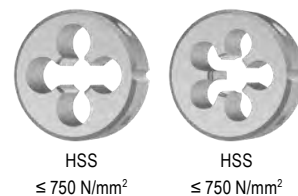
H

O

Cutting speed v_c (m/min)

CoreLine – Dies, right-hand

MF



TD mm	TP mm	OAL mm	BD mm	PHD mm	NOF
M2,5x0,35	0.35	5	16	2.44	3
M3,5x0,35	0.35	5	20	3.44	4
M4x0,35	0.35	5	20	3.94	4
M4x0,5	0.50	5	20	3.92	4
M5x0,5	0.50	5	20	4.92	4
M6x0,5	0.50	5	20	5.92	4
M6x0,75	0.75	7	20	5.90	4
M6x0,75	0.75	9	20	5.90	4
M7x0,75	0.75	9	25	6.90	4
M8x0,5	0.50	9	25	7.92	5
M8x0,75	0.75	9	25	7.90	4
M8x1	1.00	9	25	7.88	4
M9x0,75	0.75	9	25	8.90	4
M9x1	1.00	9	25	8.88	4
M10x0,75	0.75	11	30	9.90	5
M10x1	1.00	11	30	9.88	5
M10x1	1.00	11	30	9.88	4
M10x1,25	1.25	11	30	9.86	4
M11x1	1.00	11	30	10.88	5
M12x1	1.00	10	38	11.88	5
M12x1,25	1.25	10	38	11.86	4
M12x1,5	1.50	10	38	11.85	4
M12x1,5	1.50	10	38	11.86	4
M13x1	1.00	10	38	12.88	5
M14x1	1.00	10	38	13.88	5
M14x1,25	1.25	10	38	13.86	5
M14x1,5	1.50	10	38	13.85	5
M15x1	1.00	10	38	14.88	5
M15x1,5	1.50	10	38	14.85	5
M16x1	1.00	14	45	15.88	5
M16x1,5	1.50	14	45	15.85	5
M16x1,5	1.50	14	45	15.86	5
M18x1	1.00	14	45	17.88	5
M18x1,5	1.50	14	45	17.85	5
M18x2	2.00	14	45	17.82	5
M20x1	1.00	14	45	19.88	6
M20x1,5	1.50	14	45	19.85	6
M20x1,5	1.50	14	45	19.88	6
M20x2	2.00	14	45	19.82	5
M22x1	1.00	16	55	21.88	6
M22x1,5	1.50	16	55	21.85	5
M22x2	2.00	16	55	21.82	5
M24x1	1.00	16	55	23.88	6
M24x1,5	1.50	16	55	23.85	6
M24x2	2.00	16	55	23.82	5
M25x1,5	1.50	16	55	24.85	6
M26x1,5	1.50	16	55	25.85	6
M27x1,5	1.50	18	65	26.85	6
M27x2	2.00	18	65	26.82	6
M28x1,5	1.50	18	65	27.85	6
M30x1,5	1.50	18	65	29.85	6
M30x2	2.00	18	65	29.82	6

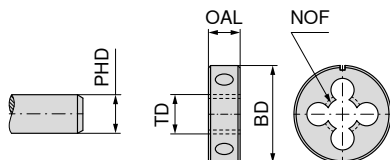
CX	TP
23 940 ...	22 711 ...
	025
	035
	040
	042
	050
	060
	062
062	
	070
080	080
082	082
084	084
	090
	092
100	102
	104
102	
104	106
	110
120	122
122	124
124	
	126
	130
140	142
142	144
144	146
	150
	152
160	160
	162
162	
180	180
182	182
	184
200	200
202	
	202
	204
	220
222	222
	224
	240
242	242
	244
	252
260	260
	272
	274
280	
300	302
	304

P	5	5
M		
K		
N		15
S		
H		
O		7

CoreLine – Dies, left-hand

▲ LH = For left-hand threads

MF



FE
LH



ISO 6g



HSS
≤ 750 N/mm²

TD mm	TP mm	OAL mm	BD mm	PHD mm	NOF
M4x0,5	0.50	5	20	3.92	3
M5x0,5	0.50	5	20	4.92	4
M6x0,5	0.50	5	20	5.92	4
M6x0,75	0.75	7	20	5.90	4
M8x0,75	0.75	9	25	7.90	4
M8x1	1.00	9	25	7.88	4
M10x1	1.00	11	30	9.88	4
M12x1	1.00	10	38	11.88	5
M12x1,5	1.50	10	38	11.85	4
M14x1	1.00	10	38	13.88	5
M14x1,5	1.50	10	38	13.85	5
M16x1,5	1.50	14	45	15.85	5
M18x1,5	1.50	14	45	17.85	5
M20x1,5	1.50	14	45	19.85	6
M22x1,5	1.50	16	55	21.85	5
M24x1,5	1.50	16	55	23.85	6

TP

22 712 ...

040

050

060

062

080

082

100

120

122

140

142

160

180

200

220

240

P

5

M

K

N

15

S

H

O

7

Cutting speed v_c (m/min)

CoreLine – Dies, right-hand

MF

VA

ISO 6g

HSS-E
≤ 900 N/mm²

TD mm	TP mm	OAL mm	BD mm	PHD mm	NOF
M6x0,75	0.75	7	20	5.90	4
M8x0,75	0.75	9	25	7.90	4
M8x1	1.00	9	25	7.88	4
M10x1	1.00	11	30	9.88	5
M12x1	1.00	10	38	11.88	5
M12x1,5	1.50	10	38	11.85	5
M14x1,5	1.50	10	38	13.85	5
M16x1,5	1.50	14	45	15.85	5
M18x1,5	1.50	14	45	17.85	5
M20x1,5	1.50	14	45	19.85	6
M22x1,5	1.50	16	55	21.85	5
M24x1,5	1.50	16	55	23.85	6

TP

22 714 ...

060

080

082

100

120

122

140

160

180

200

220

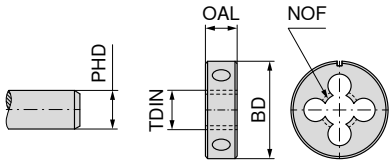
240

P	5
M	3
K	
N	15
S	
H	
O	7

Cutting speed v_c (m/min)

CoreLine – Dies, right-hand

G



FE



1,5-2

ISO 228
A



HSS
≤ 750 N/mm²

TP

22 741 ...

012

025

037

050

062

075

087

100

125

150

TDIN	TP mm	OAL mm	BD mm	PHD mm	NOF
1/8-28	0.907	11	30	9.62	4
1/4-19	1.337	10	38	13.03	5
3/8-19	1.337	14	45	16.54	5
1/2-14	1.814	14	45	20.81	6
5/8-14	1.814	16	55	22.77	5
3/4-14	1.814	16	55	26.30	6
7/8-14	1.814	18	65	30.06	6
1-11	2.309	18	65	33.07	7
1 1/4-11	2.309	20	75	41.73	7
1 1/2-11	2.309	22	90	47.62	7

P

M

K

N

S

H

O

5

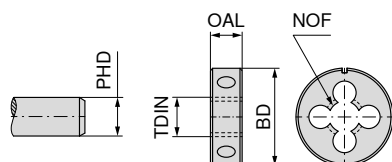
15

7

Cutting speed v_c (m/min)

CoreLine – Dies, right-hand

UNC



FE

1,5-2

2A



HSS
≤ 750 N/mm²

TDIN	TP mm	OAL mm	BD mm	PHD mm	NOF
Nr. 1-64	0.397	5	16	1.79	3
Nr. 2-56	0.454	5	16	2.12	3
Nr. 3-48	0.529	5	16	2.44	3
Nr. 4-40	0.635	5	20	2.76	3
Nr. 6-32	0.794	7	20	3.41	3
Nr. 8-32	0.794	7	20	4.07	4
Nr. 10-24	1.058	7	20	4.71	4
Nr. 12-24	1.058	7	20	5.37	4
1/4-20	1.270	7	20	6.22	4
5/16-18	1.411	9	25	7.80	4
3/8-16	1.588	11	30	9.37	4
7/16-14	1.814	11	30	10.95	4
1/2-13	1.954	14	38	12.52	4
9/16-12	2.117	14	38	14.10	4
5/8-11	2.309	18	45	15.68	4
3/4-10	2.540	18	45	18.84	5
7/8-9	2.822	22	55	22.00	5
1-8	3.175	22	55	25.15	5

TP

22 721 ...

001

002

003

004

006

008

010

012

025

031

037

043

050

056

062

075

087

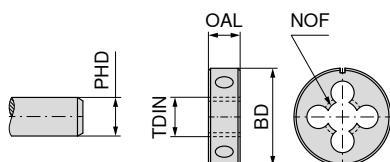
100

P	5
M	
K	
N	15
S	
H	
O	7

Cutting speed v_c (m/min)

CoreLine – Dies, right-hand

UNF



FE

1,5-2

2A



HSS
≤ 750 N/mm²

TDIN	TP mm	OAL mm	BD mm	PHD mm	NOF
Nr. 0-80	0.318	5	16	1.47	3
Nr. 1-72	0.353	5	16	1.80	3
Nr. 2-64	0.397	5	16	2.12	3
Nr. 3-56	0.454	5	16	2.44	3
Nr. 4-48	0.529	5	20	2.77	3
Nr. 5-44	0.577	5	20	3.10	3
Nr. 6-40	0.635	5	20	3.42	3
Nr. 8-36	0.706	7	20	4.08	4
Nr. 10-32	0.794	7	20	4.73	4
Nr. 12-28	0.907	7	20	5.38	4
1/4-28	0.907	7	20	6.24	4
5/16-24	1.058	9	25	7.82	4
3/8-24	1.058	11	30	9.41	4
7/16-20	1.270	11	30	10.98	4
1/2-20	1.270	10	38	12.56	4
9/16-18	1.411	10	38	14.14	5
5/8-18	1.411	14	45	15.73	5
3/4-16	1.588	14	45	18.89	5
7/8-14	1.814	16	55	22.05	5
1-2	2.117	16	55	25.21	6

TP

22 726 ...

001

002

003

004

005

006

007

008

010

012

025

031

037

043

050

056

062

075

087

100

P

5

M

K

N

15

S

H

O

7

Cutting speed v_c (m/min)

CoreLine – Dies, right-hand

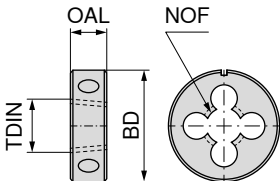
NPT

OAL

NOF

TDIN

BD



FE





HSS
≤ 750 N/mm²

TDIN	TP mm	OAL mm	BD mm	NOF
1/16-27	0.941	10	25	4
1/8-27	0.941	11	30	4
1/4-18	1.411	16	38	5
3/8-18	1.411	18	45	5
1/2-14	1.814	20	45	5
3/4-14	1.814	22	55	6
1-11,5	2.209	25	65	6

TP

22 747 ...

006

012

025

037

050

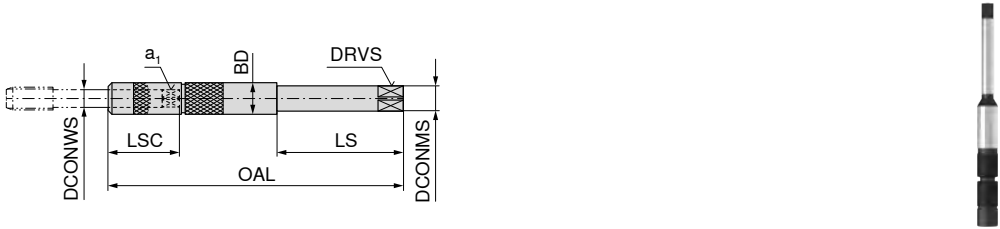
075

100

P	5
M	
K	
N	15
S	
H	
O	7

Cutting speed v_c (m/min)

CoreLine – Shank extensions for taps



DIN 371	DIN 374 / 376	DCONWS	a ₁	LSC	BD	LS	OAL	DRVS	DCONMS	TO
mm		mm	mm	mm	mm	mm	mm	mm	mm	20 450 ...
M3	M4,5 - M5	3.5	2.7	23	7.5	60	130	4.9	6	020
M3,5	M5,5	4.0	3.0	23	8.4	60	130	4.9	6	030
M4	M6	4.5	3.4	23	8.4	60	130	4.9	6	040
M4,5 - M6	M8	6.0	4.9	26	12.1	60	130	5.5	7	050
M7	M9 - M10	7.0	5.5	26	12.1	60	130	5.5	7	060
M8	M11	8.0	6.2	30	13.0	60	130	6.2	8	070
M9	M12	9.0	7.0	31	15.0	60	130	7.0	9	080
M10		10.0	8.0	33	15.0	60	130	8.0	10	090
	M14	11.0	9.0	36	18.0	90	180	9.0	11	100
(M12)	M16	12.0	9.0	36	18.0	90	180	9.0	12	110

Thread-cutting paste, chlorine-free



WT	AS
kg	22 950 ...
0.45	002
4.50	003

Thread cutting oil, chlorine-free



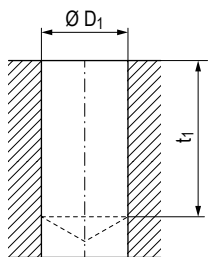
WT	AS
kg	22 950 ...
1	004

Material examples for cutting data tables

	Material sub-group	Index	Composition / Structure / Heat treatment	Hardness HB / HRC Tensile strength at rupture (Rm) lbf/in ²	Material number Material designation	Material number Material designation
P	Unalloyed steel	P.1.1	< 0.15 % C, annealed	60900 lbf/in ² / 125 HB	1.0401 1015	1.0301 1010
		P.1.2	< 0.45 % C, annealed	92800 lbf/in ² / 190 HB	1.1191 1045	1.0737 12L14
		P.1.3	< 0.45 % C, tempered	121800 lbf/in ² / 250 HB	1.1191 1045	1.0503 1043
		P.1.4	< 0.75 % C, annealed	132000 lbf/in ² / 270 HB	1.1223 1060	1.0535 1055
		P.1.5	< 0.75 % C, tempered	146500 lbf/in ² / 300 HB	1.1223 1060	1.1274 1095
	Low-alloy steel	P.2.1	Annealed	88500 lbf/in ² / 180 HB	1.7131 5115	1.6523 8620
		P.2.2	Tempered	134900 lbf/in ² / 275 HB	1.7131 5115	1.6582 4340
		P.2.3	Tempered	146500 lbf/in ² / 300 HB	1.7225 4142	1.7131 5115
		P.2.4	Tempered	174000 lbf/in ² / 375 HB	1.7225 4142	1.7223 4140
	High-alloy steel and high-alloy tool steel	P.3.1	Annealed	98600 lbf/in ² / 200 HB	1.4021 420	1.2379 D2
		P.3.2	Hardened and tempered	159500 lbf/in ² / 300 HB	1.2343 H11	1.3343 M2
		P.3.3	Hardened and tempered	188500 lbf/in ² / 400 HB	1.2343 H11	1.2363 A2
	Stainless steel	P.4.1	Ferritic / martensitic, annealed	98600 lbf/in ² / 200 HB	1.4016 430	1.4125 440C
		P.4.2	Martensitic, tempered	117500 lbf/in ² / 300 HB	1.4112 S44003	1.4021 420
M	Stainless steel	M.1.1	Austenitic / austenitic-ferritic, quenched	88500 lbf/in ² / 180 HB	1.4301 304	1.4401 316
		M.2.1	Austenitic, tempered	300 HB	1.4841 314	1.4568 17-7 PH
		M.3.1	Austenitic / ferritic (Duplex)	113100 lbf/in ² / 230 HB	1.4462 S32205	1.4410 S32750
K	Grey cast iron	K.1.1	Pearlitic / ferritic	88500 lbf/in ² / 180 HB	0.6010 A48-20B	0.6025 A48-40 B
		K.1.2	Pearlitic (martensitic)	127600 lbf/in ² / 260 HB	0.6030 A48-45B	0.6040 A48-60 B
	Spherulitic graphite cast iron	K.2.1	Ferritic	78300 lbf/in ² / 160 HB	0.7040 60-40-18	0.7050 65-45-12
		K.2.2	Pearlitic	122600 lbf/in ² / 250 HB	0.7070 100-70-03	0.7660 A439 Type D2
	Malleable iron	K.3.1	Ferritic	63800 lbf/in ² / 130 HB	0.8035 GTW-35-04	
		K.3.2	Pearlitic	113100 lbf/in ² / 230 HB	0.8170 70003	
N	Aluminium wrought alloy	N.1.1	Non-hardenable	60 HB	3.0255 A91060	3.0255 A91060
		N.1.2	Hardenable, age-hardened	49300 lbf/in ² / 100 HB	3.1355 2024	3.1355 2024
	Cast aluminium alloy	N.2.1	≤ 12 % Si, non-hardenable	36300 lbf/in ² / 75 HB	3.2581 A04130 / A413-0	3.2581 A04130 / A413-0
		N.2.2	≤ 12 % Si, hardenable, age-hardened	43500 lbf/in ² / 90 HB	3.2134 G-AISi5Cu1Mg	
		N.2.3	> 12 % Si, non-hardenable	63800 lbf/in ² / 130 HB	G-AISi17Cu4Mg	
	Copper and copper alloys (bronze/brass)	N.3.1	Free-machining alloys, Pb > 1 %	54400 lbf/in ² / 110 HB	2.0380 CuZn39Pb2 (Ms58)	2.0380 C37700
		N.3.2	CuZn, CuSnZn	43500 lbf/in ² / 90 HB	2.0331 CuZn15	2.0331 C34000
		N.3.3	CuSn, lead-free copper and electrolytic copper	49300 lbf/in ² / 100 HB	2.0060 E-Cu57	
	Magnesium alloys	N.4.1	Magnesium and magnesium alloys	70 HB	3.5612 MgAl6Zn	
S	Heat-resistant alloys	S.1.1	Fe basis, annealed	98600 lbf/in ² / 200 HB	1.4864 X12NiCrSi 36-16	1.4864 330
		S.1.2	Fe basis, age-hardened	137800 lbf/in ² / 280 HB	1.4980 X6NiCrTiMoVB25-15-2	1.4980 S66286
		S.2.1	Ni or Co basis, annealed	121800 lbf/in ² / 250 HB	2.4856 Inconel 625	2.4812 Hastelloy C
		S.2.2	Ni or Co basis, age-hardened	171100 lbf/in ² / 350 HB	2.4952 Nimonic 80A	2.4668 Inconel 718
		S.2.3	Ni or Co basis, cast	156600 lbf/in ² / 320 HB	2.4674 Nimocast PK24	2.4670 Nimocast 713
	Titanium alloys	S.3.1	Pure titanium	5800 lbf/in ²	3.7025 Ti99,8	
		S.3.2	Alpha + beta alloys, age-hardened	152300 lbf/in ² / 320 HB	3.7165 TiAl6V4	
		S.3.3	Beta alloys	203100 lbf/in ² / 410 HB	Ti555.3 Ti-5Al-5V-5Mo-3Cr	
H	Hardened steel	H.1.1	Hardened and tempered	46–55 HRC		
		H.1.2	Hardened and tempered	56–60 HRC		
		H.1.3	Hardened and tempered	61–65 HRC		
		H.1.4	Hardened and tempered	66–70 HRC		
	Chilled iron	H.2.1	Cast	400 HB		
	Hardened cast iron	H.3.1	Hardened and tempered	55 HRC		
O	Non-metal materials	O.1.1	Plastics, duroplastic	≤ 21800 lbf/in ²	EP, MF, PF, UP	
		O.1.2	Plastics, thermoplastic	≤ 14500 lbf/in ²	PA, PC, PE, PI, PMMA, POM, PP, PS, PTFE, PVC	
		O.2.1	Aramid fibre-reinforced	≤ 145000 lbf/in ²	AFK	
		O.2.2	Glass/carbon-fibre reinforced	≤ 145000 lbf/in ²	CFRP, GFRP	
		O.3.1	Graphite			

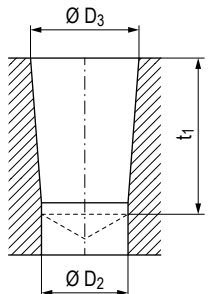
Core hole diameters for taper threads (taper 1:16)

Pre-drilling of cylindrical holes without reamer



Pitch		NPT		NPTF		Pitch		Rc	
Ø D inch	P Gg/1"	Ø D ₁ mm	t ₁ min. mm	Ø D ₁ mm	t ₁ min. mm	Ø D inch	P Gg/1"	Ø D ₁ mm	t ₁ min. mm
1/16	27	6,15	12	6,1	12	1/16	28	6,2	11,9
1/8	27	8,5	12	8,45	12	1/8	28	8,2	11,9
1/4	18	11	17,5	10,9	17,5	1/4	19	10,85	16,3
3/8	18	14,5	17,6	14,3	17,6	3/8	19	14,5	18,1
1/2	14	17,85	22,9	17,6	22,9	1/2	14	18	24
3/4	14	23,2	23	23	23	3/4	14	23,5	25,3
1	11½	29,5	27,4	28,75	27,4	1	11	29,5	30,6
1¼	11½	37,8	28,1	37,5	28,1				
1½	11½	44	28,4	43,75	28,4				
2	11½	56	28,4	55,75	28,4				

Pre-drilling of cylindrical holes and conical boring with reamer

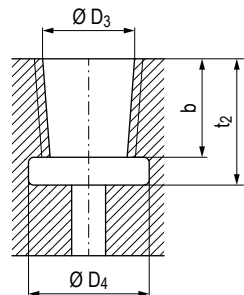


Taper 1:16

Pitch		NPT			NPTF		
Ø D inch	P Gg/1"	Ø D ₂ mm	Ø D ₃ mm	t ₁ min. mm	Ø D ₂ mm	Ø D ₃ mm	t ₁ min. mm
1/16	27	5,95	6,39	12	5,95	6,41	12
1/8	27	8,25	8,74	12	8,25	8,76	12
1/4	18	10,75	11,36	17,5	10,75	11,4	17,5
3/8	18	14,1	14,8	17,6	14,1	14,84	17,6
1/2	14	17,5	18,32	22,9	17,5	18,33	22,9
3/4	14	22,7	23,67	23	22,7	23,68	23
1	11½	28,6	29,69	27,4	28,6	29,72	27,4
1¼	11½	37,3	38,45	28,1	37,3	38,48	28,1
1½	11½	43,4	44,52	28,4	43,4	44,5	28,4
2	11½	55,5	56,56	28,4	55,5	56,59	28,4

Pitch		Rc		
Ø D inch	P Gg/1"	Ø D ₂ mm	Ø D ₃ mm	t ₁ min. mm
1/16	28	6,1	6,56	11,9
1/8	28	8,1	8,57	11,9
1/4	19	10,75	11,45	17,7
3/8	19	14,25	14,95	18,1
1/2	14	17,75	18,63	24
3/4	14	23	24,12	25,3
1	11	29	30,29	30,6

Recommendation for the pre-drilling of blind hole threads



Taper 1:16

Pitch		NPT				NPTF			
Ø D inch	P Gg/1"	Ø D ₃ mm	b mm	t ₂ min. mm	Ø D ₄ min. mm	Ø D ₃ mm	b mm	t ₂ min. mm	Ø D ₄ min. mm
1/16	27	6,39	7	10	7,6	6,41	8	11	7,4
1/8	27	8,74	7	10	10	8,76	8	11	9,8
1/4	18	11,36	10,2	14,5	13,1	11,4	11,6	15,5	12,9
3/8	18	14,8	10,6	15	16,5	14,84	12	16	16,3
1/2	14	18,32	13,8	19	20,5	18,33	15,6	20,5	20,3
3/4	14	23,67	14,2	20	25,8	23,68	16	21,5	25,6
1	11½	29,69	17	24	32,2	29,72	19,2	26	32
1¼	11½	38,45	17,5	24,5	41	38,48	19,7	26,5	40,8
1½	11½	44,52	17,5	24,5	47,2	44,5	19,7	26,5	47
2	11½	56,56	18	25	59,2	56,59	20,2	27	59

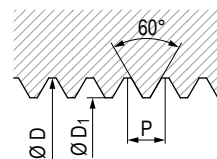
Pitch		Rc			
Ø D inch	P Gg/1"	Ø D ₃ mm	b mm	t ₂ min. mm	Ø D ₄ min. mm
1/16	28	6,56	5,6	9,5	7,6
1/8	28	8,57	5,6	9,5	9,6
1/4	19	11,45	8,4	14	13
3/8	19	14,95	8,8	14,4	16,5
1/2	14	18,63	11,4	19	20,6
3/4	14	24,12	12,7	20,3	26
1	11	30,29	14,5	24,3	32,8

Tapped pilot hole diameter

M ISO metric coarse threads 6H to DIN 13 and DIN ISO 965-1 (M1-M1.4 = 5H)

Thread nominal Ø		Ø D ₁		Core hole
D	P	min.	max.	
M1	0,25	0,729	0,785	0,75
M1,1	0,25	0,829	0,885	0,85
M1,2	0,25	0,929	0,985	0,95
M1,4	0,3	1,075	1,142	1,1
M1,6	0,35	1,221	1,321	1,25
M1,8	0,35	1,421	1,521	1,45
M2	0,4	1,567	1,679	1,6
M2,2	0,45	1,713	1,838	1,75
M2,5	0,45	2,013	2,138	2,05
M3	0,5	2,459	2,599	2,5
M3,5	0,6	2,850	3,01	2,9
M4	0,7	3,242	3,422	3,3
M4,5	0,75	3,688	3,878	3,7
M5	0,8	4,134	4,334	4,2
M6	1	4,917	5,153	5
M7	1	5,917	6,153	6
M8	1,25	6,647	6,912	6,8
M9	1,25	7,647	7,912	7,8
M10	1,5	8,376	8,676	8,5
M11	1,5	9,376	9,676	9,5

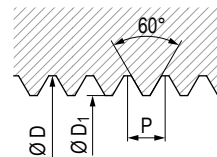
Thread nominal Ø		Ø D ₁		Core hole
D	P	min.	max.	
M12	1,75	10,106	10,441	10,2
M14	2	11,835	12,210	12
M16	2	13,835	14,210	14
M18	2,5	15,294	15,744	15,5
M20	2,5	17,294	17,744	17,5
M22	2,5	19,294	19,744	19,5
M24	3	20,752	21,252	21
M27	3	23,752	24,252	24
M30	3,5	26,211	26,771	26,5
M33	3,5	29,211	29,771	29,5
M36	4	31,67	32,270	32
M39	4	34,67	35,270	35
M42	4,5	37,129	37,799	37,5
M45	4,5	40,129	40,799	40,5
M48	5	42,587	43,297	43
M52	5	46,587	47,297	47
M56	5,5	50,046	50,796	50,5
M60	5,5	54,046	54,796	54,5
M64	6	57,505	58,305	58
M68	6	61,505	62,305	62



MF ISO metric fine threads 6H to DIN 13 and DIN ISO 965-1

Thread nominal Ø			Ø D ₁		Core hole
D	x	P	min.	max.	
M2	x	0,25	1,729	1,774	1,75
M2,2	x	0,25	1,929	1,974	1,95
M2,5	x	0,35	2,121	2,221	2,15
M3	x	0,35	2,621	2,721	2,65
M3,5	x	0,35	3,121	3,221	3,15
M4	x	0,35	3,621	3,721	3,65
M4	x	0,5	3,459	3,599	3,5
M4,5	x	0,5	3,959	4,099	4
M5	x	0,5	4,459	4,599	4,5
M6	x	0,5	5,459	5,599	5,5
M6	x	0,75	5,188	5,378	5,2
M8	x	0,75	7,188	7,378	7,2
M8	x	1,0	6,917	7,153	7
M10	x	0,75	9,188	9,378	9,2
M10	x	1,0	8,917	9,153	9
M10	x	1,25	8,647	8,912	8,8
M12	x	1,0	10,917	11,153	11
M12	x	1,5	10,376	10,676	10,5
M14	x	1,25	12,647	12,912	12,8
M16	x	1,0	14,917	15,153	15
M16	x	1,5	14,376	14,676	14,5

Thread nominal Ø			Ø D ₁		Core hole
D	x	P	min.	max.	
M20	x	1,0	18,917	19,153	19
M20	x	1,5	18,376	18,676	18,5
M20	x	2,0	17,835	18,210	18
M24	x	1,5	22,376	22,676	22,5
M30	x	2,0	27,835	28,210	28
M36	x	1,5	34,376	34,676	34,5
M36	x	3,0	32,752	33,252	33
M42	x	2,0	39,835	40,210	40
M48	x	1,5	46,376	46,676	46,5
M48	x	3,0	44,752	45,252	45
M48	x	4,0	43,67	44,270	44
M56	x	1,5	54,376	54,676	54,5
M56	x	2,0	53,835	54,210	54
M56	x	3,0	52,752	53,252	53
M56	x	4,0	51,670	52,270	52
M64	x	3,0	60,752	61,252	61
M64	x	4,0	59,670	60,270	60
M72	x	4,0	67,670	68,270	68
M80	x	6,0	73,505	74,305	74
M95	x	6,0	88,505	89,305	89
M110	x	6,0	103,505	104,305	104



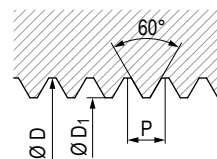
Dimensions in mm; P=pitch

Thread forming pilot hole diameter

M ISO metric coarse threads 6H to DIN 13 and DIN ISO 965-1 (M1-M1.4 = 5H)

Thread nominal Ø		Ø D ₁		Core hole
D	P	min.	max.	
M1	0,25	0,89		0,9
M1,2	0,25	1,09		1,1
M1,4	0,3	1,26		1,28
M1,6	0,35	1,45		1,47
M1,8	0,35	1,65		1,67
M2	0,4	1,83	1,86	1,85
M2,2	0,45	2	2,04	2,03
M2,5	0,45	2,3	2,34	2,33
M3	0,5	2,77	2,82	2,8
M3,5	0,6	3,23	3,28	3,25
M4	0,7	3,68	3,73	3,7
M4,5	0,75	4,15	4,21	4,2
M5	0,8	4,63	4,68	4,65

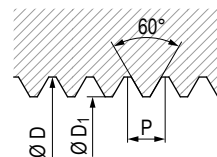
Thread nominal Ø		Ø D ₁		Core hole
D	P	min.	max.	
M6	1	5,51	5,59	5,6
M7	1	6,51	6,59	6,6
M8	1,25	7,39	7,48	7,45
M9	1,25	8,39	8,48	8,45
M10	1,5	9,25	9,35	9,35
M11	1,5	10,25	10,35	10,35
M12	1,75	11,12	11,25	11,25
M14	2	13	13,15	13,1
M16	2	15	15,15	15,1
M18	2,5	16,72	16,9	16,85
M20	2,5	18,72	18,9	18,85
M22	2,5	20,72	20,9	20,85
M24	3	22,46	22,7	22,65



MF ISO metric fine threads 6H to DIN 13 and DIN ISO 965-1

Thread nominal Ø			Ø D ₁		Core hole
D	x	P	min.	max.	
M2	x	0,25	1,89		1,9
M2,2	x	0,25	2,09		2,1
M2,5	x	0,25	2,39		2,4
M2,5	x	0,35	2,35		2,37
M3	x	0,25	2,89		2,9
M3	x	0,35	2,85		2,88
M3,5	x	0,35	3,35		3,38
M3,5	x	0,5	3,27	3,32	3,3
M4	x	0,35	3,85		3,88
M4	x	0,5	3,77	3,82	3,8
M4,5	x	0,5	4,27	4,32	4,3
M5	x	0,5	4,77	4,82	4,8
M5	x	0,75	4,65	4,71	4,7
M5,5	x	0,5	5,27	5,32	5,3
M6	x	0,5	5,78	5,83	5,8
M6	x	0,75	5,65	5,71	5,7
M7	x	0,5	6,78	6,83	6,8
M7	x	0,75	6,65	6,71	6,7
M8	x	0,5	7,78	7,83	7,8
M8	x	0,75	7,65	7,71	7,7
M8	x	1,0	7,51	7,59	7,6
M9	x	0,5	8,78	8,83	8,8
M9	x	0,75	8,65	8,71	8,7
M9	x	1,0	8,51	8,59	8,6
M10	x	0,5	9,78	9,83	9,8
M10	x	0,75	9,65	9,71	9,7
M10	x	1,0	9,51	9,59	9,6
M10	x	1,25	9,39	9,48	9,45
M11	x	0,75	10,65	10,71	10,7
M11	x	1,0	10,51	10,59	10,6
M12	x	0,75	11,66	11,72	11,7

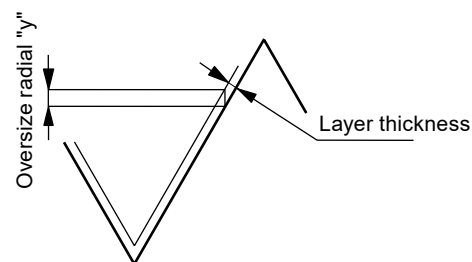
Thread nominal Ø			Ø D ₁		Core hole
D	x	P	min.	max.	
M12	x	1,0	11,52	11,6	11,6
M12	x	1,25	11,4	11,49	11,45
M12	x	1,5	11,26	11,36	11,35
M13	x	0,75	12,66	12,72	12,7
M13	x	1,0	12,52	12,6	12,6
M13	x	1,5	12,26	12,36	12,35
M14	x	0,75	13,66	13,72	13,7
M14	x	1,0	13,52	13,6	13,6
M14	x	1,25	13,4	13,49	13,45
M14	x	1,5	13,26	13,36	13,35
M15	x	0,75	14,66	14,72	14,7
M15	x	1,0	14,52	14,6	14,6
M15	x	1,5	14,26	14,36	14,35
M16	x	0,75	15,66	15,72	15,7
M16	x	1,0	15,52	15,6	15,6
M16	x	1,5	15,26	15,36	15,35
M18	x	1,0	17,52	17,6	17,6
M18	x	1,5	17,26	17,36	17,35
M18	x	2,0	17	17,15	17,1
M20	x	1,0	19,52	19,6	19,6
M20	x	1,5	19,26	19,36	19,35
M20	x	2,0	19	19,15	19,1
M22	x	1,5	21,26	21,36	21,35
M22	x	2,0	21	21,15	21,1
M24	x	1,5	23,26	23,38	23,35
M24	x	2,0	23,01	23,16	23,1
M25	x	1,5	24,26	24,38	24,35
M26	x	1,5	25,26	25,38	25,35
M27	x	2,0	26,01	26,16	26,1
M28	x	1,5	27,26	27,38	27,35
M30	x	1,5	29,26	29,38	29,35
M30	x	2,0	29,01	29,16	29,1



Dimensions in mm; P=pitch

Figure 1: Tolerances of internal threads. The chart shows tolerance zones for internal threads in μm . It is divided into three sections: "Internal thread "H" tolerance", "Tap tolerance", and "Internal thread "G" tolerance". The y-axis represents tolerance in μm , ranging from 0 to +280. The x-axis represents the tolerance zone for different thread classes. The chart includes various ISO standards (ISO 1, ISO 2, ISO 3, ISO 1X, ISO 2X, ISO 3X) and tolerance grades (4H, 5H, 6H, 7H, 7GX, 7G, 4G, 5G, 6G, 7G). A vertical arrow on the left indicates the tolerance zone for a specific thread ($t = T_{D2(5)}$). A small diagram on the right shows a cross-section of a thread with a tolerance zone.

$\text{Oversize} = 7.727 \times \text{layer thickness}$



Application class of the tap Designation according to		Tolerance class of the internal thread to be cut				
DIN	ISO					
4H	ISO1	4H	5H	–	–	–
6H	ISO2	4G	5G	6H	–	–
6G	ISO3	–	(4E)	6G	7H	8H
7G	–	–	–	(6F)	7G	8G



For special applications, e.g., abrasive cast iron materials or plastics, other dimensions must be chosen that are determined based on previous experience. In such cases, an "X" is added to the short designation of the tolerance class, e.g., ISO 2X, whereby the tolerance field assignment to the internal thread may be limited (6HX for tolerance field 6H and 5G). In addition, it must be taken into account that the dimensions of the cut internal thread not only depend on the dimensions of the tap, but also on the material to be machined and all production conditions. No thread dimensions are determined for taper and intermediate taps.

Thread formers

DuoForm thread former for cold-forming materials up to 1400 N/mm² or at least 5% elongation at break. The thread is produced through plastic deformation. This results in a formed thread with very high tensile strength.



Important

Before forming a thread, it is necessary to ensure that the client consents to a formed thread. In certain industries, thread forming is **isnot**permitted.

Dirt or bacteria can settle in the formed crest.

Incremental pressure forming



Workpiece



Thread formers



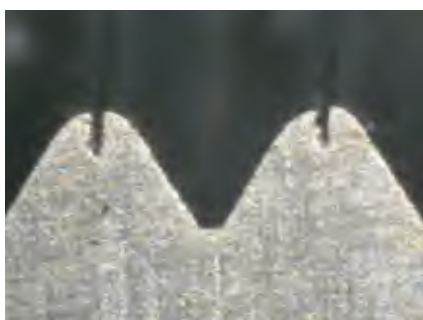
The thread profile is pressed incrementally into the material via the lead (cut) of the tap.

Characteristics

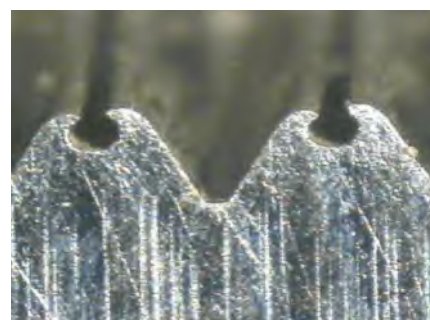
- ▲ One type can be used in different materials
- ▲ For through hole and blind hole thread
- ▲ Excellent thread surface quality
- ▲ High static and dynamic thread strength
- ▲ Secure machining of deep and deep-set threads
- ▲ Short machining times
- ▲ No chip problems
- ▲ No cutting
- ▲ High process security
- ▲ HSS-E and HSS-PM cutting material up to approximately 33 HRC with material elongation at break of at least 5%.



Underformed – core hole too large



Overformed – core hole too small



Perfectly formed – core hole correct

Troubleshooting

Poor tool life

Causes

- ▲ Overload fractures of the cutting edges on the lead
- ▲ Hardness or tool material not suitable for the application
- ▲ Pilot hole too small or work hardened
- ▲ Insufficient lubrication or incorrect application parameters

Corrective measures

- ▲ A longer lead or more flutes for the same lead length, giving a greater number of cutting teeth
- ▲ In reground tools, the hardness can be reduced; apply correct parameters for regrinding
- ▲ Increase frequency of changes or regrinding of the drilling tool
- ▲ Use the correct application parameters for the drilling tool
- ▲ Select the correct lubricant and ensure adequate supply

Axial thread error

Causes

- ▲ Selected cutting edge geometry is not suitable
- ▲ Spindle speed does not match feed (synchronization error)
- ▲ Blind hole taps are used with a feed pressure that is too high
- ▲ Through hole taps are used with a feed pressure that is too low

Corrective measures

- ▲ Check programming or master cartridge or other synchronized encoders
- ▲ Use a tapping chuck with length compensation
- ▲ Reduce feed pressure
- ▲ Increase feed pressure

Oversize thread

Causes

- ▲ Thread tolerances of tool and thread gage do not match
- ▲ Burred tool edges after regrinding
- ▲ Cold pressure welding

Corrective measures

- ▲ Use correct tolerances for tool and thread gage
- ▲ Carefully deburr
- ▲ Use appropriate (positive) geometry
- ▲ Reduce cutting speed
- ▲ Use a different surface treatment or coating
- ▲ Use a tapping chuck with length compensation
- ▲ Use appropriate lubricant

Tool breakage

Causes

- ▲ Tool is worn
- ▲ Tool has hit the bottom of the hole
- ▲ Weld deposits
- ▲ Pilot hole too small
- ▲ Chip trapping
- ▲ Incorrect cutting speed
- ▲ Chip jams in the flute
- ▲ Insufficient coolant/lubrication

Corrective measures

- ▲ Use set taps
- ▲ Use a tool with a lower helix angle
- ▲ Use tools with a shorter/longer lead
- ▲ Check the predrilling depth and thread depth
- ▲ Drill pilot hole deeper
- ▲ Correct the cutting speed
- ▲ Use a different coating or surface treatment
- ▲ Use an adapter with length compensation
- ▲ Use suitable lubricant
- ▲ Use the correct pilot hole diameter
- ▲ Change geometry and/or flute type
- ▲ Note chip shape and chip formation

Coatings

vap.

- ▲ Vaporized
- ▲ Vaporizing (steam tempering) prevents cold welding forming on the tool and increases surface hardness and therefore also wear resistance

Ti200

- ▲ TiN coating
- ▲ Well suited for high cutting speeds during thread forming
- ▲ Maximum application temperature: 450°C or 842°F

nitr.

- ▲ Nitrided
- ▲ Nitriding increases wear resistance and gives the material good anti-friction properties

OSM

- ▲ Carbide and anti-friction layer
- ▲ For use with high-tensile steels

vap.
+
nitr.

- ▲ Vaporized + nitrided
- ▲ Combination of increased surface hardness and lubricant carrier

CH

- ▲ Amorphous carbon layer
- ▲ For use with non-ferrous metals and aluminum
- ▲ Reduces material adhesion

TiN

- ▲ TiN coating
- ▲ Maximum application temperature: 450°C or 842°F

HCr

- ▲ Hard chrome plating
- ▲ For use with non-ferrous metals and aluminum
- ▲ Very low surface roughness

TiN
GS

- ▲ Titanium nitride anti-friction layer
- ▲ High wear resistance with good anti-friction properties
- ▲ Maximum application temperature: 450°C or 842°F

CrN

- ▲ Chromium-nitrogen coating
- ▲ Highly wear-resistant coating
- ▲ Specifically for use in aluminum, but also suitable for P, M, and S materials

TiCN

- ▲ TiCN multilayer coating
- ▲ Maximum application temperature: 450°C or 842°F

AlTiN-
HD

- ▲ AlTiN-based nanolayer hard material coating
- ▲ Maximum application temperature: 500°C or 932°F

DLC

- ▲ Diamond-like carbon coating
- ▲ Specifically for machining non-ferrous metals
- ▲ Maximum application temperature: 400°C or 752°F



Circular and Thread Milling



Contents

- Explanation of symbols
- Overview of circular and thread milling cutters
- Tool types
- Thread types
- Thread milling process description
- Drill thread milling process description
- Toolfinder – solid carbide and PCD thread milling cutters
- Toolfinder – solid carbide drill thread milling cutters and circular milling cutters
- Toolfinder – Thread milling cutters with indexable carbide inserts
- Toolfinder – modular circular milling tools with carbide indexable inserts
- Product program
- Cutting data
 - Technical information
- Milling processes (climb milling and conventional milling)
- Calculation of cutting data for thread milling
- Coatings

Explanation of symbols

	→ Thread types
	Flank angle 60°
	No drilling required
	Internal R/L
	External R/L
	Internal/external R/L
	Circlip grooves
	Full radius slot milling
	Slot milling
	Multipurpose milling
	Chamfering and deburring



	→ Tool types
	Central through coolant
	Radial through coolant
	Coolant supply either via the flange or centrally
	Plain cylindrical shank
	Cylindrical shank with "Weldon" lateral driving face
	Left-hand cutting

● = Main application
 ○ = Secondary application

Overview of circular and thread milling cutters

Modular circular milling cutters with carbide indexable inserts

- ▲ The perfect tool for every application
- ▲ Various holders, depending on overhang
- ▲ The same threading insert for different pitches and diameters
- ▲ Highest flexibility and stability
- ▲ In addition to circular thread milling, circular and linear milling operations can also be performed.



First choice for small batch sizes and large threads

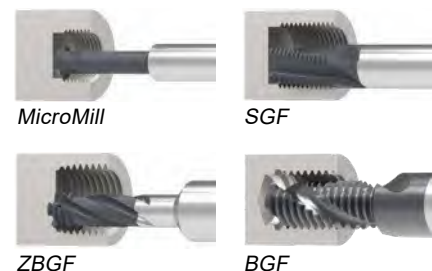
Thread milling cutters with indexable carbide inserts

- ▲ Insert can be changed for different threads
- ▲ The same threading insert for different diameters



Solid carbide thread milling cutters

- ▲ Short machining times, ideal for volume production
- ▲ One tool for all thread types
- ▲ One thread milling cutter for different diameters with the same pitch



Tool types

SGF	Shank thread milling cutter	HR	Single-row shank thread milling cutter	EAW	Single-row thread milling cutter with carbide indexable inserts and Weldon flat
ZSGF	Circular shank thread milling cutter	Micro Mill	Solid carbide circular milling cutter	EWM	Single-row thread milling cutter with carbide indexable insert
SFSE	Shank thread milling cutter with chamfer facet	MWN	Multi-tooth thread milling cutter with carbide indexable inserts (straight insert seat) and Weldon flat	Mini Mill	Circular milling cutter with solid carbide milling insert (with three-rib insert connection)
SFSE Micro	Thread milling cutter for the smallest threads	GZD	Multi-tooth thread milling cutter with carbide indexable inserts (angled insert seat) and Weldon flat	Polygon	Circular shank milling cutter with carbide indexable insert (polygon insert seat)
BGF	Solid carbide drill thread milling cutter	GZG	Multi-tooth thread milling cutter with carbide indexable inserts (straight insert seat) and Weldon flat	System 300	Circular milling cutter with solid carbide milling insert
ZBGF	Solid carbide circular drill thread milling cutter				

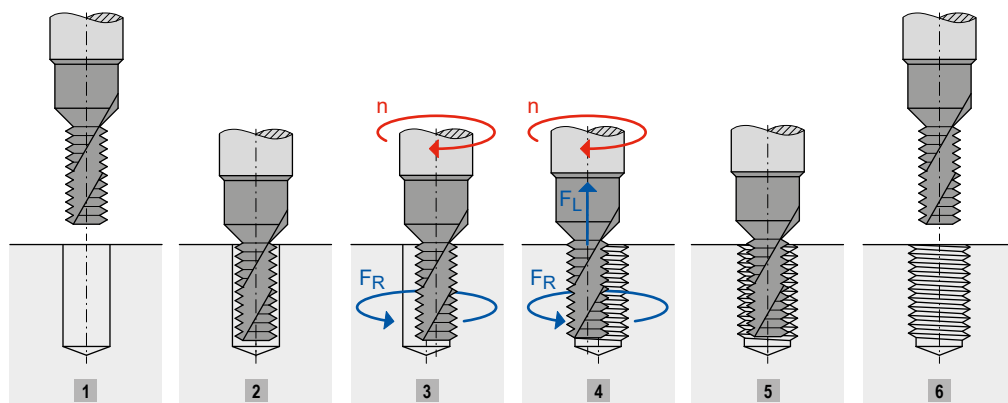
Thread types

M	ISO metric coarse thread	UNC	Unified standard thread	BSW	Whitworth thread
MF	ISO metric fine thread	UNF	Unified fine thread	BSF	Whitworth fine thread
G	Whitworth pipe thread	UNJC	Unified coarse thread ASME B1.15 and ISO 3161	NPT	American taper pipe thread
UN	Unified thread	UNJF	Unified extra fine thread ASME B1.15 and ISO 3161	Pg	Steel conduit thread
				Tr	Trapezoidal thread

Thread milling process description

Cutting thread production by circular milling in the pitch (helical interpolation) with lower torque than taps and thread formers (no reversing of the spindle necessary). Thread machining to the bottom of the hole possible and high-speed cutting (HSC) can be performed.

Thread milling



Climb milling is shown here.

→ Here you will find further information on the milling processes (climb and conventional milling).

Advantages of thread milling

- ▲ Different tolerances can be produced with one tool
- ▲ One tool for blind hole and through hole machining
- ▲ Outstanding workpiece surfaces and dimensional accuracy guaranteed
- ▲ One tool for right and left-hand threads
- ▲ Low cutting pressure when machining thin-walled parts
- ▲ Precisely repeatable thread depth
- ▲ No chip issues and no chip root residues in the finished thread

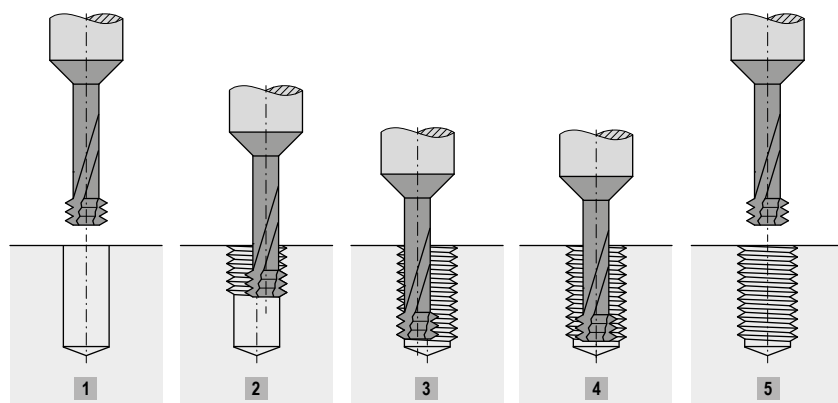
Added advantages of thread milling cutters with chamfer facet

- ▲ Savings in tool change and setup times, resulting in significantly shorter machining times
- ▲ Optimization of magazine assignment in the machine

Process

- 1 Positioning above the bore
- 2 Entry to start position for thread milling
- 3 Circular approach (milling) in inward circular grinding (90°/180°) at 1/4 pitch
- 4 1× pitch in "Z+" direction
- 5 Outward circular grinding in the center of the hole (90°/180°)
- 6 Exit to start position

Circular thread milling



Advantages

- ▲ Different tolerances can be produced with one tool
- ▲ Outstanding workpiece surfaces and dimensional accuracy guaranteed
- ▲ One tool for blind hole and through hole machining
- ▲ Precisely repeatable thread depth
- ▲ Optimum chip removal and no chip root residues in the finished thread

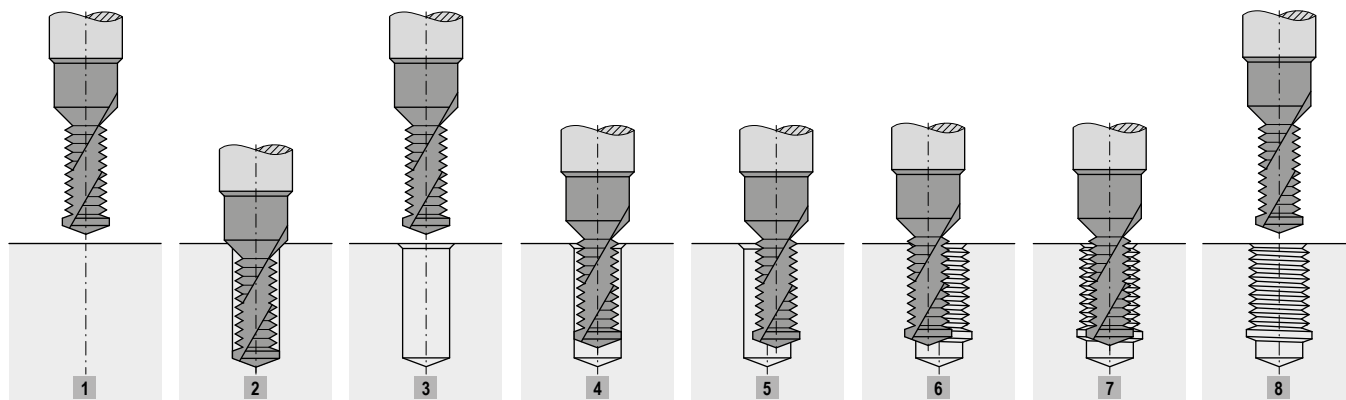
Process

- 1 Positioning above the bore
- 2 Circular drill thread milling in helical motion to the required thread depth
- 3 Outward circular grinding in the center of the hole (90°/180°)
- 4 Exit to start position

Drill thread milling process description

Cutting production of a complete thread - drilling, countersinking, and thread milling with just one tool. Prerequisite: CNC-controlled milling machine or machining center with the helical interpolation function.

Drill thread milling



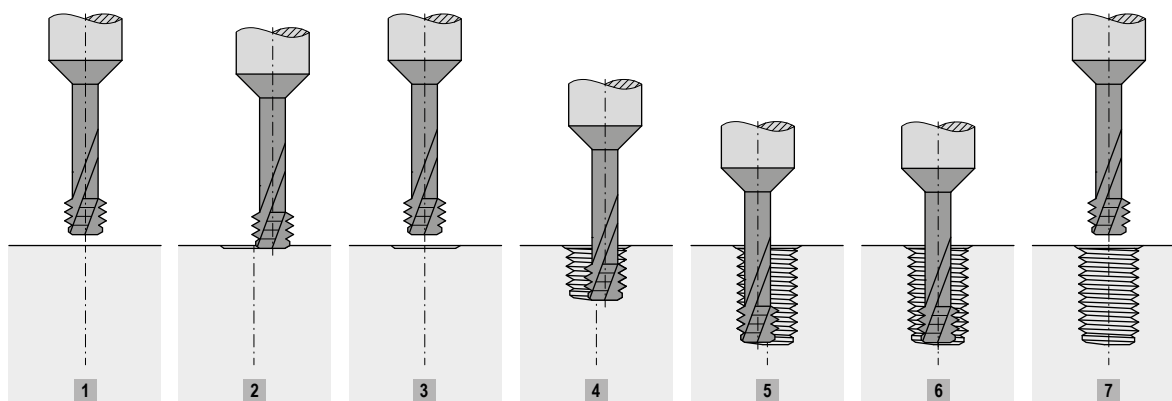
Advantages

- ▲ Shortest machining times thanks to high cutting speeds and feeds
- ▲ Savings in tool change and setup times, resulting in significantly shorter machining times
- ▲ Optimization of magazine assignment in the machine
- ▲ Different tolerances can be produced with one tool
- ▲ Outstanding workpiece surfaces and dimensional accuracy guaranteed
- ▲ One tool for blind hole and through hole machining
- ▲ Precisely repeatable thread depth
- ▲ No chip issues and no chip root residues in the finished thread
- ▲ High-speed cutting (HSC) can be performed

Process

- 1 Positioning above the workpiece
- 2 Tapping, drilling, countersinking
- 3 Chip removal
- 4 Entry to start position for thread milling
- 5 Circular approach (milling) in inward circular grinding (90°/180°) at 1/4 pitch
- 6 1× pitch in "Z+" direction
- 7 Outward circular grinding in the center of the hole (90°/180°)
- 8 Exit to start position

Circular drill thread milling



Advantages

- ▲ Shortest machining times due to simultaneous creation of the tap hole and thread
- ▲ Savings in tool change and setup times, resulting in significantly shorter machining times
- ▲ Optimization of magazine assignment in the machine
- ▲ Different tolerances can be produced with one tool
- ▲ Outstanding workpiece surfaces and dimensional accuracy guaranteed
- ▲ One tool for blind hole and through hole machining
- ▲ Precisely repeatable thread depth
- ▲ Optimum chip removal and no chip root residues in the finished thread

Process

- 1 Positioning above the workpiece
- 2 Chamfering (until countersinking depth is reached)
- 3 Return to the start position above the component
- 4 Circular drill thread milling in helical motion to the required thread depth
- 5 Outward circular grinding in the center of the hole (90°/180°)
- 6 Exit to start position

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Toolfinder – solid carbide drill thread milling cutters and circular milling cutters

Drill thread milling		M				MF	EG M
							
BGF		▲ Drill thread milling cutter ▲ Core hole, countersink, thread, and thread undercut with one tool					
		≤ 1,5×D	≤ 2×D	≤ 2,5×D	≤ 3×D	≤ 2×D	≤ 2×D
High Performance Cutting HPC – ZEFP 3		→	→	→			
For aluminum		→	→	→		→	
		→		→			→
For cast iron materials		→	→	→		→	
Specially designed for cast iron materials (GJS)		→					
Specially designed for gray cast iron (GJL)			→	→			
				→			
Specially designed for cast aluminum alloy with Si < 10%					→		
					→		

Circular drill thread milling		M
		
ZBGF		▲ Circular drill thread milling cutter ▲ Core hole, countersink, and thread with one tool
		≤ 2×D
45-65 HRC		→

Circular thread milling		M	Partial profile	Slot milling	Chamfering and deburring
					
Micro Mill		▲ Solid carbide circular milling cutter for smallest diameters			
Universal for almost all materials		→	→	→	→

Toolfinder – Thread milling cutters with indexable carbide inserts

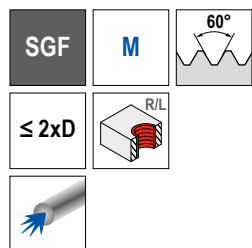
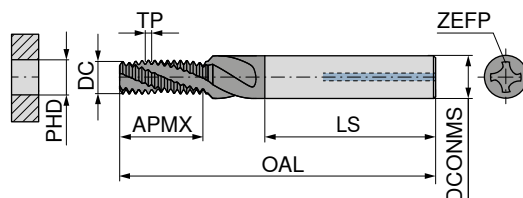
Thread milling		M 60°	MF 60°	G 55°	UN 60°	Pg 80°	NPT 60°
MWN 		▲ Multi-tooth thread milling cutter ▲ Double-sided inserts ▲ Exclusively for thread production ▲ Holder for tapered threads					
	Thread milling inserts	→	→	→	→	→	→
	Holders	→					→
GZD 		▲ Multi-tooth drilling and thread milling cutter ▲ For thread milling in solid material ▲ Core hole and thread with one tool					
	Thread milling inserts	→	→	→			
	Holders	→					
GZG 		▲ Multi-tooth thread milling cutter ▲ Exclusively for thread production					
	Thread milling inserts	→	→	→	→	→	
	Holders	→					
EAW 		▲ Single-row thread milling cutter ▲ Inserts with 2 or 4 cutting edges ▲ Exclusively for thread production ▲ Insert holder with cylindrical shank DIN 1835					
	Thread milling inserts	→		→	→		
	Holders	→					
EWM 		▲ Single-row thread milling cutter ▲ Inserts with 4 cutting edges ▲ Exclusively for thread production ▲ Monoblock insert holder with steep taper DIN 69871					
	Thread milling inserts	→			→		
	Holders	→					

Toolfinder – modular circular milling tools with carbide indexable inserts

Circular milling		M	MF	G	BSW	BSF	UNC	UNF	Tr					
<div> <div>Mini Mill</div>  </div> <ul style="list-style-type: none"> ▲ Three-rib insert connection ▲ Compatible with popular manufacturer systems ▲ 3 and 6-edged inserts ▲ Stable holders made from solid carbide and steel 		60°	60°	55°	55°	55°	60°	60°	30°					
Thread milling insert – Full profile		→		→										
Thread milling insert – Partial profile 60°						→								
Milling insert for circlip grooves										→				
Milling insert for groove milling											→			
Milling insert for groove milling (specialist for aluminum)											→			
Milling insert for groove milling, cross-pitched											→			
Milling insert for groove milling with full radius												→		
Milling insert for groove milling and chamfering													→	
Milling insert for slot and multipurpose milling														→
Milling insert for part-off														→
Circular milling cutter, extra short											→			
Circular milling cutter, short												→		
Circular milling cutter, vibration-damped												→		
Circular milling cutters											→			
<div> <div>Polygon</div>  </div> <ul style="list-style-type: none"> ▲ High power transmission through polygon connection ▲ 3 and 6-edged inserts ▲ Stable holders made from solid carbide and steel 														
Thread milling insert – Full profile		→		→	→	→	→	→	→					
Thread milling insert – Partial profile 60°						→								
Milling insert for circlip grooves without chamfer										→				
Milling insert for circlip grooves with chamfer										→				
Milling insert without profile											→			
NOF 3											→			
NOF 6											→			
Milling insert for radius milling												→		
Milling insert for chamfering and deburring													→	
Milling insert for part-off														→
Circular milling cutters												→		
Circular screw-in milling cutter												→		
<div> <div>System 300</div>  </div> <ul style="list-style-type: none"> ▲ Proven circular milling tool ▲ 3-edged inserts 														
Thread milling insert – Full profile		→	→	→	→	→								
Thread milling insert – Partial profile 60°						→								
Milling insert for circlip grooves without chamfer										→				
Milling insert for circlip grooves with chamfer										→				
Milling insert without profile											→			
Milling insert for chamfering and deburring													→	
Circular milling cutters											→			

CoreLine – Shank thread milling cutter – SGF

- ▲ Profile-corrected
▲ Performance cutting



AlTiN



Solid carbide

DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	ZEFP	PHD mm
2.44	M3	0.50	42	6.24	36	4	3	2.5
3.14	M4	0.70	49	8.00	36	6	3	3.3
3.95	M5	0.80	55	10.00	36	6	3	4.2
4.68	M6	1.00	55	12.47	36	6	4	5.0
6.22	M8	1.25	62	16.83	36	8	4	6.8
7.79	M10	1.50	74	20.20	40	10	4	8.5
9.38	M12	1.75	79	25.32	45	12	5	10.2
10.92	M14	2.00	89	28.93	45	14	5	12.0
12.83	M16	2.00	102	32.94	48	16	5	14.0
13.93	M18	2.50	102	36.17	48	16	5	15.5
15.83	M20	2.50	110	41.17	50	20	5	17.5

CS

50 531 ...

03000 ¹⁾

04000

05000

06000

08000

10000

12000

14000

16000

18000

20000

P	●
M	●
K	●
N	●
S	●
H	●
O	●

1) Without through coolant supply



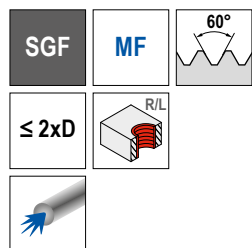
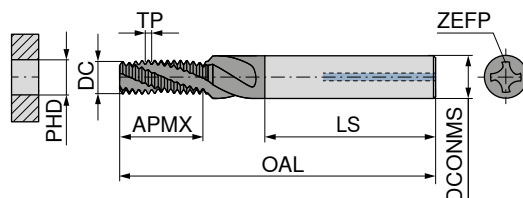
- Find the cutting data standard values here.
→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_r or center path feed v_{fm} .

CoreLine – Shank thread milling cutter – SGF

- ▲ Profile-corrected
▲ Performance cutting



AlTiN



Solid carbide

DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	ZEFP	PHD mm
3.14	M4x0,5	0.50	49	8.00	36	6	3	3.5
3.95	M5x0,5	0.50	55	10.00	36	6	3	4.5
4.68	M6x0,75	0.75	55	12.34	36	6	4	5.2
6.22	M8x0,75	0.75	62	16.09	36	8	4	7.2
6.22	M8x1	1.00	62	16.46	36	8	4	7.0
7.79	M10x1	1.00	74	20.46	40	10	4	9.0
9.38	M12x1	1.00	79	24.45	45	12	5	11.0
9.38	M12x1,5	1.50	79	24.69	45	12	5	10.5
10.92	M14x1,5	1.50	89	29.19	45	14	5	12.5
12.82	M16x1,5	1.50	102	32.19	48	16	5	14.5
13.93	M18x1,5	1.50	102	36.68	48	16	5	16.5
15.83	M20x1,5	1.50	110	41.18	50	20	5	18.5

CS

50 532 ...

04000
05000
06100
08100
08200
10200
12200
12400
14400
16400
18400
20400

P	●
M	●
K	●
N	●
S	●
H	●
O	●



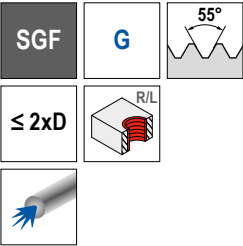
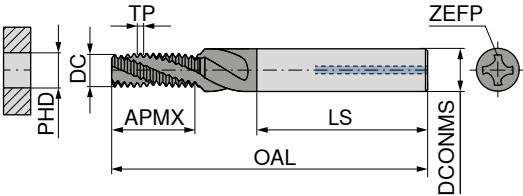
- Find the cutting data standard values here.
→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_r or center path feed v_{fm} .

CoreLine – Shank thread milling cutter – SGF

- ▲ Profile-corrected
- ▲ Performance cutting



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{n6} mm	ZEFP	PHD mm
7.79	G 1/8-28	0.907	74	20.35	40	10	4	8.80
10.92	G 1/4-19	1.337	89	27.34	45	14	5	11.80
13.92	G 3/8-19	1.337	102	35.36	48	16	5	15.25
15.90	G 1-11	2.309	102	33.29	48	16	5	30.75
15.98	G 1/2-14	1.814	110	42.51	50	20	5	19.00

CS
50 530 ...
01800
01400
03800
10000
01200

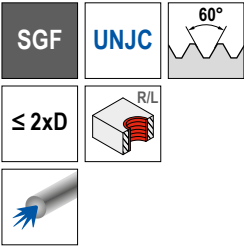
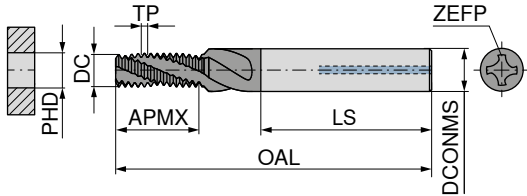
P	●
M	●
K	●
N	●
S	●
H	●
O	●

- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Thread milling cutters – SGF

- ▲ Profile-corrected
- ▲ Performance Cutting



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	ZEFP	PHD mm
4.70	UNJC 1/4-20	0.907	55	14.27	36	6	4	5.6
6.22	UNJC 5/16-18	1.411	62	16.32	36	8	4	7.0
7.79	UNJC 3/8-16	1.588	74	20.01	40	10	4	8.6
8.57	UNJC 7/16-14	1.814	79	22.87	45	12	4	10.0
9.38	UNJC 1/2-13	1.270	79	26.75	45	12	5	11.5

CS
50 524 ...
01400
05160
03800
07160
01200

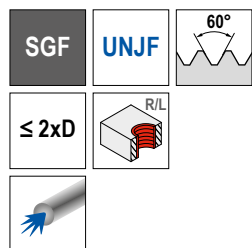
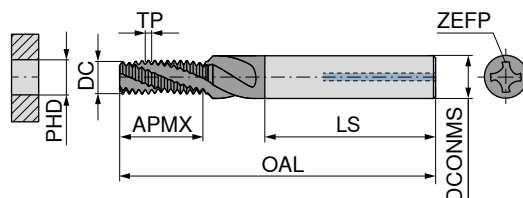
P	●
M	●
K	●
N	●
S	●
H	
O	●

- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Shank thread milling cutter – SGF

- ▲ Profile-corrected
▲ Performance cutting



AlTiN



Solid carbide

DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	ZEFP	PHD mm
2.44	UNJF 6-40	0.635	42	7.42	28	4	3	2.95
3.14	UNJF 8-36	0.706	49	8.91	36	6	3	3.50
3.95	UNJF 10-32	0.794	55	9.97	36	6	3	4.10
4.70	UNJF 1/4-28	0.907	55	14.27	36	6	4	5.60
6.22	UNJF 5/16-24	1.058	62	16.59	36	8	4	7.00
7.79	UNJF 3/8-24	1.058	74	19.77	40	10	4	8.60
9.32	UNJF 7/16-20	1.270	79	22.39	45	12	5	10.00
9.38	UNJF 1/2-20	1.270	79	25.34	45	12	5	11.50
12.90	UNJF 5/8-18	1.411	102	33.59	48	16	5	14.50

CS

50 533 ...

06000

08000

10000

01400

05160

03800

07160

01200

05800

P	●
M	●
K	●
N	●
S	●
H	●
O	●



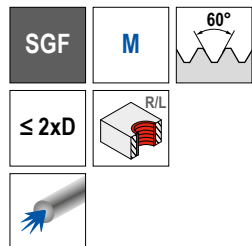
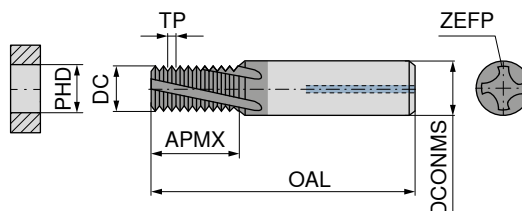
- Find the cutting data standard values here.
→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_r or center path feed v_{fm} .

CoreLine – Shank thread milling cutter – SGF

- ▲ Profile-corrected
- ▲ Available on request: M30, M36, M42, M48, M56, M64
- ▲ Standard Cutting



DC mm	Thread	TP mm	OAL mm	APMX mm	DCONMS _{h6} mm	ZEFP	PHD mm
2.40	M3	0.50	42	7.0	4	2	2.50
3.15	M4	0.70	55	10.0	6	3	3.30
4.00	M5	0.80	55	12.2	6	3	4.20
4.80	M6	1.00	55	14.3	6	3	5.00
6.00	M8	1.25	60	19.0	6	3	6.75
8.00	M10	1.50	70	23.0	8	3	8.50
9.90	M12	1.75	75	28.6	10	4	10.25
11.60	M14	2.00	85	32.6	12	4	12.00
12.00	M16	2.00	85	36.6	12	4	14.00
14.00	M18	2.50	90	43.3	14	4	15.50
14.00	M22	2.50	95	44.0	14	4	19.50
16.00	M20	2.50	90	43.3	16	4	17.50

CX	CS
54 821 ...	50 825 ...
03000 ¹⁾	
04000 ²⁾	
05000 ²⁾	
06000 ²⁾	
08000	
10000	
12000	
14000	
16000	
18000	
20000	220

P	●	●
M	●	●
K	●	●
N	●	●
S	●	●
H	○	●
O	●	●

- 1) DIN 6535 HA shank/without through coolant supply
- 2) Without through coolant supply



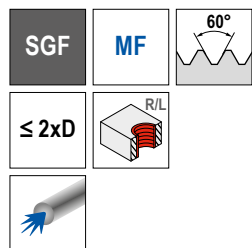
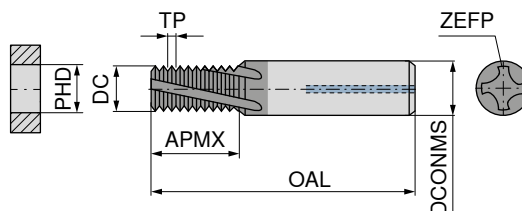
- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_r or center path feed v_{fm} .

CoreLine – Shank thread milling cutter – SGF

- ▲ Profile-corrected
- ▲ Available on request: M30, M36, M42, M48, M56, M64
- ▲ Standard Cutting



DC mm	Thread	TP mm	OAL mm	APMX mm	DCONMS _{h6} mm	ZEFP	PHD mm
4.0	M 5x0,5	0.50	55	11.6	6	3	4.50
4.8	M 6x0,75	0.75	55	14.5	6	3	5.25
6.0	M 8x1	1.00	60	19.3	6	3	7.00
8.0	M 10x1,25	1.25	70	21.6	8	3	8.75
9.9	M 12x1	1.00	75	27.3	10	4	11.00
9.9	M 12x1,25	1.25	75	27.9	10	4	10.75
9.9	M 12x1,5	1.50	75	27.5	10	4	10.50
11.6	M 14x1	1.00	85	31.3	12	4	13.00
11.6	M 14x1,5	1.50	85	32.0	12	4	12.50
12.0	M 16x1,5	1.50	85	35.0	12	4	14.50
14.0	M 18x1,5	1.50	90	42.5	14	4	16.50
14.0	M22x1,5	1.50	95	44.0	14	4	20.50
16.0	M 20x1,5	1.50	90	42.5	16	4	18.50
16.0	M24x1,5	1.50	90	36.0	16	5	22.50

CX	CS
54 822 ...	50 826 ...
05000 ¹⁾	
06000 ¹⁾	
08000	
10000	
12000	
12100	
12200	
14000	
14100	
16000	
18000	
20000	224
	244

P	●	●
M	●	●
K	●	●
N	●	●
S	●	●
H	○	
O	●	●

1) DIN 6535 HA shank/without through coolant supply



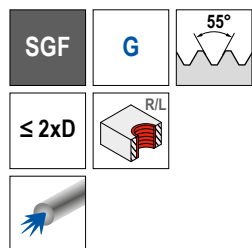
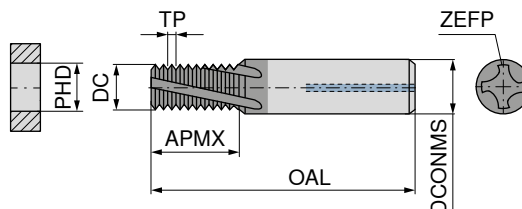
- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Shank thread milling cutter – SGF

- ▲ Profile-corrected
▲ Standard Cutting



DC mm	Thread	TP mm	OAL mm	APMX mm	DCONMS _{h6} mm	ZEFP	PHD mm
8.0	G 1/8-28	0.907	70	22.0	8	3	8.80
9.9	G 1/4-19	1.337	75	28.5	10	4	11.80
14.0	G 3/8-19	1.337	90	42.0	14	4	15.25
16.0	G 1/2-14	1.814	90	44.0	16	4	19.00
16.0	G 3/4-14	1.814	90	34.0	16	5	24.50
16.0	G 5/8-14	1.814	90	34.0	16	5	21.00

CX	CS
54 823 ...	50 827 ...
01800	
01400	
03800	
01200	
	034
	058

P	●	●
M	●	●
K	●	●
N	●	●
S	●	●
H	○	
O	●	●



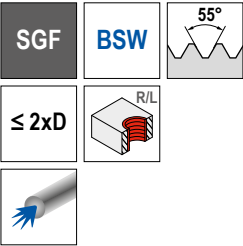
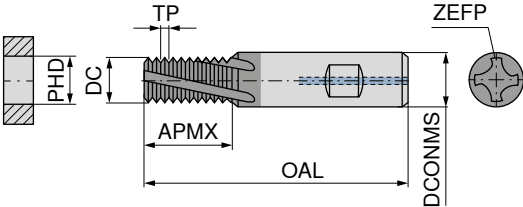
- Find the cutting data standard values here.
→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Shank thread milling cutter – SGF

- ▲ Profile-corrected
- ▲ Standard cutting



DC mm	Thread	TP mm	OAL mm	APMX mm	DCONMS _{h6} mm	ZEFP	PHD mm
6.0	BSW 5/16 - 18	1.411	60	20.0	6	3	6.50
6.0	BSW 3/8 - 16	1.588	60	21.0	6	3	7.90
8.0	BSW 7/16 - 14	1.814	70	24.0	8	3	9.25
8.0	BSW 1/2 - 12	2.117	70	24.0	8	3	10.50
9.9	BSW 5/8 - 11	2.309	75	30.5	10	4	13.50

CX
54 824 ...
51600
03800
71600
01200
05800

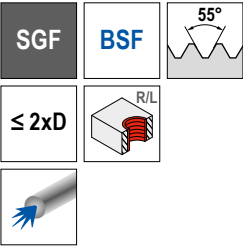
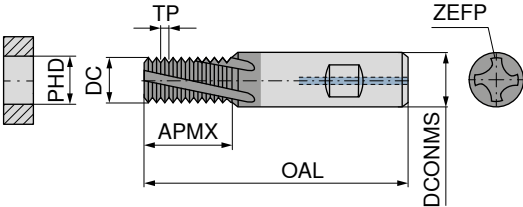
P	●
M	●
K	●
N	●
S	●
H	○
O	●

- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Shank thread milling cutter – SGF

- ▲ Profile-corrected
- ▲ Standard cutting



DC mm	Thread	TP mm	OAL mm	APMX mm	DCONMS _{h6} mm	ZEFP	PHD mm
6.0	BSF 5/16 - 22	1.155	60	20.0	6	3	6.8
6.0	BSF 3/8 - 20	1.270	60	19.4	6	3	8.3
8.0	BSF 7/16 - 18	1.411	70	23.0	8	3	9.7
8.0	BSF 1/2 - 16	1.588	70	24.2	8	3	11.1
9.9	BSF 5/8 - 14	1.814	75	29.5	10	4	14.0

CX
54 825 ...
51600
03800
71600
01200
05800

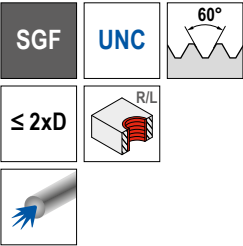
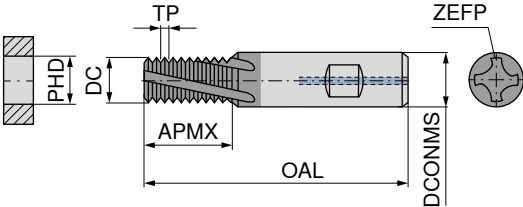
P	●
M	●
K	●
N	●
S	●
H	○
O	●

- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Shank thread milling cutter – SGF

- ▲ Profile-corrected
- ▲ Standard cutting



DC mm	Thread	TP mm	OAL mm	APMX mm	DCONMS _{h6} mm	ZEFP	PHD mm
4.80	UNC 1/4-20	1.270	55	14.4	6	3	5.1
6.00	UNC 5/16-18	1.411	60	20.2	6	3	6.6
7.60	UNC 3/8-16	1.588	70	24.3	8	3	8.0
7.95	UNC 7/16-14	1.814	70	24.0	8	3	9.4
9.90	UNC 1/2-13	1.954	75	29.0	10	4	10.8

CX
54 826 ...
01400 ¹⁾
51600
03800
71600
01200

P	●
M	●
K	●
N	●
S	●
H	○
O	●

1) DIN 6535 HA shank/without through coolant supply



- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Shank thread milling cutter – SGF

▲ Profile-corrected

▲ Standard cutting

SGF

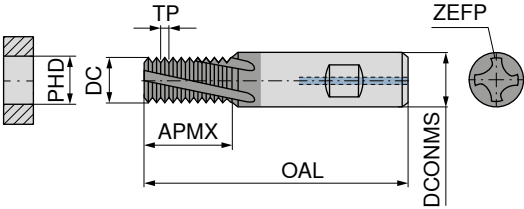
UNF



≤ 2xD







DC mm	Thread	TP mm	OAL mm	APMX mm	DCONMS _{h6} mm	ZEFP	PHD mm
4.8	UNF 1/4-28	0.907	55	14.8	6	3	5.5
6.0	UNF 5/16-24	1.058	60	19.3	6	3	6.9
8.0	UNF 3/8-24	1.058	70	22.5	8	3	8.5
8.0	UNF 7/16-20	1.270	70	23.2	8	3	9.9
9.9	UNF 1/2-20	1.270	75	28.3	10	4	11.5

CX

54 827 ...

01400 ¹⁾

51600

03800

71600

01200

P	●
M	●
K	●
N	●
S	●
H	○
O	●

1) Without through coolant supply



→ Find the cutting data standard values here.

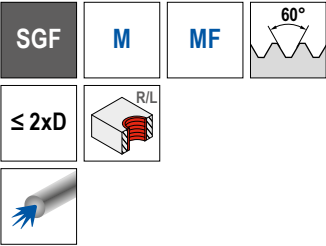
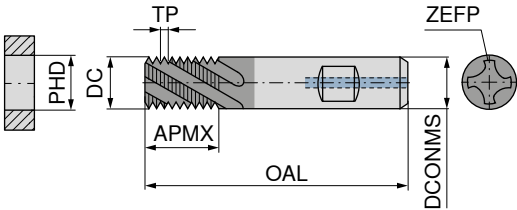
→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Shank thread milling cutter – SGF

- ▲ Profile-corrected
- ▲ Intra-dimensional, pitch-dependent
- ▲ Standard cutting



DC mm	TP mm	OAL mm	APMX mm	DCONMS _{h6} mm	ZEFP	PHD mm
8	0.50	70	12.0	8	3	10
8	0.75	70	12.0	8	3	11
10	1.00	75	16.0	10	4	14
10	1.50	75	16.5	10	4	14
12	1.00	85	20.0	12	4	16
12	1.50	85	21.0	12	4	16
12	2.00	85	20.0	12	4	18
16	1.00	90	25.0	16	5	22
16	1.50	90	25.5	16	5	22
16	2.00	90	26.0	16	5	22
16	3.00	90	27.0	16	5	24

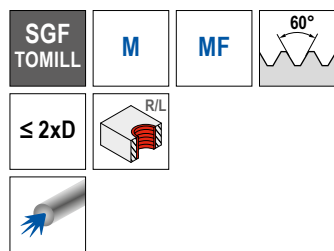
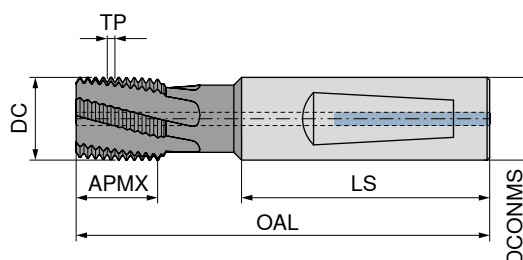
CX
54 828 ...
00800
08000
10000
10100
12000
12100
12200
16000
16100
16200
16400

P	●
M	●
K	●
N	●
S	●
H	○
O	●

- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_r or center path feed v_{fm} .

MonoThread – Shank thread milling cutter – SGF TOMILL



DC mm	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	ZEFP	DMIN mm
12	1.0	80	20.0	45	12	4	18
12	1.5	80	19.5	45	12	4	18
16	1.0	80	16.0	48	16	5	24
16	1.0	90	25.0	48	16	5	24
16	1.5	90	25.5	48	16	5	24
16	2.0	90	24.0	48	16	5	24
16	2.0	80	16.0	48	16	5	24
20	1.5	105	33.0	50	20	5	30
20	1.5	92	21.0	50	20	5	30
20	2.0	105	32.0	50	20	5	30
20	2.0	92	20.0	50	20	5	30
20	3.0	92	21.0	50	20	5	30

SH	SH
50 525 ...	50 526 ...
	12100
	12150
16100	16100
	16110
	16150
	16220
	16200
	20150
16150	
	20210
	20200
	20300

P	●
M	●
K	●
N	○
S	●
H	○
O	

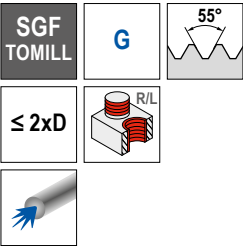
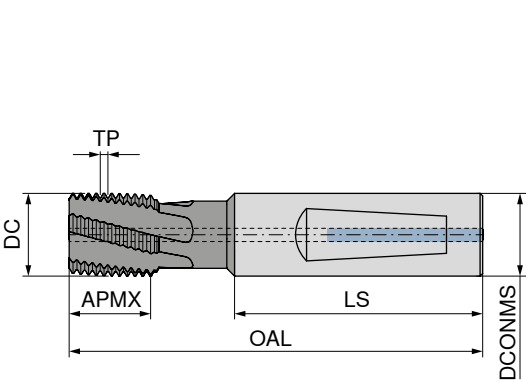


- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_r or center path feed v_{fm} .

MonoThread – Shank thread milling cutter – SGF TOMILL



DC mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	ZEFP	DMIN mm
16	90	25.4	48	16	5	19.0
20	105	32.3	50	20	5	30.5

SH	SH
50 528 ...	50 529 ...
16140	16140
	20110

P	●
M	●
K	○
N	○
S	●
H	○
O	

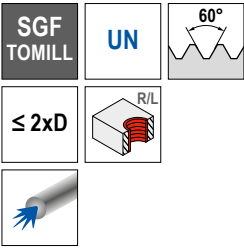
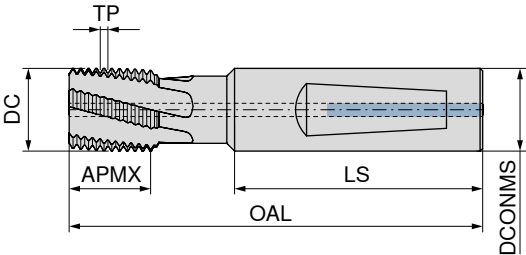


- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

MonoThread – Shank thread milling cutter – SGF TOMILL



Solid carbide

DC mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	ZEFP	DMIN mm
16	80	14.8	48	16	5	24
20	92	21.2	50	20	5	30

SH

50 527 ...

16120

20120

P	
M	
K	○
N	●
S	
H	
O	

-
- Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

MonoThread – PCD shank thread milling cutter – SGF

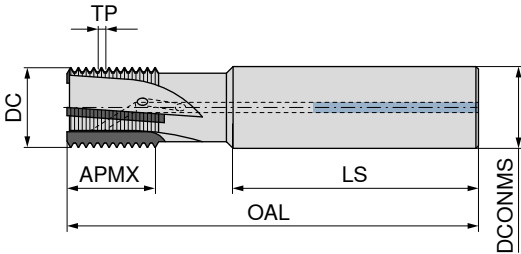
▲ For the machining of lightweight construction materials such as aluminum, magnesium, and fiber-reinforced plastics

SGF

M

MF

≤ 1xD



DC	TP	OAL	APMX	LS	DCONMS	ZEFP	DMIN
mm	mm	mm	mm	mm	mm	mm	mm
16	1.5	80	16.5	45	16	4	24

PC

50 028 ...

16000

P	
M	
K	
N	
S	
H	
O	

→ Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Circular shank thread milling cutter – ZSGF

▲ Profile-corrected

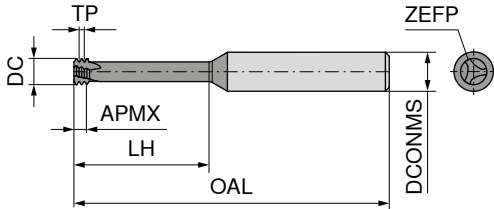
ZSGF

M



≤ 3xD





DC mm	Thread	TP mm	OAL mm	APMX mm	LH mm	DCONMS _{h6} mm	ZEFP
1.53	M2	0.40	39	0.80	6.0	3	3
2.37	M3	0.50	58	1.35	9.5	6	3
3.10	M4	0.70	58	1.95	12.5	6	3
3.80	M5	0.80	58	2.30	16.0	6	3
4.65	M6	1.00	58	2.70	20.0	6	3
6.00	M8	1.25	58	3.20	24.0	6	3
7.80	M10	1.50	64	3.80	31.5	8	3
9.00	M12	1.75	73	4.55	37.8	10	3

CS

50 545 ...

02000

03000

04000

05000

06000

08000

10000

12000

P	●
M	○
K	●
N	●
S	●
H	●
O	●



→ Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_c or center path feed v_{fm} .

CoreLine – Circular shank thread milling cutter – ZSGF

▲ Profile-corrected

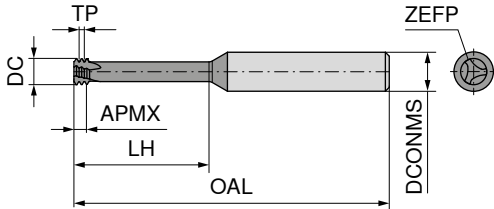
ZSGF

M



≤ 4xD





DC mm	Thread	TP mm	OAL mm	APMX mm	LH mm	DCONMS _{h6} mm	ZEFP
1.53	M2	0.40	39	1.00	10.4	3	3
2.37	M3	0.50	39	1.30	12.5	3	3
3.10	M4	0.70	58	1.80	16.7	6	3
4.00	M5	0.80	58	2.10	20.8	6	3
4.80	M6	1.00	58	2.55	25.0	6	3
6.40	M8	1.25	64	3.15	33.5	8	3
8.00	M10	1.50	76	3.85	41.5	8	3

CS

50 550 ...

02000 ¹⁾

03000

04000

05000

06000

08000

10000

P	●
M	○
K	●
N	●
S	●
H	
O	●

1) 5xD



→ Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_c or center path feed v_{fm} .

CoreLine – Circular shank thread milling cutter – ZSGF

▲ Profile-corrected

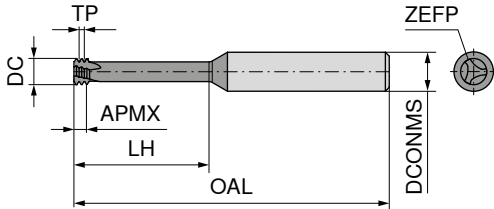
ZSGF

UNC



≤ 3xD





DC mm	Thread	TP mm	OAL mm	APMX mm	LH mm	DCONMS _{h6} mm	ZEFP
3.678	UNC No.10-No.12	1.058	58	3.17	15.5	6	3
4.697	UNC 1/4	1.270	58	3.81	19.0	6	3
6.000	UNC 5/16	1.411	58	4.23	23.0	6	3
7.345	UNC 3/8	1.588	64	4.76	30.2	8	3
7.700	UNC 7/16	1.814	64	5.44	35.2	8	3
9.376	UNC 1/2	1.954	73	5.86	40.1	10	3
10.920	UNC 9/16	2.117	105	6.35	45.0	12	3
11.419	UNC 5/8	2.309	105	6.93	50.0	12	3
15.210	UNC 3/4	2.540	105	7.62	59.7	16	4

CS

50 557 ...

01000

01400

51600

03800

71600

01200

91600

05800

03400

P	●
M	○
K	●
N	●
S	●
H	●
O	●



→ Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Circular shank thread milling cutter – ZSGF

▲ Profile-corrected

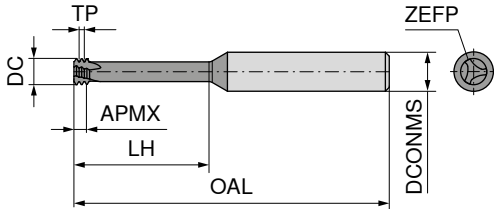
ZSGF

UNF



≤ 3xD





DC mm	Thread	TP mm	OAL mm	APMX mm	LH mm	DCONMS _{h6} mm	ZEFP
4.696	UNF 1/4	0.907	58	2.72	19.0	6	3
6.510	UNF 5/16, 3/8	1.058	64	3.17	24.0	8	3
7.994	UNF 7/16	1.270	64	3.81	34.5	8	3
11.993	UNF 5/8	1.411	105	4.23	49.0	12	4

CS

50 559 ...

01400

51600

71600

05800

P	●
M	○
K	●
N	●
S	●
H	●
O	●



→ Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Circular shank thread milling cutter – ZSGF

▲ Profile-corrected

ZSGF

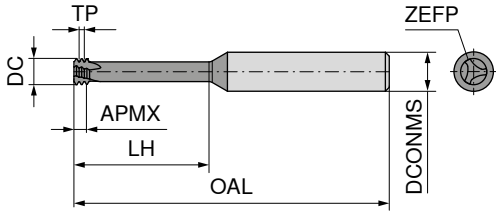
UNC

UNF



≤ 2xD





DC mm	Thread	TP mm	OAL mm	APMX mm	LH mm	DCONMS _{h6} mm	ZEFP
1.400	UNC No.1 / UNF No.2	0.397	58	1.19	3.8	6	3
1.646	UNC No.2 / UNF No.3	0.454	58	1.36	4.4	6	3
1.901	UNC No.3 / UNF No.4	0.529	58	1.59	5.2	6	3
2.034	UNC No.4	0.635	58	1.91	6.3	6	3
2.416	UNC No.5 / UNF No.6	0.635	58	1.91	7.0	6	3

CS

50 568 ...

01200

02300

03400

04000

05600

P	●
M	○
K	●
N	●
S	●
H	●
O	●



→ Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_c or center path feed v_{fm} .

CoreLine – Circular shank thread milling cutter – ZSGF

▲ Profile-corrected

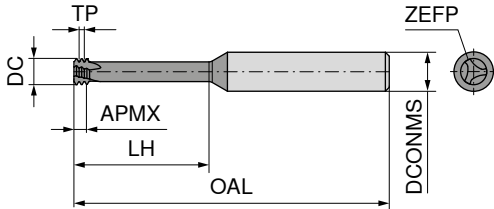
ZSGF

G



≤ 2xD





DC mm	Thread	TP mm	OAL mm	APMX mm	LH mm	DCONMS _{h6} mm	ZEFP
7.790	G1/8	0.907	64	2.72	19.5	8	3
10.015	G 1/4-3/8	1.337	73	4.01	30.0	10	4
12.013	G 1/2-G7/8	1.814	84	5.44	37.0	12	4
15.900	G 1-2	2.309	105	6.93	44.0	16	4

CS

50 569 ...

01800

01400

01200

01000

P	●
M	○
K	●
N	●
S	●
H	●
O	●



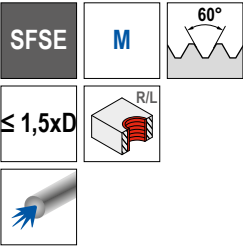
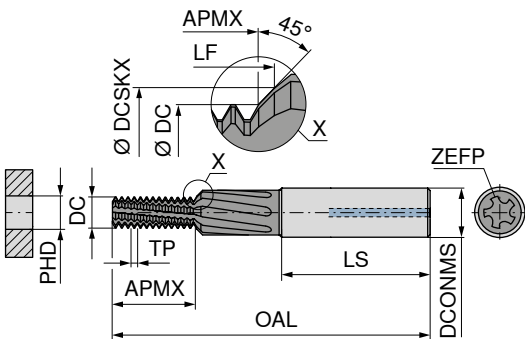
→ Find the cutting data standard values here.
→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

MonoThread – Shank thread milling cutter with chamfer facet – SFSE

- ▲ Profile-corrected
- ▲ HPC – High Performance Cutting



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCSKX mm	LF mm	ZEFP	PHD mm
4.68	M6	1.0	59.0	10.2	36	8	6.3	10.36	6	5.0
7.79	M10	1.5	74.5	16.8	45	12	10.3	16.81	7	8.5

SH

50 548 ...

06000

10000

P	●
M	●
K	●
N	●
S	●
H	
O	

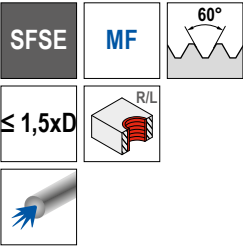
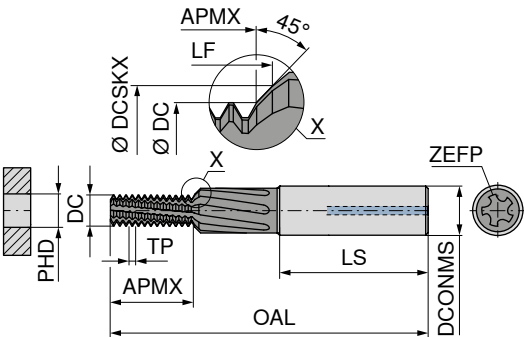
-
- Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

MonoThread – Shank thread milling cutter with chamfer facet – SFSE

- ▲ Profile-corrected
- ▲ HPC – High Performance Cutting



DC	Thread	TP	OAL	APMX	LS	DCONMS _{h6}	DCSKX	LF	ZEFP	PHD
mm		mm	mm	mm	mm	mm	mm	mm	mm	mm
4.68	M6x0,75	0.75	59	10	36	8	6.3	10.03	6	5.25

SH
50 549 ...
06000

P	•
M	•
K	•
N	•
S	•
H	
O	



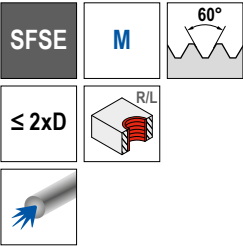
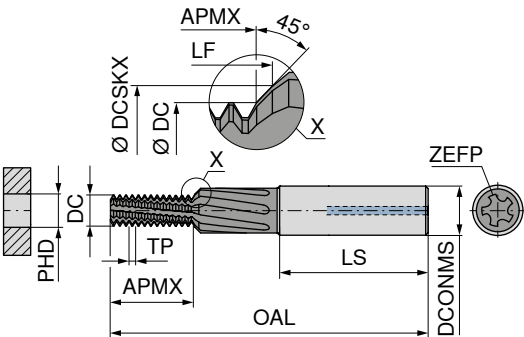
- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

MonoThread – Shank thread milling cutter with chamfer facet – SFSE

- ▲ Profile-corrected
- ▲ HPC – High Performance Cutting



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCSKX mm	LF mm	ZEFP	PHD mm
3.14	M4	0.70	49	8.0	36	6	4.3	8.6	5	3.3
3.95	M5	0.80	55	9.9	36	6	5.3	10.6	5	4.2
4.68	M6	1.00	62	12.3	36	8	6.3	13.2	6	5.0
6.22	M8	1.25	74	16.6	40	10	8.3	17.8	7	6.8
7.79	M10	1.50	79	19.9	45	12	10.3	21.3	7	8.5
9.38	M12	1.75	89	24.9	45	14	12.3	26.6	7	10.2
10.92	M14	2.00	102	28.5	48	16	14.3	30.4	7	12.0
12.83	M16	2.00	102	32.4	48	18	16.3	34.4	8	14.0

SH
50 806 ...
04000
05000
06000
08000
10000
12000
14000
16000

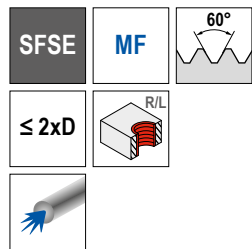
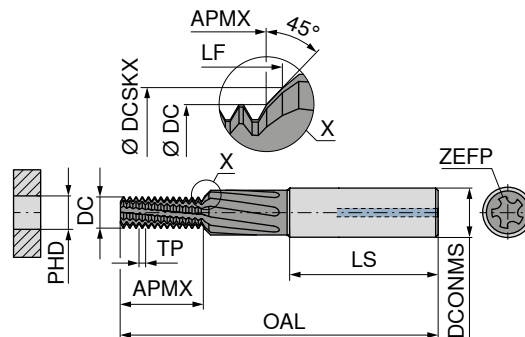
P	●
M	●
K	●
N	●
S	●
H	
O	

- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

MonoThread – Shank thread milling cutter with chamfer facet – SFSE

- ▲ Profile-corrected
▲ HPC – High Performance Cutting



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCSKX mm	LF mm	ZEFP	PHD mm
3.95	M5x0,5	0.50	55	10.2	36	6	5.3	10.8	5	4.5
4.68	M6x0,75	0.75	62	12.2	36	8	6.3	13.0	5	5.2
6.22	M8x1	1.00	74	16.2	40	10	8.3	17.3	6	7.0
7.79	M10x1	1.00	79	20.1	45	12	10.3	21.5	7	9.0
9.38	M12x1	1.00	89	24.0	45	14	12.3	25.6	7	11.0
9.38	M12x1,5	1.50	89	24.3	45	14	12.3	25.9	7	10.5
10.92	M14x1,5	1.50	102	28.7	48	16	14.3	30.6	7	12.5
12.82	M16x1,5	1.50	102	31.7	48	18	16.3	33.6	8	14.5

SH
50 807 ...
05100
06200
08300
10300
12300
12500
14500
16500

P	●
M	●
K	●
N	●
S	●
H	
O	



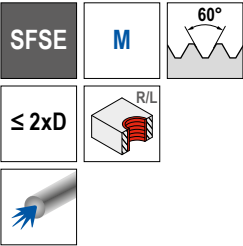
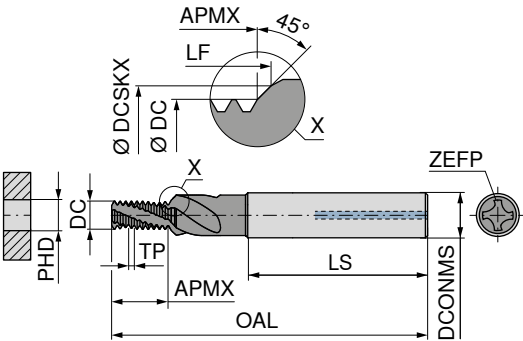
- Find the cutting data standard values here.
→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Shank thread milling cutter with chamfer facet – SFSE

- ▲ Profile-corrected
- ▲ Performance Cutting



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCSKX mm	LF mm	ZEFP	PHD mm
3.95	M5	0.80	55	10.05	36	6	5.3	10.60	3	4.2
4.68	M6	1.00	62	12.56	36	8	6.3	13.20	4	5.0
6.22	M8	1.25	74	16.99	40	10	8.3	17.76	4	6.8
7.79	M10	1.50	79	20.41	45	12	10.3	21.30	4	8.5
9.38	M12	1.75	89	25.57	45	14	12.3	26.60	5	10.2
12.83	M16	2.00	102	33.27	48	18	16.3	34.42	5	14.0

CS
50 552 ...
05000
06000
08000
10000
12000
16000

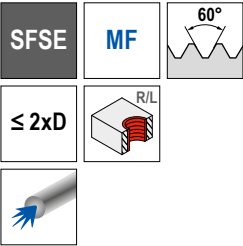
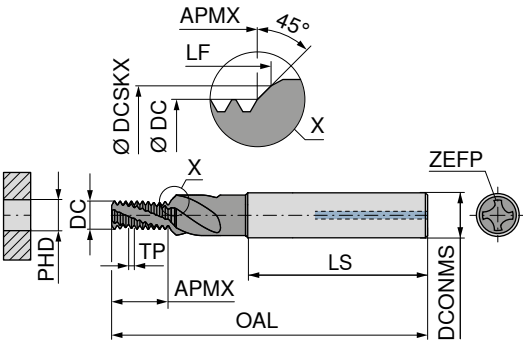
P	●
M	●
K	●
N	●
S	●
H	●
O	●

- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Shank thread milling cutter with chamfer facet – SFSE

- ▲ Profile-corrected
- ▲ Performance Cutting



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCSKX mm	LF mm	ZEFP	PHD mm
6.22	M8x1	1.00	74	16.69	40	10	8.3	17.34	4	7.0
7.79	M10x1	1.00	79	20.81	45	12	10.3	21.46	4	9.0
7.79	M10x1,25	1.25	79	20.85	45	12	12.3	21.63	4	8.8
9.38	M12x1,25	1.25	89	24.72	45	14	12.3	25.49	5	10.8
9.38	M12x1,5	1.50	89	25.02	45	14	12.3	25.92	5	10.5
10.92	M14x1	1.00	102	29.06	48	16	14.3	29.71	5	13.0
10.92	M14x1,5	1.50	102	29.65	48	16	14.3	30.55	5	12.5
12.82	M16x1,5	1.50	102	32.67	48	18	14.3	33.57	5	14.5

CS
50 553 ...
08200
10200
10300
12300
12400
14200
14400
16400

P	●
M	●
K	●
N	●
S	●
H	●
O	●

- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

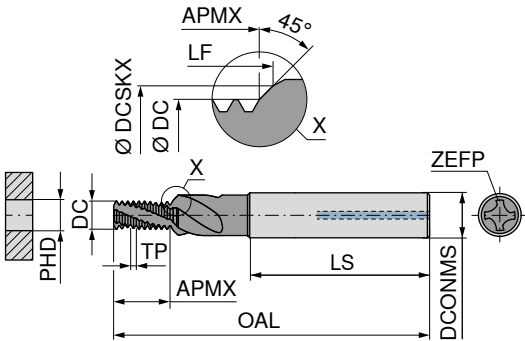
CoreLine – Shank thread milling cutter with chamfer facet – SFSE

- ▲ Profile-corrected
- ▲ Performance Cutting

SFSE

G

$\leq 2xD$



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCSKX mm	LF mm	ZEFP	PHD mm
7.79	G 1/8-28	0.907	79	20.59	45	12	10.03	21.25	4	8.80
10.92	G 1/4-19	1.337	102	27.53	48	16	13.46	28.43	5	11.80
13.92	G 3/8-19	1.337	102	34.34	48	18	16.96	35.24	5	15.25
15.98	G 1/2-14	1.814	127	43.27	56	25	21.25	44.45	5	19.00

CS

50 551 ...

01800

01400

03800

01200

P	●
M	●
K	●
N	●
S	●
H	●
O	●

-
- Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_c or center path feed v_{fm} .

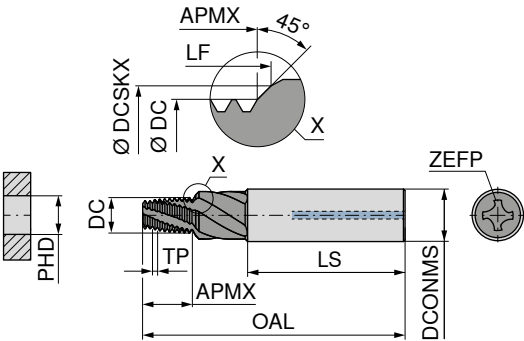
CoreLine – Shank thread milling cutter with chamfer facet – SFSE

- ▲ Profile-corrected
- ▲ Performance Cutting

SFSE

NPT

≤ 2xD



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCSKX mm	LF mm	ZEFP	PHD mm
5.45	NPT 1/16-27	0.941	64	9.86	40	10	8.70	11.33	4	6.15
7.87	NPT 1/8-27	0.941	74	9.86	45	12	11.10	11.33	4	8.50
10.10	NPT 1/4-18	1.411	80	14.78	48	16	14.50	16.76	5	11.10
16.42	NPT 1/2-14	1.814	94	18.98	48	18			5	17.90

CS

50 554 ...

11600

01800

01400

01200¹⁾

P	●
M	●
K	●
N	●
S	●
H	●
O	●

1) Chamfer section at the front of the tool

→ Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Shank thread milling cutter with chamfer facet – SFSE

- ▲ Profile-corrected
- ▲ Performance Cutting

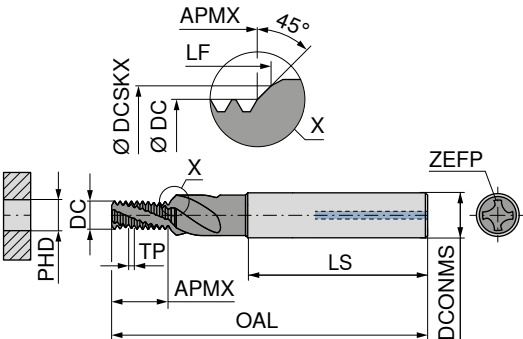
SFSE

UNC

60°

≤ 2xD

R/L



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCSKX mm	LF mm	ZEFP	PHD mm
4.70	UNC 1/4-20	1.270	62	14.68	36	8	6.65	15.46	4	5.1
6.22	UNC 5/16-18	1.411	74	16.28	40	10	8.24	17.14	4	6.6
7.34	UNC 3/8-16	1.588	79	19.98	45	12	9.83	20.92	4	8.0
8.57	UNC 7/16-14	1.814	79	22.83	45	12	11.41	23.89	4	9.4
9.38	UNC 1/2-13	1.954	89	26.71	45	14	13.00	27.83	5	10.8
10.92	UNC 9/16-12	2.117	102	30.99	48	16	14.60	32.20	5	12.2
12.50	UNC 5/8-11	2.309	102	33.72	48	18	16.18	35.03	5	13.5
15.21	UNC 3/4-10	2.540	110	39.68	50	20	19.35	41.10	5	16.5

CS

50 555 ...

01400

51600

03800

71600

01200

91600

05800

03400

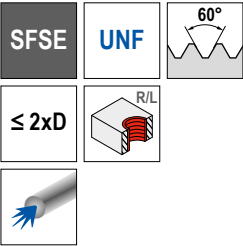
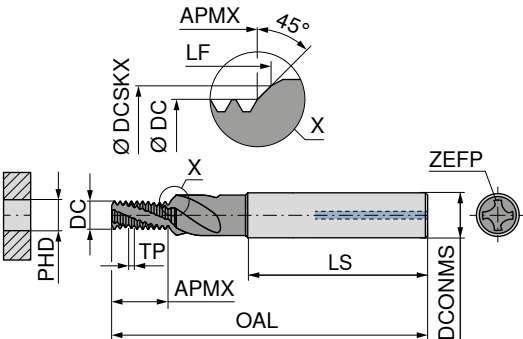
P	●
M	●
K	●
N	●
S	●
H	●
O	●

-
- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Shank thread milling cutter with chamfer facet – SFSE

- ▲ Profile-corrected
- ▲ Performance Cutting



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCSKX mm	LF mm	ZEFP	PHD mm
4.70	UNF 1/4-28	0.907	62	14.24	36	8	6.65	14.84	4	5.5
6.22	UNF 5/16-24	1.058	74	16.56	40	10	8.24	17.23	4	6.9
7.79	UNF 3/8-24	1.058	79	19.73	45	12	9.83	20.41	4	8.5
9.32	UNF 7/16-20	1.270	89	22.34	45	14	11.40	23.13	5	9.9
9.38	UNF 1/2-20	1.270	89	26.57	45	14	13.00	27.36	5	11.5
10.92	UNF 9/16-18	1.411	102	29.43	48	16	14.59	30.29	5	12.9
12.82	UNF 5/8-18	1.411	102	33.58	48	18	16.18	34.43	5	14.5
15.82	UNF 3/4-16	1.587	110	39.29	50	20	19.35	40.23	5	17.5

CS
50 556 ...
01400
51600
03800
71600
01200
91600
05800
03400

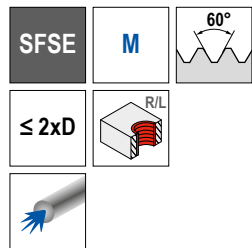
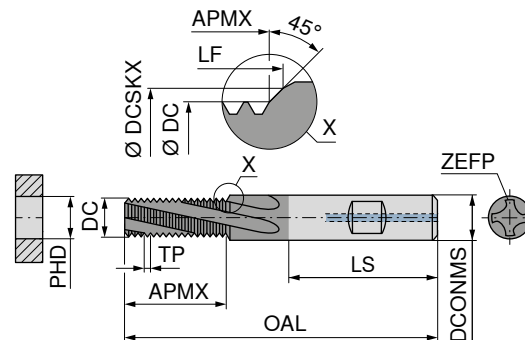
P	●
M	●
K	●
N	●
S	●
H	●
O	●

- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Shank thread milling cutter with chamfer facet – SFSE

- ▲ Profile-corrected
- ▲ Chamfer section at end of shank
- ▲ Standard cutting



Ti500



Solid carbide

DC mm	Thread	TP mm	OAL mm	LS mm	APMX mm	DCONMS _{h6} mm	DCSKX mm	LF mm	ZEPF	PHD mm
4.00	M5	0.80	62	36	12.3	8	5.3	12.98	3	4.20
4.80	M6	1.00	62	36	14.4	8	6.3	15.18	3	5.00
6.50	M8	1.25	74	40	19.0	10	8.3	20.19	3	6.80
7.95	M10	1.50	80	45	23.0	12	10.3	24.25	3	8.50
9.90	M12	1.75	90	45	28.6	14	12.3	29.94	4	10.25
11.60	M14	2.00	100	48	32.6	16	14.3	34.20	4	12.00
11.95	M16	2.00	90	45	36.6	12			4	14.00
13.95	M18	2.50	110	50	38.0	20	18.3	40.50	4	15.50
15.95	M20	2.50	100	48	43.3	16			4	17.50

CX

54 815 ...

05000 ¹⁾
 06000 ¹⁾
 08000
 10000
 12000
 14000
 16000 ²⁾
 18000
 20000 ²⁾

P	●
M	●
K	●
N	●
S	●
H	○
O	●

- 1) Without through coolant supply
- 2) Chamfer section at the front of the tool



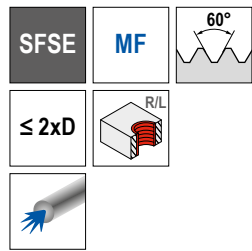
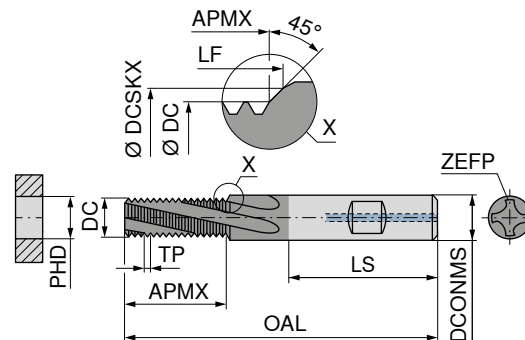
- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_r or center path feed v_{fm} .

CoreLine – Shank thread milling cutter with chamfer facet – SFSE

- ▲ Profile-corrected
- ▲ Chamfer section at end of shank
- ▲ Standard cutting



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCSKX mm	LF mm	ZEFP	PHD mm
6.0	M8x1	1.00	74	19.2	40	10	8.3	20.41	3	7.0
8.0	M10x1	1.00	80	22.2	45	12	10.3	23.41	3	9.0
8.0	M10x1,25	1.25	80	22.8	45	12	10.3	24.09	3	8.8
9.9	M12x1	1.00	90	27.2	45	14	12.3	28.42	4	11.0
9.9	M12x1,25	1.25	90	27.8	45	14	12.3	29.10	4	10.8
9.9	M12x1,5	1.50	90	27.5	45	14	12.3	28.77	4	10.5
11.6	M14x1	1.00	100	31.0	48	16	14.3	32.51	4	13.0
11.6	M14x1,5	1.50	100	32.0	48	16	14.3	33.35	4	12.5
12.0	M16x1,5	1.50	90	35.0	45	12			4	14.5
14.0	M18x1,5	1.50	110	39.0	50	20	18.3	41.30	4	16.5
16.0	M20x1,5	1.50	100	44.0	48	16			4	18.5

CX
54 816 ...
08000
10000
10100
12000
12100
12200
14000
14100
16000 ¹⁾
18000
20000 ¹⁾

P	●
M	●
K	●
N	●
S	●
H	○
O	●

1) Chamfer section at the front of the tool



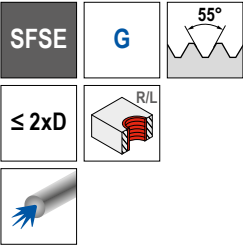
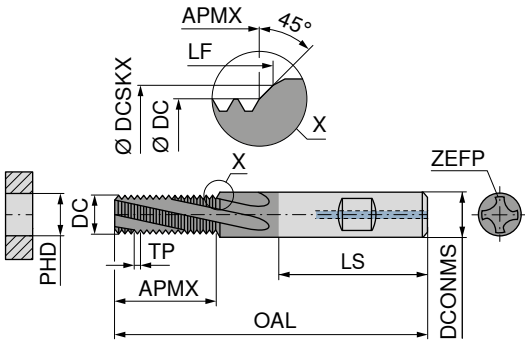
- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Shank thread milling cutter with chamfer facet – SFSE

- ▲ Profile-corrected
- ▲ Chamfer section at end of shank
- ▲ Standard cutting



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCSKX mm	LF mm	ZEFP	PHD mm
6.00	G 1/16-28	0.907	74	16.5	40	10	8.02	17.54	3	6.80
7.95	G 1/8-28	0.907	80	22.0	45	12	10.03	23.00	3	8.80
9.90	G 1/4-19	1.337	100	28.0	48	16	13.46	29.98	4	11.80
13.95	G 3/8-19	1.337	90	36.5	45	14			4	15.25
15.95	G 1/2-14	1.814	100	46.0	48	16			5	19.00
17.95	G 5/8-14	1.814	110	49.5	48	18			5	21.00

CX
54 817 ...
11600
01800
01400
03800 ¹⁾
01200 ¹⁾
05800 ¹⁾

P	●
M	●
K	●
N	●
S	●
H	○
O	●

1) Chamfer section at the front of the tool



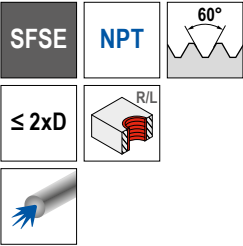
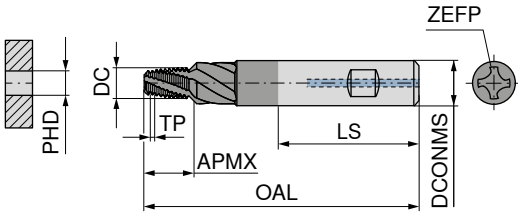
- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Shank thread milling cutter with chamfer facet – SFSE

- ▲ Profile-corrected
- ▲ Chamfer section at end of shank
- ▲ Standard cutting



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	ZEFP	PHD mm
10.1	NPT 1/4-18	1.411	90	16.0	45	14	3	11.1
12.8	NPT 3/8-18	1.411	90	16.0	48	16	4	14.5
16.0	NPT 1/2-14	1.814	110	20.5	50	20	5	17.9
18.5	NPT 3/4-14	1.814	110	20.5	50	20	5	23.2

CX
54 820 ...
01400 ¹⁾
03800 ¹⁾
01200 ¹⁾
03400 ¹⁾

P	●
M	●
K	●
N	●
S	●
H	○
O	●

1) Chamfer section at the front of the tool

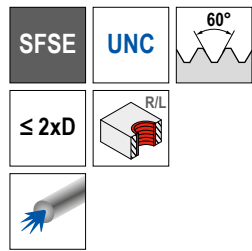
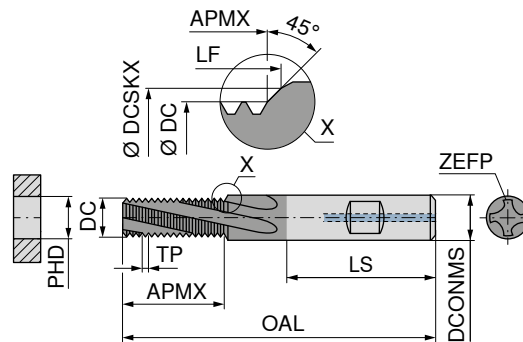
→ Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_c or center path feed v_{fm} .

CoreLine – Shank thread milling cutter with chamfer facet – SFSE

- ▲ Profile-corrected
- ▲ Chamfer section at end of shank
- ▲ Standard cutting



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCSKX mm	LF mm	ZEFP	PHD mm
4.80	UNC 1/4-20	1.270	62	14.4	36	8	6.65	15.43	3	5.1
5.95	UNC 5/16-18	1.411	74	20.2	40	10	8.24	21.44	3	6.6
7.60	UNC 3/8-16	1.588	80	24.3	45	12	9.83	25.62	3	8.0
7.95	UNC 7/16-14	1.814	90	24.0	45	14	11.41	25.86	3	9.4
9.90	UNC 1/2-13	1.954	90	29.8	45	14	13.00	31.59	4	10.8
11.80	UNC 9/16-12	2.117	100	34.5	48	16	14.59	36.19	4	12.2
12.70	UNC 5/8-11	2.309	90	37.7	45	14			4	13.5
15.20	UNC 3/4-10	2.540	110	41.2	50	20	19.35	43.63	5	16.5

CX

54 818 ...

01400 ¹⁾

51600

03800

71600

01200

91600

05800 ²⁾

03400

P	●
M	●
K	●
N	●
S	●
H	○
O	●

- 1) Without through coolant supply
 2) Chamfer section at the front of the tool



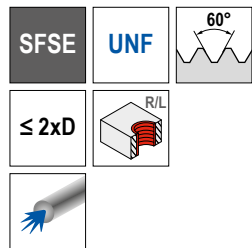
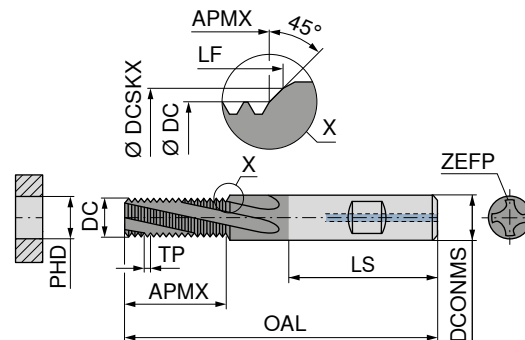
- Find the cutting data standard values here.
 → Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Shank thread milling cutter with chamfer facet – SFSE

- ▲ Profile-corrected
- ▲ Chamfer section at end of shank
- ▲ Standard cutting

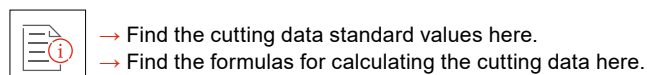
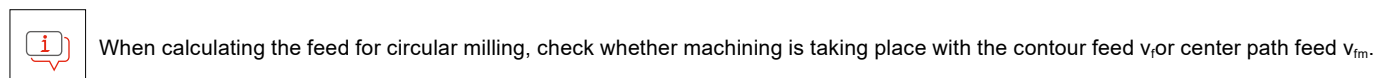


DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCSKX mm	LF mm	ZEFP	PHD mm
4.80	UNF 1/4-28	0.907	62	14.7	36	8	6.65	15.72	3	5.5
5.95	UNF 5/16-24	1.058	74	19.3	40	10	8.24	20.48	3	6.9
8.00	UNF 3/8-24	1.058	80	22.5	45	12	9.83	23.54	3	8.5
7.95	UNF 7/16-20	1.270	90	23.0	45	14	11.41	24.76	3	9.9
9.90	UNF 1/2-20	1.270	90	28.0	45	14	13.00	29.75	4	11.5
12.00	UNF 9/16-18	1.411	100	31.4	48	16	15.59	32.81	4	12.9
13.50	UNF 5/8-18	1.411	90	35.7	45	14			4	14.5
17.00	UNF 3/4-16	1.588	110	40.2	50	20	19.35	41.53	5	17.5

CX
54 819 ...
01400 ¹⁾
51600
03800
71600
01200
91600
05800 ²⁾
03400

P	●
M	●
K	●
N	●
S	●
H	○
O	●

- 1) Without through coolant supply
 2) Chamfer section at the front of the tool



CoreLine – Shank thread milling cutter with shank-end countersink – SFSE Micro

▲ Note: left-hand cutting
▲ Profile-corrected

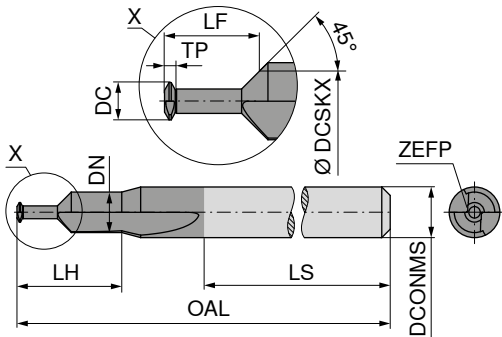
SFSE
Micro

M

60°

≤ 1,5xD

46–60
HRC



DC mm	Thread	TP mm	OAL mm	DN mm	LS mm	LH mm	DCONMS _{h6} mm	DCSKX mm	LF mm	ZEFP
0.75	M1	0.25	40	1.8	28	5.2	3	1.5	2.1	2
1.10	M1,4	0.30	40	2.0	28	5.7	3	1.7	2.6	2
1.25	M1,6	0.35	40	2.4	28	6.0	3	2.1	3.1	2
1.60	M2	0.40	40	3.0	28		3	2.6	3.7	2
1.75	M2,2	0.45	40	3.0	28		3	2.5	3.9	2
2.05	M2,5	0.45	40	3.0	28		3	2.9	4.5	3

CS

50 804 ...

01000

01400

01600

02000

02200

02500

P	○
M	○
K	
N	○
S	○
H	●
O	



→ Find the cutting data standard values here.

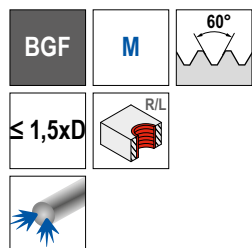
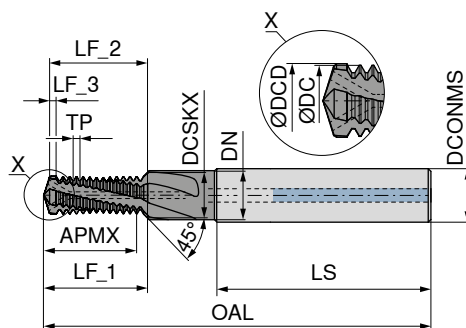


Caution: left-hand cutting (M04) → spindle rotation left!

MonoThread – Drill thread milling cutter with chamfer facet – BGF

▲ Profile-corrected

▲ HPC – High Performance Cutting



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCD mm	DCSKX mm	DN mm	LF_1 mm	LF_2 mm	LF_3 mm	ZEFP
4.840	M6	1.00	62	10.94	36	8	5.00	6.3	6.6	10.94	9.89	0.20	3
6.446	M8	1.25	74	13.86	40	10	6.75	8.3	9.0	13.86	12.44	0.25	3
8.080	M10	1.50	79	18.21	45	12	8.50	10.3	11.0	18.21	16.42	0.30	3
9.736	M12	1.75	89	21.31	45	14	10.25	12.3	13.5	21.31	19.16	0.35	3

NEW SH	NEW SH
50 281 ...	50 284 ...
08000	08000
10000	10000
12000	12000
14000	14000

P		
M		
K	○	●
N	●	○
S		
H		
O	●	○



→ Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.

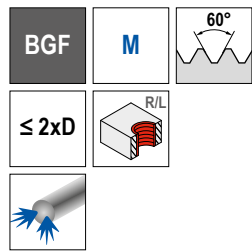
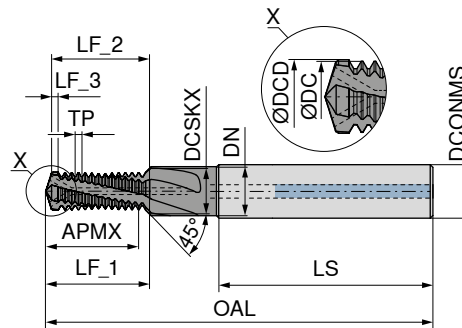


When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

MonoThread – Drill thread milling cutter with chamfer facet – BGF

▲ Profile-corrected

▲ HPC – High Performance Cutting



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCD mm	DCSKX mm	DN mm	LF_1 mm	LF_2 mm	LF_3 mm	ZEFP
4.840	M6	1.00	62	13.94	36	8	5.00	6.3	6.6	13.94	12.89	0.20	3
6.446	M8	1.25	74	17.61	40	10	6.75	8.3	9.0	17.61	16.19	0.25	3
8.080	M10	1.50	79	22.71	45	12	8.50	10.3	11.0	22.71	20.92	0.30	3
9.736	M12	1.75	89	26.56	45	14	10.25	12.3	13.5	26.56	24.41	0.35	3

NEW SH	NEW SH
50 282 ...	50 285 ...
08000	08000
10000	10000
12000	12000
14000	14000

P		
M		
K	○	●
N	●	○
S		
H		
O	●	○



→ Find the cutting data standard values here.

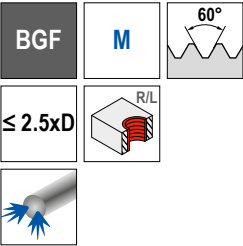
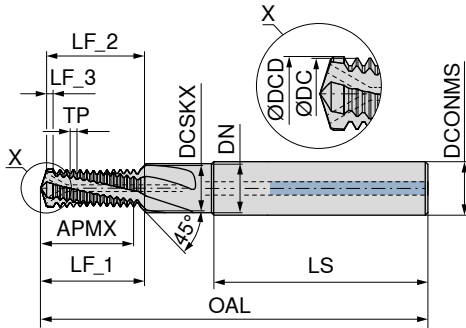
→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

MonoThread – Drill thread milling cutter with chamfer facet – BGF

- ▲ Profile-corrected
- ▲ HPC – High Performance Cutting



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCD mm	DCSKX mm	DN mm	LF_1 mm	LF_2 mm	LF_3 mm	ZEFP
4.840	M6	1.00	62	15.94	36	8	5.00	6.3	6.6	15.94	14.89	0.20	3
6.446	M8	1.25	74	22.61	40	10	6.75	8.3	9.0	22.61	21.19	0.25	3
8.080	M10	1.50	79	27.21	45	12	8.50	10.3	11.0	27.21	25.42	0.30	3
9.736	M12	1.75	89	33.56	45	14	10.25	12.3	13.5	33.56	31.41	0.35	3

NEW
SH

50 283 ...

08000

10000

12000

14000

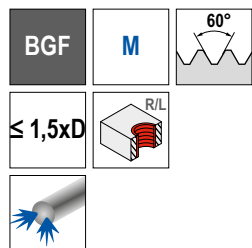
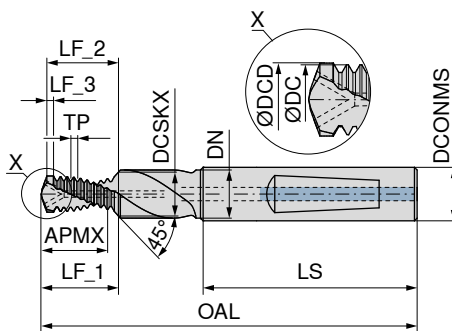
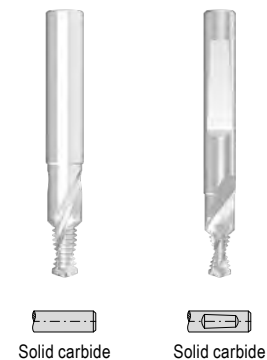
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O	●

- Find the cutting data standard values here.
→ Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_l or center path feed v_{fm} .

MonoThread – Drill thread milling cutter with chamfer facet – BGF

▲ Profile-corrected



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCD mm	DCSKX mm	DN mm	LF_1 mm	LF_2 mm	LF_3 mm	ZEFP
3.24	M4	0.70	47.0	5.25	36	6	3.3	4.3	4.5	7.3	6.8	0.7	2
4.10	M5	0.80	52.6	6.80	36	6	4.2	5.3	5.5	9.3	8.6	0.8	2
4.85	M6	1.00	59.0	8.40	36	8	5.0	6.3	6.6	11.5	10.7	1.0	2
6.45	M8	1.25	70.3	10.45	40	10	6.8	8.3	9.0	14.4	13.4	1.3	2
8.08	M10	1.50	74.5	14.00	45	12	8.5	10.3	11.0	18.9	17.6	1.5	2
9.74	M12	1.75	83.8	16.35	45	14	10.3	12.3	13.5	21.8	20.2	1.5	2

SH	SH
50 536 ...	50 534 ...
04000	04000
05000	05000
06000	
08000	
10000	10000
12000	12000

P		
M		
K	○	○
N	●	●
S		
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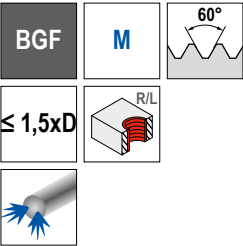
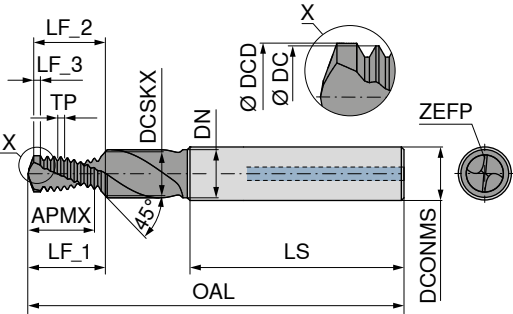
- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

MonoThread – Drill thread milling cutter with chamfer facet – BGF

▲ Profile-corrected



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{H6} mm	DCD mm	DCSKX mm	DN mm	LF_1 mm	LF_2 mm	LF_3 mm	ZEFP
4.85	M6	1.00	59.0	8.40	36	8	5.0	6.3	6.6	11.5	10.7	1.0	2
6.45	M8	1.25	70.3	10.45	40	10	6.8	8.3	9.0	14.4	13.4	1.3	2

SH

50 535 ...

06000

08000

P
M
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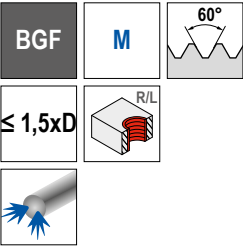
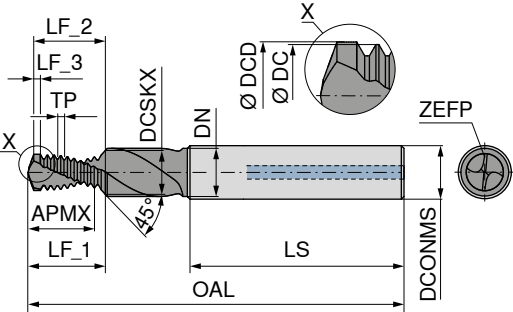
-
- Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

MonoThread – Drill thread milling cutter with chamfer facet – BGF

- ▲ Profile-corrected
- ▲ Specially designed for cast iron materials (GJS)



DC	Thread	TP	OAL	APMX	LS	DCONMS _{h6}	DCD	DCSKX	DN	LF_1	LF_2	LF_3	ZEFP
mm		mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	
9.74	M12	1.75	83.8	16.4	45	14	10.3	12.3	13.5	21.8	20.2	1.5	2

SH

50 537 ...

12000

P
M
K
N
S
H
O



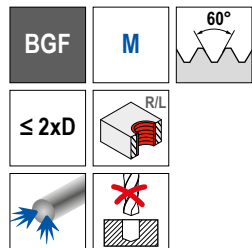
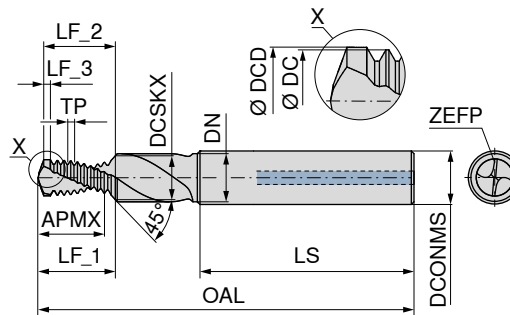
- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

MonoThread – Drill thread milling cutters with chamfer facet – BGF

▲ Profile-corrected



Solid carbide

DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{H6} mm	DCD mm	DCSKX mm	DN mm	LF_1 mm	LF_2 mm	LF_3 mm	ZEFP
2.45	M3	0.50	49	5.8	36	6	2.5	3.3	4.5	6.8	6.4	0.5	2
3.24	M4	0.70	49	7.3	36	6	3.3	4.3	4.5	9.4	8.9	0.7	2
4.10	M5	0.80	55	9.2	36	6	4.2	5.3	5.5	11.7	11.0	0.8	2
4.85	M6	1.00	62	11.4	36	8	5.0	6.3	6.6	14.5	13.7	1.0	2
6.45	M8	1.25	74	14.2	40	10	6.8	8.3	9.0	18.2	17.1	1.3	2
8.08	M10	1.50	79	18.5	45	12	8.5	10.3	11.0	23.4	22.1	1.5	2
9.74	M12	1.75	89	21.6	45	14	10.3	12.3	13.5	27.1	25.5	1.5	2
11.35	M14	2.00	102	26.6	48	16	12.0	14.3	15.5	32.8	30.9	1.5	2
13.28	M16	2.00	102	30.6	48	18	14.0	16.3	17.5	37.1	35.0	1.5	2

SH

50 869 ...
03000 ¹⁾
04000
05000
06000
08000
10000
12000
14000
16000

P	
M	
K	○
N	●
S	
H	
O	●

1) Without through coolant supply



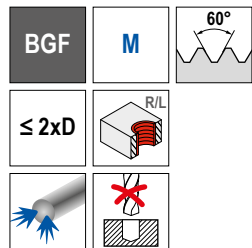
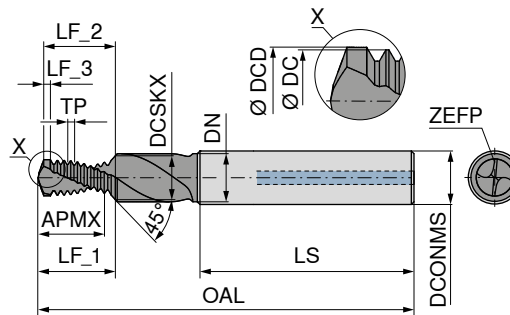
- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

MonoThread – Drill thread milling cutter with chamfer facet – BGF

▲ Profile-corrected



Ti601



Solid carbide

DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCD mm	DCSKX mm	DN mm	LF_1 mm	LF_2 mm	LF_3 mm	ZEFP
2.45	M3	0.50	49	5.8	36	6	2.5	3.3	4.5	6.8	6.4	0.5	2
3.24	M4	0.70	49	7.3	36	6	3.3	4.3	4.5	9.4	8.9	0.7	2
4.10	M5	0.80	55	9.2	36	6	4.2	5.3	5.5	11.7	11.0	0.8	2
4.85	M6	1.00	62	11.4	36	8	5.0	6.3	6.6	14.5	13.7	1.0	2
6.45	M8	1.25	74	14.2	40	10	6.8	8.3	9.0	18.2	17.1	1.3	2
8.08	M10	1.50	79	18.5	45	12	8.5	10.3	11.0	23.4	22.1	1.5	2
9.74	M12	1.75	89	21.6	45	14	10.3	12.3	13.5	27.1	25.5	1.5	2
11.35	M14	2.00	102	26.6	48	16	12.0	14.3	15.5	32.8	30.9	1.5	2
13.28	M16	2.00	102	30.6	48	18	14.0	16.3	17.5	37.1	35.0	1.5	2

SH

50 854 ...

03000 ¹⁾

04000

05000

06000

08000

10000

12000

14000

16000

P	
M	
K	●
N	○
S	
H	
O	○

1) Without through coolant supply



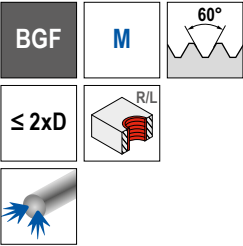
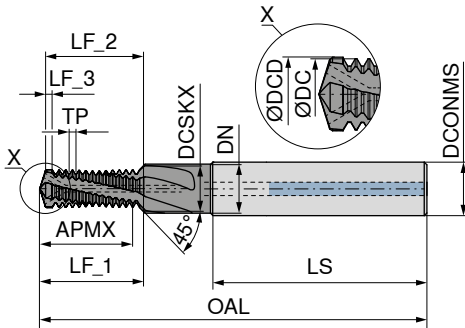
- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

MonoThread – Drill thread milling cutter with chamfer facet – BGF

- ▲ Profile-corrected
- ▲ Specially designed for gray cast iron (GJL)
- ▲ For pre-cast core holes



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCD mm	DCSKX mm	DN mm	LF_1 mm	LF_2 mm	LF_3 mm	ZEFP
4.85	M6	1.00	62	11.4	36	8	5.0	6.3	6.6	14.6	13.5	0.8	4
6.61	M8	1.25	74	14.2	40	10	6.8	8.3	9.0	18.3	16.8	1.0	4

SH
50 539 ...
06000
08000

P
M
K
N
S
H
O

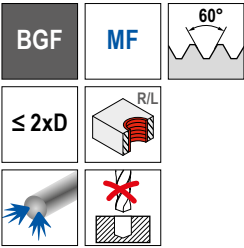
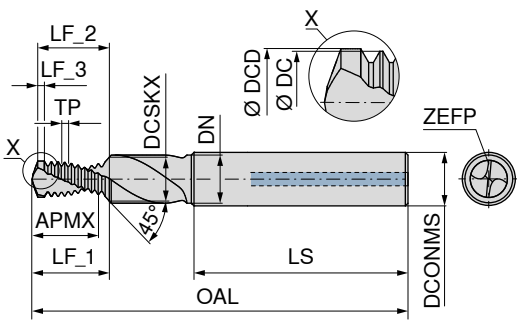


- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

MonoThread – Drill thread milling cutters with chamfer facet – BGF



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCD mm	DCSKX mm	DN mm	LF_1 mm	LF_2 mm	LF_3 mm	ZEFP
6.79	M8x1	1.0	74	15.40	40	10	7.0	8.3	9.0	18.8	17.7	1.0	2
8.75	M10x1	1.0	79	19.40	45	12	9.0	10.3	11.0	23.2	21.8	1.0	2
10.06	M12x1,5	1.5	89	23.01	45	14	10.5	12.3	13.5	28.2	26.6	1.5	2

SH
50 869 ...
08100
10100
12200

P
M
K
N
S
H
O



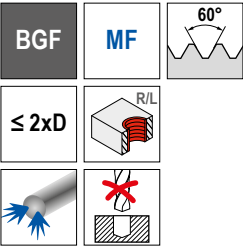
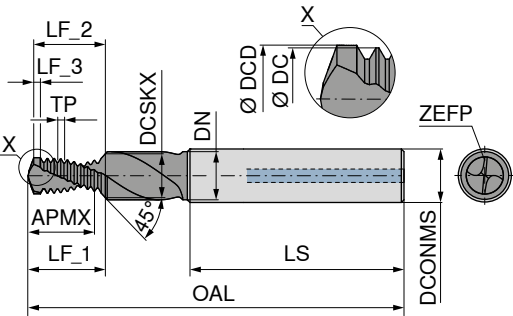
- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

MonoThread – Drill thread milling cutter with chamfer facet – BGF

▲ Profile-corrected



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{H6} mm	DCD mm	DCSKX mm	DN mm	LF_1 mm	LF_2 mm	LF_3 mm	ZEFP
6.79	M8x1	1.0	74	15.40	40	10	7.0	8.3	9.0	18.8	17.7	1.0	2
8.75	M10x1	1.0	79	19.40	45	12	9.0	10.3	11.0	23.2	21.8	1.0	2
10.74	M12x1	1.0	89	22.40	45	14	11.0	12.3	13.5	26.4	24.8	1.0	2
10.06	M12x1,5	1.5	89	23.01	45	14	10.5	12.3	13.5	28.2	26.6	1.5	2

SH

50 854 ...

08100

10100

12100

12200

P	
M	
K	●
N	○
S	
H	
O	○

→ Find the cutting data standard values here.
→ Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

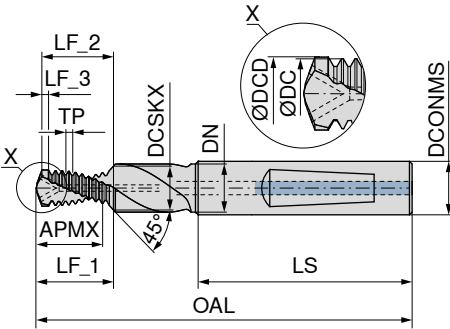
MonoThread – Drill thread milling cutter with chamfer facet – BGF

▲ Profile-corrected

BGF

EG M

≤ 2xD



Solid carbide

DC	Thread	TP	OAL	APMX	LS	DCONMS _{H6}	DCD	DCSKX	DN	LF_1	LF_2	LF_3	ZEFP
mm		mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	
5.98	EG-M6	1	74	13.4	40	10	6.3	7.6	9	16.8	15.8	1	2

SH

50 538 ...

06000

P	
M	
K	○
N	●
S	
H	
O	

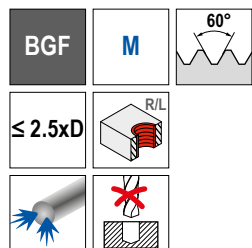
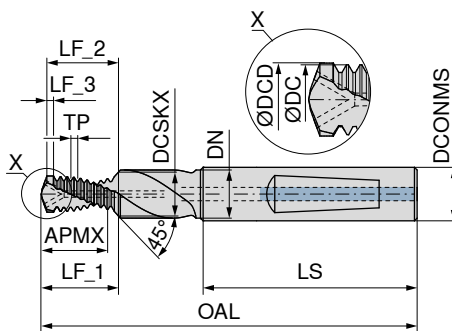
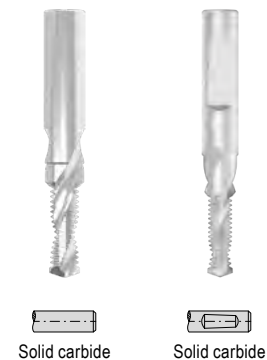
→ Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

MonoThread – Drill thread milling cutter with chamfer facet – BGF

▲ Profile-corrected



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCD mm	DCSKX mm	DN mm	LF_1 mm	LF_2 mm	LF_3 mm	ZEFP
4.10	M5	0.80	55	11.57	36	6	4.2	5.3	5.5	14.1	13.4	0.8	2
4.85	M6	1.00	62	13.40	36	8	5.0	6.3	6.6	16.5	15.7	1.0	2
6.45	M8	1.25	74	19.20	40	10	6.8	8.3	9.0	23.2	22.1	1.3	2
8.08	M10	1.50	79	23.00	45	12	8.5	10.3	11.0	27.9	26.6	1.5	2
9.74	M12	1.75	89	28.60	45	14	10.3	12.3	13.5	34.1	32.5	1.5	2

SH	SH
50 898 ...	50 542 ...
05000	
06000	
08000	08000
10000	
12000	

P		
M		
K	○	○
N	●	●
S		
H		
O	●	



- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_c or center path feed v_{fm} .

MonoThread – Drill thread milling cutter with chamfer facet – BGF

▲ Profile-corrected

BGF

M

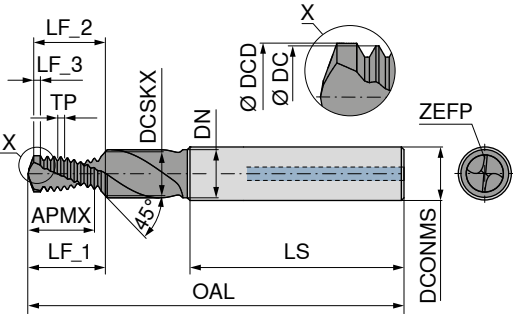


≤ 2.5xD









DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{H6} mm	DCD mm	DCSKX mm	DN mm	LF_1 mm	LF_2 mm	LF_3 mm	ZEFP
4.85	M6	1.00	62	13.4	36	8	5.0	6.3	6.6	16.5	15.7	1.0	2
6.45	M8	1.25	74	19.2	40	10	6.8	8.3	9.0	23.2	22.1	1.3	2
8.08	M10	1.50	79	23.0	45	12	8.5	10.3	11.0	27.9	26.6	1.5	2
9.74	M12	1.75	89	28.6	45	14	10.3	12.3	13.5	34.1	32.5	1.5	2

SH

50 862 ...

06000

08000

10000

12000

P	
M	
K	●
N	○
S	
H	
O	○

- 
- Find the cutting data standard values here.

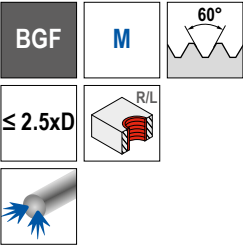
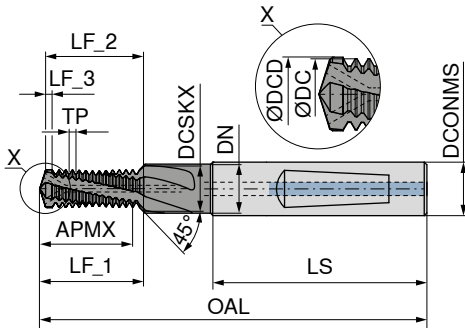
→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

MonoThread – Drill thread milling cutter with chamfer facet – BGF

- ▲ Profile-corrected
- ▲ Specially designed for gray cast iron (GJL)
- ▲ For pre-cast core holes



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCD mm	DCSKX mm	DN mm	LF_1 mm	LF_2 mm	LF_3 mm	ZEFP
4.85	M6	1.00	62	13.4	36	8	5.0	6.3	6.6	16.6	15.5	0.8	4
6.61	M8	1.25	74	19.3	40	10	6.8	8.3	9.0	23.3	21.8	1.0	4

SH	SH
50 540 ... 06000	50 541 ... 08000

P	
M	
K	
N	● ○
S	○
H	
O	

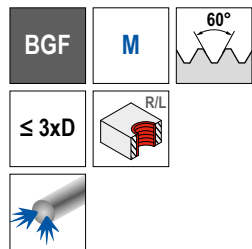
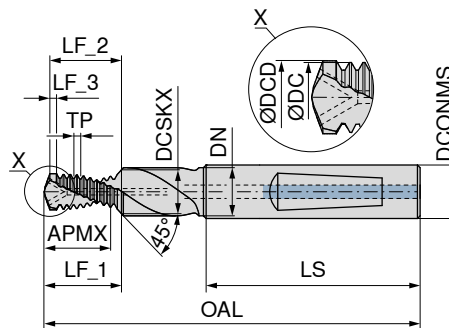
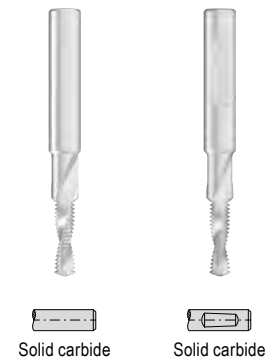
- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

MonoThread – Drill thread milling cutter with chamfer facet – BGF

▲ Profile-corrected

▲ Specially designed for cast aluminum alloy with Si < 10%



DC mm	Thread	TP mm	OAL mm	APMX mm	LS mm	DCONMS _{h6} mm	DCD mm	DCSKX mm	DN mm	LF_1 mm	LF_2 mm	LF_3 mm	ZEFP
3.24	M4	0.70	58	11.55	36	6	3.3	4.3	4.5	13.16	12.54	0.14	2
4.10	M5	0.90	63	14.77	36	6	4.2	5.3	5.5	16.73	15.94	0.16	2
4.85	M6	1.00	68	17.42	36	8	5.0	6.3	6.6	19.83	18.89	0.20	2
6.45	M8	1.25	82	22.97	40	10	6.8	8.3	9.0	26.11	24.89	0.25	2

SH	SH
50 544 ...	50 543 ...
	04000
	05000
06000	06000
08000	08000

P	
M	
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S	•
H	
O	



→ Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.

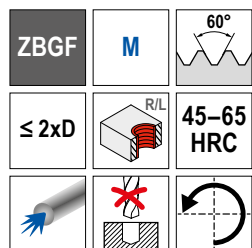
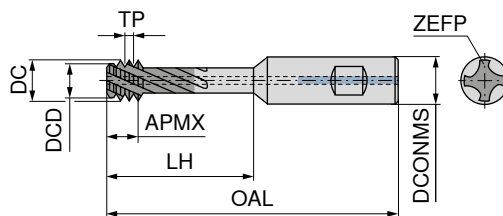


When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Circular drill thread milling cutter – ZBGF

▲ Note: left-hand cutting (M04)

▲ Profile-corrected



TICN



Solid carbide

DC mm	Thread	TP mm	APMX mm	LH mm	DCONMS _{h6} mm	DCD mm	OAL mm	ZEFP
2.3	M3x0,5	0.50	2.0	7.0	6	2.10	51	4
3.0	M4x0,7	0.70	2.8	9.4	6	2.60	51	4
3.8	M5x0,8	0.80	3.2	11.6	6	3.40	51	4
4.6	M6x1 - M7x1	1.00	4.0	14.0	8	4.10	60	4
6.2	M8x1,25 - M10x1,25	1.25	5.0	19.0	10	5.60	71	4
7.8	M10x1,5 - M12x1,5	1.50	6.0	25.0	10	7.00	76	4
9.2	M12x1,75	1.75	7.0	31.0	12	8.30	86	4
11.1	M14x2 - M16x2	2.00	8.0	36.0	16	10.04	98	4

CS

50 840 ...

030 ¹⁾040 ¹⁾050 ¹⁾060 ¹⁾

080

100

120

140

P	
M	
K	
N	
S	○
H	●
O	○

1) Without through coolant supply



- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_r or center path feed v_{fm} .



Caution: left-hand cutting (M04) → spindle rotation left!

CoreLine – Shank thread milling cutter – HR

▲ Available on request from M3

HR

M

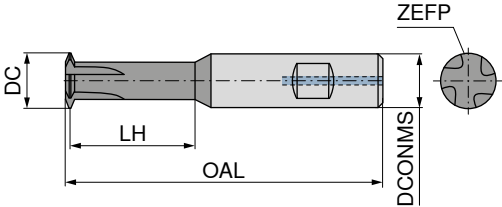


$\leq 3xD$



46-60
HRC





DC mm	Thread	TP mm	LH mm	DCONMS _{h6} mm	OAL mm	ZEFP
3.14	M4	0.70	9	6	55	3
3.95	M5	0.80	11	6	55	3
4.68	M6 - M7	1.00	16	8	60	3
6.22	M8 - M9	1.25	22	10	71	4
7.79	M10 - M12X1,5	1.50	26	10	76	4
7.79	M10 - M12	1.50	26	10	76	4
9.38	M12	1.75	27	12	86	4

CS	CS
50 546 ...	50 547 ...
04000	04000
05000	05000
06000	06000
08000	08000
10000	
	10000
12000	12000

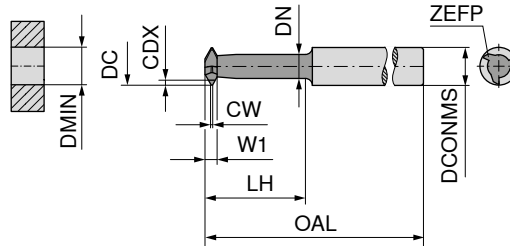
P	○	○
M	○	○
K	○	○
N	○	○
S	○	○
H	●	●
O	○	○

 → Find the cutting data standard values here.

 Other dimensions are available on request.

CoreLine – Solid carbide circular thread milling cutter – Full profile – MicroMill

▲ Profile-corrected



CWX500



Solid carbide

DC mm	Thread	TP mm	W1 mm	CW mm	CDX mm	LH mm	OAL mm	DN mm	DCONMS _{h6} mm	ZEFP	DMIN mm
1.18	M1,6	0.35	0.40	0.04	0.19	4.0	32	0.64	3	3	1.25
1.38	M1,8	0.35	0.50	0.04	0.19	5.0	32	0.70	3	3	1.45
1.50	M2	0.40	0.56	0.05	0.22	5.0	32	0.90	3	4	1.60
1.95	M2,5	0.45	0.60	0.06	0.25	6.0	32	1.15	3	4	2.05
2.40	M3	0.50	0.60	0.06	0.27	7.0	32	1.60	3	4	2.50
2.80	M3,5	0.60	0.74	0.08	0.33	8.0	32	1.80	3	4	2.90
3.10	M4	0.70	0.82	0.09	0.38	9.0	44	1.98	5	4	3.30
3.60	M5	0.80	0.98	0.10	0.43	10.0	44	2.20	5	4	4.20
4.10	M6	1.00	0.98	0.13	0.54	12.2	44	2.70	5	4	5.00

CS

53 052 ...

160
180
200
250
300
350
400
500
600

P	●
M	●
K	●
N	●
S	●
H	●
O	●

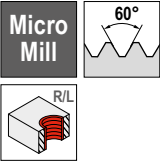
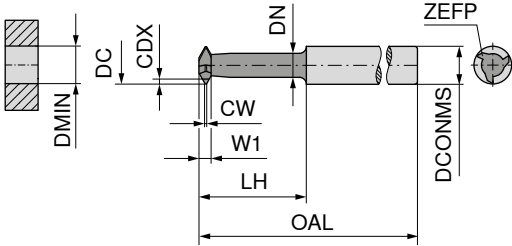


- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Solid carbide circular thread milling cutter – Partial profile – MicroMill



DC mm	TP mm	W1 mm	CW mm	CDX mm	LH mm	OAL mm	DN mm	DCONMS _{h6} mm	ZEFP	DMIN mm
5.8	0,5 - 1,5	2	0.06	0.91	15.2	58	3.5	6	3	6
7.8	0,5 - 1,5	2	0.06	0.91	25.4	68	5.5	8	3	8
7.8	1,0 - 2,0	2	0.12	1.19	25.4	68	5.0	8	3	8

CS
53 053 ...
010
110
120

P	●
M	●
K	●
N	●
S	●
H	●
O	●



- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.

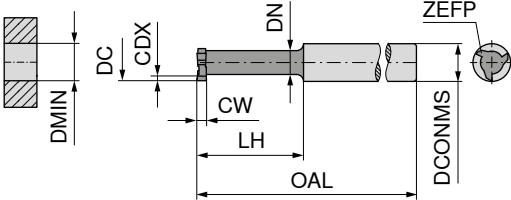


When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Solid carbide circular milling cutter – MicroMill

Micro
Mill





CWX500




Solid carbide

DC mm	CW _{±0.02} mm	CDX mm	LH mm	OAL mm	DN mm	DCONMS _{h6} mm	ZEFP	DMIN mm
5.8	0.7	0.8	15.2	58	3.8	6	3	6
	0.8	0.8	15.2	58	3.8	6	3	6
	0.9	0.8	15.2	58	3.8	6	3	6
	1.0	0.8	15.2	58	3.8	6	3	6
	1.5	0.8	15.2	58	3.8	6	3	6
7.8	0.7	1.2	25.4	68	5.0	8	3	8
	0.8	1.2	25.4	68	5.0	8	3	8
	0.9	1.2	25.4	68	5.0	8	3	8
	1.0	1.2	25.4	68	5.0	8	3	8
	1.5	1.2	25.4	68	5.0	8	3	8
	2.0	1.2	25.4	68	5.0	8	3	8

CS

53 050 ...

070

080

090

100

150

170

180

190

200

250

300

P

M

K

N

S

H

O



→ Find the cutting data standard values here.
→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Solid carbide circular milling cutter – MicroMill

Micro Mill

CWX500

Solid carbide

DC mm	W1 mm	CW mm	CDX mm	LH mm	OAL mm	DN mm	DCONMS _{H6} mm	ZEFP	DMIN mm
5.8	2	0.2	0.8	15	58	4.2	6	3	6
	2	0.2	0.8	25	68	4.2	6	3	6
7.8	2	0.2	1.2	25	68	5.0	8	3	8
	2	0.2	1.2	35	78	5.0	8	3	8

CS

53 051 ...

010

020

110

120

P

M

K

N

S

H

O

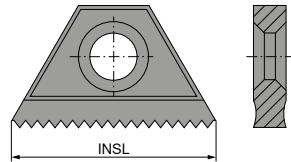
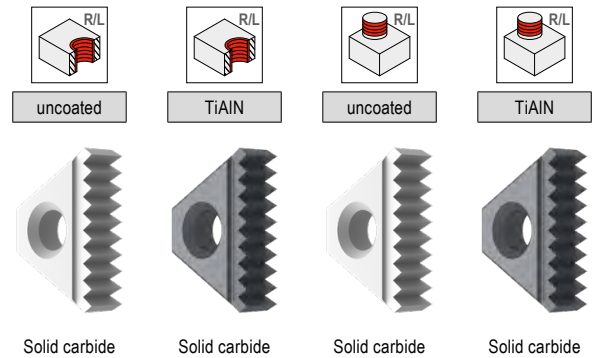
-
- Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Thread milling insert – MWN

▲ Can be used on both sides (except for INSL 10.4)



INSL mm	TP mm	IH 50 890 ...	IH 50 890 ...	IH 50 891 ...	IH 50 891 ...
10.4	0.50	100			
	0.75	101			
	1.00	102	302		
	1.25	103			
	1.50	104	304		
11.0	0.50	120			
	0.75	121			
	1.00	122	322		
	1.25	123			
	1.50	124	324		
16.0	0.50	140			
	0.75	141			
	1.00	142	342	142	342
	1.25	143		143	
	1.50	144	344	144	344
	1.75	145		145	
	2.00	146	346	146	346
27.0	1.00	162	362	162	362
	1.25	163		163	
	1.50	164	364	164	364
	1.75	165			
	2.00	166	366	166	366
	2.50	167		167	
	3.00	168	368	168	368
	3.50	169		169	
	4.00	170		170	
P		●	●	●	●
M		○	●	○	●
K		●	●	●	●
N		●	●	●	●
S					
H					
O		●	○	●	○



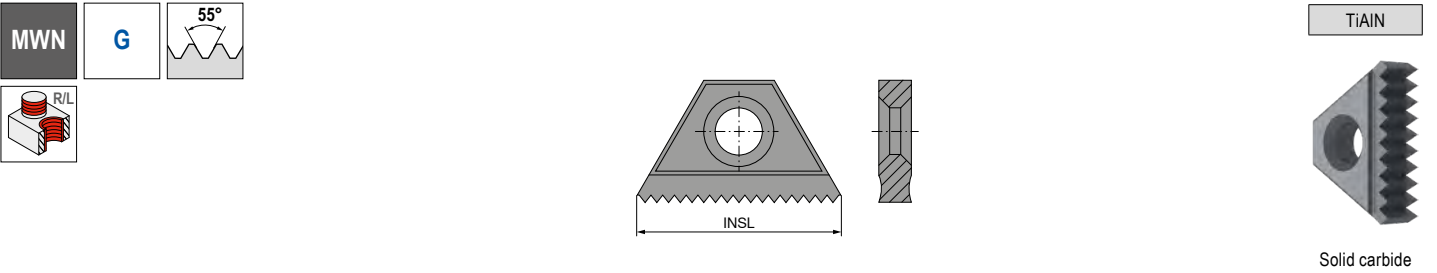
- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Thread milling insert – MWN

▲ Can be used on both sides (except for INSL 10.4)

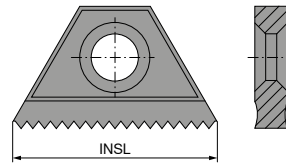
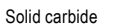


INSL mm	TPI 1/"	TP mm	IH
10.4	19	1.337	50 895 ...
			300
16.0	14	1.814	342
	11	2.309	344
27.0	11	2.309	366
P			●
M			●
K			●
N			●
S			●
H			●
O			○

→ Find the cutting data standard values here.
→ Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

▲ Can be used on both sides (except for INSL 10.4)



- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_r or center path feed v_{fm} .

CoreLine – Thread milling insert – MWN

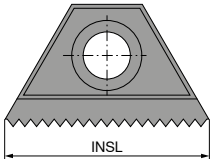
▲ Double sided

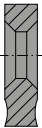
MWN

Pg

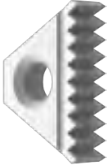








uncoated



Solid carbide

INSL mm	TPI 1/"	TP mm	IH	
16	18	1.411	50 896 ...	142
	16	1.588		144
P				●
M				○
K				●
N				●
S				
H				
O				●

- 
- Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.



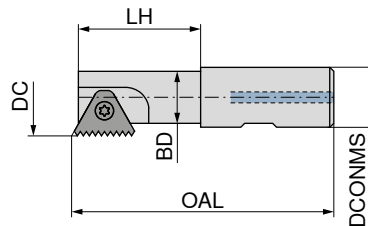
When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Circular milling cutter – MWN

▲ INSL refers to milling inserts

Scope of supply:

Includes key



Steel

INSL mm	BD mm	LH mm	DCONMS _{h6} mm	OAL mm	DC mm	Tightening torque Nm	TO
10.4	6.8	12	12	69	9.0	0,9	50 843 ...
	6.8	17	20	84	9.0	0,9	101 102
11.0	8.9	12	12	70	11.5	1,2	111 112
	8.9	20	20	85	11.5	1,2	
16.0	13.6	22	16	90	17.0	2,5	161 162 163
	16.6	43	20	95	20.0	2,5	
	18.6	25	25	125	22.0	2,5	
27.0	24.0	52	25	110	30.0	9,0	271 273 272 274
	31.0	58	32	120	37.0	9,0	
	24.0	92	25	150	30.0	9,0	
	31.0	98	32	160	37.0	9,0	



→ Find the formulas for calculating the cutting data here.



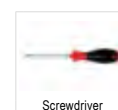
When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

Pilot hole diameter for circular milling cutter 50 843 ...

BD	0,5 mm 48 G/"	0,75 mm 32 G/"	1,0 mm 24 G/"	1,25 mm 20 G/"	1,5 mm 16 G/"	TP 2,0 mm 12 G/"	2,5 mm 10 G/"	3,0 mm 8 G/"	3,5 mm 7 G/"	4,0 mm 6 G/"
6,8	9,5	10	10,7	11,4	12					
8,9	12	12,5	13,2	13,9	14,5					
13,6	17,6	18,2	19	19,6	20	21				
16,6	20,7	21,4	22	22,6	23	24				
18,6	22,7	23,4	24	24,6	25	26				
24,0	30,7	31,4	32	32,8	33,5	34,6	36,6	39	42	45
31,0	38	38,6	39,5	40,4	41	42	44	46,5	49	52

Spare parts INSL

10,4	T07	109	M2,2x5,0	200
11	T08	110	M2,6x6,5	201
16	T10	112	UNC5-40 x 8	202
27	T25	115	M5x15	203



Screwdriver

AS

80 950 ...



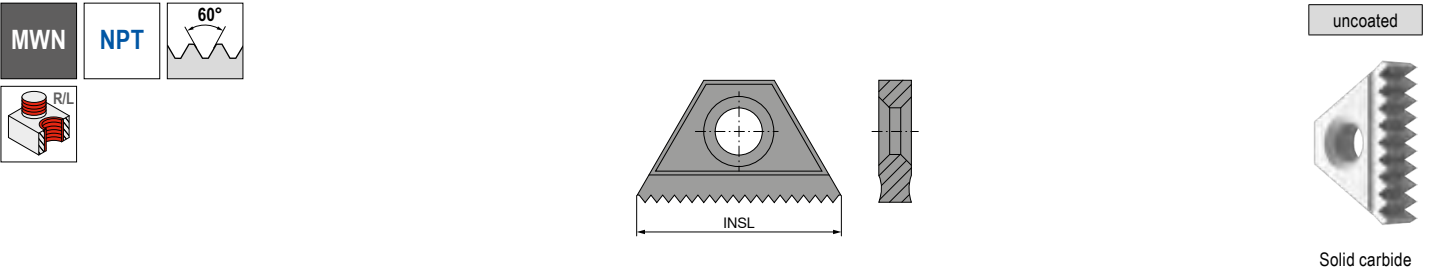
Clamping screw

AS

70 950 ...

CoreLine – Thread milling insert – MWN

▲ Double sided



INSL mm	TPI 1/"	TP mm	IH 50 897 ...
16	14.0	1.814	142
	11.5	2.209	144
27	11.5	2.209	164
	8.0	3.175	166
P			●
M			○
K			●
N			●
S			
H			
O			●



→ Find the cutting data standard values here.
→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

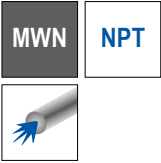
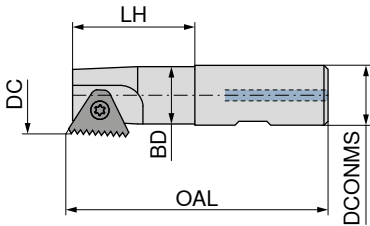


Note! Threading inserts are marked R (right-hand thread) and L (left-hand thread). The standard tool holder cannot be used to produce a left-hand thread! Tool holder for left-hand thread available on special request.

CoreLine – Circular milling cutter – MWN

▲ INSL refers to milling inserts

Scope of supply:
Includes key



Steel

INSL mm	BD mm	Thread	LH mm	DCONMS _{h6} mm	OAL mm	DC mm	Tightening torque Nm
16	12.5	NPT 1/2	22	16	90	15.5	2,5
	15.0	NPT 3/4 - 1 1/4	23	20	85	19.0	2,5
27	24.0	NPT 1 1/2 - 2	52	25	110	30.0	9,0
	31.0	NPT > 2	58	32	120	37.0	9,0

TO
50 844 ...
161
162
271
272



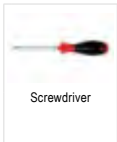
→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

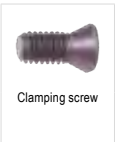
Spare parts
INSL

16	T10	112	UNC5-40 x 8	202
27	T25	115	M5x15	203



Screwdriver

AS
80 950 ...



Clamping screw

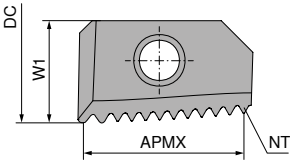
AS
70 950 ...

CoreLine – Thread milling insert – GZD

GZD

M

MF



Ti500

Solid carbide

DC mm	TP mm	W1 mm	APMX mm	NT
12	1.0	7.5	12.0	13
	1.5	7.5	10.5	8
17	1.0	11.0	16.0	17
	1.5	11.0	16.5	12
	2.0	11.0	16.0	9
20	1.0	7.5	12.0	13
	1.5	7.5	10.5	8
25	1.0	11.0	16.0	17
	1.5	11.0	16.5	12
	2.0	11.0	16.0	9

IH

50 863 ...

300

302

310

312

314

320

322

330

332

334

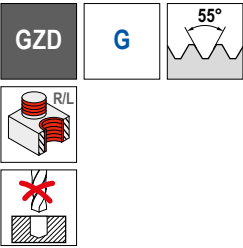
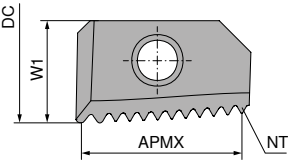
P	●
M	●
K	●
N	●
S	●
H	
O	

→ Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Thread milling insert – GZD



Solid carbide

DC mm	TPI 1/"	W1 mm	APMX mm	NT
12	14	7.5	9.07	6
17	14	11.0	16.33	10
	14	11.0	16.33	10
	11	11.0	16.16	8
25	14	11.0	16.33	10
	11	11.0	16.16	8

50 864 ...
300
312 ¹⁾
314 ²⁾
310
332
330

P	●
M	●
K	●
N	●
S	●
H	
O	

- 1) Thread: 5/8 – 3/4 – 7/8
- 2) 1/2" profile-corrected

→ Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.

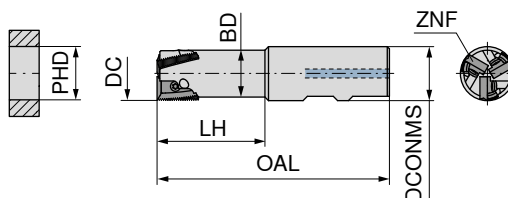
When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Circular milling cutter – GZD

Scope of supply:

Includes key

GZD



DC mm	LH mm	DCONMS _{h6} mm	OAL mm	BD mm	ZNF	PHD mm	Tightening torque Nm	TO
12	18	16	74.0	9.4	1	14	1,1	50 842 ... 121
17	30	16	79.0	13.7	1	19	3,8	171
20	32	20	83.0	17.5	3	22	1,1	201
25	50	25	107.6	21.7	3	26	3,8	251
	85	25	142.6	21.7	3	26	3,8	252 ¹⁾

1) Heavy metal version with mounted head



→ Find the formulas for calculating the cutting data here.

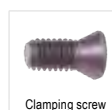
When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_c or center path feed v_{fm} .

Spare parts

DC			AS		AS
12	T08 - IP	039	80 950 ...	M2,5x6,5	244
17	T15 - IP	120		M4x7,5	245
20	T08 - IP	039		M2,5x6,5	244
25	T15 - IP	120		M4x7,5	245

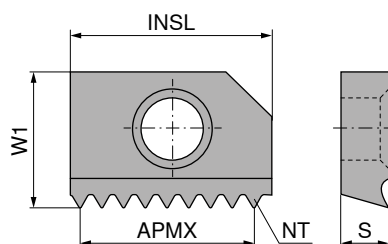
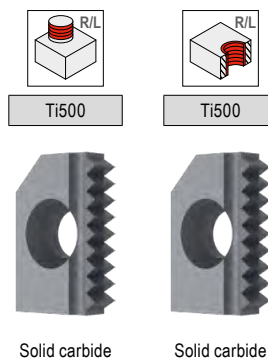


Screwdriver



Clamping screw

CoreLine – Thread milling insert – GZG



INSL mm	TP mm	W1 mm	APMX mm	S mm	NT
14.5	0.50	10.0	13.50	3.18	28
	0.75	10.0	13.50	3.18	19
	1.00	10.0	13.00	3.18	14
	1.25	10.0	12.50	3.18	11
	1.50	10.0	12.00	3.18	9
	1.75	10.0	12.25	3.18	8
	2.00	10.0	12.00	3.18	7
	2.50	10.0	10.00	3.18	5
	2.50	10.0	10.00	3.18	5
15.0	3.00	10.5	12.00	3.18	5
	3.50	10.5	10.50	3.18	4
21.0	1.00	10.0	19.00	3.18	20
	1.50	10.0	19.50	3.18	14
	1.50	10.0	18.00	3.18	13
	2.00	10.0	18.00	3.18	10
26.0	1.50	15.0	24.00	5.0	17
	2.00	15.0	24.00	5.0	13
	3.00	15.0	21.00	5.0	8
	3.50	15.0	20.00	5.0	7
	4.00	15.0	20.00	5.0	6

IH	IH
50 887 ...	50 885 ...
	350
	352
304	354
	356
308	358
	360
312	362
	364
	366 ¹⁾
	370 ²⁾
	372 ²⁾
	380
	382
320	384
	390
	392
	396
	398
	400

P	•	•
M	•	•
K	•	•
N	•	•
S	•	•
H		
O		

1) M20x2.5 profile-corrected

2) Without chamfer



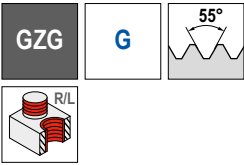
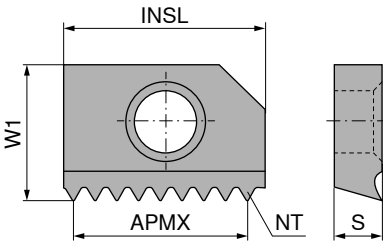
→ Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_r or center path feed v_{fm} .

CoreLine – Thread milling insert – GZG



INSL mm	TPI 1/"	TP mm	W1 mm	APMX mm	S mm	NT
14.5	18	1.411	10	11.28	3.18	9
	16	1.587	10	11.11	3.18	8
	14	1.814	10	12.69	3.18	8
	12	2.116	10	10.58	3.18	6
	11	2.309	10	11.54	3.18	6
21.0	14	1.814	10	18.14	3.18	11
	11	2.309	10	18.47	3.18	9
26.0	11	2.309	15	23.09	5.0	11

IH
50 888 ...
310
312
314
316
318
320
322
330

P	●
M	●
K	●
N	●
S	●
H	
O	

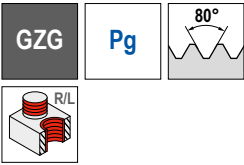
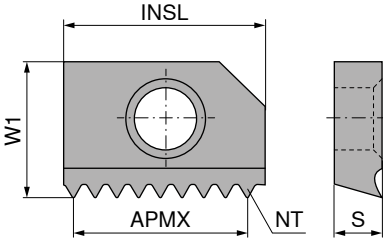


- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Thread milling insert – GZG



INSL mm	TPI 1/"	TP mm	W1 mm	APMX mm	S mm	NT
14.5	18	1.411	10	12.69	3.18	10
	16	1.587	10	11.11	3.18	8

IH
50 894 ...
302
304

P	●
M	●
K	●
N	●
S	●
H	
O	

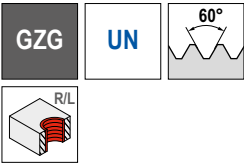
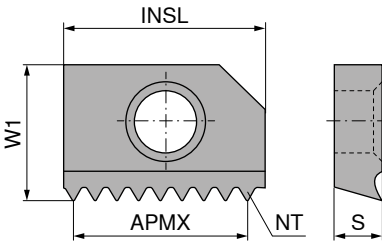


- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Thread milling insert – GZG



INSL mm	TPI 1/"	TP mm	W1 mm	APMX mm	S mm	NT
14.5	18	1.411	10	12.69	3.18	10
	16	1.587	10	12.70	3.18	9

21.0	16	1.587	10	19.05	3.18	13
	14	1.814	10	18.14	3.18	11
	12	2.116	10	18.04	3.18	10

IH
50 889 ...
310
312
320
322
324

P	●
M	●
K	●
N	●
S	●
H	
O	



- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



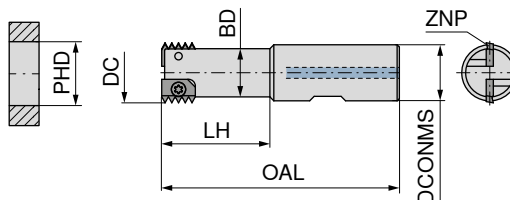
When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Circular milling cutter – GZG

▲ INSL refers to milling inserts

Scope of supply:

Includes key



INSL mm	DC mm	LH mm	DCONMS _{h6} mm	OAL mm	BD mm	ZNP	PHD mm	Tightening torque Nm
14.5	16	30.0	16	78	12.7	1	18.5	3,8
	16	50.0	16	98	12.7	1	17.0	3,8
	20	60.0	20	110	16.8	1	23.0	3,8
	25	48.2	25	106	21.5	2	30.0	3,8
	25	92.2	25	150	21.5	2	30.0	3,8
15.0	18	30.0	16	79	12.7	1	20.0	3,8
	22	60.0	20	110	16.8	1	26.0	3,8
	27	48.2	25	106	21.5	2	32.0	3,8
21.0	16	31.3	20	85	12.7	1	18.5	3,8
	22	32.8	25	92	18.7	1	26.0	3,8
	22	62.8	25	122	18.7	1	26.0	3,8
	28	38.3	32	102	24.7	2	35.0	3,8
	28	78.3	32	142	24.5	2	35.0	3,8
26.0	25	48.5	25	107	20.0	1	30.0	3,8

TO
50 841 ...
016
017 ¹⁾
020
025
026 ¹⁾
218
222
227
316
322
323 ¹⁾
328
327 ¹⁾
125

1) Heavy metal version



→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

Spare parts for article number

		Screwdriver		Clamping screw	
		AS		AS	
		80 950 ...		70 960 ...	
50 841 016	T15 - IP	120	M4x6,9	237	
50 841 017	T15 - IP	120	M4x6,9	237	
50 841 020	T15 - IP	120	M4x7,5	245	
50 841 025	T15 - IP	120	M4x8	242	
50 841 026	T15 - IP	120	M4x8	242	
50 841 218	T15 - IP	120	M4x6,9	237	
50 841 222	T15 - IP	120	M4x6,9	237	
50 841 227	T15 - IP	120	M4x8	242	
50 841 316	T15 - IP	120	M4x6,9	237	
50 841 322	T15 - IP	120	M4x6,9	237	
50 841 323	T15 - IP	120	M4x8	242	
50 841 328	T15 - IP	120	M4x8	242	
50 841 327	T15 - IP	120	M4x8	242	
50 841 125	T15 - IP	120	M4x11,5	241	

CoreLine – Thread milling insert – Partial profile – EAW

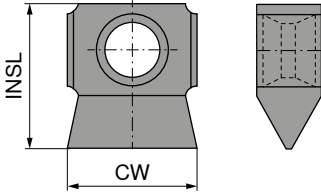
EAW

M

UN







TiN



Solid carbide

DC mm	TP mm	TPI 1/"	CW mm	INSL mm
16,5	1,5 - 3,0	16 - 10	5	7.0
18	2,5 - 3,5	10 - 7	5	7.8

IH

50 867 ...

115

225

P

M

K

N

S

H

O



→ Find the cutting data standard values here.

CoreLine – Thread milling insert – Partial profile – EAW

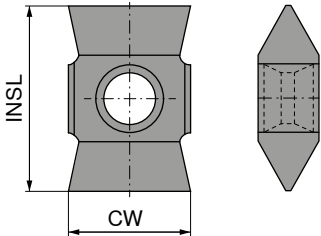
EAW

M

UN







TiN



Solid carbide

DC mm	TP mm	TPI 1/"	CW mm	INSL mm
23,85	1,5 - 2,5	16 - 10	6.35	9.52
23,85	2,5 - 4,0	10 - 6	6.35	9.52
32,85	1,5 - 2,5	16 - 10	8.50	13.50
32,85	2,5 - 5,5	10 - 4,5	8.50	13.50

IH

50 860 ...

315

325

415

425

P

M

K

N

S

H

O



→ Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.



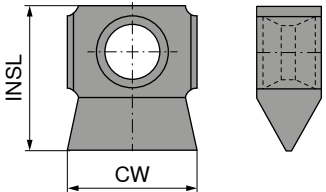
When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Thread milling insert – Partial profile – EAW

EAW

G




Solid carbide

DC mm	TP mm	TPI 1/"	CW mm	INSL mm
16,5	1.814	14	5	7

TiN

IH

50 868 ...

114

P	●
M	●
K	●
N	●
S	●
H	○
O	○

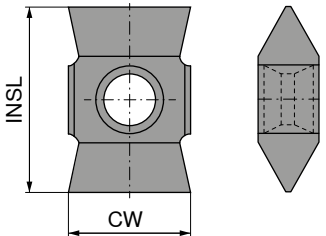
 → Find the cutting data standard values here.

CoreLine – Thread milling insert – Partial profile – EAW

EAW

G




Solid carbide

DC mm	TP mm	TPI 1/"	CW mm	INSL mm
23,85	2.309	11	6.35	9.52
32,85	2.309	11	8.50	13.50

TiN

IH

50 861 ...

311

411

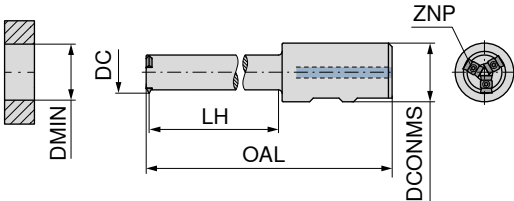
P	●
M	●
K	●
N	●
S	●
H	○
O	○

 → Find the cutting data standard values here.
 → Find the formulas for calculating the cutting data here.

 When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Circular milling cutter – EAW

Scope of supply:
Includes key



DC mm	DMIN mm	TP mm	TPI 1/"	LH mm	DCONMS _{h6} mm	OAL mm	ZNP	Tightening torque Nm
16,5 / 18,0	17,5 / 19,0	1,5 - 3,5	16 - 10	60	20	114	2	0,9
23,85	25,5	1,5 - 4,0	24 - 6	90	32	154	3	0,9
32,85	35,0	1,5 - 5,5	16 - 4,5	115	32	179	3	2,5

TO
50 848 ...
020
030
040



→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_c or center path feed v_{fm} .

Spare parts
for article number

50 848 020	T07 - IP	117	M2,5x8,5 - 07IP	739
50 848 030	T07 - IP	117	M2,5x8,5 - 07IP	739
50 848 040	T09 - IP	118	M3x11 - 09IP	740



Screwdriver

AS

80 950 ...

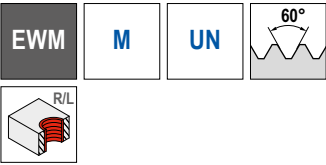
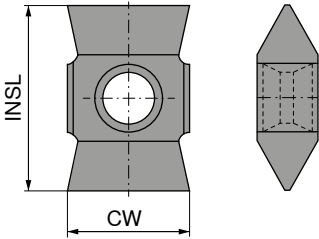


Clamping screw

AS

70 950 ...

CoreLine – Thread milling insert – Partial profile – EWM



DC mm	TP mm	TPI 1/"	CW mm	INSL mm
40,25	1,5 - 3,0	16 - 9	9.5	15.50
40,25	3,0 - 6,0	9 - 4	9.5	15.50
52,55 / 66,55	1,5 - 3,0	16 - 9	12.5	19.00
52,55 / 66,55	3,0 - 6,0	9 - 4	12.5	19.00
92	6,0 - 8,0	4	14.3	28.58

IH
50 870 ...
515
530
615
630
760

P	●
M	●
K	●
N	●
S	●
H	○
O	○



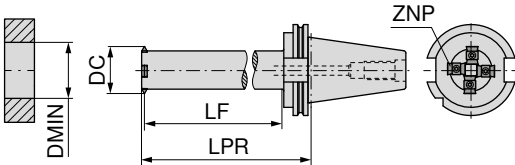
- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Circular milling cutter – EWM

Scope of supply:
Includes key



DIN 69871
Steel

DC mm	DMIN mm	TP mm	TPI 1/"	LF mm	LPR mm	Adapter	ZNP	Tightening torque Nm
40.25	43.0	1,5 - 6,0	16 - 4,0	145	178.7	SK 50	4	5,5
40.25	43.0	1,5 - 6,0	16 - 4,0	145	178.7	SK 40	4	5,5
52.55	56.0	1,5 - 6,0	16 - 4,0	195	229.2	SK 50	4	8,0
66.55	70.5	1,5 - 6,0	16 - 4,0	260	296.2	SK 50	7	8,0
92.00	100.0	6,0 - 8,0	4,0	360	395.0	SK 50	7	8,0

TO
50 849 ...
148
048
164
080
115



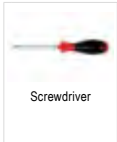
→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_c or center path feed v_{fm} .

Spare parts
DC

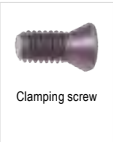
40,25	T15 - IP	120	M4x13 - 15IP	741
52,55 - 92	T20 - IP	121	M5x15 - 20IP	742



Screwdriver

AS

80 950 ...



Clamping screw

AS

70 950 ...

CoreLine – Milling insert for internal thread milling – Full profile – MiniMill

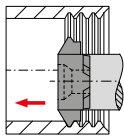
Mini
Mill

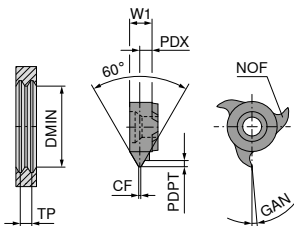
M

60°

≥
M22

R/L





CWX500



Solid carbide

Size	Thread _{min.}	TP mm	DMIN mm	CF mm	PDPT mm	W1 mm	PDX mm	GAN °	NOF	EH
18	M22	1.50	17.7	0.18	0.81	5.85	4.8	5	3	53 011 ...
	M22	1.75	17.7	0.20	0.95	5.85	4.7	5	3	415
	M22	2.00	17.7	0.25	1.08	5.85	4.6	5	3	417
	M24	2.50	17.7	0.31	1.35	5.85	4.4	5	3	420
	M27	3.00	17.7	0.37	1.62	5.85	4.3	5	3	425
	M27	3.50	17.7	0.43	1.89	5.85	4.0	5	3	430
22	M24	1.50	21.7	0.19	0.81	5.85	4.8	5	3	435
	M24	1.50	21.7	0.19	0.81	6.20	5.3	5	6	615
	M27	1.75	21.7	0.22	0.95	6.20	5.2	5	6	715
	M27	1.75	21.7	0.22	0.95	5.85	4.7	5	3	717
	M27	2.00	21.7	0.25	1.08	6.20	5.0	5	6	617
	M27	2.00	21.7	0.25	1.08	5.85	4.6	5	3	720
	M30	3.00	21.7	0.37	1.62	5.85	4.3	5	3	620
	M30	3.00	21.7	0.37	1.62	6.20	4.8	5	6	630
	M30	3.50	21.7	0.43	1.89	5.85	4.0	5	3	730
	M33	4.00	21.7	0.50	2.16	5.85	3.9	5	3	635
	M33	4.00	21.7	0.50	2.16	6.20	4.4	5	6	640
	M33	4.50	21.7	0.56	2.43	5.85	3.7	5	3	740
P										645
M										
K										
N										
S										
H										
O										

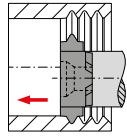
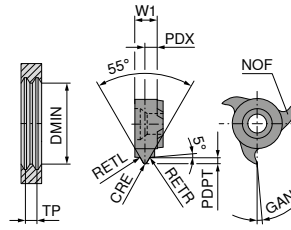
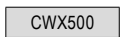


→ Find the cutting data standard values here.
→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

Mini Mill	G	55°
≥ G 3/8"	R/L	



Solid carbide

Size	Thread _{min.}	TP mm	DMIN mm	TPI 1/"	W1 mm	PDX mm	PDPT mm	CRE mm	RETL mm	RETR mm	GAN °	NOF		53 012 ...
10	G 3/8"	1.34	11.7	19	3.60	2.5	0.860	0.18	0.18	0.18	5	3		113
	G 1/2"	1.81	11.7	14	3.60	2.3	1.160	0.24	0.24	0.24	5	3		118
	G 1"	2.31	11.7	11	3.60	2.0	1.480	0.31	0.31	0.31	5	3		123
18		1.34	17.7	19	5.85	4.9	0.856	0.18	0.18	0.18	5	3		219
	G 3/4"	1.81	17.7	14	5.85	4.6	1.160	0.24	0.24	0.24	5	3		214
	G 1"	2.31	17.7	11	5.85	4.4	1.480	0.31	0.31	0.31	5	3		211
22	G 1"	2.31	21.7	11	5.85	4.0	1.480	0.31	0.31	0.31	5	3		311
		3.17	21.7	8	5.85	3.5	2.030	0.43	0.43	0.43	5	3		308
	BSW 1 1/2"	4.23	21.7	6	5.85	3.1	2.710	0.58	0.58	0.58	5	3		306
P														●
M														●
K														●
N														●
S														○
H														
O														●

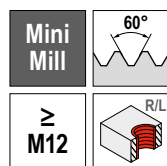
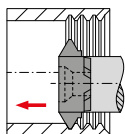
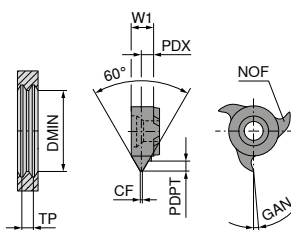


- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_t or center path feed v_{fm} .

CoreLine – Milling insert for internal thread milling – Partial profile – MiniMill



CWX500



Solid carbide

Size	Thread _{min.}	TP mm	DMIN mm	CF mm	PDPT mm	W1 mm	PDX mm	GAN °	NOF	
10	M12	1,0 - 1,75	9.8	0.13	1.02	3.20	2.4	5	6	53 010 ...
	M14	1,0 - 1,75	11.7	0.13	1.08	3.60	2.8	5	3	017
	M14	1,0 - 2,0	10.1	0.13	1.25	3.20	2.2	5	6	010
	M14	1,0 - 2,0	11.7	0.13	1.25	3.60	2.8	5	3	021
	M16	1,5 - 2,75	11.0	0.19	1.67	3.20	2.0	5	6	020
	M16	1,5 - 2,75	11.7	0.19	1.67	3.60	2.4	5	3	027
	M16	2,0 - 3,0	11.1	0.25	1.78	3.20	1.9	5	6	015
14	M18	1,0 - 1,75	15.7	0.12	1.08	4.60	3.8	5	3	029
	M18	1,0 - 2,0	15.7	0.12	1.25	4.60	3.5	5	3	030
	M20	1,5 - 2,75	15.7	0.18	1.67	4.60	3.5	5	3	210
	M22	2,5 - 3,0	15.7	0.31	1.78	4.60	3.4	5	3	220
18	M22	1,0 - 1,75	17.7	0.12	1.03	5.85	5.0	5	3	215
	M22	1,0 - 2,0	17.7	0.12	1.19	5.85	4.7	5	3	230
	M22	1,0 - 2,0	17.7	0.12	1.19	5.85	5.0	5	6	410
	M22	1,5 - 2,75	17.7	0.19	1.62	5.85	4.6	5	3	412
	M24	2,0 - 3,0	17.7	0.25	1.73	5.85	4.4	5	3	416
	M24	2,0 - 3,5	17.7	0.25	2.06	5.85	4.2	5	3	415
	M24	2,0 - 3,5	17.7	0.25	2.06	5.85	4.3	5	6	425
	M24	2,0 - 3,75	17.7	0.25	2.22	5.85	4.2	5	3	425
	M24	2,5 - 5,0	17.7	0.31	2.98	5.85	3.8	5	3	455
22	M27	1,0 - 2,0	21.7	0.12	1.19	5.85	4.6	5	3	434
	M27	1,0 - 2,0	21.7	0.12	1.19	6.20	5.0	5	6	420
	M27	1,5 - 2,75	21.7	0.18	1.62	5.85	4.5	5	3	430
	M27	2,0 - 3,75	21.7	0.25	2.22	5.85	4.2	5	3	435
	M27	2,5 - 4,5	21.7	0.25	2.70	5.85	3.7	5	3	610
	M27	2,0 - 4,5	21.7	0.25	2.70	6.05	4.2	5	6	710
	M30	2,5 - 5,0	21.7	0.31	2.98	5.85	3.8	5	3	615
	M30	3,5 - 6,0	21.7	0.44	3.52	5.85	3.4	5	3	620
28	M30	3,5 - 6,5	21.7	0.44	3.84	5.85	3.2	5	3	655
	M33	1,0 - 2,0	27.7	0.12	1.20	6.60	4.5	5	3	755
	M33	1,5 - 2,5	27.7	0.18	1.49	6.60	4.3	5	3	630
	M33	1,5 - 2,5	27.7	0.19	1.60	6.10	5.0	5	6	640
	M36	2,5 - 5,0	27.7	0.38	2.93	6.10	2.3	5	6	645
	M36	2,5 - 5,0	27.7	0.37	2.93	6.60	4.0	5	3	820
32	M39	4,0 - 6,0	27.7	0.62	3.37	6.60	3.6	5	3	825
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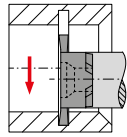
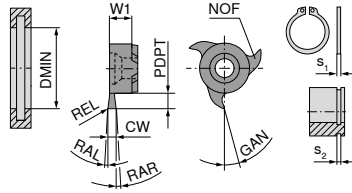


→ Find the cutting data standard values here.
 → Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_r or center path feed v_{fm} .

CoreLine – Milling insert for circlip grooves – MiniMill



Size	DMIN mm	S ₂ H13 mm	CW _{-0.02} mm	PDPT mm	W1 mm	REL mm	RAL °	RAR °	GAN °	s ₁ mm	NOF	
10	10	0.70	0.74	1.5	3.50		1	1	15	0.60	3	
	10	0.80	0.84	1.5	3.50		1	1	15	0.70	3	
	10	0.90	0.94	1.5	3.50		1	1	15	0.80	3	
	10	1.10	1.21	1.5	3.50		3	3	15	1.00	3	
	10	1.30	1.41	1.5	3.50	0.10	3	3	15	1.20	3	
	10	1.60	1.71	1.5	3.50	0.10	3	3	15	1.50	3	
	12	1.10	1.21	2.5	3.50		3	3	15	1.00	3	
	12	1.30	1.41	2.5	3.50	0.10	3	3	15	1.20	3	
	12	1.60	1.71	2.5	3.50	0.10	3	3	15	1.50	3	
18	18	0.70	0.74	1.5	5.75		1	1	15	0.60	3	
	18	0.80	0.84	1.7	5.75		1	1	15	0.70	3	
	18	0.90	0.94	1.9	5.75		1	1	15	0.80	3	
	18	1.10	1.21	3.5	5.75		3	3	15	1.00	3	
	18	1.30	1.41	3.5	5.75	0.10	3	3	15	1.20	3	
	18	1.60	1.71	3.5	5.75	0.10	3	3	15	1.50	3	
22	22	0.70	0.74	1.5	5.70		1	1	15	0.60	3	
	22	0.80	0.84	1.7	5.70		1	1	15	0.70	3	
	22	0.90	0.94	1.9	5.70		1	1	15	0.80	3	
	22	1.00	1.04	2.1	5.70		1	1	15	0.90	3	
	22	1.10	1.21	2.5	5.70		1	1	15	1.00	3	
	22	1.30	1.41	4.5	5.70	0.10	3	3	15	1.20	3	
	22	1.60	1.71	4.5	5.70	0.10	3	3	15	1.50	3	
	22	1.85	1.96	4.5	5.70	0.15	3	3	15	1.75	3	
	22	2.15	2.26	4.5	5.70	0.15	3	3	15	2.00	3	
	22	2.65	2.76	4.5	5.70	0.15	3	3	15	2.50	3	
	22	3.15	3.26	4.5	5.70	0.20	3	3	15	3.00	3	
	22	4.15	4.26	4.5	5.70	0.20	3	3	15	4.00	3	
	22	5.15	5.26	4.5	5.70	0.20	3	3	15	5.00	3	
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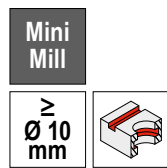
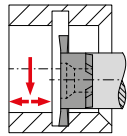
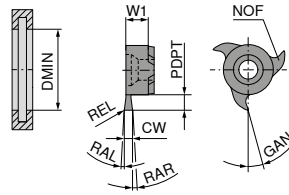


- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Milling insert for groove milling – MiniMill



CWX500



Solid carbide

Size	DMIN mm	CW _{0.02} mm	PDPT mm	W1 mm	REL mm	RAL °	RAR °	GAN °	NOF	
10	10	1.0	1.5	3.50	0.1	3	3	15	3	
	10	1.5	1.5	3.50	0.2	3	3	15	3	
	10	2.0	1.5	3.50	0.2	3	3	15	3	
	10	2.5	1.5	3.50	0.2	3	3	15	3	
	12	1.5	2.0	3.50	0.2	3	3	15	6	
	12	1.5	2.5	3.50	0.2	3	3	15	3	
	12	2.0	2.0	3.50	0.2	3	3	15	6	
	12	2.0	2.5	3.50	0.2	3	3	15	3	
14	14	1.0	2.5	4.50		3	3	15	3	
	14	1.5	2.5	4.50	0.2	3	3	15	3	
	14	2.0	2.5	4.50	0.2	3	3	15	3	
	14	2.5	2.5	4.50	0.2	3	3	15	3	
	16	1.5	3.5	4.50	0.2	3	3	15	3	
	16	2.0	3.5	4.50	0.2	3	3	15	3	
	16	2.5	3.5	4.50	0.2	3	3	15	3	
	16	2.5	3.5	4.50	0.2	3	3	15	3	
18	18	1.5	3.5	5.75	0.1	3	3	15	6	
	18	1.5	3.5	5.75	0.2	3	3	15	3	
	18	2.0	3.5	5.75	0.2	3	3	15	3	
	18	2.0	3.5	5.75	0.2	3	3	15	6	
	18	2.5	3.5	5.75	0.2	3	3	15	6	
	18	2.5	3.5	5.75	0.2	3	3	15	3	
	18	3.0	3.5	5.75	0.2	3	3	15	6	
	18	3.0	3.5	5.75	0.2	3	3	15	3	
	18	4.0	3.5	5.75	0.2	3	3	15	3	
22	22	1.0	4.5	6.20	0.1	3	3	15	6	
	22	1.5	4.5	5.70	0.2	3	3	15	3	
	22	1.5	4.5	6.20	0.1	3	3	15	6	
	22	2.0	4.5	6.20	0.2	3	3	15	6	
	22	2.0	4.5	5.70	0.2	3	3	15	3	
	22	2.5	4.5	6.20	0.2	3	3	15	6	
	22	2.5	4.5	5.70	0.2	3	3	15	3	
	22	3.0	4.5	5.70	0.2	3	3	15	3	
	22	3.0	4.5	6.20	0.2	3	3	15	6	
	22	3.5	4.5	5.70	0.2	3	3	15	3	
	22	4.0	4.5	5.70	0.2	3	3	15	3	
	22	4.0	4.5	6.20	0.2	3	3	15	6	

EH

53 007 ...

010

015

020

025

114

115

119

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840

P	●
M	●
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- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_r or center path feed v_{fm} .

CoreLine – Milling insert for groove milling – MiniMill

Mini
Mill

$\geq \varnothing 10$
mm

CWX500

Solid carbide

Size	DMIN mm	CW _{0.02} mm	PDPT mm	W1 mm	REL mm	RAL °	RAR °	GAN °	NOF	EH	
28	25	2.0	5.0	6.50	0.2	3	3	15	3	53 007 ...	620
	25	2.5	5.0	6.50	0.2	3	3	15	3		625
	25	3.0	5.0	6.50	0.2	3	3	15	3		630
	25	3.5	5.0	6.50	0.2	3	3	15	3		635
	25	4.0	5.0	6.50	0.2	3	3	15	3		640
	28	1.0	6.5	6.25	0.1	3	3	15	6		610
	28	1.5	6.5	6.25	0.1	3	3	15	6		615
	28	1.5	6.5	6.50	0.2	3	3	15	3		715
	28	2.0	6.5	6.25	0.2	3	3	15	6		721
	28	2.0	6.5	6.50	0.2	3	3	15	3		720
	28	2.5	6.5	6.25	0.2	3	3	15	6		726
	28	2.5	6.5	6.50	0.2	3	3	15	3		725
	28	3.0	6.5	6.50	0.2	3	3	15	3		730
	28	3.0	6.5	6.25	0.2	3	3	15	6		731
	28	3.5	6.5	6.50	0.2	3	3	15	3		735
	28	4.0	6.5	6.25	0.2	3	3	15	6		741
	28	4.0	6.5	6.50	0.2	3	3	15	3		740
	28	5.0	6.5	6.50	0.2	3	3	15	3		750
	28	6.0	6.5	6.50	0.2	3	3	15	3		760
P											●
M											●
K											●
N											●
S											○
H											
O											●

→ Find the cutting data standard values here.

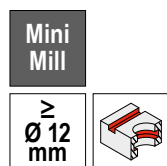
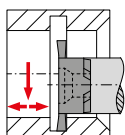
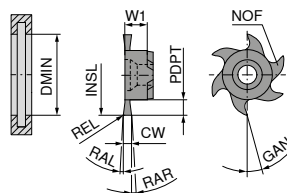
→ Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

Solid carbide

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Milling insert for groove milling, cross-pitched – MiniMill



CWX500



Solid carbide

Size	DMIN mm	INSL mm	CW _{+0,02} mm	PDPT mm	W1 mm	REL mm	RAL °	RAR °	GAN °	NOF	
10	12	11.7	1.5	2.0	3.5	0.2	3	3	15	6	
	12	11.7	2.0	2.0	3.5	0.2	3	3	15	6	
14	16	15.7	1.5	2.5	4.5	0.2	3	3	15	6	
	16	15.7	2.0	2.5	4.5	0.2	3	3	15	6	
	16	15.7	2.5	2.5	4.5	0.2	3	3	15	6	
18	18	17.7	2.0	4.0	5.8	0.2	3	3	15	6	
	18	17.7	2.5	4.0	5.8	0.2	3	3	15	6	
	18	17.7	3.0	4.0	5.8	0.2	3	3	15	6	
	20	19.7	2.0	5.0	5.8	0.2	3	3	15	6	
	20	19.7	2.5	5.0	5.8	0.2	3	3	15	6	
	20	19.7	3.0	5.0	5.8	0.2	3	3	15	6	
22	22	21.7	2.0	4.5	6.2	0.2	3	3	15	6	
	22	21.7	2.5	4.5	6.2	0.2	3	3	15	6	
	22	21.7	3.0	4.5	6.2	0.2	3	3	15	6	
	22	21.7	4.0	4.5	6.2	0.2	3	3	15	6	
	37	36.7	1.5	12.0	6.2	0.1	3	3	15	6	
	37	36.7	2.0	12.0	6.2	0.2	3	3	15	6	
28	25	24.8	2.5	5.0	6.4	0.2	3	3	15	6	
	25	24.8	3.0	5.0	6.4	0.2	3	3	15	6	
	25	24.8	4.0	5.0	6.4	0.2	3	3	15	6	
	25	24.8	5.0	5.0	6.4	0.2	3	3	15	6	
	25	24.8	6.0	5.0	6.4	0.2	3	3	15	6	
	28	27.7	2.5	6.5	6.2	0.2	3	3	15	6	
	28	27.7	3.0	6.5	6.2	0.2	3	3	15	6	
	28	27.7	4.0	6.5	6.2	0.2	3	3	15	6	
	28	27.7	5.0	6.5	6.2	0.2	3	3	15	6	
	28	27.7	6.0	6.5	6.2	0.2	3	3	15	6	
	35	34.7	2.0	10.0	6.2	0.2	3	3	15	6	
	35	34.7	2.5	10.0	6.2	0.2	3	3	15	6	
	35	34.7	3.0	10.0	6.2	0.2	3	3	15	6	
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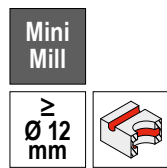
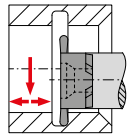
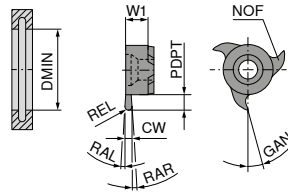


- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_r or center path feed v_{fm} .

CoreLine – Milling insert for groove milling with full radius – MiniMill



CWX500



Solid carbide

Size	DMIN mm	CW _{+0.03} mm	PDPT mm	W1 mm	REL mm	RAL °	RAR °	GAN °	NOF
10	12	2.2	2.5	3.50	1.1	3	3	15	3
14	16	2.2	3.5	4.60	1.1	3	3	15	3
18	18	2.2	3.5	5.75	1.1	3	3	15	3
22	22	1.0	4.5	5.75	0.5	3	3	15	3
	22	1.6	4.5	5.75	0.8	3	3	15	3
	22	2.0	4.5	5.75	1.0	3	3	15	3
	22	2.4	4.5	5.75	1.2	3	3	15	3
	22	2.8	4.5	5.75	1.4	3	3	15	3
	22	3.0	4.5	5.75	1.5	3	3	15	3
	22	4.0	4.5	5.75	2.0	3	3	15	3
	22	4.4	4.5	5.75	2.2	3	3	15	3
	22	5.0	4.5	5.75	2.5	3	3	15	3

EH

53 008 ...

011

111

211

305

308

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312

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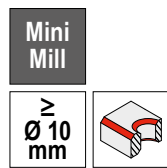
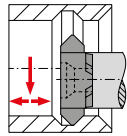
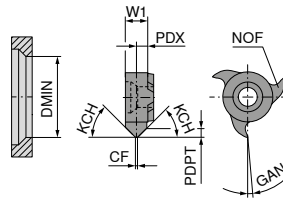


- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Milling insert for groove milling and chamfering – MiniMill



CW500



Solid carbide

Size	DMIN mm	CF _{+0.03} mm	PDPT mm	W1 mm	KCH °	PDX mm	GAN °	NOF	
10	10	0.2	0.35	3.60	15	1.80	5	6	
	10	0.2	0.45	3.60	20	1.80	5	6	
	10	0.2	0.70	3.60	30	1.80	5	6	
	10	0.2	1.20	3.60	45	1.80	5	6	
	12	1.2	0.80	3.50	45	1.20	5	3	
14	16	1.4	1.20	4.50	45	1.60	5	3	
18	18	2.5	1.40	5.85	45	1.70	5	3	
	18	0.2	2.20	5.75	45	3.00	5	6	
22	22	2.0	1.70	5.85	45	2.00	5	3	
	22	0.2	2.50	6.40	45	3.90	5	6	
	22	3.0	3.00	9.40	45	3.25	5	3	
28	28	0.2	1.90	6.05	45	3.75	5	6	
P									●
M									●
K									●
N									●
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H									
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EH

53 009 ...

015

020

030

045

035

145

258

259

358

463

394¹⁾

560

1) Use clamping screw 73 082 006



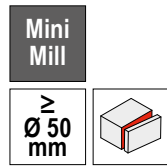
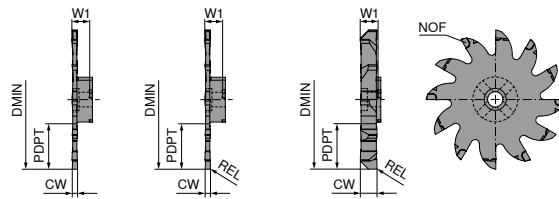
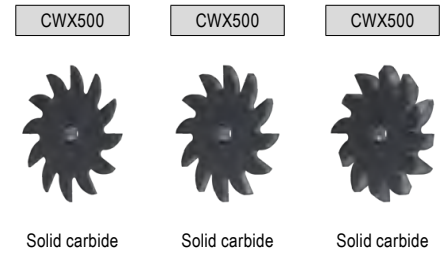
- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Milling insert for slot and multipurpose milling – MiniMill

- ▲ Interface with four driving slots
- ▲ CW 1.5 – 6 mm: cross-pitched



Size	DMIN mm	CW ± 0.02 mm	PDPT mm	W1 mm	REL mm	NOF
50	50	0.5	16.5	6.35		12
	50	1.0	16.5	6.35		12
	50	1.5	16.5	6.35	0.1	12
	50	2.0	16.5	6.35	0.2	12
	50	2.5	16.5	6.35	0.2	12
	50	3.0	16.5	6.35	0.2	12
	50	4.0	16.5	6.35	0.2	12
	50	5.0	16.5	6.35	0.2	12
	50	6.0	16.5	6.35	0.2	12

EH	EH	EH
53 017 ...	53 017 ...	53 017 ...
00500		
01000		
	01500	
	02000	
	02500	
	03000	
		04000
		05000
		06000

P	•	•	•
M	•	•	•
K	•	•	•
N	•	•	•
S	○	○	○
H			
O	•	•	•



- Find the cutting data standard values here.
- Here you will find suitable holders.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Milling insert for part-off – MiniMill

- ▲ PDPT = 12.0 mm in combination with holder 53 003 624
- ▲ Reduce feed rate by 50%!

Mini Mill

≥ Ø 37 mm

CWX500

Solid carbide

Size	DMIN mm	CW ^{+0.02} mm	PDPT mm	W1 mm	REL mm	RAL °	RAR °	NOF	EH 53 013 ...	
22	37	0.5	12	5.6		3	3	6	705 ¹⁾	
	37	0.6	12	5.7		3	3	6	706 ¹⁾	
	37	0.8	12	6.0		3	3	6	708 ¹⁾	
	37	1.0	12	6.2	0.1	3	3	6	710	
	37	1.5	12	6.2	0.1	3	3	6	715	
P									●	
M									●	
K									●	
N									●	
S									○	
H										
O									●	

1) The end face is not ground free to the center

→ Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_c or center path feed v_{fm} .

CoreLine – Set for part-off – MiniMill

- Mini Mill

Scope of supply:

 - ▲ 2 x cutting insert
 - 53 013 715 bore diameter 37 mm
 - ▲ 1 holder
 - 53 003 624
 - ▲ 1 M5 x 12 screw
 - 73 082 005
 - ▲ 1 clamping key – T20



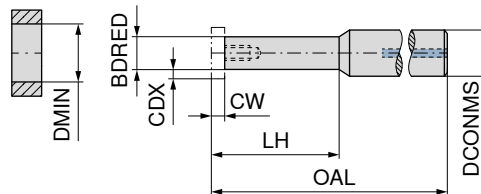
DMIN mm	TO
37	53 014 ...
	990

CoreLine – Circular milling cutter, extra short – MiniMill

▲ Steel version

Scope of supply:

Includes key



Steel

Size	DCONMS mm	BDRED mm	OAL mm	LH mm	DMIN mm	CW mm	CDX mm	Tightening torque Nm	TO
10	10	6.0	60	15.2	9,7 / 11,7	≤3,35	1,4 / 2,5	2,0	53 004 ...
14	10	8.0	60	17.7	13,7 / 15,7	≤4,35	2,5 / 3,5	3,5	015
	13	8.0	70	25.7	13,7 / 15,7	≤4,35	2,5 / 3,5	3,5	217
18	10	9.0	60	17.0	17,7	≤5,6	3,5	4,5	225
	13	9.0	70	25.0	17,7	≤5,6	3,5	4,5	417
22	10	11.3	60	10.7	21,7	≤9,15	4,5	7,0	425
	13	11.3	70	25.7	21,7	≤9,15	4	7,0	610
28	13	14.0	70	10.7	27,7	≤10	6,5	7,0	625
	20	14.0	100	35.7	27,7	≤10	6,5	7,0	810
									835



→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_r or center path feed v_{fm} .

								
		Screwdriver			Clamping screw			Clamping screw
		AS			AS			AS
Spare parts		80 950 ...			73 082 ...			73 082 ...
Size								
10	T08	110					M2,6	002
14	T10	112					M3,5	003
18	T15	113					M4	004
22	T20	114		M5	006		M5	005
28	T20	114					M5	005



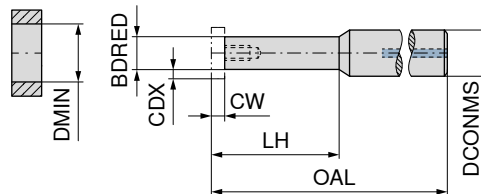
Use clamping screw 73 082 006 for milling insert 53 009 394

CoreLine – Circular milling cutter, short – MiniMill

▲ Steel version

Scope of supply:

Includes key



Size	DCONMS mm	BDRED mm	OAL mm	LH mm	DMIN mm	CW mm	CDX mm	Tightening torque Nm
10	16	6	80	12.0	9,7 / 11,7	≤3,35	1,4 / 2,5	2,0
14	16	8	80	16.0	13,7 / 15,7	≤4,35	2,5 / 3,5	3,5
18	16	9	80	18.0	17,7	≤5,6	3,5	4,5
22	16	12	80	24.0	21,7	≤9,15	4,5	7,0
28	20	14	100	35.7	27,7	≤10	6,5	7,0

TO	TO
53 002 ...	53 003 ...
012	012
216	216
418	418
624	624
	835



→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

Spare parts

Size		AS		AS		AS
10	T08	80 950 ... 110		73 082 ...	M2,6	73 082 ... 002
14	T10	112			M3,5	003
18	T15	113			M4	004
22	T20	114	M5	006	M5	005
28	T20	114			M5	005

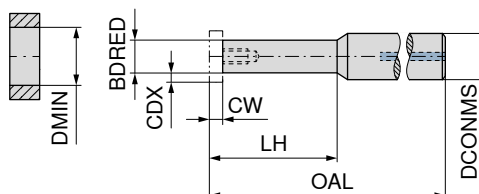


Use clamping screw 73 082 006 for milling insert 53 009 394

CoreLine – Circular milling cutter, vibration-damped – MiniMill

Scope of supply:

Includes key



Size	DCONMS _{h6} mm	BDRED mm	OAL mm	LH mm	DMIN mm	CW mm	CDX mm	Tightening torque Nm	TO 53 001 ...	TO 53 000 ...
10	12	6.0	80	21	9,7 / 11,7	≤3,35	1,4 / 2,5	2,0	021	021
	12	6.0	90	30	9,7 / 11,7	≤3,35	1,4 / 2,5	2,0	030	030
	12	6.0	100	42	9,7 / 11,7	≤3,35	1,4 / 2,5	2,0	042	042
	12	7.3	90	30	9,7 / 11,7	≤3,35	0,9 / 1,85	2,0	130	130
	16	7.3	100	25	9,7 / 11,7	≤3,35	0,9 / 1,85	2,0	025	025
14	12	8.0	95	29	13,7 / 15,7	≤4,35	2,5 / 3,5	3,5	229	229
	12	8.0	110	42	13,7 / 15,7	≤4,35	2,5 / 3,5	3,5	242	242
	12	8.0	120	56	13,7 / 15,7	≤4,35	2,5 / 3,5	3,5	256	256
	12	9.5	110	42	13,7 / 15,7	≤4,35	1,65 / 2,7	3,5	342	342
	16	9.5	110	33	13,7 / 15,7	≤4,35	1,65 / 2,7	3,5	233	233
18	12	9.0	100	32	17,7	≤5,6	3,5	4,5	432	432
	12	9.0	100	45	17,7	≤5,6	3,5	4,5	445	445
	12	9.0	120	64	17,7	≤5,6	3,5	4,5	464	464
	16	9.0	93	25	17,7	≤5,6	3,5	4,5	425	425
	16	9.0	100	32	17,7	≤5,6	3,5	4,5	532	532
	16	9.0	110	45	17,7	≤5,6	3,5	4,5	545	545
	16	9.0	130	64	17,7	≤5,6	3,5	4,5	564	564
	16	13.0	110	64	17,7	≤5,6	1,5	4,5	465	465
	16	13.0	130	66	17,7	≤5,6	1,5	4,5	466	466
22	12		100	42	21,7	≤9,15	4,5	7,0	642	642
	12		130	60	21,7	≤9,15	4,5	7,0	660	660
	16	11.5	90	30	21,7	≤9,15	4,5	7,0	630	630
	16	12.0	100	42	21,7	≤9,15	4,5	7,0	742	742
	16	12.0	130	60	21,7	≤9,15	4,5	7,0	760	760
	16	12.0	160	85	21,7	≤9,15	4,5	7,0	685	685
	20	16.0	110	45	21,7	≤9,15	2,5	7,0	645	645
	20	16.0	130	65	21,7	≤9,15	2,5	7,0	665	665

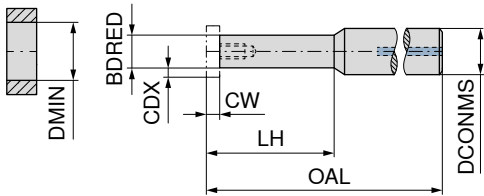


→ Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Circular milling cutter, vibration-damped – MiniMill

Scope of supply:
Includes key



Size	DCONMS _{h6} mm	BDRED mm	OAL mm	LH mm	DMIN mm	CW mm	CDX mm	Tightening torque Nm	TO	
									53 001 ...	53 000 ...
28	16	14.3	100	42	27,7 / 24,8	≤10	6,5 / 5	7,0	842	842
	16	14.3	130	60	27,7 / 24,8	≤10	6,5 / 5	7,0	860	860
	16	14.3	160	85	27,7 / 24,8	≤10	6,5 / 5	7,0	885	885
	20	13.5	104	35	27,7 / 24,8	≤10	6,5 / 5	7,0	835	835
	20	14.3	160	85	27,7 / 24,8	≤10	6,5 / 5	7,0	985	985



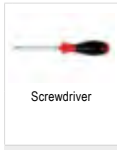
→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

Spare parts
Size

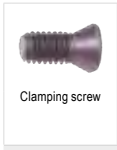
10	T08	110		M2,6	002
14	T10	112		M3,5	003
18	T15	113		M4	004
22	T20	114	M5	M5	005
28	T20	114		M5	005



Screwdriver

AS

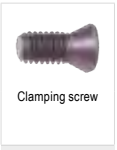
80 950 ...



Clamping screw

AS

73 082 ...



Clamping screw

AS

73 082 ...

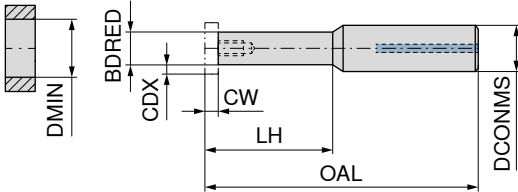


Use clamping screw 73 082 006 for milling insert 53 009 394

CoreLine – Circular milling cutter – MiniMill

- ▲ Steel and carbide versions
- ▲ Specialized cutting point with four driving slots exclusively for cutting operations in the larger diameter range

Scope of supply:
Includes key



Size	DCONMS _{h6} mm	BDRED mm	OAL mm	LH mm	DMIN mm	CW mm	CDX mm	Tightening torque Nm	TO 53 016 ...	TO 53 016 ...
50	16		125	60	50	≤6	16,5	7,0	06000	
	16		155	90	50	≤6	16,5	7,0	09000	
	16		185	120	50	≤6	16,5	7,0	12000	
	20	16	100	32	50	≤6	16,5	7,0		23200

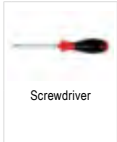


→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_c or center path feed v_{fm} .

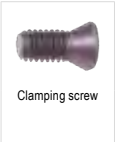
Spare parts
Size



Screwdriver

AS

80 950 ...



Clamping screw

AS

73 082 ...

50

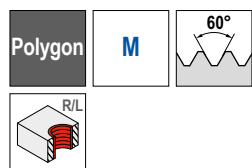
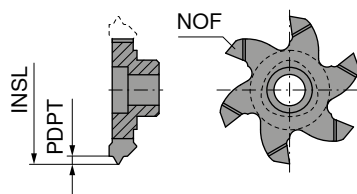
T20

114

M5

006

CoreLine – Thread milling insert – Full profile – Polygon



Ti500



Solid carbide

Size	TP mm	INSL mm	PDPT mm	NOF	Thread	EH
6	1	9.6	0.572	3	≥ M12x1	50 881 ...
	1,5	9.6	0.875	3	≥ M14x1,5	292
	2	10.5	1.157	3	≥ M18x2	293
7	1,5	16.0	0.864	6	≥ M20x1,5	296
	2	16.0	1.157	6	≥ M22x2	302
	2,5	16.0	1.444	6	≥ M24x2,5	304
	2,5	16.0	1.400	6	M20, M22	306
	3	16.0	1.702	6	≥ M24	308 ¹⁾
9	1,5	20.0	0.875	6	≥ M24x1,5	310
	2	20.0	1.157	6	≥ M27x2	312
	3	20.0	1.745	6	M24, M27	314
10	1,5	26.0	0.875	6	≥ M30x1,5	316 ¹⁾
	2	26.0	1.159	6	≥ M33x2	322
	3	26.0	1.702	6	≥ M39x3	324
	3,5	26.0	1.980	6	≥ M42x3,5	330
	3,5	24.0	1.960	6	M30, M33	332
	4	26.0	2.263	6	M36-M54x4	331 ¹⁾
	4	26.0	2.263	6	≥ M48x4	335 ¹⁾
	4,5	26.0	2.602	6	≥ M42	334
	5	26.0	2.836	6	≥ M48	336
P						337
M						•
K						•
N						•
S						•
H						•
O						•

1) Profile-corrected



- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Thread milling insert – Full profile – Polygon

▲ 50 883 322 for threads > 1"

Polygon

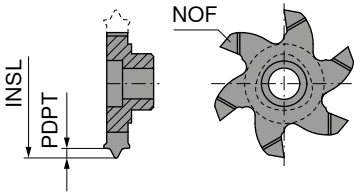
G

BSW

BSF







Ti500



Solid carbide

Size	TPI 1/"	TP mm	INSL mm	PDPT mm	NOF	
6	19	1.337	9.6	0.871	3	
7	14	1.814	17.7	1.177	6	
	14	1.814	16.0	1.177	6	
	11	2.309	16.0	1.494	6	
	10	2.540	16.0	1.646	6	
9	14	1.814	20.0	1.177	6	
	11	2.309	20.0	1.494	6	
10	11	2.309	26.0	1.494	6	

EH

50 883 ...

292

308

304

302

306

316

314

322

P	●
M	●
K	●
N	●
S	●
H	●
O	●



→ Find the cutting data standard values here.

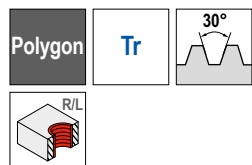
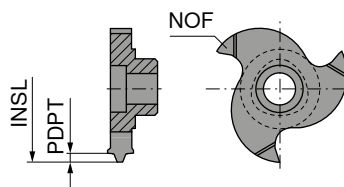
→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Thread milling insert – Full profile – Polygon

▲ DIN 103



Ti500



Solid carbide

Size	TP mm	INSL mm	PDPT mm	NOF	Thread	
6	2	11.7	1.25	3	Tr 16x2 - Tr 20x2	
	3	11.0	1.75	3	Tr 18x3 - Tr 20x3	
	4	12.0	2.25	3	Tr 20x4	
7	3	14.0	1.75	3	Tr 24x3 - Tr 32x3	
	5	15.3	2.75	3	Tr 28x5 - Tr 36x5	
	5	15.3	2.75	3	Tr 26x5	
	6	16.2	3.50	3	Tr 34x6 - Tr 42x6	
	6	16.2	3.50	3	Tr 30x6 - Tr 32x6	
10	5	25.0	2.75	3	Tr 44x5 - Tr 48x5	
	7	22.0	3.75	3	Tr 38x7 - Tr 42x7	

EH

50 872 ...

292

294

296 ¹⁾

302 ²⁾

306 ³⁾

304 ³⁾

310 ²⁾

308 ²⁾

322 ⁴⁾

324 ⁴⁾

P	●
M	●
K	●
N	●
S	●
H	●
O	●

- 1) Profile-corrected
- 2) Not suitable for the 50 805 011 and 50 805 010 holders
- 3) Not suitable for the 50 805 011 and 50 805 010 holders / Profile-corrected
- 4) Not suitable for the 50 805 026, 50 805 025, and 50 805 024 holders



- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_r or center path feed v_{fm} .

CoreLine – Thread milling insert – Full profile – Polygon

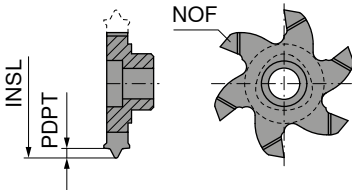
▲ With holder 50 805 010 / 50 805 011 maximum pitch of 3 mm is possible!

Polygon

UNC







Ti500



Solid carbide

Size	TPI 1/"	INSL mm	PDPT mm	NOF	EH 50 886 ...
6	12	9.6	1.228	3	202
	11	10.5	1.355	3	204
	10	11.7	1.485	3	206
7	9	16.0	1.577	6	212
9	8	18.0	1.809	6	222
	7	20.0	2.043	6	224
P					●
M					●
K					●
N					●
S					●
H					●
O					●



→ Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Thread milling insert – Full profile – Polygon

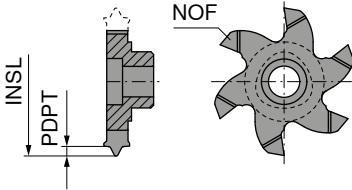
▲ With holder 50 805 010 / 50 805 011 maximum pitch of 3 mm is possible

Polygon

UNF







Ti500



Solid carbide

Size	Thread	INSL mm	PDPT mm	NOF	EH 50 886 ...
6	1/2 - 20	9.6	0.733	3	302
	9/16 - 18	10.5	0.827	3	304
	3/4 - 16	11.7	0.945	3	306
7	7/8 - 14	17.7	1.071	6	312
9	1 - 12	20.0	1.228	6	322
P					●
M					●
K					●
N					●
S					●
H					●
O					●



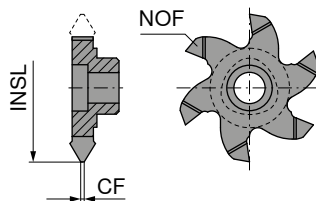
→ Find the cutting data standard values here.
→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Thread milling insert – Partial profile – Polygon

▲ With holder 50 805 010 / 50 805 011 maximum pitch of 3 mm is possible!



Ti500



Solid carbide

Size	TP mm	INSL mm	CF mm	NOF	TD mm
6	1 - 3	11.7	0.10	3	≥16
7	1 - 3	17.7	0.10	6	≥22
	1 - 4	16.0	0.10	6	≥20
	2,5 - 4	16.0	0.25	6	≥22
9	1 - 2	21.7	0.10	6	≥27
	1 - 3	20.0	0.10	6	≥24
	2 - 4	21.7	0.15	6	≥30
10	1 - 3	26.0	0.10	6	≥32
	2,5 - 5	26.0	0.25	6	≥36
	3,5 - 6	26.0	0.40	6	≥52

EH

50 882 ...

292

306

302

304

314

312

316

322

324

32600

P	●
M	●
K	●
N	●
S	●
H	●
O	●

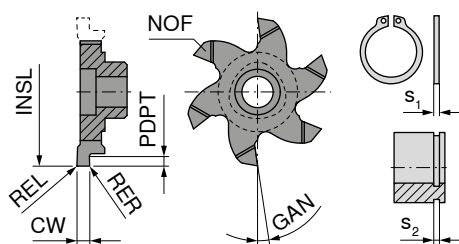


- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Milling insert for circlip grooves without chamfer – Polygon



Solid carbide

Size	S ₂ H13 mm	INSL mm	CW _{-0.03} mm	PDPT mm	REL mm	RER mm	GAN °	s ₁ mm	NOF	EH
6	0.90	9.6	0.98	1.20	0.05	0.05	6	0.80	3	50 880 ...
	1.10	11.7	1.18	1.00	0.05	0.05	6	1.00	3	292
	1.30	11.7	1.38	1.00	0.05	0.05	6	1.20	3	294
	1.60	11.7	1.68	1.00	0.10	0.10	6	1.50	3	296
7	1.10	16.0	1.18	0.90	0.05	0.05	6	1.00	6	298
	1.30	16.0	1.38	1.10	0.05	0.05	6	1.20	6	301
	1.60	16.0	1.68	1.25	0.10	0.10	6	1.50	6	302
	1.85	16.0	1.93	1.25	0.10	0.10	6	1.75	6	304
	1.10	17.7	1.18	0.90	0.05	0.05	6	1.00	6	306
	1.30	17.7	1.38	1.10	0.05	0.05	6	1.20	6	308
	1.60	17.7	1.68	1.25	0.10	0.10	6	1.50	6	309
	1.85	17.7	1.93	1.25	0.10	0.10	6	1.75	6	310
9	1.10	20.0	1.18	0.90	0.05	0.05	6	1.00	6	311
	1.30	20.0	1.38	1.10	0.05	0.05	6	1.20	6	313
	1.60	20.0	1.68	1.25	0.10	0.10	6	1.50	6	314
	1.85	20.0	1.93	1.25	0.10	0.10	6	1.75	6	315
	1.60	21.7	1.68	1.25	0.10	0.10	6	1.50	6	316
	1.85	21.7	1.93	1.25	0.10	0.10	6	1.75	6	318
	2.15	21.7	2.23	1.75	0.10	0.10	6	2.00	6	319
	2.65	21.7	2.73	1.75	0.20	0.20	6	2.50	6	320
10	1.30	26.0	1.38	1.10	0.05	0.05	6	1.20	6	321
	1.60	26.0	1.68	1.25	0.10	0.10	6	1.50	6	322
	1.85	26.0	1.93	1.25	0.10	0.10	6	1.75	6	324
	2.15	26.0	2.23	1.75	0.10	0.10	6	2.00	6	326
	2.65	26.0	2.73	1.75	0.20	0.20	6	2.20	6	328
	3.15	26.0	3.23	2.20	0.20	0.20	6	3.00	6	330
P										332
M										
K										
N										
S										
H										
O										



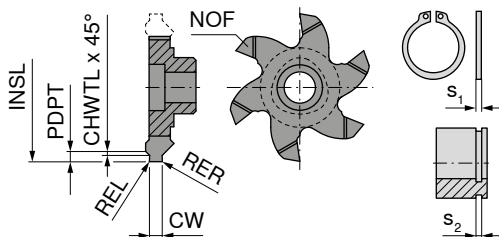
- Find the recommended values for cutting speeds here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Milling insert for circlip grooves with chamfer – Polygon

▲ Both edges chamfered CHWTL x 45°



Ti500



Solid carbide

Size	S ₂ H13 mm	INSL mm	CW ^{-0.03} mm	PDPT mm	REL mm	RER mm	CHWTL mm	s ₁ mm	NOF	EH 50 879 ...
7	1.10	16.0	1.18	0.50	0.05	0.05	0.10	1.00	6	292
	1.30	16.0	1.38	0.85	0.05	0.05	0.15	1.20	6	302
	1.60	16.0	1.68	1.00	0.10	0.10	0.15	1.50	6	304
	1.85	16.0	1.93	1.25	0.10	0.10	0.20	1.75	6	306
9	1.10	20.0	1.18	0.50	0.05	0.05	0.10	1.00	6	307
	1.30	20.0	1.38	0.85	0.05	0.05	0.15	1.20	6	308
	1.60	20.0	1.68	1.00	0.10	0.10	0.15	1.50	6	309
	1.85	20.0	1.93	1.25	0.10	0.10	0.20	1.75	6	310
	1.60	21.7	1.68	1.00	0.10	0.10	0.15	1.50	6	312
	1.85	21.7	1.93	1.25	0.10	0.10	0.20	1.75	6	314
	2.15	21.7	2.23	1.50	0.10	0.10	0.20	2.00	6	316
	2.65	21.7	2.73	1.75	0.20	0.20	0.20	2.50	6	318
10	1.30	26.0	1.38	0.85	0.05	0.05	0.15	1.20	6	322
	1.60	26.0	1.68	1.00	0.10	0.10	0.15	1.50	6	324
	1.85	26.0	1.93	1.25	0.10	0.10	0.20	1.75	6	326
	2.15	26.0	2.23	1.50	0.10	0.10	0.20	2.00	6	328
	2.65	26.0	2.73	1.75	0.20	0.20	0.20	2.50	6	330
	3.15	26.0	3.23	1.75	0.20	0.20	0.20	3.00	6	332
P										●
M										●
K										●
N										●
S										●
H										●
O										●



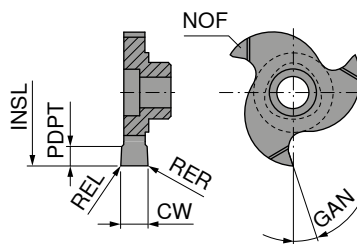
- Find the recommended values for cutting speeds here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Milling insert without profile – Polygon

- ▲ Size 7: from 5.0 mm groove width with ground chip breaker
 ▲ Size 10: from 6.5 mm groove width with ground chip breaker



Size	CW mm +/-0.02	INSL mm	PDPT mm	REL mm	RER mm	GAN °	NOF	
6	1.5	11.7	2.25	0.10	0.10	6	3	
	2.0	11.7	2.25	0.15	0.15	6	3	
	2.5	11.7	2.25	0.15	0.15	6	3	
	3.0	11.7	2.25	0.15	0.15	6	3	
7	3.5	16.0	3.50	0.15	0.15	0	3	
	3.5	16.0	3.50	0.15	0.15	8	3	
	3.5	16.0	3.50	0.15	0.15	12	3	
	5.0	16.0	3.50	0.15	0.15	0	3	
	5.0	16.0	3.50	0.15	0.15	8	3	
	5.0	16.0	3.50	0.15	0.15	12	3	
10	4.0	25.0	5.70	0.15	0.15	0	3	
	4.0	25.0	5.70	0.15	0.15	8	3	
	4.0	25.0	5.70	0.15	0.15	12	3	
	5.0	25.0	5.70	0.15	0.15	8	3	
	6.5	25.0	5.70	0.15	0.15	0	3	
	6.5	25.0	5.70	0.15	0.15	8	3	
	6.5	25.0	5.70	0.15	0.15	12	3	
	8.0	25.0	5.70	0.15	0.15	0	3	
	8.0	25.0	5.70	0.15	0.15	8	3	
	8.0	25.0	5.70	0.15	0.15	12	3	
								EH
								50 875 ...
								302
								304
								306
								308
								310
								312
								314
								316
								318
								320
								330
								332
								334
								337
								340
								342
								344
								350
								352
								354
P								●
M								●
K								●
N								●
S								●
H								●
O								●

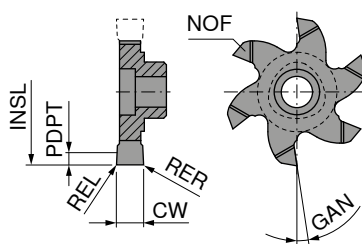


- Find the recommended values for cutting speeds here.
 → Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_c or center path feed v_{fm} .

CoreLine – Milling insert without profile – Polygon



Size	CW mm +/-0.02	INSL mm	PDPT mm	REL mm	RER mm	GAN °	NOF	
7	1.5	17.7	4.0	0.10	0.10	6	6	
	2.0	17.7	4.0	0.10	0.10	6	6	
	2.5	17.7	4.0	0.15	0.15	6	6	
	3.0	16.0	3.5	0.15	0.15	6	6	
	4.0	16.0	3.5	0.15	0.15	6	6	
	5.0	16.0	3.5	0.15	0.15	6	6	
9	1.5	21.7	5.0	0.10	0.10	6	6	
	2.0	21.7	5.0	0.10	0.10	6	6	
	2.5	21.7	5.0	0.15	0.15	6	6	
	3.0	21.7	5.0	0.15	0.15	6	6	
	3.0	20.0	4.2	0.15	0.15	6	6	
	4.0	20.0	4.2	0.15	0.15	6	6	
10	1.5	27.7	6.8	0.10	0.10	6	6	
	2.0	27.7	6.8	0.10	0.10	6	6	
	2.5	27.7	6.8	0.15	0.15	6	6	
	3.0	26.0	6.2	0.15	0.15	6	6	
	3.0	27.7	6.8	0.15	0.15	6	6	
	4.0	26.0	6.2	0.15	0.15	6	6	
	5.0	26.0	6.2	0.15	0.15	6	6	
	6.5	26.0	6.2	0.15	0.15	6	6	
P								●
M								●
K								●
N								●
S								●
H								●
O								●

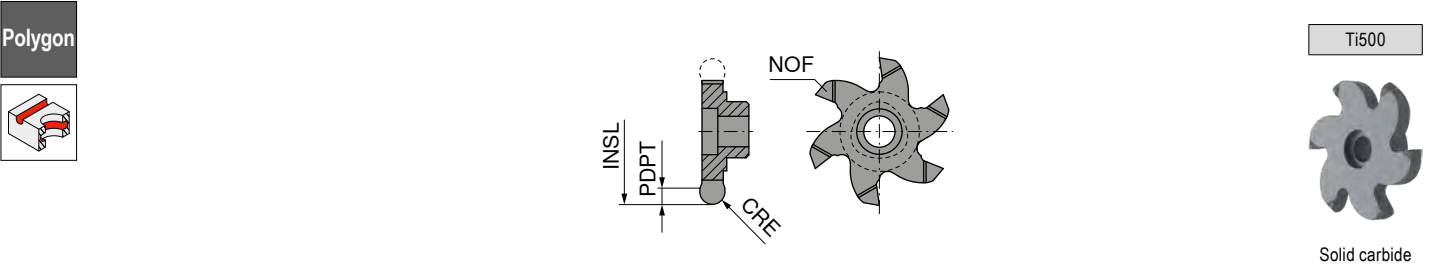


- Find the recommended values for cutting speeds here.
- Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Milling insert for radius milling – Polygon



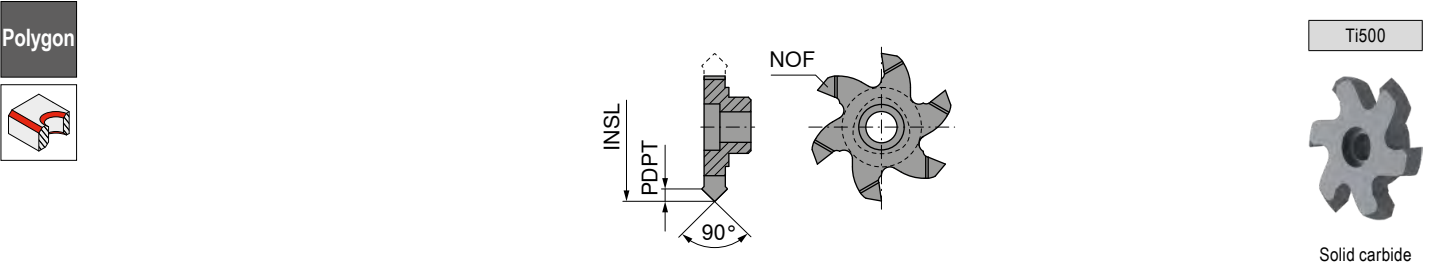
Size	CRE mm	INSL mm	PDPT mm	NOF	EH
6	1.100	9.6	1.20	3	50 886 ...
	0.788	11.7	2.25	3	702
	1.100	11.7	2.25	3	704
	1.190	11.7	2.25	3	708
7	0.788	17.7	4.20	6	706
	1.100	17.7	4.20	6	712
9	0.785	21.7	5.00	6	714
	1.000	21.7	5.00	6	720
	1.200	21.7	5.00	6	722
	1.400	21.7	5.00	6	724
	1.500	21.7	5.00	6	726
P					728
M					
K					
N					
S					
H					
O					

→ Find the recommended values for cutting speeds here.

→ Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_l or center path feed v_{fm} .

CoreLine – Milling insert for chamfering and deburring – Polygon



Size	INSL mm	PDPT mm	NOF	EH
6	9.6	1.20	3	50 884 ...
	11.7	1.50	3	292
7	16.0	1.90	6	294
	17.7	1.30	6	302
9	20.0	1.90	6	304
	21.7	1.95	6	312
10	26.0	2.10	6	314
P				322
M				
K				
N				
S				
H				
O				



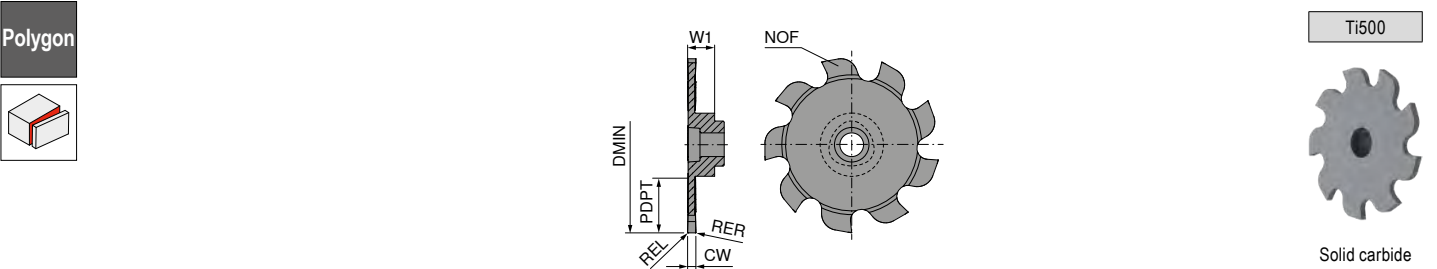
→ Find the recommended values for cutting speeds here.

→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Milling insert for part-off – Polygon



Size	DMIN mm	PDPT mm	CW ^{+0.02} mm	REL mm	RER mm	W1 mm	NOF	EH	
6	14	3.40	1.5	0.1	0.1	3.50	6	51 800 ...	14000
7	22	6.40	1.5	0.1	0.1	3.86	9	22000	
9	32	10.25	1.5	0.1	0.1	4.91	9	32000	
10	37	11.50	1.5	0.1	0.1	4.86	9	37000	
P									●
M									●
K									●
N									●
S									●
H									●
O									●

→ Find the recommended values for cutting speeds here.

→ Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Circular milling cutter – Polygon

▲ For maximum machining depth, note insert width (CW)

▲ Size 6 = for INSL 9.6; 10.5; 11.7; 12

▲ Size 7 = for INSL 16; 17.7

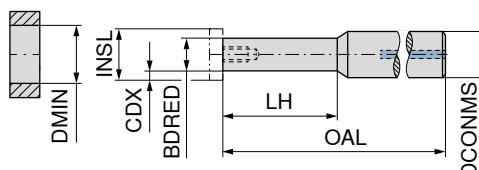
▲ Size 9 = for INSL 18; 20; 21.7

▲ Size 10 = for INSL 24; 25; 26; 27.7

Scope of supply:

Includes key

Polygon



Size	LH mm	CDX mm	DCONMS _{h6} mm	OAL mm	BDRED mm	DMIN mm	Tightening torque Nm	TO 50 805 ...	TO 50 805 ...
6	20.00	2.25	12	67.5	7.0	12	1,0		050 ¹⁾
	20.00	2.25	12	67.5	7.0	12	1,0		051
	20.00	2.25	12	67.5	7.0	12	1,0	052	
	30.00	2.25	12	80.0	7.0	12	1,0		053
	30.00	2.25	12	80.0	7.0	12	1,0	054	
	40.00	2.25	12	100.0	7.0	12	1,0		055
	40.00	2.25	12	100.0	7.0	12	1,0	056	
7	20.90	4.00	12	67.4	9.0	18	1,1		002 ¹⁾
	21.00	4.00	12	67.4	9.0	18	1,1		004
	21.00	4.00	12	67.4	9.0	18	1,1	005	
	36.00	4.00	12	82.4	9.0	18	1,1		008
	36.00	4.00	12	82.4	9.0	18	1,1	085	
		4.00	12	122.5	12.0	18	1,1	010	
	4.00	12	82.4	12.0	18	1,1	1,1	011	
9	29.75	5.00	16	80.0	11.5	22	3,8		070 ¹⁾
	30.00	5.00	16	80.0	11.5	22	3,8		071
	30.00	5.00	16	80.0	11.5	22	3,8	072	
	50.00	5.00	16	100.0	11.5	22	3,8		073
	50.00	5.00	16	100.0	11.5	22	3,8	074	

1) Steel version



→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Circular milling cutter – Polygon

▲ For maximum machining depth, note insert width (CW)

▲ Size 6 = for INSL 9.6; 10.5; 11.7; 12

▲ Size 7 = for INSL 16; 17.7

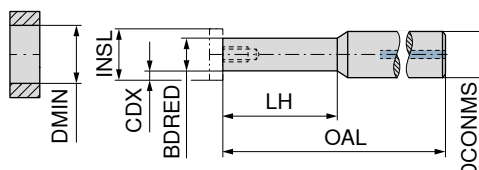
▲ Size 9 = for INSL 18; 20; 21.7

▲ Size 10 = for INSL 24; 25; 26; 27.7

Scope of supply:

Includes key

Polygon



Size	LH mm	CDX mm	DCONMS _{h6} mm	OAL mm	BDRED mm	DMIN mm	Tightening torque Nm	TO 50 805 ...	TO 50 805 ...
10	20.50	5.70	16	105.0	15.5	28	5,5	025	
	20.50	6.80	16	149.7	15.5	28	5,5	024	
	20.50	6.80	20	175.4	15.5	28	5,5	026	
	30.40	6.80	16	79.6	13.6	28	5,5		012 ¹⁾
	30.50	6.80	16	79.6	13.6	28	5,5	015	
	30.50	6.80	16	79.6	13.6	28	5,5		014
	45.50	6.80	16	94.6	13.6	28	5,5	021	
	45.50	6.80	16	94.6	13.6	28	5,5		020
	60.50	6.80	16	109.6	13.6	28	5,5		022
	60.50	6.80	16	109.6	13.6	28	5,5	023	

1) Steel version



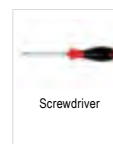
→ Find the formulas for calculating the cutting data here.



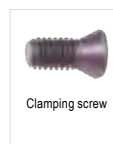
When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

Spare parts

Size			AS 80 950 ...		AS 70 960 ...
6	T08 - IP	039		M2,5x7	246
7	T08 - IP	039		M3x13	231
9	T15 - IP	120		M4x13	236
10	T20 - IP	121		M5x13,5	243



Screwdriver

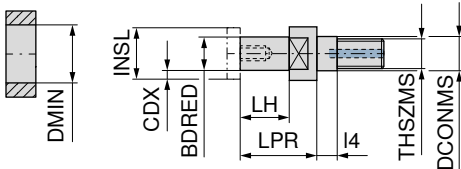


Clamping screw

CoreLine – Circular screw-in milling cutter – Polygon

- ▲ Size 7 = for INSL 16; 17.7
- ▲ Size 10 = for INSL 25; 26
- ▲ Steel version

Scope of supply:
Includes key



Steel

Size	LH mm	CDX mm	DCONMS _{n6} mm	BDRED mm	DMIN mm	Tightening torque Nm	I ₄ mm	THSZMS
7	16.0	3.5	8.5	9.0	18	1,1	5.5	M8
10	25.5	5.7	12.5	13.6	27	5,5	5.0	M12

TO
50 799 ...
002
012



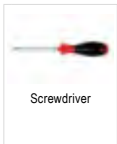
→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_c or center path feed v_{fm} .

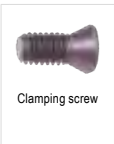
Spare parts
Size

7	T08 - IP	039	M3x13	231
10	T20 - IP	121	M5x13,5	243



Screwdriver

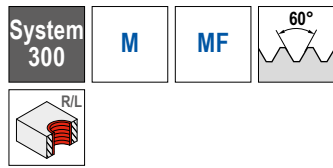
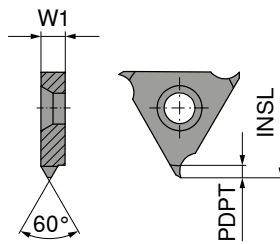
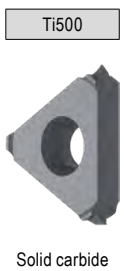
AS
80 950 ...



Clamping screw

AS
70 960 ...

CoreLine – Thread milling insert – Full profile – System 300



Size	TP mm	INSL mm	W1 mm	PDPT mm
03	1.0	10.6	2.34	0.578
	1.5	10.6	2.34	0.864
	2.0	10.6	2.34	1.159
02	1.0	17.5	3.50	0.578
	1.5	17.5	3.50	0.864
	2.0	17.5	3.50	1.159
	2.5	16.0	3.50	1.444
	2.5	17.5	3.50	1.444
	3.0	17.5	3.50	1.728
01	1.0	23.0	4.00	0.578
	1.5	23.0	4.00	0.864
	2.0	23.0	4.00	1.159
	2.5	23.0	4.00	1.444
	3.0	23.0	4.00	1.728
	3.5	23.0	4.00	2.023
	4.0	23.0	4.00	2.308
	4.5	23.0	6.50	2.602
	5.0	23.0	6.50	2.887
	6.0	23.0	6.50	3.467

EH
50 859 ...
304
308
310
311
312
314
317 ¹⁾
316
318
320
322
324
326
328
330
332
334
336
338 ²⁾

P	●
M	●
K	●
N	●
S	●
H	○
O	●

- 1) M20x2.5 profile-corrected
 2) With circular milling cutter 50 800 090 PDPT = 3.0 mm



- Find the cutting data standard values here.
 → Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_r or center path feed v_{fm} .

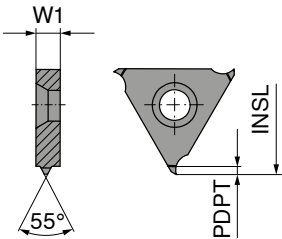
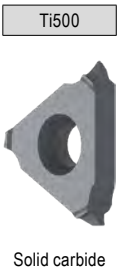
CoreLine – Thread milling insert – Full profile – System 300

System 300

G

BSW

BSF



Size	TP mm	TPI 1/"	INSL mm	W1 mm	PDPT mm
02	1.814	14	17.5	3.5	1.162
	2.309	11	17.5	3.5	1.494
01	2.309	11	23.0	4.0	1.494

EH

50 858 ...
314
312
322

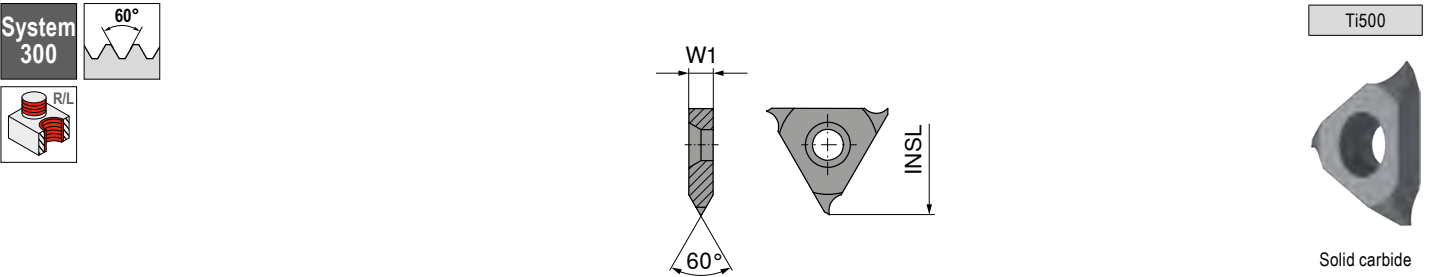
P	●
M	●
K	●
N	●
S	●
H	○
O	●

→ Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Thread milling insert – Partial profile – System 300



Size	TP mm	INSL mm	W1 mm	
02	1 - 3,5	17.5	3.5	
01	1 - 4,0	23.0	4.0	

EH

50 855 ...

314

324

P

M

K

N

S

H

O

●

●

●

●

●

○

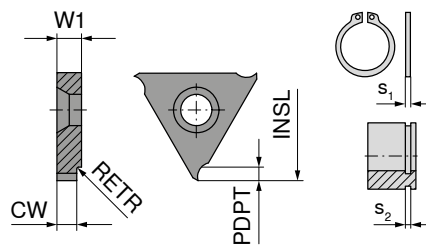
●

→ Find the cutting data standard values here.

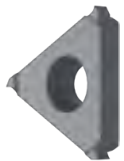
→ Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_r or center path feed v_{fm} .

CoreLine – Milling insert for circlip grooves without chamfer – System 300



Ti500



Solid carbide

Size	s_2 H13 mm	INSL mm	W1 mm	CW _{-0.03} mm	PDPT mm	RETR mm	s_1 mm	EH
03	0.90	10.6	2.34	0.98	0.70	0.3	0.80	50 853 ...
	1.10	10.6	2.34	1.18	0.90	0.3	1.00	302
	1.30	10.6	2.34	1.38	1.10	0.3	1.20	304
	1.60	10.6	2.34	1.68	1.25	0.3	1.50	306
	1.85	10.6	2.34	1.93	1.25	0.3	1.75	308
02	0.90	17.5	3.50	0.98	0.70	0.3	0.80	310
	1.10	17.5	3.50	1.18	0.90	0.3	1.00	312
	1.30	17.5	3.50	1.38	1.10	0.3	1.20	314
	1.60	17.5	3.50	1.68	1.25	0.3	1.50	316
	1.85	17.5	3.50	1.93	1.25	0.3	1.75	318
	2.15	17.5	3.50	2.23	1.75	0.3	2.00	320
	2.65	17.5	3.50	2.73	1.75	0.3	2.50	322
	3.15	17.5	3.50	3.23	2.20	0.3	3.00	324
01	0.90	23.0	4.00	0.98	0.70	0.3	0.80	326
	1.10	23.0	4.00	1.18	0.90	0.3	1.00	328
	1.30	23.0	4.00	1.38	1.10	0.3	1.20	330
	1.60	23.0	4.00	1.68	1.25	0.3	1.50	332
	1.85	23.0	4.00	1.93	1.25	0.3	1.75	334
	2.15	23.0	4.00	2.23	1.75	0.3	2.00	336
	2.65	23.0	4.00	2.73	1.75	0.3	2.50	338
	3.15	23.0	4.00	3.23	2.20	0.3	3.00	340
P								342
M								●
K								●
N								●
S								●
H								○
O								●



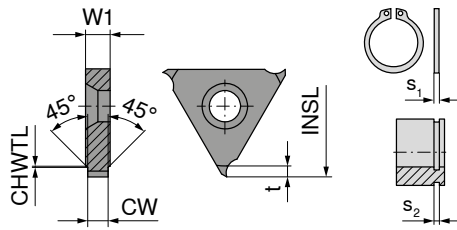
- Find the cutting data standard values here.
- Find the formulas for calculating the cutting data here.



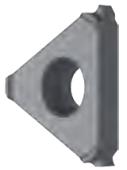
When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_r or center path feed v_{fm} .

CoreLine – Milling insert for circlip grooves with chamfer – System 300

System
300



Ti500



Solid carbide

Size	S ₂ H13 mm	INSL mm	W1 mm	CW _{-0.03} mm	t mm	CHWTL mm	s ₁ mm
03	1.10	10.6	2.34	1.18	0.50	0.10	1.00
02	1.10	17.5	3.50	1.18	0.50	0.10	1.00
	1.30	17.5	3.50	1.38	0.85	0.15	1.20
	1.60	17.5	3.50	1.68	1.00	0.15	1.50
	1.85	17.5	3.50	1.93	1.25	0.20	1.75
	2.15	17.5	3.50	2.23	1.50	0.20	2.00
	2.65	17.5	3.50	2.73	1.50	0.20	2.50
01	1.10	23.0	4.00	1.18	0.50	0.10	1.00
	1.30	23.0	4.00	1.38	0.70	0.15	1.20
	1.30	23.0	4.00	1.38	0.85	0.15	1.20
	1.60	23.0	4.00	1.68	1.00	0.15	1.50
	1.60	23.0	4.00	1.68	0.85	0.15	1.50
	1.85	23.0	4.00	1.93	1.25	0.20	1.75
	2.15	23.0	4.00	2.23	1.50	0.20	2.00
	2.65	23.0	4.00	2.73	1.75	0.20	2.50
	2.65	23.0	4.00	2.73	1.50	0.20	2.50
	3.15	23.0	4.00	3.32	1.75	0.20	3.00

EH

50 852 ...

302

312

314

316

317

318

319

320

321

322

324

323

325

326

328

327

329

P	●
M	●
K	●
N	●
S	●
H	○
O	●



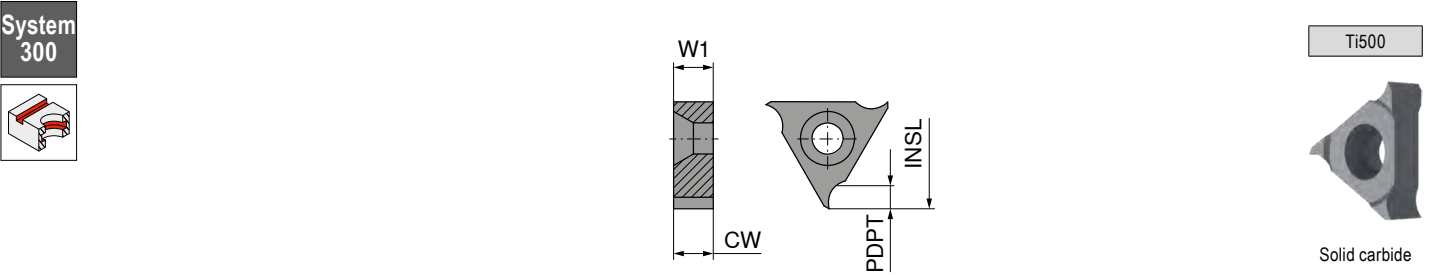
→ Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Milling insert without profile, ground ready-for-use – System 300



Size	CW _{+0.02} mm	PDPT mm	INSL mm	W1 mm	EH 50 851 ... 304 306 312 314 316 322 ¹⁾ 324 ¹⁾
03	2.34	1.60	10.6	2.34	
	3.00	1.60	10.6	3.00	
02	3.50	2.60	17.5	3.50	
	5.00	2.60	17.5	5.00	
	6.00	2.60	17.5	6.00	
01	4.00	3.45	23.0	4.00	
	6.50	3.45	23.0	6.50	
P					●
M					●
K					●
N					●
S					●
H					○
O					●

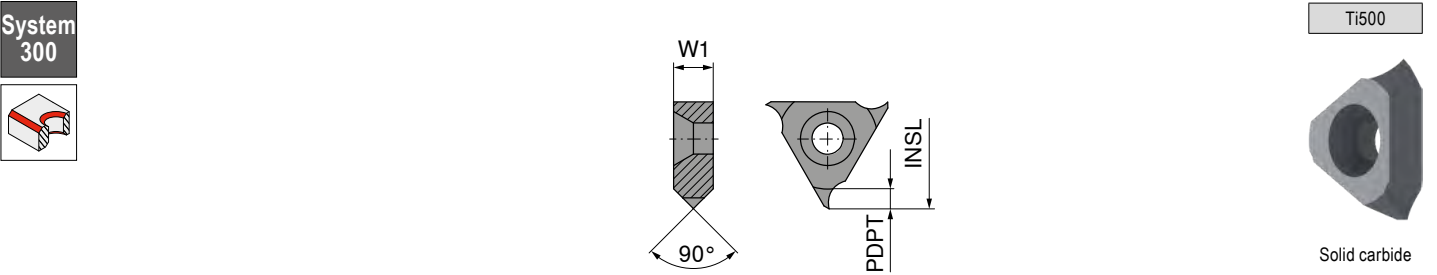
1) With circular milling cutter 50 800 090 PDPT = 3.0 mm

→ Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.

When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

CoreLine – Milling insert for chamfering and deburring – System 300



Size	PDPT mm	INSL mm	W1 mm
03	1.50	10.6	3.0
02	2.50	17.5	5.0
01	3.25	23.0	6.5

EH

50 857 ...

304

314

322 ¹⁾

P

M

K

N

S

H

O

●

●

●

●

●

○

●

1) With circular milling cutter 50 800 090 PDPT = 3.0 mm



→ Find the cutting data standard values here.

→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

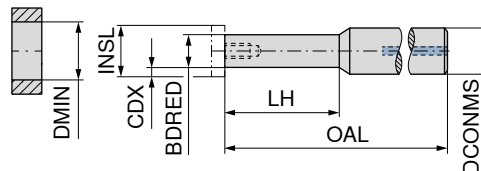
CoreLine – Circular milling cutter – System 300

▲ Size refers to milling inserts

Scope of supply:

Includes key

System
300



Size	INSL mm	CDX mm	LH mm	DCONMS _{h6} mm	OAL mm	BDRED mm	DMIN mm	Tightening torque Nm	TO 50 800 ...
03	10.6	1.60	17.2	10	57.20	7.4	11	0,9	020 ¹⁾
	10.6	1.60	34.2	10	74.20	7.4	11	0,9	025 ²⁾
02	17.5	2.60	28.7	12	74.05	12.0	20	3,8	030
	17.5	2.60	63.7	12	108.70	12.0	20	3,8	045 ²⁾
01	23.0	3.45	38.5	16	87.00	16.1	25	5,5	050
	23.0	3.45	67.5	16	116.00	16.1	25	5,5	070
	23.0	3.00	88.5	16	137.00	17.0	25	5,5	090 ²⁾

1) Without through coolant supply

2) Carbide version



→ Find the formulas for calculating the cutting data here.



When calculating the feed for circular milling, check whether machining is taking place with the contour feed v_f or center path feed v_{fm} .

Spare parts

Size

Size	T06 - IP	80 950 ...	M2x9	232
03	T15 - IP	116	M4x12,3	233
02	T20 - IP	121	M5x15	234
01				



Screwdriver

AS

80 950 ...



Clamping screw

AS

70 960 ...

Material examples for cutting data tables

	Material sub-group	Index	Composition / Structure / Heat treatment	Hardness HB / HRC Tensile strength at rupture (Rm) lbf/in ²	Material number Material designation	Material number Material designation
P	Unalloyed steel	P.1.1	< 0.15 % C, annealed	60900 lbf/in ² / 125 HB	1.0401 1015	1.0301 1010
		P.1.2	< 0.45 % C, annealed	92800 lbf/in ² / 190 HB	1.1191 1045	1.0737 12L14
		P.1.3	< 0.45 % C, tempered	121800 lbf/in ² / 250 HB	1.1191 1045	1.0503 1043
		P.1.4	< 0.75 % C, annealed	132000 lbf/in ² / 270 HB	1.1223 1060	1.0535 1055
		P.1.5	< 0.75 % C, tempered	146500 lbf/in ² / 300 HB	1.1223 1060	1.1274 1095
	Low-alloy steel	P.2.1	Annealed	88500 lbf/in ² / 180 HB	1.7131 5115	1.6523 8620
		P.2.2	Tempered	134900 lbf/in ² / 275 HB	1.7131 5115	1.6582 4340
		P.2.3	Tempered	146500 lbf/in ² / 300 HB	1.7225 4142	1.7131 5115
		P.2.4	Tempered	174000 lbf/in ² / 375 HB	1.7225 4142	1.7223 4140
	High-alloy steel and high-alloy tool steel	P.3.1	Annealed	98600 lbf/in ² / 200 HB	1.4021 420	1.2379 D2
		P.3.2	Hardened and tempered	159500 lbf/in ² / 300 HB	1.2343 H11	1.3343 M2
		P.3.3	Hardened and tempered	188500 lbf/in ² / 400 HB	1.2343 H11	1.2363 A2
	Stainless steel	P.4.1	Ferritic / martensitic, annealed	98600 lbf/in ² / 200 HB	1.4016 430	1.4125 440C
		P.4.2	Martensitic, tempered	117500 lbf/in ² / 300 HB	1.4112 S44003	1.4021 420
M	Stainless steel	M.1.1	Austenitic / austenitic-ferritic, quenched	88500 lbf/in ² / 180 HB	1.4301 304	1.4401 316
		M.2.1	Austenitic, tempered	300 HB	1.4841 314	1.4568 17-7 PH
		M.3.1	Austenitic / ferritic (Duplex)	113100 lbf/in ² / 230 HB	1.4462 S32205	1.4410 S32750
K	Grey cast iron	K.1.1	Pearlitic / ferritic	88500 lbf/in ² / 180 HB	0.6010 A48-20B	0.6025 A48-40 B
		K.1.2	Pearlitic (martensitic)	127600 lbf/in ² / 260 HB	0.6030 A48-45B	0.6040 A48-60 B
	Spherulitic graphite cast iron	K.2.1	Ferritic	78300 lbf/in ² / 160 HB	0.7040 60-40-18	0.7050 65-45-12
		K.2.2	Pearlitic	122600 lbf/in ² / 250 HB	0.7070 100-70-03	0.7660 A439 Type D2
	Malleable iron	K.3.1	Ferritic	63800 lbf/in ² / 130 HB	0.8035 GTW-35-04	
		K.3.2	Pearlitic	113100 lbf/in ² / 230 HB	0.8170 70003	
N	Aluminium wrought alloy	N.1.1	Non-hardenable	60 HB	3.0255 A91060	3.0255 A91060
		N.1.2	Hardenable, age-hardened	49300 lbf/in ² / 100 HB	3.1355 2024	3.1355 2024
	Cast aluminium alloy	N.2.1	≤ 12 % Si, non-hardenable	36300 lbf/in ² / 75 HB	3.2581 A04130 / A413-0	3.2581 A04130 / A413-0
		N.2.2	≤ 12 % Si, hardenable, age-hardened	43500 lbf/in ² / 90 HB	3.2134 G-AISi5Cu1Mg	
		N.2.3	> 12 % Si, non-hardenable	63800 lbf/in ² / 130 HB	G-AISi17Cu4Mg	
	Copper and copper alloys (bronze/brass)	N.3.1	Free-machining alloys, Pb > 1 %	54400 lbf/in ² / 110 HB	2.0380 CuZn39Pb2 (Ms58)	2.0380 C37700
		N.3.2	CuZn, CuSnZn	43500 lbf/in ² / 90 HB	2.0331 CuZn15	2.0331 C34000
		N.3.3	CuSn, lead-free copper and electrolytic copper	49300 lbf/in ² / 100 HB	2.0060 E-Cu57	
	Magnesium alloys	N.4.1	Magnesium and magnesium alloys	70 HB	3.5612 MgAl6Zn	
S	Heat-resistant alloys	S.1.1	Fe basis, annealed	98600 lbf/in ² / 200 HB	1.4864 X12NiCrSi 36-16	1.4864 330
		S.1.2	Fe basis, age-hardened	137800 lbf/in ² / 280 HB	1.4980 X6NiCrTiMoVB25-15-2	1.4980 S66286
		S.2.1	Ni or Co basis, annealed	121800 lbf/in ² / 250 HB	2.4856 Inconel 625	2.4812 Hastelloy C
		S.2.2	Ni or Co basis, age-hardened	171100 lbf/in ² / 350 HB	2.4952 Nimonic 80A	2.4668 Inconel 718
		S.2.3	Ni or Co basis, cast	156600 lbf/in ² / 320 HB	2.4674 Nimocast PK24	2.4670 Nimocast 713
	Titanium alloys	S.3.1	Pure titanium	5800 lbf/in ²	3.7025 Ti99,8	
		S.3.2	Alpha + beta alloys, age-hardened	152300 lbf/in ² / 320 HB	3.7165 TiAl6V4	
		S.3.3	Beta alloys	203100 lbf/in ² / 410 HB	Ti555.3 Ti-5Al-5V-5Mo-3Cr	
H	Hardened steel	H.1.1	Hardened and tempered	46–55 HRC		
		H.1.2	Hardened and tempered	56–60 HRC		
		H.1.3	Hardened and tempered	61–65 HRC		
		H.1.4	Hardened and tempered	66–70 HRC		
	Chilled iron	H.2.1	Cast	400 HB		
	Hardened cast iron	H.3.1	Hardened and tempered	55 HRC		
O	Non-metal materials	O.1.1	Plastics, duroplastic	≤ 21800 lbf/in ²	EP, MF, PF, UP	
		O.1.2	Plastics, thermoplastic	≤ 14500 lbf/in ²	PA, PC, PE, PI, PMMA, POM, PP, PS, PTFE, PVC	
		O.2.1	Aramid fibre-reinforced	≤ 145000 lbf/in ²	AFK	
		O.2.2	Glass/carbon-fibre reinforced	≤ 145000 lbf/in ²	CFRP, GFRP	
		O.3.1	Graphite			

Cutting data standard values

Index	54 821 ..., 54 822 ..., 54 823 ..., 54 824 ..., 54 825 ..., 54 826 ..., 54 827 ..., 54 828 ...				50 825 ..., 50 826 ..., 50 827 ...			
	SGF	Ti500 – Standard Cutting			SGF	TiAlN – Standard Cutting		
		Solid carbide				Solid carbide		
		Ø 2,4 – 6,0	Ø 6,0 – 10,0	Ø 10,0 – 20,0		Ø 2,4 – 6,0	Ø 6,0 – 10,0	Ø 10,0 – 20,0
	v _c (m/min)	f _z (mm/tooth)			v _c (m/min)	f _z (mm/tooth)		
P.1.1	150	0,01–0,04	0,04–0,06	0,08–0,15	150	0,04	0,06	0,10
P.1.2	120	0,01–0,04	0,04–0,06	0,08–0,15	130	0,04	0,06	0,10
P.1.3	120	0,007–0,03	0,03–0,05	0,05–0,10	110	0,04	0,06	0,10
P.1.4	120	0,007–0,03	0,03–0,05	0,05–0,10	110	0,03	0,05	0,07
P.1.5	100	0,006–0,02	0,02–0,04	0,04–0,06	100	0,03	0,05	0,07
P.2.1	120	0,007–0,04	0,04–0,06	0,08–0,15	120	0,04	0,06	0,10
P.2.2	100	0,007–0,03	0,03–0,05	0,05–0,10	110	0,03	0,05	0,07
P.2.3	80	0,006–0,02	0,02–0,04	0,04–0,06	100	0,03	0,05	0,07
P.2.4	70	0,006–0,02	0,02–0,04	0,04–0,06	80	0,02	0,04	0,06
P.3.1	80	0,01–0,03	0,03–0,05	0,06–0,12	80	0,04	0,06	0,10
P.3.2	70	0,006–0,02	0,02–0,04	0,04–0,06	70	0,03	0,05	0,07
P.3.3	60	0,006–0,02	0,02–0,04	0,04–0,06	60	0,02	0,04	0,06
P.4.1	60	0,006–0,02	0,02–0,04	0,04–0,06	80	0,04	0,06	0,10
P.4.2	60	0,006–0,02	0,02–0,04	0,04–0,06	70	0,04	0,06	0,10
M.1.1	100	0,008–0,03	0,03–0,05	0,05–0,10	70	0,02	0,04	0,06
M.2.1	100	0,008–0,03	0,03–0,05	0,05–0,10	50	0,01	0,03	0,05
M.3.1	100	0,008–0,03	0,03–0,05	0,05–0,10	50	0,01	0,03	0,05
K.1.1	120	0,01–0,04	0,04–0,06	0,08–0,15	150	0,05	0,07	0,12
K.1.2	100	0,007–0,03	0,03–0,05	0,05–0,10	130	0,05	0,07	0,12
K.2.1	120	0,01–0,04	0,04–0,06	0,08–0,15	130	0,03	0,05	0,07
K.2.2	100	0,007–0,03	0,03–0,05	0,05–0,10	110	0,03	0,05	0,07
K.3.1	130	0,01–0,04	0,04–0,06	0,08–0,15	120	0,04	0,06	0,10
K.3.2	100	0,007–0,03	0,03–0,05	0,05–0,10	100	0,04	0,06	0,10
N.1.1	400	0,03–0,06	0,08–0,12	0,14–0,20	210	0,06	0,085	0,15
N.1.2	400	0,03–0,06	0,08–0,12	0,14–0,20	180	0,05	0,07	0,12
N.2.1	300	0,03–0,06	0,08–0,12	0,14–0,20	130	0,05	0,07	0,12
N.2.2	300	0,03–0,06	0,08–0,12	0,14–0,20	130	0,05	0,07	0,12
N.2.3	200	0,03–0,06	0,08–0,12	0,14–0,20	120	0,05	0,07	0,12
N.3.1	160	0,03–0,06	0,08–0,12	0,14–0,20	180	0,06	0,085	0,15
N.3.2	160	0,03–0,06	0,08–0,12	0,14–0,20	180	0,06	0,085	0,15
N.3.3	160	0,03–0,06	0,08–0,12	0,14–0,20	130	0,06	0,085	0,15
N.4.1	300	0,03–0,06	0,08–0,12	0,14–0,20	150	0,06	0,085	0,15
S.1.1	80	0,008–0,03	0,03–0,05	0,05–0,10	60	0,01	0,03	0,05
S.1.2	60	0,006–0,02	0,02–0,04	0,04–0,06				
S.2.1	40	0,006–0,02	0,02–0,04	0,04–0,06				
S.2.2	40	0,006–0,02	0,02–0,04	0,04–0,06				
S.2.3	40	0,006–0,02	0,02–0,04	0,04–0,06				
S.3.1	100	0,01–0,03	0,03–0,05	0,06–0,12	70	0,01	0,03	0,05
S.3.2	80	0,006–0,02	0,02–0,04	0,04–0,06				
S.3.3	60	0,006–0,02	0,02–0,04	0,04–0,06				
H.1.1	50	0,003–0,006	0,008–0,012	0,014–0,02				
H.1.2	40		0,006–0,01	0,01–0,015				
H.1.3								
H.1.4								
H.2.1	60		0,006–0,01	0,01–0,015				
H.3.1	40		0,006–0,01	0,01–0,015				
O.1.1	100	0,02–0,06	0,06–0,10	0,12–0,20	240	0,08	0,10	0,16
O.1.2	100	0,02–0,06	0,06–0,10	0,12–0,20	240	0,08	0,10	0,16
O.2.1	80	0,01–0,04	0,04–0,06	0,08–0,15	130	0,03	0,05	0,07
O.2.2	80	0,01–0,04	0,04–0,06	0,08–0,15	130	0,03	0,05	0,07
O.3.1	200	0,01–0,04	0,04–0,06	0,08–0,15	110	0,03	0,05	0,07



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approximately $\pm 20\%$ according to the usage conditions.

Cutting data standard values

Index	50 524 ..., 50 530 ..., 50 531 ..., 50 532 ..., 50 533 ...			
	SGF	AlTiN – Performance Cutting		
		Solid carbide		
		Ø 2,4 – 5,9	Ø 6,0 – 11,9	Ø 12,0 – 20,0
	v_c (m/min)	f_z (mm/tooth)		
P.1.1	80–150	0,015–0,04	0,04–0,08	0,08–0,15
P.1.2	80–120	0,015–0,04	0,04–0,08	0,08–0,15
P.1.3	80–120	0,015–0,04	0,04–0,08	0,08–0,15
P.1.4	80–120	0,015–0,04	0,04–0,08	0,08–0,15
P.1.5	60–100	0,01–0,04	0,04–0,06	0,04–0,10
P.2.1	80–120	0,015–0,04	0,04–0,08	0,08–0,15
P.2.2	80–100	0,015–0,04	0,04–0,08	0,08–0,15
P.2.3	80–100	0,010–0,04	0,04–0,08	0,08–0,15
P.2.4	80–100	0,010–0,04	0,04–0,08	0,08–0,15
P.3.1	70–90	0,01–0,03	0,03–0,05	0,06–0,12
P.3.2	60–80	0,006–0,02	0,02–0,04	0,04–0,06
P.3.3	50–70	0,006–0,02	0,02–0,04	0,04–0,06
P.4.1	70–90	0,006–0,02	0,02–0,04	0,04–0,06
P.4.2	60–80	0,006–0,02	0,02–0,04	0,04–0,06
M.1.1	60–100	0,01–0,04	0,04–0,08	0,08–0,10
M.2.1	60–100	0,01–0,03	0,03–0,06	0,06–0,10
M.3.1	60–100	0,01–0,03	0,03–0,06	0,06–0,10
K.1.1	80–120	0,02–0,06	0,06–0,12	0,10–0,15
K.1.2	80–120	0,02–0,05	0,05–0,10	0,10–0,12
K.2.1	80–100	0,02–0,05	0,05–0,10	0,08–0,15
K.2.2	80–100	0,02–0,05	0,05–0,10	0,08–0,12
K.3.1	80–100	0,015–0,05	0,05–0,08	0,08–0,12
K.3.2	80–100	0,015–0,03	0,03–0,08	0,08–0,12
N.1.1	100–400	0,04–0,09	0,08–0,15	0,12–0,20
N.1.2	100–400	0,04–0,09	0,08–0,15	0,12–0,20
N.2.1	100–400	0,04–0,09	0,08–0,15	0,12–0,20
N.2.2	100–400	0,04–0,09	0,08–0,15	0,12–0,20
N.2.3	100–250	0,04–0,09	0,08–0,15	0,12–0,20
N.3.1	100–400	0,04–0,09	0,08–0,15	0,12–0,20
N.3.2	100–400	0,04–0,09	0,08–0,15	0,12–0,20
N.3.3	100–400	0,04–0,09	0,08–0,15	0,12–0,20
N.4.1	100–400	0,04–0,09	0,08–0,15	0,12–0,20
S.1.1	40–100	0,01–0,04	0,04–0,07	0,07–0,12
S.1.2				
S.2.1				
S.2.2				
S.2.3				
S.3.1	40–100	0,01–0,04	0,04–0,07	0,07–0,15
S.3.2				
S.3.3				
H.1.1				
H.1.2				
H.1.3				
H.1.4				
H.2.1				
H.3.1				
O.1.1	100–400	0,03–0,08	0,08–0,15	0,15–0,20
O.1.2	100–400	0,03–0,08	0,08–0,15	0,15–0,20
O.2.1	50–80	0,03–0,08	0,08–0,15	0,15–0,20
O.2.2	50–80	0,03–0,08	0,08–0,15	0,15–0,20
O.3.1				



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approximately $\pm 20\%$ according to the usage conditions.

Cutting data standard values

Index	50 525 ..., 50 526 ..., 50 527 ..., 50 528 ..., 50 529 ...					50 028 ...		
	SGF TOMILL					SGF	PCD	
	TiCN	uncoated	Ø 12	Ø 16	Ø 20		Ø 16	Ø 20
	v_c (m/min)	v_c (m/min)	f_z (mm/tooth)			v_c (m/min)	f_z (mm/tooth)	
P.1.1	100		0,05	0,08	0,10			
P.1.2	100		0,05	0,08	0,10			
P.1.3	100		0,04	0,06	0,08			
P.1.4	100		0,04	0,06	0,08			
P.1.5	80		0,04	0,06	0,08			
P.2.1	100		0,05	0,08	0,10			
P.2.2	100		0,04	0,06	0,08			
P.2.3	80		0,03	0,04	0,06			
P.2.4	80		0,03	0,04	0,06			
P.3.1	100		0,05	0,08	0,10			
P.3.2	80		0,05	0,08	0,10			
P.3.3	80		0,03	0,04	0,06			
P.4.1	100		0,03	0,04	0,06			
P.4.2	100		0,04	0,06	0,08			
M.1.1	60		0,03	0,04	0,06			
M.2.1	60		0,03	0,04	0,06			
M.3.1	60		0,03	0,04	0,06			
K.1.1	120	80	0,08	0,10	0,15			
K.1.2	120	80	0,08	0,10	0,15			
K.2.1	120		0,06	0,08	0,12			
K.2.2	100		0,06	0,08	0,10			
K.3.1	100		0,05	0,08	0,10			
K.3.2	100		0,05	0,08	0,10			
N.1.1	400	300	0,10	0,15	0,20	1500	0,11	0,14
N.1.2	400	300	0,10	0,15	0,20	1500	0,11	0,14
N.2.1	400	300	0,10	0,15	0,20	1500	0,11	0,14
N.2.2	400	300	0,10	0,15	0,20	1500	0,11	0,14
N.2.3	150	100	0,06	0,10	0,15	1500	0,11	0,14
N.3.1	400	300	0,08	0,12	0,18	1100	0,11	0,14
N.3.2	400	300	0,08	0,12	0,18	1100	0,11	0,14
N.3.3	300	200	0,06	0,10	0,15	1100	0,11	0,14
N.4.1	400	300	0,10	0,15	0,20	1100	0,11	0,14
S.1.1	50		0,06	0,08	0,10			
S.1.2	40		0,05	0,08	0,10			
S.2.1	40		0,05	0,08	0,10			
S.2.2	30		0,04	0,06	0,08			
S.2.3	30		0,04	0,06	0,08			
S.3.1	80		0,08	0,10	0,12			
S.3.2	60		0,08	0,10	0,12			
S.3.3	60		0,08	0,10	0,12			
H.1.1	30		0,015	0,03	0,05			
H.1.2	20		0,015	0,02	0,05			
H.1.3								
H.1.4								
H.2.1								
H.3.1								
O.1.1								
O.1.2								
O.2.1						1500	0,15	0,16
O.2.2						1500	0,15	0,16
O.3.1								



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approximately $\pm 20\%$ according to the usage conditions.

Cutting data standard values

Index	54 815 ..., 54 816 ..., 54 817 ..., 54 818 ..., 54 819 ..., 54 820 ...			
	SFSE	Ti500 – Standard Cutting		
		Solid carbide		
		Ø 2,4 – 6,0	Ø 6,0 – 10,0	Ø 10,0 – 20,0
	v_c (m/min)	f_z (mm/tooth)		
P.1.1	150	0,01–0,04	0,04–0,06	0,08–0,15
P.1.2	120	0,01–0,04	0,04–0,06	0,08–0,15
P.1.3	120	0,007–0,03	0,03–0,05	0,05–0,10
P.1.4	120	0,007–0,03	0,03–0,05	0,05–0,10
P.1.5	100	0,006–0,02	0,02–0,04	0,04–0,06
P.2.1	120	0,007–0,04	0,04–0,06	0,08–0,15
P.2.2	100	0,007–0,03	0,03–0,05	0,05–0,10
P.2.3	80	0,006–0,02	0,02–0,04	0,04–0,06
P.2.4	70	0,006–0,02	0,02–0,04	0,04–0,06
P.3.1	80	0,01–0,03	0,03–0,05	0,06–0,12
P.3.2	70	0,006–0,02	0,02–0,04	0,04–0,06
P.3.3	60	0,006–0,02	0,02–0,04	0,04–0,06
P.4.1	60	0,006–0,02	0,02–0,04	0,04–0,06
P.4.2	60	0,006–0,02	0,02–0,04	0,04–0,06
M.1.1	100	0,008–0,03	0,03–0,05	0,05–0,10
M.2.1	100	0,008–0,03	0,03–0,05	0,05–0,10
M.3.1	100	0,008–0,03	0,03–0,05	0,05–0,10
K.1.1	120	0,01–0,04	0,04–0,06	0,08–0,15
K.1.2	100	0,007–0,03	0,03–0,05	0,05–0,10
K.2.1	120	0,01–0,04	0,04–0,06	0,08–0,15
K.2.2	100	0,007–0,03	0,03–0,05	0,05–0,10
K.3.1	130	0,01–0,04	0,04–0,06	0,08–0,15
K.3.2	100	0,007–0,03	0,03–0,05	0,05–0,10
N.1.1	400	0,03–0,06	0,08–0,12	0,14–0,20
N.1.2	400	0,03–0,06	0,08–0,12	0,14–0,20
N.2.1	300	0,03–0,06	0,08–0,12	0,14–0,20
N.2.2	300	0,03–0,06	0,08–0,12	0,14–0,20
N.2.3	200	0,03–0,06	0,08–0,12	0,14–0,20
N.3.1	160	0,03–0,06	0,08–0,12	0,14–0,20
N.3.2	160	0,03–0,06	0,08–0,12	0,14–0,20
N.3.3	160	0,03–0,06	0,08–0,12	0,14–0,20
N.4.1	300	0,03–0,06	0,08–0,12	0,14–0,20
S.1.1	80	0,008–0,03	0,03–0,05	0,05–0,10
S.1.2	60	0,006–0,02	0,02–0,04	0,04–0,06
S.2.1	40	0,006–0,02	0,02–0,04	0,04–0,06
S.2.2	40	0,006–0,02	0,02–0,04	0,04–0,06
S.2.3	40	0,006–0,02	0,02–0,04	0,04–0,06
S.3.1	100	0,01–0,03	0,03–0,05	0,06–0,12
S.3.2	80	0,006–0,02	0,02–0,04	0,04–0,06
S.3.3	60	0,006–0,02	0,02–0,04	0,04–0,06
H.1.1	50	0,003–0,006	0,008–0,012	0,014–0,02
H.1.2	40		0,006–0,01	0,01–0,015
H.1.3				
H.1.4				
H.2.1	60		0,006–0,01	0,01–0,015
H.3.1	40		0,006–0,01	0,01–0,015
O.1.1	100	0,02–0,06	0,06–0,10	0,12–0,20
O.1.2	100	0,02–0,06	0,06–0,10	0,12–0,20
O.2.1	80	0,01–0,04	0,04–0,06	0,08–0,15
O.2.2	80	0,01–0,04	0,04–0,06	0,08–0,15
O.3.1	200	0,01–0,04	0,04–0,06	0,08–0,15



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Cutting data standard values

Index	50 551 ..., 50 552 ..., 50 553 ..., 50 554 ..., 50 555 ..., 50 556 ...			
	SFSE	AlTiN – Performance Cutting		
		Solid carbide		
		Ø 2,4 – 5,9	Ø 6,0 – 11,9	Ø 12,0 – 20,0
	v_c (m/min)	f_z (mm/tooth)		
P.1.1	80–150	0,015–0,04	0,04–0,08	0,08–0,15
P.1.2	80–120	0,015–0,04	0,04–0,08	0,08–0,15
P.1.3	80–120	0,015–0,04	0,04–0,08	0,08–0,15
P.1.4	80–120	0,015–0,04	0,04–0,08	0,08–0,15
P.1.5	60–100	0,01–0,04	0,04–0,06	0,04–0,10
P.2.1	80–120	0,015–0,04	0,04–0,08	0,08–0,15
P.2.2	80–100	0,015–0,04	0,04–0,08	0,08–0,15
P.2.3	80–100	0,010–0,04	0,04–0,08	0,08–0,15
P.2.4	80–100	0,010–0,04	0,04–0,08	0,08–0,15
P.3.1	70–90	0,01–0,03	0,03–0,05	0,06–0,12
P.3.2	60–80	0,006–0,02	0,02–0,04	0,04–0,06
P.3.3	50–70	0,006–0,02	0,02–0,04	0,04–0,06
P.4.1	70–90	0,006–0,02	0,02–0,04	0,04–0,06
P.4.2	60–80	0,006–0,02	0,02–0,04	0,04–0,06
M.1.1	60–100	0,01–0,04	0,04–0,08	0,08–0,10
M.2.1	60–100	0,01–0,03	0,03–0,06	0,06–0,10
M.3.1	60–100	0,01–0,03	0,03–0,06	0,06–0,10
K.1.1	80–120	0,02–0,06	0,06–0,12	0,10–0,15
K.1.2	80–120	0,02–0,05	0,05–0,10	0,10–0,12
K.2.1	80–100	0,02–0,05	0,05–0,10	0,08–0,15
K.2.2	80–100	0,02–0,05	0,05–0,10	0,08–0,12
K.3.1	80–100	0,015–0,05	0,05–0,08	0,08–0,12
K.3.2	80–100	0,015–0,03	0,03–0,08	0,08–0,12
N.1.1	100–400	0,04–0,09	0,08–0,15	0,12–0,20
N.1.2	100–400	0,04–0,09	0,08–0,15	0,12–0,20
N.2.1	100–400	0,04–0,09	0,08–0,15	0,12–0,20
N.2.2	100–400	0,04–0,09	0,08–0,15	0,12–0,20
N.2.3	100–250	0,04–0,09	0,08–0,15	0,12–0,20
N.3.1	100–400	0,04–0,09	0,08–0,15	0,12–0,20
N.3.2	100–400	0,04–0,09	0,08–0,15	0,12–0,20
N.3.3	100–400	0,04–0,09	0,08–0,15	0,12–0,20
N.4.1	100–400	0,04–0,09	0,08–0,15	0,12–0,20
S.1.1	40–100	0,01–0,04	0,04–0,07	0,07–0,12
S.1.2				
S.2.1				
S.2.2				
S.2.3				
S.3.1	40–100	0,01–0,04	0,04–0,07	0,07–0,15
S.3.2				
S.3.3				
H.1.1				
H.1.2				
H.1.3				
H.1.4				
H.2.1				
H.3.1				
O.1.1	100–400	0,03–0,08	0,08–0,15	0,15–0,20
O.1.2	100–400	0,03–0,08	0,08–0,15	0,15–0,20
O.2.1	50–80	0,03–0,08	0,08–0,15	0,15–0,20
O.2.2	50–80	0,03–0,08	0,08–0,15	0,15–0,20
O.3.1				



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Cutting data standard values

Index	50 806 ..., 50 807 ..., 50 548 ..., 50 549 ...			
	SFSE	AlCrN – HPC – High Performance Cutting		
		Solid carbide		
		Ø 3–5	Ø 6–10	Ø 10–13
	v_c (m/min)	f_z (mm/tooth)		
P.1.1	100–140	0,015–0,03	0,04–0,06	0,06–0,10
P.1.2	100–120	0,015–0,03	0,04–0,06	0,06–0,10
P.1.3	80–100	0,015–0,02	0,03–0,05	0,03–0,07
P.1.4	80–100	0,015–0,02	0,02–0,04	0,03–0,05
P.1.5	80–100	0,015–0,02	0,02–0,03	0,03–0,04
P.2.1	100–120	0,015–0,03	0,04–0,06	0,06–0,10
P.2.2	80–100	0,015–0,03	0,02–0,05	0,03–0,07
P.2.3	80–100	0,015–0,02	0,02–0,03	0,03–0,04
P.2.4	80–100	0,015–0,02	0,02–0,03	0,03–0,04
P.3.1	100–120	0,015–0,03	0,04–0,06	0,06–0,10
P.3.2	80–100	0,015–0,02	0,02–0,03	0,03–0,04
P.3.3	80–100	0,015–0,02	0,02–0,03	0,03–0,04
P.4.1	60–80	0,015–0,03	0,04–0,06	0,06–0,10
P.4.2	60–80	0,015–0,03	0,04–0,06	0,06–0,10
M.1.1	60–80	0,015–0,03	0,04–0,06	0,06–0,10
M.2.1	60–80	0,015–0,03	0,04–0,06	0,06–0,10
M.3.1	60–80	0,015–0,03	0,04–0,06	0,06–0,10
K.1.1	100–120	0,02–0,04	0,04–0,08	0,06–0,10
K.1.2	100–120	0,02–0,04	0,04–0,08	0,06–0,10
K.2.1	100–120	0,02–0,04	0,04–0,08	0,06–0,10
K.2.2	80–100	0,02–0,04	0,04–0,08	0,06–0,10
K.3.1	80–100	0,02–0,04	0,04–0,08	0,06–0,08
K.3.2	80–100	0,02–0,04	0,04–0,08	0,06–0,08
N.1.1				
N.1.2				
N.2.1				
N.2.2				
N.2.3				
N.3.1				
N.3.2				
N.3.3				
N.4.1				
S.1.1				
S.1.2				
S.2.1				
S.2.2				
S.2.3				
S.3.1	60–80	0,015–0,02	0,02–0,03	0,03–0,04
S.3.2	60–80	0,01–0,015	0,015–0,02	0,025–0,035
S.3.3				
H.1.1				
H.1.2				
H.1.3				
H.1.4				
H.2.1				
H.3.1				
O.1.1				
O.1.2				
O.2.1				
O.2.2				
O.3.1				



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Cutting data standard values

Index	50 804 ...	
	SFSE Micro	Ti602 Solid carbide Ø 0,7–2,1
	v_c (m/min)	f_z (mm/tooth)
P.1.1	20–40	0,01–0,02
P.1.2	20–40	0,01–0,02
P.1.3	20–40	0,01–0,02
P.1.4	20–40	0,01–0,02
P.1.5	20–40	0,01–0,02
P.2.1	20–40	0,01–0,02
P.2.2	20–40	0,01–0,02
P.2.3	20–40	0,01–0,02
P.2.4	20–40	0,01–0,02
P.3.1	20–40	0,01–0,02
P.3.2	20–40	0,01–0,02
P.3.3	20–40	0,01–0,02
P.4.1	20–40	0,01–0,02
P.4.2	20–40	0,01–0,02
M.1.1	20–30	0,01–0,02
M.2.1	20–30	0,01–0,02
M.3.1	20–30	0,01–0,02
K.1.1		
K.1.2		
K.2.1		
K.2.2		
K.3.1		
K.3.2		
N.1.1	30–50	0,02–0,03
N.1.2	30–50	0,02–0,03
N.2.1	30–50	0,02–0,03
N.2.2	30–50	0,02–0,03
N.2.3	30–50	0,02–0,03
N.3.1	30–50	0,02–0,03
N.3.2	30–50	0,02–0,03
N.3.3	30–50	0,02–0,03
N.4.1	30–50	0,02–0,03
S.1.1	20–30	0,01–0,02
S.1.2	20–30	0,01–0,02
S.2.1	20–30	0,01–0,02
S.2.2	20–30	0,01–0,015
S.2.3	20–30	0,01–0,015
S.3.1	20–30	0,01–0,02
S.3.2	20–30	0,01–0,015
S.3.3	20–30	0,01–0,015
H.1.1	20–30	0,01–0,015
H.1.2	20–30	0,01–0,015
H.1.3		
H.1.4		
H.2.1		
H.3.1		
O.1.1		
O.1.2		
O.2.1		
O.2.2		
O.3.1		



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Cutting data standard values

Index	50 281 ..., 50 284 ...								50 282 ..., 50 283 ..., 50 285 ...								
	BGF		HPC – High Performance Cutting						BGF		HPC – High Performance Cutting						
			1,5xD								2xD / 2,5xD						
			Drilling			Thread milling					Drilling			Thread milling			
	coated	uncoated	Ø 3–5	Ø 6–12	Ø 14–16	Ø 3–5	Ø 6–12	Ø 14–16	coated	uncoated	Ø 3–5	Ø 6–12	Ø 14–16	Ø 3–5	Ø 6–12	Ø 14–16	
	v _c (m/min)		f (mm/rev)			f _z (mm/tooth)				v _c (m/min)		f (mm/rev)			f _z (mm/tooth)		
P.1.1																	
P.1.2																	
P.1.3																	
P.1.4																	
P.1.5																	
P.2.1																	
P.2.2																	
P.2.3																	
P.2.4																	
P.3.1																	
P.3.2																	
P.3.3																	
P.4.1																	
P.4.2																	
M.1.1																	
M.2.1																	
M.3.1																	
K.1.1	80-120	80	0,14-0,22	0,22-0,33	0,25-0,50	0,03-0,07	0,07-0,15	0,09-0,20	80-120	50-80	0,09-0,22	0,22-0,33	0,25-0,40	0,03-0,07	0,07-0,15	0,15-0,20	
K.1.2	80-120	80	0,14-0,22	0,22-0,33	0,25-0,50	0,03-0,07	0,07-0,15	0,09-0,20	80-120	50-80	0,09-0,22	0,22-0,33	0,25-0,40	0,03-0,07	0,07-0,15	0,15-0,20	
K.2.1	60-100		0,09-0,12	0,12-0,22	0,22-0,35	0,06-0,09	0,09-0,17	0,12-0,20									
K.2.2	60-100			0,12-0,22	0,22-0,35		0,09-0,17	0,15-0,20									
K.3.1																	
K.3.2																	
N.1.1	100-400	100-400	0,15-0,37	0,3-0,45	0,14-0,50	0,06-0,09	0,09-0,15	0,15-0,21	100-400	100-400	0,15-0,37	0,37-0,45	0,14-0,50	0,04-0,09	0,09-0,15	0,15-0,21	
N.1.2	100-400	100-400	0,15-0,37	0,3-0,45	0,14-0,50	0,06-0,09	0,09-0,15	0,15-0,21	100-400	100-400	0,15-0,37	0,37-0,45	0,14-0,50	0,04-0,09	0,09-0,15	0,15-0,21	
N.2.1	100-300	100-400	0,25-0,37	0,3-0,45	0,35-0,50	0,06-0,09	0,09-0,15	0,15-0,21	100-300	100-400	0,15-0,37	0,37-0,45	0,35-0,50	0,04-0,09	0,09-0,15	0,15-0,21	
N.2.2	100-400	100-400	0,25-0,37	0,3-0,45	0,35-0,50	0,06-0,09	0,09-0,15	0,15-0,21	100-400	100-400	0,15-0,37	0,37-0,45	0,35-0,50	0,04-0,09	0,09-0,15	0,15-0,21	
N.2.3	100-160		0,25-0,37	0,3-0,45	0,35-0,50	0,06-0,09	0,09-0,15	0,15-0,21	100-160		0,15-0,37	0,37-0,45	0,35-0,50	0,04-0,09	0,09-0,15	0,15-0,21	
N.3.1	100-300	100-300	0,25-0,37	0,3-0,45	0,35-0,50	0,06-0,09	0,09-0,15	0,15-0,21	100-300	100-300	0,15-0,45	0,37-0,45	0,35-0,50	0,04-0,09	0,09-0,15	0,15-0,21	
N.3.2																	
N.3.3																	
N.4.1	100-400	100-400	0,25-0,37	0,3-0,45	0,35-0,50	0,06-0,09	0,09-0,15	0,15-0,21	100-400	100-400	0,15-0,37	0,37-0,45	0,35-0,50	0,04-0,09	0,09-0,15	0,15-0,21	
S.1.1																	
S.1.2																	
S.2.1																	
S.2.2																	
S.2.3																	
S.3.1																	
S.3.2																	
S.3.3																	
H.1.1																	
H.1.2																	
H.1.3																	
H.1.4																	
H.2.1																	
H.3.1																	
O.1.1	60-150	60-150	0,1-0,38	0,25-0,45	0,25-0,45	0,03-0,09	0,06-0,15	0,06-0,15	60-150	60-150	0,1-0,38	0,25-0,45	0,25-0,45	0,03-0,09	0,06-0,15	0,06-0,15	
O.1.2	60-150	60-150	0,1-0,38	0,25-0,45	0,25-0,45	0,03-0,09	0,06-0,15	0,06-0,15	60-150	60-150	0,1-0,38	0,25-0,45	0,25-0,45	0,03-0,09	0,06-0,15	0,06-0,15	
O.2.1	60-150	60-150	0,1-0,38	0,25-0,45	0,25-0,45	0,03-0,09	0,06-0,15	0,06-0,15	60-150	60-150	0,1-0,38	0,25-0,45	0,25-0,45	0,03-0,09	0,06-0,15	0,06-0,15	
O.2.2	60-150	60-150	0,1-0,38	0,25-0,45	0,25-0,45	0,03-0,09	0,06-0,15	0,06-0,15	60-150	60-150	0,1-0,38	0,25-0,45	0,25-0,45	0,03-0,09	0,06-0,15	0,06-0,15	
O.3.1	60-150	60-150	0,1-0,38	0,25-0,45	0,25-0,45	0,03-0,09	0,06-0,15	0,06-0,15	60-150	60-150	0,1-0,38	0,25-0,45	0,25-0,45	0,03-0,09	0,06-0,15	0,06-0,15	



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approximately **±20%** according to the usage conditions.

Cutting data standard values

Index	50 534 ..., 50 535 ..., 50 536 ..., 50 537 ...								50 538 ..., 50 539 ..., 50 540 ..., 50 541 ..., 50 542 ..., 50 854 ..., 50 862 ..., 50 869 ..., 50 898 ...								50 543 ..., 50 544 ...					
	BGF		1,5xD						BGF		2xD / 2,5xD						BGF		3xD			
			Drilling			Thread milling					Drilling			Thread milling					Drilling		Thread milling	
	coated	uncoated	Ø 3–5	Ø 6–12	Ø 14–16	Ø 3–5	Ø 6–12	Ø 14–16	coated	uncoated	Ø 3–5	Ø 6–12	Ø 14–16	Ø 3–5	Ø 6–12	Ø 14–16	uncoated	Ø 3–5	Ø 6–12	Ø 3–5	Ø 6–12	
	v _c (m/min)	f (mm/rev)			f _z (mm/tooth)			v _c (m/min)	f (mm/rev)			f _z (mm/tooth)			v _c (m/min)	f (mm/rev)		f _z (mm/tooth)				
P.1.1																						
P.1.2																						
P.1.3																						
P.1.4																						
P.1.5																						
P.2.1																						
P.2.2																						
P.2.3																						
P.2.4																						
P.3.1																						
P.3.2																						
P.3.3																						
P.4.1																						
P.4.2																						
M.1.1																						
M.2.1																						
M.3.1																						
K.1.1	120	80	0,10	0,15	0,18	0,02	0,07	0,10	120	80	0,10	0,15	0,18	0,02	0,07	0,10						
K.1.2	120	80	0,10	0,15	0,18	0,04	0,07	0,10	120	80	0,10	0,15	0,18	0,04	0,07	0,10						
K.2.1	100		0,06	0,08	0,15	0,04	0,06	0,08														
K.2.2	100			0,08	0,12		0,06	0,10														
K.3.1																						
K.3.2																						
N.1.1	150	150	0,03	0,05	0,10	0,04	0,08	0,10	150	150	0,03	0,05	0,10	0,04	0,08	0,10						
N.1.2	200	200	0,04	0,06	0,10	0,05	0,08	0,10	200	200	0,04	0,06	0,10	0,05	0,08	0,10						
N.2.1	200	200	0,20	0,25	0,25	0,05	0,08	0,10	200	200	0,20	0,25	0,25	0,05	0,08	0,10	200	0,08	0,10	0,05	0,07	
N.2.2	200	200	0,20	0,25	0,25	0,05	0,08	0,10	200	200	0,20	0,25	0,25	0,05	0,08	0,10	200	0,08	0,10	0,05	0,07	
N.2.3	160		0,20	0,25	0,25	0,05	0,08	0,10	160		0,20	0,25	0,25	0,05	0,08	0,10						
N.3.1	200	200	0,20	0,25	0,25	0,05	0,08	0,10	200	200	0,20	0,25	0,25	0,05	0,08	0,10						
N.3.2																						
N.3.3																						
N.4.1	200	200	0,20	0,25	0,25	0,05	0,08	0,10	200	200	0,20	0,25	0,25	0,05	0,08	0,10						
S.1.1																						
S.1.2																						
S.2.1																						
S.2.2																						
S.2.3																						
S.3.1																						
S.3.2																						
S.3.3																						
H.1.1																						
H.1.2																						
H.1.3																						
H.1.4																						
H.2.1																						
H.3.1																						
O.1.1																						
O.1.2																						
O.2.1																						
O.2.2																						
O.3.1																						



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approximately $\pm 20\%$ according to the usage conditions.

Cutting data standard values

Index	50 840 ...			
	ZBGF	TiCN Solid carbide		
		Ø 3–5	Ø 6–10	Ø 12–16
	v_c (m/min)	f_z (mm/tooth)		
P.1.1				
P.1.2				
P.1.3				
P.1.4				
P.1.5				
P.2.1				
P.2.2				
P.2.3				
P.2.4				
P.3.1				
P.3.2				
P.3.3				
P.4.1				
P.4.2				
M.1.1				
M.2.1				
M.3.1				
K.1.1				
K.1.2				
K.2.1				
K.2.2				
K.3.1				
K.3.2				
N.1.1				
N.1.2				
N.2.1				
N.2.2				
N.2.3				
N.3.1				
N.3.2				
N.3.3				
N.4.1				
S.1.1				
S.1.2	80	0,01	0,03	0,03
S.2.1	60	0,01	0,02	0,02
S.2.2	60	0,01	0,02	0,02
S.2.3	60	0,01	0,02	0,02
S.3.1				
S.3.2	80	0,01	0,03	0,03
S.3.3	60	0,01	0,02	0,02
H.1.1	80	0,01	0,03	0,03
H.1.2	60	0,01	0,02	0,02
H.1.3	40	0,005	0,01	0,01
H.1.4				
H.2.1	100	0,03	0,04	0,04
H.3.1	60	0,01	0,02	0,02
O.1.1				
O.1.2				
O.2.1				
O.2.2				
O.3.1	180	0,04	0,05	0,08



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approximately **±20%** according to the usage conditions.

Cutting data standard values

Index	50 545 ..., 50 550 ..., 50 557 ..., 50 559 ..., 50 568 ..., 50 569 ...			
	ZSGF	AlTiN – Performance		
		Solid carbide		
		Ø 1,5–5,9	Ø 6,0–11,9	Ø 12,0–20,0
	v_c (m/min)	f_z (mm/tooth)		
P.1.1	60–120	0,04–0,11	0,13–0,17	0,18–0,20
P.1.2	60–120	0,04–0,11	0,13–0,17	0,18–0,20
P.1.3	60–120	0,04–0,11	0,13–0,17	0,18–0,20
P.1.4	60–120	0,04–0,11	0,13–0,17	0,18–0,20
P.1.5	60–120	0,04–0,11	0,13–0,17	0,18–0,20
P.2.1	60–90	0,03–0,08	0,09–0,14	0,14–0,18
P.2.2	60–90	0,03–0,08	0,09–0,14	0,14–0,18
P.2.3	60–90	0,03–0,08	0,09–0,14	0,14–0,18
P.2.4	60–90	0,03–0,08	0,09–0,14	0,14–0,18
P.3.1	50–80	0,03–0,08	0,09–0,14	0,14–0,18
P.3.2	50–80	0,03–0,08	0,09–0,14	0,14–0,18
P.3.3	50–80	0,03–0,08	0,09–0,14	0,14–0,18
P.4.1	50–80	0,03–0,08	0,09–0,14	0,14–0,18
P.4.2	50–80	0,03–0,08	0,09–0,14	0,14–0,18
M.1.1	60–90	0,02–0,06	0,06–0,11	0,12–0,13
M.2.1	60–90	0,02–0,06	0,06–0,11	0,12–0,13
M.3.1	60–90	0,02–0,06	0,06–0,11	0,12–0,13
K.1.1	40–80	0,04–0,11	0,13–0,17	0,17–0,18
K.1.2	40–80	0,04–0,11	0,13–0,17	0,17–0,18
K.2.1	40–80	0,04–0,11	0,13–0,17	0,17–0,18
K.2.2	40–80	0,04–0,11	0,13–0,17	0,17–0,18
K.3.1	40–80	0,04–0,11	0,13–0,17	0,17–0,18
K.3.2	40–80	0,04–0,11	0,13–0,17	0,17–0,18
N.1.1	100–200	0,04–0,11	0,13–0,16	0,17–0,18
N.1.2	100–200	0,04–0,11	0,13–0,16	0,17–0,18
N.2.1	100–200	0,04–0,1	0,07–0,16	0,17–0,18
N.2.2	100–200	0,04–0,1	0,07–0,16	0,17–0,18
N.2.3	60–140	0,04–0,06	0,07–0,11	0,13–0,14
N.3.1	50–200	0,05–0,16	0,14–0,19	0,19–0,20
N.3.2	50–200	0,05–0,16	0,14–0,19	0,19–0,20
N.3.3	50–200	0,05–0,16	0,14–0,19	0,19–0,20
N.4.1	50–200	0,04–0,11	0,07–0,17	0,17–0,18
S.1.1	20–40	0,03–0,05	0,06–0,07	0,08
S.1.2	20–40	0,03–0,05	0,06–0,07	0,08
S.2.1	20–40	0,03–0,05	0,06–0,07	0,08
S.2.2	20–40	0,03–0,05	0,06–0,07	0,08
S.2.3	20–40	0,03–0,05	0,06–0,07	0,08
S.3.1	20–40	0,03–0,05	0,06–0,07	0,08
S.3.2	20–40	0,03–0,05	0,06–0,07	0,08
S.3.3	20–40	0,03–0,05	0,06–0,07	0,08
H.1.1				
H.1.2				
H.1.3				
H.1.4				
H.2.1				
H.3.1				
O.1.1	100–200	0,06–0,16	0,19–0,22	0,22–0,3
O.1.2	100–200	0,06–0,16	0,19–0,22	0,22–0,3
O.2.1	100–200	0,06–0,16	0,19–0,22	0,22–0,3
O.2.2	100–200	0,06–0,16	0,19–0,22	0,22–0,3
O.3.1	60–140	0,05–0,15	0,14–0,20	0,20–0,25



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approximately $\pm 20\%$ according to the usage conditions.

Cutting data standard values

Index	50 546 ..., 50 547 ...		
	HR	TiCN Solid carbide	
		< Ø 10	> Ø 10
	v_c (m/min)	f_z (mm/tooth)	
P.1.1	100	0,025	0,05
P.1.2	100	0,025	0,05
P.1.3	100	0,025	0,05
P.1.4	80	0,015	0,035
P.1.5	80	0,015	0,035
P.2.1	100	0,025	0,05
P.2.2	80	0,015	0,035
P.2.3	80	0,015	0,035
P.2.4	80	0,015	0,035
P.3.1	100	0,025	0,05
P.3.2	80	0,015	0,035
P.3.3	80	0,02	0,04
P.4.1	80	0,02	0,04
P.4.2	80	0,02	0,04
M.1.1	80	0,02	0,04
M.2.1	80	0,02	0,04
M.3.1	80	0,02	0,04
K.1.1	120	0,03	0,09
K.1.2	120	0,03	0,09
K.2.1	100	0,02	0,05
K.2.2	100	0,02	0,05
K.3.1	100	0,02	0,05
K.3.2	100	0,02	0,05
N.1.1	350	0,05	0,1
N.1.2	350	0,05	0,1
N.2.1	350	0,05	0,1
N.2.2	250	0,05	0,1
N.2.3	250	0,05	0,1
N.3.1	350	0,05	0,1
N.3.2	350	0,05	0,1
N.3.3	350	0,05	0,1
N.4.1	350	0,05	0,1
S.1.1	40	0,02	0,05
S.1.2	20	0,02	0,05
S.2.1	20	0,02	0,05
S.2.2			
S.2.3			
S.3.1	100	0,02	0,05
S.3.2	80	0,02	0,05
S.3.3	80	0,02	0,05
H.1.1	40	0,008	0,017
H.1.2	25	0,005	0,012
H.1.3			
H.1.4			
H.2.1	60	0,02	0,04
H.3.1	25	0,005	0,012
O.1.1	120	0,04	0,1
O.1.2	120	0,04	0,1
O.2.1	80	0,04	0,1
O.2.2	80	0,04	0,1
O.3.1	130	0,04	0,1



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approximately $\pm 20\%$ according to the usage conditions.

Cutting data standard values

Index	53 050 ..., 53 051 ..., 53 052 ..., 53 053 ...	
	Micro Mill	
	v_c (m/min)	f_z (mm/tooth)
P.1.1	70 (40–120)	0,01–0,05
P.1.2	60 (40–110)	0,01–0,05
P.1.3	50 (30–80)	0,01–0,05
P.1.4	50 (30–80)	0,01–0,05
P.1.5	40 (30–70)	0,01–0,05
P.2.1	50 (30–80)	0,01–0,05
P.2.2	40 (30–70)	0,01–0,05
P.2.3	40 (20–70)	0,01–0,05
P.2.4	30 (20–60)	0,01–0,04
P.3.1	30 (20–60)	0,01–0,05
P.3.2	30 (20–50)	0,01–0,04
P.3.3	20 (10–40)	0,005–0,03
P.4.1	40 (30–70)	0,01–0,05
P.4.2	40 (20–70)	0,01–0,05
M.1.1	50 (30–80)	0,01–0,03
M.2.1	40 (20–70)	0,01–0,03
M.3.1	30 (20–50)	0,01–0,03
K.1.1	60 (40–110)	0,008–0,06
K.1.2	50 (30–80)	0,008–0,06
K.2.1	40 (30–70)	0,008–0,06
K.2.2	30 (20–60)	0,008–0,06
K.3.1	60 (40–110)	0,008–0,06
K.3.2	50 (30–90)	0,008–0,06
N.1.1	150 (90–260)	0,01–0,06
N.1.2	140 (90–240)	0,01–0,06
N.2.1	120 (70–210)	0,01–0,06
N.2.2	100 (60–180)	0,01–0,06
N.2.3	60 (40–110)	0,01–0,06
N.3.1	110 (70–180)	0,01–0,06
N.3.2	80 (50–150)	0,01–0,06
N.3.3	80 (50–140)	0,01–0,06
N.4.1	70 (40–120)	0,01–0,06
S.1.1	30 (20–50)	0,01–0,06
S.1.2	20 (10–30)	0,01–0,06
S.2.1	30 (20–50)	0,01–0,06
S.2.2	20 (10–40)	0,01–0,06
S.2.3	20 (10–30)	0,01–0,06
S.3.1	20 (10–40)	0,01–0,06
S.3.2	20 (10–30)	0,01–0,06
S.3.3	10 (10–20)	0,01–0,06
H.1.1	20 (10–40)	0,005–0,03
H.1.2		
H.1.3		
H.1.4		
H.2.1		
H.3.1	20 (10–40)	0,005–0,03
O.1.1	80 (50–130)	0,02–0,09
O.1.2	70 (40–120)	0,02–0,09
O.2.1	50 (30–100)	0,02–0,09
O.2.2	40 (30–70)	0,02–0,09
O.3.1	60 (40–110)	0,02–0,09



The cutting data depend heavily on the external conditions, the material, and the machine type. The specified values represent guideline values that must be increased or reduced, within the range shown in brackets, according to the application conditions.

Cutting data standard values

Index	50 890 ..., 50 891 ..., 50 892 ..., 50 896 ..., 50 897 ...		50 890 ..., 50 891 ..., 50 895 ...	
	MWN	uncoated Solid carbide	MWN	TiAlN Solid carbide
	v_c (m/min)	f_z (mm/tooth)	v_c (m/min)	f_z (mm/tooth)
P.1.1	85	0,10	170	0,10
P.1.2	75	0,10	150	0,10
P.1.3	65	0,10	130	0,10
P.1.4	65	0,07	130	0,07
P.1.5	60	0,07	120	0,07
P.2.1	70	0,10	140	0,10
P.2.2	65	0,07	130	0,07
P.2.3	60	0,07	120	0,07
P.2.4	45	0,06	90	0,06
P.3.1	45	0,10	90	0,10
P.3.2	40	0,07	80	0,07
P.3.3	35	0,06	70	0,06
P.4.1	45	0,10	90	0,10
P.4.2	40	0,10	80	0,10
M.1.1	40	0,06	80	0,06
M.2.1	30	0,05	60	0,05
M.3.1	30	0,05	60	0,05
K.1.1	85	0,12	170	0,12
K.1.2	75	0,12	150	0,12
K.2.1	75	0,07	150	0,07
K.2.2	65	0,07	130	0,07
K.3.1	70	0,10	140	0,10
K.3.2	60	0,10	120	0,10
N.1.1	120	0,15	240	0,15
N.1.2	105	0,12	210	0,12
N.2.1	75	0,12	150	0,12
N.2.2	75	0,12	150	0,12
N.2.3	70	0,12	140	0,12
N.3.1	105	0,15	210	0,15
N.3.2	105	0,15	210	0,15
N.3.3	75	0,15	150	0,15
N.4.1	85	0,15	170	0,15
S.1.1				
S.1.2				
S.2.1				
S.2.2				
S.2.3				
S.3.1				
S.3.2				
S.3.3				
H.1.1				
H.1.2				
H.1.3				
H.1.4				
H.2.1				
H.3.1				
O.1.1	140	0,16		
O.1.2	140	0,16		
O.2.1	75	0,07		
O.2.2	75	0,07		
O.3.1			130	0,07



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approximately $\pm 20\%$ according to the usage conditions.

Cutting data standard values

Index	50 863 ..., 50 864 ...			50 885 ..., 50 887 ..., 50 888 ..., 50 889 ..., 50 894 ...		
	GZD	Ti500 Solid carbide		GZG	Ti500 Solid carbide	
		Ø 12–17	Ø 20–26		Ø 12–17	Ø 20–26
	v_c (m/min)	f_z (mm/tooth)		v_c (m/min)	f_z (mm/tooth)	
P.1.1	220	0,10–0,30	0,05–0,30	220	0,10–0,30	0,05–0,30
P.1.2	220	0,10–0,30	0,05–0,30	220	0,10–0,30	0,05–0,30
P.1.3	190	0,10–0,30	0,05–0,30	190	0,10–0,30	0,05–0,30
P.1.4	160	0,10–0,30	0,05–0,30	160	0,10–0,30	0,05–0,30
P.1.5	160	0,10–0,30	0,05–0,30	160	0,10–0,30	0,05–0,30
P.2.1	150	0,10–0,30	0,05–0,30	150	0,10–0,30	0,05–0,30
P.2.2	120	0,10–0,30	0,05–0,30	120	0,10–0,30	0,05–0,30
P.2.3	100	0,10–0,30	0,05–0,30	100	0,10–0,30	0,05–0,30
P.2.4	90	0,10–0,30	0,05–0,30	90	0,10–0,30	0,05–0,30
P.3.1	100	0,10–0,20	0,05–0,20	100	0,10–0,20	0,05–0,20
P.3.2	90	0,10–0,20	0,05–0,20	90	0,10–0,20	0,05–0,20
P.3.3	80	0,10–0,20	0,05–0,20	80	0,10–0,20	0,05–0,20
P.4.1	70	0,10–0,20	0,05–0,20	70	0,10–0,20	0,05–0,20
P.4.2	60	0,10–0,20	0,05–0,20	60	0,10–0,20	0,05–0,20
M.1.1	130	0,10–0,30	0,05–0,30	130	0,10–0,30	0,05–0,30
M.2.1	120	0,10–0,30	0,05–0,30	120	0,10–0,30	0,05–0,30
M.3.1	120	0,10–0,30	0,05–0,30	120	0,10–0,30	0,05–0,30
K.1.1	140	0,10–0,30	0,05–0,30	140	0,10–0,30	0,05–0,30
K.1.2	100	0,10–0,30	0,05–0,30	100	0,10–0,30	0,05–0,30
K.2.1	140	0,10–0,30	0,05–0,30	140	0,10–0,30	0,05–0,30
K.2.2	120	0,10–0,30	0,05–0,30	120	0,10–0,30	0,05–0,30
K.3.1	140	0,10–0,30	0,05–0,30	140	0,10–0,30	0,05–0,30
K.3.2	100	0,10–0,30	0,05–0,30	100	0,10–0,30	0,05–0,30
N.1.1	700	0,10–0,40	0,05–0,40	700	0,10–0,40	0,05–0,40
N.1.2	400	0,10–0,40	0,05–0,40	400	0,10–0,40	0,05–0,40
N.2.1	400	0,10–0,40	0,05–0,40	400	0,10–0,40	0,05–0,40
N.2.2	300	0,10–0,40	0,05–0,40	300	0,10–0,40	0,05–0,40
N.2.3	200	0,10–0,40	0,05–0,40	200	0,10–0,40	0,05–0,40
N.3.1	160	0,10–0,40	0,05–0,40	160	0,10–0,40	0,05–0,40
N.3.2	160	0,10–0,40	0,05–0,40	160	0,10–0,40	0,05–0,40
N.3.3	160	0,10–0,40	0,05–0,40	160	0,10–0,40	0,05–0,40
N.4.1	160	0,10–0,40	0,05–0,40	160	0,10–0,40	0,05–0,40
S.1.1						
S.1.2						
S.2.1						
S.2.2						
S.2.3						
S.3.1						
S.3.2						
S.3.3						
H.1.1						
H.1.2						
H.1.3						
H.1.4						
H.2.1						
H.3.1						
O.1.1						
O.1.2						
O.2.1						
O.2.2						
O.3.1						



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approximately $\pm 20\%$ according to the usage conditions.

Cutting data standard values

Index	50 860 ..., 50 861 ..., 50 867 ..., 50 868 ...		50 870 ...	
	EAW		EWM	
	v_c (m/min)	f_z (mm/tooth)	v_c (m/min)	f_z (mm/tooth)
P.1.1	280	0,20	280	0,20
P.1.2	240	0,20	240	0,20
P.1.3	200	0,20	200	0,20
P.1.4	200	0,15	200	0,15
P.1.5	180	0,15	180	0,15
P.2.1	220	0,20	220	0,20
P.2.2	200	0,15	200	0,15
P.2.3	180	0,15	180	0,15
P.2.4	150	0,12	150	0,12
P.3.1	150	0,20	150	0,20
P.3.2	130	0,10	130	0,10
P.3.3	110	0,10	110	0,10
P.4.1	150	0,20	150	0,20
P.4.2	130	0,20	130	0,20
M.1.1	130	0,10	130	0,10
M.2.1	90	0,08	90	0,08
M.3.1	90	0,08	90	0,08
K.1.1	280	0,25	280	0,25
K.1.2	240	0,25	240	0,25
K.2.1	240	0,15	240	0,15
K.2.2	200	0,15	200	0,15
K.3.1	220	0,20	220	0,20
K.3.2	190	0,20	190	0,20
N.1.1	390	0,30	390	0,30
N.1.2	330	0,25	330	0,25
N.2.1	240	0,25	240	0,25
N.2.2	240	0,25	240	0,25
N.2.3	220	0,25	220	0,25
N.3.1	330	0,30	330	0,30
N.3.2	330	0,30	330	0,30
N.3.3	240	0,30	240	0,30
N.4.1	280	0,30	280	0,30
S.1.1	110	0,10	110	0,10
S.1.2	90	0,07	90	0,07
S.2.1	70	0,05	70	0,05
S.2.2	70	0,05	70	0,05
S.2.3	70	0,05	70	0,05
S.3.1	130	0,10	130	0,10
S.3.2	90	0,07	90	0,07
S.3.3	70	0,05	70	0,05
H.1.1	80	0,05	80	0,05
H.1.2	60	0,04	60	0,04
H.1.3				
H.1.4				
H.2.1	80	0,05	80	0,05
H.3.1	60	0,04	60	0,04
O.1.1				
O.1.2				
O.2.1				
O.2.2				
O.3.1	200	0,14	200	0,14



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approximately $\pm 20\%$ according to the usage conditions.

Cutting data standard values

Index	53 006 ..., 53 007 ..., 53 008 ..., 53 009 ..., 53 010 ..., 53 011 ..., 53 012 ..., 53 013 ..., 53 015 ..., 53 016 ..., 53 017 ...			
	Mini Mill	Bore (circular milling)	Thread (thread milling)	Parting (multipurpose milling)
	v_c (m/min)	f_z (mm/tooth)		
P.1.1	120 (80–200)	0,03–0,10	0,05–0,20	0,015–0,05
P.1.2	110 (70–190)	0,03–0,10	0,05–0,20	0,015–0,05
P.1.3	90 (60–150)	0,03–0,10	0,05–0,20	0,015–0,05
P.1.4	90 (60–150)	0,03–0,08	0,05–0,18	0,015–0,04
P.1.5	70 (50–120)	0,03–0,08	0,05–0,18	0,015–0,04
P.2.1	90 (60–150)	0,03–0,10	0,05–0,20	0,015–0,05
P.2.2	70 (50–120)	0,03–0,08	0,05–0,18	0,015–0,04
P.2.3	60 (40–110)	0,02–0,07	0,05–0,16	0,015–0,035
P.2.4	60 (40–100)	0,03–0,07	0,05–0,16	0,015–0,035
P.3.1	60 (40–100)	0,03–0,10	0,05–0,20	0,015–0,05
P.3.2	50 (30–80)	0,02–0,07	0,05–0,16	0,015–0,035
P.3.3	30 (20–60)	0,02–0,07	0,05–0,16	0,015–0,035
P.4.1	80 (50–130)	0,03–0,08	0,05–0,18	0,015–0,04
P.4.2	60 (40–110)	0,02–0,07	0,05–0,16	0,015–0,035
M.1.1	90 (60–150)	0,02–0,07	0,05–0,16	0,015–0,035
M.2.1	60 (40–110)	0,02–0,07	0,05–0,16	0,015–0,035
M.3.1	50 (30–90)	0,02–0,07	0,05–0,16	0,015–0,035
K.1.1	110 (70–190)	0,03–0,10	0,05–0,20	0,015–0,05
K.1.2	80 (50–140)	0,03–0,10	0,05–0,20	0,015–0,05
K.2.1	70 (50–120)	0,03–0,10	0,05–0,20	0,015–0,05
K.2.2	60 (40–100)	0,03–0,10	0,05–0,20	0,015–0,05
K.3.1	110 (70–190)	0,03–0,10	0,05–0,20	0,015–0,05
K.3.2	90 (60–160)	0,03–0,10	0,05–0,20	0,015–0,05
N.1.1	230 (150–390)	0,04–0,15	0,06–0,25	0,02–0,075
N.1.2	220 (140–370)	0,04–0,15	0,06–0,25	0,02–0,075
N.2.1	190 (120–320)	0,04–0,15	0,06–0,25	0,02–0,075
N.2.2	160 (110–270)	0,04–0,15	0,06–0,25	0,02–0,075
N.2.3	90 (60–160)	0,04–0,15	0,06–0,25	0,02–0,075
N.3.1	170 (110–280)	0,04–0,15	0,06–0,25	0,02–0,075
N.3.2	140 (90–240)	0,04–0,15	0,06–0,25	0,02–0,075
N.3.3	120 (80–210)	0,04–0,15	0,06–0,25	0,02–0,075
N.4.1	170 (110–280)	0,04–0,15	0,06–0,25	0,02–0,075
S.1.1	60 (40–100)	0,04–0,15	0,06–0,25	0,02–0,075
S.1.2	40 (30–70)	0,04–0,15	0,06–0,25	0,02–0,075
S.2.1	60 (40–100)	0,04–0,15	0,06–0,25	0,02–0,075
S.2.2	50 (30–80)	0,04–0,15	0,06–0,25	0,02–0,075
S.2.3	30 (20–60)	0,04–0,15	0,06–0,25	0,02–0,075
S.3.1	60 (40–100)	0,04–0,15	0,06–0,25	0,02–0,075
S.3.2	30 (20–60)	0,04–0,15	0,06–0,25	0,02–0,075
S.3.3	30 (20–50)	0,04–0,15	0,06–0,25	0,02–0,075
H.1.1	50 (30–90)	0,02–0,06	0,04–0,14	0,02–0,037
H.1.2				
H.1.3				
H.1.4				
H.2.1				
H.3.1	40 (30–70)	0,02–0,10		0,015–0,05
O.1.1	180 (120–310)	0,04–0,15	0,06–0,25	0,02–0,037
O.1.2	170 (110–280)	0,04–0,15	0,06–0,25	0,02–0,037
O.2.1	140 (90–230)	0,04–0,15	0,06–0,25	0,02–0,037
O.2.2	100 (70–170)	0,04–0,15	0,06–0,25	0,02–0,037
O.3.1	140 (90–230)	0,005–0,05	0,06–0,25	0,0025–0,025



The cutting data depend heavily on the external conditions, the material, and the machine type. The specified values represent guideline values that must be increased or reduced, within the range shown in brackets, according to the application conditions.

Cutting data standard values

Index	50 872 ..., 50 875 ..., 50 876 ..., 50 879 ..., 50 880 ..., 50 881 ..., 50 882 ..., 50 883 ..., 50 884 ..., 50 886 ...		51 800 ...	
	Polygon		Polygon	Multipurpose milling
	v_c (m/min)	f_z (mm/tooth)	v_c (m/min)	f_z (mm/tooth)
P.1.1	220	0,05–0,25	220	0,03–0,10
P.1.2	220	0,05–0,25	220	0,03–0,10
P.1.3	190	0,05–0,25	190	0,03–0,10
P.1.4	160	0,05–0,25	160	0,03–0,09
P.1.5	160	0,05–0,25	160	0,03–0,09
P.2.1	150	0,05–0,25	150	0,03–0,10
P.2.2	120	0,05–0,25	120	0,03–0,09
P.2.3	100	0,05–0,25	100	0,03–0,09
P.2.4	90	0,05–0,25	90	0,03–0,09
P.3.1	100	0,05–0,20	100	0,03–0,10
P.3.2	90	0,05–0,20	90	0,03–0,08
P.3.3	80	0,05–0,20	80	0,03–0,08
P.4.1	70	0,05–0,20	70	0,03–0,08
P.4.2	60	0,05–0,20	60	0,03–0,08
M.1.1	130	0,05–0,25	130	0,03–0,08
M.2.1	120	0,05–0,25	120	0,03–0,08
M.3.1	120	0,05–0,25	120	0,03–0,08
K.1.1	140	0,05–0,25	140	0,03–0,11
K.1.2	100	0,05–0,25	100	0,03–0,10
K.2.1	140	0,05–0,25	140	0,03–0,11
K.2.2	120	0,05–0,25	120	0,03–0,10
K.3.1	140	0,05–0,25	140	0,03–0,11
K.3.2	100	0,05–0,25	100	0,03–0,10
N.1.1	700	0,15–0,40	700	0,04–0,15
N.1.2	400	0,15–0,40	400	0,04–0,15
N.2.1	400	0,15–0,40	400	0,04–0,15
N.2.2	300	0,15–0,40	300	0,04–0,15
N.2.3	200	0,15–0,40	200	0,04–0,15
N.3.1	160	0,15–0,40	160	0,04–0,15
N.3.2	160	0,15–0,40	160	0,04–0,15
N.3.3	160	0,15–0,40	160	0,04–0,15
N.4.1	160	0,15–0,40	160	0,04–0,15
S.1.1	100	0,01–0,15	100	0,01–0,11
S.1.2	80	0,01–0,15	80	0,01–0,11
S.2.1	60	0,01–0,15	60	0,01–0,11
S.2.2	40	0,01–0,15	40	0,01–0,11
S.2.3	40	0,01–0,15	40	0,01–0,11
S.3.1	100	0,01–0,15	100	0,01–0,11
S.3.2	80	0,01–0,15	80	0,01–0,11
S.3.3	60	0,01–0,15	60	0,01–0,11
H.1.1	60	0,01–0,10	60	0,01–0,06
H.1.2	50	0,01–0,10	50	0,01–0,06
H.1.3	40	0,01–0,10	40	0,01–0,06
H.1.4	30	0,01–0,10	30	0,01–0,06
H.2.1	60	0,01–0,10	60	0,01–0,06
H.3.1	50	0,01–0,10	50	0,01–0,06
O.1.1	180	0,05–0,25	180	0,04–0,15
O.1.2	220	0,05–0,25	220	0,04–0,15
O.2.1	120	0,05–0,25	120	0,04–0,15
O.2.2	120	0,05–0,25	120	0,04–0,15
O.3.1	800	0,05–0,25	800	0,04–0,15



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approximately $\pm 20\%$ according to the usage conditions.

Cutting data standard values

Index	50 851 ..., 50 852 ..., 50 853 ..., 50 855 ..., 50 857 ..., 50 858 ..., 50 859 ...	
	System 300	
	v_c (m/min)	f_z (mm/tooth)
P.1.1	220	0,05–0,15
P.1.2	220	0,05–0,15
P.1.3	190	0,05–0,15
P.1.4	160	0,05–0,15
P.1.5	160	0,05–0,15
P.2.1	150	0,05–0,15
P.2.2	120	0,05–0,15
P.2.3	100	0,05–0,15
P.2.4	90	0,05–0,15
P.3.1	100	0,05–0,12
P.3.2	90	0,05–0,12
P.3.3	80	0,05–0,12
P.4.1	70	0,05–0,12
P.4.2	60	0,05–0,12
M.1.1	130	0,05–0,15
M.2.1	120	0,05–0,15
M.3.1	120	0,05–0,15
K.1.1	140	0,05–0,15
K.1.2	100	0,05–0,15
K.2.1	140	0,05–0,15
K.2.2	120	0,05–0,15
K.3.1	140	0,05–0,15
K.3.2	100	0,05–0,15
N.1.1	700	0,10–0,25
N.1.2	400	0,10–0,25
N.2.1	400	0,10–0,25
N.2.2	300	0,10–0,25
N.2.3	200	0,10–0,25
N.3.1	160	0,10–0,25
N.3.2	160	0,10–0,25
N.3.3	160	0,10–0,25
N.4.1	160	0,10–0,25
S.1.1	100	0,01–0,12
S.1.2	80	0,01–0,12
S.2.1	60	0,01–0,12
S.2.2	40	0,01–0,12
S.2.3	40	0,01–0,12
S.3.1	100	0,01–0,12
S.3.2	80	0,01–0,12
S.3.3	60	0,01–0,12
H.1.1	60	0,01–0,10
H.1.2	50	0,01–0,10
H.1.3	40	0,01–0,10
H.1.4	30	0,01–0,10
H.2.1	60	0,01–0,10
H.3.1	50	0,01–0,10
O.1.1	180	0,05–0,15
O.1.2	220	0,05–0,15
O.2.1	120	0,05–0,15
O.2.2	120	0,05–0,15
O.3.1	800	0,05–0,15

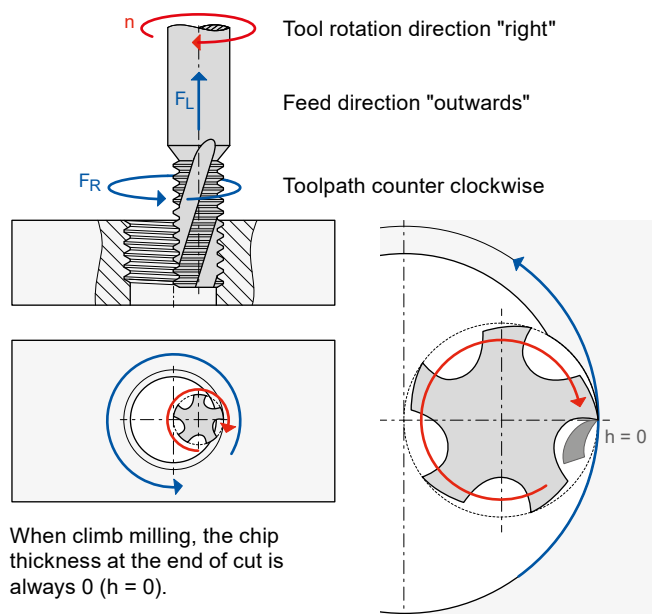


The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approximately $\pm 20\%$ according to the usage conditions.

Milling processes

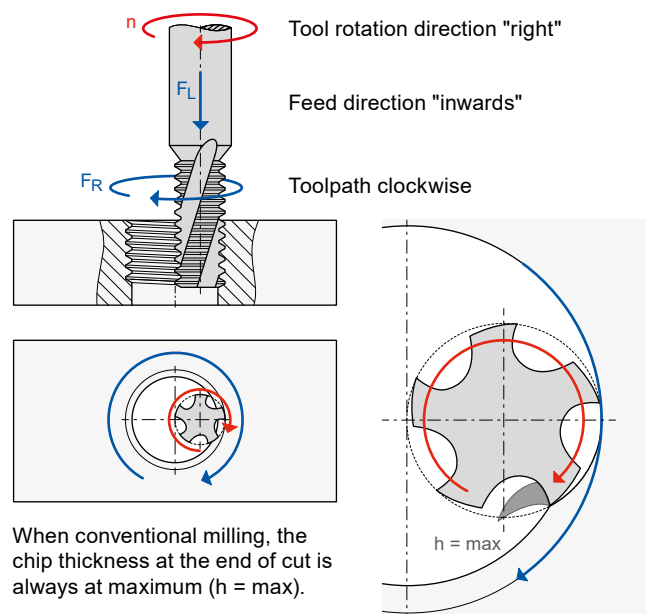
Climb milling

Right-hand thread



Conventional milling

Right-hand thread



Correction values for the internal thread milling

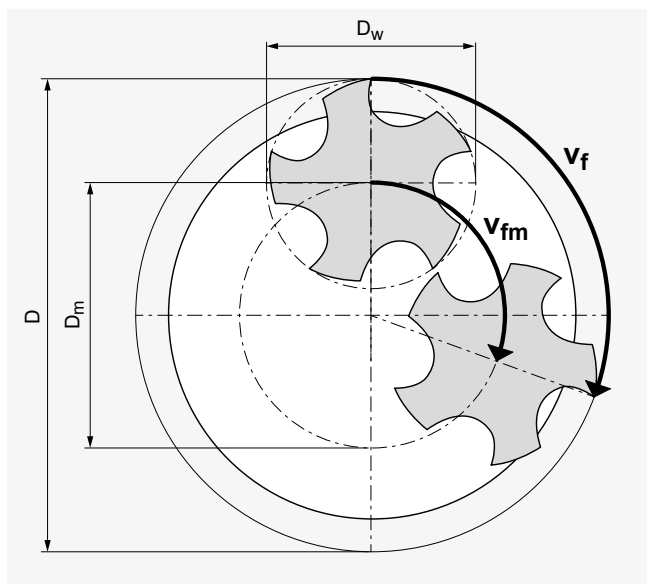
The milling radius correction, which is entered into the machine control, can be calculated as follows:

Half the cutter $\varnothing$ – ($0.05 \times \text{pitch } P$)

Example: M30×3	Cutter $\varnothing$: 20mm	$\frac{\varnothing 20}{2} - (0,05 \times 3) = \underline{\underline{9,85 \text{ mm}}}$	9.85 mm is the milling radius to be entered into the machine control!
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Calculation of cutting data for thread milling

Feed calculation



Peripheral feed rate (v_f)

$$v_f = n \times f_z \times z \text{ mm/min.}$$

Centerline feed rate v_{fm}

$$v_{fm} = \frac{v_f \times (D - D_w)}{D} \text{ mm/min.}$$

D_w = Effective diameter in mm

n = RPM

f_z = Feed per tooth in mm

z = Number of cutting edges (radial)

D = Nominal thread diameter = external profile diameter in mm

D_m = Center path diameter ($D - D_w$) in mm



Tips for the user

When thread milling, there are two different ways of programming the tool feed:

One is where the machine controls the feed at the diameter of the tool, the other controls the feed at the tool center line. In order to ascertain which method the machine control uses, the following method should be employed:

- ▲ Enter the thread milling program into the control
- ▲ Enter a safety margin into the program, so that the thread program runs without contacting the workpiece
- ▲ Run the program and check the machining time taken
- ▲ Compare the actual time with the calculated theoretical time

If the time is longer than the calculated time, use the tool center feed.

If the time is shorter than the calculated time, use the diameter feed.

$$n = \frac{v_c \times 1000}{d \times \pi}$$

$$n = \frac{v_f}{f_z \times z}$$

$$v_c = \frac{d \times \pi \times n}{1000}$$

$$v_f = n \times f_z \times z$$

$$f_z = \frac{v_f}{z \times n}$$

n	rpm	= Spindle rotation speed
v_c	m/min	= Cutting speed
d	mm	= Tool diameter
D	mm	= Nominal thread $\emptyset$
v_f	mm/min.	= Feed rate at the diameter
v_{fm}	mm/min.	= Feed rate at the center
U_{arc}	mm/min.	= Programmed ramping feed rate
f_z	mm	= Feed per tooth
z	Piece	= Number of cutting edges of the cutter

Milling – external contour

$$v_{fm} = \frac{v_f \times (D + d)}{D}$$

$$v_f = \frac{D \times v_{fm}}{(D + d)}$$

Milling – internal contour

$$v_{fm} = \frac{v_f \times (D - d)}{D}$$

$$v_f = \frac{D \times v_{fm}}{(D - d)}$$

Helical plunging

$$U_{arc} = 0,25 \times v_{fm}$$

Ramping in the arc

$$U_{arc} = v_{fm}$$

Coatings

<div>AICrN</div>	<div><div>▲ High-performance AlCrN multilayer coating</div><div>▲ Max. application temperature: > 1100 °C</div></div>	<div>Ti 500</div>	<div><div>▲ TiAlN coating</div><div>▲ Maximum application temperature: 500 °C</div></div>
<div>CWX 500</div>	<div><div>▲ Carbide, TiAlN-coated</div><div>▲ The universal carbide grade for almost all materials</div></div>	<div>Ti 600</div>	<div><div>▲ TiAlN multilayer coating</div><div>▲ Maximum application temperature: 650 °C</div></div>
<div>TiAlN</div>	<div><div>▲ TiAlN multilayer coating</div><div>▲ Maximum application temperature: 900 °C</div></div>	<div>Ti 601</div>	<div><div>▲ High-performance TiAlN multilayer coating</div><div>▲ Maximum application temperature: 900 °C</div></div>
<div>TiCN</div>	<div><div>▲ TiCN multilayer coating</div><div>▲ Maximum application temperature: 450 °C</div></div>	<div>Ti 602</div>	<div><div>▲ TiCN multilayer coating</div><div>▲ Maximum application temperature: 400 °C</div></div>
<div>TiN</div>	<div><div>▲ TiN coating</div><div>▲ Maximum application temperature: 450 °C</div></div>		



Thread turning



Contents

→ Explanation of symbols

→ Toolfinder

→ Product program

→ Shims

Technical information

→ Cutting data

→ Thread turning methods

→ Approach angle

→ Designation key

→ Troubleshooting

→ Grade description and profile explanation

Toolfinder

MiniCut



Full profile
Partial profile



Partial profile



Partial profile

→ **Miniature turning tools**

UltraMini



Full profile
Partial profile



Full profile
Partial profile



Partial profile

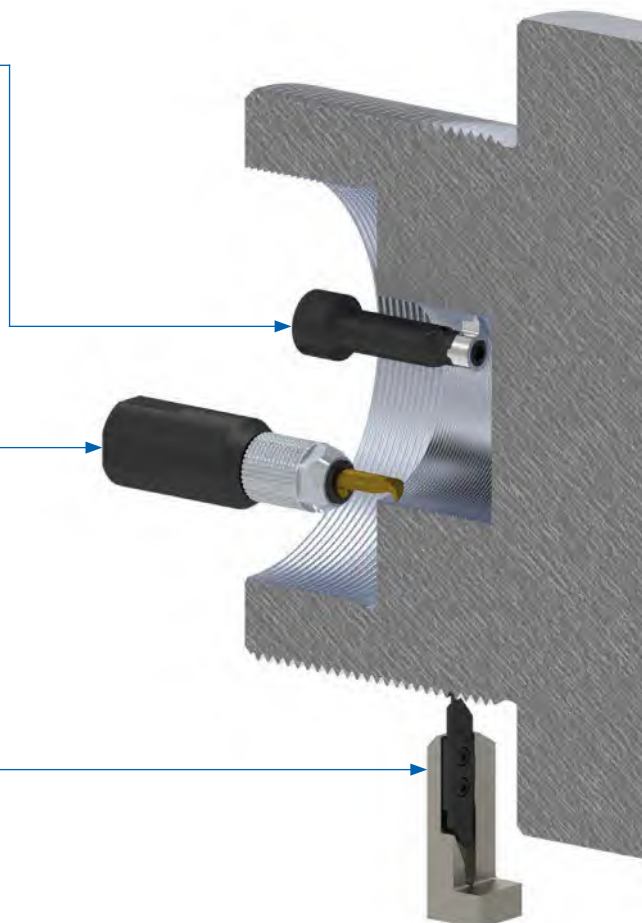


Partial profile

→ **Miniature turning tools**

VertiClamp

→ **Indexable insert turning tools**



Explanation of symbols

Flank angle



Flank angle 30° (trapezoidal thread)



Flank angle 30° (round thread)



Flank angle 55°



Flank angle 60°



Flank angle 80° (conduit thread)

- TP / TPI = Pitch
- NT = Number of teeth
- = Main application
 - = Secondary application

Thread

M

ISO metric coarse thread DIN 13

MF

ISO metric fine thread DIN 13

BSW

British Whitworth thread 55° BS 84 – BSW, BSF, BSP, BSB – commonly abbreviated as W or G

BSPT

British Whitworth tapered thread BS 21

UN

American unified thread BS 1580 (ASME B 1.1)

UNC

American unified thread (coarse) BS 1580 (ASME B 1.1)

UNF

American unified thread (fine) BS 1580 (ASME B 1.1)

UNEF

American unified thread (extra fine) BS 1580 (ASME B 1.1)

NPT

American pipe thread ANSI/ASME B 1.20.3

Tr

Trapezoidal thread DIN 103

Rd

Round thread DIN 405

Pg

Conduit thread DIN 40430

Standard external thread turning

Full profile

M

BSW

UN

UNC

UNF

UNEF

NPT

Tr

Rd

Pg

BSPT

Partial profile

60°

55°

Multi-cutting edge

M

→ Here you will find suitable holders.

Standard internal thread turning

Full profile

M

BSW

UN

UNC

UNF

UNEF

NPT

Tr

Rd

Pg

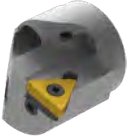
BSPT

Partial profile

60°

55°

→ Here you will find suitable holders.



Internal thread turning with MaxiChange – our exchangeable head system
→ Indexable insert turning tools

Mini 06
Full profile

M

BSW

Partial profile

60°

55°

Mini 08
Full profile

M

Partial profile

60°

55°

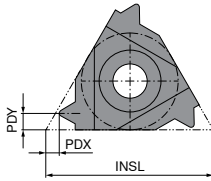
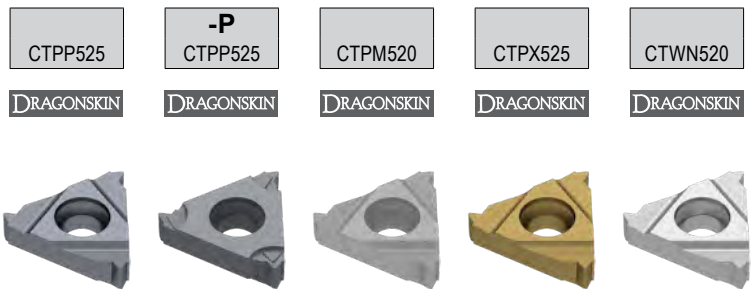
→ Here you will find suitable holders.



→ This is where you'll find information on the different thread profiles.

CoreLine – Right hand external thread turning insert

▲ Full profile



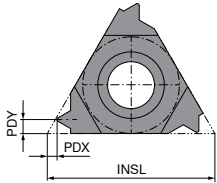
Designation	TP mm	INSL mm	PDX mm	PDY mm	ER TR 71 220 ...	ER TR 71 220 ...	ER TR 71 220 ...	ER TR 71 220 ...	ER TR 71 220 ...
11 ER 0,35	0.35	11	0.8	0.4	00401				
11 ER 0,4	0.40	11	0.7	0.4	00601				
11 ER 0,45	0.45	11	0.7	0.4	00801				
11 ER 0,5	0.50	11	0.6	0.6	00901				
11 ER 0,6	0.60	11	0.6	0.6	01001				
11 ER 0,7	0.70	11	0.6	0.6	01101				
11 ER 0,75	0.75	11	0.6	0.6	01201				
11 ER 0,8	0.80	11	0.6	0.6	01301				
11 ER 1,0	1.00	11	0.7	0.7	01401				
11 ER 1,25	1.25	11	0.8	0.9	01601				
11 ER 1,5	1.50	11	0.8	1.0	01801				
11 ER 1,75	1.75	11	0.8	1.1	02001				
16 ER 0,35	0.35	16	0.8	0.4	03401		734		13401
16 ER 0,4	0.40	16	0.7	0.4	03601		736		13601
16 ER 0,45	0.45	16	0.7	0.4	03801				13801
16 ER 0,5	0.50	16	0.6	0.6	04001	940	740	140	14001
16 ER 0,7	0.70	16	0.6	0.6	04101		741	141	14101
16 ER 0,75	0.75	16	0.6	0.6	04201	942	742	142	14201
16 ER 0,8	0.80	16	0.6	0.6	04301	943	743	143	14301
16 ER 1,0	1.00	16	0.7	0.7	04401	944	744	144	14501
16 ER 1,25	1.25	16	0.8	0.9	04601	946	746	146	14601
16 ER 1,5	1.50	16	0.8	1.0	04801	948	748	148	14901
16 ER 1,75	1.75	16	0.9	1.2	05001		750	150	15001
16 ER 2,0	2.00	16	1.0	1.3	05201	952	752	152	15201
16 ER 2,5	2.50	16	1.1	1.5	05401	954	754	154	15401
16 ER 3,0	3.00	16	1.2	1.6	05601	956	756	156	15601
22 ER 3,5	3.50	22	1.6	2.3	07001		770	170	
22 ER 4,0	4.00	22	1.6	2.3	07201		772	172	
22 ER 4,5	4.50	22	1.7	2.4	07401		774	174	
22 ER 5,0	5.00	22	1.7	2.5	07601		776	176	
22 ER 5,5	5.50	22	1.7	2.6				178	
22 ER 5,5	5.50	22	1.9	2.7	07801				
22 ER 6,0	6.00	22	1.9	2.7			780	180	
22 ER 6,0	6.00	22	2.0	2.9	08001				
P					●	●	○	●	
M					○	○	●	○	
K					●	●	○	●	
N							○	●	●
S					○	○	○	○	○
H					○	○	○		
O							○		



→ Find the cutting data standard values here.

CoreLine – Right hand outer thread-turning insert

- ▲ Thread-turning inserts are precision-sintered with chip breaker
- ▲ Full profile

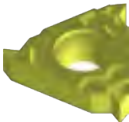


-P
CTPM520

-P
CTPX525

DRAGONSKIN

DRAGONSKIN



Designation	TP mm	INSL mm	PDX mm	PDY mm
16 ER-M 1,0	1.00	16	0.7	0.7
16 ER-M 1,25	1.25	16	0.8	0.9
16 ER-M 1,5	1.50	16	0.8	1.0
16 ER-M 1,75	1.75	16	0.9	1.2
16 ER-M 2,0	2.00	16	1.0	1.3
16 ER-M 2,5	2.50	16	1.1	1.5
16 ER-M 3,0	3.00	16	1.2	1.6

ER-M TR
71 220 ...
44400
44600
44800
45000
45200
45400
45600

ER-M TR
71 220 ...
04400
04600
04800
05000
05200
05400
05600

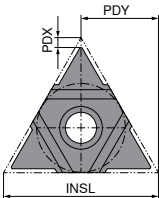
P	○	●
M	●	○
K	○	●
N	○	●
S	○	○
H	○	
O	○	



→ Find the cutting data standard values here.

CoreLine – Neutral external thread turning insert

- ▲ Full profile
- ▲ Can be used for the production of right-hand and left-hand threads
- ▲ Neutral tool holder marked (U) is required



Designation	TP mm	INSL mm	PDX mm	PDY mm
22 EN 5,5	5.5	22	2.3	11
22 EN 6,0	6.0	22	2.6	11

EN
TR

71 220 ...

08201
08401

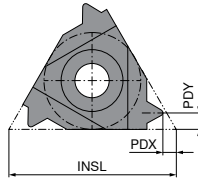
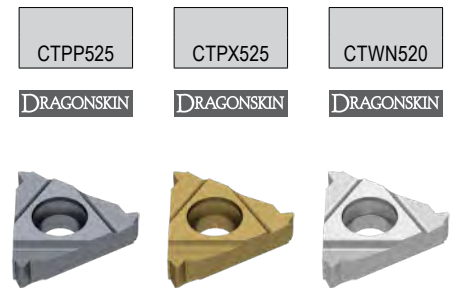
P	●
M	○
K	●
N	
S	○
H	○
O	



→ Find the cutting data standard values here.

CoreLine – Left hand external thread turning insert

▲ Full profile



Designation	TP mm	INSL mm	PDX mm	PDY mm
11 EL 0,35	0.35	11	0.8	0.4
11 EL 0,4	0.40	11	0.7	0.4
11 EL 0,45	0.45	11	0.7	0.4
11 EL 0,5	0.50	11	0.6	0.6
11 EL 0,6	0.60	11	0.6	0.6
11 EL 0,7	0.70	11	0.6	0.6
11 EL 0,75	0.75	11	0.6	0.6
11 EL 0,8	0.80	11	0.6	0.6
11 EL 1,0	1.00	11	0.7	0.7
11 EL 1,25	1.25	11	0.8	0.9
11 EL 1,5	1.50	11	0.8	1.0
11 EL 1,75	1.75	11	0.8	1.1
16 EL 0,35	0.35	16	0.8	0.4
16 EL 0,4	0.40	16	0.7	0.4
16 EL 0,45	0.45	16	0.7	0.4
16 EL 0,5	0.50	16	0.6	0.6
16 EL 0,7	0.70	16	0.6	0.6
16 EL 0,75	0.75	16	0.6	0.6
16 EL 0,8	0.80	16	0.6	0.6
16 EL 1,0	1.00	16	0.7	0.7
16 EL 1,25	1.25	16	0.8	0.9
16 EL 1,5	1.50	16	0.8	1.0
16 EL 1,75	1.75	16	0.9	1.2
16 EL 2,0	2.00	16	1.0	1.3
16 EL 2,5	2.50	16	1.1	1.5
16 EL 3,0	3.00	16	1.2	1.6
22 EL 3,5	3.50	22	1.6	2.3
22 EL 4,0	4.00	22	1.6	2.3
22 EL 4,5	4.50	22	1.7	2.4
22 EL 5,0	5.00	22	1.7	2.5
22 EL 5,5	5.50	22	1.9	2.7
22 EL 6,0	6.00	22	2.0	2.9

EL TR	EL TR	EL TR
71 222 ...	71 222 ...	71 222 ...
00401		10401
00601		10601
00801		10801
00901		10901
01001		
01101		
01201		11201
01301		11301
01401		11401
01601		11601
01801		11801
02001		12001
03401		13401
03601		13601
03801		13801
04001		14001
04101		14101
04201		14201
04301		14301
04401	144	14401
04601	146	14601
04801	148	14801
05001		15001
05201	152	15201
05401		15401
05601	156	15601
07001		17001
07201		17201
07401		17401
07601		17601
07801		
08001		

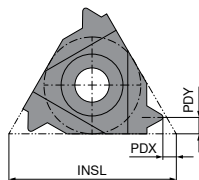
P	●	●	
M	○	○	
K	●	●	
N		●	●
S	○	○	○
H	○		
O			



→ Find the cutting data standard values here.

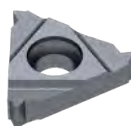
CoreLine – Right hand internal thread turning insert

▲ Full profile

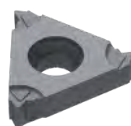


CTPP525

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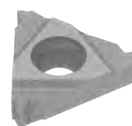
-P
CTPP525

DRAGONSKIN



CTPM520

DRAGONSKIN



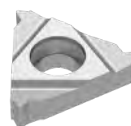
CTPX525

DRAGONSKIN



CTWN520

DRAGONSKIN



Designation	TP mm	INSL mm	PDX mm	PDY mm
11 IR 0,35	0.35	11	0.8	0.3
11 IR 0,4	0.40	11	0.8	0.4
11 IR 0,45	0.45	11	0.8	0.4
11 IR 0,5	0.50	11	0.6	0.6
11 IR 0,7	0.70	11	0.6	0.6
11 IR 0,75	0.75	11	0.6	0.6
11 IR 0,8	0.80	11	0.6	0.6
11 IR 1,0	1.00	11	0.6	0.6
11 IR 1,0	1.00	11	0.6	0.7
11 IR 1,25	1.25	11	0.8	0.9
11 IR 1,5	1.50	11	0.8	0.9
11 IR 1,5	1.50	11	0.8	1.0
11 IR 1,75	1.75	11	0.9	1.1
11 IR 2,0	2.00	11	0.8	0.9
11 IR 2,0	2.00	11	0.9	1.1
11 IR 2,5	2.50	11	0.8	1.2
11 IR 2,5	2.50	11	0.9	1.1
16 IR 0,35	0.35	16	0.8	0.4
16 IR 0,4	0.40	16	0.7	0.4
16 IR 0,45	0.45	16	0.7	0.4
16 IR 0,5	0.50	16	0.6	0.6
16 IR 0,7	0.70	16	0.6	0.6
16 IR 0,75	0.75	16	0.6	0.6
16 IR 0,8	0.80	16	0.6	0.6
16 IR 1,0	1.00	16	0.6	0.7
16 IR 1,0	1.00	16	0.7	0.7
16 IR 1,25	1.25	16	0.8	0.9
16 IR 1,5	1.50	16	0.8	1.0
16 IR 1,75	1.75	16	0.9	1.2
16 IR 2,0	2.00	16	1.0	1.3
16 IR 2,5	2.50	16	1.1	1.5
16 IR 3,0	3.00	16	1.1	1.5
22 IR 3,5	3.50	22	1.6	2.3
22 IR 4,0	4.00	22	1.6	2.3
22 IR 4,5	4.50	22	1.6	2.4
22 IR 4,5	4.50	22	1.7	2.4
22 IR 5,0	5.00	22	1.6	2.3
22 IR 5,0	5.00	22	1.7	2.5
22 IR 5,5	5.50	22	1.6	2.3
22 IR 5,5	5.50	22	1.9	2.7
22 IR 6,0	6.00	22	1.6	2.4
22 IR 6,0	6.00	22	2.0	2.9

IR TR	IR TR	IR TR	IR TR	IR TR
71 224 ...	71 224 ...	71 224 ...	71 224 ...	71 224 ...
00401				
00601				
00801				
00901				10901
01101				
01201	912			11201
01301		713		
	914			
01401		714	114	11401
01601				
	918			
01801		718	118	11801
02001				
		722	122	
02201				
		724	124	
02401				
03401				13401
03601				13601
03801				13801
04001				14001
04101				14101
04201		742	142	14201
04301				14301
	944	744	144	
04401				14401
04601	946	746		14601
04801	948	748	148	14801
05001		750		15001
05201	952	752	152	15201
05401	954	754	154	15401
05601	956	756	156	15601
07001		770	170	
07201		772	172	
		774	174	
07401				
			176	
07601				
			178	
07801				
			180	
08001				

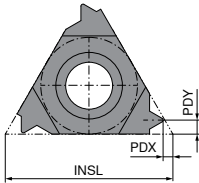
P	●	●	○	●
M	○	○	●	○
K	●	●	○	●
N			○	●
S	○	○	○	○
H	○	○	○	
O			○	



→ Find the cutting data standard values here.

CoreLine – Right hand internal thread-turning insert

- ▲ Thread-turning inserts are precision-sintered with chip breaker
- ▲ Full profile

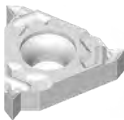


-P
CTPM520

-P
CTPX525

DRAGONSKIN

DRAGONSKIN



Designation	TP mm	INSL mm	PDX mm	PDY mm
11 IR-M 1,0	1.00	11	0.6	0.7
11 IR-M 1,25	1.25	11	0.8	0.9
11 IR-M 1,5	1.50	11	0.8	1.0
16 IR-M 1,0	1.00	16	0.6	0.7
16 IR-M 1,25	1.25	16	0.8	0.9
16 IR-M 1,5	1.50	16	0.8	1.0
16 IR-M 1,75	1.75	16	0.9	1.2
16 IR-M 2,0	2.00	16	1.0	1.3
16 IR-M 2,5	2.50	16	1.1	1.5
16 IR-M 3,0	3.00	16	1.1	1.5

IR-M TR	IR-M TR
71 224 ...	71 224 ...
41400	01400
41600	01600
41800	01800
44400	04400
44600	04600
44800	04800
45000	05000
45200	05200
45400	05400
45600	05600

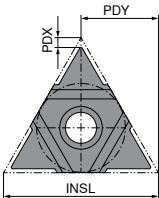
P	○	●
M	●	○
K	○	●
N	○	●
S	○	○
H	○	
O	○	



→ Find the cutting data standard values here.

CoreLine – Neutral internal thread turning insert

- ▲ Full profile
- ▲ Can be used for the production of right-hand and left-hand threads
- ▲ Neutral tool holder marked (U) is required



Designation	TP mm	INSL mm	PDX mm	PDY mm
22 IN 5,5	5.5	22	2.3	11
22 IN 6,0	6.0	22	2.6	11

IN
TR

71 224 ...

08201

08401

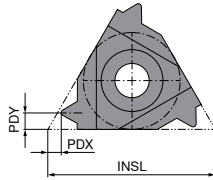
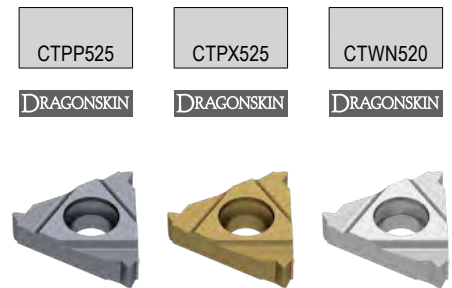
P	●
M	○
K	●
N	
S	○
H	○
O	



→ Find the cutting data standard values here.

CoreLine – Left hand internal thread turning insert

▲ Full profile



Designation	TP mm	INSL mm	PDX mm	PDY mm
11 IL 0,35	0.35	11	0.8	0.3
11 IL 0,4	0.40	11	0.8	0.4
11 IL 0,45	0.45	11	0.8	0.4
11 IL 0,5	0.50	11	0.6	0.6
11 IL 0,7	0.70	11	0.6	0.6
11 IL 0,75	0.75	11	0.6	0.6
11 IL 0,8	0.80	11	0.6	0.6
11 IL 1,0	1.00	11	0.6	0.7
11 IL 1,25	1.25	11	0.8	0.9
11 IL 1,5	1.50	11	0.8	1.0
11 IL 1,75	1.75	11	0.9	1.1
11 IL 2,0	2.00	11	0.9	1.1
11 IL 2,5	2.50	11	0.9	1.1
16 IL 0,35	0.35	16	0.8	0.4
16 IL 0,4	0.40	16	0.7	0.4
16 IL 0,45	0.45	16	0.7	0.4
16 IL 0,5	0.50	16	0.6	0.6
16 IL 0,7	0.70	16	0.6	0.6
16 IL 0,75	0.75	16	0.6	0.6
16 IL 0,8	0.80	16	0.6	0.6
16 IL 1,0	1.00	16	0.6	0.7
16 IL 1,0	1.00	16	0.7	0.7
16 IL 1,25	1.25	16	0.8	0.9
16 IL 1,5	1.50	16	0.8	1.0
16 IL 1,75	1.75	16	0.9	1.2
16 IL 2,0	2.00	16	1.0	1.3
16 IL 2,5	2.50	16	1.1	1.5
16 IL 3,0	3.00	16	1.2	1.6
16 IL 3,5	3.50	16	1.6	2.3
22 IL 3,5	3.50	22	1.6	2.3
22 IL 4,0	4.00	22	1.6	2.3
22 IL 4,0	4.00	22	1.7	2.4
22 IL 4,5	4.50	22	1.7	2.4
22 IL 4,5	4.50	22	1.7	2.5
22 IL 5,0	5.00	22	1.7	2.5
22 IL 5,0	5.00	22	1.9	2.7
22 IL 5,5	5.50	22	1.9	2.7
22 IL 5,5	5.50	22	2.0	2.9
22 IL 6,0	6.00	22	2.0	2.9

IL TR	IL TR	IL TR
71 226 ...	71 226 ...	71 226 ...
00401		10401
00601		10601
00801		10801
00901		10901
01101		11101
01201		11201
01301		11301
01401		11401
01601		11601
01801		11801
02001		12001
02201		12201
02401		12401
03401		13401
03601		13601
03801		13801
04001		14001
04101		14101
04201		14201
04301		14301
04401	144	14401
04601		14601
04801	148	14801
05001		15001
05201	152	15201
05401		15401
05601		15601
		15801
07001		17001
07201		17201
07401		17401
07601		17601
07801		17801
08001		

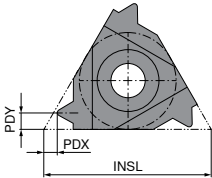
P	●	●	
M	○	○	
K	●	●	
N		●	●
S	○	○	○
H	○		
O			



→ Find the cutting data standard values here.

CoreLine – Right hand external thread turning insert

▲ Full profile

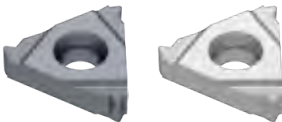


CTPP525

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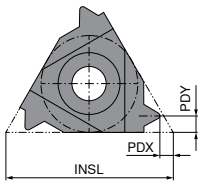
Designation	TP mm	INSL mm	PDX mm	PDY mm	ER	
					TR	TR
					71 286 ...	71 286 ...
11 ER 1,0	1.00	11	0.7	0.8	01401	11401
11 ER 1,25	1.25	11	0.8	0.9	01601	11601
11 ER 1,5	1.50	11	0.8	1.0	01801	11801
16 ER 1,0	1.00	16	0.7	0.8	04401	14401
16 ER 1,25	1.25	16	0.8	0.9	04601	14601
16 ER 1,5	1.50	16	0.8	1.0	04801	14801
16 ER 2,0	2.00	16	1.0	1.3	05201	15201
P					●	
M					○	
K					●	
N						●
S					○	○
H					○	
O						



→ Find the cutting data standard values here.

CoreLine – Right hand internal thread turning insert

▲ Full profile

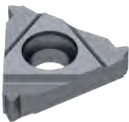
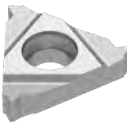


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Designation	TP mm	INSL mm	PDX mm	PDY mm
11 IR 1,0	1.00	11	0.7	0.8
11 IR 1,25	1.25	11	0.8	0.9
11 IR 1,5	1.50	11	0.8	1.0
11 IR 2,0	2.00	11	0.9	1.0
16 IR 1,0	1.00	16	0.7	0.8
16 IR 1,25	1.25	16	0.8	0.9
16 IR 1,5	1.50	16	0.8	1.0
16 IR 2,0	2.00	16	1.0	1.3

IR TR	IR TR
71 284 ...	71 284 ...
01401	11401
01601	11601
01801	11801
02201	12201
04401	14401
04601	14601
04801	14801
05201	15201

P	●	
M	○	
K	●	
N		●
S	○	○
H	○	
O		



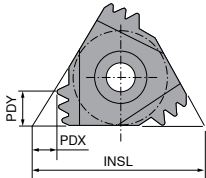
→ Find the cutting data standard values here.

CoreLine – Right hand external thread turning insert

▲ Multi-tooth inserts

M





CTPM520

DRAGONSKIN



Designation	TP mm	INSL mm	PDX mm	PDY mm	NT
16 ER 1,0 3M	1.0	16	1.7	2.5	3
16 ER 1,5 2M	1.5	16	1.5	2.3	2

ER

TR

71 221 ...

700

702

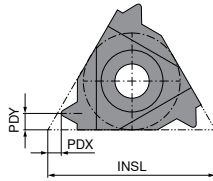
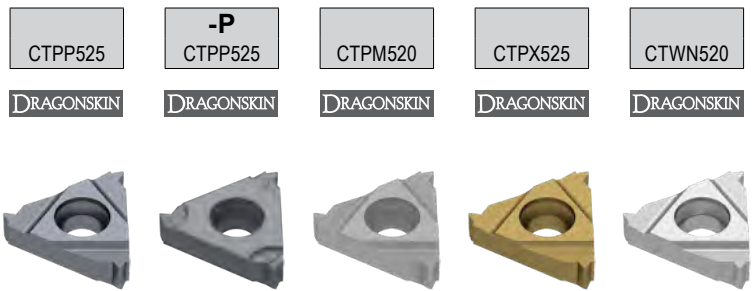
P	○
M	●
K	○
N	○
S	○
H	○
O	○



→ Find the cutting data standard values here.

CoreLine – Right hand external thread turning insert

▲ Full profile



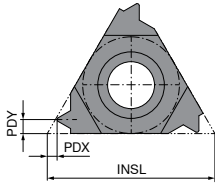
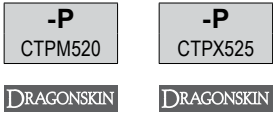
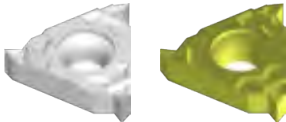
Designation	TPI 1/"	INSL mm	PDX mm	PDY mm	ER TR 71 228 ...	ER TR 71 228 ...	ER TR 71 228 ...	ER TR 71 228 ...	ER TR 71 228 ...
11 ER 72	72	11	0.7	0.4	00201				
11 ER 60	60	11	0.7	0.4	00401				
11 ER 56	56	11	0.7	0.4	00601				
11 ER 48	48	11	0.6	0.6	00801				
11 ER 40	40	11	0.6	0.6	01001				
11 ER 36	36	11	0.6	0.6	01201				
11 ER 32	32	11	0.6	0.6	01401				
11 ER 28	28	11	0.6	0.7	01601				
11 ER 26	26	11	0.7	0.8	01801				
11 ER 24	24	11	0.7	0.8	02001				
11 ER 22	22	11	0.8	0.9	02201				
11 ER 20	20	11	0.8	0.9	02401				
11 ER 19	19	11	0.8	1.0	02601				
11 ER 18	18	11	0.8	1.0	02801				
11 ER 16	16	11	0.9	1.1	03001				
11 ER 14	14	11	0.9	1.1	03201				
16 ER 40	40	16	0.6	0.6	04001				14001
16 ER 36	36	16	0.6	0.6	04201				14201
16 ER 32	32	16	0.6	0.6	04401				14401
16 ER 28	28	16	0.6	0.7	04601		746		14601
16 ER 26	26	16	0.7	0.7			748		
16 ER 26	26	16	0.7	0.8	04801				14801
16 ER 24	24	16	0.7	0.8	05001				15001
16 ER 22	22	16	0.8	0.9	05201				15201
16 ER 20	20	16	0.8	0.9	05401		754		15401
16 ER 19	19	16	0.8	1.0	05601	956	756	156	15601
16 ER 18	18	16	0.8	1.0	05801				15801
16 ER 16	16	16	0.9	1.1	06001		760	160	16001
16 ER 14	14	16	1.0	1.2	06201	962	762	162	16201
16 ER 12	12	16	1.1	1.4	06401		764	164	16401
16 ER 11	11	16	1.1	1.5	06601	966	766	166	16601
16 ER 10	10	16	1.1	1.5	06801				16801
16 ER 9	9	16	1.2	1.7	07001				17001
16 ER 8	8	16	1.2	1.5	07201				17201
22 ER 7	7	22	1.6	2.3	08001				
22 ER 6	6	22	1.6	2.3	08201				
22 ER 5	5	22	1.7	2.4	08401				
P					●	●	○	●	
M					○	○	●	○	
K					●	●	○	●	
N							○	●	●
S					○	○	○	○	○
H					○	○	○		
O							○		



→ Find the cutting data standard values here.

CoreLine – Right hand outer thread-turning insert

- ▲ Thread-turning inserts are precision-sintered with chip breaker
- ▲ Full profile



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
16 ER-M 19	19	16	0.8	1.0
16 ER-M 14	14	16	1.0	1.2
16 ER-M 11	11	16	1.1	1.5

ER-M TR	ER-M TR
71 228 ...	71 228 ...
45600	05600
46200	06200
46600	06600

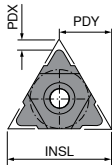
P	○	●
M	●	○
K	○	●
N	○	●
S	○	○
H	○	
O	○	



→ Find the cutting data standard values here.

CoreLine – Neutral external/internal thread turning insert

- ▲ Full profile
- ▲ Can be used for the production of right-hand and left-hand threads
- ▲ Neutral tool holder marked (U) is required



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
22 EIN 4	4.0	22	1.8	11
22 EIN 4,5	4.5	22	2.3	11

EIN
TR

71 228 ...

09201

09001

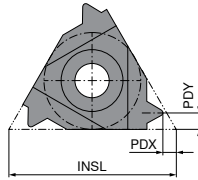
P	●
M	○
K	●
N	
S	○
H	○
O	



→ Find the cutting data standard values here.

CoreLine – Left hand external thread turning insert

▲ Full profile

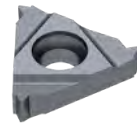
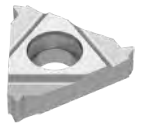


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DRAGSKIN



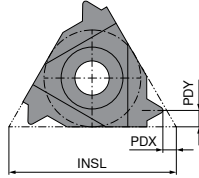
Designation	TPI 1/"	INSL mm	PDX mm	PDY mm	EL TR 71 229 ...	EL TR 71 229 ...
11 EL 28	28	11	0.6	0.7	01601	
11 EL 19	19	11	0.8	1.0	02601	
11 EL 18	18	11	0.8	1.0	02801	
11 EL 14	14	11	0.9	1.1	03201	
16 EL 32	32	16	0.6	0.6	04401	
16 EL 28	28	16	0.6	0.7	04601	
16 EL 26	26	16	0.7	0.8	04801	
16 EL 24	24	16	0.7	0.8	05001	
16 EL 22	22	16	0.8	0.9	05201	
16 EL 20	20	16	0.8	0.9	05401	15401
16 EL 19	19	16	0.8	1.0	05601	15601
16 EL 18	18	16	0.8	1.0	05801	15801
16 EL 16	16	16	0.9	1.1	06001	16001
16 EL 14	14	16	1.0	1.2	06201	16201
16 EL 12	12	16	1.1	1.4	06401	
16 EL 11	11	16	1.1	1.5	06601	16601
16 EL 10	10	16	1.1	1.5	06801	16801
16 EL 9	9	16	1.2	1.7	07001	
16 EL 8	8	16	1.2	1.5	07201	
22 EL 7	7	22	1.6	2.3	08001	
22 EL 6	6	22	1.6	2.3	08201	
22 EL 5	5	22	1.7	2.4	08401	
P					●	
M					○	
K					●	
N						●
S					○	○
H					○	
O						



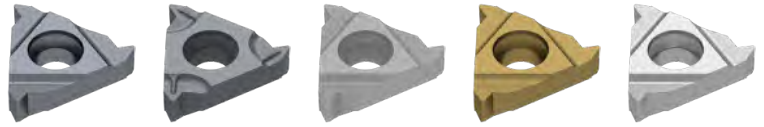
→ Find the cutting data standard values here.

CoreLine – Right hand internal thread turning insert

▲ Full profile



CTPP525	-P CTPP525	CTPM520	CTPX525	CTWN520
DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN



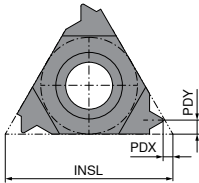
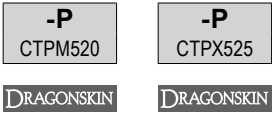
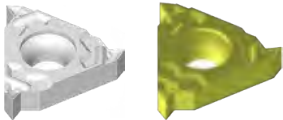
Designation	TPI 1/"	INSL mm	PDX mm	PDY mm	IR TR 71 230 ...	IR TR 71 230 ...	IR TR 71 230 ...	IR TR 71 230 ...	IR TR 71 230 ...
11 IR 48	48	11	0.6	0.6	00801				
11 IR 40	40	11	0.6	0.6	01001				
11 IR 36	36	11	0.6	0.6	01201				
11 IR 32	32	11	0.6	0.6	01401				
11 IR 28	28	11	0.6	0.7	01601				
11 IR 26	26	11	0.7	0.8	01801				
11 IR 24	24	11	0.7	0.8	02001				
11 IR 22	22	11	0.8	0.9	02201				
11 IR 20	20	11	0.8	0.9	02401				
11 IR 19	19	11	0.8	0.9		924			
11 IR 19	19	11	0.8	1.0	02601		724	124	
11 IR 18	18	11	0.8	1.0	02801				
11 IR 16	16	11	0.9	1.1	03001				
11 IR 14	14	11	0.8	0.9		930			
11 IR 14	14	11	0.9	1.1	03201		730	130	
16 IR 40	40	16	0.6	0.6	04001				
16 IR 36	36	16	0.6	0.6	04201				
16 IR 32	32	16	0.6	0.6	04401				
16 IR 28	28	16	0.6	0.7	04601				
16 IR 26	26	16	0.7	0.8	04801				
16 IR 24	24	16	0.7	0.8	05001				
16 IR 22	22	16	0.8	0.9	05201				
16 IR 20	20	16	0.8	0.9	05401				
16 IR 19	19	16	0.8	1.0	05601				
16 IR 18	18	16	0.8	1.0	05801				
16 IR 16	16	16	0.9	1.1	06001		760		
16 IR 14	14	16	1.0	1.2	06201	962	762	162	
16 IR 12	12	16	1.1	1.4	06401				
16 IR 11	11	16	1.1	1.5	06601	966	766	166	16601
16 IR 10	10	16	1.1	1.5	06801				
16 IR 9	9	16	1.2	1.7	07001				
16 IR 8	8	16	1.2	1.5	07201				
22 IR 7	7	22	1.6	2.3	08001				
22 IR 6	6	22	1.6	2.3	08201				
22 IR 5	5	22	1.7	2.4	08401				
P					●	●	○	●	
M					○	○	●	○	
K					●	●	○	●	
N							○	●	●
S					○	○	○	○	○
H					○	○	○		
O							○		



→ Find the cutting data standard values here.

CoreLine – Right hand internal thread-turning insert

- ▲ Thread-turning inserts are precision-sintered with chip breaker
- ▲ Full profile



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
16 IR-M 19	19	16	0.8	1.0
16 IR-M 14	14	16	1.0	1.2
16 IR-M 11	11	16	1.1	1.5

IR-M TR	IR-M TR
71 230 ...	71 230 ...
45600	05600
46200	06200
46600	06600

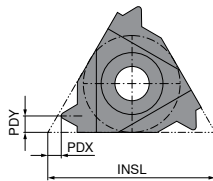
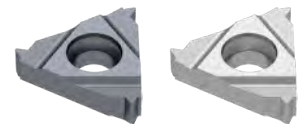
P	○	●
M	●	○
K	○	●
N	○	●
S	○	○
H	○	
O	○	



→ Find the cutting data standard values here.

CoreLine – Left hand internal thread turning insert

▲ Full profile



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
11 IL 36	36	11	0.6	0.6
11 IL 32	32	11	0.6	0.6
11 IL 28	28	11	0.6	0.7
11 IL 26	26	11	0.7	0.8
11 IL 24	24	11	0.7	0.8
11 IL 22	22	11	0.8	0.9
11 IL 20	20	11	0.8	0.9
11 IL 19	19	11	0.8	1.0
11 IL 18	18	11	0.8	1.0
11 IL 16	16	11	0.9	1.1
11 IL 14	14	11	0.9	1.1
16 IL 32	32	16	0.6	0.6
16 IL 28	28	16	0.6	0.7
16 IL 26	26	16	0.7	0.8
16 IL 24	24	16	0.7	0.8
16 IL 22	22	16	0.8	0.9
16 IL 20	20	16	0.8	0.9
16 IL 19	19	16	0.8	1.0
16 IL 18	18	16	0.8	1.0
16 IL 16	16	16	0.9	1.1
16 IL 14	14	16	1.0	1.2
16 IL 12	12	16	1.1	1.4
16 IL 11	11	16	1.1	1.5
16 IL 10	10	16	1.1	1.5
16 IL 9	9	16	1.2	1.7
16 IL 8	8	16	1.2	1.5
22 IL 7	7	22	1.6	2.3
22 IL 6	6	22	1.6	2.3
22 IL 5	5	22	1.7	2.4

IL TR	IL TR
71 231 ...	71 231 ...
01201	
01401	
01601	
01801	
02001	
02201	
02401	
02601	
02801	
03001	
03201	
04401	
04601	
04801	
05001	
05201	
05401	
05601	15601
05801	
06001	16001
06201	16201
06401	16401
06601	16601
06801	
07001	17001
07201	17201
08001	
08201	
08401	

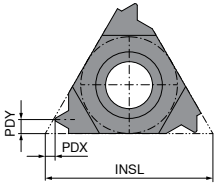
P	●	
M	○	
K	●	
N		●
S	○	○
H	○	
O		



→ Find the cutting data standard values here.

CoreLine – Right hand outer thread-turning insert

- ▲ Thread-turning inserts are precision-sintered with chip breaker
- ▲ Full profile

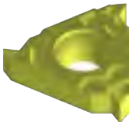


-P
CTPM520

-P
CTPX525

DRAGONSKIN

DRAGONSKIN



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
16 ER-M 19	19	16	0.8	0.9
16 ER-M 14	14	16	1.0	1.2
16 ER-M 11	11	16	1.1	1.5

ER-M TR
71 288 ...
45600
46200
46600

ER-M TR
71 288 ...
05600
06200
06600

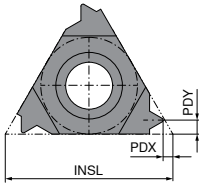
P	○	●
M	●	○
K	○	●
N	○	●
S	○	○
H	○	
O	○	



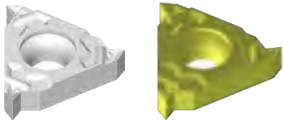
→ Find the cutting data standard values here.

CoreLine – Right hand internal thread-turning insert

- ▲ Thread-turning inserts are precision-sintered with chip breaker
- ▲ Full profile



-P CTPM520	-P CTPX525
DRAGONSKIN	DRAGONSKIN



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
16 IR-M 19	19	16	0.8	0.9
16 IR-M 14	14	16	1.0	1.2
16 IR-M 11	11	16	1.1	1.5

IR-M TR	IR-M TR
71 289 ...	71 289 ...
45600	05600
46200	06200
46600	06600

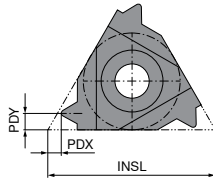
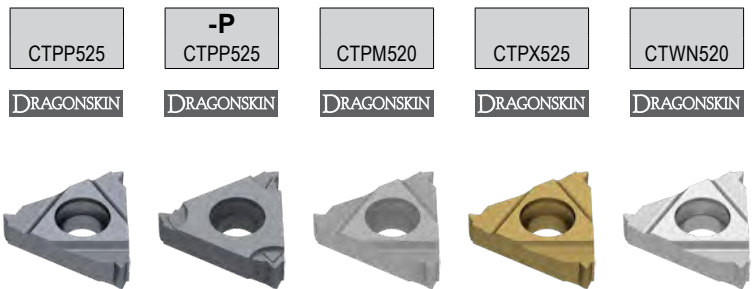
P	○	●
M	●	○
K	○	●
N	○	●
S	○	○
H	○	
O	○	



→ Find the cutting data standard values here.

CoreLine – Right hand external thread turning insert

▲ Full profile



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm	ER TR 71 264 ...	ER TR 71 264 ...	ER TR 71 264 ...	ER TR 71 264 ...	ER TR 71 264 ...
11 ER 72	72.0	11	0.8	0.4	00201				
11 ER 64	64.0	11	0.8	0.4	00401				
11 ER 56	56.0	11	0.7	0.4	00601				
11 ER 48	48.0	11	0.6	0.6	00801				
11 ER 44	44.0	11	0.6	0.6	01001				
11 ER 40	40.0	11	0.6	0.6	01201				
11 ER 36	36.0	11	0.6	0.6	01401				
11 ER 32	32.0	11	0.6	0.6	01601				
11 ER 28	28.0	11	0.6	0.7	01801				
11 ER 27	27.0	11	0.7	0.8	02001				
11 ER 24	24.0	11	0.7	0.8	02201				
11 ER 20	20.0	11	0.8	0.9	02401				
11 ER 18	18.0	11	0.8	1.0	02601				
11 ER 16	16.0	11	0.9	1.1	02801				
11 ER 14	14.0	11	0.9	1.1	03001				
16 ER 72	72.0	16	0.8	0.4	03201				
16 ER 64	64.0	16	0.8	0.4	03401				
16 ER 56	56.0	16	0.7	0.4	03601				
16 ER 48	48.0	16	0.6	0.6	03801				
16 ER 44	44.0	16	0.6	0.6	04001				
16 ER 40	40.0	16	0.6	0.6	04201				
16 ER 36	36.0	16	0.6	0.6	04401				
16 ER 32	32.0	16	0.6	0.6	04601		746		
16 ER 28	28.0	16	0.6	0.7	04801		748		
16 ER 27	27.0	16	0.7	0.8	05001				
16 ER 24	24.0	16	0.7	0.8	05201		752	152	
16 ER 20	20.0	16	0.8	0.9	05401	954	754	154	
16 ER 18	18.0	16	0.8	1.0	05601		756	156	15601
16 ER 16	16.0	16	0.9	1.1	05801	958	758	158	15801
16 ER 14	14.0	16	1.0	1.2	06001		760	160	
16 ER 13	13.0	16	1.0	1.3	06201				
16 ER 12	12.0	16	1.1	1.4	06401		764	164	
16 ER 11,5	11.5	16	1.1	1.5	06601				
16 ER 11	11.0	16	1.1	1.5	06801			168	
16 ER 10	10.0	16	1.1	1.5	07001				
16 ER 9	9.0	16	1.2	1.7	07201				
16 ER 8	8.0	16	1.1	1.1		974			
16 ER 8	8.0	16	1.1	1.5				174	
16 ER 8	8.0	16	1.2	1.6	07401				
22 ER 7	7.0	22	1.6	2.3	07601				
22 ER 6	6.0	22	1.6	2.3	07801				
22 ER 5	5.0	22	1.7	2.5	08001				
P					●	●	○	●	
M					○	○	●	○	
K					●	●	○	●	
N							○	●	●
S					○	○	○	○	○
H					○	○	○		
O							○		



→ Find the cutting data standard values here.

CoreLine – Right hand outer thread-turning insert

- ▲ Thread-turning inserts are precision-sintered with chip breaker
- ▲ Full profile

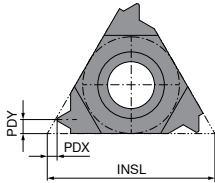
UN

UNC

UNF

UNEF





-P

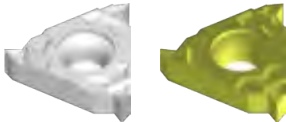
CTPM520

DRAGONSKIN

-P

CTPX525

DRAGONSKIN



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
16 ER-M 24	24	16	0.7	0.8
16 ER-M 20	20	16	0.8	0.9
16 ER-M 12	12	16	0.8	0.9
16 ER-M 18	18	16	0.8	1.0
16 ER-M 16	16	16	0.9	1.1
16 ER-M 14	14	16	1.0	1.2
16 ER-M 8	8	16	1.2	1.6

ER-M TR	ER-M TR
71 264 ...	71 264 ...
45200	05200
45400	05400
46400	06400
45600	05600
45800	05800
46000	06000
47400	07400

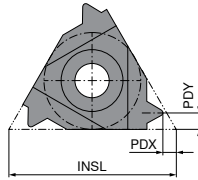
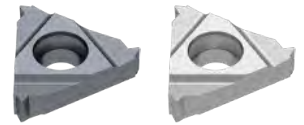
P	○	●
M	●	○
K	○	●
N	○	●
S	○	○
H	○	
O	○	



→ Find the cutting data standard values here.

CoreLine – Left hand external thread turning insert

▲ Full profile



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
11 EL 56	56.0	11	0.7	0.4
11 EL 36	36.0	11	0.6	0.6
11 EL 28	28.0	11	0.6	0.7
11 EL 27	27.0	11	0.7	0.8
11 EL 24	24.0	11	0.7	0.8
11 EL 18	18.0	11	0.8	1.0
11 EL 14	14.0	11	0.9	1.1
16 EL 48	48.0	16	0.6	0.6
16 EL 40	40.0	16	0.6	0.6
16 EL 36	36.0	16	0.6	0.6
16 EL 32	32.0	16	0.6	0.6
16 EL 28	28.0	16	0.6	0.7
16 EL 27	27.0	16	0.7	0.8
16 EL 24	24.0	16	0.7	0.8
16 EL 20	20.0	16	0.8	0.9
16 EL 18	18.0	16	0.8	1.0
16 EL 16	16.0	16	0.9	1.1
16 EL 14	14.0	16	1.0	1.2
16 EL 13	13.0	16	1.0	1.3
16 EL 12	12.0	16	1.1	1.4
16 EL 11,5	11.5	16	1.1	1.5
16 EL 11	11.0	16	1.1	1.5
16 EL 10	10.0	16	1.1	1.5
16 EL 9	9.0	16	1.2	1.7
16 EL 8	8.0	16	1.2	1.6
22 EL 7	7.0	22	1.6	2.3
22 EL 6	6.0	22	1.6	2.3

EL TR	EL TR
71 266 ...	71 266 ...
00601	
	11401
01801	
02001	
	12201
02601	
03001	
03801	
04201	14201
04401	14401
04601	14601
04801	14801
05001	15001
05201	15201
05401	15401
05601	15601
05801	15801
06001	16001
06201	16201
06401	16401
06601	
06801	16801
07001	17001
07201	
07401	17401
07601	17601
07801	

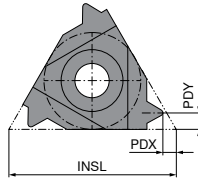
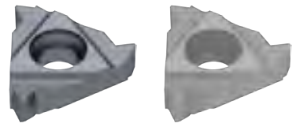
P	●	
M	○	
K	●	
N		●
S	○	○
H	○	
O		



→ Find the cutting data standard values here.

CoreLine – Right hand internal thread turning insert

▲ Full profile



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
11 IR 72	72.0	11	0.8	0.3
11 IR 64	64.0	11	0.8	0.4
11 IR 56	56.0	11	0.7	0.4
11 IR 48	48.0	11	0.6	0.6
11 IR 44	44.0	11	0.6	0.6
11 IR 40	40.0	11	0.6	0.6
11 IR 36	36.0	11	0.6	0.6
11 IR 32	32.0	11	0.6	0.6
11 IR 28	28.0	11	0.6	0.7
11 IR 27	27.0	11	0.7	0.8
11 IR 24	24.0	11	0.7	0.8
11 IR 20	20.0	11	0.8	0.9
11 IR 18	18.0	11	0.8	1.0
11 IR 16	16.0	11	0.9	1.1
11 IR 14	14.0	11	1.0	1.1
16 IR 72	72.0	16	0.8	0.3
16 IR 64	64.0	16	0.8	0.4
16 IR 56	56.0	16	0.7	0.4
16 IR 48	48.0	16	0.6	0.6
16 IR 44	44.0	16	0.6	0.6
16 IR 40	40.0	16	0.6	0.6
16 IR 36	36.0	16	0.6	0.6
16 IR 32	32.0	16	0.6	0.6
16 IR 28	28.0	16	0.6	0.7
16 IR 27	27.0	16	0.7	0.8
16 IR 24	24.0	16	0.7	0.8
16 IR 20	20.0	16	0.8	0.9
16 IR 18	18.0	16	0.8	1.0
16 IR 16	16.0	16	0.9	1.1
16 IR 14	14.0	16	1.0	1.2
16 IR 13	13.0	16	1.0	1.3
16 IR 12	12.0	16	1.1	1.4
16 IR 11,5	11.5	16	1.1	1.5
16 IR 11	11.0	16	1.1	1.5
16 IR 10	10.0	16	1.1	1.5
16 IR 9	9.0	16	1.2	1.7
16 IR 8	8.0	16	1.2	1.6
16 IR 8	8.0	16	1.1	1.5
22 IR 7	7.0	22	1.6	2.3
22 IR 6	6.0	22	1.6	2.3
22 IR 5	5.0	22	1.7	2.5

IR TR	IR TR
71 268 ...	71 268 ...
00201	
00401	
00601	
00801	
01001	
01201	
01401	
01601	
01801	
02001	
02201	
02401	
02601	
02801	
03001	
03201	
03401	
03601	
03801	
04001	
04201	
04401	
04601	
04801	
05001	
05201	
05401	
05601	
05801	
06001	760
06201	
06401	764
06601	
06801	
07001	
07201	
07401	
	774
07601	776
07801	
08001	

P	●	○
M	○	●
K	●	○
N		○
S	○	○
H	○	○
O		○



→ Find the cutting data standard values here.

CoreLine – Right hand internal thread-turning insert

- ▲ Thread-turning inserts are precision-sintered with chip breaker
- ▲ Full profile

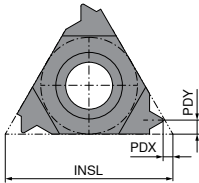
UN

UNC

UNF

UNEF





-P

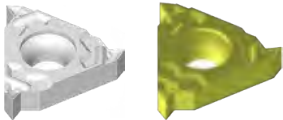
CTPM520

DRAGONSKIN

-P

CTPX525

DRAGONSKIN



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
16 IR-M 20	20	16	0.8	0.9
16 IR-M 18	18	16	0.8	1.0
16 IR-M 16	16	16	0.9	1.1
16 IR-M 14	14	16	0.9	1.2
16 IR-M 12	12	16	1.1	1.4

IR-M TR	IR-M TR
71 268 ...	71 268 ...
45400	05400
45600	05600
45800	05800
46000	06000
46400	06400

P	○	●
M	●	○
K	○	●
N	○	●
S	○	○
H	○	
O	○	



→ Find the cutting data standard values here.

CoreLine – Neutral internal thread turning insert

- ▲ Full profile
- ▲ Can be used for the production of right-hand and left-hand threads
- ▲ Neutral tool holder marked (U) is required

UN

UNC

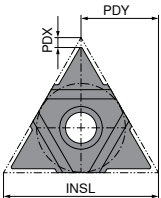
UNF

UNEF



CTPP525

DRAGONSKIN



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
22 IN 4,5	4.5	22	2	11
22 IN 4	4.0	22	2	11

IN

TR

71 268 ...

08201

08401

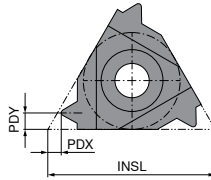
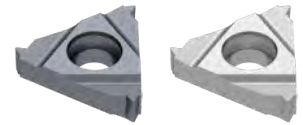
P	●
M	○
K	●
N	
S	○
H	○
O	



→ Find the cutting data standard values here.

CoreLine – Left hand internal thread turning insert

▲ Full profile



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
11 IL 64	64.0	11	0.8	0.4
11 IL 56	56.0	11	0.7	0.4
11 IL 32	32.0	11	0.6	0.6
11 IL 28	28.0	11	0.6	0.7
11 IL 27	27.0	11	0.7	0.8
11 IL 24	24.0	11	0.7	0.8
11 IL 20	20.0	11	0.8	0.9
11 IL 18	18.0	11	0.8	1.0
11 IL 16	16.0	11	0.9	1.1
11 IL 14	14.0	11	0.9	1.1
16 IL 48	48.0	16	0.6	0.6
16 IL 40	40.0	16	0.6	0.6
16 IL 32	32.0	16	0.6	0.6
16 IL 28	28.0	16	0.6	0.7
16 IL 24	24.0	16	0.7	0.8
16 IL 20	20.0	16	0.8	0.9
16 IL 18	18.0	16	0.8	1.0
16 IL 16	16.0	16	0.9	1.1
16 IL 14	14.0	16	1.0	1.2
16 IL 13	13.0	16	1.0	1.3
16 IL 12	12.0	16	1.1	1.4
16 IL 11,5	11.5	16	1.1	1.5
16 IL 11	11.0	16	1.1	1.5
16 IL 10	10.0	16	1.1	1.5
16 IL 9	9.0	16	1.2	1.7
16 IL 8	8.0	16	1.2	1.6
22 IL 7	7.0	22	1.6	2.3
22 IL 6	6.0	22	1.6	2.3
22 IL 5	5.0	22	1.7	2.5

IL TR	IL TR
71 270 ...	71 270 ...
	10401
	10601
01601	11601
01801	
02001	
02201	12201
02401	12401
02601	12601
02801	12801
03001	13001
03801	13801
	14201
04601	14601
04801	14801
05201	15201
05401	15401
05601	15601
05801	15801
06001	16001
06201	
06401	16401
06601	
06801	
07001	17001
07201	
07401	17401
07601	17601
07801	
08001	

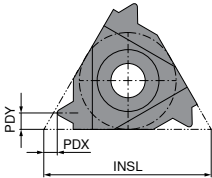
P	●	
M	○	
K	●	
N		●
S	○	○
H	○	
O		



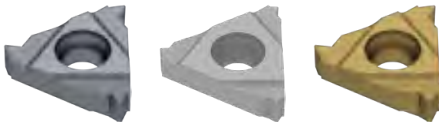
→ Find the cutting data standard values here.

CoreLine – Right hand external thread turning insert

▲ Full profile



CTPP525	CTPM520	CTPX525
DRAGONSKIN	DRAGONSKIN	DRAGONSKIN



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
11 ER 18	18.0	11	0.8	0.9
16 ER 27	27.0	16	0.7	0.8
16 ER 18	18.0	16	0.8	1.0
16 ER 14	14.0	16	0.9	1.2
16 ER 11,5	11.5	16	1.1	1.5
16 ER 8	8.0	16	1.3	1.8

ER TR	ER TR	ER TR
71 256 ...	71 256 ...	71 256 ...
	41200	
04001		
04201	742	
04401	744	144
04601	746	146
04801		

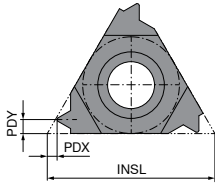
P	●	○	●
M	○	●	○
K	●	○	●
N		○	●
S	○	○	○
H	○	○	
O		○	



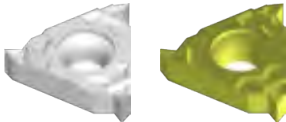
→ Find the cutting data standard values here.

CoreLine – Right hand outer thread-turning insert

- ▲ Thread-turning inserts are precision-sintered with chip breaker
- ▲ Full profile



-P CTPM520	-P CTPX525
DRAGONSKIN	DRAGONSKIN



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
16 ER-M 18	18.0	16	0.8	1.0
16 ER-M 14	14.0	16	1.0	1.2
16 ER-M 11,5	11.5	16	1.1	1.5

ER-M TR	ER-M TR
71 256 ...	71 256 ...
44200	04200
44400	04400
44600	04600

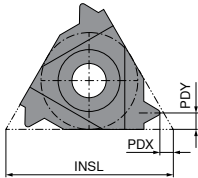
P	○	●
M	●	○
K	○	●
N	○	●
S	○	○
H	○	
O	○	



→ Find the cutting data standard values here.

CoreLine – Left hand external thread turning insert

▲ Full profile



CTPP525

CTWN520

DRAGONSKIN

DRAGONSKIN



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
16 EL 27	27.0	16	0.7	0.8
16 EL 18	18.0	16	0.8	1.0
16 EL 14	14.0	16	0.9	1.2
16 EL 11,5	11.5	16	1.1	1.5
16 EL 8	8.0	16	1.3	1.8

EL TR
71 258 ...
04001
04201
04401
04601
04801

EL TR
71 258 ...
14201
14401
14601

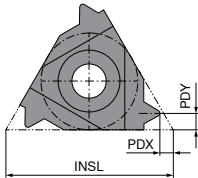
P	●	
M	○	
K	●	
N		●
S	○	○
H	○	
O		



→ Find the cutting data standard values here.

CoreLine – Right hand internal thread turning insert

▲ Full profile



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CTPP525

DRAGONSKIN

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Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
11 IR 27	27.0	11	0.7	0.8
11 IR 18	18.0	11	0.8	1.0
11 IR 14	14.0	11	0.9	1.1
16 IR 27	27.0	16	0.7	0.8
16 IR 18	18.0	16	0.8	1.0
16 IR 14	14.0	16	0.9	1.2
16 IR 11,5	11.5	16	1.1	1.5
16 IR 8	8.0	16	1.3	1.8

IR TR	IR TR
71 260 ...	71 260 ...
01001	
01201	
01401	
04001	
04201	
04401	944
04601	946
04801	

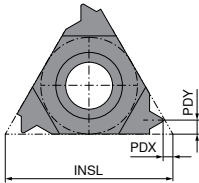
P	●	●
M	○	○
K	●	●
N		
S	○	○
H	○	○
O		



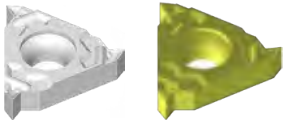
→ Find the cutting data standard values here.

CoreLine – Right hand internal thread-turning insert

- ▲ Thread-turning inserts are precision-sintered with chip breaker
- ▲ Full profile



-P CTPM520	-P CTPX525
DRAGONSKIN	DRAGONSKIN



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
16 IR-M 14	14.0	16	0.9	1.2
16 IR-M 11,5	11.5	16	1.1	1.5
16 IR-M 8	8.0	16	1.3	1.8

IR-M TR	IR-M TR
71 260 ...	71 260 ...
44400	04400
44600	04600
44800	04800

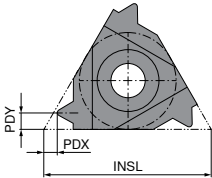
P	○	●
M	●	○
K	○	●
N	○	●
S	○	○
H	○	
O	○	



→ Find the cutting data standard values here.

CoreLine – Left hand internal thread turning insert

▲ Full profile

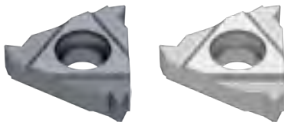


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DRAGONSKIN

DRAGONSKIN



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm	IL	
					TR	TR
11 IL 27	27.0	11	0.7	0.8	71 262 ...	71 262 ...
11 IL 18	18.0	11	0.8	1.0	01001	
11 IL 14	14.0	11	0.9	1.1	01201	11201
					01401	11401
16 IL 18	18.0	16	0.8	1.0	04201	
16 IL 14	14.0	16	0.9	1.2	04401	
16 IL 11,5	11.5	16	1.1	1.5	04601	14601
16 IL 8	8.0	16	1.3	1.8	04801	14801
P					●	
M					○	
K					●	
N						●
S					○	○
H					○	
O						



→ Find the cutting data standard values here.

CoreLine – Right hand external thread turning insert

- ▲ Full profile
- ▲ Trapezoidal thread DIN 103



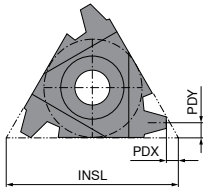
Designation	TP mm	INSL mm	PDX mm	PDY mm	ER TR 71 232 ...	ER TR 71 232 ...
16 ER 1,5	1.5	16	1.0	1.1	04001	
16 ER 2,0	2.0	16	1.1	1.3	04201	
16 ER 2,0	2.0	16	1.0	1.3		142
16 ER 3,0	3.0	16	1.3	1.5	04401	144
22 ER 4,0	4.0	22	1.7	1.9	07001	
22 ER 4,0	4.0	22	1.8	1.9		170
22 ER 5,0	5.0	22	2.0	2.4		172
22 ER 5,0	5.0	22	2.1	2.5	07201	
22 ER 6,0	6.0	22	2.3	2.7	07401 ¹⁾	
P					●	●
M					○	○
K					●	●
N						●
S					○	○
H					○	
O						

1) Caution: Requires special holder or an independently modified standard holder

→ Find the cutting data standard values here.

CoreLine – Left hand external thread turning insert

- ▲ Full profile
- ▲ Trapezoidal thread DIN 103

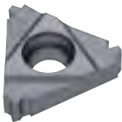
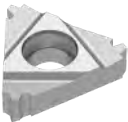


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DRAGONSKIN

DRAGONSKIN



Designation	TP mm	INSL mm	PDX mm	PDY mm
16 EL 1,5	1.5	16	1.0	1.1
16 EL 2,0	2.0	16	1.1	1.3
16 EL 3,0	3.0	16	1.3	1.5
22 EL 4,0	4.0	22	1.7	1.9
22 EL 5,0	5.0	22	2.1	2.5
22 EL 6,0	6.0	22	2.3	2.7

EL TR	EL TR
71 234 ...	71 234 ...
04001	
04201	14201
04401	14401
07001	17001
07201	17201
07401 ¹⁾	

P	●	
M	○	
K	●	
N		●
S	○	○
H	○	
O		

1) Caution: Requires special holder or an independently modified standard holder

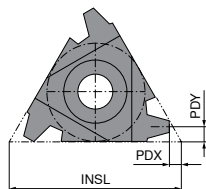


→ Find the cutting data standard values here.

CoreLine – Right hand internal thread turning insert

▲ Full profile

▲ Trapezoidal thread DIN 103



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DRAGONSKIN

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Designation	TP mm	INSL mm	PDX mm	PDY mm
16 IR 1,5	1.5	16	1.0	1.1
16 IR 2,0	2.0	16	1.1	1.3
16 IR 3,0	3.0	16	1.3	1.5
22 IR 4,0	4.0	22	1.7	1.9
22 IR 4,0	4.0	22	1.8	1.9
22 IR 5,0	5.0	22	2.0	2.4
22 IR 5,0	5.0	22	2.1	2.5
22 IR 6,0	6.0	22	2.3	2.7

IR TR	IR TR
71 236 ...	71 236 ...
04001	
04201	
04401	144
07001	
	170
	172
07201	
07401 ¹⁾	

P	●	●
M	○	○
K	●	●
N	●	●
S	○	○
H	○	
O		

1) Caution: Requires special holder or an independently modified standard holder



→ Find the cutting data standard values here.

CoreLine – Neutral internal thread turning insert

- ▲ Full profile
- ▲ Trapezoidal thread DIN 103
- ▲ Can be used for the production of right-hand and left-hand threads
- ▲ Neutral tool holder marked (U) is required

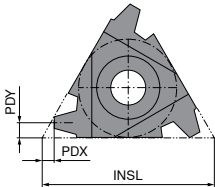


Designation	TP mm	INSL mm	PDX mm	PDY mm	IN	
					TR	
22 IN 6,0	6	22	2.0	11	71 236 ...	07601
22 IN 7,0	7	22	2.3	11		07801
P						●
M						○
K						●
N						
S						○
H						○
O						

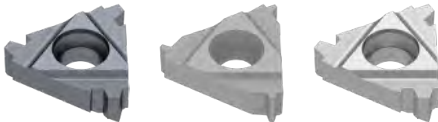
→ Find the cutting data standard values here.

CoreLine – Left hand internal thread turning insert

- ▲ Full profile
- ▲ Trapezoidal thread DIN 103



CTPP525	CTPM520	CTWN520
DRAGONSKIN	DRAGONSKIN	DRAGONSKIN



Designation	TP mm	INSL mm	PDX mm	PDY mm
16 IL 1,5	1.5	16	1.0	1.1
16 IL 2,0	2.0	16	1.1	1.3
16 IL 3,0	3.0	16	1.3	1.5
22 IL 4,0	4.0	22	1.7	1.9
22 IL 5,0	5.0	22	2.1	2.5
22 IL 6,0	6.0	22	2.3	2.7

IL TR	IL TR	IL TR
71 238 ...	71 238 ...	71 238 ...
04201	44000	
04401		14401
07001		17001
07201		17201
07401 ¹⁾		17401 ¹⁾

P	●	○	
M	○	●	
K	●	○	
N		○	●
S	○	○	○
H	○	○	
O		○	

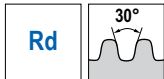
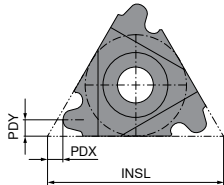
1) Caution: Requires special holder or an independently modified standard holder



→ Find the cutting data standard values here.

CoreLine – Right hand external thread turning insert

- ▲ Full profile
- ▲ Round thread DIN 405

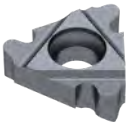


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Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
16 ER 10	10	16	1.1	1.2
16 ER 8	8	16	1.4	1.3
16 ER 6	6	16	1.5	1.7
22 ER 6	6	22	1.5	1.7
22 ER 4	4	22	2.2	2.3

ER TR	ER TR
71 248 ...	71 248 ...
04001	14001
04201	14201
04601	14601
07001	17001
07201	17201

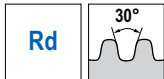
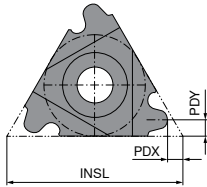
P	●	
M	○	
K	●	
N		●
S	○	○
H	○	
O		



→ Find the cutting data standard values here.

CoreLine – Left hand external thread turning insert

- ▲ Full profile
- ▲ Round thread DIN 405

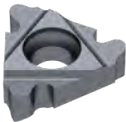


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DRAGONSKIN

DRAGONSKIN



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
16 EL 10	10	16	1.1	1.2
16 EL 8	8	16	1.4	1.3
16 EL 6	6	16	1.5	1.7
22 EL 6	6	22	1.5	1.7
22 EL 4	4	22	2.2	2.3

EL TR	EL TR
71 250 ...	71 250 ...
04001	14001
04201	14201
04601	14601
07001	
07201	

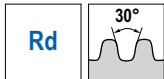
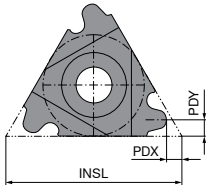
P	●	
M	○	
K	●	
N		●
S	○	○
H	○	
O		



→ Find the cutting data standard values here.

CoreLine – Right hand internal thread turning insert

- ▲ Full profile
- ▲ Round thread DIN 405



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Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
16 IR 10	10	16	1.1	1.2
16 IR 8	8	16	1.4	1.4
16 IR 6	6	16	1.4	1.5
22 IR 6	6	22	1.5	1.7
22 IR 4	4	22	2.2	2.3

IR TR	IR TR
71 252 ...	71 252 ...
04001	14001
04201	14201
04601	14601
07001	17001
07201	17201

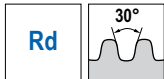
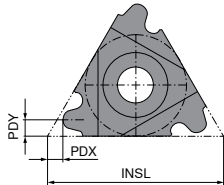
P	●
M	○
K	●
N	●
S	○
H	○
O	



→ Find the cutting data standard values here.

CoreLine – Left hand internal thread turning insert

- ▲ Full profile
- ▲ Round thread DIN 405



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Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
16 IL 10	10	16	1.1	1.2
16 IL 8	8	16	1.4	1.4
16 IL 6	6	16	1.4	1.5
22 IL 6	6	22	1.5	1.7
22 IL 4	4	22	2.2	2.3

IL TR	IL TR
71 254 ...	71 254 ...
04001	
04201	14201
04601	14601
07001	17001
07201	

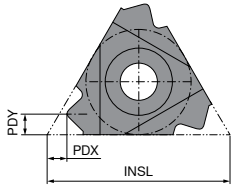
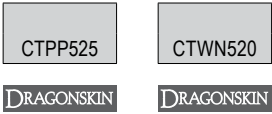
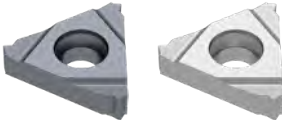
P	●	
M	○	
K	●	
N		●
S	○	○
H	○	
O		



→ Find the cutting data standard values here.

CoreLine – Right hand external thread turning insert

- ▲ Full profile
- ▲ Conduit thread DIN 40430



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
16 ER 20	20	16	0.8	0.8
16 ER 18	18	16	0.8	0.9
16 ER 16	16	16	0.8	1.0

ER TR	ER TR
71 240 ...	71 240 ...
04001	14001
04201	14201
04401	14401

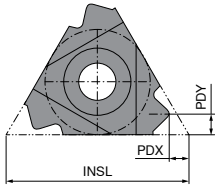
P	●	
M	○	
K	●	
N		●
S	○	○
H	○	
O		



→ Find the cutting data standard values here.

CoreLine – Right hand internal thread turning insert

- ▲ Full profile
- ▲ Conduit thread DIN 40430

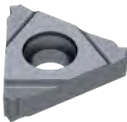
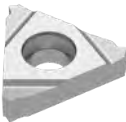


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Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
11 IR 18	18	11	0.8	0.9
16 IR 18	18	16	0.8	0.9
16 IR 16	16	16	0.8	1.0

IR TR	IR TR
71 244 ... 03801	71 244 ... 13801
04201 04401	14201 14401

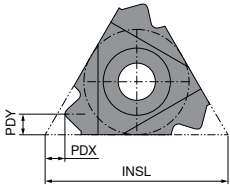
P	●	
M	○	
K	●	
N		●
S	○	○
H	○	
O		



→ Find the cutting data standard values here.

CoreLine – Left hand internal thread turning insert

- ▲ Full profile
- ▲ Conduit thread DIN 40430



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DRAGONSKIN



Designation	TPI	INSL	PDX	PDY
	1/"	mm	mm	mm
16 IL 16	16	16	0.8	1

IL
TR
71 246 ...
04401

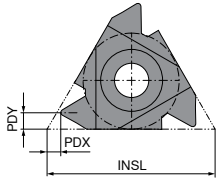
P	●
M	○
K	●
N	
S	○
H	○
O	



→ Find the cutting data standard values here.

CoreLine – Right hand external thread turning insert

▲ Partial profile



Designation	TP mm	INSL mm	PDX mm	PDY mm
16 ER A60	0,5 - 1,5	16	0.8	0.9
16 ER AG60	0,5 - 3	16	1.2	1.7
16 ER G60	1,75 - 3	16	1.2	1.7
22 ER N60	3,5 - 5	22	1.7	2.5

P	●	●	○	●	
M	○	○	●	○	
K	●	●	○	●	
N			○	●	●
S	○	○	○	○	○
H	○	○	○		
O			○		



→ Find the cutting data standard values here.

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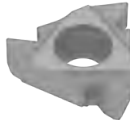
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ER TR
71 206 ...
04001
04401
04201
07001

ER TR
71 206 ...
940
944
942

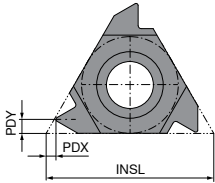
ER TR
71 206 ...
740
744
742

ER TR
71 206 ...
140
144
142
170

ER TR
71 206 ...
14001
14401
14201
17001

CoreLine – Right hand outer thread-turning insert

- ▲ Thread-turning inserts are precision-sintered with chip breaker
- ▲ Partial profile

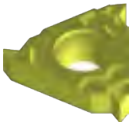


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DRAGONSKIN



Designation	TP mm	INSL mm	PDX mm	PDY mm
16 ER-M A60	0,5 - 1,5	16	0.8	0.9
16 ER-M AG60	0,5 - 3	16	1.2	1.7
16 ER-M G60	1,75 - 3	16	1.2	1.7

ER-M TR
71 206 ...
44000
44400
44200

ER-M TR
71 206 ...
04000
04400
04200

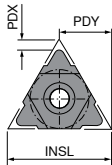
P	○	●
M	●	○
K	○	●
N	○	●
S	○	○
H	○	
O	○	



→ Find the cutting data standard values here.

CoreLine – Neutral external/internal thread turning insert

- ▲ Partial profile
- ▲ Can be used for the production of right-hand and left-hand threads
- ▲ Neutral tool holder marked (U) is required



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Designation	TP mm	INSL mm	PDX mm	PDY mm
22 EIN U60	5,5 - 8	22	0.9	11

EIN TR
71 210 ...
07201

EIN TR
71 206 ...
17201

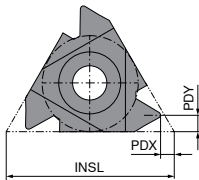
P	●	
M	○	
K	●	
N		●
S	○	○
H	○	
O		



→ Find the cutting data standard values here.

CoreLine – Left hand external thread turning insert

▲ Partial profile

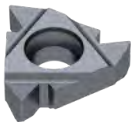


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DRAGONSKIN

DRAGONSKIN



Designation	TP mm	INSL mm	PDX mm	PDY mm
16 EL A60	0,5 - 1,5	16	0.8	0.9
16 EL AG60	0,5 - 3	16	1.2	1.7
16 EL G60	1,75 - 3	16	1.2	1.7
22 EL N60	3,5 - 5	22	1.7	2.5

EL TR
71 208 ...
04001
04401
04201
07001

EL TR
71 208 ...
14001
14401
14201
17001

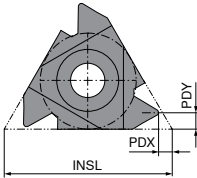
P	●	
M	○	
K	●	
N		●
S	○	○
H	○	
O		



→ Find the cutting data standard values here.

CoreLine – Right hand internal thread turning insert

▲ Partial profile



Designation	TP mm	INSL mm	PDX mm	PDY mm
11 IR A60	0,5 - 1,5	11	0.8	0.9
16 IR A60	0,5 - 1,5	16	0.8	0.9
16 IR AG60	0,5 - 3	16	1.2	1.7
16 IR G60	1,75 - 3	16	1.2	1.7
22 IR N60	3,5 - 5	22	1.7	2.5

P	●	●	○	●
M	○	○	●	○
K	●	●	○	●
N			○	●
S	○	○	○	○
H	○	○	○	
O			○	



→ Find the cutting data standard values here.

CTPP525

DRAGONSKIN

-P
CTPP525

DRAGONSKIN

CTPM520

DRAGONSKIN

CTPX525

DRAGONSKIN

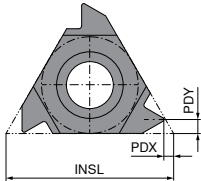
CTWN520

DRAGONSKIN

IR TR	IR TR	IR TR	IR TR	IR TR
71 210 ... 01001	71 210 ...	71 210 ...	71 210 ... 110	71 210 ... 11001
04001			140	14001
04401	944	744	144	14401
04201			142	14201
07001			170	17001

CoreLine – Right hand internal thread-turning insert

- ▲ Thread-turning inserts are precision-sintered with chip breaker
- ▲ Partial profile

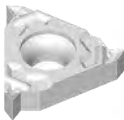


-P
CTPM520

DRAGONSKIN

-P
CTPX525

DRAGONSKIN



Designation	TP mm	INSL mm	PDX mm	PDY mm
11 IR-M A60	0,5 - 1,5	11	0.8	0.9
16 IR-M A60	0,5 - 1,5	16	0.8	0.9
16 IR-M AG60	0,5 - 3	16	1.2	1.7
16 IR-M G60	1,75 - 3	16	1.2	1.7

IR-M TR
71 210 ...
41000
44000
44400
44200

IR-M TR
71 210 ...
01000
04000
04400
04200

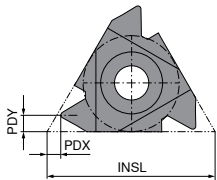
P	○	●
M	●	○
K	○	●
N	○	●
S	○	○
H	○	
O	○	



→ Find the cutting data standard values here.

CoreLine – Left hand internal thread turning insert

▲ Partial profile

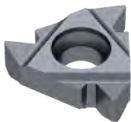


CTPP525

CTWN520

DRAGONSKIN

DRAGONSKIN



Designation	TP mm	INSL mm	PDX mm	PDY mm
11 IL A60	0,5 - 1,5	11	0.8	0.9
16 IL A60	0,5 - 1,5	16	0.8	0.9
16 IL AG60	0,5 - 3	16	1.2	1.7
16 IL G60	1,75 - 3	16	1.2	1.7
22 IL N60	3,5 - 5	22	1.7	2.5

IL TR	IL TR
71 212 ...	71 212 ...
01001	11001
04001	14001
04401	14401
04201	14201
07001	17001

P	●	
M	○	
K	●	
N		●
S	○	○
H	○	
O		

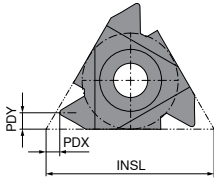


→ Find the cutting data standard values here.

CoreLine – Right hand external thread turning insert

▲ Partial profile





CTPP525

DRAGONSKIN



-P
CTPP525

DRAGONSKIN



CTPM520

DRAGONSKIN



CTPX525

DRAGONSKIN



CTWN520

DRAGONSKIN



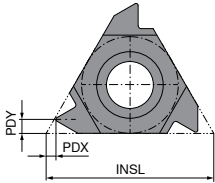
Designation	TPI 1/"	INSL mm	PDX mm	PDY mm	ER TR 71 200 ...	ER TR 71 200 ...	ER TR 71 200 ...	ER TR 71 200 ...	ER TR 71 200 ...
16 ER A55	48 - 16	16	0.8	0.9	04001	940	740	140	14001
16 ER AG55	48 - 8	16	1.2	1.7	04401	944	744	144	14401
16 ER G55	14 - 8	16	1.2	1.7	04201	942	742	142	14201
22 ER N55	7 - 5	22	1.7	2.5	07001		770	170	17001
P					●	●	○	●	
M					○	○	●	○	
K					●	●	○	●	
N							○	●	●
S					○	○	○	○	○
H					○	○	○		
O							○		



→ Find the cutting data standard values here.

CoreLine – Right hand outer thread-turning insert

- ▲ Thread-turning inserts are precision-sintered with chip breaker
- ▲ Partial profile

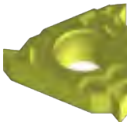


-P
CTPX525

-P
CTPM520

DRAGONSKIN

DRAGONSKIN



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
16 ER-M A55	48 - 16	16	0.8	0.9
16 ER-M AG55	48 - 8	16	1.2	1.7
16 ER-M G55	14 - 8	16	1.2	1.7

ER-M TR
71 200 ...
04000
04400
04200

ER-M TR
71 200 ...
44000
44400
44200

P	●	○
M	○	●
K	●	○
N	●	○
S	○	○
H		○
O		○



→ Find the cutting data standard values here.

CoreLine – Neutral external/internal thread turning insert

- ▲ Partial profile
- ▲ Can be used for the production of right-hand and left-hand threads
- ▲ Neutral tool holder marked (U) is required



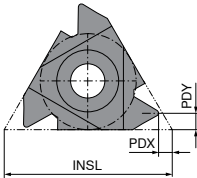
Designation	TPI 1/"	INSL mm	PDX mm	PDY mm	EIN	
					TR	TR
22 EIN U55	4,5 - 3,25	22	0.9	11	71 200 ... 07201	71 200 ... 17201
P					●	
M					○	
K					●	
N						●
S					○	○
H					○	
O						



→ Find the cutting data standard values here.

CoreLine – Left hand external thread turning insert

▲ Partial profile

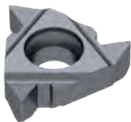


CTPP525

CTWN520

DRAGONSKIN

DRAGONSKIN



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
16 EL A55	48 - 16	16	0.8	0.9
16 EL AG55	48 - 8	16	1.2	1.7
16 EL G55	14 - 8	16	1.2	1.7
22 EL N55	7 - 5	22	1.7	2.5

EL TR	EL TR
71 202 ...	71 202 ...
04001	14001
04401	
04201	14201
07001	17001

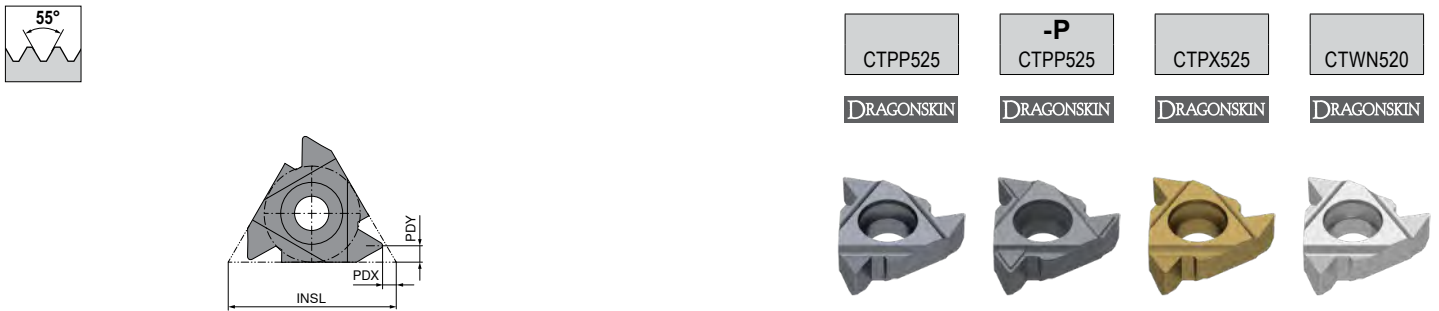
P	●	
M	○	
K	●	
N		●
S	○	○
H	○	
O		



→ Find the cutting data standard values here.

CoreLine – Right hand internal thread turning insert

▲ Partial profile



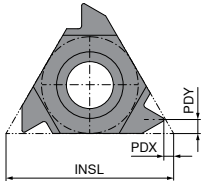
Designation	TPI 1/"	INSL mm	PDX mm	PDY mm	IR TR 71 204 ...	IR TR 71 204 ...	IR TR 71 204 ...	IR TR 71 204 ...
11 IR A55	48 - 16	11	0.8	0.9	01001			11001
16 IR A55	48 - 16	16	0.8	0.9	04001			14001
16 IR AG55	48 - 8	16	1.2	1.7	04401			14401
16 IR G55	14 - 8	16	1.2	1.7	04201	942	142	14201
22 IR N55	7 - 5	22	1.7	2.5	07001			17001
P					●	●	●	
M					○	○	○	
K					●	●	●	
N							●	●
S					○	○	○	○
H					○	○		
O								



→ Find the cutting data standard values here.

CoreLine – Right hand internal thread-turning insert

- ▲ Thread-turning inserts are precision-sintered with chip breaker
- ▲ Partial profile

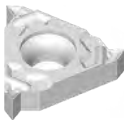


-P
CTPM520

-P
CTPX525

DRAGONSKIN

DRAGONSKIN



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
11 IR-M A55	48 - 16	11	0.8	0.9
16 IR-M A55	48 - 16	16	0.8	0.9
16 IR-M AG55	48 - 8	16	1.2	1.7
16 IR-M G55	14 - 8	16	1.2	1.7

IR-M TR	IR-M TR
71 204 ...	71 204 ...
41000	01000
44000	04000
44400	04400
44200	04200

P	○	●
M	●	○
K	○	●
N	○	●
S	○	○
H	○	
O	○	



→ Find the cutting data standard values here.

CoreLine – Left hand internal thread turning insert

▲ Partial profile



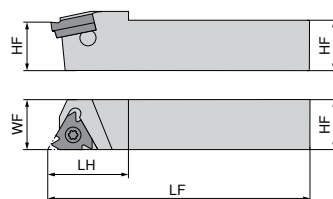
Designation	TPI 1/"	INSL mm	PDX mm	PDY mm	IL	
					TR	TR
11 IL A55	48 - 16	11	0.8	0.9	71 203 ... 01001	71 203 ... 11001
16 IL A55	48 - 16	16	0.8	0.9	04001	14001
16 IL AG55	48 - 8	16	1.2	1.7	04401	14401
16 IL G55	14 - 8	16	1.2	1.7	04201	14201
22 IL N55	7 - 5	22	1.7	2.5	07001	
P					●	
M					○	
K					●	
N						●
S					○	○
H					○	
O						



→ Find the cutting data standard values here.

CoreLine – Standard external threading holder

▲ Tool holder with approach angle $\beta = 1.5^\circ$



Illustrations show right-hand versions



Designation	HF mm	WF mm	LF mm	LH mm	Indexable insert	Tightening torque Nm	Left	Right
							TO 71 281 ...	TO 71 280 ...
SE R/L 08 08 H11	8	11	100	16	11 ..	1,3	908 ²⁾	908 ²⁾
SE R/L 10 10 H11	10	12	100	18	11 ..	1,3	910 ²⁾	910 ²⁾
SE R/L 12 12 K11	12	12	125	20	11 ..	1,3	912 ²⁾	912 ²⁾
SE R/L 12 12 F16	12	16	80	22	16 ..	3,5	012	012
SE R/L 16 16 H16	16	16	100	25	16 ..	3,5	016	016
SE R/L 20 20 K16	20	20	125	30	16 ..	3,5	020	020
SE R/L 25 25 M16	25	25	150	30	16 ..	3,5	025	025
SE R/L 32 32 P16	32	32	170	30	16 ..	3,5	032	032
SE R/L 25 25 M22	25	25	150	32	22 ..	10	125	125
SE R 32 32 P22	32	32	170	34	22 ..	10		132
SE R 32 32 P22U	32	21	170	32	22 ..N	10		232 ¹⁾

1) Neutral indexable insert marked (N) is required

2) without shim

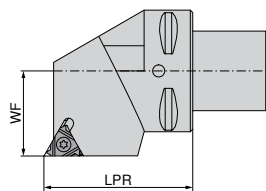
Spare parts for article number	Multi-tooth shims		Shims		Screw U		Screwdriver		Clamping screw	
	AS	71 950 ...	AS	71 950 ...	AS	71 950 ...	AS	80 950 ...	AS	71 950 ...
71 280 908 / 71 281 908							T08	110		230
71 280 910 / 71 281 910							T08	110		230
71 280 912 / 71 281 912							T08	110		230
71 280 012			ER 16 / IL 16	101	ER 16 / IL 16	121	234	T10	112	231
71 281 012			EL 16 / IR 16	108	EL 16 / IR 16	129	234	T10	112	231
71 280 016			ER 16 / IL 16	101	ER 16 / IL 16	121	234	T10	112	231
71 281 016			EL 16 / IR 16	108	EL 16 / IR 16	129	234	T10	112	231
71 280 020			ER 16 / IL 16	101	ER 16 / IL 16	121	234	T10	112	231
71 281 020			EL 16 / IR 16	108	EL 16 / IR 16	129	234	T10	112	231
71 280 025			ER 16 / IL 16	101	ER 16 / IL 16	121	234	T10	112	231
71 281 025			EL 16 / IR 16	108	EL 16 / IR 16	129	234	T10	112	231
71 280 032			ER 16 / IL 16	101	ER 16 / IL 16	121	234	T10	112	231
71 281 032			EL 16 / IR 16	108	EL 16 / IR 16	129	234	T10	112	231
71 280 125			ER 22 / IL 22	110	ER 22 / IL 22	137	235	T20	114	232
71 281 125			EL 22 / IR 22	115	EL 22 / IR 22	145	235	T20	114	232
71 280 132			ER 22 / IL 22		ER 22 / IL 22	137	235	T20	114	232
71 280 232			ER 22U / IL 22U		ER 22U / IL 22U	153	235	T20	114	232



→ You will find shims for approach angle correction here.

CoreLine – External threading holder

▲ Tool holder with approach angle $\beta = 1.5^\circ$



Illustrations show right-hand versions



Left

Right

Designation	Adapter	LPR mm	WF mm	Indexable insert	Tightening torque Nm	Left TO 84 191 ...	Right TO 84 190 ...
PSC40 SE R/L 27050-16.IK	PSC 40	50	27	16 ..	3,5	412	412
PSC40 SE R/L 27050-22.IK	PSC 40	50	27	22 ..	10	422	422
PSC50 SE R/L 35060-16.IK	PSC 50	60	35	16 ..	3,5	512	512
PSC50 SE R/L 35060-22.IK	PSC 50	60	35	22 ..	10	522	522
PSC63 SE R/L 45065-16.IK	PSC 63	65	45	16 ..	3,5	612	612
PSC63 SE R/L 45065-22.IK	PSC 63	65	45	22 ..	10	622	622
PSC80 SE R/L 55080-22.IK	PSC 80	80	55	22 ..	10	822	822

Spare parts
for article number



Multi-tooth shims

AS

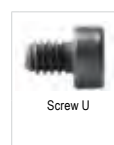
71 950 ...



Shims

AS

71 950 ...



Screw U

AS

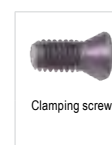
71 950 ...



Screwdriver

AS

80 950 ...



Clamping screw

AS

71 950 ...

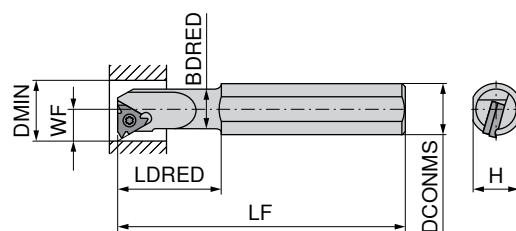
84 190 412	ER 16 / IL 16	101	ER 16 / IL 16	121	234	T10	112	231
84 191 412	EL 16 / IR 16	108	EL 16 / IR 16	129	234	T10	112	231
84 190 422	ER 22 / IL 22	110	ER 22 / IL 22	137	235	T20	114	232
84 191 422	EL 22 / IR 22	115	EL 22 / IR 22	145	235	T20	114	232
84 190 512	ER 16 / IL 16	101	ER 16 / IL 16	121	234	T10	112	231
84 191 512	EL 16 / IR 16	108	EL 16 / IR 16	129	234	T10	112	231
84 190 522	ER 22 / IL 22	110	ER 22 / IL 22	137	235	T20	114	232
84 191 522	EL 22 / IR 22	115	EL 22 / IR 22	145	235	T20	114	232
84 190 612	ER 16 / IL 16	101	ER 16 / IL 16	121	234	T10	112	231
84 191 612	EL 16 / IR 16	108	EL 16 / IR 16	129	234	T10	112	231
84 190 622	ER 22 / IL 22	110	ER 22 / IL 22	137	235	T20	114	232
84 191 622	EL 22 / IR 22	115	EL 22 / IR 22	145	235	T20	114	232
84 190 822	ER 22 / IL 22	110	ER 22 / IL 22	137	235	T20	114	232
84 191 822	EL 22 / IR 22	115	EL 22 / IR 22	145	235	T20	114	232



→ You will find shims for approach angle correction here.

CoreLine – Standard internal threading holder

▲ Tool holder with approach angle $\beta = 1.5^\circ$



Illustrations show right-hand versions



Designation	H mm	LF mm	LDRED mm	DCONMS mm	BDRED mm	WF mm	DMIN mm	Indexable insert	Tightening torque Nm
SI R 0010 H11	9.0	100	25	10	9.5	7.4	12	11 ..	1,3
SI R/L 0010 K11	14.0	125	25	16	10.0	7.4	12	11 ..	1,3
SI R 0013 L11	14.0	140	32	16	12.0	8.9	15	11 ..	1,3
SI R/L 0013 M16	14.0	150	32	16	13.0	10.2	16	16 ..	3,5
SI R/L 0016 P16	18.0	170	40	20	15.0	11.7	19	16 ..	3,5
SI R/L 0020 P16	18.0	170	40	20	19.5	13.7	24	16 ..	3,5
SI R 0025 R16	22.6	200	40	25	24.5	16.2	29	16 ..	3,5
SI R/L 0032 S16	28.8	250	50	32	31.5	19.7	36	16 ..	3,5
SI R 0040 T16	36.0	300	50	40	39.5	23.7	44	16 ..	3,5
SI R 0020 P22	18.0	170	40	20	19.5	15.6	24	22 ..	10
SI R/L 0025 R22	22.6	200	40	25	24.5	18.1	29	22 ..	10
SI R 0032 S22	28.8	250	50	32	31.5	21.6	38	22 ..	10
SI R 0040 T22	36.0	300	60	40	39.5	25.6	46	22 ..	10
SI R 0032 S22U	28.8	250	60	32	31.5	24.4	38	22 ..N	10

Left TO	Right TO
71 283 ...	71 282 ...
010 ¹⁾	011 ¹⁾
	010 ¹⁾
	013 ¹⁾
015 ¹⁾	015 ¹⁾
016 ¹⁾	016 ¹⁾
020	020
	026
032	032
	040
126	120 ¹⁾
	126
	132
	140
	133 ²⁾

1) without shim

2) Neutral indexable insert marked (N) is required

Spare parts for article number

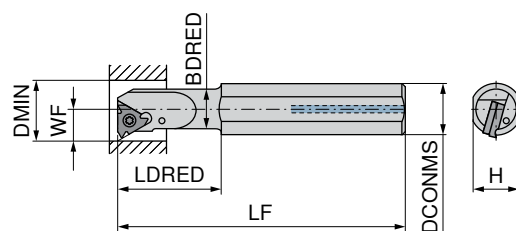
	Multi-tooth shims AS 71 950 ...	Shims AS 71 950 ...	Screw U AS 71 950 ...	Screwdriver AS 80 950 ...	Clamping screw AS 71 950 ...
71 282 011				T08	110
71 282 010 / 71 283 010				T08	110
71 282 013				T08	110
71 282 015 / 71 283 015				T10	112
71 282 016 / 71 283 016				T10	112
71 282 020	EL 16 / IR 16 108	EL 16 / IR 16 129	234	T10	112
71 283 020	ER 16 / IL 16 101	ER 16 / IL 16 121	234	T10	112
71 282 026	EL 16 / IR 16 108	EL 16 / IR 16 129	234	T10	112
71 282 032	EL 16 / IR 16 108	EL 16 / IR 16 129	234	T10	112
71 283 032	ER 16 / IL 16 101	ER 16 / IL 16 121	234	T10	112
71 282 040	EL 16 / IR 16 108	EL 16 / IR 16 129	234	T10	112
71 282 120			234	T20	114
71 282 126	EL 22 / IR 22 115	EL 22 / IR 22 145	235	T20	114
71 283 126	ER 22 / IL 22 110	ER 22 / IL 22 137	235	T20	114
71 282 132	EL 22 / IR 22 115	EL 22 / IR 22 145	235	T20	114
71 282 140	EL 22 / IR 22 115	EL 22 / IR 22 145	235	T20	114
71 282 133		AL 22U / IR 22U 161	235	T20	114



→ You will find shims for approach angle correction here.

CoreLine – Standard internal threading holder with through coolant supply

▲ Tool holder with approach angle $\beta = 1.5^\circ$



Illustrations show right-hand versions



Designation	H mm	LF mm	LDRED mm	DCONMS mm	BDRED mm	WF mm	DMIN mm	Indexable insert	Tightening torque Nm	Left	Right
										TO	TO
SI R 0010 M11CB	9.0	150	25	10	9.5	7.4	12	11 ..	1,3	71 283 ...	510 ²⁾
SI R 0012 P11CB	11.0	170	30	12	11.5	8.4	15	11 ..	1,3		512 ²⁾
SI R/L 0010 K11B	14.0	125	25	16	10.0	7.4	12	11 ..	1,3		310
SI R/L 0013 M16B	14.0	150	32	16	13.0	10.2	16	16 ..	3,5	310	315
SI R 0016 P16B	18.0	170	40	20	16.0	11.7	19	16 ..	3,5		316
SI R 0020 P16B	18.0	170	40	20	19.5	13.7	24	16 ..	3,5		320 ¹⁾
SI R/L 0032 S16B	28.8	250	50	32	31.5	19.7	36	16 ..	3,5	332 ¹⁾	332 ¹⁾

1) with shim

2) Carbide version

Spare parts for article number	Multi-tooth shims		Shims		Screw U		Screwdriver		Clamping screw	
	AS	71 950 ...	AS	71 950 ...	AS	71 950 ...	AS	80 950 ...	AS	71 950 ...
71 282 510							T08	110		230
71 282 512							T08	110		230
71 282 310 / 71 283 310							T08	110		230
71 282 315 / 71 283 315							T10	112		236
71 282 316							T10	112		236
71 282 320			EL 16 / IR 16	108	EL 16 / IR 16	129	T10	112		231
71 282 332			EL 16 / IR 16	108	EL 16 / IR 16	129	T10	112		231
71 283 332			ER 16 / IL 16	101	ER 16 / IL 16	121	T10	112		231



→ You will find shims for approach angle correction here.



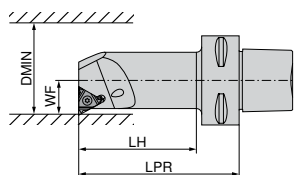
Are you familiar with our MaxiChange exchangeable head system?

Use our thread milling inserts for the exchangeable head system.

Curious? You'll find more information and products in → Chapter – Indexable insert turning tools

CoreLine – Internal threading holder

▲ Tool holder with approach angle $\beta = 1.5^\circ$



Illustrations show right-hand versions

Designation	Adapter	WF mm	LPR mm	LH mm	DMIN mm	Indexable insert	Tightening torque Nm	Left	Right
								TO 84 197 ...	TO 84 196 ...
PSC40 SI R/L 12060-16.IK	PSC 40	12	60	37	20	16 ..	3,5	410	410
PSC40 SI R/L 14060-16.IK	PSC 40	14	60	38	25	16 ..	3,5	412	412
PSC40 SI R/L 17070-16.IK	PSC 40	17	70	48	32	16 ..	3,5	414	414
PSC40 SI R/L 22090-16.IK	PSC 40	22	90	69	40	16 ..	3,5	416	416
PSC40 SI R/L 27080-16.IK	PSC 40	27	80	60	50	16 ..	3,5	418	418
PSC40 SI R/L 15065-22.IK	PSC 40	15	65	42	25	22 ..	10	420	420
PSC40 SI R/L 19070-22.IK	PSC 40	19	70	48	32	22 ..	10	422	422
PSC40 SI R/L 22090-22.IK	PSC 40	22	90	69	40	22 ..	10	424	424
PSC40 SI R/L 27080-22.IK	PSC 40	27	80	60	50	22 ..	10	426	426
PSC50 SI R/L 12060-16.IK	PSC 50	12	60	35	20	16 ..	3,5	510	510
PSC50 SI R/L 14060-16.IK	PSC 50	14	60	36	25	16 ..	3,5	512	512
PSC50 SI R/L 17070-16.IK	PSC 50	17	70	47	32	16 ..	3,5	514	514
PSC50 SI R/L 22090-16.IK	PSC 50	22	90	68	40	16 ..	3,5	516	516
PSC50 SI R/L 27105-16.IK	PSC 50	27	105	84	50	16 ..	3,5	518	518
PSC50 SI R/L 15065-22.IK	PSC 50	15	65	41	25	22 ..	10	520	520
PSC50 SI R/L 19070-22.IK	PSC 50	19	70	47	32	22 ..	10	522	522
PSC50 SI R/L 22090-22.IK	PSC 50	22	90	68	40	22 ..	10	524	524
PSC50 SI R/L 27105-22.IK	PSC 50	27	105	84	50	22 ..	10	526	526
PSC63 SI R/L 14070-16.IK	PSC 63	14	70	42	25	16 ..	3,5	610	610
PSC63 SI R/L 17075-16.IK	PSC 63	17	75	48	32	16 ..	3,5	612	612
PSC63 SI R/L 22090-16.IK	PSC 63	22	90	64	40	16 ..	3,5	614	614
PSC63 SI R/L 27105-16.IK	PSC 63	27	105	80	50	16 ..	3,5	616	616
PSC63 SI R/L 19075-22.IK	PSC 63	19	75	48	32	22 ..	10	620	620
PSC63 SI R/L 22090-22.IK	PSC 63	22	90	64	40	22 ..	10	622	622
PSC63 SI R/L 27105-22.IK	PSC 63	27	105	80	50	22 ..	10	624	624

Spare parts

Indexable insert

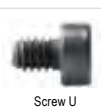
16 ..	rechts	EL 16 / IR 16	108	EL 16 / IR 16	129	234	T10	112	231
16 ..	links	ER 16 / IL 16	101	ER 16 / IL 16	121	234	T10	112	231
22 ..	links	ER 22 / IL 22	110	ER 22 / IL 22	137	235	T20	114	232
22 ..	rechts	EL 22 / IR 22	115	EL 22 / IR 22	145	235	T20	114	232



Multi-tooth shims



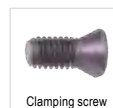
Shims



Screw U



Screwdriver



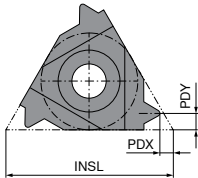
Clamping screw



→ You will find shims for approach angle correction here.

CoreLine – Right hand internal thread turning insert – Mini size 06

- ▲ Full profile
- ▲ Thread production from diameter 6 mm



CTPP525

CTPX525

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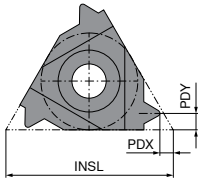
Designation	TP mm	PDX mm	PDY mm	INSL mm	IR	
					TR	TR
06 IR 0,5	0.50	0.9	0.5	6	71 224 ...	71 271 ...
06 IR 0,75	0.75	0.8	0.5	6	35700	110
06 IR 1,0	1.00	0.7	0.6	6	36100	112
06 IR 1,25	1.25	0.6	0.6	6	36500	114
					36700	116
P					●	●
M					○	○
K						●
N						●
S						
H						
O						



→ Find the cutting data standard values here.

CoreLine – Right hand internal thread turning insert – Mini size 06

- ▲ Full profile
- ▲ Thread production from diameter 6 mm



CTPP525

CTPX525

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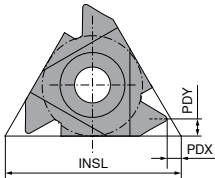
Designation	TPI 1/"	PDX mm	PDY mm	INSL mm	IR	
					TR	TR
06 IR 26	26	0.7	0.6	6	71 230 ...	71 230 ...
06 IR 22	22	0.6	0.6	6	33500	13500
06 IR 20	20	0.6	0.7	6	33100	13100
06 IR 18	18	0.6	0.7	6	32900	12900
					32500	12500
P					●	●
M					○	○
K						●
N						●
S						
H						
O						



→ Find the cutting data standard values here.

CoreLine – Right hand internal thread turning insert – Mini size 06

- ▲ Partial profile
- ▲ Thread production from diameter 6 mm

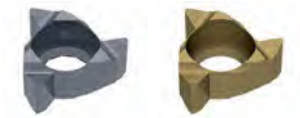


CTPP525

CTPX525

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DRAGONSKIN



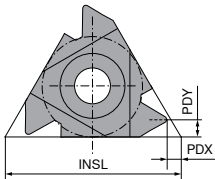
Designation	TP mm	INSL mm	PDX mm	PDY mm	IR TR	IR TR
06 IR A60	0,5 - 1,25	6	0.6	0.6	71 272 ... 30000	71 274 ... 210
P					●	●
M					○	○
K						●
N						●
S						
H						
O						



→ Find the cutting data standard values here.

CoreLine – Right hand internal thread turning insert – Mini size 06

- ▲ Partial profile
- ▲ Thread production from diameter 6 mm



CTPP525

CTPX525

DRAGONSKIN

DRAGONSKIN



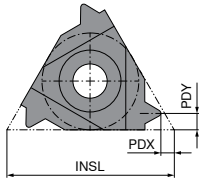
Designation	TPI 1/"	INSL mm	PDX mm	PDY mm	IR TR	IR TR
06 IR A55	48 - 20	6	0.5	0.6	71 272 ... 30100	71 272 ... 10100
P					●	●
M					○	○
K						●
N						●
S						
H						
O						



→ Find the cutting data standard values here.

CoreLine – Right hand internal thread turning insert – Mini size 08

- ▲ Full profile
- ▲ Thread production from diameter 8 mm



CTPP525

CTPX525

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Designation	TP mm	PDX mm	PDY mm	INSL mm
08 IR 0,5	0.50	0.6	0.5	8
08 IR 0,75	0.75	0.6	0.5	8
08 IR 1,0	1.00	0.6	0.6	8
08 IR 1,25	1.25	0.6	0.7	8
08 IR 1,5	1.50	0.6	0.7	8
08 IR 1,75	1.75	0.6	0.8	8
08 IN 2,0	2.00	0.9	4.0	8

IR TR	IR TR
71 224 ...	71 224 ...
34300	14300
33700	13700
33300	13300
33100	13100
32900	12900
32700	12700
32500 ¹⁾	12500 ¹⁾

P	●	●
M	○	○
K		●
N		●
S		
H		
O		

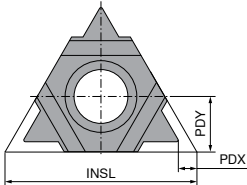
1) Neutral version (N)



→ Find the cutting data standard values here.

CoreLine – Neutral internal thread turning insert – Mini size 08

- ▲ Partial profile
- ▲ Thread production from diameter 8 mm



CTPP525

DRAGONSKIN

CTPX525

DRAGONSKIN



Designation	TP mm	INSL mm	PDX mm	PDY mm
08 IN M60	1,75 - 2,0	8	0.8	4

IN TR
71 273 ...
30800

IN TR
71 273 ...
10800

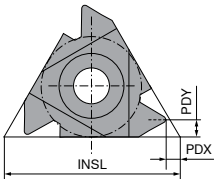
P	●	●
M	○	○
K		●
N		●
S		
H		
O		



→ Find the cutting data standard values here.

CoreLine – Right hand internal thread turning insert – Mini size 08

- ▲ Partial profile
- ▲ Thread production from diameter 8 mm



CTPP525

DRAGONSKIN

CTPX525

DRAGONSKIN



Designation	TP mm	PDX mm	PDY mm	INSL mm
08 IR A60	0,5 - 1,5	0.6	0.7	8

IR TR
71 272 ...
30600

IR TR
71 272 ...
10600

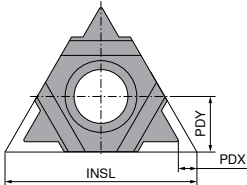
P	●	●
M	○	○
K		●
N		●
S		
H		
O		



→ Find the cutting data standard values here.

CoreLine – Neutral internal thread turning insert – Mini size 08

- ▲ Partial profile
- ▲ Thread production from diameter 8 mm



CTPP525

DRAGONSKIN

CTPX525

DRAGONSKIN



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
08 IN M55	14 - 11	8	0.9	4

IN TR
71 273 ...
30900

IN TR
71 273 ...
10900

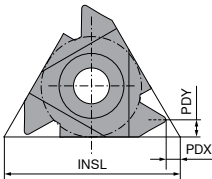
P	●	●
M	○	○
K		●
N		●
S		
H		
O		



→ Find the cutting data standard values here.

CoreLine – Right hand internal thread turning insert – Mini size 08

- ▲ Partial profile
- ▲ Thread production from diameter 8 mm



CTPP525

DRAGONSKIN

CTPX525

DRAGONSKIN



Designation	TPI 1/"	INSL mm	PDX mm	PDY mm
08 IR A55	48 - 16	8	0.6	0.7

IR TR
71 272 ...
30700

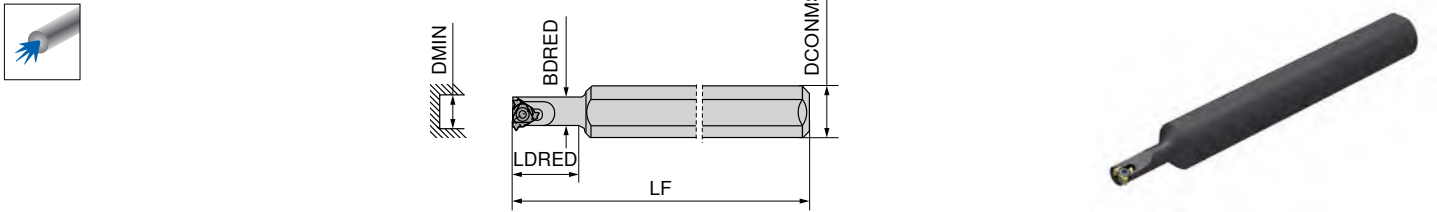
IR TR
71 272 ...
10700

P	●	●
M	○	○
K		●
N		●
S		
H		
O		



→ Find the cutting data standard values here.

CoreLine – Right internal threading holder – Mini size 06



Designation	LF mm	LDRED mm	DCONMS mm	BDRED mm	DMIN mm	Indexable insert	Tightening torque Nm
SI R 0005 H06	100	12	12	5.1	6	06 ..	0,6
SI R 0005 H06 C	100	26	6	5.1	6	06 ..	0,6

Right

TO
71 282 ...
00500
10500 ¹⁾

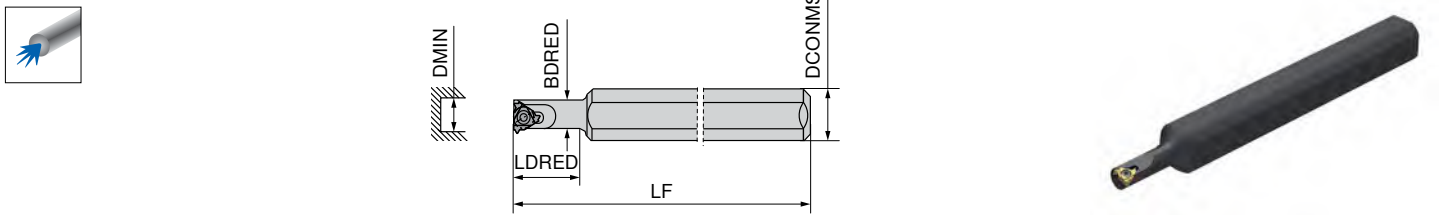
1) Solid carbide shank with through coolant

Spare parts
for article number

71 282 00500	T06
71 282 10500	T06

	
Screwdriver	Clamping screw
AS	AS
80 950 ...	71 950 ...
108	23800
108	23800

CoreLine – Right internal threading holder – Mini size 08



Designation	LF mm	LDRED mm	DCONMS mm	BDRED mm	DMIN mm	Indexable insert	Tightening torque Nm
SI R 0007 K08	125	18	16	6.6	7.8	08 ..	0,6
SI R 0008 K08U	125	21	16	7.3	9.0	08 .N	0,6
SI R 0007 K08CB	125	31	8	6.6	7.8	08 ..	0,6

Right
TO
71 282 ...
00700
00800 ¹⁾
10700 ²⁾

- 1) Neutral indexable insert marked (N) is required
- 2) Solid carbide shank with through coolant

Spare parts
for article number

71 282 00700	T06	108	23900
71 282 00800	T06	108	23900
71 282 10700	T06	108	23900



Screwdriver

AS

80 950 ...



Clamping screw

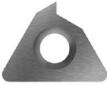
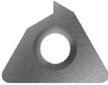
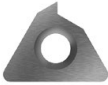
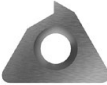
AS

71 950 ...

Shims for standard threading inserts

▲ Use the formula on **page** → 80 to calculate the required correction angle α ($\pm$).

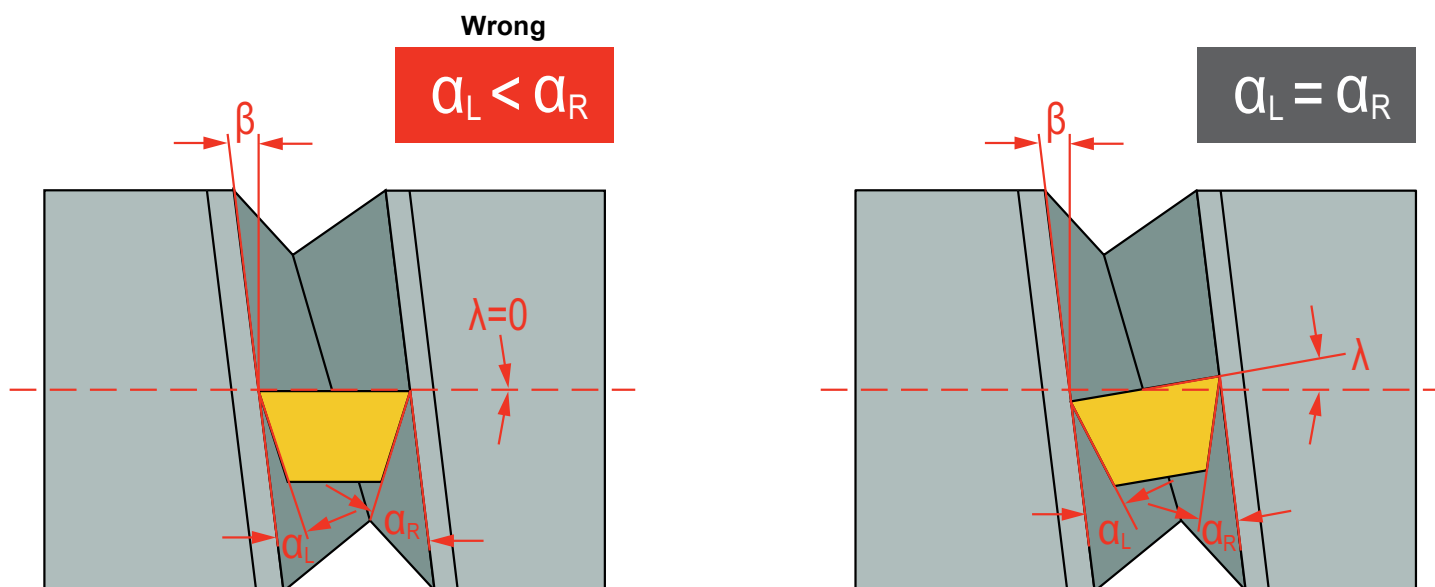
▲ Then find the corresponding correction plate below.

																	
		AE 16 ER 16 / IL 16		AI 16 EL 16 / IR 16		AE 22 ER 22 / IL 22		AI 22 EL 22 / IR 22		AE 22 U ER 22 / IL 22		AI 22 U EL 22 / IR 22		AE 16 M ER 16 / IL 16		AI 16 M EL 16 / IR 16	
		AS		AS		AS		AS		AS		AS		AS		AS	
Approach angle β	Correction angle α	71 950 ...		71 950 ...		71 950 ...		71 950 ...		71 950 ...		71 950 ...		71 950 ...		71 950 ...	
+ 4,5°	+ 3°	118		126		134		142		150 ¹⁾		158 ¹⁾		101		108	
+ 3,5°	+ 2°	119		127		135		143		151 ¹⁾		159 ¹⁾					
+ 2,5°	+ 1°	120		128		136		144		152 ¹⁾		160 ¹⁾					
+ 1,5°	0°	121		129		137		145		153 ¹⁾		161 ¹⁾					
+ 0,5°	- 1°	122		130		138		146		154 ¹⁾		162 ¹⁾					
0°	- 1,5°	123		131		139		147									
- 0,5°	- 2°	124		132		140		148		156 ¹⁾		164 ¹⁾					
- 1,5°	- 3°	125		133		141		149		157 ¹⁾		165 ¹⁾					

1) Neutral version for tool holder marked (U).

Flank clearance angle and effective approach angle

The angle of inclination λ of the cutting edges, in concert with the thread approach angle β ensures an equal rake angle and side clearance angle on both thread flanks.



α = Side clearance angle

λ = Approach angle

β = An effective angle of inclination is achieved by using a suitable insert seat

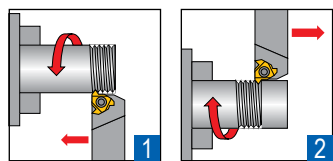
	Material sub-group	Index	Composition / Structure / Heat treatment	Hardness HB / HRC Tensile strength at rupture (Rm) lbf/in ²	Material number Material designation		Material number Material designation	
P	Unalloyed steel	P.1.1	< 0.15 % C, annealed	60900 lbf/in ² / 125 HB	1.0401	1015	1.0301	1010
		P.1.2	< 0.45 % C, annealed	92800 lbf/in ² / 190 HB	1.1191	1045	1.0737	12L14
		P.1.3	< 0.45 % C, tempered	121800 lbf/in ² / 250 HB	1.1191	1045	1.0503	1043
		P.1.4	< 0.75 % C, annealed	132000 lbf/in ² / 270 HB	1.1223	1060	1.0535	1055
		P.1.5	< 0.75 % C, tempered	146500 lbf/in ² / 300 HB	1.1223	1060	1.1274	1095
	Low-alloy steel	P.2.1	Annealed	88500 lbf/in ² / 180 HB	1.7131	5115	1.6523	8620
		P.2.2	Tempered	134900 lbf/in ² / 275 HB	1.7131	5115	1.6582	4340
		P.2.3	Tempered	146500 lbf/in ² / 300 HB	1.7225	4142	1.7131	5115
		P.2.4	Tempered	174000 lbf/in ² / 375 HB	1.7225	4142	17223	4140
	High-alloy steel and high-alloy tool steel	P.3.1	Annealed	98600 lbf/in ² / 200 HB	1.4021	420	1.2379	D2
		P.3.2	Hardened and tempered	159500 lbf/in ² / 300 HB	1.2343	H11	1.3343	M2
		P.3.3	Hardened and tempered	188500 lbf/in ² / 400 HB	1.2343	H11	1.2363	A2
	Stainless steel	P.4.1	Ferritic / martensitic, annealed	98600 lbf/in ² / 200 HB	1.4016	430	1.4125	440C
		P.4.2	Martensitic, tempered	117500 lbf/in ² / 300 HB	1.4112	S44003	1.4021	420
M	Stainless steel	M.1.1	Austenitic / austenitic-ferritic, quenched	88500 lbf/in ² / 180 HB	1.4301	304	1.4401	316
		M.2.1	Austenitic, tempered	300 HB	1.4841	314	1.4568	17-7 PH
		M.3.1	Austenitic / ferritic (Duplex)	113100 lbf/in ² / 230 HB	1.4462	S32205	1.4410	S32750
K	Grey cast iron	K.1.1	Pearlitic / ferritic	88500 lbf/in ² / 180 HB	0.6010	A48-20B	0.6025	A48-40 B
		K.1.2	Pearlitic (martensitic)	127600 lbf/in ² / 260 HB	0.6030	A48-45B	0.6040	A48-60 B
	Spherulitic graphite cast iron	K.2.1	Ferritic	78300 lbf/in ² / 160 HB	0.7040	60-40-18	0.7050	65-45-12
		K.2.2	Pearlitic	122600 lbf/in ² / 250 HB	0.7070	100-70-03	0.7660	A439 Type D2
	Malleable iron	K.3.1	Ferritic	63800 lbf/in ² / 130 HB	0.8035	GTW-35-04		
		K.3.2	Pearlitic	113100 lbf/in ² / 230 HB	0.8170	70003		
N	Aluminium wrought alloy	N.1.1	Non-hardenable	60 HB	3.0255	A91060	3.0255	A91060
		N.1.2	Hardenable, age-hardened	49300 lbf/in ² / 100 HB	3.1355	2024	3.1355	2024
	Cast aluminium alloy	N.2.1	≤ 12 % Si, non-hardenable	36300 lbf/in ² / 75 HB	3.2581	A04130 / A413-0	3.2581	A04130 / A413-0
		N.2.2	≤ 12 % Si, hardenable, age-hardened	43500 lbf/in ² / 90 HB	3.2134	G-AISi5Cu1Mg		
		N.2.3	> 12 % Si, non-hardenable	63800 lbf/in ² / 130 HB		G-AISi17Cu4Mg		
	Copper and copper alloys (bronze/brass)	N.3.1	Free-machining alloys, Pb > 1 %	54400 lbf/in ² / 110 HB	2.0380	CuZn39Pb2 (Ms58)	2.0380	C37700
		N.3.2	CuZn, CuSnZn	43500 lbf/in ² / 90 HB	2.0331	CuZn15	2.0331	C34000
		N.3.3	CuSn, lead-free copper and electrolytic copper	49300 lbf/in ² / 100 HB	2.0060	E-Cu57		
	Magnesium alloys	N.4.1	Magnesium and magnesium alloys	70 HB	3.5612	MgAl6Zn		
S	Heat-resistant alloys	S.1.1	Fe basis, annealed	98600 lbf/in ² / 200 HB	1.4864	X12NiCrSi 36-16	1.4864	330
		S.1.2	Fe basis, age-hardened	137800 lbf/in ² / 280 HB	1.4980	X6NiCrTiMoVB25-15-2	1.4980	S66286
		S.2.1	Ni or Co basis, annealed	121800 lbf/in ² / 250 HB	2.4856	Inconel 625	2.4812	Hastelloy C
		S.2.2	Ni or Co basis, age-hardened	171100 lbf/in ² / 350 HB	2.4952	Nimonic 80A	2.4668	Inconel 718
		S.2.3	Ni or Co basis, cast	156600 lbf/in ² / 320 HB	2.4674	Nimocast PK24	2.4670	Nimocast 713
	Titanium alloys	S.3.1	Pure titanium	5800 lbf/in ²	3.7025	Ti99,8		
		S.3.2	Alpha + beta alloys, age-hardened	152300 lbf/in ² / 320 HB	3.7165	TiAl6V4		
		S.3.3	Beta alloys	203100 lbf/in ² / 410 HB	Ti555.3	Ti-5Al-5V-5Mo-3Cr		
H	Hardened steel	H.1.1	Hardened and tempered	46–55 HRC				
		H.1.2	Hardened and tempered	56–60 HRC				
		H.1.3	Hardened and tempered	61–65 HRC				
		H.1.4	Hardened and tempered	66–70 HRC				
	Chilled iron	H.2.1	Cast	400 HB				
	Hardened cast iron	H.3.1	Hardened and tempered	55 HRC				
O	Non-metal materials	O.1.1	Plastics, duroplastic	≤ 21800 lbf/in ²	EP, MF, PF, UP			
		O.1.2	Plastics, thermoplastic	≤ 14500 lbf/in ²	PA, PC, PE, PI, PMMA, POM, PP, PS, PTFE, PVC			
		O.2.1	Aramid fibre-reinforced	≤ 145000 lbf/in ²	AFK			
		O.2.2	Glass/carbon-fibre reinforced	≤ 145000 lbf/in ²	CFRP, GFRP			
		O.3.1	Graphite					

Cutting data standard values

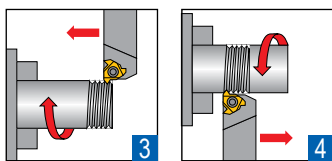
Index	CTPP525			CTPM520			CTPX525			CTWN520			CTPP525			CTPX525		
													Mini			Mini		
							v _c (m/min)											
	min. – Recommended – max.			min. – Recommended – max.			min. – Recommended – max.			min. – Recommended – max.			min. – Recommended – max.			min. – Recommended – max.		
P.1.1	120	160	180	120	180	210	100	130	180				120	150	180	70	110	150
P.1.2	120	160	180	120	180	210	100	130	180				120	150	180	70	110	150
P.1.3	120	160	180	120	180	210	100	130	180				120	150	180	70	110	150
P.1.4	120	160	180	120	180	210	100	130	180				120	150	180	70	110	150
P.1.5	120	160	180	120	180	210	100	130	180				120	150	180	70	110	150
P.2.1	80	110	130	90	120	140	70	90	120				80	100	130	60	70	90
P.2.2	80	110	130	90	120	140	70	90	120				80	100	130	60	70	90
P.2.3	80	110	130	90	120	140	70	90	120				80	100	130	60	70	90
P.2.4	80	110	130	90	120	140	70	90	120				80	100	130	60	70	90
P.3.1	60	70	80	70	80	90	55	60	70				60	70	80	50	55	60
P.3.2	60	70	80	70	80	90	55	60	70				60	70	80	50	55	60
P.3.3	60	70	80	70	80	90	55	60	70				60	70	80	50	55	60
P.4.1	60	70	80	70	80	90	55	60	70				60	70	80	50	55	60
P.4.2	60	70	80	70	80	90	55	60	70				60	70	80	50	55	60
M.1.1	90	110	130	110	140	160	60	70	90				90	100	130	50	60	80
M.2.1	90	110	130	110	140	160	60	70	90				90	100	130	50	60	80
M.3.1	90	110	130	110	140	160	60	70	90				90	100	130	50	60	80
K.1.1	100	120	130	120	140	150	80	90	110							60	70	90
K.1.2	100	120	130	120	140	150	80	90	110							60	70	90
K.2.1	120	120	130	140	145	150	90	95	100							65	70	85
K.2.2	120	120	130	140	145	150	90	95	100							65	70	85
K.3.1	100	120	130	110	130	140	80	90	100							60	70	85
K.3.2	100	120	130	110	130	140	80	90	100							60	70	85
N.1.1				250	380	500	200	290	400	200	280	400				150	270	400
N.1.2				250	380	500	200	290	400	200	280	400				150	270	400
N.2.1				280	400	500	200	330	500	200	300	500				150	270	400
N.2.2				280	400	500	200	330	500	200	300	500				150	270	400
N.2.3				280	400	500	200	330	500	200	300	500				150	240	350
N.3.1				280	400	500	200	330	500	200	300	500				150	240	350
N.3.2				190	280	350	150	190	250	150	180	250				110	140	180
N.3.3				190	280	350	150	190	250	150	180	250				110	140	180
N.4.1				190	280	350	150	190	250	150	180	250				110	140	180
S.1.1	25	45	60	30	50	65	25	40	60									
S.1.2	25	45	60	30	50	65	25	40	60									
S.2.1	25	45	60	30	50	65	25	40	60									
S.2.2	25	45	60	30	50	65	25	40	60									
S.2.3	25	45	60	30	50	65	25	40	60									
S.3.1	35	40	45	40	45	50	35	35	45	35	40	45						
S.3.2	35	40	45	40	45	50	35	35	45	35	40	45						
S.3.3	35	40	45	40	45	50	35	35	45	35	40	45						
H.1.1	35	40	45	40	45	50												
H.1.2	35	40	45	40	45	50												
H.1.3	35	40	45	40	45	50												
H.1.4																		
H.2.1	25	30	35	30	35	40												
H.3.1	15	20	25	20	25	30												
O.1.1				20	40	50												
O.1.2				20	40	50												
O.2.1				30	50	70												
O.2.2				20	40	60												
O.3.1				20	40	60												

Thread turning methods

External right-hand thread

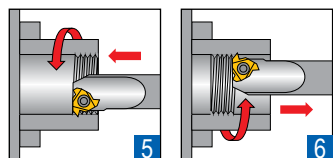


External left-hand thread

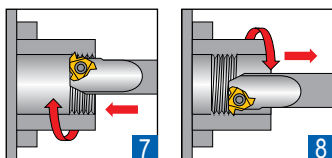


The machining examples 2, 4, 6, and 8 require negative shims.

Internal right-hand thread

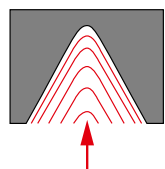


Internal left-hand thread



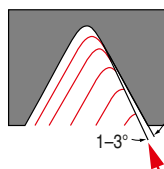
Thread infeed methods

Radial infeed



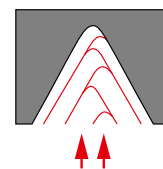
- ▲ For pitches less than 1.5 mm
- ▲ For short-chipping materials
- ▲ For machining hardened materials
- ▲ Quick and simple infeed method

Flank infeed



- ▲ For pitches greater than 1.5 mm
- ▲ With radial infeed, the effective cutting edge length is too long, which can lead to chatter
- ▲ With TRAPEZ and ACME, machining on three flanks is disadvantageous for chip flow

Alternating infeed



- ▲ For larger pitches
- ▲ For long-chipping materials
- ▲ Uniform wear of the cutting edges
- ▲ Complicated programming process required

Approach angle

Important information about standard shims

- ▲ The approach angle should always be determined by means of a calculation or using the diagram below.
- ▲ The threaded tool holders have a 1.5° inclined insert seat and a shim without angle correction. This means that the tool holders have an approach angle β of 1.5° when delivered.



Without the appropriate approach angle correction, the following may occur:

- ▲ The profile may become distorted.
- ▲ The indexable insert sits on top – the clearance angle is insufficient.
- ▲ The tool life of the insert is greatly reduced.

Method 1: Calculation

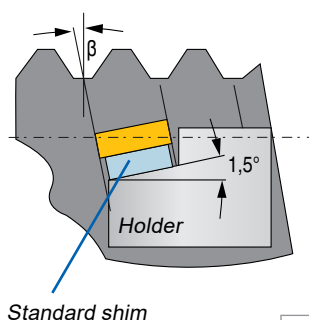
Calculation of the approach angle β :

$$\beta = \frac{20 \times TP}{DMIN}$$

20 = constant
 β = approach angle (°)
 TP = pitch (mm)
 DMIN = nominal diameter (mm)

For trapezium:

$$\frac{15 \times TP}{DMIN}$$



Example calculation

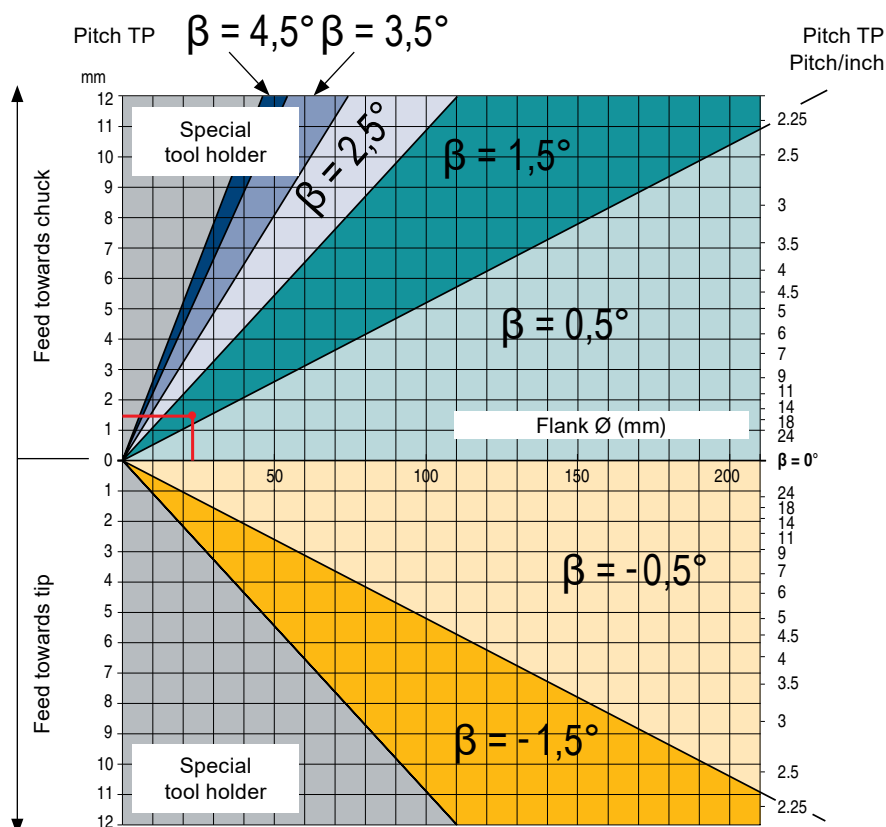
External thread M24 x 1.5
 Feed towards chuck
 DMIN = nominal Ø: M24 = 24 mm
 TP = pitch: 1.5 mm

$$\beta = \frac{20 \times 1,5 \text{ mm}}{24 \text{ mm}}$$

$$\beta = 1,25^\circ$$

Method 2: Diagram

A line is drawn vertically upward from the flank diameter in the diagram until it intersects with the line representing the pitch of the thread to be produced. In the color-coded region where you are currently located, the corresponding factor is displayed at the edge of the diagram.



Calculated approach angle β value	Correction angle α
0,0°–0,49°	-1,5°
0,5°–0,99°	-1°
1,0°–1,99°	0°
2,0°–2,99°	+1°
3,0°–3,99°	+2°
4,0°–4,99°	+3°
0,0°–(-0,49°)	-2°
-0,5°–(-1,5°)	-3°

Designation key – indexable inserts

Example

16ER-M.1,50.ISO-P CTPM520

16	E	R	-M	1,50	ISO	-P		CTPM520
Insert size	Insert	Cutting design	Tolerance	Pitch (TP/TPI)	Thread profile	Chip breaker	Number of teeth (NT)	Cutting material grades
L IC	E External	R Right	G Ground	Full profile	ISO Metric / metric fine		2M Multi-tooth insert with 2 teeth	
06 5/32"	I Internal	L Left	M Directly pressed	0,35-6,0 mm	W Whitworth / BSW, BSP, ...			
08 3/16"		N Neutral		1,50 = 1,5 mm	BSPT Whitworth BSPT		3M Multi-tooth insert with 3 teeth	
11 1/4"				Partial profile	UN American Unified Thread			
16 3/8"				mm G/Z	NPT American Pipe Thread			
22 1/2"				A 0,5-1,5 48-16	TR Trapezoidal thread			
				AG 0,5-3,0 48-8	RD Round thread			
				M 1,7-2,0 14-11	PG Conduit thread			
				G 1,75-3,0 14-8				
				N 3,5-5,0 7-5				
				U 5,5-8,0 4,5-3,5				
				Flank angle				
				55°				
				60°				

Designation key – cutting material grades

C

T

P

M

5

2

0

(Example)

CT

CERATZIT

Insert size

W Carbide, uncoated

C CVD-coated carbide

P PVD-coated carbide

T Cermet, uncoated

E Cermet, coated

N Silicon nitride, uncoated

M Silicon nitride, coated

S Mixed ceramic

K Whisker ceramic

I SiAlON

D PCD

B PcBN

H HSS sintered

Main application - material

P Steel

M Stainless steel

K Cast iron

N Non-ferrous metals

S Heat-resistant

H Hardened steel

O Non-metal materials

X Universal application

Process

1 Turning

2 Milling

3 Grooving

4 Drilling

5 Thread turning

6 Other

7 Several processes

Degree of hardness

05 ISO 05

10 ISO 10

15 ISO 15

20 ISO 20

25 ISO 25

30 ISO 30

35 ISO 35

40 ISO 40

○

↑

↓

□

Designation key – holders

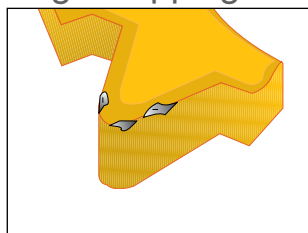
Example

SE R 1212 F 16
right external holder with 12 x 12 mm square shank,
overall length of 80 mm, only suitable for a size 16 threading insert

SE		R	1212		F	16					
Holder		Cutting design		Shank cross-section		Overall length		Insert size		Characteristics	
SE	External	R	Right	Example		mm		L	IC	B	with thru coolant
SI	Internal	L	Left	External holder	1212 = 12 mm x 12mm	F	80	06	5/32"	C	with carbide shank
				square shank		H	100	08	3/16"	U	Neutral holder
				Internal boring bar	0020 = 20 mm	K	125	11	1/4"		
				Diameter		L	140	16	3/8"		
						M	150	22	1/2"		
						P	170				
						R	200				
						S	250				
						T	300				

Troubleshooting

Edge chipping



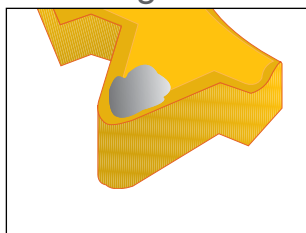
Causes

- ▲ Frequently occurs with stainless workpiece materials
- ▲ Incorrect carbide grade

Corrective measures

- ▲ Avoid tool overhang
- ▲ Check whether the threading insert is correctly clamped
- ▲ Avoid vibrations
- ▲ Use a tougher carbide quality

Cratering



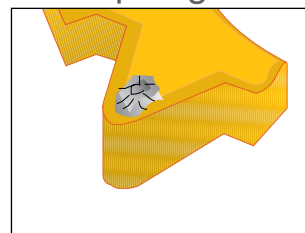
Causes

- ▲ Frequently occurs with stainless workpiece materials
- ▲ Cutting speed too high
- ▲ Incorrect carbide grade

Corrective measures

- ▲ Apply coolant
- ▲ Reduce cutting depth
- ▲ Use a harder carbide quality

Built-up edge



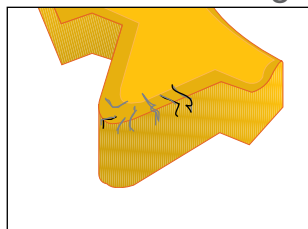
Causes

- ▲ Cutting speed too low
- ▲ Incorrect carbide grade

Corrective measures

- ▲ Apply coolant
- ▲ Increase cutting speed
- ▲ Use a tougher carbide quality

Thermal cracking



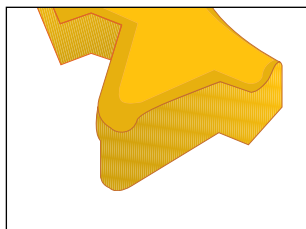
Causes

- ▲ Insufficient coolant
- ▲ Cutting speed too high
- ▲ Incorrect carbide grade

Corrective measures

- ▲ Apply coolant
- ▲ Keep cutting speed to a minimum
- ▲ Use a tougher carbide quality

Deformation



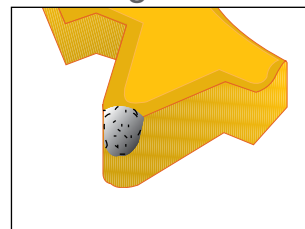
Causes

- ▲ Infeed too great
- ▲ Insufficient coolant
- ▲ Cutting speed too high
- ▲ Incorrect carbide grade

Corrective measures

- ▲ Apply coolant
- ▲ Reduce cutting depth
- ▲ Keep cutting speed to a minimum
- ▲ Use a harder carbide quality

Breakage



Causes

- ▲ Infeed too great
- ▲ Insufficient coolant
- ▲ Plastic deformation
- ▲ Unstable
- ▲ Incorrect approach angle
- ▲ Incorrect carbide grade

Corrective measures

- ▲ Reduce cutting depth
- ▲ Check machine and tool stability
- ▲ Reduce cutting speed
- ▲ Observe the approach angle
- ▲ Use a tougher carbide quality

Grade description

Steel

CTPP525

- ▲ Carbide PVD TiAlN-coated
- ▲ ISO | **P25** | M15 | **K25** | **S20** | H25
- ▲ PVD-coated carbide grade for the machining of general steels and cast iron materials at medium to high cutting speeds

Stainless steel

CTPM520

- ▲ Carbide PVD TiAlN-coated
- ▲ ISO | P25 | **M20** | K25 | N20 | S25
- ▲ PVD-coated carbide grade for the machining of stainless steels at medium to high cutting speeds

Non-ferrous metals

CTWN520

- ▲ Carbide, uncoated
- ▲ ISO | **N20** | S20
- ▲ Uncoated carbide grade for machining non-ferrous metals and, to a limited extent, heat-resistant alloys

Universal

CTPX525

- ▲ Carbide, PVD TiN-coated
- ▲ ISO | **P25** | M20 | **K25** | **N25** | S25
- ▲ Universal carbide grade for a wide variety of materials at low cutting speeds

Profile information

Full profile



- ▲ Core diameter does not have to be machined to the finished core diameter
- ▲ A minimum infeed of 0.07 mm is required
- ▲ Insert can only be used for one pitch

- Advantages:**
- ▲ High-quality thread
 - ▲ No burr formation
 - ▲ No rework
 - ▲ Longer downtime in some cases.

Partial profile



- ▲ Core diameter must be premachined to the finished size
- ▲ A minimum infeed of 0.07 mm is required

- Advantages:**
- ▲ One threading insert can be used to machine several pitches
 - ▲ Threading insert can be used for any application
 - ▲ Reduced stock requirements

Multi-tooth threading insert



- ▲ Core diameter does not have to be machined to the finished core diameter
- ▲ A minimum infeed of 0.07 mm is required
- ▲ Insert can only be used for one pitch

- Advantages:**
- ▲ Fewer passes required
 - ▲ Thread production in less time

Note: ▲ Check there is sufficient thread run-out

Mini threading insert



- ▲ From a min. core hole diameter of Ø 6 mm or Ø 8 mm

- Advantages:**
- ▲ Special cutting materials for low cutting speeds
 - ▲ Three cutting edges for miniature applications



Adaptors and Accessories



Contents

- Explanation of symbols
- Toolfinder – Machine interface
- Toolfinder – Adapters, rotating, maximum accuracy
- Toolfinder – Adapters, rotating, high accuracy
- Toolfinder – Adapters, rotating, medium accuracy
- Toolfinder – Adapters, stationary
- Toolfinder – Adapters, stationary, VDI adapters for star turrets
- Toolfinder – Adapters, stationary, VDI adapters for disc turrets
- Toolfinder – Adapters, stationary, General VDI adapters, VDI accessories
- Toolfinder – Adapters, stationary, BMT adapters
- Toolfinder – Accessories
- Toolfinder – Small Part Machining
- Product program
- Technical information
 - Driven tools
 - Modular quick-change systems for driven tools
 - Quick-Change
 - HSK/PSC clamping units
 - Technical data for steep taper tools
 - Technical data for HSK adapters
 - Technical information for polygon shank adapters
 - High pressure and hydraulic chucks
 - Clamping torque values (Md)
 - Static clamping torques
 - Technical information – ABS

Explanation of symbols

Version



Without coolant supply
Steep taper shape A



Central coolant supply
Steep taper shape AD



Coolant supply centrally or via the flange
Steep taper shape AD/B



Coolant supply centrally
with eroded coolant channels



Coolant supply centrally or via the flange
with eroded coolant channels



Coolant supply centrally
additional coolant holes



Coolant supply centrally or via the flange
additional coolant holes



Central coolant supply or via a coolant nozzle



Minimum quantity lubrication (MQL) is a lubricating process in manufacturing whereby very small quantities of lubricants are introduced into the machining area in a targeted manner.



Coolant supply



DC = DirectCooling



Direct damping

Tool types

Centro-P

PCC

ER precision collet chuck

Rough

The Rough high pressure chuck is a high-performance tool specially developed for milling. It is ideal for HSC und HPC applications and features high temperature resistance.

Complus

The Complus high pressure chuck is a versatile all-rounder whose short and stable design makes it most suited to both roughing and finishing applications.

Access 3°

The Access 3° high pressure chuck has an extremely slim design.

Access 4,5°

The Access 4.5° high pressure chuck has identical dimensions to a heat shrink adapter and is the ideal choice for drilling and reaming operations.

Fit

The Fit hydraulic chuck has a short and slim design and can be used for a wide range of applications.

Compact

The Compact hydraulic chuck is a versatile all-rounder whose short and stable design makes it most suited to both roughing and finishing applications.

DAH

The integrated compensation systems enable μ -precision run-out, allow run-out and axis errors to be corrected with ease, and are optimized for high speeds and through coolant supply for a long tool life.

TG

Specially matched heat shrink adapter for ThermoGrip® shrinking process.

NC 2010

Precision short drill chuck for maximum radial run-out accuracy.

ABS

The ABS interface is a modular coupling system delivering higher force transmission, lower noise generation, and a shorter overhang length for improved performance.

ABS N

The ABS-N interface is a variant with highly precise grooves that reliably withstand torques and cutting forces.

Collet description

ER 5 μ m

ER 10 μ m

ER-A 2 μ m

ER-A 10 μ m

ER-A 15 μ m

ER-B 2 μ m

ER-B 5 μ m

ER-B 20 μ m

Type version
Radial run-out accuracy



Warning



Page reference



Information

Toolfinder – Machine interface

CAT – Steep taper holders



- ▲ CAT 40 ▲ CAT-FC 40
- ▲ CAT 50 ▲ CAT-FC-50

Toolfinder – Adapters, rotating →

Product program →

ISO 7388-1 – SK steep taper holders



- ▲ SK 30 ▲ SK 50
- ▲ SK 40 ▲ SK-FC 50

Toolfinder – Adapters, rotating →

Product program →

ISO 7388-2 – MAS-BT steep taper shanks

MAS-BT/MAS-BT-FC with face contact



- ▲ BT 30 ▲ BT-FC 30
- ▲ BT 40 ▲ BT-FC 40
- ▲ BT 50 ▲ BT-FC 50

Toolfinder – Adapters, rotating →

MAS-BT product range →

MAS-BT-FC product range →

HSK hollow taper adapters with face contact

ISO 12164 – HSK-A / HSK-E



- ▲ HSK-A 40 ▲ HSK-E 25
- ▲ HSK-A 50 ▲ HSK-E 32
- ▲ HSK-A 63 ▲ HSK-E 40
- ▲ HSK-A 100 ▲ HSK-E 50

Toolfinder – Adapters, rotating →

HSK-A product range →

HSK-E product range →

ISO 12164-3 – HSK-T

- ▲ HSK-T 63
- ▲ HSK-T 100

Toolfinder – Adapters, stationary →

Product program →

ISO 26623-1 – PSC polygon hollow adapters with face contact

PSC, rotating



- ▲ PSC 32 ▲ PSC 63
- ▲ PSC 40 ▲ PSC 80
- ▲ PSC 50

Toolfinder – Adapters, rotating →

Product program →

PSC, stationary

- ▲ PSC 32 ▲ PSC 63
- ▲ PSC 40 ▲ PSC 80
- ▲ PSC 50 ▲ PSC 80X

Toolfinder – Adapters, stationary →

Product program →

ISO 10889 – VDI tool holders with cylindrical shank



- ▲ VDI 16 ▲ VDI 30
- ▲ VDI 20 ▲ VDI 40
- ▲ VDI 25 ▲ VDI 50

Toolfinder – Adapters, stationary →

Product program →

Driven tools →

BMT tool holders

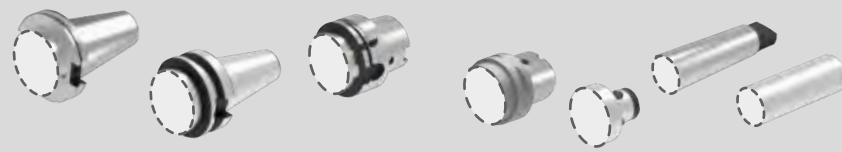


- ▲ Doosan/Spinner – BMT 45
- ▲ Doosan – BMT 55
- ▲ EMAG – BMT 55
- ▲ HAAS/Doosan – BMT 65
- ▲ Mori/Seiki – BMT 40
- ▲ Mori/Seiki – BMT 60
- ▲ Mazak – BMT 68

Toolfinder – Adapters, stationary – BMT tool holders →

Product program →

Toolfinder – Adapters, rotating

Adapter type	CAT	Steep taper adapter ASME B5.50									
	SK	Steep taper adapter ISO 7388-1									
	MAS-BT	Steep taper adapter ISO 7388-2									
	HSK	Adapter ISO 12164									
	PSC	Adapter ISO 26623-1									
	ABS	Adapter									
	MK	Morse taper									
	ZYL	Cylindrical shank									
				CAT	SK	BT	HSK-A	HSK-E	PSC	ABS	MK
			CAT-FC	SK-FC	BT-FC						

Maximum accuracy	ER precision collet chuck – Centro-P		SK	BT	HSK-A	HSK-E	PSC	ZYL
			→	→	→	→	→	→
				BT-FC				
				→				
	High pressure chuck		CAT	SK	BT	HSK-A	PSC	ABS
			→	→	→	→	→	→
					BT-FC			
					→			
	Hydraulic chuck		SK	BT	HSK-A			ZYL
			→	→	→			→
	Heat shrink adapter		SK	BT	HSK-A	HSK-E	PSC	ABS
			→	→	→	→	→	→
					BT-FC			
					→			
	Micro-precision collet chuck							ZYL
								→

Main application



Finishing



Roughing-finishing

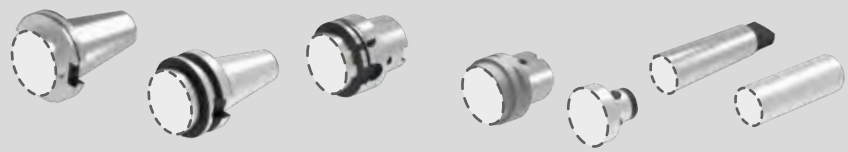


Roughing

Secondary application



Toolfinder – Adapters, rotating

Adapter type	CAT	Steep taper adapter ASME B5.50									
	SK	Steep taper adapter ISO 7388-1									
	MAS-BT	Steep taper adapter ISO 7388-2									
	HSK	Adapter ISO 12164									
	PSC	Adapter ISO 26623-1	CAT	SK	BT	HSK-A	HSK-E	PSC	ABS	MK	ZYL
	ABS	Adapter	CAT-FC	SK-FC	BT-FC						
	MK	Morse taper									
	ZYL	Cylindrical shank									

High accuracy	Cylindrical shank adapter Weldon 	<div>CAT</div> <div>→</div> <div>SK</div> <div>→</div> <div>BT</div> <div>→</div> <div>BT-FC</div> <div>→</div> <div>HSK-A</div> <div>→</div> <div>PSC</div> <div>→</div> <div>ABS</div> <div>→</div> <div>ZYL</div> <div>→</div>
	Cylindrical shank adapter Whistle Notch 	<div>SK</div> <div>→</div> <div>BT</div> <div>→</div> <div>HSK-A</div> <div>→</div> <div>PSC</div> <div>→</div> <div>ABS</div> <div>→</div>
	Indexable insert drill adapter 	<div>SK</div> <div>→</div> <div>BT</div> <div>→</div> <div>HSK-A</div> <div>→</div> <div>PSC</div> <div>→</div>
	ER precision collet chuck – PCC 	<div>SK</div> <div>→</div> <div>BT</div> <div>→</div> <div>HSK-A</div> <div>→</div>
	ER collet chuck 	<div>SK</div> <div>→</div> <div>BT</div> <div>→</div> <div>BT-FC</div> <div>→</div> <div>HSK-A</div> <div>→</div> <div>PSC</div> <div>→</div> <div>ABS</div> <div>→</div> <div>ZYL</div> <div>→</div>
	Short drill chuck 	<div>SK</div> <div>→</div> <div>BT</div> <div>→</div> <div>HSK-A</div> <div>→</div> <div>PSC</div> <div>→</div> <div>ABS</div> <div>→</div> <div>MK</div> <div>→</div> <div>ZYL</div> <div>→</div>
	Quick change tapping chuck with minimum length compensation 	<div>SK</div> <div>→</div> <div>BT</div> <div>→</div> <div>HSK-A</div> <div>→</div> <div>PSC</div> <div>→</div> <div>ABS</div> <div>→</div> <div>ZYL</div> <div>→</div>
	Quick change tapping chuck with length compensation 	<div>SK</div> <div>→</div> <div>BT</div> <div>→</div> <div>HSK-A</div> <div>→</div> <div>PSC</div> <div>→</div> <div>ABS</div> <div>→</div> <div>MK</div> <div>→</div> <div>ZYL</div> <div>→</div>
	ABS adapters 	<div>CAT</div> <div>→</div> <div>SK</div> <div>→</div> <div>BT</div> <div>→</div> <div>HSK-A</div> <div>→</div> <div>PSC</div> <div>→</div> <div>ABS</div> <div>→</div> <div>ZYL</div> <div>→</div> <div>CAT-FC</div> <div>→</div> <div>SK-FC</div> <div>→</div> <div>BT-FC</div> <div>→</div>
	DAH compensation holder 	<div>CAT</div> <div>→</div> <div>SK</div> <div>→</div> <div>BT</div> <div>→</div> <div>HSK-A</div> <div>→</div> <div>ABS</div> <div>→</div>

Main application



Finishing



Roughing-finishing

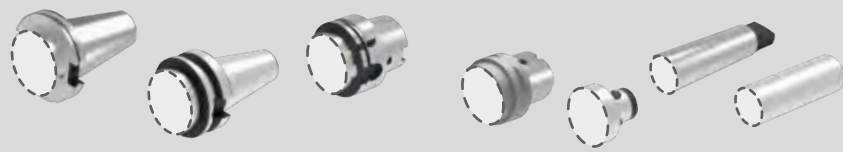


Roughing

Secondary application



Toolfinder – Adapters, rotating

Adapter type	CAT	Steep taper adapter ASME B5.50									
	SK	Steep taper adapter ISO 7388-1									
	MAS-BT	Steep taper adapter ISO 7388-2									
	HSK	Adapter ISO 12164									
	PSC	Adapter ISO 26623-1	CAT	SK	BT	HSK-A	HSK-E	PSC	ABS	MK	ZYL
	ABS	Adapter									
	MK	Morse taper									
	ZYL	Cylindrical shank									

Medium accuracy	Adapter for screw-in cutter		<div>SK</div> <div>→</div>	<div>BT</div> <div>→</div>	<div>HSK-A</div> <div>→</div>	<div>PSC</div> <div>→</div>	<div>ZYL</div> <div>→</div>
	Combination shell mill adapter		<div>SK</div> <div>→</div>	<div>BT</div> <div>→</div>	<div>HSK-A</div> <div>→</div>	<div>ABS</div> <div>→</div>	
	Shell mill adapter		<div>CAT</div> <div>→</div>	<div>SK</div> <div>→</div>	<div>BT</div> <div>→</div>	<div>HSK-A</div> <div>→</div>	<div>PSC</div> <div>→</div> <div>ABS</div> <div>→</div>
	Large diameter shell mill adapter		<div>SK</div> <div>→</div>	<div>BT</div> <div>→</div>			
	Drill chuck adapter						<div>MK</div> <div>→</div>
	Taper adapter for Morse taper		<div>SK</div> <div>→</div>	<div>BT</div> <div>→</div>	<div>HSK-A</div> <div>→</div>	<div>PSC</div> <div>→</div>	<div>MK</div> <div>→</div>
	Milling adapter sleeve		<div>SK</div> <div>→</div>	<div>BT</div> <div>→</div>			
	Extension/reduction				<div>HSK-A</div> <div>→</div>		<div>ABS</div> <div>→</div> <div>ABS</div> <div>→</div>
	Blank		<div>SK</div> <div>→</div>	<div>BT</div> <div>→</div>	<div>HSK-A</div> <div>→</div>	<div>PSC</div> <div>→</div>	<div>ABS</div> <div>→</div>
	Test arbor		<div>SK</div> <div>→</div>	<div>BT</div> <div>→</div>	<div>HSK-A</div> <div>→</div>	<div>PSC</div> <div>→</div>	

Main application



Finishing



Roughing-finishing



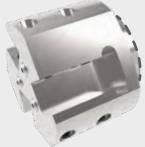
Roughing

Secondary application



Toolfinder – Adapters, stationary

Adapter type	HSK	Adapter ISO 12164		
	PSC	Adapter ISO 26623-1		
			HSK-T	PSC

Square shank holder 0°			→	→
Square shank holder 45°			→	→
Square shank holder 90°			→	→
Square shank holder 3 face 0°			→	
Boring bar holder			→	→
Adapter			→	
Blank			→	
Parting blade holder 0°			→	→
Parting blade holder 90°			→	→

Accessories

Sealing plug		→
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Toolfinder – Adapters, stationary

There is a wide range of monoblock tools and modular systems available that are compatible with the adapters.

Thread turning tools

→ Thread turning tools



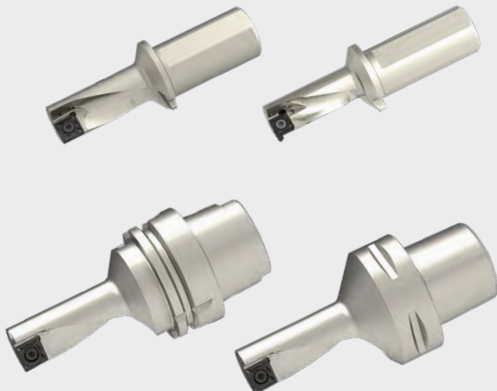
Tool holders and boring bars

→ Indexable insert turning tools



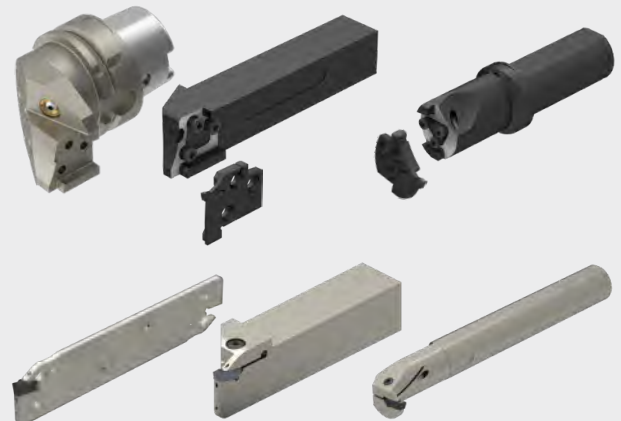
EcoCut – multi-purpose tools

→ Multi-function tools



Grooving tools

→ Grooving tools

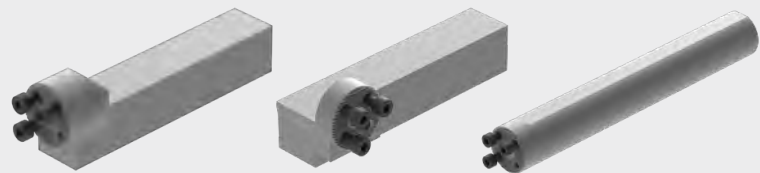


MaxiChange – exchangeable head system

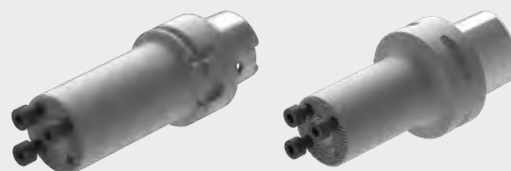
→ Indexable insert turning tools



→ Indexable insert turning tools

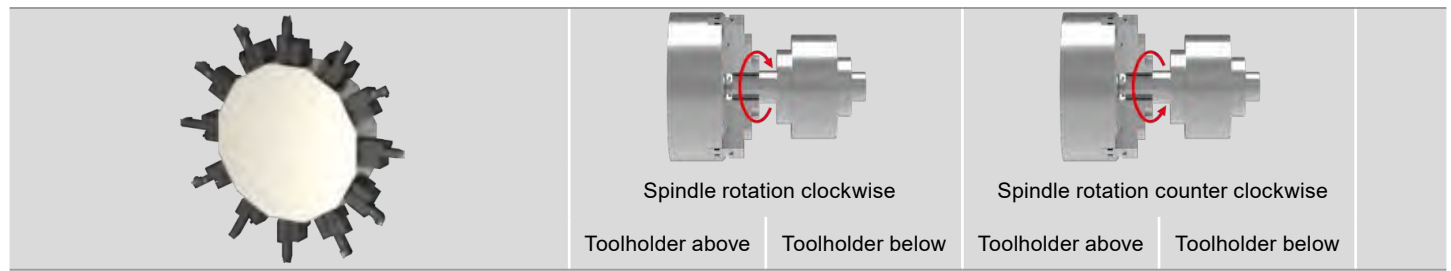


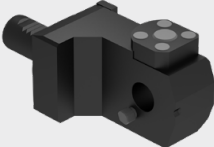
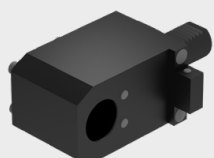
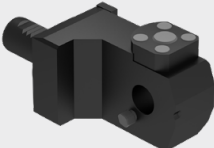
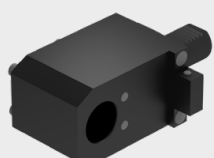
→ Grooving tools



Toolfinder – Adapters, stationary

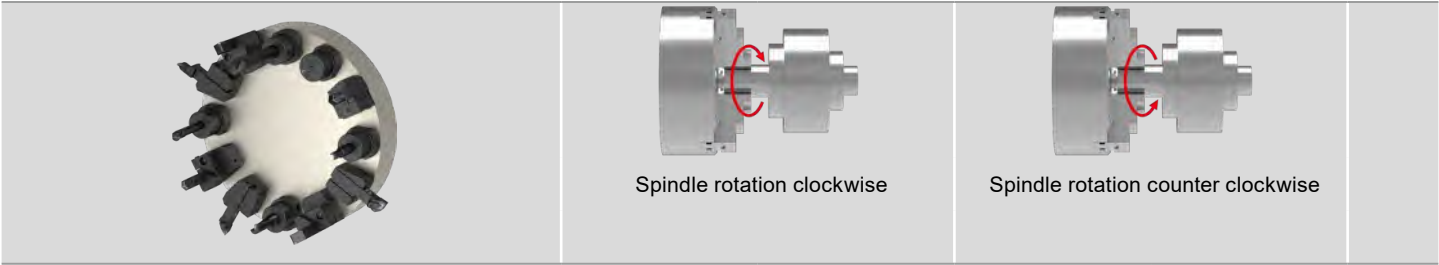
VDI adapters for star turrets

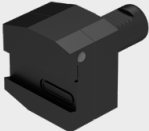
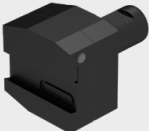


Upper turret	Square shank holders			B2 / B3 / B6 / B7 / C1 / C2 / D1 / D2	B2 / B3 / B6 / B7 / C3 / C4 / D1 / D2	B2 / B3 / B6 / B7 / C3 / C4 / D1 / D2	B2 / B3 / B6 / B7 / C1 / C2 / D1 / D2	→
	Parting blade holders			Double	Double	Double – overhead	Double – overhead	→
	VDI to VDI adapter			Left	Right	Left	Right	→
	Boring bar holder			Left	Right	Left	Right	→
Lower turret	Square shank holders			B2 / B3 / B6 / B7 / C3 / C4 / D1 / D2	B2 / B3 / B6 / B7 / C1 / C2 / D1 / D2	B2 / B3 / B6 / B7 / C1 / C2 / D1 / D2	B2 / B3 / B6 / B7 / C3 / C4 / D1 / D2	→
	Parting blade holders			Double – overhead	Double – overhead	Double	Double	→
	VDI to VDI adapter			Right	Left	Right	Left	→
	Boring bar holder			Right	Left	Right	Left	→

Toolfinder – Adapters, stationary

VDI adapters for disc turrets



Lower turret	Square shank holders	 	B1 / B5 / C1 / C2 / D1	B3 / B7 / C3 / C4 / D2	→
	Parting blade holders	 	Right	Overhead right	→
Upper turret	Square shank holders	 	B4 / B8 / C3 / C4 / D2	B2 / B6 / C1 / C2 / D1	→
	Parting blade holders	 	Overhead left	Left	→

Toolfinder – Adapters, stationary

General VDI adapters

Cylindrical tool holders E / E1 / E2 / E3 / E4		→
Tool holder for indexable insert drills		→
Boring bar holder		→
Morse taper adapter F1		→
Hydraulic chuck		→
ER collet chuck		→
Short drill chuck NC 2010		→
Quick change tapping chuck		→
90° VDI to OC50 adapter		→
VDI to OC50 adapter IL		→
VDI to OC50 adapter IN		→
Base holder with cylindrical shank		→
VDI to PSC adapter		→
VDI to HSK-T adapter		→

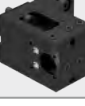
VDI accessories

Test arbor		→
Blank		→
Bar puller		→
Gripper accessories		→
Sealing plug		→

Toolfinder – Adapters, stationary

BMT tool holders

Doosan/Spinner – BMT 45	Axial square section tool holder			Left	→
	Radial square section tool holder			Left	→
	Multi square section tool holders				→
	Combination tool holder				→

Mori/Seiki – BMT 40	Axial square section tool holder			Left	→
	Radial square section tool holder			Left	→
	Multi square section tool holders				→
	Combination tool holder				→

Doosan – BMT 55	Axial square section tool holder			Left	→
	Radial square section tool holder			Left	→
	Multi square section tool holders				→
	Combination tool holder				→

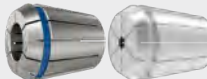
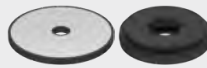
Mori/Seiki – BMT 60	Axial square section tool holder			Left	→
	Radial square section tool holder			Left	→
	Multi square section tool holders				→
	Combination tool holder				→

EMAG – BMT 55	Axial square section tool holder			Left	→
	Radial square section tool holder			Left	→
	Boring bar holder				→

Mazak – BMT 68	Axial square section tool holder			Left	→
	Radial square section tool holder			Left	→
	Multi square section tool holders				→
	Combination tool holder				→

HAAS/Doosan – BMT 65	Axial square section tool holder			Left	→
	Radial square section tool holder			Left	→
	Multi square section tool holders				→
	Combination tool holder				→

Toolfinder – Accessories

Pull studs		SK	→	Spare parts for VDI		→
		MAS-BT	→			
		PSC	→			
Coolant pipe/key		HSK-A	→	Spare parts for driven tools		→
		PSC	→			
Drill chuck with internal taper			→	Quick change adapters		→
Clamping sleeve for taps in Weldon chucks			→	Reduction sleeves and reducing bushings		→
Extensions for shell mill adapters			→	3D tester and zero setting device		→
Milling adapter ring			→	Cleaning propeller		→
ER-Standard and ER-Mini lock nuts			→	TORX® screwdrivers, TORX® interchangeable blades, TORX® bit holders, and adapters		→
Y clamping keys and ER-Mini clamping keys			→	Assembly device for SK, HSK, and PSC adapters		→
Spare parts Centro-P			→	MultiChange – holder		→
Roll keys			→	MultiChange – key		→
ER collets			→	Cool-jet		→
Sealing discs			→	Taper wiper		→

Toolfinder – Sliding head tooling

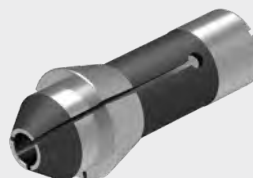
Pressure collets

Collets for clamping the bar in the main spindle and for the sub-spindle



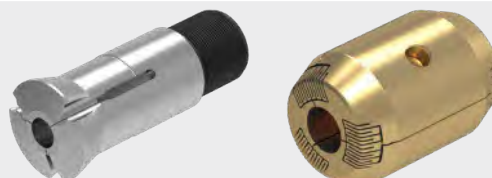
Stem collets

With an adapted stem for improved pick-up of the workpieces and for better secondary operation machinability



Guide bushes

Ensures bar guidance in the main spindle



Clamping sleeves

Mounting for bar feeder magazines



Reduction sleeves

With a reduction sleeve, small tools can be used directly on tool clamping points with larger mounting diameters.



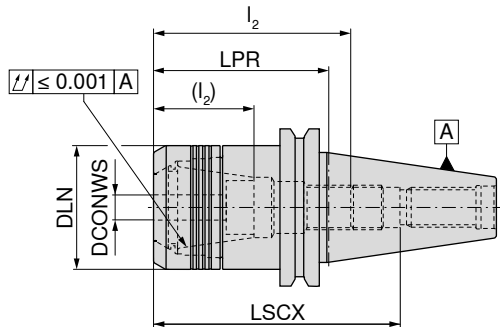
CoreLine – ER precision collet chucks – Centro-P

- ▲ For standard or sealing disc lock nuts
- ▲ Maximum clamping range covered according to ISO tolerance field H10
- ▲ Roll key required for clamping
- ▲ $p_{\max} = 80$ bar
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body **without** lock nut, **without** stop screw

Centro-P



AD

G 2.5 $n_{\max}$ 25000

Adapter	DCONWS mm	LPR mm	DLN mm	LSCX mm	l_2 (l_2) mm	for collet	CT 84 424 ...
CAT 40	1 - 10	63.5	30	39.0	31,5 - 50,5	426E (ER16)	11052
CAT 40	1 - 10	127.0	30	102.5	32 - 67	426E (ER16)	31052
CAT 40	2 - 20	101.6	50	80.5	45 - 80	470E (ER32)	22052
CAT 40	2 - 20	152.4	50	131.0	45 - 80	470E (ER32)	42052
CAT 40	3 - 26	101.6	63	82.5	57 - 77	472E (ER40)	22652
CAT 50	1 - 10	101.6	30	72.5	32 - 62	426E (ER16)	21053
CAT 50	1 - 10	152.4	30	123.0	32 - 67	426E (ER16)	41053
CAT 50	2 - 20	101.6	50	77.5	45 - 80	470E (ER32)	22053
CAT 50	2 - 20	152.4	50	128.0	45 - 80	470E (ER32)	42053
CAT 50	3 - 26	101.6	63	79.5	57 - 88	472E (ER40)	22653
CAT 50	3 - 26	152.4	63	130.0	57 - 88	472E (ER40)	42653



LSCX = Clamping depth without stop screw

l_2 = Clamping depth with stop screw type 1, dimension in brackets (l_2) = Clamping depth with stop screw type 2

Dimension LPR is 3 mm longer when using lock nuts with sealing discs

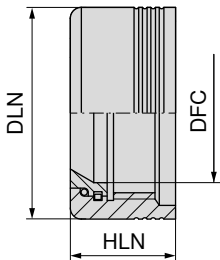


→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

HyPower – ER lock nut for precision collet chucks – Centro-P

- ▲ with thrust collar and angular contact ball bearing
- ▲ Excellent damping and clamping force
- ▲ High-precision lock nut for a perfect fit
- ▲ Run-out ≤ 3 µm with ER precision collets (blue ring)

Centro-P



for collet	DCONWS mm	HLN mm	DFC mm	DLN mm	CT 84 728 ... 05000 06300
470E (ER32)	2 - 20	26.5	32	50	
472E (ER40)	3 - 26	31.0	40	63	

Spare parts for collet

- 426E (ER16)
- 470E (ER32)
- 472E (ER40)

 HyPower – Lock nuts	 Lock nut IK	 Lock nut
CT 84 728 ... 05000 06300	CT 84 950 ... 011 015 017	CT 84 950 ... 001 005 007

Accessories



CoreLine – ER precision tapered collet chuck – Centro-P

- ▲ For special tapered nuts
- ▲ Maximum clamping range covered according to ISO tolerance field H10
- ▲ Roll key required for clamping
- ▲ $p_{max} = 80$ bar
- ▲ **On request:** Also available with Balluff chip

Scope of supply:
Base body **without** lock nut, **without** stop screw

Centro-P

AD
G 2.5 n_{max}.25000

Adapter	DCONWS mm	LPR mm	DLN mm	LSCX mm	l ₂ (l ₂) mm	for collet	ALP
CAT 40	1 - 10	101.6	24	78.0	32 - 62	426E (ER16)	4.5°
CAT 40	1 - 10	152.4	24	131.5	32 - 72	426E (ER16)	4.5°

CT

84 417 ...

21052

41052

LSCX = Clamping depth without stop screw
l₂ = Clamping depth with stop screw type 1, dimension in brackets (l₂) = Clamping depth with stop screw type 2
Dimension LPR is 4 mm longer when using lock nuts with sealing discs

→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
for collet
426E (ER16)

Tapered lock nut IK

CT

84 950 ...

033

Tapered lock nut

CT

84 950 ...

031

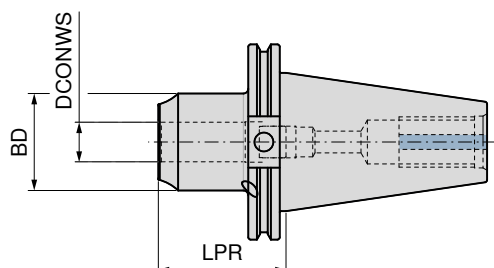
Accessories

Sealing disc

HyPower – High pressure chuck – Complus

- ▲ High pressure chuck, short and stable version
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Complus



AD/B
G 2.5 n_{max} 25000

CT

87 425 ...

02052

02053

03253

Adapter	DCONWS inch	BD inch	LPR inch
CAT40	0.787	1.929	2.539
CAT50	0.787	1.929	2.539
CAT50	1.260	2.750	3.189



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
for article number

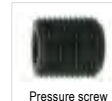
		CT		AS		CT		CT
		83 950 ...		80 397 ...		83 950 ...		83 950 ...
87 425 02052	M5x5 - SW2,5	157	SW5	050	M10x1x14	429	M16x1x13,5 - SW8	424
87 425 02053	M5x5 - SW2,5	157	SW5	050	M10x1x14	429	M16x1x13,5 - SW8	424
87 425 03253	M5x5 - SW2,5	157	SW5	050	M10x1x14	429	M16x1x13,5 - SW8	424



Cylindrical screw



Clamping key T



Pressure screw

Backstop screw with
internal cooling

Accessories

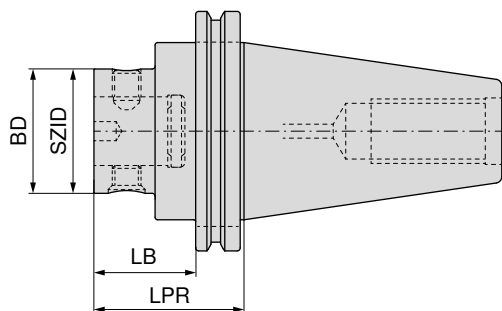


Reduction sleeve



HyPower – adapter – ABS

ABS



AD

CT

Adapter	SZID	LB inch	LPR inch	BD inch	Product Reference No.
CAT 40	ABS 25	1.610	2.362	0.984	A52 10120
CAT 40	ABS 32	1.610	2.362	1.260	A52 10130
CAT 40	ABS 40	1.610	2.362	1.575	A52 10140
CAT 40	ABS 50	4.764	5.512	1.969	A52 10180
CAT 40	ABS 50	2.205	2.953	1.969	A52 10150
CAT 40	ABS 63	2.791	3.543	2.480	A52 10160
CAT 50	ABS 100	4.169	4.921	3.937	A52 10380
CAT 50	ABS 25	1.610	2.362	0.984	A52 10320
CAT 50	ABS 32	1.610	2.362	1.260	A52 10330
CAT 50	ABS 40	1.610	2.362	1.575	A52 10340
CAT 50	ABS 50	1.610	2.362	1.969	A52 10350
CAT 50	ABS 50	5.547	6.299	1.969	A52 10400
CAT 50	ABS 63	2.402	3.150	2.480	A52 10360
CAT 50	ABS 80	3.185	3.937	3.150	A52 10370

87 201 ...

01352
01652
02052
12852
02852
03452

05653
01353
01653
02053
02853
12853
03453
04653

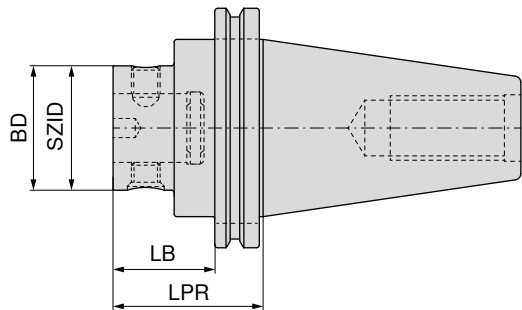
Spare parts SZID

ABS 25	
ABS 32	M8x1x12/SW4
ABS 40	
ABS 50	
ABS 63	
ABS 80	
ABS 100	

Clamping screw	Clamping screw	Set	Taper screw	Sealing disc – ABS
CT	CT	CT	CT	CT
62 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...
	26800	99700	27000	30400
13989	99600	99500	27100	30500
	26900	99800	27200	30600
	20300	99400	20400	30700
	25500	99300	27300	30800
	25600	99200	25100	30900
	25700		25200	31000

HyPower – adapter – ABS

ABS



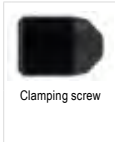
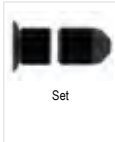
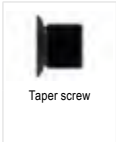
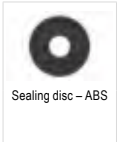
B

Adapter	SZID	LB inch	LPR inch	BD inch	Product Reference No.
CAT 40 / Mori Seiki	ABS 40	1.610	2.362	1.575	A52 50140
CAT 40 / Mori Seiki	ABS 50	2.205	2.953	1.969	A52 50150
CAT 50 / Mori Seiki	ABS 50	1.610	2.362	1.969	A52 50350
CAT 50 / Mori Seiki	ABS 63	2.402	3.150	2.480	A52 50360
CAT 50 / Mori Seiki	ABS 80	3.185	3.937	3.150	A52 50370

CT
87 002 ...
02052
02852
02853
03453
04653

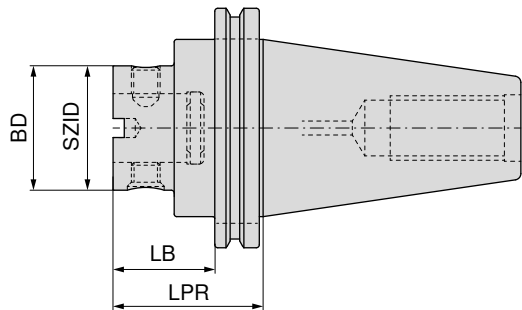
Spare parts
SZID

ABS 40	26900	99500	27200	30600
ABS 50	20300	99800	20400	30700
ABS 63	25500	99400	27300	30800
ABS 80	25600	99300	25100	30900

 Clamping screw	 Set	 Taper screw	 Sealing disc – ABS
CT	CT	CT	CT
84 950 ...	84 950 ...	84 950 ...	84 950 ...
26900	99500	27200	30600
20300	99800	20400	30700
25500	99400	27300	30800
25600	99300	25100	30900

HyPower – adapter – ABS N

ABS N



AD/B
G 6.3 n_{max} 8000

Adapter	SZID	LB inch	BD inch	LPR inch
CAT 50	ABS 50 N	1.612	1.969	2.362
CAT 50	ABS 63 N	2.400	2.480	3.150
CAT 50	ABS 80 N	3.187	3.150	3.937

CT
87 234 ...
12853
13453
14653

Spare parts
SZID

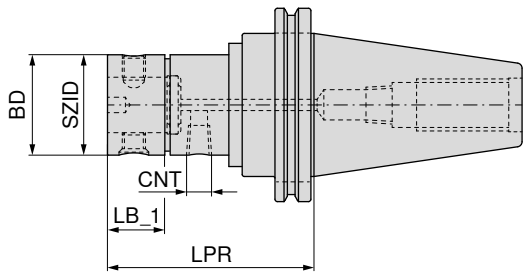
ABS 50 N
ABS 63 N
ABS 80 N

Clamping screw	Set	Taper screw	Sealing disc – ABS
CT	CT	CT	CT
84 950 ...	84 950 ...	84 950 ...	84 950 ...
20300	99800	20400	30700
25500	99400	27300	30800
25600	99300	25100	30900

HyPower – Adapter for coolant ring – ABS

▲ Adjustment ± 0.010" in diameter

ABS



AD

Adapter	SZID	DCONWS inch	BD_1 inch	BD_2 inch	LPR inch	BD_2 inch	LB_1 inch
CAT 40	ABS 50	1.102	1.969	2.362	3.740	2.362	2.087
CAT 50	ABS 50	1.102	1.969	2.362	3.937	2.362	2.283
CAT 50	ABS 63	1.339	2.480	2.756	4.331	2.756	1.260

CT
87 233 ...
02852
02853
03453

Spare parts

SZID	20300	99800	20400	30700
ABS 50	25500	99400	27300	30800
ABS 63				

			
CT	CT	CT	CT
84 950 ...	84 950 ...	84 950 ...	84 950 ...
20300	99800	20400	30700
25500	99400	27300	30800

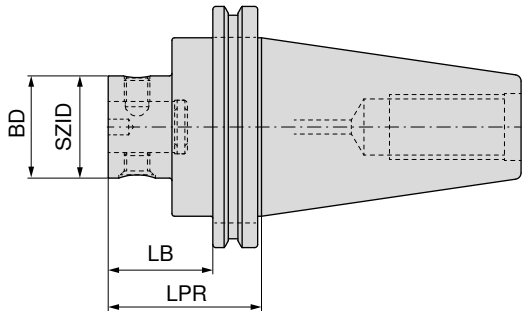
Accessories

		
Coolant connection with break section	Sealing ring for coolant ring	Coolant ring
→	→	→

HyPower – Adapter – CAT-FC – ABS

- ▲ With face contact
- ▲ Also available with Balluff chip **on request**

ABS



AD
G 6.3 n_{max} 8000

Adapter	SZID	LB inch	LPR inch	BD inch
CAT-FC 40	ABS 50	2.203	2.953	1.969
CAT-FC 40	ABS 63	2.793	3.543	2.480
CAT-FC 50	ABS 40	1.612	2.362	1.575
CAT-FC 50	ABS 50	1.612	2.362	1.969
CAT-FC 50	ABS 63	2.400	3.150	2.480
CAT-FC 50	ABS 80	3.187	3.937	3.150
CAT-FC 50	ABS 100	4.171	4.921	3.937

CT
87 213 ...
12861
13461
12062
12862
13462
14662
15662

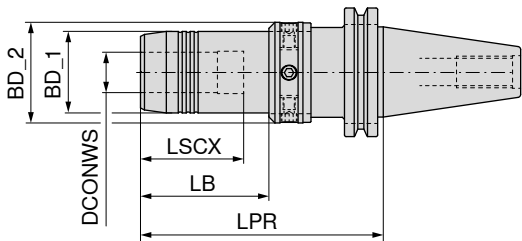
Spare parts
SZID

ABS 40
ABS 50
ABS 63
ABS 80
ABS 100

		
Clamping screw	Set	Taper screw
CT	CT	CT
84 950 ...	84 950 ...	84 950 ...
26900	99500	27200
20300	99800	20400
25500	99400	27300
25600	99300	25100
25700	99200	25200

HyPower – Compensation holder – DAH

DAH



AD
G 2.5 n_{max} 25000

Adapter	DCONWS inch	BD_1 inch	BD_2 inch	LB inch	LSCX inch	LPR inch	OAL inch
CAT 40	0.750	1.614	1.969	2.543	2.047	4.764	7.451
CAT 40	0.787	1.614	1.969	2.543	2.047	4.764	7.451

CT

87 326 ...

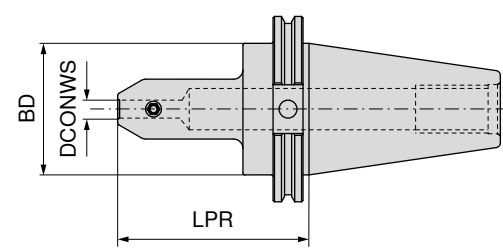
07552

07952



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Cylindrical shank adapter Weldon



AD
G 2.5 n_{max} 25000

	Adapter	DCONWS _{H6}	LPR	BD
		inch	inch	inch
Short	CAT 40	0.375	2.500	1.000
	CAT 40	0.437	2.500	1.380
	CAT 40	0.500	1.750	1.750
	CAT 40	0.563	3.000	1.620
	CAT 40	0.625	1.750	1.750
	CAT 40	0.750	1.750	1.750
	CAT 40	1.000	1.750	1.750
	CAT 40	1.250	2.000	2.250
Long	CAT 40	1.500	4.620	2.750
	CAT 50	0.375	4.000	1.000
	CAT 50	0.437	4.000	1.380
	CAT 50	0.500	4.000	1.380
	CAT 50	0.625	4.000	1.620
	CAT 50	0.653	4.000	1.620
	CAT 50	0.750	4.000	1.750
	CAT 50	1.000	4.000	2.250
	CAT 50	1.250	4.000	2.500
	CAT 50	1.500	4.000	2.750

CT
87 000 ...
10952
11152
11252
11452
11552
11952
12552
13152
23852
20953
21153
21253
21553
21653
21953
22553
23153
23853

Spare parts
DCONWS _{H6}

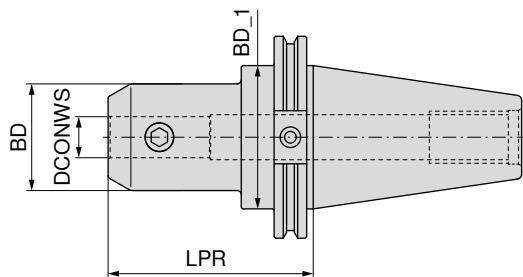
0.375	3/8"-24 UNF
0.437	7/16"-20 UNF
0.500	7/16"-20 UNF
0.563	9/16"-18 UNF
0.625	9/16"-18 UNF
0.653	9/16"-18 UNF
0.750	5/8"-18 UNF
1.000	5/8"-18 UNF
1.000	3/4"-18 UNF
1.250	5/8"-18 UNF
1.250	3/4"-18 UNF
1.500	3/4"-18 UNF



AS
87 950 ...

00002
00003
00003
00004
00004
00004
00005
00005
00006
00005
00006
00006

Cylindrical shank adapter Weldon



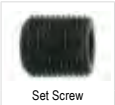
AD
G 2.5 n_{max} 25000

	Adapter	DCONWS _{H6}	BD_1	BD	LPR
		inch	inch	inch	inch
Short	CAT 40	0.236	0.984	0.984	2.362
	CAT 40	0.315	1.102	1.102	2.953
	CAT 40	0.394	1.378	1.378	2.953
	CAT 40	0.472	1.654	1.654	2.953
	CAT 40	0.630		1.750	1.772
	CAT 40	0.787	1.750	2.047	2.953
	CAT 40	0.984	1.750	2.362	3.150
	CAT 40	1.260	2.250	2.250	1.969
	CAT 50	0.236	0.984	0.984	2.559
	CAT 50	0.315	1.102	1.102	2.559
Medium length	CAT 50	0.394		1.378	1.969
	CAT 50	0.472	1.654	1.654	3.937
	CAT 50	0.630	1.890	1.890	3.937
	CAT 50	0.787	2.047	2.047	3.937
	CAT 50	0.984	2.559	2.559	3.937
	CAT 50	1.260		2.756	3.937

CT
87 216 ...
10652
10852
11052
11252
11652
12052
12552
13252
30653
30853
31053
71253
71653
72053
72553
73253

Spare parts
DCONWS _{H6}

0.236	M6x10
0.315	M8x10
0.394	M10x12
0.472	M12x16
0.630	M14x16
0.787	M16x16
0.984	M18x2x20
1.260	M20x2x20



Set Screw

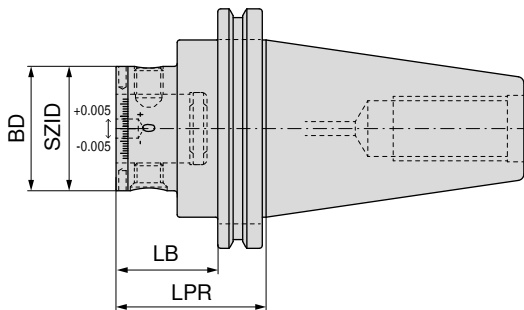
CT
62 950 ...

006
008
010
012
016
020
025
032

HyPower – Eccentric adjuster – ABS

▲ Adjustment ± 0.010" in diameter

ABS



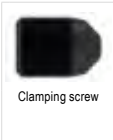
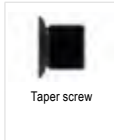
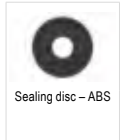
AD/B

Adapter	SZID	BD inch	LPR inch	LB inch
CAT 40	ABS 50	1.969	2.953	2.203
CAT 40	ABS 63	2.480	3.543	2.793
CAT 50	ABS 50	1.969	2.362	1.612
CAT 50	ABS 63	2.480	3.150	2.400

CT
87 204 ...
02852
03452
02853
03453

Spare parts SZID

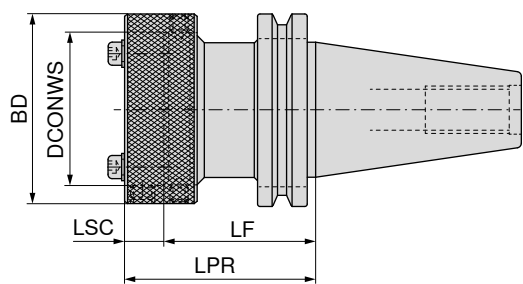
ABS 50	20300	99800	20400	30700
ABS 63	25500	99400	27300	30800

			
Clamping screw	Set	Taper screw	Sealing disc – ABS
CT	CT	CT	CT
84 950 ...	84 950 ...	84 950 ...	84 950 ...
20300	99800	20400	30700
25500	99400	27300	30800

HyPower – Compensation holder – DAH

Scope of supply:
DAH compensation holder complete with assembly screws

DAH



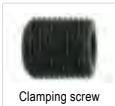
AD/B

Adapter	SZID	DCONWS inch	LSC inch	LF inch	BD inch	LPR inch
CAT 40	DAH 63	1.969	0.472	2.008	2.480	2.480
CAT 40	DAH 81	2.559	0.472	2.008	3.189	2.480
CAT 50	DAH 81	2.559	0.472	2.008	3.189	2.480
CAT 50	DAH 115	3.937	0.630	2.717	4.528	3.346

CT
87 329 ...
06352
06552
06553
01053

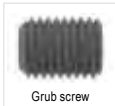
Spare parts
SZID

DAH 63	M8x6 - SW4	53400	M6x8	42700	DAH 63	42200
DAH 81	M8x6 - SW4	53400	M6x10	42800	DAH 81	42000
DAH 115	M8x8 - SW4	14700	M8x10	43000	DAH 115	42100



Clamping screw

AS
62 950 ...



Grub screw

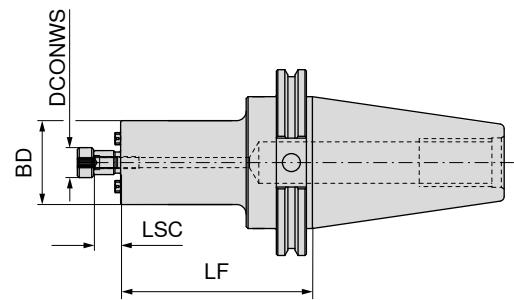
CT
84 950 ...



DAH adjustment ring

CT
84 950 ...

Shell mill adapter



AD
G 2.5 n_{max} 25000

	Adapter	DCONWS	LF	BD	LSC	CT
		inch	inch	inch	inch	
Short	CAT 40	0.500	1.380	1.750	0.560	87 001 ... 11252 11952 12552 13152 13852
	CAT 40	0.750	1.770	1.750	0.690	
	CAT 40	1.000	2.360	2.190	0.690	
	CAT 40	1.250	2.360	2.750	0.690	
	CAT 40	1.500	2.360	3.380	0.940	
	CAT 50	1.000	2.000	2.190	0.690	12553 13153 13853 15053 16353
	CAT 50	1.250	1.750	2.750	0.690	
	CAT 50	1.500	2.500	3.940	0.940	
	CAT 50	2.000	2.500	4.900	0.940	
	CAT 50	2.500	2.500	4.900	0.940	
Long	CAT 50	0.500	4.000	1.750	0.560	21253
	CAT 50	0.750	3.500	1.750	0.690	21953

Spare parts
DCONWS

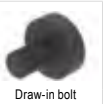
0.500			1/4"-28 UNF	00011	1/4"-28 UNF	00021
0.750			3/8"-24 UNF	00012	3/8"-24 UNF	00022
0.750			3/8"-24 UNF	00012	3/8"-24 UNF	00022
1.000			1/2"-20 UNF	00013	1/2"-20 UNF	00023
1.250			5/8"-18 UNF	00041		
1.500			3/4"-16 UNF	00015	3/4"-16 UNF	00025
2.000	5/8"-11 UNC	00030	1"-14 UNF	00016	1"-14 UNF	00026
2.500	5/8"-11 UNC	00030	1"-14 UNF	00017	1"-14 UNF	00027



AS
87 950 ...

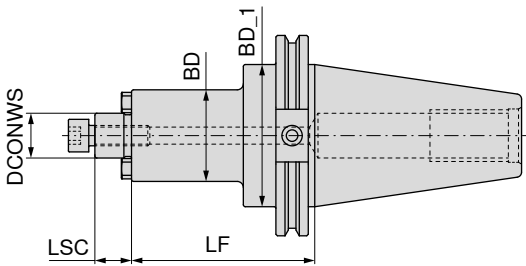


AS
87 950 ...



AS
87 950 ...

Shell mill adapter



AD
G 2.5 n_{max} 25000

	Adapter	DCONWS inch	LF inch	BD_1 inch	BD inch	LSC inch
Short	CAT 40	0.630	1.378		1.339	0.591
	CAT 40	0.866	1.969		1.772	0.709
	CAT 40	1.063	1.969	1.750	2.362	0.787
	CAT 40	1.260	1.969	1.750	3.150	0.866
	CAT 50	1.063	2.362		2.756	0.787
	CAT 50	1.260	2.362	2.750	3.150	0.866
	CAT 50	1.575	2.362	2.750	3.346	1.024
Medium length	CAT 40	0.866	3.937		1.772	0.709
	CAT 40	1.063	3.937	1.750	2.362	0.787
	CAT 50	0.866	3.543	1.772		0.709
	CAT 50	1.063	3.937		2.756	0.787
Long	CAT 50	0.866	5.512	1.772		0.709

CT

87 217 ...

11652
12252
12752
13252
32753
33253
34053

42252
42752
62253
62753

92253

Spare parts
DCONWS

0.630	M8x25
0.866	M10x18
1.063	M12x22
1.260	M16x26
1.575	M20x30



Draw-in bolt – IK

AS

87 950 ...

00036
00037
00038
00039
00040

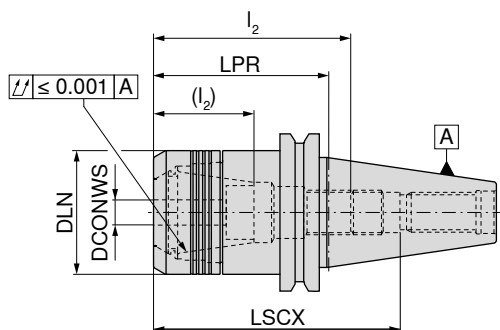
CoreLine – ER precision collet chucks – Centro-P

- ▲ For standard or sealing disc lock nuts
- ▲ Maximum clamping range covered according to ISO tolerance field H10
- ▲ Roll key required for clamping
- ▲ $p_{\max} = 80$ bar
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body **without** lock nut, **without** stop screw

Centro-P



AD

G 2.5 $n_{\max}$ 25000



AD/B

G 2.5 $n_{\max}$ 25000

Adapter	DCONWS mm	LPR mm	DLN mm	LSCX mm	l_2 (l_2) mm	for collet	CT 84 424 ...	CT 84 414 ...
SK 30	2 - 16	70	40	66	35 - 49 (18 - 31)	430E (ER25)	016	
SK 40	1 - 10	70	30	110	28 - 45 (16 - 31)	426E (ER16)	102	
SK 40	1 - 10	100	30	140	28 - 45 (16 - 31)	426E (ER16)	103	
SK 40	1 - 10	130	30	140	28 - 50 (14 - 34)	426E (ER16)		510
SK 40	1 - 10	160	30	200	28 - 45 (16 - 31)	426E (ER16)		910
SK 40	2 - 16	45	40	85	35 - 60 (20 - 42)	430E (ER25)		816
SK 40	2 - 16	70	40	110	35 - 60 (20 - 42)	430E (ER25)	162	
SK 40	2 - 16	100	40	113	35 - 60 (20 - 42)	430E (ER25)	163	
SK 40	2 - 16	130	40	140	38 - 67 (21 - 49)	430E (ER25)		516
SK 40	2 - 16	160	40	118	35 - 60 (20 - 42)	430E (ER25)		916
SK 40	2 - 20	50	50	85	52 - 70 (26 - 52)	470E (ER32)	201	
SK 40	2 - 20	70	50	111	55 - 75 (42 - 62)	470E (ER32)	202	
SK 40	2 - 20	100	50	114	52 - 70 (32 - 52)	470E (ER32)	203	
SK 40	2 - 20	130	50	114	50 - 74 (36 - 55)	470E (ER32)		620
SK 40	2 - 20	160	50	119	52 - 70 (32 - 52)	470E (ER32)		920
SK 40	3 - 26	70	63	105	48 - 55	472E (ER40)	261 ¹⁾	
SK 50	2 - 16	100	40	150	35 - 64 (20 - 48)	430E (ER25)	167	
SK 50	2 - 20	70	50	120	59 - 85 (40 - 70)	470E (ER32)		320
SK 50	2 - 20	100	50	150	53 - 81 (35 - 63)	470E (ER32)		520
SK 50	2 - 20	130	50	150	53 - 81 (35 - 63)	470E (ER32)		52100
SK 50	2 - 20	160	50	200	53 - 83 (35 - 65)	470E (ER32)		720
SK 50	3 - 26	70	63	120	48 - 60	472E (ER40)		26600
SK 50	3 - 26	100	63	90	48 - 70	472E (ER40)		26700
SK 50	3 - 26	130	63	90	47 - 57	472E (ER40)		26800
SK 50	3 - 26	160	63	90	47 - 57	472E (ER40)		26900

1) Groove before tool change collar ($\varnothing=63$ mm) deviates from DIN



LSCX = Clamping depth without stop screw

l_2 = Clamping depth with stop screw type 1, dimension in brackets (l_2) = Clamping depth with stop screw type 2

Dimension LPR is 3 mm longer when using lock nuts with sealing discs

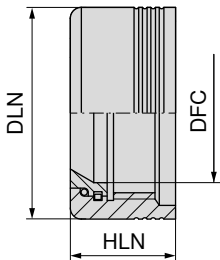


→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

HyPower – ER lock nut for precision collet chucks – Centro-P

- ▲ with thrust collar and angular contact ball bearing
- ▲ Excellent damping and clamping force
- ▲ High-precision lock nut for a perfect fit
- ▲ Run-out ≤ 3 µm with ER precision collets (blue ring)

Centro-P



for collet	DCONWS mm	HLN mm	DFC mm	DLN mm	CT 84 728 ... 05000 06300
470E (ER32)	2 - 20	26.5	32	50	
472E (ER40)	3 - 26	31.0	40	63	

Spare parts for collet

426E (ER16)	CT 84 728 ...	CT 84 950 ...	CT 84 950 ...	CT 83 950 ...	CT 83 950 ...
430E (ER25)		011	001	M11x1 - SW6 341	M11x1 - SW6 337
470E (ER32)	05000	013	003	M18x1,5 - SW6 432	M18x1,5 - SW6 431
472E (ER40)	06300	015	005	M22x1,5 - SW6 402	M22x1,5 - SW6 401
		017	007	M28x1,5 - SW6	M28x1,5 - SW6 400

Accessories



ER collet

→



Sealing disc

→



Roll key

→



Roll key device

→



Pull stud

→



Others

→

CoreLine – ER precision tapered collet chuck – Centro-P

- ▲ For special tapered nuts
- ▲ Maximum clamping range covered according to ISO tolerance field H10
- ▲ Roll key required for clamping
- ▲ $p_{max} = 80$ bar
- ▲ **On request:** Also available with Balluff chip

Scope of supply:
Base body **without** lock nut, **without** stop screw

Centro-P

AD/B
G 2.5 n_{max} 25000

Adapter	DCONWS mm	LPR mm	DLN mm	LSCX mm	l ₂ (l ₂) mm	for collet	ALP
SK 40	1 - 10	100	24	140	28 - 48 (20 - 35)	426E (ER16)	4.5°
SK 40	1 - 10	130	24	105	28 - 48 (20 - 35)	426E (ER16)	3.5°
SK 40	1 - 10	160	24	200	28 - 48 (20 - 35)	426E (ER16)	2.5°

CT

84 417 ...

410

61000

910

LSCX = Clamping depth without stop screw
l₂ = Clamping depth with stop screw type 1, dimension in brackets (l₂) = Clamping depth with stop screw type 2
Dimension LPR is 4 mm longer when using lock nuts with sealing discs

→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
for collet

426E (ER16)

CT

84 950 ...

033

CT

84 950 ...

031

CT

83 950 ...

341

CT

83 950 ...

337

M11x1 - SW6

M11x1 - SW6

Accessories

ER collet

→

Sealing disc

→

Roll key

→

Roll key device

→

Pull stud

→

Others

→

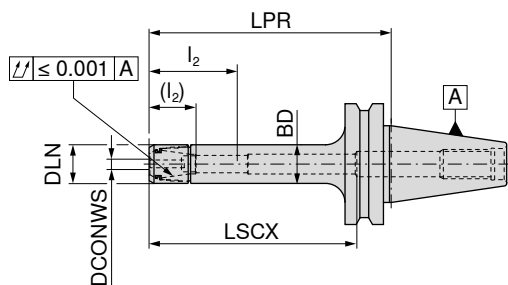
CoreLine – ER precision collet chuck, slim version – Centro-P

- ▲ For mini lock nuts
- ▲ Maximum clamping range covered according to ISO tolerance field H10
- ▲ Roll key required for clamping
- ▲ $p_{\max} = 80$ bar
- ▲ **On request:** Also available with Balluff chip

Scope of supply:

Base body **without** lock nut, **without** stop screw

Centro-P



AD/B

G 2.5 $n_{\max}$ 25000

CT

84 412 ...

207

407

607

907

210

310

410

510

Adapter	DCONWS mm	LPR mm	DLN mm	BD mm	LSCX mm	l_2 (l_2) mm	for collet
SK 40	1 - 7	70	16	16	60	15 - 32 (7 - 22)	4008E (ER11)
SK 40	1 - 7	100	16	16	68	18 - 36 (12 - 26)	4008E (ER11)
SK 40	1 - 7	130	16	16	110	15 - 32 (7 - 22)	4008E (ER11)
SK 40	1 - 7	160	16	16	68	18 - 36 (12 - 26)	4008E (ER11)
SK 40	1 - 10	70	22	22	90	28 - 50 (14 - 36)	426E (ER16)
SK 40	1 - 10	100	22	22	110	28 - 50 (14 - 36)	426E (ER16)
SK 40	1 - 10	130	22	22	140	28 - 50 (14 - 36)	426E (ER16)
SK 40	1 - 10	160	22	22	170	28 - 50 (14 - 36)	426E (ER16)



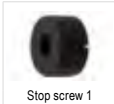
LSCX = Clamping depth without stop screw

l_2 = Clamping depth with stop screw type 1, dimension in brackets (l_2) = Clamping depth with stop screw type 2

Dimension LPR is 4 mm longer when using lock nuts with sealing discs



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts for collet								
	CT		CT		CT		CT	
	84 950 ...		84 950 ...		83 950 ...		83 950 ...	
4008E (ER11)			041		M8x1 - SW4		M8x1 - SW4	
426E (ER16)	035		034		M11x1 - SW6		M11x1 - SW6	

Accessories

						
ER collet	Sealing disc	Removal aid	Roll key	Roll key device	Pull stud	Others
→	→	→	→	→	→	→

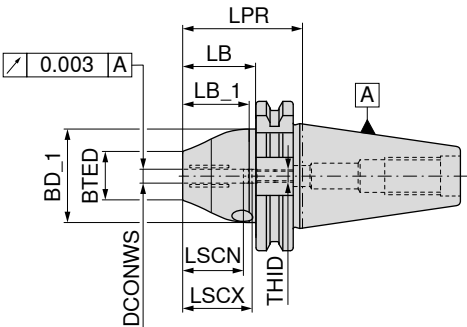
HyPower – High pressure chuck – Rough

- ▲ High pressure chuck – especially for milling
- ▲ Ideal for HSC and HPC applications
- ▲ High temperature resistance
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with backstop screw and pressure screw

Rough



AD/B
G 2.5 n_{max} 25000

Adapter	DCONWS mm	LPR mm	BTED mm	BD_1 mm	LB_1 mm	LB mm	LSCX mm	LSCN mm	THID
SK 40	6	50.0	26.0	42.0	27.1	30.9	37	27	M5
SK 40	8	50.0	28.0	42.0	27.1	30.9	37	27	M6
SK 40	10	50.0	30.0	42.0	27.1	30.9	41	31	M8x1
SK 40	12	50.0	32.0	49.0	27.1	30.9	46	36	M10x1
SK 40	16	64.5	38.0	49.0	41.6	45.4	49	39	M12x1
SK 40	20	64.5	38.0	49.0	41.6	45.4	51	41	M16x1
SK 40	25	110.0	48.0	57.0	45.0	90.9	57	47	M10X1
SK 40	32	115.0	58.5	62.5	50.0	95.9	61	51	M12X1

CT
84 254 ...
10679
10879
11079
11279
11679
12079
12579
13279



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

		 Clamping key T		 Pressure screw		 Backstop screw with internal cooling	
		AS		CT		CT	
Spare parts DCONWS		80 397 ...		83 950 ...		83 950 ...	
6	SW5	050	M10x12	55000	M5x12,5 - SW2,5	418	
8	SW5	050	M10x12	55000	M6x12,5 - SW3	419	
10	SW5	050	M10x12	55000	M8x1x13,5 - SW3	420	
12	SW5	050	M10x12	55000	M10x1x13,5 - SW5	421	
16	SW5	050	M10x12	55000	M12x1x13,5 - SW5	422	
20	SW5	050	M10x12	55000	M16x1x13,5 - SW8	424	
25	SW5	050	M10x12	55000	M10x1x13,5 - SW5	421	
32	SW5	050	M10x12	55000	M12x1x13,5 - SW5	422	

Accessories

		
Reduction sleeve	Pull stud	Others
→	→	→

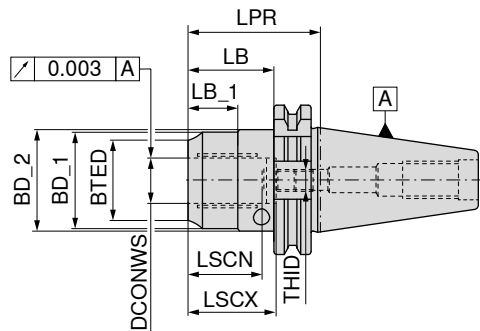
HyPower – High pressure chuck – Complus

- ▲ High pressure chuck, short and stable version
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with stop screw and pressure screw

Complus



AD/B
G 2.5 n_{max} 25000

Adapter	DCONWS mm	LPR mm	BTED mm	BD_1 mm	BD_2 mm	LB mm	LB_1 mm	LSCX mm	LSCN mm	THID
SK 40	20	64.5	38					51	40	M16x1x13,5
SK 40	32	81.0	57	63	70	61.9	26	61	51	M16x1x13,5
SK 50	20	64.5	38	49		45.4		51	41	M16x1x13,5
SK 50	32	81.0	57	68	72	61.9	35	61	51	M16x1x13,5

CT
83 427 ...
120
13279
12078
13278

 LSCX = maximum insertion depth
LSCN = minimum insertion depth

 → Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts for article number		Cylindrical screw		Clamping key T		Pressure screw		Backstop screw with internal cooling	
		CT	83 950 ...	AS	80 397 ...	CT	83 950 ...	CT	83 950 ...
83 427 13279	M5x5 - SW2,5	157	SW5	050	M10x1x14	429	M16x1x13,5 - SW8	424	
83 427 12078	M5x5 - SW2,5	157	SW5	050	M10x1x14	429	M16x1x13,5 - SW8	424	
83 427 13278	M5x5 - SW2,5	157	SW5	050	M10x1x14	429	M16x1x13,5 - SW8	424	

Accessories

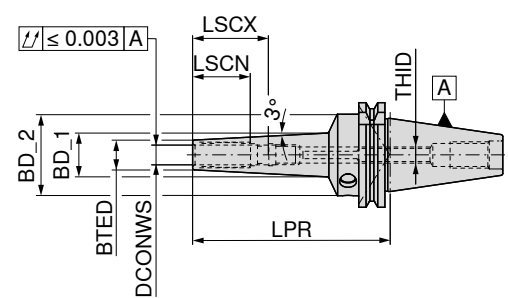


HyPower – High pressure chuck – Access 3°

- ▲ High pressure chuck, slim version 3°
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with stop screw, pressure screw, and cylindrical screw



AD/B
G 2.5 n_{max} 25000

		Adapter	DCONWS mm	LPR mm	BTED mm	BD_1 mm	BD_2 mm	LSCX mm	LSCN mm	THID	CT
											83 421 ...
Medium length		SK 40	3	120	9	17.40	49.5	28	12	M3	103
		SK 40	4	120	10	18.40	49.5	28	16	M3	104
		SK 40	5	120	11	19.40	49.5	28	20	M3	105
		SK 40	6	120	12	20.40	49.5	37	27	M5	106
		SK 40	8	120	14	22.40	49.5	37	27	M6	108
		SK 40	10	120	16	24.50	49.5	41	31	M8x1	110
		SK 40	12	120	18	26.60	49.5	46	36	M10x1	112
		SK 40	16	120	24	32.30	49.5	49	39	M12x1	116
		SK 40	20	120	28	36.40	49.5	51	41	M16x1	120
		SK 40	6	160	16	34.37	49.5	37	27	M5	206
		SK 40	8	160	18	35.45	49.5	37	27	M6	208
		SK 40	10	160	20	37.10	49.5	41	31	M8x1	210
		SK 40	12	160	22	38.72	49.5	46	36	M10x1	212
		SK 40	6	200	16	38.72	49.5	37	27	M5	306
		SK 40	8	200	18	39.74	49.5	37	27	M6	308
		SK 40	10	200	20	41.40	49.5	41	31	M8x1	310
		SK 40	12	200	22	43.02	49.5	46	36	M10x1	312



LSCX = maximum insertion depth
LSCN = minimum insertion depth



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

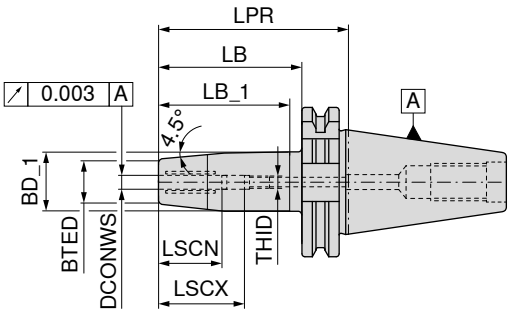
		<div> Cylindrical screw</div>		<div> Clamping key T</div>		<div> Pressure screw</div>		<div> Backstop screw with internal cooling</div>	
		CT		AS		CT		CT	
Spare parts		83 950 ...		80 397 ...		83 950 ...		83 950 ...	
DCONWS									
3	M5x5 - SW2,5	157	SW5	050	M10x1x10	158	M3x20 - SW1,5	172	
4	M5x5 - SW2,5	157	SW5	050	M10x1x10	158	M3x20 - SW1,5	172	
5	M5x5 - SW2,5	157	SW5	050	M10x1x10	158	M3x20 - SW1,5	172	
6	M5x5 - SW2,5	157	SW5	050	M10x1x10	158	M5x12,5 - SW2,5	418	
8	M5x5 - SW2,5	157	SW5	050	M10x1x10	158	M6x12,5 - SW3	419	
10	M5x5 - SW2,5	157	SW5	050	M10x1x12	159	M8x1x13,5 - SW3	420	
12	M5x5 - SW2,5	157	SW5	050	M10x1x12	159	M8x1x13,5 - SW3	420	
12	M5x5 - SW2,5	157	SW5	050	M10x1x12	159	M10x1x13,5 - SW5	421	
16	M5x5 - SW2,5	157	SW5	050	M10x1x12	159	M12x1x13,5 - SW5	422	
20	M5x5 - SW2,5	157	SW5	050	M10x1x12	159	M16x1x13,5 - SW8	424	

HyPower – High pressure chuck – Access 4,5°

- ▲ High pressure chuck with slim contour, original dimensions of a 4.5° shrink contour
- ▲ Especially for reaming and drilling applications
- ▲ Ideal for tool and die production
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with backstop screw and pressure screw



AD/B
G 2.5 n_{max} 25000

Adapter	DCONWS mm	LPR mm	BTED mm	BD_1 mm	LB_1 mm	LB mm	LSCX mm	LSCN mm	THID
SK 40	6	80	21	27	55.7	60.9	37	27	M5
SK 40	8	80	21	27	55.7	60.9	37	27	M6
SK 40	10	80	24	32	55.7	60.9	41	31	M8x1
SK 40	12	80	24	32	55.7	60.9	46	36	M10x1
SK 40	16	80	27	34	55.8	60.9	49	39	M12x1
SK 40	20	80	33	42	57.2	60.9	51	41	M16x1
SK 40	6	120	21	27	48.9	100.9	37	27	M5
SK 40	8	120	21	27	48.9	100.9	37	27	M6
SK 40	10	120	24	32	61.6	100.9	41	31	M8X1
SK 40	12	120	24	32	61.6	100.9	46	36	M10X1
SK 40	16	120	27	34	56.2	100.9	49	39	M12X1
SK 40	20	120	33	42	68.9	100.9	51	41	M16X1

CT
84 255 ...
10679
10879
11079
11279
11679
12079
20679
20879
21079
21279
21679
22079



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

								
				AS		CT		CT
Spare parts DCONWS				80 397 ...		83 950 ...		83 950 ...
6	SW5	050	M10x12			55000	M5x12,5 - SW2,5	418
8	SW5	050	M10x12			55000	M6x12,5 - SW3	419
10	SW5	050	M10x12			55000	M8x1x13,5 - SW3	420
12	SW5	050	M10x12			55000	M10x1x13,5 - SW5	421
16	SW5	050	M10x12			55000	M12x1x13,5 - SW5	422
20	SW5	050	M10x12			55000	M16x1x13,5 - SW8	424

Accessories

		
Reduction sleeve	Pull stud	Others
→	→	→

CoreLine – Hydraulic chuck – Fit

- ▲ Hydraulic chuck, short and slim version
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body with stop screw and pressure screw

Fit

AD/B
G 2.5 n_{max} 25000

Adapter	DCONWS mm	LPR mm	BD_1 mm	BD_2 mm	LSCX mm	LSCN mm	LB_1 mm	THID
SK 40	6	80.5	26	49.5	37	27	29.5	M5
SK 40	8	80.5	28	49.5	37	27	30.0	M6
SK 40	10	80.5	30	49.5	41	31	35.0	M8x1
SK 40	12	80.5	32	49.5	46	36	40.0	M10x1
SK 40	16	80.5	38	49.5	49	39	45.0	M12x1
SK 40	20	80.5	42	49.5	51	41	47.0	M16x1
SK 40	25	80.5	55	63.0	57	47	28.0	M16x1
SK 40	32	80.5	63	70.0	61	51	25.5	M16x1
SK 50	6	80.5	26	49.5	37	27	29.5	M5
SK 50	8	80.5	28	49.5	37	27	30.0	M6
SK 50	10	80.5	30	49.5	41	31	35.0	M8x1
SK 50	12	80.5	32	49.5	46	36	40.0	M10x1
SK 50	16	80.5	38	49.5	49	39	45.0	M12x1
SK 50	20	80.5	42	49.5	51	41	42.0	M16x1
SK 50	25	100.0	55	63.0	57	47	48.0	M16x1
SK 50	32	100.0	63	70.0	61	51	51.0	M16x1

CT

83 402 ...

106

108

110

112

116

120

125

132

306

308

310

312

316

320

325

332

→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

										
				Pressure screw			Stop screw IK			Backstop screw with internal cooling
				CT			CT			CT
Spare parts DCONWS				83 950 ...			83 950 ...			83 950 ...
6	M8x1x10	439						M5x12,5 - SW2,5	418	
8	M8x1x10	439	M6x14 - SW2			417		M6x12,5 - SW3	419	
10	M10x1x12	440						M8x1x13,5 - SW3	420	
12	M10x1x12	440						M10x1x13,5 - SW5	421	
16	M10x1x12	440						M12x1x13,5 - SW5	422	
20 - 32	M10x1x12	440						M16x1x13,5 - SW8	424	

Accessories

		
Reduction sleeve	Pull stud	Others
→	→	→

CoreLine – Hydraulic chuck – Compact

- ▲ Hydraulic chuck, short and stable version
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body with stop screw and pressure screw

Compact

AD
G 2.5 n_{max} 25000

Adapter	DCONWS mm	LPR mm	BD mm	BTED mm	LB mm	LSCN mm	LSCX mm	THID
SK 40	12	50.0	42	32	31.0	46	56	M8x1
SK 40	20	64.5	49	38	45.5	41	51	M16x1
SK 50	20	64.5	49	38	45.5	41	51	M16x1

CT

83 430 ...

01279

02079

02078

→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts		Clamping key T		Pressure screw		Backstop screw with internal cooling	
DCONWS		AS		CT		CT	
12	SW5	80 397 ...	050	M10x1x10	158	M8x1x13,5 - SW3	420
20	SW5		050	M10x1x10	158	M16x1x13,5 - SW8	424

Accessories

Reduction sleeve

→

Pull stud

→

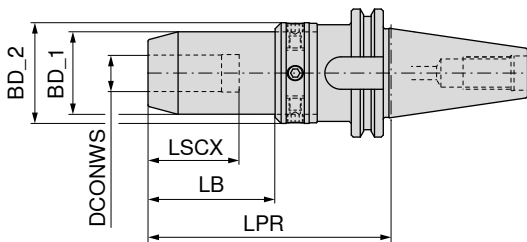
Others

→

HyPower – Compensation holder – DAH

- ▲ Tried-and-tested hydraulic expansion clamping technology
- ▲ Maximum radial run-out accuracy and repeatability < 1 µ ensures consistent cutting action
- ▲ Very simple run-out adjustment
- ▲ Compact design
- ▲ Unbeatable vibration damping, meaning outstanding surface quality
- ▲ Flexible clamping range with reduction sleeves
- ▲ Speeds of up to 25,000 rpm
- ▲ Suitable for minimum quantity lubrication (MMS)

DAH



AD
G 2.5 n_{max} 25000

Adapter	DCONWS	BD_1	BD_2	LB	LSCX	LPR	OAL
SK 40	20	41	50	65	41	110	178.4

CT
84 326 ...
02079



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

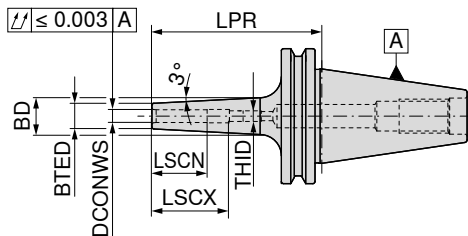
Accessories

		
Reduction sleeve	Pull stud	Others
→	→	→

CoreLine – Heat shrink adapter, slim 3° – TG

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
 ▲ **By request:** Also available with Balluff chip

TG



AD/B
 G 2.5 n_{max} 25000

		Adapter	DCONWS mm	LPR mm	BTED mm	BD mm	LSCX mm	LSCN mm	THID		
Short	SK 40	3	80	9	14	28	12	M6		84 320 ...	103
	SK 40	4	80	10	15	28	16	M6			104
	SK 40	5	80	11	16	30	20	M6			105
	SK 40	6	80	12	17	36	26	M5			106
	SK 40	8	80	14	19	36	26	M6			108
	SK 40	10	80	16	21	41	31	M8x1			110
	SK 40	12	80	18	23	47	37	M10x1			112
	SK 40	14	80	20	26	47	37	M10x1			114
	SK 40	16	80	22	28	50	40	M12x1			116
	SK 40	18	80	24	30	50	40	M12x1			118
	SK 40	20	80	26	32	52	42	M16x1			120
Medium length	SK 40	3	120	9	16	12	12				203
	SK 40	4	120	10	17	16	16				204
	SK 40	5	120	11	18	20	20				205
	SK 40	6	120	12	22	36	26	M5			206
	SK 40	8	120	14	24	36	26	M6			208
	SK 40	10	120	16	26	41	31	M8x1			210
	SK 40	12	120	18	28	47	37	M10x1			212
	SK 40	14	120	20	30	47	37	M10x1			214
	SK 40	16	120	22	32	50	40	M12x1			216
	SK 40	18	120	24	34	50	40	M12x1			218
	SK 40	20	120	26	36	52	42	M16x1			220
Extended	SK 40	3	160	9	19	12	12				303
	SK 40	4	160	10	20	16	16				304
	SK 40	5	160	11	21	20	20				305
	SK 40	6	160	12	24	36	26	M5			306
	SK 40	8	160	14	26	36	26	M6			308
	SK 40	10	160	16	28	41	31	M8x1			310
	SK 40	12	160	18	30	47	37	M10x1			312
	SK 40	14	160	20	32	47	37	M10x1			314
	SK 40	16	160	22	34	50	40	M12x1			316
	SK 40	18	160	24	36	50	40	M12x1			318
	SK 40	20	160	26	38	52	42	M16x1			320



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
DCONWS

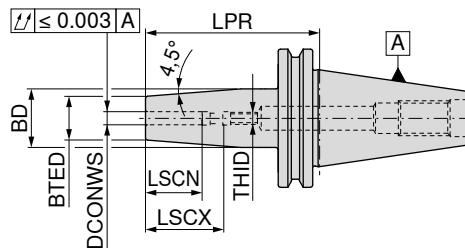
3	
4	
5	
6	
8	
10	
12	
14	
16	
18	
20	

	
Stop screw IK	Backstop screw with internal cooling
CT	CT
83 950 ...	83 950 ...
417	
417	
417	
	418
	419
	420
	421
	421
	422
	422
	424

CoreLine – Heat shrink adapter 4.5° – TG

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
 ▲ **By request:** Also available with Balluff chip

TG



AD/B
 G 2.5 n_{max} 25000

		Adapter	DCONWS	LPR	BTED	BD	LSCX	LSCN	THID		
			mm	mm	mm	mm	mm	mm			
Short	SK 40	3	80	10	17	22	12		M6	84 300 ...	103
	SK 40	4	80	15	22	26	16		M6		104
	SK 40	5	80	15	22	30	20		M6		105
	SK 40	6	80	21	27	36	26		M5		106
	SK 40	8	80	21	27	26	26		M6		108
	SK 40	10	80	24	32	41	31		M8x1		110
	SK 40	12	80	24	32	47	37		M10x1		112
	SK 40	14	80	27	34	47	37		M10x1		114
	SK 40	16	80	27	34	50	40		M12x1		116
	SK 40	18	80	33	42	50	40		M12x1		118
	SK 40	20	80	33	42	52	42		M16x1		120
	SK 40	25	100	44	53	58	48		M16x1		125
Medium length	SK 40	3	120	10	20	12	12			CT	203
	SK 40	4	120	15	22	16	16				204
	SK 40	5	120	15	22	20	20				205
	SK 40	6	120	21	27	36	26		M5		206
	SK 40	8	120	21	27	36	26		M6		208
	SK 40	10	120	24	32	41	31		M8x1		210
	SK 40	12	120	24	32	47	37		M10x1		212
	SK 40	14	120	27	34	47	37		M10x1		214
	SK 40	16	120	27	34	50	40		M12x1		216
	SK 40	18	120	33	42	50	40		M12x1		218
	SK 40	20	120	33	42	52	42		M16x1		220
	SK 40	25	120	44	53	58	48		M16x1		225
Extended	SK 40	3	160	10	20	12	12			CT	303
	SK 40	4	160	15	22	16	16				304
	SK 40	5	160	15	22	20	20				305
	SK 40	6	160	21	27	36	26		M5		306
	SK 40	8	160	21	27	36	26		M6		308
	SK 40	10	160	24	32	41	31		M8x1		310
	SK 40	12	160	24	32	47	37		M10x1		312
	SK 40	14	160	27	34	47	37		M10x1		314
	SK 40	16	160	27	34	50	40		M12x1		316
	SK 40	18	160	33	42	50	40		M12x1		318
	SK 40	20	160	33	42	52	42		M16x1		320
	SK 40	25	160	44	53	58	48		M16x1		325



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
DCONWS

3 - 5	M6x14 - SW2	417	M5x12,5 - SW2,5	418	M2x6	512
6						
8						
10						
12 - 14						
16 - 18						
20 - 25			M16x1x13,5 - SW8	424	M2x6	512



Stop screw IK

CT

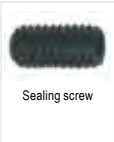
83 950 ...



Backstop screw with internal cooling

CT

83 950 ...



Sealing screw

CT

83 950 ...

Accessories



Shrink fit extension

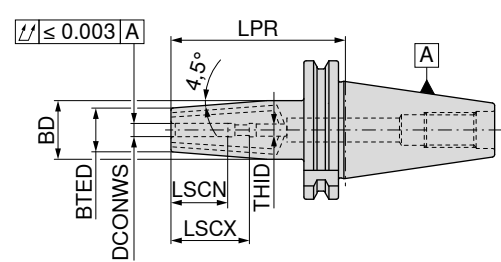


Others



CoreLine – Heat shrink adapter 4.5°

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip



AD/B – 2KMB
G 2.5 n_{max} 25000

Short	Adapter	DCONWS mm	LPR mm	BTED mm	BD mm	LSCX mm	LSCN mm	THID	CT
	SK 40	3	80	10	17	28	12	M6	84 317 ...
	SK 40	4	80	15	22	28	16	M6	103
	SK 40	5	80	15	22	30	20	M6	104
	SK 40	6	80	21	27	36	26	M5	105
	SK 40	8	80	21	27	36	26	M6	106
	SK 40	10	80	24	32	41	31	M8x1	108
	SK 40	12	80	24	32	47	37	M10x1	110
	SK 40	14	80	27	34	47	37	M10x1	112
	SK 40	16	80	27	34	50	40	M12x1	114
	SK 40	18	80	33	42	50	40	M12x1	116
	SK 40	20	80	33	42	52	42	M16x1	118
	SK 40	25	100	44	53	58	48	M16x1	120
	SK 40	32	100	44	53	62	52	M16x1	125
									132



LSCX = maximum insertion depth
LSCN = minimum insertion depth



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
DCONWS

3 - 5			
6			
8			
10			
12 - 14			
16			
18			
20			
25			
32			

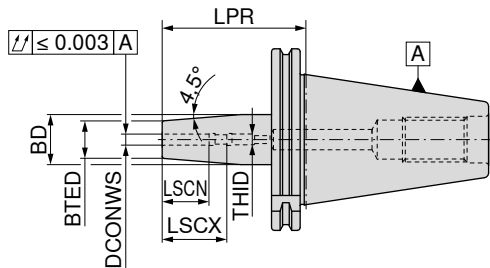
		
Stop screw IK	Backstop screw with internal cooling	Sealing screw
CT	CT	CT
83 950 ...	83 950 ...	83 950 ...
417		512
	418	512
	419	512
	420	512
	421	512
	422	512
510		512
511		512
	424	512
511		512

Accessories

		
Shrink fit extension	Pull stud	Others
→	→	→

CoreLine – Heat shrink adapter 4.5°

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
 ▲ **By request:** Also available with Balluff chip



AD/B
G 2.5 n_{max} 25000

									CT
Adapter									84 301 ...
DCONWS mm									
LPR mm									
BTED mm									
BD mm									
LSCX mm									
LSCN mm									
THID									
Short	SK 50	6	80	21	27	36	26	M5	106
	SK 50	8	80	21	27	36	26	M6	108
	SK 50	10	80	24	32	41	31	M8x1	110
	SK 50	12	80	24	32	47	37	M10x1	112
	SK 50	14	80	27	34	47	37	M10x1	114
	SK 50	16	80	27	34	50	40	M12x1	116
	SK 50	18	80	33	42	50	40	M12x1	118
	SK 50	20	80	33	42	52	42	M16x1	120
	SK 50	25	100	44	53	58	48	M16x1	125
	SK 50	32	100	44	53	62	52	M16x1	132
Medium length	SK 50	6	120	21	27	36	26	M5	206
	SK 50	8	120	21	27	36	26	M6	208
	SK 50	10	120	24	32	41	31	M8x1	210
	SK 50	12	120	24	32	47	37	M10x1	212
	SK 50	14	120	27	34	47	37	M10x1	214
	SK 50	16	120	27	34	50	40	M12x1	216
	SK 50	18	120	33	42	50	40	M12x1	218
	SK 50	20	120	33	42	52	42	M16x1	220
	SK 50	25	120	44	53	58	48	M16x1	225
	SK 50	32	120	44	53	62	52	M16x1	232
Extended	SK 50	6	160	21	27	36	26	M5	306
	SK 50	8	160	21	27	36	26	M6	308
	SK 50	10	160	24	32	41	31	M8x1	310
	SK 50	12	160	24	32	47	37	M10x1	312
	SK 50	14	160	27	34	47	37	M10x1	314
	SK 50	16	160	27	34	50	40	M12x1	316
	SK 50	18	160	33	42	50	40	M12x1	318
	SK 50	20	160	33	42	52	42	M16x1	320
	SK 50	25	160	44	53	58	48	M16x1	325
	SK 50	32	160	44	53	62	52	M16x1	332



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.



Backstop screw with internal cooling

CT

Spare parts
DCONWS

6	418
8	419
10	420
12 - 14	421
16 - 18	422
20 - 32	424

83 950 ...

Accessories

		
Shrink fit extension	Pull stud	Others
→	→	→

CoreLine – Heat shrink adapter 4.5° – TG

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body **without** stop screw

TG

AD/B
G 2.5 n_{max} 25000

Adapter	DCONWS mm	LPR mm	BTED mm	BD mm	LSCX mm	LSCN mm	THID		
Short	SK 40	3	70	12	17.0				
	SK 40	4	70	12	17.0				
	SK 40	5	70	12	17.0				
	SK 40	6	80	21	30.5	36	26	M5	
	SK 40	8	80	21	30.5	36	26	M6	
	SK 40	10	80	24	33.5	41	31	M8x1	
	SK 40	12	80	24	33.5	47	37	M10x1	
	SK 40	14	80	27	36.5	47	37	M10x1	
	SK 40	16	80	27	36.5	50	40	M12x1	
	SK 40	18	80	33	42.5	50	40	M12x1	
	SK 40	20	80	33	42.5	52	42	M16x1	
	SK 40	25	100	44	50.0	58	48	M16x1	
	SK 50	6	80	21	27.0	36	26	M5	
	SK 50	8	80	21	27.0	36	26	M6	
	SK 50	10	80	24	32.0	41	31	M8x1	
	SK 50	12	80	24	32.0	47	37	M10x1	
	SK 50	14	80	27	34.0	47	37	M10x1	
	SK 50	16	80	27	34.0	50	40	M12x1	
	SK 50	18	80	33	42.0	50	40	M12x1	
	SK 50	20	80	33	42.0	52	42	M12x1	
	SK 50	25	100	44	53.0	58	48	M16x1	
	SK 50	32	100	44	53.0	62	52	M16x1	

CX

82 310 ...

10379

10479

10579

10679

10879

11079

11279

11479

11679

11879

12079

12579

10678

10878

11078

11278

11478

11678

11878

12078

12578

13278

→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

CoreLine – Heat shrink adapter 4.5° – TG

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body **without** stop screw

TG

AD/B
G 2.5 n_{max} 25000

	Adapter	DCONWS mm	LPR mm	BTED mm	BD mm	LSCX mm	LSCN mm	THID	
Medium length	SK 40	3	120	12	17.0				82 310 ...
	SK 40	4	120	12	17.0				20379
	SK 40	5	120	12	17.0				20479
	SK 40	6	120	21	31.0	36	26	M5	20579
	SK 40	8	120	21	32.0	36	26	M6	20679
	SK 40	10	120	24	34.0	41	31	M8x1	20879
	SK 40	12	120	24	34.0	47	37	M10x1	21079
	SK 40	16	120	27	36.0	50	40	M12x1	21279
	SK 40	20	120	33	44.0	52	42	M16x1	21679
									22079
	SK 50	6	120	21	27.0	36	26	M5	20678
	SK 50	8	120	21	27.0	36	26	M6	20878
	SK 50	10	120	24	32.0	41	31	M8x1	21078
	SK 50	12	120	24	32.0	47	37	M10x1	21278
	SK 50	14	120	27	34.0	47	37	M10x1	21478
	SK 50	16	120	27	34.0	50	40	M12x1	21678
	SK 50	18	120	33	42.0	50	40	M12x1	21878
	SK 50	20	120	33	42.0	52	42	M16x1	22078
	SK 50	25	120	44	53.0	58	48	M16x1	22578
	SK 50	32	120	44	53.0	62	52	M16x1	23278

→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

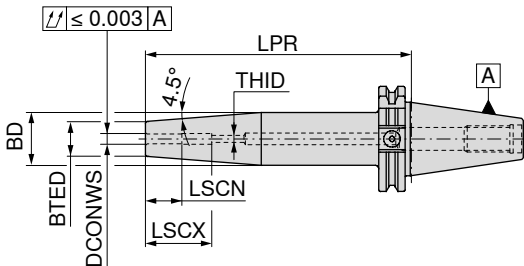
Continued on next page

CoreLine – Heat shrink adapter 4.5° – TG

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body **without** stop screw

TG



AD/B
G 2.5 n_{max} 25000

Adapter									CX
Extended	Adapter	DCONWS mm	LPR mm	BTED mm	BD mm	LSCX mm	LSCN mm	THID	82 310 ...
	SK 40	6	160	21	31.0	36	26	M5	30679
	SK 40	8	160	21	32.0	36	26	M6	30879
	SK 40	10	160	24	34.0	41	31	M8x1	31079
	SK 40	12	160	24	34.0	47	37	M10x1	31279
	SK 40	14	160	27	36.0	47	37	M10x1	31479
	SK 40	16	160	27	36.0	50	40	M12x1	31679
	SK 40	18	160	33	44.0	50	40	M12x1	31879
	SK 40	20	160	33	44.0	52	42	M16x1	32079
	SK 40	25	160	44	50.0	58	48	M16x1	32579
	SK 50	6	160	21	27.0	36	26	M5	30678
	SK 50	8	160	21	27.0	36	26	M6	30878
	SK 50	10	160	24	32.0	41	31	M8x1	31078
	SK 50	12	160	24	32.0	47	37	M10x1	31278
	SK 50	14	160	27	34.0	47	37	M10x1	31478
	SK 50	16	160	27	34.0	50	40	M12x1	31678
	SK 50	18	160	33	42.0	50	40	M12x1	31878
	SK 50	20	160	33	42.0	52	42	M16x1	32078
	SK 50	25	160	44	53.0	58	48	M16x1	32578
	SK 50	32	160	44	53.0	62	52	M16x1	33278



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
DCONWS

6	
8	
10	
12	
14	
16	
18	
20	
25	
32	



Stop screw IK

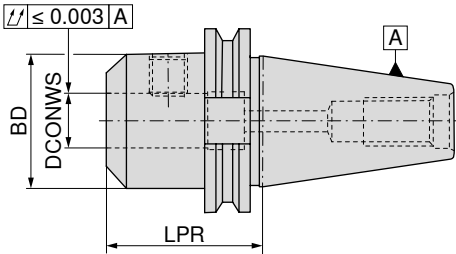
CX

82 950 ...

30000
30100
30200
30300
30300
30400
30400
30500
30500
30500

CoreLine – Cylindrical shank adapter Weldon

- ▲ For shanks according to DIN 6535 HB / 1835 B with lateral clamping flat
- ▲ **By request:** Also available with Balluff chip



AD
G 2.5 n_{max} 25000

	Adapter	DCONWS _{H4}	LPR	BD
		mm	mm	mm
Short	SK 30	6	50	25
	SK 30	8	50	28
	SK 30	10	50	35
	SK 30	12	50	42
	SK 30	14	63	44
	SK 30	16	63	48
	SK 30	18	63	50
	SK 30	20	70	52
Extra short	SK 40	16	35	48
	SK 40	20	35	50
	SK 40	25	40	50
	SK 40	32	75	72

CX
82 401 ...
00600
00800
01000
01200
01400
01600
01800
02000
416
420
425 ¹⁾
43200 ¹⁾

1) Version with two clamping screws

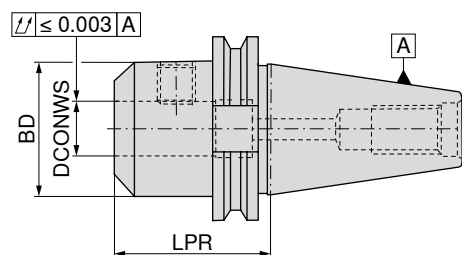


You can find SK 50 adapters and other lengths on the following pages.

CoreLine – Cylindrical shank adapter Weldon

▲ For shanks according to DIN 6535 HB / 1835 B with lateral clamping flat

▲ **By request:** Also available with Balluff chip



AD/B
G 2.5 n_{max} 25000

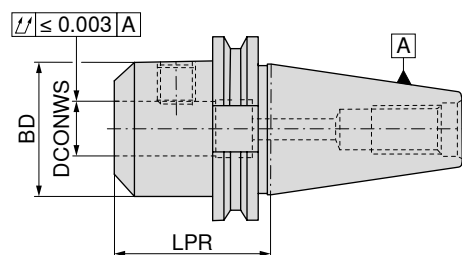
					CX	
					82 401 ...	
Short	Adapter	DCONWS _{H4} mm	LPR mm	BD mm		
	SK 40	6	50	25	106	
	SK 40	8	50	28	108	
	SK 40	10	50	35	110	
	SK 40	12	50	42	112	
	SK 40	14	50	44	114	
	SK 40	16	63	48	116	
	SK 40	18	63	50	118	
	SK 40	20	63	52	120	
	SK 40	25	100	65	125 ¹⁾	
	SK 40	32	100	72	132 ¹⁾	
	SK 40	40	120	90	14000 ¹⁾	
	SK 50	6	63	25	306	
	SK 50	8	63	28	308	
	SK 50	10	63	35	310	
	SK 50	12	63	42	312	
	SK 50	14	63	44	314	
	SK 50	16	63	48	316	
	SK 50	18	63	50	318	
	SK 50	20	63	52	320	
	SK 50	25	80	65	325 ¹⁾	
	SK 50	32	100	72	332 ¹⁾	
	SK 50	40	120	90	34000 ¹⁾	
Medium length	SK 40	6	100	25	506	
	SK 40	8	100	28	508	
	SK 40	10	100	35	510	
	SK 40	12	100	42	512	
	SK 40	14	100	44	514	
	SK 40	16	100	48	516	
	SK 40	18	100	50	518	
	SK 40	20	100	52	520	
	SK 50	6	100	25	70600	
	SK 50	8	100	28	70800	
	SK 50	10	100	35	71000	
	SK 50	12	100	42	71200	
	SK 50	14	100	44	71400	
	SK 50	16	100	48	71600	
	SK 50	18	100	50	71800	
	SK 50	20	100	52	72000	
	SK 50	25	100	65	72500 ¹⁾	

1) Version with two clamping screws

CoreLine – Cylindrical shank adapter Weldon

▲ For shanks according to DIN 6535 HB / 1835 B with lateral clamping flat

▲ **By request:** Also available with Balluff chip



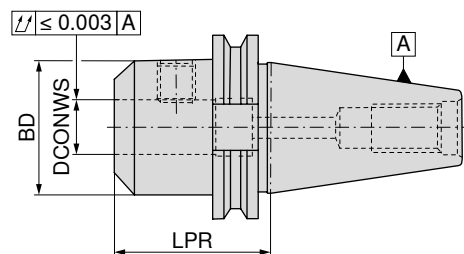
AD/B
G 2.5 n_{max} 25000

					CX
					82 401 ...
Long	Adapter	DCONWS _{H4} mm	LPR mm	BD mm	
	SK 40	6	130	25	206
	SK 40	8	130	28	208
	SK 40	10	130	35	210
	SK 40	12	130	42	212
	SK 40	14	130	44	214
	SK 40	16	130	48	216
	SK 40	18	130	50	218
	SK 40	20	130	52	220
	SK 50	6	130	25	90600
	SK 50	8	130	28	90800
	SK 50	10	130	35	91000
	SK 50	12	130	42	91200
	SK 50	14	130	44	91400
	SK 50	16	130	48	91600
	SK 50	18	130	50	91800
	SK 50	20	130	52	92000
	SK 50	25	130	65	92500 ¹⁾
Extended	SK 40	6	160	25	606
	SK 40	8	160	28	608
	SK 40	10	160	35	610
	SK 40	12	160	42	612
	SK 40	14	160	44	614
	SK 40	16	160	48	616
	SK 40	18	160	50	618
	SK 40	20	160	52	620
	SK 40	25	160	65	625 ¹⁾
	SK 50	6	160	25	80600
	SK 50	8	160	28	80800
	SK 50	10	160	35	81000
	SK 50	12	160	42	81200
	SK 50	14	160	44	81400
	SK 50	16	160	48	81600
	SK 50	18	160	50	81800
	SK 50	20	160	52	82000
	SK 50	25	160	65	82500 ¹⁾
	SK 50	32	160	72	83200 ¹⁾

1) Version with two clamping screws

CoreLine – Cylindrical shank adapter Weldon

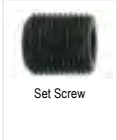
- ▲ For shanks according to DIN 6535 HB / 1835 B with lateral clamping flat
- ▲ With eroded coolant channels
- ▲ **By request:** Also available with Balluff chip



AD/Be
G 2.5 n_{max} 25000

	Adapter	DCONWS _{H4} mm	LPR mm	BD mm	
Short	SK 40	6	50	25	
	SK 40	8	50	28	
	SK 40	10	50	35	
	SK 40	12	50	42	
	SK 40	14	50	44	
	SK 40	16	63	48	
	SK 40	18	63	50	
	SK 40	20	63	52	
	SK 40	25	100	65	
	SK 40	32	100	72	
	SK 40	40	120	80	
	SK 50	6	63	25	
	SK 50	8	63	28	
	SK 50	10	63	35	
	SK 50	12	63	42	
	SK 50	14	63	44	
	SK 50	16	63	48	
	SK 50	18	63	50	
	SK 50	20	63	52	
	SK 50	25	80	65	
	SK 50	32	100	72	
	SK 50	40	120	90	
					CX
					82 404 ...
					106
					108
					110
					112
					114
					116
					118
					120
					125 ¹⁾
					13200 ¹⁾
					54000 ¹⁾
					30600
					30800
					31000
					31200
					31400
					31600
					31800
					32000
					32500 ¹⁾
					33200 ¹⁾
					34000

1) Version with two clamping screws



Spare parts
DCONWS_{H4}

		CT	62 950 ...
6	M6x10		006
8	M8x10		008
10	M10x12		010
12	M12x16		012
14	M12x16		012
16	M14x16		016
18	M14x16		016
20	M16x16		020
25	M18x2x20		025
32	M20x2x20		032
40	M20x2x20		032

Accessories



Pull stud

→

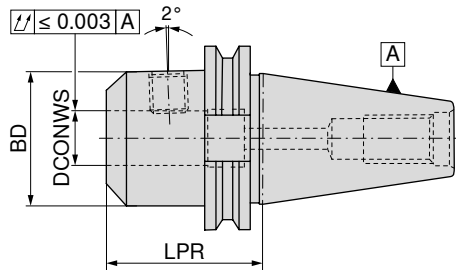


Others

→

CoreLine – Cylindrical shank adapter Whistle Notch

- ▲ For shanks according to DIN 6535 HE / 1835 E with angled clamping flat
- ▲ The groove in the flat face is a characteristic feature of the Whistle Notch version
- ▲ **By request:** Also available with Balluff chip



AD/B
G 2.5 n_{max} 25000

		Adapter	DCONWS _{H4} mm	LPR mm	BD mm		
Short	SK 40		6	50	25	CX	82 407 ...
			8	50	28		106
			10	50	35		108
			12	50	42		110
			14	50	44		112
			16	63	48		114
			18	63	50		116
			20	63	52		118
			25	100	65		120
			32	100	72		12500 ¹⁾
	SK 50		6	63	25		13200 ¹⁾
			8	63	28		30600
			10	63	35		30800
			12	63	42		31000
			14	63	44		31200
			16	63	48		31400
			18	63	50		31600
			20	63	52		31800
			25	80	65		32000
			32	100	72		32500 ¹⁾
Long	SK 40		6	130	25		33200 ¹⁾
			8	130	28		206
			10	130	35		208
			12	130	42		210
			16	130	48		212
			20	130	52		216
			25	130	65		218
	SK 50		6	130	25		220
			8	130	28		225 ¹⁾
			10	130	35		90600
			12	130	42		90800
			16	130	48		91000
			20	130	52		91200
			25	130	65		91600
			32	130	72		92000
	SK 40		6	130	25		92500 ¹⁾
			8	130	28		93200 ¹⁾

1) Version with two clamping screws

				
			Set Screw	Stop screw IK
			CT	CT
Spare parts			62 950 ...	83 950 ...
DCONWS _{H4}				
6	M6x10	006	M5x35	033
8	M8x10	008	M6x35	034
10	M10x12	010	M8x35	035
12 - 14	M12x16	012	M10x35	036
16 - 18	M14x16	016	M12x40	037
20	M16x16	020	M16x45	272
25	M18x2x20	025	M20x35	290
32	M20x2x20	032	M20x35	290

Accessories





Pull stud

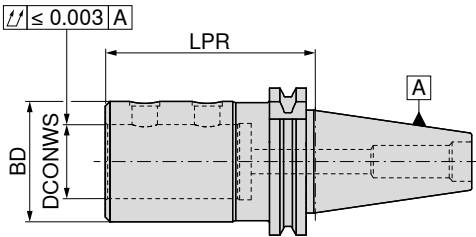
Others

→

→

CoreLine – Indexable insert drill adapter

▲ **By request:** Also available with Balluff chip



AD/B
G 6.3 n_{max} 15000

Adapter	DCONWS mm	LPR mm	BD mm
SK 40	20	80	40
SK 40	25	85	45
SK 40	32	90	52
SK 50	20	80	40
SK 50	25	85	45
SK 50	32	90	52
SK 50	40	90	65
SK 50	50	100	75

CX
10 840 ...
120
125
132
220
225
232
240
250

Spare parts

DCONWS	
20	M10x1x10
25 - 32	M12x1x10
40 - 50	M16x1x12

Set Screw
CX
10 950 ...
001
002
003

Accessories



Pull stud

→



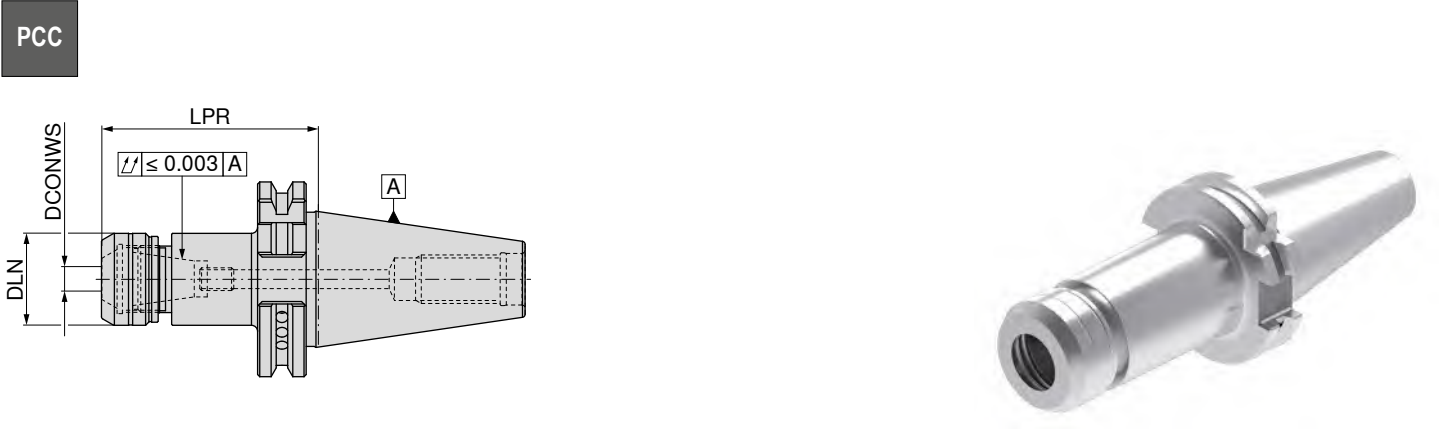
Others

→

CoreLine – ER precision collet chucks – PCC

- ▲ For standard or sealing disc lock nuts
- ▲ Maximum clamping range covered according to ISO tolerance field H10
- ▲ Roll key required for clamping
- ▲ $p_{max} = 100 \text{ bar}$
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body with lock nut and stop screws




AD/B
G 2.5 n_{max} 25000

Adapter	DCONWS mm	LPR mm	DLN mm	for collet
SK 40	1 - 10	70	30	426E (ER16)
SK 40	1 - 10	100	30	426E (ER16)
SK 40	2 - 16	70	40	430E (ER25)
SK 40	2 - 16	100	40	430E (ER25)
SK 40	2 - 20	70	50	470E (ER32)
SK 40	2 - 20	100	50	470E (ER32)
SK 50	2 - 16	70	40	430E (ER25)
SK 50	2 - 16	100	40	430E (ER25)
SK 50	2 - 20	70	50	470E (ER32)
SK 50	2 - 20	100	50	470E (ER32)

CX

82 700 ...
11079
21079
11679
21679
12079
22079
11678
21678
12078
22078



Dimension LPR is 4.5 mm longer for ER16 and ER32 and 5.0 mm longer for ER25 when using thru coolant lock nut

Spare parts
for collet

426E (ER16)
430E (ER25)
470E (ER32)

			
Lock nut IK	Lock nut	Stop screw PCC 2	Stop screw PCC 1
CX	CX	CX	CX
82 950 ...	82 950 ...	82 950 ...	82 950 ...
11000	01000		00100
11600	01600	00200	00300
12000	02000	00200	00300

Accessories

		
ER collet	Sealing disc	Roll key
→	→	→

Dimension LPR is 5.0 mm longer for ER16, ER25 and ER32, and 5.5 mm for ER40 when using thru coolant lock nuts.

Spare parts for collet								
	Lock nut IK	Lock nut	Y clamping key	ER-Mini clamping key	Mini lock nut	Mini lock nut IK	Stop screw IK	Stop screw IK
	CT	CT	CX	CT	CT	CT	CX	CT
	83 950 ...	62 950 ...	83 357 ...	83 950 ...	62 950 ...	83 950 ...	82 950 ...	83 950 ...
	426E (ER16 mini)			101	066	058	30000	
	426E (ER16)	054	054	116				
	430E (ER25)	055	055	125				010
	470E (ER32)	056	65600	132				010
	472E (ER40)	057	65700	140				011

Accessories

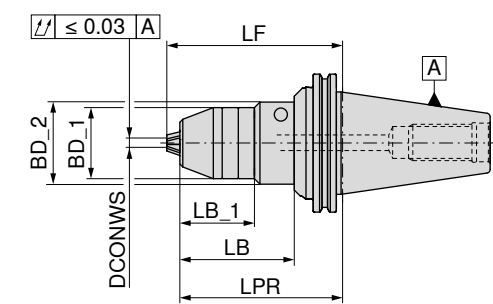
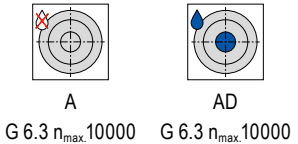
			
ER collet	Sealing disc	Pull stud	Others
→	→	→	→

CoreLine – Short drill chuck – NC 2010

- ▲ Independent of direction of rotation
- ▲ Tightening torque = 12 Nm
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body including clamping key SW4

NC
2010



Adapter	DCONWS mm	LPR mm	BD_1 mm	BD_2 mm	LB_1 mm	LB mm	LF mm
SK 30	0,5 - 10	80	43.0			59.9	89.0
SK 40	0,5 - 13	80	48.5			60.8	89.0
SK 40	2,5 - 16	80	51.0			60.0	90.5
SK 40	2,5 - 16	80	51.0			60.8	90.5
SK 50	0,5 - 13	110	48.5	56	50.9	78.0	119.0
SK 50	0,5 - 13	110	48.5	56	50.9	78.1	119.0
SK 50	2,5 - 16	110	51.0	56	50.9	78.0	120.5
SK 50	2,5 - 16	110	56.0		50.9	78.0	120.5

CX	CX
84 418 ...	84 419 ...
313	
413	413
416	416
	513
513	
	516
516	



Can be used with G 2.5 to 30,000 rpm by subsequent balancing!

Accessories

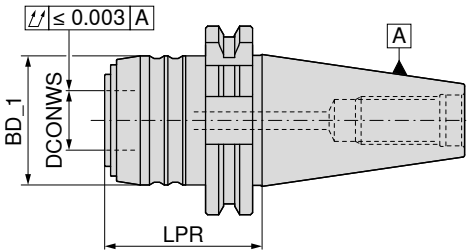
Others

→

CoreLine – Synchro quick change tapping chuck with minimum length compensation

- ▲ With length compensation under tension and compression (LZD)
- ▲ For collets
- ▲ $p_{max.} = 50 \text{ bar}$
- ▲ For synchro use
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Without insert



AD

Adapter	Cutting range	SZID	LPR mm	BD_1 mm	DCONWS mm	LZD± mm
SK 40	M3 - M12	1	53	43	20	1,0 / 0,2
SK 40	M6 - M20	2	90	60	32	1,0 / 0,2
SK 50	M3 - M12	1	53	43	20	1,0 / 0,2
SK 50	M6 - M20	2	74	60	32	1,0 / 0,2

CT
83 416 ...
012
020
112
120

Accessories



Pull stud

→



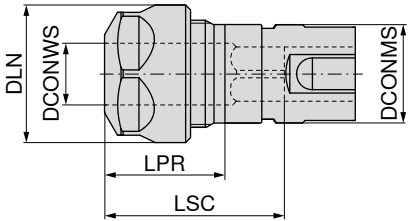
Others

→

Insert for synchro quick change tapping chuck with minimum length compensation

▲ SZID = for insert size

Scope of supply:
Includes lock nut



SZID	DCONWS mm	Cutting range	LPR mm	DLN mm	LSC mm	for collet	DCONMS mm
1	2 - 10	M3 - M12	24	28	42	426E (ER16)	20
2	2 - 16	M6 - M20	28	42	59	430E (ER25)	32

CT
83 608 ...
012 ¹⁾
020

1) With hex nut

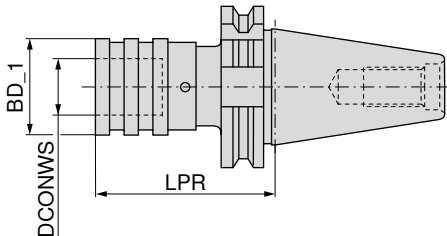
Spare parts
for article number

83 608 012
83 608 020

			
Lock nut SW	Lock nut IK	Lock nut	Y clamping key
CT	CT	CT	CX
62 950 ...	83 950 ...	62 950 ...	83 357 ...
044	054 055	054 055	116 125

CoreLine – Quick change tapping chuck with length compensation

- ▲ With length compensation under tension and compression (LZD)
- ▲ **By request:** Also available with Balluff chip



A

							CT	
Adapter	Cutting range	SZID	LPR mm	BD_1 mm	DCONWS mm	LZD± mm	83 428 ...	
SK 30	M3 - M12	01	60	38	19	9	312	
SK 30	M6 - M20	02	101	55	31	15	320	
SK 40	M3 - M12	01	60	38	19	9	412	
SK 40	M6 - M20	02	100	55	31	15	420	
SK 50	M3 - M12	01	62	38	19	9	512	
SK 50	M6 - M20	02	83	55	31	15	520	

Accessories



Insert

→



Pull stud

→



Others

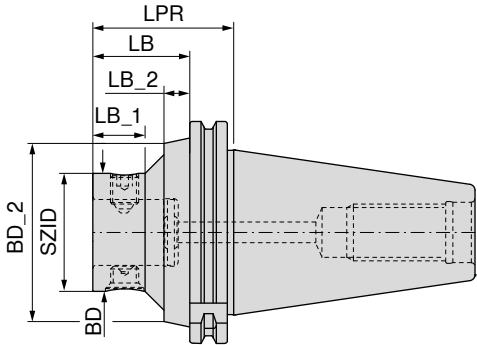
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HyPower – Adapter – ABS

▲ **By request:** Also available with Balluff chip

Scope of supply:
Steep taper adapter (shape B) with conversion kit (shape AD) and sealing disc

ABS







AD/B
G 6.3 n_{max} 8000

Adapter	SZID	BD	LPR	LB	LB_1	LB_2	BD_2
		mm	mm	mm	mm	mm	mm
SK 40	ABS 25	25	50	30.9	20.0	7.9	50
SK 40	ABS 32	32	50	30.9	20.0	7.9	50
SK 40	ABS 40	40	50	30.9	20.0		50
SK 40	ABS 50	50	50	30.9			
SK 40	ABS 63	63	90	70.9		15.9	50
SK 50	ABS 25	25	60	40.9	20.0	12.9	80
SK 50	ABS 32	32	60	40.9	20.0	12.9	80
SK 50	ABS 40	40	60	40.9	20.0	12.9	80
SK 50	ABS 50	50	60	40.9	22.0	10.9	80
SK 50	ABS 63	63	60	40.9	30.4	7.3	80
SK 50	ABS 80	80	70	50.9			
SK 50	ABS 100	100	115	95.9		15.9	80

CT

84 201 ...

04090

04089

04088

04097

04096

05090

05089

05088

05097

05096

05092

05091

Conversion kit – Coolant supply



for	Adapter
4 mm	SK 40 / BT 40
6 mm	SK 50 / BT 50

CT

84 950 ...

23200

23400

Spare parts
SZID

ABS 50				
ABS 25				
ABS 32	M8x1x12/SW4			
ABS 40				
ABS 63				
ABS 80				
ABS 100				

			
Clamping screw	Clamping screw	Set	Taper screw
CT	CT	CT	CT
62 950 ...	84 950 ...	84 950 ...	84 950 ...
	20300	99800	20400
	26800	99700	27000
13989		99600	27100
	26900	99500	27200
	25500	99400	27300
	25700	99300	25200
	25700	99200	25200

Accessories

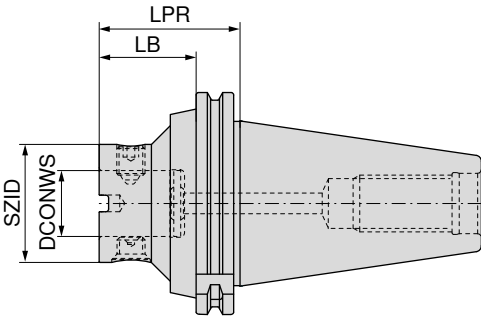
		
Pull stud	Extension	Others
→	→	→

HyPower – Adapter – ABS N

▲ **By request:** Also available with Balluff chip

Scope of supply:
Steep taper adapter (shape B) with conversion kit (shape AD) and sealing disc

ABS N



AD/B
G 6.3 n_{max} 8000

Adapter	SZID	DCONWS	BD_1	BD_2	LPR	BD_2	LB_1	LSC
		mm	mm	mm	mm	mm	mm	mm
SK 50	ABS 50 N	28	50	80	60	80	22.0	31
SK 50	ABS 63 N	34	63	80	60	80	30.4	38
SK 50	ABS 80 N	46			70			43
SK 50	ABS 100 N	56	100	80	115	80		55

CT
84 234 ...
05078
06378
08078
10078

Spare parts

SZID	Clamping screw	Set	Positioning pin	Positioning pin	Taper screw	Sealing disc – ABS
	CT	CT	CT	CT	CT	CT
ABS 50 N	84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...
ABS 63 N	20300	99800	31800	20200	20400	30700
ABS 80 N	25500	99400	31900	23900	27300	30800
ABS 100 N	25600	99300	32000	24000	25100	30900
	25700	99200	32100	24100	25200	31000

Accessories



Pull stud

→



Extension

→



Others

→

HyPower – Eccentric adjuster – ABS

- ▲ Adjustment ±0.010 inch on diameter
- ▲ also available with Balluff chip **on request**

Scope of supply:
Steep taper adapter (shape B) with conversion kit (shape AD) and sealing disc

ABS

AD/B

Adapter	SZID	BD mm	LPR mm	LB mm	LB_1 mm	LB_2 mm	BD_2 mm
SK 40	ABS 50	50	50	30.9			
SK 40	ABS 63	63	90	70.9		15.9	50
SK 50	ABS 50	50	60	40.9	22.0	10.9	80
SK 50	ABS 63	63	60	40.9	30.4	7.3	80

CT

84 204 ...

04097

04096

05097

05096

Spare parts
SZID

ABS 50
ABS 63

 Clamping screw	 Set	 Taper screw
CT	CT	CT
84 950 ...	84 950 ...	84 950 ...
20300	99800	20400
25500	99400	27300

Accessories


Pull stud
→


Extension
→

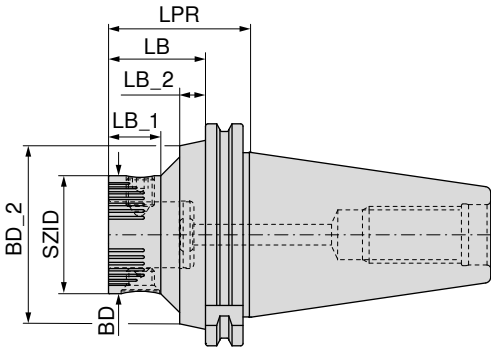

Others
→

HyPower – Torsional vibration damper – ABS

▲ **By request:** Also available with Balluff chip

Scope of supply:
Steep taper adapter (shape B) with conversion kit (shape AD) and sealing disc

ABS






AD/B

Adapter	SZID	BD	LPR	BD_2	LB	LB_1	LB_2
		mm	mm	mm	mm	mm	mm
SK 40	ABS 50	50	50		30.9		
SK 40	ABS 63	63	90	50	70.9		15.9
SK 50	ABS 50	50	60	80	40.9	22.0	10.9
SK 50	ABS 63	63	60	80	40.9	30.4	7.3
SK 50	ABS 80	80	70		50.9		

CT

84 207 ...

04097

04096

05097

05096

05092

Spare parts
SZID

ABS 50
ABS 63
ABS 80

 Clamping screw	 Set	 Taper screw
CT	CT	CT
84 950 ...	84 950 ...	84 950 ...
20300	99800	20400
25500	99400	27300
25600	99300	25100

Accessories

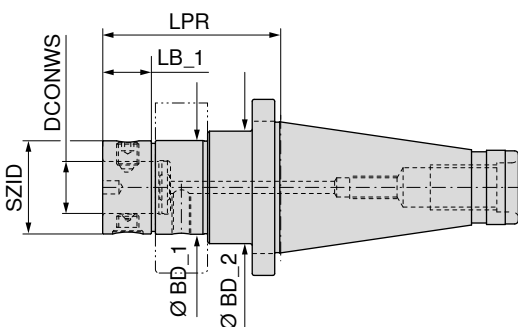
		
Pull stud	Extension	Others
→	→	→

HyPower – Adapter for coolant ring – ABS

- ▲ DIN2080
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Steep taper adapter (shape B) with conversion kit (shape AD) and sealing disc

ABS






AD

Adapter	SZID	DCONWS	BD_1	BD_2	LPR	BD_2	LB_1	LSC
	mm	mm	mm	mm	mm	mm	mm	mm
SK 50	ABS 50	28	50	60	95	60	56	31

CT

84 233 ...

05032

Spare parts
SZID

ABS 50

			
Clamping screw	Set	Taper screw	Sealing disc – ABS
CT	CT	CT	CT
84 950 ...	84 950 ...	84 950 ...	84 950 ...
20300	99800	20400	30700

Accessories

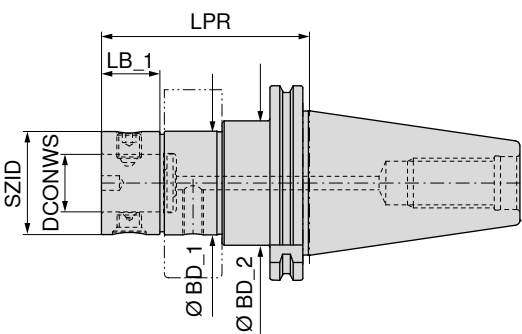
			
Coolant connection with break section	Circlip DIN 471	Sealing ring for coolant ring	Coolant ring
→	→	→	→

HyPower – Adapter for coolant ring – ABS

- ▲ DIN2080
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Steep taper adapter (shape B) with conversion kit (shape AD) and sealing disc

ABS






AD

Adapter	SZID	DCONWS	BD_1	BD_2	LPR	BD_2	LB_1	LSC
		mm	mm	mm	mm	mm	mm	mm
SK 50	ABS 50	28	50	60	100	60	58	31
SK 50	ABS 63	34	63	70	110	70	30	38

CT

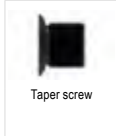
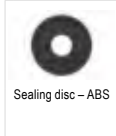
84 233 ...

05078

06378

Spare parts
SZID

ABS 50	20300	99800	20400	30700
ABS 63	25500	99400	27300	30800

			
CT	CT	CT	CT
84 950 ...	84 950 ...	84 950 ...	84 950 ...

Accessories















Pull stud

Extension

Others

Coolant connection with break section

Circlip DIN 471

Sealing ring for coolant ring

Coolant ring

→

→

→

→

→

→

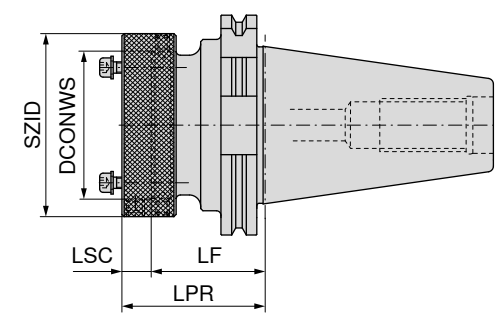
→

HyPower – Compensation holder – DAH

- ▲ Compensation systems for μ -precision run-out
- ▲ Simple correction of run-out and axis errors
- ▲ Optimized for high rpm
- ▲ Designed for internal coolant supply
- ▲ Rotary tools provide long tool life

Scope of supply:
DAH compensation holder complete with assembly screws

DAH



Adapter	SZID	DCONWS mm	LSC mm	LF mm	LPR mm
SK 40	DAH 63	50	12	51	63
SK 40	DAH 81	65	12	51	63
SK 50	DAH 81	65	12	51	63
SK 50	DAH 115	100	16	69	85

CT
84 329 ...
06379
08179
08178
11578

						
			Grub screw	Spring washer	DAH adjustment ring	
			CT	CT	CT	
Spare parts SZID			84 950 ...	84 950 ...	84 950 ...	
DAH 63	M6x8	42700	Ø5,3 - M5	42300	DAH 63	42200
DAH 81	M6x10	42800	Ø5,3 - M5	42300	DAH 81	42000
DAH 115	M8x10	43000	Ø8,4 - M8	42400	DAH 115	42100
						
				Cylindrical screw	Clamping screw	
			CT	AS		
Spare parts SZID			84 950 ...	62 950 ...		
DAH 63			M5x22	42500	M8x6 - SW4	53400
DAH 81			M5x22	42500	M8x6 - SW4	53400
DAH 115			M8X30	42600	M8x8 - SW4	14700

Accessories





Pull stud

Others

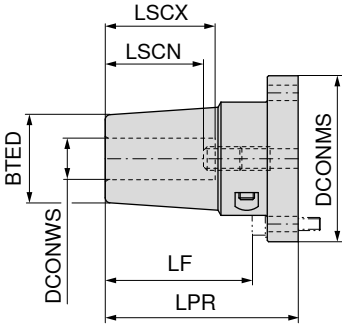
→

→

HyPower – Adapter – DAH

- ▲ Compensation systems for μ-precision run-out
- ▲ Simple correction of run-out and axis errors
- ▲ Optimized for high rpm
- ▲ Designed for internal coolant supply
- ▲ Rotary tools provide long tool life

DAH



AD

Adapter	DCONWS mm	DCONMS mm	BD mm	BTED mm	LB mm	LF mm	LPR mm	LSCN mm	LSCX mm
DAH 63	12	49.5	27	21.0	45	52	70	35	45
DAH 81	12	64.5	32	24.0	45	52	70	35	45
DAH 81	16	64.5	44	34.0	45	57	75	39	49
DAH 81	20	64.5	40	37.0	50	57	75	41	51
DAH 81	25	64.5	50	46.5	52		110	46	56
DAH 81	32	64.5	60	56.5	59		115	51	61

CT

84 327 ...
12600
12800
16800
20800
25800
32800

Accessories



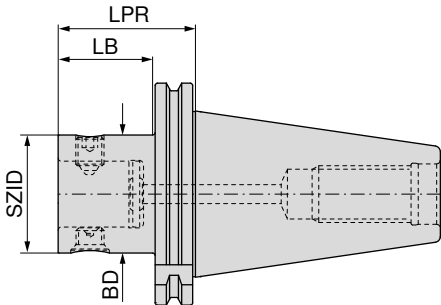
Reduction sleeve



HyPower – Adapter – ABS

- ▲ With face contact
- ▲ **By request:** Also available with Balluff chip

ABS



AD
G 6.3 n_{max} 8000

Adapter	SZID	BD mm	LPR mm	LB mm
SK-FC 50	ABS 50	50	60	40.9
SK-FC 50	ABS 63	63	60	40.9
SK-FC 50	ABS 80	80	70	50.9
SK-FC 50	ABS 100	100	115	95.9

CT
84 264 ...
05073
06373
08073
10073

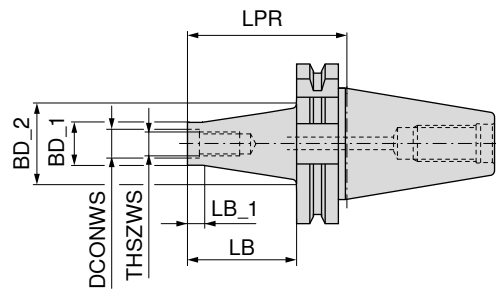
Spare parts SZID

ABS 50
ABS 63
ABS 80
ABS 100

 Clamping screw	 Set	 Taper screw
CT	CT	CT
84 950 ...	84 950 ...	84 950 ...
20300	99800	20400
25500	99400	27300
25600	99300	25100
25700	99200	25200

CoreLine – Adapter for screw-in cutter – Conical

▲ **By request:** Also available with Balluff chip



AD
G 2.5 n_{max} 25000

Adapter	THSZWS	DCONWS mm	LB mm	BD_1 mm	BD_2 mm	LB_1 mm	LPR mm
SK 40	M8	8.5	25	13.8	15	12	44
SK 40	M8	8.5	50	13.8	23	12	69
SK 40	M8	8.5	75	13.8	25	12	94
SK 40	M10	10.5	25	18.0	23	12	44
SK 40	M10	10.5	50	18.0	25	12	69
SK 40	M10	10.5	75	18.0	30	12	94
SK 40	M10	10.5	100	18.0	35	12	119
SK 40	M12	12.5	25	21.0	24	12	44
SK 40	M12	12.5	50	21.0	30	12	69
SK 40	M12	12.5	75	21.0	35	12	94
SK 40	M12	12.5	100	21.0	38	12	119
SK 40	M16	17.0	25	29.0	29	12	44
SK 40	M16	17.0	50	29.0	34	12	69
SK 40	M16	17.0	75	29.0	35	12	94
SK 40	M16	17.0	100	29.0	40	12	119
SK 40	M16	17.0	125	29.0	44	12	144
SK 40	M16	17.0	150	29.0	48	12	169
SK 40	M16	17.0	200	29.0	50	12	219
SK 50	M12	12.5	50	21.0	30	12	69
SK 50	M12	12.5	100	21.0	38	12	119
SK 50	M12	12.5	150	21.0	52	12	169
SK 50	M16	17.0	50	29.0	34	12	69
SK 50	M16	17.0	100	29.0	40	12	119
SK 50	M16	17.0	150	29.0	48	12	169
SK 50	M16	17.0	200	29.0	58	12	219
SK 50	M16	17.0	250	29.0	62	12	269

CX
82 749 ...
08179
08279
08379
10179
10279
10379
10479
12179
12279
12379
12479
16179
16279
16379
16479
16579
16679
16779
12278
12478
12678
16278
16478
16678
16778
16878

Accessories



Extension/reduction

→



Pull stud

→

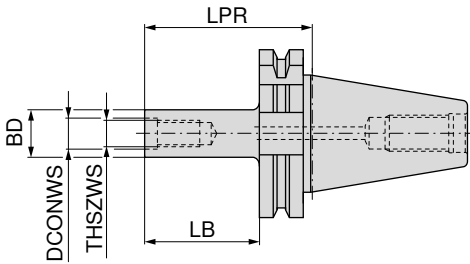
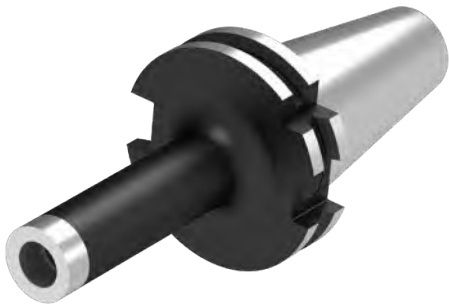


Others

→

CoreLine – Adapter for screw-in cutter – Cylindrical

▲ **By request:** Also available with Balluff chip



AD
G 2.5 n_{max} 25000

Adapter	THSZWS	DCONWS mm	LB mm	BD mm	LPR mm
SK 40	M8	8.5	50	13.8	69
SK 40	M10	10.5	50	18.0	69
SK 40	M10	10.5	75	18.0	94
SK 40	M10	10.5	100	18.0	119
SK 40	M12	12.5	50	21.0	69
SK 40	M12	12.5	75	21.0	94
SK 40	M12	12.5	100	21.0	119
SK 40	M16	17.0	50	29.0	69
SK 40	M16	17.0	75	29.0	94
SK 40	M16	17.0	100	29.0	119

CX
82 750 ...
08279
10279
10379
10479
12279
12379
12479
16279
16379
16479

Accessories



Extension/reduction

→



Pull stud

→



Others

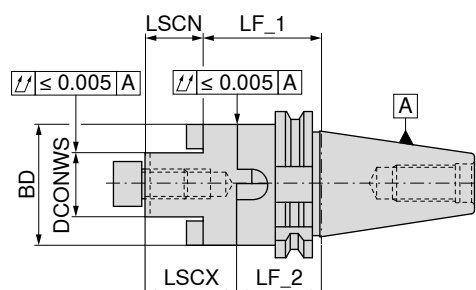
→

CoreLine – Combination shell mill adapter

- ▲ For milling cutters with transverse or longitudinal slot according to DIN 6358
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with clamping screw, drive ring, and parallel key



A

G 2.5 n_{max} 25000

		Adapter	DCONWS mm	LF_1 mm	BD mm	LSCX mm	LSCN mm	LF_2 mm	CX 82 429 ...
Short	SK 30	SK 30	16	50	32	27	17	40	01600
		SK 30	22	50	40	31	19	38	02200
		SK 30	27	55	48	33	21	43	02700
		SK 30	32	60	58	38	24	46	03200
	SK 40	SK 40	16	55	32	27	17	45	116
		SK 40	22	55	40	31	19	43	122
		SK 40	27	55	48	33	21	43	127
		SK 40	32	60	58	38	24	46	132
		SK 40	40	60	70	41	27	46	140 ¹⁾
	SK 50	SK 50	16	55	32	27	17	45	316
		SK 50	22	55	40	31	19	43	322
		SK 50	27	55	48	33	21	43	327
		SK 50	32	55	58	38	24	41	332
		SK 50	40	55	70	41	27	41	340 ¹⁾
		SK 50	50	70	90	46	30	54	350 ¹⁾
	Medium length	SK 40	16	100	32	27	17	90	21600
		SK 40	22	100	40	31	19	88	22200
		SK 40	27	100	48	33	21	88	22700
		SK 40	32	100	58	38	24	86	23200
		SK 40	40	100	70	41	27	86	24000

1) With cross screw

						
		Parallel key	Drive ring	Cross nut key	Retaining screws	Tightening screw
		CT	CX	CX	CX	CT
Spare parts		83 950 ...	83 370 ...	83 368 ...	83 367 ...	83 950 ...
DCONWS						
16	4 x 4 x 20	284	116	116	M8 016	M8x25 113
22	6 x 6 x 25	285	122	122	M10 022	M10x25 124
27	7 x 7 x 25	286	127	127	M12 027	M12x30 125
32	8 x 7 x 28	287	132	132	M16 032	M16x35 126
40	10 x 8 x 32	288	140	140	M20 040	M20x40 - SW17 112
50	12 x 8 x 36	289	150	150	M24 050	

Accessories

		
Pull stud	Milling adapter ring	Others
→	→	→

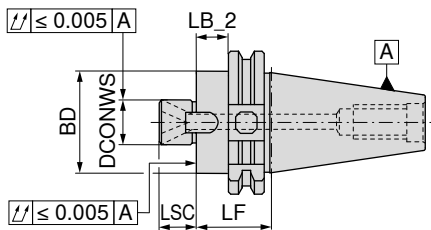
CoreLine – Shell mill adapter with reduced flange diameter

▲ Screwed in drive keys

▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with retaining screw and drive key



AD

G 2.5 n_{max} 25000

	Adapter	DCONWS mm	LB_2 mm	LF mm	BD mm	LSC mm	
Short	SK 40	22	41	60	38	19	82 315 ... 12279 12779 12778 12278
	SK 40	27	25	44	48	21	
	SK 50	27	25	44	48	21	
	SK 50	22	41	60	38	19	
Medium length	SK 40	22	81	100	38	19	22279 22779 22778 22278
	SK 40	27	81	100	48	21	
	SK 50	27	81	100	48	21	
	SK 50	22	81	100	38	19	
Long	SK 40	22	111	130	38	19	32279 32779 32778 32278
	SK 40	27	111	130	48	21	
	SK 50	27	111	130	48	21	
	SK 50	22	111	130	38	19	



These shell mill adapters have been specially developed for MaxiMill 211-KN porcupine cutters. Now they can be clamped perfectly, due to the adapted flange diameters.

Spare parts DCONWS

22	M4x8	51700	10x7x20,5	51500	M10x25	124
27	M5x8	51800	12x9x24,3	51600	M12x30	125



Carrier screws

CT

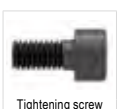
83 950 ...



Drive key

CT

83 950 ...



Tightening screw

CT

83 950 ...

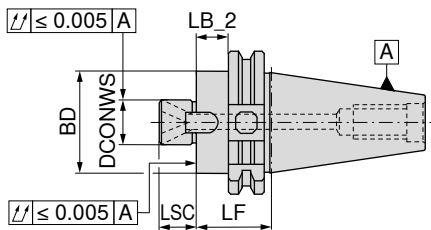
CoreLine – Shell mill adapter

▲ Screwed drive pins

▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with clamping screw



A

G 2.5 n_{max} 25000

AD/B

G 2.5 n_{max} 25000

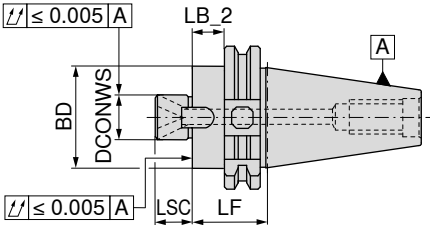
	Adapter	DCONWS mm	LB_2 mm	LF mm	BD mm	LSC mm		
Short	SK 30	16	21.0	40	38	17		
	SK 30	22	14.6	50	48	19		
	SK 30	27	19.3	55	58	21		
	SK 30	32	31.0	50	78	24		
	SK 40	16	25.0	44	38	17		
	SK 40	22	25.0	44	48	19		
	SK 40	27	36.0	55	58	21		
	SK 40	32	31.0	50	78	24		
	SK 40	40	31.0	50	88	27		
	SK 50	16	25.0	44	38	17		
	SK 50	22	25.0	44	48	19		
	SK 50	27	25.0	44	58	21		
	SK 50	32	21.0	40	78	24		
	SK 50	40	31.0	50	88	27		
	SK 40	16	81.0	100	38	17		
	SK 40	22	81.0	100	48	19		
Medium length	SK 40	27	81.0	100	58	21		
	SK 40	32	81.0	100	78	24		
	SK 40	40	81.0	100	88	27		
	SK 50	16	81.0	100	38	17		
	SK 50	22	81.0	100	48	19		
	SK 50	27	81.0	100	58	21		
	SK 50	32	81.0	100	78	24		
	SK 50	40	81.0	100	88	27		
	SK 40	16	111.0	130	38	17		
	SK 40	22	111.0	130	48	19		
Long	SK 40	27	111.0	130	58	21		
	SK 40	32	111.0	130	78	24		
	SK 40	40	111.0	130	88	27		
	SK 50	16	111.0	130	38	17		
	SK 50	22	111.0	130	48	19		
	SK 50	27	111.0	130	58	21		
	SK 50	32	111.0	130	78	24		
	SK 50	40	111.0	130	88	27		
	SK 40	16	111.0	130	38	17		
	SK 40	22	111.0	130	48	19		

1) With cross screw and 4 threaded holes M12 front face, pitch circle diameter = 66.7 mm, coolant outlet on the outer diameter of the spigot (DCONWS)!

CoreLine – Shell mill adapter

- ▲ Screwed drive pins
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body with clamping screw



A
G 2.5 n_{max} 25000

AD/B
G 2.5 n_{max} 25000

Adapter							CX	
							82 428 ...	82 428 ...
Extended	SK 40	16	141.0	160	38	17		516
	SK 40	22	141.0	160	48	19		522
	SK 40	27	141.0	160	58	21		527
	SK 40	32	141.0	160	78	24		532
	SK 40	40	141.0	160	88	27		540 ¹⁾
	SK 50	16	141.0	160	38	17		716
	SK 50	22	141.0	160	48	19		722
	SK 50	27	141.0	160	58	21		727
	SK 50	32	141.0	160	78	24		732
	SK 50	40	141.0	160	88	27		740 ¹⁾

1) With cross screw and 4 threaded holes M12 front face, pitch circle diameter = 66.7 mm, coolant outlet on the outer diameter of the spigot (DCONWS)!

					
			Cross nut key	Retaining screws	Tightening screw
			CX	CX	CT
Spare parts DCONWS			83 368 ...	83 367 ...	83 950 ...
16	116	M8	016	M8x25	113
22	122	M10	022	M10x25	124
27	127	M12	027	M12x30	125
32	132	M16	032	M16x35	126
40	140	M20	040	M20x40 - SW17	112
					
			Carrier screws	Drive key	
			CT	CT	
Spare parts DCONWS			83 950 ...	83 950 ...	
16		M3x8	296	8x9x17,5	120
22		M4x12	297	10x11x20,5	121
27		M5x12	136	12x13x24,3	122
32		M5x20	137	14x21x21,2	123
40		M6x16	138	15,9x16,3x19,5	295

Accessories

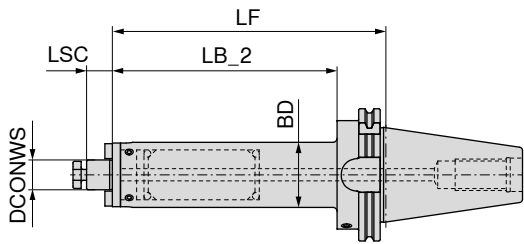
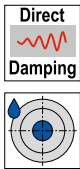
		
Pull stud	Extension	Others
→	→	→

HyPower – Actively vibration-damped shell mill adapter

- ▲ The specially mounted damping core enables perfect machining results even with longer tool overhangs
- ▲ Reduction in machining times due to optimum machining parameters
- ▲ Damped machining and therefore perfect surface qualities
- ▲ Protection of the machine spindle and increased tool life
- ▲ Screwed in drive keys
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with retaining screw and drive key



AD
G 2.5 n_{max} 25000

Adapter	DCONWS mm	LB_2 mm	LF mm	BD mm	LSC mm
SK 40	16	180.9	200	39	17
SK 40	22	180.9	200	48	19
SK 50	16	180.9	200	39	17
SK 50	22	180.9	200	48	19
SK 50	27	180.9	200	58	21

CT
84 752 ...
51679
52279
51678
52278
52778

Spare parts
DCONWS

16	M3x8	296	8x9x17,5	120	M8	016	M8x25	113
22	M4x12	297	10x11x20,5	121	M10	022	M10x25	124
27	M5x12	136	12x13x24,3	122	M12	027	M12x30	125



Carrier screws

CT

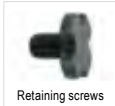
83 950 ...



Drive key

CT

83 950 ...



Retaining screws

CX

83 367 ...



Tightening screw

CT

83 950 ...

Accessories



Pull stud

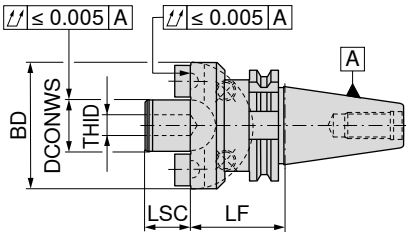


Others

CoreLine – Large diameter shell mill adapter

- ▲ For milling cutters with transverse or longitudinal slot according to DIN 6357
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body with integrated drive pins according to DIN 2079 and 4 clamping screws



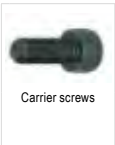
A
G 6.3 n_{max} 8000

Adapter	DCONWS mm	LF mm	BD mm	LSC mm	THID
SK 40	40	60	89	30	M20
SK 50	40	70	89	30	M20
SK 50	60	70	129	40	M30

CX
82 432 ...
040
240
260

Spare parts
DCONWS

40	M6x16	138	15,9x16,3x19,5	295			M12x50	140
60			25,4x25x26,5	298	M12x30 - SW10	181	M16x45	160



Carrier screws

CT

83 950 ...



Drive key

CT

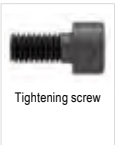
83 950 ...



Socket head screw

AS

70 950 ...



Tightening screw

CT

83 950 ...

Accessories



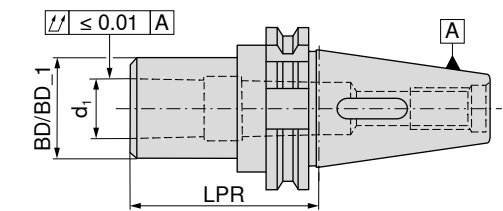
Pull stud



Others

CoreLine – Taper sleeve adapter DIN6383 for DIN 228-2D Morse taper shanks

▲ **By request:** Also available with Balluff chip



AD
G 6.3 n_{max} 8000

						CX	
						82 439 ...	
Short	Adapter	d ₁	LPR mm	BD mm	BD_1 mm		
	SK 30	MK1	50	25		01000	
	SK 30	MK2	63	32		02000	
	SK 30	MK3	80	40		03000	
	SK 40	MK1	50		25	110	
	SK 40	MK2	50		32	120	
	SK 40	MK3	70		40	130	
	SK 40	MK4	95	48		140	
	SK 50	MK1	50		25	310	
	SK 50	MK2	60		32	320	
	SK 50	MK3	65		40	330	
	SK 50	MK4	95		48	340	
	SK 50	MK5	105		63	350	
Medium length	SK 40	MK2	117	32		22000	
	SK 40	MK3	133	40		23000	
	SK 40	MK4	156	48		24000	

Accessories



Morse taper adapter sleeve
→



Pull stud
→



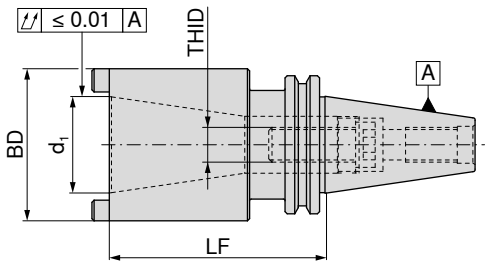
Others
→

CoreLine – Milling adapter sleeve

- ▲ For mounting steep taper adapters according to DIN 2080
- ▲ With an extended clamping screw, adapters compliant with ISO 7388-1 – SK, ISO 7388-2 – MAS-BT, and ANSI-CAT can also be clamped
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with clamping screw for DIN 2080 adapters



A
G 6.3 n_{max} 8000

Adapter	d ₁	LF mm	BD mm	THID
SK 40	SK 30	50	50	M12
SK 40	SK 40	100	70	M16
SK 50	SK 40	80	70	M16
SK 50	SK 50	120	100	M24

CX

82 453 ...

03000

040

240

250

Spare parts for article number										
	CT		CT		CT		CX		CT	
	83 950 ...		83 950 ...		83 950 ...		83 359 ...		83 950 ...	
82 453 03000			18400		030		017		18500	
82 453 040	009				030		023		270	
82 453 240	264									
82 453 250	256				031		133		257	

Auxiliary table for finding the required spare parts and accessories for intermediate sleeves for SK adaptors

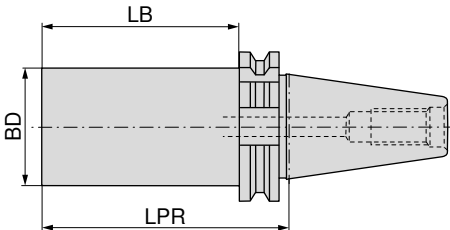
ISO 7388-1	Standard of the SK shank		Clamping screw length								
	Suitable for article no.		THID	Clamping screw SK Article no.		Threaded ring Article no.		Counterscrew Article no.		Hollow key Article no.	
	ISO 7388-1	DIN 2080									
8404013079		SK 30	M12 x 30	83950125	84950127	83950030	83359017				
8404014079	SK40		M16 x 70	83950264	8495043800	83950030	83359023				
8404014079		SK40	M16 x 45	8495043700	8495043800	83950030	83359023				
8404014078	SK40		M16 x 65	8495043600							
8404014078		SK40	M16 x 40	83950009							
8404015078	SK50		M24 x 80	83950256	8495043900	83950030	83359133				
8404015078		SK50	M24 x 50	83950263	8495043900	83950030	83359133				

Accessories

			
Pull stud		Others	
→		→	

CoreLine – Blank

- ▲ Material: Steel 1.7131
- ▲ For the production of special tools
- ▲ Diameter BD turned with 0.5 mm oversize
- ▲ Taper hardened and ground
- ▲ Special tool area in soft state
- ▲ **By request:** Also available with Balluff chip



AD/B

Adapter	BD mm	LPR mm	LB mm
SK 40	63.0	250	231
SK 50	63.5	300	281

CX
82 458 ...
040
050

Accessories



Pull stud

→



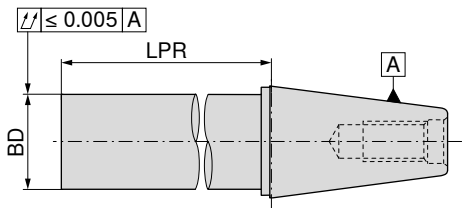
Others

→

CoreLine – Test arbor

- ▲ Without tool change groove
- ▲ Use for MAS BT 40 special pull studs with 3 mm shorter LF dimension, as standard

Scope of supply:
In wooden box



A

Adapter	BD mm	LPR mm
SK / BT 40	40	330
SK / BT 50	50	330

CT
82 456 ...
040
050

Accessories



Pull stud

→



Others

→

Pull studs for adaptors according to ISO 7388-1

- ▲ ISO 7388-3 AD
- ▲ For tools with or without axial coolant supply

Scope of supply:
Including O ring

A

B

Adapter	BD_1 mm	BD_2 mm	BD_3 mm	BD_4 mm	CRKS	OAL mm	LF mm	LB_1 mm	LB_2 mm	CND mm	DRVS mm	TQX Nm
SK 30	13	9	17	13	M12	44	24	19	5	3.5	14	20
SK 40	19	14	23	17	M16	54	26	20	7	7.0	19	50
SK 50	28	21	36	25	M24	74	34	25	10	11.5	30	150
SK 30	13	9	17	13	M12	44	24	19	5		14	20
SK 40	19	14	23	17	M16	54	26	20	7		19	50
SK 50	28	21	36	25	M24	74	34	25	10		30	150

A
CX
82 468 ...
030
040
050

B
CX
82 475 ...

030
040
050

Pull studs for adaptors according to ISO 7388-1

- ▲ Similar to BT 45°, but 3 mm shorter
- ▲ For Haas, Micron, and Hurco machines

Scope of supply:
Including O ring

A

B

Adapter	BD_1 mm	BD_2 mm	BD_3 mm	BD_4 mm	CRKS	OAL mm	LF mm	LB_1 mm	LB_2 mm	CND mm	DRVS mm	TQX Nm
SK 40	15	10	23	17	M16	57	32	25	5	4	19	50
SK 40	15	10	23	17	M16	57	32	25	5		19	50

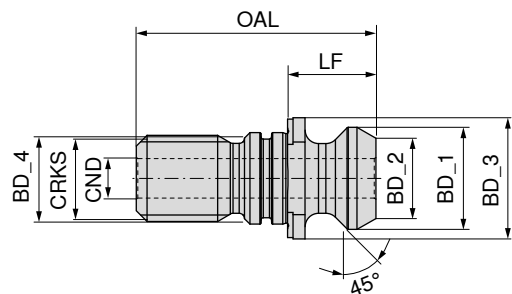
A
CX
83 535 ...
040

B
CX
83 538 ...

040

Pull studs for adaptors according to ISO 7388-1

- ▲ ISO 7388-3 Form UD
- ▲ For tools with axial coolant supply



Adapter	BD_1 mm	BD_2 mm	BD_3 mm	BD_4 mm	CRKS	OAL mm	LF mm	LB_1 mm	CND mm	DRVS mm	TQX Nm
SK 40	18.95	12.95	22.5	17	M16	44.5	16.4	11.15	7.35	19	50

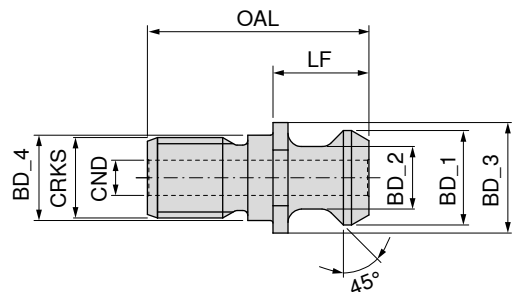
CX

82 469 ...

04000

Pull studs for adaptors according to ANSI-CAT (MAZAK)

- ▲ ANSI – CAT 40
- ▲ Similar to BT 45°, but 3 mm shorter
- ▲ For Mazak machines



Adapter	BD_1 mm	BD_2 mm	BD_3 mm	BD_4 mm	CRKS	OAL mm	LF mm	LB_1 mm	CND mm	DRVS mm	TQX Nm
SK 40	18.796	12.449	22	17	M16	44.106	19.106	14.026	7	19	50

CX

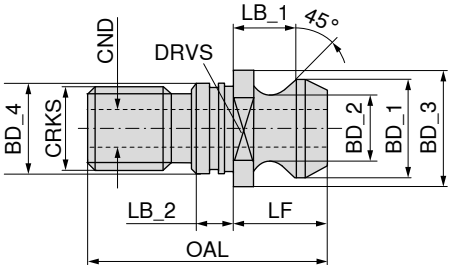
82 469 ...

14000

Pull studs for adaptors according to ISO 7388-1

- ▲ CAT Mazak
- ▲ Face ground flat

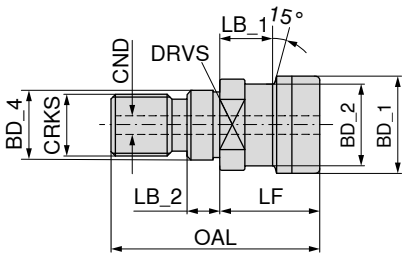
Scope of supply:
SK 50 including O ring, SK 40 without O-ring groove



Adapter													CX	
	BD_1 mm	BD_2 mm	BD_3 mm	BD_4 mm	CRKS	OAL mm	LF mm	LB_1 mm	LB_2 mm	CND mm	DRVS mm	TQX Nm	82 487 ...	
SK 40	18.79	12.44	21.8	17	M16	41.26	16.25	11.17	4.0	7.0	19	50	040	050
SK 50	29.10	19.60	37.0	25	M24	65.50	25.55	17.95	5.5	11.5	30	150		

Pull studs for adaptors according to ISO 7388-1

- ▲ SK 40 with circlip groove and edge protection, with and without internal thread
- ▲ SK 50 with circlip groove, with and without internal thread
- ▲ For tools according to ISO 7388-1 for conversion to DIN 2080

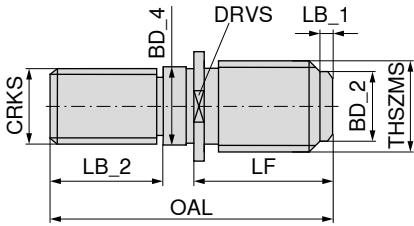


												Without internal thread	With internal thread	
Adapter	BD_1	BD_2	BD_4	CRKS	OAL	LF	LB_1	LB_2	CND	DRVS	TQX		CX	CX
	mm	mm	mm		mm	mm	mm	mm	mm	mm	Nm		82 493 ...	82 494 ...
SK 40	25.0	21.1	17	M16	53	25	13.6	8	7	19	50		040	040
SK 50	39.3	32.0	25	M24	65	25	13.3	10		30	150		050 ¹⁾	050

1) With O ring

Pull studs for adaptors according to ISO 7388-1

▲ DECKEL thread S 20 x 2



Adapter	THSZMS	CRKS	OAL	LF	LB_1	LB_2	BD_2	BD_4	DRVS	<div>CX</div> <div>83 471 ...</div> <div>040</div>
SK 40	S 20 x 2	M16	55	33	4	17	16.7	17	22	

Spare parts
BD_4



<div>CX</div> <div>83 476 ...</div> <div>040</div>
--

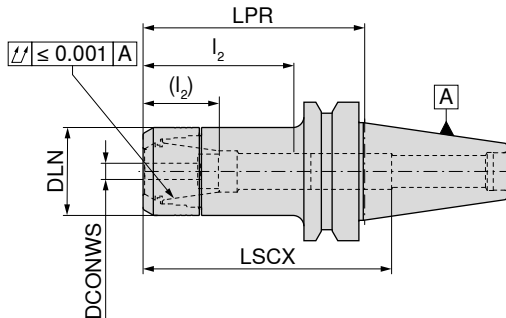
CoreLine – ER precision collet chucks – Centro-P

- ▲ For standard or sealing disc lock nuts
- ▲ Maximum clamping range covered according to ISO tolerance field H10
- ▲ Roll key required for clamping
- ▲ $p_{\max} = 80$ bar
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body **without** lock nut, **without** stop screw

Centro-P



AD

G 2.5 $n_{\max}$ 25000

Adapter	DCONWS mm	LPR mm	DLN mm	LSCX mm	l_2 (l_2) mm	for collet	CT 84 524 ...
BT 30	1 - 10	50	30	73	28 - 44 (16 - 31)	426E (ER16)	001
BT 30	1 - 10	75	30	97	28 - 45 (14 - 31)	426E (ER16)	002
BT 30	1 - 10	100	30	123	28 - 44 (16 - 31)	426E (ER16)	003
BT 30	1 - 10	120	30	112	28 - 45 (14 - 31)	426E (ER16)	004
BT 30	2 - 16	60	40	77	35 - 59 (30 - 42)	430E (ER25)	160
BT 30	2 - 16	75	40	72	38 - 56 (23 - 39)	430E (ER25)	161
BT 30	2 - 16	90	40	87	38 - 56 (23 - 39)	430E (ER25)	162
BT 30	2 - 16	120	40	115	38 - 56 (23 - 39)	430E (ER25)	164
BT 30	2 - 20	60	50	69	42 - 52	470E (ER32)	207
BT 30	2 - 20	75	50	84	42 - 62 (24 - 45)	470E (ER32)	208
BT 30	2 - 20	90	50	94	42 - 62 (24 - 45)	470E (ER32)	209
BT 40	1 - 10	75	30	90	38 - 53 (29 - 39)	426E (ER16)	210
BT 40	1 - 10	90	30	120	30 - 50 (29 - 36)	426E (ER16)	310
BT 40	1 - 10	120	30	140	29 - 45 (29 - 35)	426E (ER16)	410
BT 40	1 - 10	150	30	180	29 - 45 (29 - 32)	426E (ER16)	510
BT 40	1 - 10	200	30	220	29 - 50 (29 - 36)	426E (ER16)	610
BT 40	2 - 16	60	40	92	44 - 64 (36 - 46)	430E (ER25)	116
BT 40	2 - 16	75	40	100	42 - 59 (36 - 41)	430E (ER25)	216
BT 40	2 - 16	90	40	91	42 - 59 (36 - 41)	430E (ER25)	316
BT 40	2 - 16	105	40	100	35 - 60 (20 - 42)	430E (ER25)	168
BT 40	2 - 16	120	40	91	40 - 65 (36 - 47)	430E (ER25)	416
BT 40	2 - 16	150	40	100	40 - 64 (36 - 45)	430E (ER25)	516
BT 40	2 - 16	200	40	150	40 - 64 (36 - 45)	430E (ER25)	616



LSCX = Clamping depth without stop screw

l_2 = Clamping depth with stop screw type 1, dimension in brackets (l_2) = Clamping depth with stop screw type 2

Dimension LPR is 3 mm longer when using lock nuts with sealing discs



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

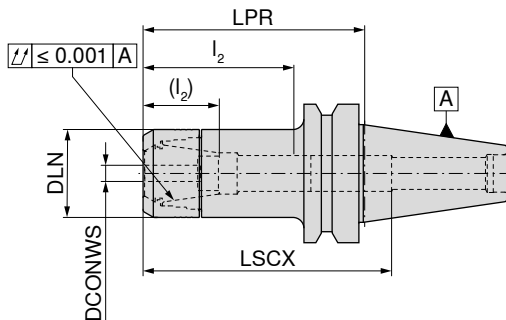
CoreLine – ER precision collet chucks – Centro-P

- ▲ For standard or sealing disc lock nuts
- ▲ Maximum clamping range covered according to ISO tolerance field H10
- ▲ Roll key required for clamping
- ▲ $p_{\max} = 80$ bar
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body **without** lock nut, **without** stop screw

Centro-P



AD

G 2.5 $n_{\max}$ 25000

Adapter	DCONWS mm	LPR mm	DLN mm	LSCX mm	l_2 (l_2) mm	for collet	CT
BT 40	2 - 20	60	50	55	45 - 64 (42 - 46)	470E (ER32)	84 524 ...
BT 40	2 - 20	75	50	100	42 - 76 (42 - 52)	470E (ER32)	120
BT 40	2 - 20	90	50	100	42 - 76 (42 - 52)	470E (ER32)	220
BT 40	2 - 20	120	50	110	42 - 71 (42 - 53)	470E (ER32)	320
BT 40	2 - 20	150	50	110	42 - 71 (42 - 53)	470E (ER32)	420
							520
BT 40	3 - 26	75	63	78	54 - 59	472E (ER40)	226
BT 40	3 - 26	105	63	93	55 - 71 (48 - 53)	472E (ER40)	326
BT 50	2 - 20	75	50	110	45 - 70 (42 - 53)	470E (ER32)	720
BT 50	2 - 20	105	50	140	45 - 63 (42 - 45)	470E (ER32)	820
BT 50	2 - 20	165	50	200	45 - 74 (42 - 56)	470E (ER32)	920
BT 50	3 - 26	75	63	100	48 - 58	472E (ER40)	726
BT 50	3 - 26	105	63	100	48 - 58	472E (ER40)	826



LSCX = Clamping depth without stop screw

l_2 = Clamping depth with stop screw type 1, dimension in brackets (l_2) = Clamping depth with stop screw type 2

Dimension LPR is 3 mm longer when using lock nuts with sealing discs

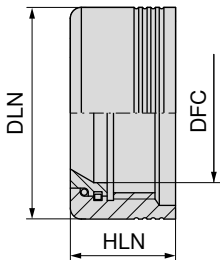


→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

HyPower – ER lock nut for precision collet chucks – Centro-P

- ▲ with thrust collar and angular contact ball bearing
- ▲ Excellent damping and clamping force
- ▲ High-precision lock nut for a perfect fit
- ▲ Run-out ≤ 3 µm with ER precision collets (blue ring)

Centro-P



for collet	DCONWS mm	HLN mm	DFC mm	DLN mm	CT 84 728 ... 05000 06300
470E (ER32)	2 - 20	26.5	32	50	
472E (ER40)	3 - 26	31.0	40	63	

Spare parts for collet

	HyPower – Lock nuts CT 84 728 ... 05000 06300	Lock nut IK CT 84 950 ... 011 013 015 017	Lock nut CT 84 950 ... 001 003 005 007		Stop screw 2 CT 83 950 ... 341 432 402		Stop screw 1 CT 83 950 ... 337 431 401 400
426E (ER16)		011	001	M11x1 - SW6	341	M11x1 - SW6	337
430E (ER25)		013	003	M18x1,5 - SW6	432	M18x1,5 - SW6	431
470E (ER32)	05000	015	005	M22x1,5 - SW6	402	M22x1,5 - SW6	401
472E (ER40)	06300	017	007			M28x1,5 - SW6	400

Accessories



ER collet

→



Sealing disc

→



Roll key

→



Roll key device

→



Pull stud

→



Others

→

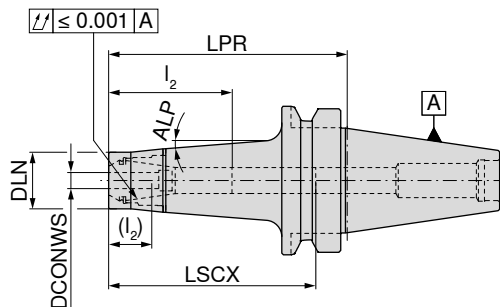
CoreLine – ER precision tapered collet chuck – Centro-P

- ▲ For special tapered nuts
- ▲ Maximum clamping range covered according to ISO tolerance field H10
- ▲ Roll key required for clamping
- ▲ $p_{\max} = 80$ bar
- ▲ **On request:** Also available with Balluff chip

Scope of supply:

Base body **without** lock nut, **without** stop screw

Centro-P



AD/B
G 2.5 $n_{\max}$ 25000

Adapter	DCONWS mm	LPR mm	DLN mm	LSCX mm	l_2 (l_2) mm	for collet	ALP
BT 40	1 - 10	100	24	72	28 - 48 (20 - 35)	426E (ER16)	4.5°
BT 40	1 - 10	135	24	165	28 - 48 (20 - 35)	426E (ER16)	4.5°
BT 40	1 - 10	160	24	180	28 - 48 (20 - 35)	426E (ER16)	4.5°

CT

84 517 ...

410

31000

510



LSCX = Clamping depth without stop screw

l_2 = Clamping depth with stop screw type 1, dimension in brackets (l_2) = Clamping depth with stop screw type 2

Dimension LPR is 4 mm longer when using lock nuts with sealing discs



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts for collet	Tapered lock nut IK				Lock nut IK		Lock nut		Stop screw 2	Stop screw 1
	CT	CT	CT	CT	CT	CT	CT	CT	CT	CT
	84 950 ...	84 950 ...	84 950 ...	84 950 ...	83 950 ...	83 950 ...	83 950 ...	83 950 ...	83 950 ...	83 950 ...
426E (ER16)	033	031	011	001	M11x1 - SW6	341	M11x1 - SW6	337	M11x1 - SW6	337
426E (ER16)	033	031	011	001	M11x1 - SW6	341	M11x1 - SW6	337	M11x1 - SW6	337

Accessories

ER collet	Sealing disc	Roll key	Roll key device	Pull stud	Others
→	→	→	→	→	→

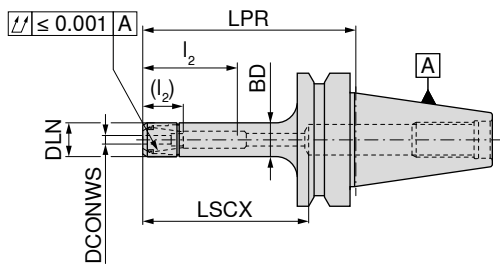
CoreLine – ER precision collet chuck, slim version – Centro-P

- ▲ For mini lock nuts
- ▲ Maximum clamping range covered according to ISO tolerance field H10
- ▲ Roll key required for clamping
- ▲ $p_{\max} = 80$ bar
- ▲ **On request:** Also available with Balluff chip

Scope of supply:

Base body **without** lock nut, **without** stop screw

Centro-P



AD

G 2.5 $n_{\max}$ 25000



AD/B

G 2.5 $n_{\max}$ 25000

Adapter	DCONWS mm	LPR mm	DLN mm	BD mm	LSCX mm	l_2 (l_2) mm	for collet	CT 84 507 ...	CT 84 508 ...
BT 30	1 - 7	50	16	16	68	18 - 32 (12 - 22)	4008E (ER11)	007	
BT 30	1 - 7	100	16	16	68	18 - 36 (12 - 26)	4008E (ER11)	008	
BT 40	1 - 7	75	16	16	100	15 - 30 (8 - 21)	4008E (ER11)		307
BT 40	1 - 7	90	16	16	68	18 - 36 (12 - 26)	4008E (ER11)		40600
BT 40	1 - 7	120	16	16	140	15 - 30 (8 - 21)	4008E (ER11)		507
BT 40	1 - 7	150	16	16	68	18 - 36 (12 - 26)	4008E (ER11)		90600
BT 40	1 - 10	75	22	22	100	27 - 49 (16 - 32)	426E (ER16)		216
BT 40	1 - 10	90	22	22	115	27 - 49 (16 - 32)	426E (ER16)		316
BT 40	1 - 10	120	22	22	145	27 - 49 (16 - 32)	426E (ER16)		416
BT 40	1 - 10	150	22	22	175	27 - 49 (16 - 32)	426E (ER16)		516



LSCX = Clamping depth without stop screw

l_2 = Clamping depth with stop screw type 1, dimension in brackets (l_2) = Clamping depth with stop screw type 2

Dimension LPR is 4 mm longer when using lock nuts with sealing discs



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts for collet								
	CT		CT		CT		CT	
	84 950 ...		84 950 ...		83 950 ...		83 950 ...	
4008E (ER11)			041		M8x1 - SW4		M8x1 - SW4	
426E (ER16)	035		034		M11x1 - SW6		M11x1 - SW6	

Accessories

						
ER collet	Sealing disc	Removal aid	Roll key	Roll key device	Pull stud	Others
→	→	→	→	→	→	→

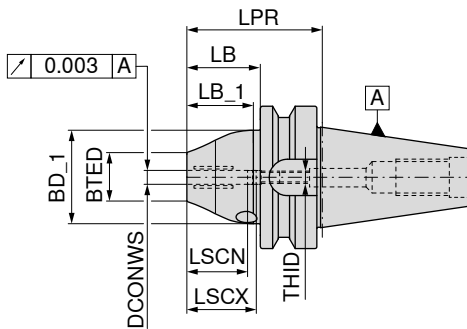
HyPower – High pressure chuck – Rough

- ▲ High pressure chuck – especially for milling
- ▲ Ideal for HSC and HPC applications
- ▲ High temperature resistance
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with backstop screw and pressure screw

Rough



AD
G 2.5 n_{max} 25000



AD/B
G 2.5 n_{max} 25000

Adapter	DCONWS mm	LPR mm	BTED mm	BD_1 mm	LB_1 mm	LB mm	LSCX mm	LSCN mm	THID
BT 30	6	54.0	26.0	46	29.0	32.0	37	27	M5
BT 30	8	54.0	28.0	46	29.0	32.0	37	27	M6
BT 30	10	54.0	30.0	50	21.0	32.0	41	31	M8x1
BT 30	12	54.0	32.0	50	21.0	32.0	46	36	M10x1
BT 30	16	69.0	38.0	55	36.0	47.0	49	39	M12x1
BT 30	20	69.0	38.0	58	36.0	47.0	51	41	M12x1
BT 40	6	58.0	26.0	42	27.2	31.0	37	27	M5
BT 40	8	58.0	28.0	42	27.2	31.0	37	27	M6
BT 40	10	58.0	30.0	42	27.2	31.0	41	31	M8x1
BT 40	12	58.0	32.0	49	27.2	31.0	46	36	M10x1
BT 40	16	72.5	38.0	49	41.7	45.5	49	38	M12x1
BT 40	20	72.5	38.0	49	41.7	45.5	51	41	M16x1
BT 40	25	100.0	48.0	57	44.6	75.0	57	47	M16x1
BT 40	32	105.0	58.5	62	50.0	80.0	61	51	M16x1

CT
84 254 ...
10670
10870
11070
11270
11670
12070

CT
84 254 ...
10669
10869
11069
11269
11669
12069
12569
13269



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

								
				AS		CT		CT
Spare parts DCONWS				80 397 ...		83 950 ...		83 950 ...
6	SW5	050	M10x12			55000	M5x12,5 - SW2,5	418
8	SW5	050	M10x12			55000	M6x12,5 - SW3	419
10	SW5	050	M10x12			55000	M8x1x13,5 - SW3	420
12	SW5	050	M10x12			55000	M10x1x13,5 - SW5	421
16	SW5	050	M10x12			55000	M12x1x13,5 - SW5	422
20	SW5	050	M10x12			55000	M12x1x13,5 - SW5	422
20	SW5	050	M10x12			55000	M16x1x13,5 - SW8	424
25	SW5	050	M10x12			55000	M10x1x13,5 - SW5	421
32	SW5	050	M10x12			55000	M10x1x13,5 - SW5	421

Accessories

		
Reduction sleeve	Pull stud	Others
→	→	→

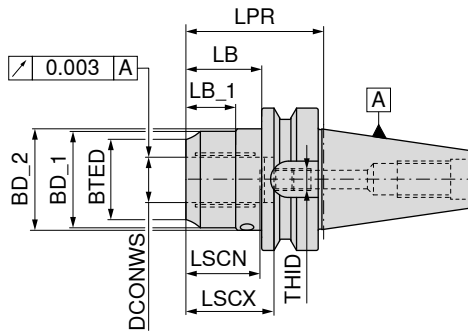
HyPower – High pressure chuck – Complus

- ▲ High pressure chuck, short and stable version
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with stop screw and pressure screw

Complus



AD/B
G 2.5 n_{max} 25000

Adapter	DCONWS mm	LPR mm	BTED mm	BD_1 mm	BD_2 mm	LB mm	LB_1 mm	LSCX mm	LSCN mm	THID
BT 40	20	72.5	38					51	40	M16x1x13,5
BT 40	32	90.0	54	63		63.0		61	51	M16x1x13,5
BT 50	20	83.5	38	49		45.5		51	41	M16x1x13,5
BT 50	32	90.0	57	68	72	52.0	35	61	51	M16x1x13,5

CT
83 513 ...
120
13269
12068
13268

 LSCX = maximum insertion depth
LSCN = minimum insertion depth

 → Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts for article number		Cylindrical screw		Clamping key T		Pressure screw		Backstop screw with internal cooling	
		CT		AS		CT		CT	
		83 950 ...		80 397 ...		83 950 ...		83 950 ...	
83 513 13269	M5x5 - SW2,5	157	SW5	050	M10x1x14	429	M16x1x13,5 - SW8	424	
83 513 12068	M5x5 - SW2,5	157	SW5	050	M10x1x14	429	M16x1x13,5 - SW8	424	
83 513 13268	M5x5 - SW2,5	157	SW5	050	M10x1x14	429	M16x1x13,5 - SW8	424	

Accessories



Reduction sleeve

Pull stud

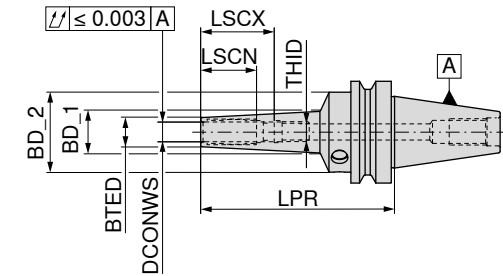
Others

HyPower – High pressure chuck – Access 3°

- ▲ High pressure chuck, slim version 3°
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with stop screw, pressure screw, and cylindrical screw



AD/B
G 2.5 n_{max} 25000

										CT
										83 522 ...
Medium length	Adapter	DCONWS mm	LPR mm	BTED mm	BD_1 mm	BD_2 mm	LSCX mm	LSCN mm	THID	
	BT40	3	120	9	16.55	49.5	28	12	M3	103
	BT40	4	120	10	17.55	49.5	28	16	M3	104
	BT40	5	120	11	18.55	49.5	28	20	M3	105
	BT40	6	120	12	19.55	49.5	37	27	M5	106
	BT40	8	120	14	21.55	49.5	37	27	M6	108
	BT40	10	120	16	23.65	49.5	41	31	M8x1	110
	BT40	12	120	18	25.76	49.5	46	36	M10x1	112
	BT40	16	120	24	31.45	49.5	49	39	M12x1	116
	BT40	20	120	28	35.55	49.5	51	41	M16x1	120
	BT40	6	160	16	33.53	49.5	37	27	M5	206
	BT40	8	160	18	34.60	49.5	37	27	M6	208
	BT40	10	160	20	36.27	49.5	41	31	M8x1	210
	BT40	12	160	22	37.88	49.5	46	36	M10x1	212
	BT40	6	200	16	37.88	49.5	37	27	M5	306
	BT40	8	200	18	38.90	49.5	37	27	M6	308
	BT40	10	200	20	40.57	49.5	41	31	M8x1	310
	BT40	12	200	22	42.18	49.5	46	36	M10x1	312



LSCX = maximum insertion depth
LSCN = minimum insertion depth



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts DCONWS		 Cylindrical screw		 Clamping key T		 Pressure screw		 Backstop screw with internal cooling	
		CT		AS		CT		CT	
		83 950 ...		80 397 ...		83 950 ...		83 950 ...	
3	M5x5 - SW2,5	157	SW5	050	M10x1x10	158	M3x20 - SW1,5	172	
4	M5x5 - SW2,5	157	SW5	050	M10x1x10	158	M3x20 - SW1,5	172	
5	M5x5 - SW2,5	157	SW5	050	M10x1x10	158	M3x20 - SW1,5	172	
6	M5x5 - SW2,5	157	SW5	050	M10x1x10	158	M5x12,5 - SW2,5	418	
8	M5x5 - SW2,5	157	SW5	050	M10x1x10	158	M6x12,5 - SW3	419	
10	M5x5 - SW2,5	157	SW5	050	M10x1x12	159	M8x1x13,5 - SW3	420	
12	M5x5 - SW2,5	157	SW5	050	M10x1x12	159	M10x1x13,5 - SW5	421	
16	M5x5 - SW2,5	157	SW5	050	M10x1x12	159	M12x1x13,5 - SW5	422	
20	M5x5 - SW2,5	157	SW5	050	M10x1x12	159	M16x1x13,5 - SW8	424	

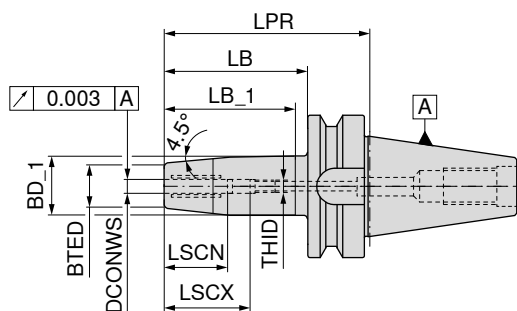
HyPower – High pressure chuck – Access 4,5°

- ▲ High pressure chuck with slim contour, original dimensions of a 4.5° shrink contour
- ▲ Especially for reaming and drilling applications
- ▲ Ideal for tool and die production
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with backstop screw and pressure screw

Access
4,5°



AD

G 2.5 n_{max} 25000



AD/B

G 2.5 n_{max} 25000

Adapter	DCONWS mm	LPR mm	BTED mm	BD_1 mm	LB_1 mm	LB mm	LSCX mm	LSCN mm	THID
BT 30	6	85	21	27	57.7	65	37	27	M5
BT 30	8	85	21	27	57.7	65	37	27	M6
BT 30	10	85	24	32	57.7	65	41	31	M8X1
BT 30	12	85	24	32	57.7	65	46	36	M10X1
BT 30	16	85	27	34	57.2	65	49	39	M10X1
BT 30	20	85	33	42	57.5	65	51	41	M10X1
BT 40	6	90	21	27	57.7	63	37	27	M5
BT 40	8	90	21	27	57.7	63	37	27	M6
BT 40	10	90	24	32	57.7	63	41	31	M8x1
BT 40	12	90	24	32	57.7	63	46	36	M10x1
BT 40	16	90	27	34	57.2	63	49	39	M12x1
BT 40	20	90	33	42	57.5	63	51	41	M16x1
BT 40	6	120	21	27	48.9	95	37	27	M5
BT 40	8	120	21	27	48.9	95	37	27	M6
BT 40	10	120	24	32	61.6	95	41	31	M8X1
BT 40	12	120	24	32	61.6	95	46	36	M10X1
BT 40	16	120	27	34	56.2	95	49	39	M12X1
BT 40	20	120	33	42	68.9	95	51	41	M16X1

CT	CT
84 255 ...	84 255 ...
10670	
10870	
11070	
11270	
11670	
12070	
	10669
	10869
	11069
	11269
	11669
	12069
	20669
	20869
	21069
	21269
	21669
	22069



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

							
				Clamping key T	Pressure screw	Backstop screw with internal cooling	
				AS	CT	CT	
Spare parts DCONWS				80 397 ...	83 950 ...	83 950 ...	
6	SW5	050	M10x12		55000	M5x12,5 - SW2,5	418
8	SW5	050	M10x12		55000	M6x12,5 - SW3	419
10	SW5	050	M10x12		55000	M8x1x13,5 - SW3	420
12	SW5	050	M10x12		55000	M10x1x13,5 - SW5	421
16	SW5	050	M10x12		55000	M12x1x13,5 - SW5	422
20	SW5	050	M10x12		55000	M16x1x13,5 - SW8	424

Accessories

		
Reduction sleeve	Pull stud	Others
→	→	→

CoreLine – Hydraulic chuck – Fit

- ▲ Hydraulic chuck, short and slim version
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body with stop screw and pressure screw



AD/B

G 2.5 n_{max} 25000

Adapter	DCONWS	LPR	BD_1	BD_2	LSCX	LSCN	LB_1	THID
	mm	mm	mm	mm	mm	mm	mm	
BT 40	6	90	26	49.5	37	27	29	M5
BT 40	8	90	28	49.5	37	27	30	M6
BT 40	10	90	30	49.5	41	31	35	M8x1
BT 40	12	90	32	49.5	46	36	40	M10x1
BT 40	16	90	38	49.5	49	39	45	M12x1
BT 40	20	90	42	49.5	51	41	47	M16x1
BT 40	25	90	55	52.0	57	47	50	M16x1
BT 40	32	90	63	62.0	61	51	48	M16x1
BT 50	6	90	26	49.5	37	27	29	M5
BT 50	8	90	28	49.5	37	27	30	M6
BT 50	10	90	30	49.5	41	31	34	M8x1
BT 50	12	90	32	49.5	46	36	34	M10x1
BT 50	16	90	38	49.5	49	39	35	M12x1
BT 50	20	90	42	49.5	51	41	35	M16x1
BT 50	25	110	55	63.0	57	47	48	M16x1
BT 50	32	110	63	70.0	61	51	50	M16x1

CT

83 521 ...

106

108

110

112

116

120

125

132

306

308

310

312

316

320

325

332

→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

		 Pressure screw		 Stop screw IK		 Backstop screw with internal cooling	
		CT		CT		CT	
Spare parts DCONWS		83 950 ...		83 950 ...		83 950 ...	
6	M8x1x10	439				M5x12,5 - SW2,5	418
8	M8x1x10	439	M6x14 - SW2	417		M6x12,5 - SW3	419
10	M10x1x12	440				M8x1x13,5 - SW3	420
12	M10x1x12	440				M10x1x13,5 - SW5	421
16	M10x1x12	440				M12x1x13,5 - SW5	422
20 - 32	M10x1x12	440				M16x1x13,5 - SW8	424

Accessories

		
Reduction sleeve	Pull stud	Others
→	→	→

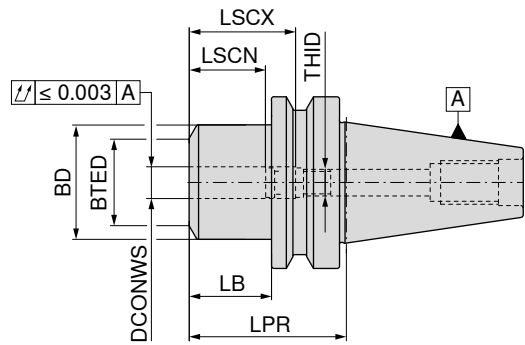
CoreLine – Hydraulic chuck – Compact

- ▲ Hydraulic chuck, short and stable version
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with stop screw and pressure screw

Compact



AD
G 2.5 n_{max} 25000

Adapter	DCONWS mm	LPR mm	BD mm	BTED mm	LB mm	LSCN mm	LSCX mm	THID
BT 40	12	58.0	42	32	31.0	36	46	M8x1
BT 40	20	72.5	49	38	45.5	41	51	M16x1
BT 50	20	83.5	49	38	45.5	41	51	M16x1

CT
83 430 ...
01269
02069
02068



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

**Spare parts
for article number**

83 430 01269
83 430 02069
83 430 02068

AS	CT	CT
80 397 ...	83 950 ...	83 950 ...
050	158	420
050	158	424
050	158	424

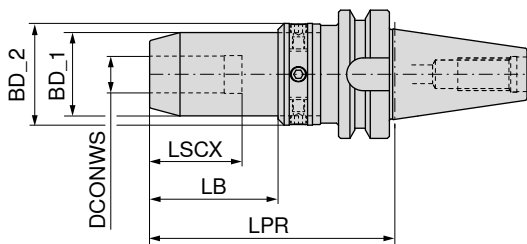
Accessories

Reduction sleeve	Pull stud	Others
→	→	→

HyPower – Compensation holder – DAH

- ▲ Tried-and-tested hydraulic expansion clamping technology
- ▲ Maximum radial run-out accuracy and repeatability < 1 µ ensures consistent cutting action
- ▲ Very simple run-out adjustment
- ▲ Compact design
- ▲ Unbeatable vibration damping, meaning outstanding surface quality
- ▲ Flexible clamping range with reduction sleeves
- ▲ Speeds of up to 25,000 rpm
- ▲ Suitable for minimum quantity lubrication (MMS)

DAH



AD
G 2.5 n_{max} 25000

Adapter	DCONWS	BD_1	BD_2	LB	LSCX	LPR	OAL
BT 40	20	41	50	69.1	41	115	180.4

CT
84 326 ...
02069



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Accessories



Reduction sleeve

→



Pull stud

→



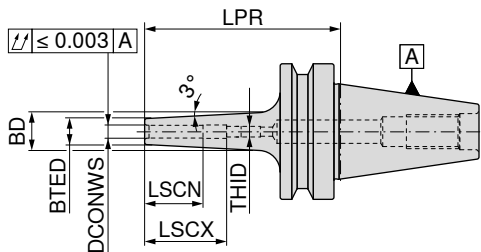
Others

→

CoreLine – Heat shrink adapter, slim 3° – TG

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

TG



AD/B
G 2.5 n_{max} 25000

		Adapter	DCONWS mm	LPR mm	BTED mm	BD mm	LSCX mm	LSCN mm	THID		
Short	BT 40	3	90	9	15	28	12	M6		84 323 ...	103
	BT 40	4	90	10	16	28	16	M6			104
	BT 40	5	90	11	17	30	20	M6			105
	BT 40	6	90	12	18	36	26	M5			106
	BT 40	8	90	14	20	36	26	M6			108
	BT 40	10	90	16	22	41	31	M8x1			110
	BT 40	12	90	18	24	47	37	M10x1			112
	BT 40	14	90	20	26	47	37	M10x1			114
	BT 40	16	90	22	28	50	40	M12x1			116
	BT 40	18	90	24	30	50	40	M12x1			118
	BT 40	20	90	26	32	52	42	M16x1			120
Medium length	BT 40	3	120	9	16	12	12				203
	BT 40	4	120	10	17	16	16				204
	BT 40	5	120	11	18	20	20				205
	BT 40	6	120	12	21	36	26	M5			206
	BT 40	8	120	14	23	36	26	M6			208
	BT 40	10	120	16	25	41	31	M8x1			210
	BT 40	12	120	18	27	47	37	M10x1			212
	BT 40	14	120	20	29	47	37	M10x1			214
	BT 40	16	120	22	31	50	40	M12x1			216
	BT 40	18	120	24	33	50	40	M12x1			218
	BT 40	20	120	26	35	52	42	M16x1			220
Extended	BT 40	3	160	9	19	12	12				303
	BT 40	4	160	10	20	16	16				304
	BT 40	5	160	11	21	20	20				305
	BT 40	6	160	12	24	36	26	M5			306
	BT 40	8	160	14	26	36	26	M6			308
	BT 40	10	160	16	28	41	31	M8x1			310
	BT 40	12	160	18	30	47	37	M10x1			312
	BT 40	14	160	20	32	47	37	M10x1			314
	BT 40	16	160	22	34	50	40	M12x1			316
	BT 40	18	160	24	36	50	40	M12x1			318
	BT 40	20	160	26	38	52	42	M16x1			320



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
DCONWS

3 - 5	M6x14 - SW2	417		
6			M5x12,5 - SW2,5	418
8			M6x12,5 - SW3	419
10			M8x1x13,5 - SW3	420
12 - 14			M10x1x13,5 - SW5	421
16 - 18			M12x1x13,5 - SW5	422
20			M16x1x13,5 - SW8	424



Stop screw IK

CT

83 950 ...



Backstop screw with
internal cooling

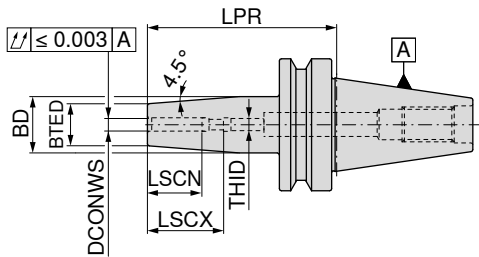
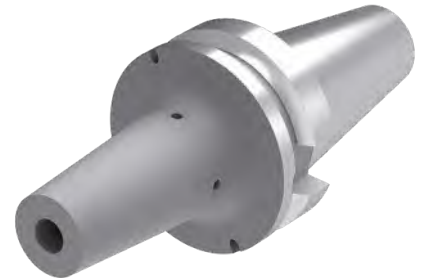
CT

83 950 ...

CoreLine – Heat shrink adapter 4.5° – TG

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
 ▲ **By request:** Also available with Balluff chip

TG



AD
G 2.5 n_{max} 25000



AD/B
G 2.5 n_{max} 25000

	Adapter	DCONWS mm	LPR mm	BTED mm	BD mm	LSCX mm	LSCN mm	THID		
									CT	CT
Short	BT 30	3	85	10	17	28	12	M6	84 303 ...	84 303 ...
	BT 30	4	85	15	22	28	16	M6	003	
	BT 30	5	85	15	22	30	20	M6	004	
	BT 30	6	85	21	27	36	26	M5	005	
	BT 30	8	85	21	27	36	26	M6	006	
	BT 30	10	85	24	32	41	31	M8x1	008	
	BT 30	12	85	24	32	47	37	M10x1	010	
	BT 30	14	85	27	34	47	37	M10x1	012	
	BT 30	16	85	27	34	50	40	M12x1	014	
	BT 30	18	85	33	42	50	40	M12x1	016	
	BT 30	20	85	33	42	52	42	M16x1	018	
									020	
	BT 40	3	90	10	17	28	12	M6		103
	BT 40	4	90	15	22	28	16	M6		104
	BT 40	5	90	15	22	30	20	M6		105
	BT 40	6	90	21	27	36	26	M5		106
	BT 40	8	90	21	27	36	26	M6		108
	BT 40	10	90	24	32	41	31	M8x1		110
	BT 40	12	90	24	32	47	37	M10x1		112
	BT 40	14	90	27	34	47	37	M10x1		114
	BT 40	16	90	27	34	50	40	M12x1		116
Medium length	BT 40	18	90	33	42	50	40	M12x1		118
	BT 40	20	90	33	42	52	42	M16x1		120
	BT 40	25	100	44	53	58	48	M16x1		125
	BT 40	3	120	10	20	12	12			203
	BT 40	4	120	15	22	16	16			204
	BT 40	5	120	15	22	20	20			205
	BT 40	6	120	21	27	36	26	M5		206
	BT 40	8	120	21	27	36	26	M6		208
	BT 40	10	120	24	32	41	31	M8x1		210
	BT 40	12	120	24	32	47	37	M10x1		212
	BT 40	14	120	27	34	47	37	M10x1		214
	BT 40	16	120	27	34	50	40	M12x1		216
	BT 40	18	120	33	42	50	40	M12x1		218
	BT 40	20	120	33	42	52	42	M16x1		220
	BT 40	25	120	44	53	58	48	M16x1		225

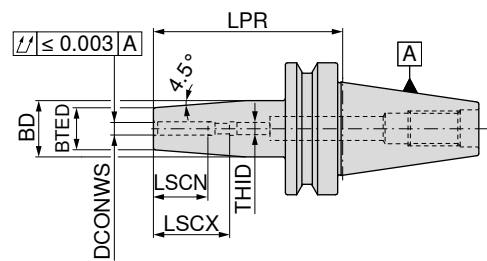
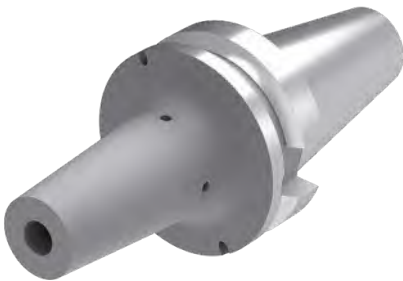


→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

CoreLine – Heat shrink adapter 4.5° – TG

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

TG



AD

G 2.5 n_{max} 25000



AD/B

G 2.5 n_{max} 25000

Extended	Adapter	DCONWS mm	LPR mm	BTED mm	BD mm	LSCX mm	LSCN mm	THID	CT	CT
	BT 40	3	160	10	20	12	12		84 303 ...	84 303 ...
	BT 40	4	160	15	22	16	16			303
	BT 40	5	160	15	22	20	20			304
	BT 40	6	160	21	27	36	26	M5		305
	BT 40	8	160	21	27	36	26	M6		306
	BT 40	10	160	24	32	41	31	M8x1		308
	BT 40	12	160	24	32	47	37	M10x1		310
	BT 40	14	160	27	34	47	37	M10x1		312
	BT 40	16	160	27	34	50	40	M12x1		314
	BT 40	18	160	33	42	50	40	M12x1		316
	BT 40	20	160	33	42	52	42	M16x1		318
	BT 40	25	160	44	53	58	48	M16x1		320
										325



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
DCONWS

3 - 5	M6x14 - SW2	417		
6			M5x12,5 - SW2,5	418
8			M6x12,5 - SW3	419
10			M8x1x13,5 - SW3	420
12 - 14			M10x1x13,5 - SW5	421
16 - 18			M12x1x13,5 - SW5	422
20 - 25			M16x1x13,5 - SW8	424



Stop screw IK

CT

83 950 ...



Backstop screw with internal cooling

CT

83 950 ...

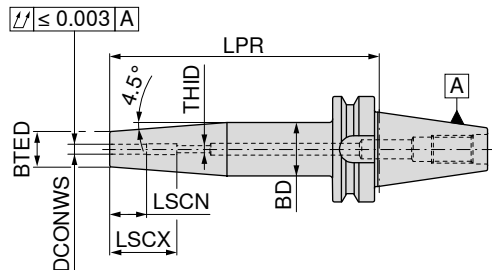
Accessories

		
Shrink fit extension	Pull stud	Others
→	→	→

CoreLine – Heat shrink adapter 4.5° – TG

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
 ▲ **By request:** Also available with Balluff chip

TG



AD/B
G 2.5 n_{max} 25000

		Adapter	DCONWS mm	LPR mm	BTED mm	BD mm	LSCX mm	LSCN mm	THID		
Short	BT 40	3	90	11	15					82 310 ...	10369
	BT 40	4	90	11	15						10469
	BT 40	5	90	11	15						10569
	BT 40	6	90	21	27	36	26		M5		10669
	BT 40	8	90	21	27	36	26		M6		10869
	BT 40	10	90	24	34	41	31		M8x1		11069
	BT 40	12	90	24	34	46	36		M10x1		11269
	BT 40	14	90	27	34	46	36		M10x1		11469
	BT 40	16	90	27	34	49	39		M12x1		11669
	BT 40	18	90	33	42	49	39		M12x1		11869
	BT 40	20	90	33	42	51	41		M16x1		12069
	BT 40	25	100	44	53	57	47		M16x1		12569
Medium length	BT 50	6	100	21	27	36	26		M5		10668
	BT 50	8	100	21	27	36	26		M6		10868
	BT 50	10	100	24	32	41	31		M8x1		11068
	BT 50	12	100	24	32	47	37		M10x1		11268
	BT 50	14	100	27	34	47	37		M10x1		11468
	BT 50	16	100	27	34	50	40		M12x1		11668
	BT 50	18	100	33	42	50	40		M12x1		11868
	BT 50	20	100	33	42	52	42		M16x1		12068
	BT 50	25	100	44	53	58	48		M16x1		12568
	BT 50	32	100	44	53	62	52		M16x1		13268
	BT 50	6	120	21	27	36	26		M5		20668
	BT 50	8	120	21	27	36	26		M6		20868
	BT 50	10	120	24	32	41	31		M8x1		21068
	BT 50	12	120	24	32	47	37		M10x1		21268
	BT 50	14	120	27	34	47	37		M10x1		21468
	BT 50	16	120	27	34	50	40		M12x1		21668
	BT 50	18	120	33	42	50	40		M12x1		21868
	BT 50	20	120	33	42	52	42		M16x1		22068
	BT 50	25	120	44	53	58	48		M16x1		22568
	BT 50	32	120	44	53	62	52		M16x1		23268

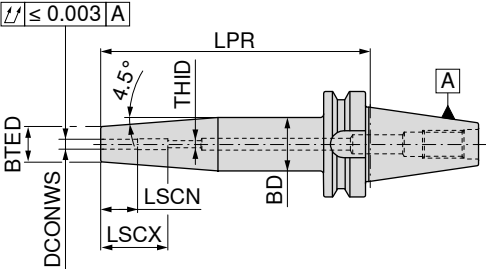


→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

CoreLine – Heat shrink adapter 4.5° – TG

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

TG



AD/B
G 2.5 n_{max} 25000

	Adapter	DCONWS	LPR	BTED	BD	LSCX	LSCN	THID
		mm	mm	mm	mm	mm	mm	
Extended	BT 40	6	160	21	27	36	26	M5
	BT 40	8	160	21	27	36	26	M6
	BT 40	10	160	24	34	41	31	M8x1
	BT 40	12	160	24	34	46	36	M10x1
	BT 40	14	160	27	34	46	36	M10x1
	BT 40	16	160	27	34	49	39	M12x1
	BT 40	18	160	33	42	49	39	M12x1
	BT 40	20	160	33	42	51	41	M16x1
	BT 40	25	160	44	53	57	47	M16x1
	BT 50	6	160	21	27	36	26	M5
	BT 50	8	160	21	27	36	26	M6
	BT 50	10	160	24	32	41	31	M8x1
	BT 50	12	160	24	32	47	37	M10x1
	BT 50	14	160	27	34	47	37	M10x1
	BT 50	16	160	27	34	50	40	M12x1
	BT 50	18	160	33	42	50	40	M12x1
	BT 50	20	160	33	42	52	42	M16x1
	BT 50	25	160	44	53	58	48	M16x1
	BT 50	32	160	44	53	62	52	M16x1

CX
82 310 ...
30669
30869
31069
31269
31469
31669
31869
32069
32569
30668
30868
31068
31268
31468
31668
31868
32068
32568
33268



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
DCONWS

6	M5x16 - SW2,5	30000
8	M6x16 - SW3	30100
10	M8x1x16 - SW4	30200
12 - 14	M10x1x14 - SW5	30300
16 - 18	M12x1x16 - SW6	30400
20 - 32	M16x1x16 - SW8	30500



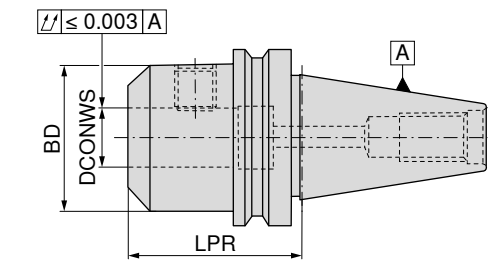
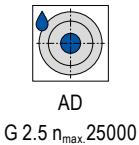
Stop screw IK

CX

82 950 ...

CoreLine – Cylindrical shank adapter Weldon

- ▲ For shanks according to DIN 6535 HB / 1835 B with lateral clamping flat
- ▲ **By request:** Also available with Balluff chip



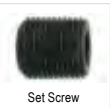
	Adapter	DCONWS _{H4}	LPR	BD
		mm	mm	mm
Short	BT 30	6	50	25
	BT 30	8	50	28
	BT 30	10	50	35
	BT 30	12	55	42
	BT 30	14	55	44
	BT 30	16	63	48
	BT 30	18	63	50
	BT 30	20	63	52
Extra short	BT 40	16	35	48
	BT 40	20	35	50
	BT 40	25	40	50
	BT 40	32	75	72

CX
82 501 ...
00600
00800
01000
01200
01400
01600
01800
02000
416
420
425 ¹⁾
43200 ¹⁾

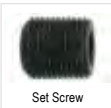
1) Version with two clamping screws

Spare parts
DCONWS _{H4}

6			M6x10	006
8			M8x10	008
10			M10x12	010
12 - 14			M12x16	012
16 - 18			M14x16	016
20			M16x16	020
25	M16x10	275		
32	M14x10	259	M20x2x20	032



CT
83 950 ...



CT
62 950 ...

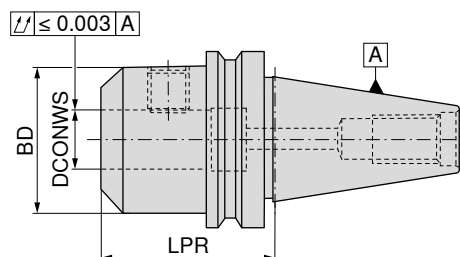
Accessories



CoreLine – Cylindrical shank adapter Weldon

▲ For shanks according to DIN 6535 HB / 1835 B with lateral clamping flat

▲ **By request:** Also available with Balluff chip



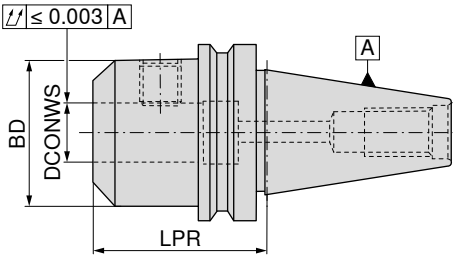
AD/B
G 2.5 n_{max} 25000

		Adapter	DCONWS _{H4} mm	LPR mm	BD mm	CX 82 501 ...
Short	BT 40	6	50	25		106
		8	50	28		108
		10	63	35		110
		12	63	42		112
		14	63	44		114
		16	63	48		116
		18	63	50		118
		20	63	52		120
		25	100	65		125
		32	100	72		132 ¹⁾
		40	120	90		14000 ¹⁾
	BT 50	6	63	25		30600
		8	63	28		30800
		10	80	35		31000
		12	80	42		31200
		14	80	44		31400
		16	80	48		31600
		18	80	50		31800
		20	80	52		32000
		25	100	65		32500 ¹⁾
		32	105	72		33200 ¹⁾
		40	120	90		34000 ¹⁾
Medium length	BT 40	6	100	25		506
		8	100	28		508
		10	100	35		510
		12	100	42		512
		14	100	44		514
		16	100	48		516
		18	100	50		518
		20	100	52		520
	BT 50	6	100	25		70600
		8	100	28		70800
		10	100	35		71000
		12	100	42		71200
		14	100	44		71400
		16	100	48		71600
		18	100	50		71800
		20	100	52		72000
		25	120	65		72500 ¹⁾

1) Version with two clamping screws

CoreLine – Cylindrical shank adapter Weldon

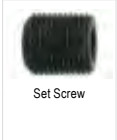
- ▲ For shanks according to DIN 6535 HB / 1835 B with lateral clamping flat
- ▲ **By request:** Also available with Balluff chip



AD/B
G 2.5 n_{max} 25000

	Adapter	DCONWS _{H4} mm	LPR mm	BD mm		CX
Extended	BT 40	6	160	25		82 501 ...
	BT 40	8	160	28		606
	BT 40	10	160	35		608
	BT 40	12	160	42		610
	BT 40	14	160	44		612
	BT 40	16	160	48		614
	BT 40	18	160	50		616
	BT 40	20	160	52		618
	BT 40	25	160	65		620
						625 ¹⁾
	BT 50	6	160	25		80600
	BT 50	8	160	28		80800
	BT 50	10	160	35		81000
	BT 50	12	160	42		81200
	BT 50	14	160	44		81400
	BT 50	16	160	48		81600
	BT 50	18	160	50		81800
	BT 50	20	160	52		82000
	BT 50	25	160	65		82500 ¹⁾
	BT 50	32	160	72		83200 ¹⁾

1) Version with two clamping screws



Set Screw

CT

Spare parts
DCONWS_{H4}

62 950 ...

6	M6x10	006
8	M8x10	008
10	M10x12	010
12	M12x16	012
14	M12x16	012
16	M14x16	016
18	M14x16	016
20	M16x16	020
25	M18x2x20	025
32	M20x2x20	032
40	M20x2x20	032

Accessories



Pull stud

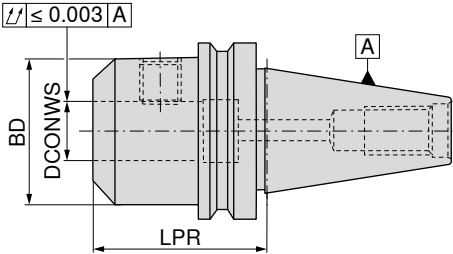


Others



CoreLine – Cylindrical shank adapter Weldon

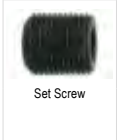
- ▲ For shanks according to DIN 6535 HB / 1835 B with lateral clamping flat
- ▲ With eroded coolant channels
- ▲ **By request:** Also available with Balluff chip



AD/Be
G 2.5 n_{max} 25000

	Adapter	DCONWS _{H4} mm	LPR mm	BD mm	
Short	BT 40	6	50	25	
	BT 40	8	50	28	
	BT 40	10	63	35	
	BT 40	12	63	42	
	BT 40	14	63	44	
	BT 40	16	63	48	
	BT 40	18	63	50	
	BT 40	20	63	52	
	BT 40	25	100	65	
	BT 40	32	100	72	
	BT 40	40	120	90	
	BT 50	6	63	25	
	BT 50	8	63	28	
	BT 50	10	80	35	
	BT 50	12	80	42	
	BT 50	14	80	44	
	BT 50	16	80	48	
	BT 50	18	80	50	
	BT 50	20	80	52	
	BT 50	25	100	65	
	BT 50	32	105	72	
	BT 50	40	120	90	
					CX
					82 504 ...
					106
					108
					110
					112
					114
					116
					118
					120
					125 ¹⁾
					13200 ¹⁾
					14000
					30600
					30800
					31000
					31200
					31400
					31600
					31800
					32000
					32500 ¹⁾
					33200 ¹⁾
					34000

1) Version with two clamping screws



Set Screw

CT

Spare parts
DCONWS_{H4}

62 950 ...

6	M6x10	006
8	M8x10	008
10	M10x12	010
12	M12x16	012
14	M12x16	012
16	M14x16	016
18	M14x16	016
20	M16x16	020
25	M18x2x20	025
32	M20x2x20	032
40	M20x2x20	032

Accessories



Pull stud

→

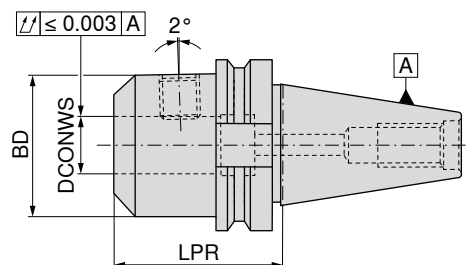


Others

→

CoreLine – Cylindrical shank adapter Whistle Notch

- ▲ For shanks according to DIN 6535 HE / 1835 E with angled clamping flat
- ▲ The groove in the flat face is a characteristic feature of the Whistle Notch version
- ▲ **By request:** Also available with Balluff chip



AD/B
G 2.5 n_{max} 25000

					CX	
					82 507 ...	
Short	Adapter	DCONWS _{H4} mm	LPR mm	BD mm		
	BT 40	6	50	25	106	
	BT 40	8	50	28	108	
	BT 40	10	63	35	110	
	BT 40	12	63	42	112	
	BT 40	14	63	44	114	
	BT 40	16	63	48	116	
	BT 40	18	63	50	118	
	BT 40	20	63	52	120	
	BT 40	25	100	65	12500 ¹⁾	
	BT 40	32	100	72	13200 ¹⁾	
	BT 40	40	120	80	14000 ¹⁾	
	BT 50	6	63	25	30600	
	BT 50	8	63	28	30800	
	BT 50	10	80	35	31000	
	BT 50	12	80	42	31200	
	BT 50	14	80	44	31400	
	BT 50	16	80	48	31600	
	BT 50	18	80	50	31800	
	BT 50	20	80	52	32000	
	BT 50	25	100	65	32500 ¹⁾	
	BT 50	32	105	72	33200 ¹⁾	
Long						
	BT 40	6	130	25	206	
	BT 40	8	130	28	208	
	BT 40	10	130	35	210	
	BT 40	12	130	42	212	
	BT 40	16	130	48	216	
	BT 40	20	130	52	220	
	BT 40	25	130	65	225 ¹⁾	
	BT 50	6	130	25	90600	
	BT 50	8	130	28	90800	
	BT 50	10	130	35	91000	
	BT 50	12	130	42	91200	
	BT 50	16	130	48	91600	
	BT 50	20	130	52	92000	
	BT 50	25	130	65	92500 ¹⁾	
	BT 50	32	130	72	93200 ¹⁾	

1) Version with two clamping screws

Spare parts
DCONWS_{H4}

				
		Set Screw		Stop screw IK
		CT		CT
		62 950 ...		83 950 ...
6	M6x10	006	M5x35	033
8	M8x10	008	M6x35	034
10	M10x12	010	M8x35	035
12 - 14	M12x16	012	M10x35	036
16 - 18	M14x16	016	M12x40	037
20	M16x16	020	M16x45	272
25	M18x2x20	025	M20x35	290
32	M20x2x20	032	M20x35	290
40	M20x2x20	032		

Accessories





Pull stud

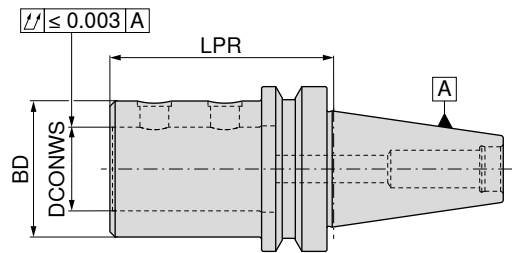
Others

→

→

CoreLine – Indexable insert drill adapter

▲ **By request:** Also available with Balluff chip



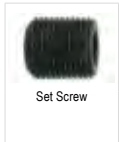
AD/B
G 6.3 n_{max} 15000

Adapter	DCONWS mm	LPR mm	BD mm
BT 40	20	75	40
BT 40	25	80	45
BT 40	32	85	52
BT 50	20	85	40
BT 50	25	90	45
BT 50	32	95	52
BT 50	40	105	65
BT 50	50	113	75

CX
10 841 ...
120
125
132
220
225
232
240
250

Spare parts

20	M10x1x10	001
25 - 32	M12x1x10	002
40 - 50	M16x1x12	003



CX
10 950 ...
001
002
003

Accessories



Pull stud	Others
→	→

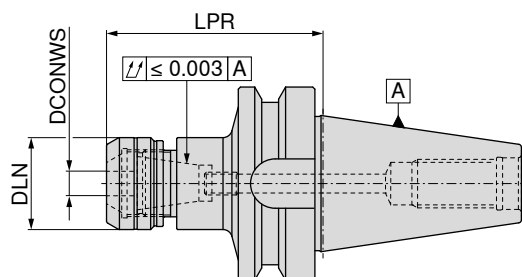
CoreLine – ER precision collet chucks – PCC

- ▲ For standard or sealing disc lock nuts
- ▲ Maximum clamping range covered according to ISO tolerance field H10
- ▲ Roll key required for clamping
- ▲ $p_{\max} = 100$ bar
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with lock nut and stop screws

PCC



AD/B
G 2.5 $n_{\max}$ 25000

Adapter	DCONWS mm	LPR mm	DLN mm	for collet	Tightening torque / clamping force Nm	
BT 40	1 - 10	70	30	426E (ER16)	40 / 2-70	
BT 40	1 - 10	100	30	426E (ER16)	40 / 2-70	
BT 40	2 - 16	70	40	430E (ER25)	80 / 10-160	
BT 40	2 - 16	100	40	430E (ER25)	80 / 10-160	
BT 40	2 - 20	70	50	470E (ER32)	125 / 15-250	
BT 40	2 - 20	100	50	470E (ER32)	125 / 15-250	
BT 50	2 - 16	80	40	430E (ER25)	80 / 10-160	
BT 50	2 - 16	100	40	430E (ER25)	80 / 10-160	
BT 50	2 - 20	80	50	470E (ER32)	125 / 15-250	
BT 50	2 - 20	100	50	470E (ER32)	125 / 15-250	

CX
82 700 ...

11069
21069

11669
21669

12069
22069

11668
21668

12068
22068



Dimension LPR is 4.5 mm longer for ER16 and ER32 and 5.0 mm longer for ER25 when using thru coolant lock nut

Spare parts
for collet

426E (ER16)	11000	01000			M8X3,0	00100
430E (ER25)	11600	01600	M18x1,5	00200	M8x8	00300
470E (ER32)	12000	02000	M18x1,5	00200	M8x8	00300

 Lock nut IK	 Lock nut	 Stop screw PCC 2	 Stop screw PCC 1
CX	CX	CX	CX
82 950 ...	82 950 ...	82 950 ...	82 950 ...

Accessories

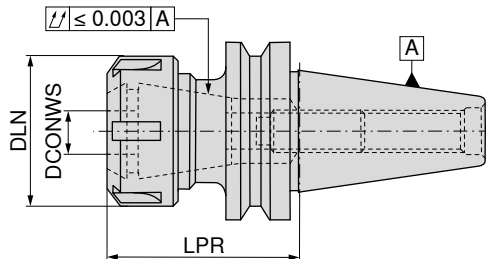
		
ER collet	Sealing disc	Roll key
→	→	→

CoreLine – ER collet chuck

▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with lock nut and stop screw



AD
G 2.5 n_{max} 25000



AD/B
G 2.5 n_{max} 25000

	Adapter	DCONWS mm	LPR mm	DLN mm	TQX Nm	for collet	CX 82 509 ...	CX 82 509 ...
Short	BT 30	1 - 10	70	32	56	426E (ER16)		
	BT 30	1 - 16	70	42	104	430E (ER25)	01000	
	BT 30	2 - 20	70	50	136	470E (ER32)	01600	
							02000	
	BT 40	1 - 10	60	22	56	426E (ER16 mini)		11169
	BT 40	1 - 10	60	32	56	426E (ER16)		110
	BT 40	1 - 16	70	42	104	430E (ER25)		116
	BT 40	2 - 20	70	50	136	470E (ER32)		120
	BT 40	3 - 26	70	63	176	472E (ER40)		126
	BT 50	1 - 10	75	32	56	426E (ER16)	31000	
	BT 50	1 - 16	75	42	104	430E (ER25)	31600	
Medium length	BT 30	1 - 10	100	32	56	426E (ER16)	21000	
	BT 30	1 - 16	100	42	104	430E (ER25)	21600	
	BT 40	1 - 10	120	22	56	426E (ER16 mini)		21169
	BT 40	1 - 10	120	32	56	426E (ER16)		410
	BT 40	1 - 16	120	42	104	430E (ER25)		416
	BT 40	2 - 20	120	50	136	470E (ER32)		420
	BT 40	3 - 26	100	63	176	472E (ER40)		42600
	BT 50	1 - 10	100	32	56	426E (ER16)	71000	
	BT 50	1 - 16	100	42	104	430E (ER25)	71600	
	BT 50	2 - 20	100	50	136	470E (ER32)	72000	
Extended	BT 50	3 - 26	100	63	176	472E (ER40)	72600	
	BT 40	1 - 10	160	32	56	426E (ER16)		51000
	BT 40	1 - 16	160	42	104	430E (ER25)		51600
	BT 40	2 - 20	160	50	136	470E (ER32)		52000
	BT 40	3 - 26	160	63	176	472E (ER40)		52600
	BT 50	1 - 16	160	42	104	430E (ER25)	81600	
	BT 50	2 - 20	160	50	136	470E (ER32)	82000	



Dimension LPR is 5.0 mm longer for ER16, ER25 and ER32, and 5.5 mm for ER40 when using thru coolant lock nuts.

								
	Lock nut IK	Lock nut	Y clamping key	ER-Mini clamping key	Mini lock nut	Mini lock nut IK	Stop screw IK	Stop screw IK
	CT	CT	CX	CT	CT	CT	CX	CT
Spare parts for collet	83 950 ...	62 950 ...	83 357 ...	83 950 ...	62 950 ...	83 950 ...	82 950 ...	83 950 ...
426E (ER16 mini)				101	066	058	30000	
426E (ER16)	054	054	116					
430E (ER25)	055	055	125					010
470E (ER32)	056	65600	132					010
472E (ER40)	057	65700	140					011

Accessories

		
ER collet	Pull stud	Others
→	→	→

CoreLine – Short drill chuck – NC 2010

- ▲ Independent of direction of rotation
- ▲ Tightening torque = 12 Nm
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body including clamping key SW4

NC
2010

A
G 6.3 n_{max} 10000

AD
G 6.3 n_{max} 10000

Adapter	DCONWS mm	BD_1 mm	BD_2 mm	LB_1 mm	LB mm	LPR mm	LF mm
BT 40	0,5 - 13	48.5		50.9		80	89.0
BT 40	2,5 - 16	51.0		50.9		80	90.5
BT 50	2,5 - 16	51.0	56	50.9	73	120	130.5

CX

84 509 ...
413
416
516

CX

84 510 ...
413
416
516

Can be used with G 2.5 to 30,000 rpm by subsequent balancing!

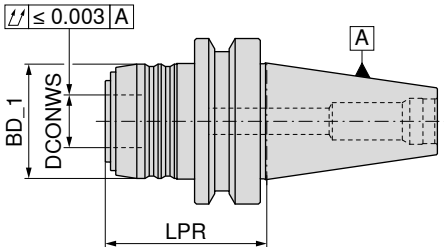
Accessories

Others

→

CoreLine – Synchro quick change tapping chuck with minimum length compensation

- ▲ With length compensation under tension 1.0 mm and under compression 0.2 mm (LZD)
- ▲ For collets according to DIN 6499
- ▲ $p_{max} = 50$ bar
- ▲ For synchro use
- ▲ **By request:** Also available with Balluff chip



AD

Adapter	Cutting range	SZID	LPR mm	BD_1 mm	DCONWS mm	LZD± mm
BT 40	M3 - M12	1	61	43	20	1,0 / 0,2
BT 40	M6 - M20	2	82	60	32	1,0 / 0,2
BT 50	M3 - M12	1	72	43	20	1,0 / 0,2
BT 50	M6 - M20	2	93	60	32	1,0 / 0,2

CT

83 515 ...

012

020

112

120

Accessories



Pull stud

→



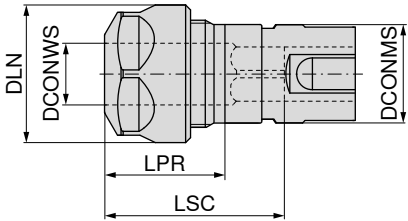
Others

→

Insert for synchro quick change tapping chuck with minimum length compensation

▲ SZID = for insert size

Scope of supply:
Includes lock nut



SZID	DCONWS mm	Cutting range	LPR mm	DLN mm	LSC mm	for collet	DCONMS mm	CT 83 608 ... 012 ¹⁾ 020
1	2 - 10	M3 - M12	24	28	42	426E (ER16)	20	
2	2 - 16	M6 - M20	28	42	59	430E (ER25)	32	

1) With hex nut

Spare parts
for article number

83 608 012	M22x1,5 - SW25	044	M22x1,5	054	M22x1,5	054	116
83 608 020			M32x1,5	055	M32x1,5	055	125



Lock nut SW

CT

62 950 ...



Lock nut IK

CT

83 950 ...



Lock nut

CT

62 950 ...



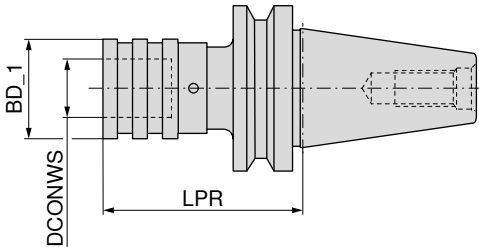
Y clamping key

CX

83 357 ...

CoreLine – Quick change tapping chuck with length compensation

- ▲ With length compensation under tension and compression (LZD)
- ▲ **By request:** Also available with Balluff chip



A

Adapter	Cutting range	SZID	LPR mm	BD_1 mm	DCONWS mm	LZD± mm	CT
BT 30	M3 - M12	01	63	38	19	9	83 528 ...
BT 30	M6 - M20	02	96	55	31	15	312
							320
BT 40	M3 - M12	01	68	38	19	9	412
BT 40	M6 - M20	02	93	55	31	15	420
BT 50	M3 - M12	01	80	38	19	9	512
BT 50	M6 - M20	02	102	55	31	15	520

Accessories



Insert

→



Pull stud

→



Others

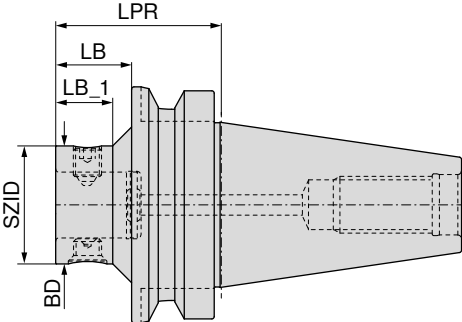
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HyPower – Adapter – ABS

▲ **By request:** Also available with Balluff chip

Scope of supply:
Steep taper adapter (shape B) with conversion kit (shape AD) and sealing disc

ABS






AD


AD/B

Adapter	SZID	BD	LPR	LB	LB_1
		mm	mm	mm	mm
BT 40	ABS 25	25	60	33	25
BT 40	ABS 32	32	60	33	
BT 40	ABS 40	40	60	33	
BT 40	ABS 50	50	60	33	
BT 40	ABS 63	63	70		
BT 50	ABS 32	32	70	32	24
BT 50	ABS 40	40	70	32	24
BT 50	ABS 50	50	70	32	24
BT 50	ABS 63	63	80	42	37
BT 50	ABS 80	80	100	62	
BT 50	ABS 100	100	110		

CT

84 202 ...

04090

04089

04088

05089

05088

CT

84 212 ...

04097

04096

05097

05096

05092

05091

Conversion kit – Coolant supply



for	Adapter
4 mm	SK 40 / BT 40
6 mm	SK 50 / BT 50

CT

84 950 ...

23200

23400

Spare parts
SZID

ABS 25				
ABS 32				
ABS 40				
ABS 50				
ABS 63				
ABS 80				
ABS 100				

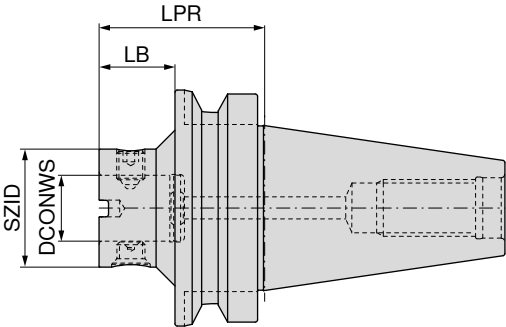
 Clamping screw	 Clamping screw	 Set	 Taper screw
CT	CT	CT	CT
62 950 ...	84 950 ...	84 950 ...	84 950 ...
	26800	99700	27000
13989		99600	27100
	26900	99500	27200
	20300	99800	20400
	25500	99400	27300
	25600	99300	25100
	25700	99200	25200

HyPower – Adapter – ABS N

▲ **By request:** Also available with Balluff chip

Scope of supply:
Steep taper adapter (shape B) with conversion kit (shape AD) and sealing disc

ABS N



AD/B

Adapter	SZID	BD mm	LPR mm	LB mm	LB_1 mm
BT 50	ABS 50 N	50	70		24
BT 50	ABS 63 N	63	80		37
BT 50	ABS 80 N	80	100	60	

CT
84 235 ...
05068
06368
08068

Spare parts SZID

ABS 50 N	20300	99800	31800	20200	20400	30700
ABS 63 N	25500	99400	31900	23900	27300	30800
ABS 80 N	25600	99300	32000	24000	25100	30900

					
CT	CT	CT	CT	CT	CT
84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...

Accessories

	
Pull stud	Others
→	→

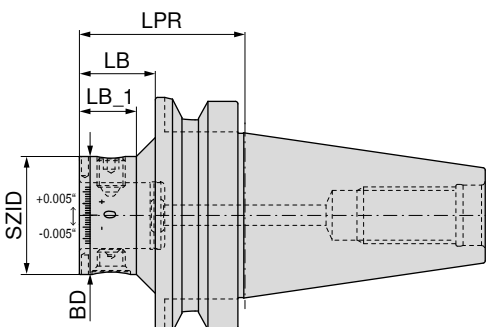
HyPower – Eccentric adjuster – ABS

- ▲ Adjustment ±0.010 inch on diameter
- ▲ also available with Balluff chip **on request**

Scope of supply:

Steep taper adapter (shape B) with conversion kit (shape AD) and sealing disc

ABS






AD


AD/B

Adapter	SZID	BD mm	LPR mm	LB mm	LB_1 mm
BT 40	ABS 50	50	60	33	
BT 40	ABS 63	63	70		
BT 50	ABS 50	50	70	32	24
BT 50	ABS 63	63	80	42	37

CT

84 205 ...

04096

05096

CT

84 205 ...

04097

05097


Clamping screw

CT

84 950 ...

20300

25500


Set

CT

84 950 ...

99800

99400


Taper screw

CT

84 950 ...

20400

27300

Spare parts

SZID

ABS 50

ABS 63

Accessories


Pull stud


Extension


Others

→

→

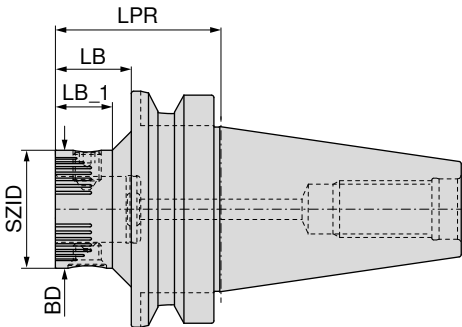
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HyPower – Torsional vibration damper – ABS

▲ **By request:** Also available with Balluff chip

Scope of supply:
Steep taper adapter (shape B) with conversion kit (shape AD) and sealing disc

ABS







AD/B

Adapter	SZID	BD mm	LPR mm	LB mm	LB_1 mm
BT 40	ABS 50	50	60	33	
BT 40	ABS 63	63	70		
BT 50	ABS 50	50	70	32	24
BT 50	ABS 63	63	80	42	37

CT

84 208 ...

04097
04096

05097
05096

Spare parts
SZID

ABS 50	20300	99800	20400
ABS 63	25500	99400	27300

 Clamping screw	 Set	 Taper screw
CT	CT	CT
84 950 ...	84 950 ...	84 950 ...
20300	99800	20400
25500	99400	27300

Accessories



Pull stud

→



Extension

→



Others

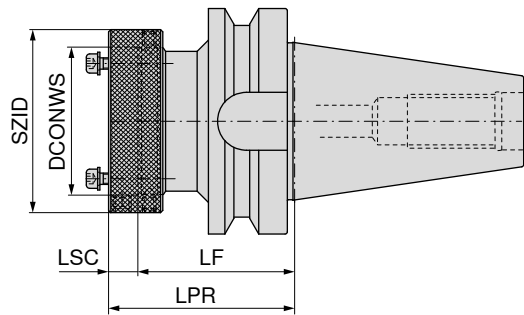
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HyPower – Compensation holder – DAH

- ▲ Compensation systems for μ-precision run-out
- ▲ Simple correction of run-out and axis errors
- ▲ Optimized for high rpm
- ▲ Designed for internal coolant supply
- ▲ Rotary tools provide long tool life

Scope of supply:
DAH compensation holder complete with assembly screws

DAH



Adapter	SZID	DCONWS mm	LSC mm	LPR mm	LF mm
BT 40	DAH 63	50	12	71	59
BT 40	DAH 81	65	12	71	59
BT 50	DAH 81	65	12	82	70
BT 50	DAH 115	100	16	104	88

CT
84 329 ...
06369
08169
08168
11568

							
			Grub screw		Spring washer		DAH adjustment ring
			CT		CT		CT
Spare parts			84 950 ...		84 950 ...		84 950 ...
SZID							
DAH 63	M6x8	42700	Ø5,3 - M5	42300	DAH 63	42200	
DAH 81	M6x10	42800	Ø5,3 - M5	42300	DAH 81	42000	
DAH 115	M8x10	43000	Ø8,4 - M8	42400	DAH 115	42100	
							
					Cylindrical screw		Clamping screw
				CT		AS	
Spare parts				84 950 ...		62 950 ...	
SZID							
DAH 63			M5x22	42500	M8x6 - SW4	53400	
DAH 81			M5x22	42500	M8x6 - SW4	53400	
DAH 115			M8X30	42600	M8x8 - SW4	14700	

Accessories





Pull stud

Others

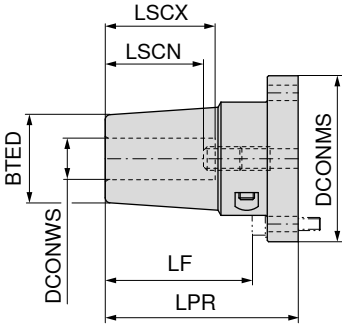
→

→

HyPower – Adapter – DAH

- ▲ Compensation systems for μ-precision run-out
- ▲ Simple correction of run-out and axis errors
- ▲ Optimized for high rpm
- ▲ Designed for internal coolant supply
- ▲ Rotary tools provide long tool life

DAH



AD

Adapter	DCONWS mm	DCONMS mm	BD mm	BTED mm	LB mm	LF mm	LPR mm	LSCN mm	LSCX mm
DAH 63	12	49.5	27	21.0	45	52	70	35	45
DAH 81	12	64.5	32	24.0	45	52	70	35	45
DAH 81	16	64.5	44	34.0	45	57	75	39	49
DAH 81	20	64.5	40	37.0	50	57	75	41	51
DAH 81	25	64.5	50	46.5	52		110	46	56
DAH 81	32	64.5	60	56.5	59		115	51	61

CT

84 327 ...
12600
12800
16800
20800
25800
32800

Accessories

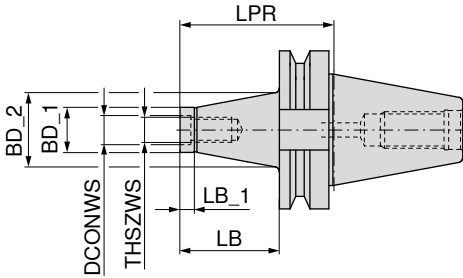


Reduction sleeve



CoreLine – Adapter for screw-in cutter – Conical

▲ **By request:** Also available with Balluff chip



AD
G 2.5 n_{max} 25000

Adapter	THSZWS	DCONWS mm	LB mm	BD_1 mm	BD_2 mm	LB_1 mm	LPR mm
BT 40	M8	8.5	25	13.8	15	12	52
BT 40	M8	8.5	50	13.8	23	12	77
BT 40	M8	8.5	75	13.8	25	12	102
BT 40	M10	10.5	25	18.0	23	12	52
BT 40	M10	10.5	50	18.0	25	12	77
BT 40	M10	10.5	75	18.0	30	12	102
BT 40	M12	12.5	25	21.0	24	12	52
BT 40	M12	12.5	50	21.0	30	12	77
BT 40	M12	12.5	75	21.0	35	12	102
BT 40	M12	12.5	100	21.0	38	12	127
BT 40	M16	17.0	25	29.0	29	12	52
BT 40	M16	17.0	50	29.0	34	12	77
BT 40	M16	17.0	75	29.0	35	12	102
BT 40	M16	17.0	100	29.0	40	12	127

CX
82 749 ...
08169
08269
08369
10169
10269
10369
12169
12269
12369
12469
16169
16269
16369
16469

Accessories



Extension/reduction

→



Pull stud

→



Others

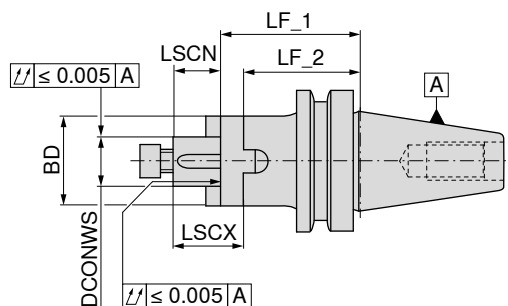
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CoreLine – Combination shell mill adapter

- ▲ For milling cutters with transverse or longitudinal slot according to DIN 6358
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with clamping screw, drive ring, and parallel key



A

G 2.5 n_{max} 25000

	Adapter	DCONWS mm	LF_1 mm	BD mm	LSCX mm	LSCN mm	LF_2 mm	
Short	BT 30	16	45	32	27	17	35	
	BT 30	22	47	40	31	19	35	
	BT 30	27	49	48	33	21	37	
	BT 40	16	55	32	27	17	45	
	BT 40	22	55	40	31	19	43	
	BT 40	27	55	48	33	21	43	
	BT 40	32	60	58	38	24	46	
	BT 40	40	60	70	41	27	46	
Medium length	BT 50	16	70	32	27	17	60	
	BT 50	22	70	40	31	19	58	
	BT 50	27	70	48	33	21	58	
	BT 50	32	70	58	38	24	56	
	BT 50	40	70	70	41	27	56	
	BT 30	16	80	32	27	17	70	
	BT 30	22	80	40	31	19	68	
	BT 30	27	90	48	33	21	78	
	BT 40	16	100	32	27	17	90	
	BT 40	22	100	40	31	19	88	
	BT 40	27	100	48	33	21	88	
	BT 40	32	100	58	38	24	86	
	BT 40	40	100	70	41	27	86	

CX

82 516 ...

01600

02200

02700

116

122

127

132

140 ¹⁾

216

222

227

232

240 ¹⁾

91600

92200

92700

31600

32200

32700

33200

34000 ¹⁾

1) With cross screw

						
		Parallel key	Drive ring	Cross nut key	Retaining screws	Tightening screw
		CT	CX	CX	CX	CT
Spare parts		83 950 ...	83 370 ...	83 368 ...	83 367 ...	83 950 ...
DCONWS						
16	4 x 4 x 20	284	116	116	M8 016	M8x25 113
22	6 x 6 x 25	285	122	122	M10 022	M10x25 124
27	7 x 7 x 25	286	127	127	M12 027	M12x30 125
32	8 x 7 x 28	287	132	132	M16 032	M16x35 126
40	10 x 8 x 32	288	140	140	M20 040	M20x40 - SW17 112

Accessories

		
Pull stud	Milling adapter ring	Others
→	→	→

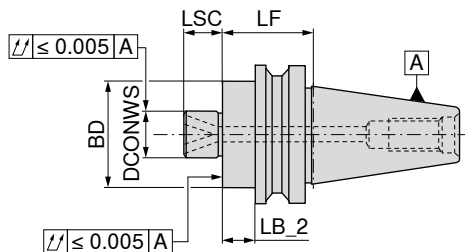
CoreLine – Shell mill adapter with reduced flange diameter

▲ Screwed in drive keys

▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with retaining screw and drive key



AD

G 2.5 n_{max} 25000

	Adapter	DCONWS mm	BD mm	LB_2 mm	LF mm	LSC mm	
Short	BT 40	22	38	33	60	19	82 315 ... 12269 12769
	BT 40	27	48	25	52	21	
	BT 50	22	38	22	60	19	
	BT 50	27	48	25	63	21	
Medium length	BT 40	22	38	73	100	19	22269 22769
	BT 40	27	48	73	100	21	
	BT 50	22	38	62	100	19	
	BT 50	27	48	62	100	21	
Long	BT 40	22	38	103	130	19	32269 32769
	BT 40	27	48	103	130	21	
	BT 50	22	38	92	130	19	
	BT 50	27	48	92	130	21	



These shell mill adapters have been specially developed for MaxiMill 211-KN porcupine cutters. Now they can be clamped perfectly, due to the adapted flange diameters.

Spare parts DCONWS

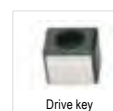
22	M4x8	51700	10x7x20,5	51500	M10x25	124
27	M5x8	51800	12x9x24,3	51600	M12x30	125



Carrier screws

CT

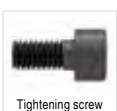
83 950 ...



Drive key

CT

83 950 ...



Tightening screw

CT

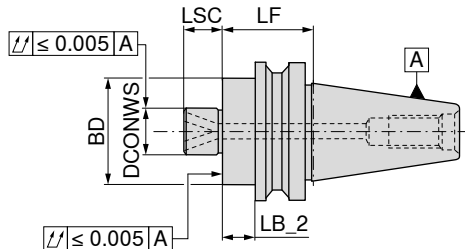
83 950 ...

CoreLine – Shell mill adapter

- ▲ With fixed drive dogs and enlarged contact face for milling cutters with transverse slot
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with clamping screw



A

G 2.5 n_{max} 25000

AD

G 2.5 n_{max} 25000

AD/B

G 2.5 n_{max} 25000

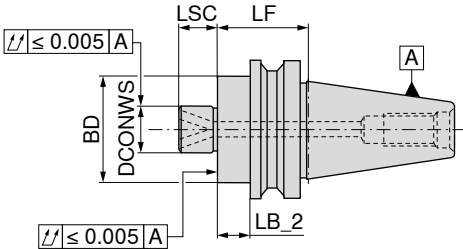
	Adapter	DCONWS mm	LB_2 mm	LF mm	BD mm	LSC mm	CX 82 514 ...	CX 82 514 ...	CX 82 514 ...
Short	BT 30	16	18	40	38	17	01600		
	BT 30	22	18	40	48	19	02200		
	BT 30	27	18	50	58	21	02700		
	BT 30	32	28	50	78	24	03200		
	BT 40	16	25	52	38	17			116
	BT 40	22	25	52	48	19			122
	BT 40	27	25	52	58	21			127
	BT 40	32	23	50	78	24			132
	BT 40	40	23	50	88	27			140 ¹⁾
	BT 50	16	25	63	38	17		316	
	BT 50	22	25	63	48	19		322	
	BT 50	27	25	63	58	21		327	
	BT 50	32	22	60	78	24		332	
	BT 50	40	22	60	88	27		340 ¹⁾	
Medium length	BT 40	16	73	100	38	17			416
	BT 40	22	73	100	48	19			422
	BT 40	27	73	100	58	21			427
	BT 40	32	73	100	78	24			432
	BT 40	40	73	100	88	27			440 ¹⁾
	BT 50	16	62	100	38	17		616	
	BT 50	22	62	100	48	19		622	
	BT 50	27	62	100	58	21		627	
	BT 50	32	62	100	78	24		632	
	BT 50	40	62	100	88	27		640 ¹⁾	
Long	BT 40	16	103	130	38	17			816
	BT 40	22	103	130	48	19			822
	BT 40	27	103	130	58	21			827
	BT 40	32	103	130	78	24			832
	BT 40	40	103	130	88	27			840 ¹⁾
	BT 50	16	92	130	38	17		916	
	BT 50	22	92	130	48	19		922	
	BT 50	27	92	130	58	21		927	
	BT 50	32	92	130	78	24		932	
	BT 50	40	92	130	88	27		940 ¹⁾	

1) With cross screw and 4 threaded holes M12 front face, pitch circle diameter = 66.7 mm, coolant outlet on the outer diameter of the spigot (DCONWS)!

CoreLine – Shell mill adapter

- ▲ With fixed drive dogs and enlarged contact face for milling cutters with transverse slot
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body with clamping screw



A

G 2.5 n_{max} 25000



AD

G 2.5 n_{max} 25000



AD/B

G 2.5 n_{max} 25000

Adapter							CX	CX	CX
							82 514 ...	82 514 ...	82 514 ...
Extended	BT 40	16	133	160	38	17			516
	BT 40	22	133	160	48	19			522
	BT 40	27	133	160	58	21			527
	BT 40	32	133	160	78	24			532
	BT 40	40	133	160	88	27			540 ¹⁾
	BT 50	16	122	160	38	17		716	
	BT 50	22	122	160	48	19		722	
	BT 50	27	122	160	58	21		727	
	BT 50	32	122	160	78	24		732	
	BT 50	40	122	160	88	27		740 ¹⁾	

1) With cross screw and 4 threaded holes M12 front face, pitch circle diameter = 66.7 mm, coolant outlet on the outer diameter of the spigot (DCONWS)!

					
			Cross nut key	Retaining screws	Tightening screw
			CX	CX	CT
Spare parts DCONWS			83 368 ...	83 367 ...	83 950 ...
16	116	M8	016	M8x25	113
22	122	M10	022	M10x25	124
27	127	M12	027	M12x30	125
32	132	M16	032	M16x35	126
40	140	M20	040	M20x40 - SW17	112
					
			Carrier screws	Drive key	
			CT	CT	
Spare parts DCONWS			83 950 ...	83 950 ...	
16		M3x8	296	8x9x17,5	120
22		M4x12	297	10x11x20,5	121
27		M5x12	136	12x13x24,3	122
32		M5x20	137	14x21x21,2	123
40		M6x16	138	15,9x16,3x19,5	295

Accessories

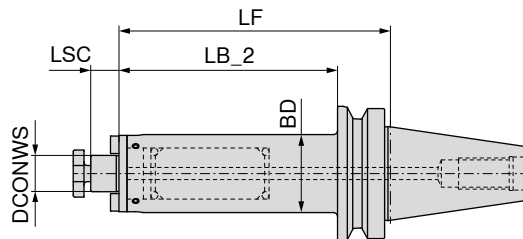
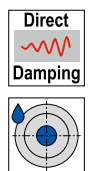
		
Pull stud	Extension	Others
→	→	→

HyPower – Actively vibration-damped shell mill adapter

- ▲ The specially mounted damping core enables perfect machining results even with longer tool overhangs
- ▲ Reduction in machining times due to optimum machining parameters
- ▲ Damped machining and therefore perfect surface qualities
- ▲ Protection of the machine spindle and increased tool life
- ▲ Screwed in drive keys
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with retaining screw and drive key



AD

CT

84 752 ...

51669

52269

51668

52268

52768

Adapter	DCONWS mm	LB_2 mm	LF mm	BD mm	LSC mm
BT 40	16	173.0	200	39	17
BT 40	22	173.0	200	48	19
BT 50	16	162.5	200	39	17
BT 50	22	162.0	200	48	19
BT 50	27	162.0	200	58	21

Spare parts DCONWS

Carrier screws	Drive key	Retaining screws	Tightening screw
CT 83 950 ...	CT 83 950 ...	CX 83 367 ...	CT 83 950 ...
16 M3x8 296	8x9x17,5 120	M8 016	M8x25 113
22 M4x12 297	10x11x20,5 121	M10 022	M10x25 124
27 M5x12 136	12x13x24,3 122	M12 027	M12x30 125

Accessories



Pull stud



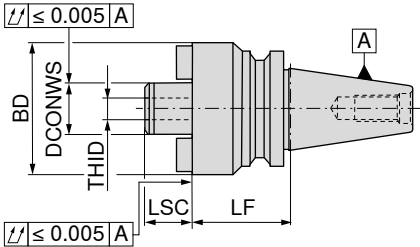
Others



CoreLine – Large diameter shell mill adapter

- ▲ For milling cutters with transverse or longitudinal slot according to DIN 6357
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body with integrated drive pins according to DIN 2079 and 4 clamping screws



A
G 6.3 n_{max} 8000

Adapter	DCONWS mm	LF mm	BD mm	LSC mm	THID	
BT 50	40	70	89	30	M20	
BT 50	60	80	129	40	M30	

CX

82 519 ...
240
260

Spare parts

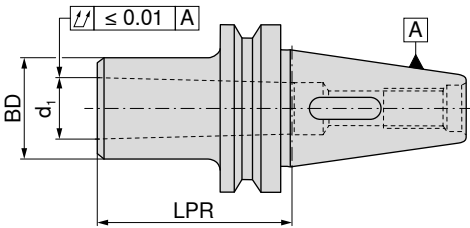
DCONWS	Carrier screws	Drive key	Socket head screw	Tightening screw
40	M6x16 138	15,9x16,3x19,5 295	M12x30 - SW10 181	M12x50 140
60		25,4x25x26,5 298		M16x45 160

Accessories



CoreLine – Taper sleeve adapter DIN 6383 for DIN 228-2D Morse taper shanks

▲ **By request:** Also available with Balluff chip



AD
G 6.3 n_{max} 8000

Adapter	d ₁	LPR mm	BD mm
BT 30	MK1	50	25
BT 30	MK2	60	32
BT 30	MK3	77	40
BT 40	MK1	50	25
BT 40	MK2	50	32
BT 40	MK3	70	40
BT 40	MK4	95	48
BT 50	MK1	45	25
BT 50	MK2	60	32
BT 50	MK3	65	40
BT 50	MK4	95	48
BT 50	MK5	105	63

CX
82 525 ...
01000
02000
03000
110
120
130
140
210
220
230
240
250

Accessories



Morse taper adapter sleeve
→



Pull stud
→

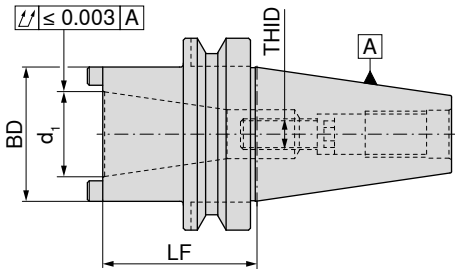


Others
→

CoreLine – Milling adapter sleeve

- ▲ For mounting steep taper adapters according to DIN 2080
- ▲ With an extended clamping screw, adapters compliant with ISO 7388-1 – SK, ISO 7388-2 – MAS-BT, and ANSI-CAT can also be clamped
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body with clamping screw for DIN 2080 adapters



A
G 6.3 n_{max} 8000

Adapter	d ₁	LF mm	BD mm	THID
BT 40	SK 30	60	51	M12
BT 40	SK 40	100	63	M16
BT 50	SK 40	80	70	M16

CX

82 518 ...

10600

11000

250

Spare parts
for article number

82 518 10600					
82 518 11000					
82 518 250					

				
Clamping screw SK	Morse taper clamping screw	Counterscrew	Hollow key with nose	Fixing ring
CT	CT	CT	CX	CT
83 950 ...	83 950 ...	83 950 ...	83 359 ...	83 950 ...
	18400	030	017	18500
009		030	023	270
009				

Screw length required when pulling in ISO 7388-1 – SK, ISO 7388-2 – MAS BT, or DIN 2080 shanks

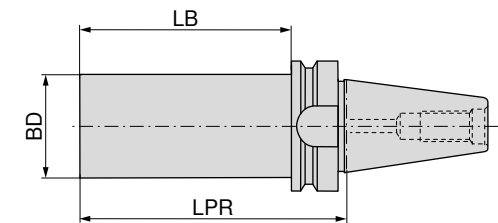
ISO 7388-2 Suitable for article no.	Taper shank	Clamping screw length	
	Ø d1	ISO 7388-1, ISO 7388-2 THID	DIN 2080 THID
8404013069	SK 30 – BT 30		M12x30 – 83950125
8404014069	SK 40 – BT 40	M16x70 – 83950264	M16x45 – 8495043700
8404014068	SK 40 – BT 40	M16x65 – 8495043600	M16x40 – 83950009

Accessories

	
Pull stud	Others
→	→

CoreLine – Blank

- ▲ Material: Steel 1.7131
- ▲ For the production of special tools
- ▲ Diameter BD turned with 0.5 mm oversize
- ▲ Taper hardened and ground
- ▲ Special tool area in soft state
- ▲ **By request:** Also available with Balluff chip



A



AD/B

Adapter	BD mm	LPR mm	LB mm
BT 40	63.0	250	223
BT 50	63.5	300	262

CX
82 523 ...
050

CX
82 523 ...
040

Accessories



Pull stud

→



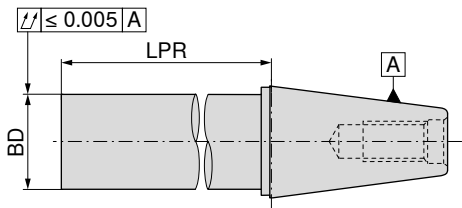
Others

→

CoreLine – Test arbor

- ▲ Without tool change groove
- ▲ Use for MAS BT 40 special pull studs with 3 mm shorter LF dimension, as standard

Scope of supply:
In wooden box



A

Adapter	BD mm	LPR mm
SK / BT 40	40	330
SK / BT 50	50	330

CT
82 456 ...
040
050

Accessories



Pull stud

→



Others

→

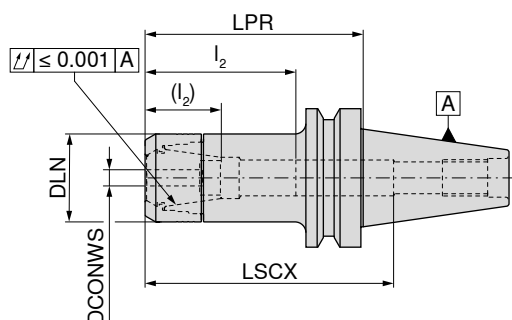
CoreLine – ER precision collet chucks – Centro-P

- ▲ With face contact
- ▲ For standard or sealing disc lock nuts
- ▲ Maximum clamping range covered according to ISO tolerance field H10
- ▲ Roll key required for clamping
- ▲ $p_{\max} = 80$ bar
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body **without** lock nut, **without** stop screw

Centro-P



AD
G 2.5 $n_{\max} 25000$

CT

84 525 ...

002
00400
00600
012
022

102
10400
10600
11400
112
11600
122
12400
12600

Adapter	DCONWS mm	LPR mm	DLN mm	LSCX mm	l_2 (l_2) mm	for collet
BT-FC 30	1 - 10	75	30	97	28 - 45 (14 - 31)	426E (ER16)
BT-FC 30	1 - 10	90	30	105	29 - 41 (29 - 38)	426E (ER16)
BT-FC 30	1 - 10	120	30	130	29 - 45 (29 - 32)	426E (ER16)
BT-FC 30	2 - 16	75	40	72	38 - 56 (23 - 39)	430E (ER25)
BT-FC 30	2 - 20	75	50	84	42 - 62 (24 - 45)	470E (ER32)
BT-FC 40	1 - 10	75	30	90	38 - 53 (29 - 39)	426E (ER16)
BT-FC 40	1 - 10	90	30	115	38 - 53 (29 - 38)	426E (ER16)
BT-FC 40	1 - 10	120	30	145	38 - 53 (29 - 38)	426E (ER16)
BT-FC 40	1 - 16	90	40	84	41 - 64 (36 - 46)	430E (ER25)
BT-FC 40	2 - 16	75	40	100	42 - 59 (36 - 41)	430E (ER25)
BT-FC 40	2 - 16	120	40	113	41 - 64 (36 - 46)	430E (ER25)
BT-FC 40	2 - 20	75	50	100	42 - 76 (42 - 52)	470E (ER32)
BT-FC 40	2 - 20	90	50	95	41 - 72 (41 - 55)	470E (ER32)
BT-FC 40	2 - 20	120	50	110	41 - 72 (41 - 55)	470E (ER32)



LSCX = Clamping depth without stop screw

l_2 = Clamping depth with stop screw type 1, dimension in brackets (l_2) = Clamping depth with stop screw type 2

Dimension LPR is 4 mm longer when using lock nuts with sealing discs

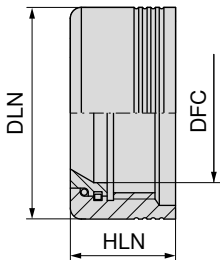


→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

HyPower – ER lock nut for precision collet chucks – Centro-P

- ▲ with thrust collar and angular contact ball bearing
- ▲ Excellent damping and clamping force
- ▲ High-precision lock nut for a perfect fit
- ▲ Run-out ≤ 3 µm with ER precision collets (blue ring)

Centro-P



for collet	DCONWS mm	HLN mm	DFC mm	DLN mm	CT	
470E (ER32)	2 - 20	26.5	32	50	84 728 ...	05000
472E (ER40)	3 - 26	31.0	40	63		06300

Spare parts
for collet

426E (ER16)		011	001	M11x1 - SW6	341	M11x1 - SW6	337
430E (ER25)		013	003	M18x1,5 - SW6	432	M18x1,5 - SW6	431
470E (ER32)	05000	015	005	M22x1,5 - SW6	402	M22x1,5 - SW6	401

Accessories



ER collet

→



Sealing disc

→



Roll key

→



Roll key device

→



Pull stud

→



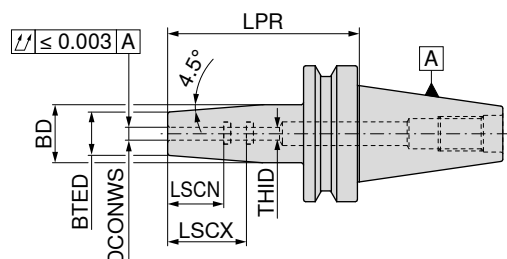
Others

→

CoreLine – Heat shrink adapter 4.5° – TG

- ▲ With face contact
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

TG



AD
G 2.5 n_{max} 25000

CT

84 325 ...

	Adapter	DCONWS mm	LPR mm	BTED mm	BD mm	LSCX mm	LSCN mm	THID	
Short	BT-FC 30	3	85	10	17	28	12	M6	003
	BT-FC 30	4	85	15	22	28	16	M6	004
	BT-FC 30	5	85	15	22	30	20	M6	005
	BT-FC 30	6	85	21	27	36	26	M5	006
	BT-FC 30	8	85	21	27	36	26	M6	008
	BT-FC 30	10	85	24	32	41	31	M8x1	010
	BT-FC 30	12	85	24	32	47	37	M10x1	012
	BT-FC 30	16	85	27	34	50	40	M12x1	016
	BT-FC 30	20	85	33	42	52	42	M16x1	020
	BT-FC 40	3	90	10	17	28	12	M6	103
	BT-FC 40	4	90	15	22	28	16	M6	104
	BT-FC 40	5	90	15	22	30	20	M6	105
	BT-FC 40	6	90	21	27	36	26	M5	106
	BT-FC 40	8	90	21	27	36	26	M6	108
	BT-FC 40	10	90	24	32	41	31	M8x1	110
	BT-FC 40	12	90	24	32	47	37	M10x1	112
	BT-FC 40	16	90	27	34	50	40	M12x1	116
	BT-FC 40	20	90	33	42	52	42	M16x1	120
	BT-FC 40	25	100	44	53	58	48	M16x1	125



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
DCONWS

3 - 5	
6	
8	
10	
12	
16	
20 - 25	

	
Stop screw IK	Backstop screw with internal cooling
CT	CT
83 950 ...	83 950 ...
417	418
	419
	420
	421
	422
	424

Accessories

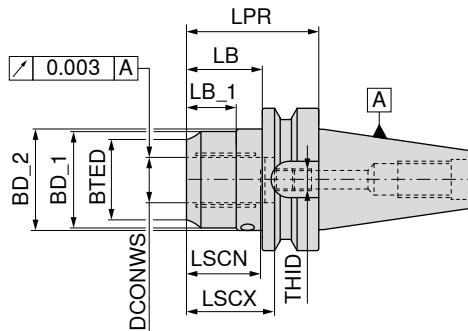
		
Shrink fit extension	Pull stud	Others
→	→	→

HyPower – High pressure chuck – Complus

- ▲ High pressure chuck, short and stable version
- ▲ With face contact
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with stop screw and pressure screw



AD

G 2.5 n_{max} 25000

Adapter	DCONWS mm	LPR mm	BTED mm	BD_1 mm	BD_2 mm	LB mm	LB_1 mm	LSCX mm	LSCN mm	THID
BT-FC 40	20	72.5	38					51	40	M16x1x13,5
BT-FC 40	32	90.0	54	63	62	64.0	48	61	51	M16x1x13,5
BT-FC 50	20	83.5	38	49		47.0		51	41	M16x1x13,5
BT-FC 50	32	90.0	57	68	72	53.5	35	61	51	M16x1x13,5

CT

83 527 ...
120
13274
12073
13273



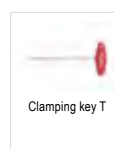
LSCX = maximum insertion depth
LSCN = minimum insertion depth



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts for article number

		AS		CT		CT
83 527 120	SW5	050	M10x1x10	158	M8x1x13,5 - SW3	420
83 527 13274	SW5	050	M10x1x14	429	M16x1x13,5 - SW8	424
83 527 12073	SW5	050	M10x1x14	429	M16x1x13,5 - SW8	424
83 527 13273	SW5	050	M10x1x14	429	M16x1x13,5 - SW8	424



Clamping key T

AS

80 397 ...



Pressure screw

CT

83 950 ...



Backstop screw with
internal cooling

CT

83 950 ...

Accessories



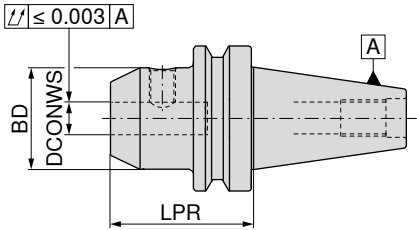
Reduction sleeve

Pull stud

Others

CoreLine – Cylindrical shank adapter Weldon

- ▲ With face contact
- ▲ For shanks according to DIN 6535 / 1835 B with lateral clamping flat
- ▲ **By request:** Also available with Balluff chip



AD
G 2.5 n_{max} 25000

	Adapter	DCONWS _{H4} mm	LPR mm	BD mm		
Short	BT-FC 30	6	50	25	CT	82 741 ...
	BT-FC 30	8	50	28		
	BT-FC 30	10	50	35		
	BT-FC 30	12	55	42		
	BT-FC 30	16	63	48		
	BT-FC 30	20	63	52		
	BT-FC 40	6	50	25		
	BT-FC 40	8	50	28		
	BT-FC 40	10	63	35		
	BT-FC 40	12	63	42		
	BT-FC 40	16	63	48		
	BT-FC 40	20	63	52		
	BT-FC 40	25	100	65		
	BT-FC 40	32	100	72		
	BT-FC 50	6	63	25		
	BT-FC 50	8	63	28		
	BT-FC 50	10	80	35		
	BT-FC 50	12	80	42		
	BT-FC 50	16	80	48		
	BT-FC 50	20	80	52		
	BT-FC 50	25	100	65		
	BT-FC 50	32	105	72		
						10665
						10865
						11065
						11265
						11665
						12065
						10664
						10864
						11064
						11264
						11664
						12064
						12564 ¹⁾
						13264 ¹⁾
						10663
						10863
						11063
						11263
						11663
						12063
						12563 ¹⁾
						13263 ¹⁾

1) Version with two clamping screws

Spare parts
DCONWS_{H4}

6	006
8	008
10	010
12	012
16	016
20	020
25	025
32	032


Set Screw

CT

62 950 ...

Accessories


Pull stud
→


Others
→

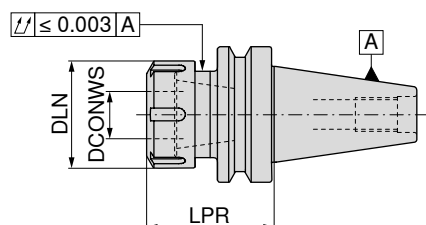
CoreLine – ER collet chuck

▲ With face contact

▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body including lock nut



AD
G 2.5 n_{max} 25000

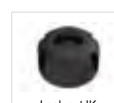
	Adapter	DCONWS mm	LPR mm	DLN mm	TQX Nm	for collet	
Short	BT-FC 30	1 - 10	63	32	56	426E (ER16)	
	BT-FC 30	1 - 16	60	42	104	430E (ER25)	
	BT-FC 30	2 - 20	60	50	136	470E (ER32)	
	BT-FC 40	1 - 10	63	32	56	426E (ER16)	
	BT-FC 40	1 - 16	60	42	104	430E (ER25)	
	BT-FC 40	2 - 20	60	50	136	470E (ER32)	
	BT-FC 50	1 - 10	100	32	56	426E (ER16)	
	BT-FC 50	1 - 16	75	42	104	430E (ER25)	
	BT-FC 50	2 - 20	75	50	136	470E (ER32)	
							CT
							82 743 ...
							11065
							11665
							12065
							11064
							11664
							12064
							11063
							11663
							12063



Dimension LPR is 5.0 mm longer for ER16, ER25 and ER32, and 5.5 mm for ER40 when using thru coolant lock nuts.

Spare parts for collet

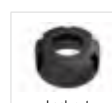
426E (ER16) / BT30-BT50	M22x1,5	054		M22x1,5	054				116
430E (ER25) / BT30-BT50	M32x1,5	055		M32x1,5	055				125
470E (ER32) / BT30-BT50	M40x1,5	056		M40x1,5	65600				132



Lock nut IK

CT

83 950 ...



Lock nut

CT

62 950 ...



Y clamping key

CX

83 357 ...

Accessories



ER collet



Pull stud



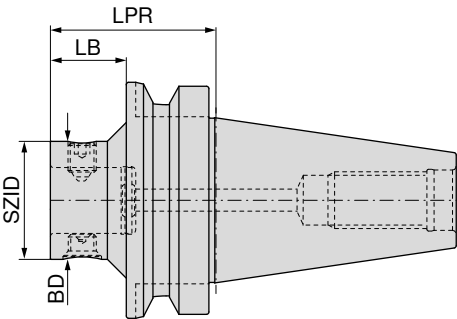
Others



HyPower – Adapter – ABS

- ▲ With face contact
- ▲ **By request:** Also available with Balluff chip

ABS



AD

Adapter	SZID	BD mm	LPR mm	LB mm
BT-FC 40	ABS 50	50	60	33
BT-FC 40	ABS 63	63	70	
BT-FC 50	ABS 50	50	70	32
BT-FC 50	ABS 63	63	80	42
BT-FC 50	ABS 80	80	100	62
BT-FC 50	ABS 100	100	110	

CT
84 264 ...
05064
06364
05063
06363
08063
10063

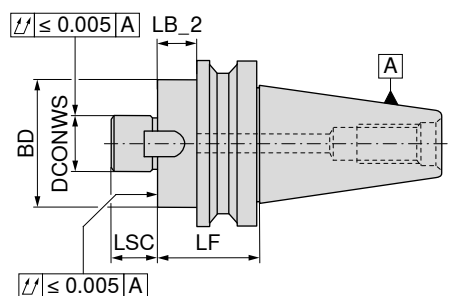
Spare parts

SZID	Clamping screw	Set	Taper screw
ABS 50	20300	99800	20400
ABS 63	25500	99400	27300
ABS 80	25600	99300	25100
ABS 100	25700	99200	25200

		
Clamping screw	Set	Taper screw
CT	CT	CT
84 950 ...	84 950 ...	84 950 ...
20300	99800	20400
25500	99400	27300
25600	99300	25100
25700	99200	25200

CoreLine – Shell mill adapter

- ▲ With face contact
- ▲ With fixed drive dogs and enlarged contact face for milling cutters with transverse slot
- ▲ **By request:** Also available with Balluff chip



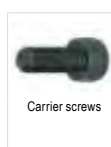
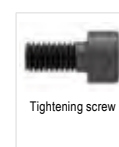
AD
G 2.5 n_{max} 25000

	Adapter	DCONWS	LB_2	LF	BD	LSC	CT
		mm	mm	mm	mm	mm	
Short	BT-FC 30	16	18	39.0	40	17	82 745 ...
	BT-FC 30	22	18	39.0	50	19	11665
	BT-FC 30	27	28	49.0	60	21	12265
	BT-FC 30	32	28	49.0	80	24	12765
							13265
	BT-FC 40	16	25	51.0	40	17	11664
	BT-FC 40	22	25	51.0	50	19	12264
	BT-FC 40	27	25	51.0	60	21	12764
	BT-FC 40	32	23	49.0	80	24	13264
	BT-FC 40	40	23	49.0	89	27	14064
	BT-FC 50	22	25	61.5	50	19	12263
	BT-FC 50	27	25	61.5	60	21	12763
	BT-FC 50	32	22	58.5	80	24	13263
	BT-FC 50	40	22	58.5	89	27	14063

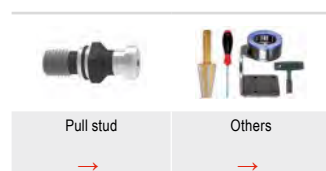
Spare parts

DCONWS

		CT		CT		CT
16	M3x8	296	8x9x17,5	120	M8x25	113
22	M4x12	297	10x11x20,5	121	M10x25	124
27	M5x12	136	12x13x24,3	122	M12x30	125
32	M5x20	137	14x21x21,2	123	M16x35	126
40	M6x16	138	15,9x16,3x19,5	295	M20x40 - SW17	112



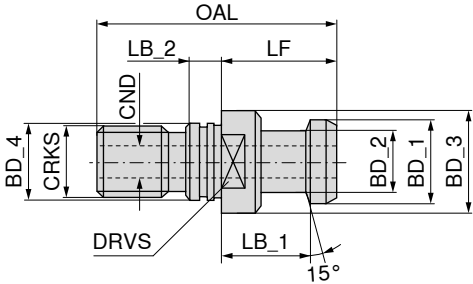
Accessories



Pull studs for adaptors according to ISO 7388-2

▲ MAS-BT 15° shape A

Scope of supply:
Including O ring

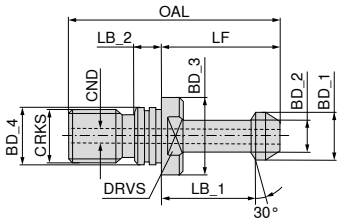


Adapter	BD_1 mm	BD_2 mm	BD_3 mm	BD_4 mm	CRKS	OAL mm	LF mm	LB_1 mm	LB_2 mm	CND mm	DRVS mm	TQX Nm	CX 83 532 ... 040
BT 40	19	14	23	17	M16	54	29	23	5	5	19	50	

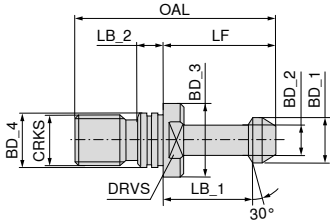
Pull studs for adaptors according to ISO 7388-2

▲ MAS-BT 30° shape A and B

Scope of supply:
Including O ring



A



B

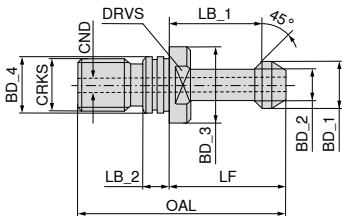


													A	B
Adapter	BD_1	BD_2	BD_3	BD_4	CRKS	OAL	LF	LB_1	LB_2	CND	DRVS	TQX	CX	CX
	mm	mm	mm	mm		mm	mm	mm	mm	mm	mm	Nm	82 531 ...	82 533 ...
BT 30	11	7	16.5	12.5	M12	43	23	18	4.0	2.2	13	20	030	
BT 40	15	10	23.0	17.0	M16	60	35	28	5.5	4.0	19	50	040	
BT 50	23	17	38.0	25.0	M24	85	45	35	8.0	6.0	30	150	050	
BT 30	11	7	16.5	12.5	M12	43	23	18	4.0		13	20		030
BT 40	15	10	23.0	17.0	M16	60	35	28	5.5		19	50		040
BT 50	23	17	38.0	25.0	M24	85	45	35	8.0		30	150		050

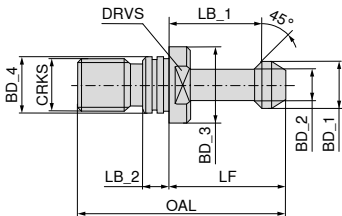
Pull studs for adapters according to ISO 7388-2

▲ MAS-BT 45° shape A and B

Scope of supply:
Including O ring



A



B

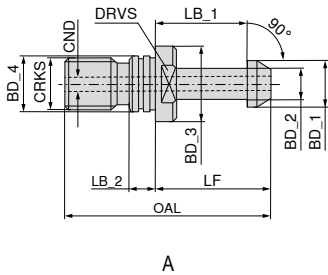
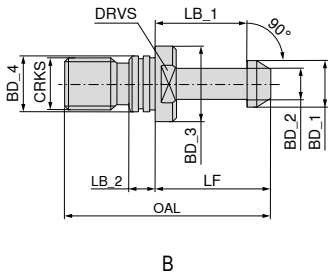


Adapter	A												CX		B		CX	
	BD_1 mm	BD_2 mm	BD_3 mm	BD_4 mm	CRKS	OAL mm	LF mm	LB_1 mm	LB_2 mm	CND mm	DRVS mm	TQX Nm	82 534 ...		82 530 ...			
BT 30	11	7	16.5	12.5	M12	43	23	18	4.0	2.2	13	20	030 040 050				030 040 050	
BT 40	15	10	23.0	17.0	M16	60	35	28	5.5	4.0	19	50						
BT 50	23	17	38.0	25.0	M24	85	45	35	8.0	6.0	30	150						
BT 30	11	7	16.5	12.5	M12	43	23	18	4.0		13	20						
BT 40	15	10	23.0	17.0	M16	60	35	28	5.5		19	50						
BT 50	23	17	38.0	25.0	M24	85	45	35	8.0		30	150						

Pull studs for adaptors according to ISO 7388-2

▲ MAS-BT 90° shape A and B

Scope of supply:
Including O ring



Adapter	BD_1 mm	BD_2 mm	BD_3 mm	BD_4 mm	CRKS	OAL mm	LF mm	LB_1 mm	LB_2 mm	CND mm	DRVS mm	TQX Nm	A	B
													CX 82 537 ... 040 050	CX 82 536 ... 040 050
BT 40	15	10	23	17	M16	60	35	28	5.5	4	19	50		
BT 50	23	17	38	25	M24	85	45	35	8.0	6	30	150		
BT 40	15	10	23	17	M16	60	35	28	5.5		19	50		
BT 50	23	17	38	25	M24	85	45	35	8.0		30	150		

Spare parts
BD_4

	O ring	Pull stud
	CX 83 476 ... 040 050	CX 82 487 ... 040 050
17		
25		

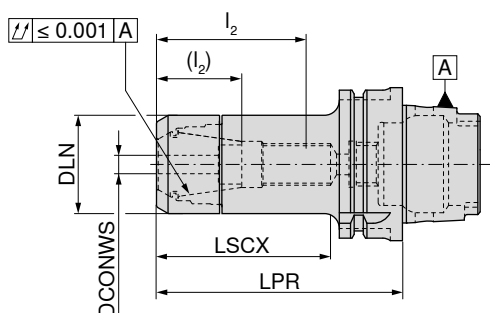
CoreLine – ER precision collet chucks – Centro-P

- ▲ For standard or sealing disc lock nuts
- ▲ Maximum clamping range covered according to ISO tolerance field H10
- ▲ Roll key required for clamping
- ▲ $p_{\max} = 80$ bar
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body **without** lock nut, **without** stop screw

Centro-P



G 2.5 $n_{\max}$ 25000

Adapter	DCONWS mm	LPR mm	DLN mm	LSCX mm	l_2 (l_2) mm	for collet	CT
HSK-A 40	1 - 10	60	30	40	32 - 54	426E (ER16)	84 722 ...
HSK-A 40	2 - 16	60	40	40		430E (ER25)	401
HSK-A 40	2 - 20	61	50	45		470E (ER32)	404 ²⁾
							407 ²⁾
HSK-A 50	2 - 16	60	40	37		430E (ER25)	504 ²⁾
HSK-A 50	2 - 16	70	40	49	34 - 35	430E (ER25)	505
HSK-A 63	1 - 10	55	30	32		426E (ER16)	609 ²⁾
HSK-A 63	1 - 10	100	30	71	28 - 45 (16 - 31)	426E (ER16)	610
HSK-A 63	1 - 10	130	30	87	26 - 50 (17 - 38)	426E (ER16)	613
HSK-A 63	1 - 10	160	30	106	28 - 45 (16 - 31)	426E (ER16)	611
HSK-A 63	1 - 10	200	30	136	28 - 45 (16 - 31)	426E (ER16)	612
HSK-A 63	2 - 16	60	40	37		430E (ER25)	615
HSK-A 63	2 - 16	100	40	70	35 - 55 (24 - 37)	430E (ER25)	616
HSK-A 63	2 - 16	130	40	89	37 - 60 (12 - 42)	430E (ER25)	619
HSK-A 63	2 - 16	160	40	128	35 - 60 (24 - 42)	430E (ER25)	617
HSK-A 63	2 - 20	70	50	46		470E (ER32)	620
HSK-A 63	2 - 20	100	50	71	41 - 57 (26 - 39)	470E (ER32)	621
HSK-A 63	2 - 20	130	50	101	42 - 69 (18 - 41)	470E (ER32)	625
HSK-A 63	2 - 20	160	50	129	52 - 70 (26 - 60)	470E (ER32)	622
HSK-A 63	3 - 26	80	63	56		472E (ER40)	626
HSK-A 63	3 - 26	120	63	91		472E (ER40)	62700
HSK-A 100	1 - 10	100	30	70	28 - 48 (16 - 35)	426E (ER16)	110
HSK-A 100	1 - 10	130	30	101	28 - 48 (16 - 35)	426E (ER16)	11200
HSK-A 100	1 - 10	160	30	130	28 - 48 (16 - 35)	426E (ER16)	111
HSK-A 100	2 - 16	100	40	71	38 - 56 (20 - 40)	430E (ER25)	116
HSK-A 100	2 - 16	130	40	98	40 - 60 (22 - 42)	430E (ER25)	11800
HSK-A 100	2 - 16	160	40	105	38 - 68 (20 - 50)	430E (ER25)	117
HSK-A 100	2 - 20	100	50	70	42 - 59 (24 - 40)	470E (ER32)	121
HSK-A 100	2 - 20	130	50	97	44 - 69 (41 - 51)	470E (ER32)	12400
HSK-A 100	2 - 20	160	50	99	42 - 70 (24 - 52)	470E (ER32)	122
HSK-A 100	3 - 26	100	63	65		472E (ER40)	12600 ¹⁾
HSK-A 100	3 - 26	130	63	95		472E (ER40)	13000 ¹⁾
HSK-A 100	3 - 26	160	63	125		472E (ER40)	16000 ¹⁾

1) Not in stock

2) Item cannot be combined with stop screw



LSCX = Clamping depth without stop screw

l_2 = Clamping depth with stop screw type 1, dimension in brackets (l_2) = Clamping depth with stop screw type 2

Dimension LPR is 4 mm longer when using lock nuts with sealing discs

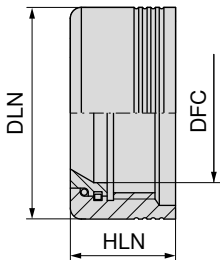


→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

HyPower – ER lock nut for precision collet chucks – Centro-P

- ▲ with thrust collar and angular contact ball bearing
- ▲ Excellent damping and clamping force
- ▲ High-precision lock nut for a perfect fit
- ▲ Run-out ≤ 3 µm with ER precision collets (blue ring)

Centro-P



for collet	DCONWS mm	HLN mm	DFC mm	DLN mm	CT 84 728 ...
470E (ER32)	2 - 20	26.5	32	50	05000
472E (ER40)	3 - 26	31.0	40	63	06300

Spare parts for collet

	HyPower – Lock nuts	Lock nut IK	Lock nut	Stop screw 2	Stop screw 1
	CT	CT	CT	CT	CT
	84 728 ...	84 950 ...	84 950 ...	83 950 ...	83 950 ...
426E (ER16)		011	001		
426E (ER16)		011	001	M11x1 - SW6 341	M11x1 - SW6 337
430E (ER25)		013	003	M18x1,5 - SW6 432	M18x1,5 - SW6 431
430E (ER25)		013	003		
470E (ER32)	05000	015	005	M22x1,5 - SW6 402	M22x1,5 - SW6 401
470E (ER32)	05000	015	005		
472E (ER40)	06300	017	007		
472E (ER40)	06300	017	007		M28x1,5 - SW6 400

Accessories

ER collet	Sealing disc	Roll key	Roll key device	Coolant transfer pipe	Others
→	→	→	→	→	→

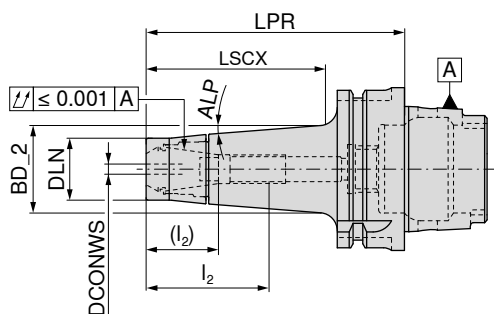
CoreLine – ER precision tapered collet chuck – Centro-P

- ▲ For special tapered nuts
- ▲ Maximum clamping range covered according to ISO tolerance field H10
- ▲ Roll key required for clamping
- ▲ $p_{\max} = 80$ bar
- ▲ **On request:** Also available with Balluff chip

Scope of supply:

Base body **without** lock nut, **without** stop screw

Centro-P



G 2.5 $n_{\max}$ 25000

Adapter	DCONWS mm	LPR mm	DLN mm	BD_2 mm	LSCX mm	I ₂ (I ₂) mm	ALP	for collet
HSK-A 40	1 - 10	100	24	30.8	67	26 - 47 (12 - 32)	2.0°	426E (ER16)
HSK-A 50	1 - 10	65	24	28.9	44	26 - 32	4.5°	426E (ER16)
HSK-A 50	1 - 10	100	24	34.4	77	26 - 47 (12 - 32)	4.5°	426E (ER16)
HSK-A 63	1 - 10	100	24	33.8	74	28 - 48 (20 - 35)	4.5°	426E (ER16)
HSK-A 63	1 - 10	130	24	36.0	77	28 - 48 (20 - 35)	3.5°	426E (ER16)
HSK-A 63	1 - 10	160	24	36.0	106	28 - 48 (20 - 35)	2.5°	426E (ER16)

CT

84 721 ...

310

710

810

610

61200

611



LSCX = Clamping depth without stop screw

I₂ = Clamping depth with stop screw type 1, dimension in brackets (I₂) = Clamping depth with stop screw type 2

Dimension LPR is 4 mm longer when using lock nuts with sealing discs



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts for collet

426E (ER16)

			
CT	CT	CT	CT
84 950 ...	84 950 ...	83 950 ...	83 950 ...
033	031	341	337

Accessories

					
ER collet	Sealing disc	Roll key	Roll key device	Coolant transfer pipe	Others
→	→	→	→	→	→

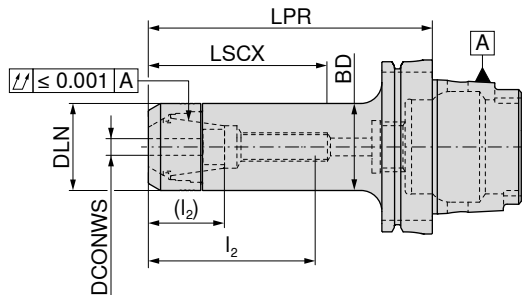
CoreLine – ER precision collet chuck, slim version – Centro-P

- ▲ For mini lock nuts
- ▲ Maximum clamping range covered according to ISO tolerance field H10
- ▲ Roll key required for clamping
- ▲ $p_{\max} = 80$ bar
- ▲ **On request:** Also available with Balluff chip

Scope of supply:

Base body **without** lock nut, **without** stop screw

Centro-P



G 2.5 $n_{\max}$ 25000

Adapter	DCONWS mm	LPR mm	BD mm	DLN mm	LSCX mm	I_2 (I_2) mm	for collet
HSK-A 50	1 - 7	130	16	16	60	15 - 32 (7 - 22)	4008E (ER11)
HSK-A 63	1 - 7	70	16	16	48	15 - 32 (7 - 22)	4008E (ER11)
HSK-A 63	1 - 7	100	16	16	68	18 - 36 (12 - 26)	4008E (ER11)
HSK-A 63	1 - 7	130	16	16	108	15 - 32 (7 - 22)	4008E (ER11)
HSK-A 63	1 - 7	160	16	16	68	18 - 36 (12 - 26)	4008E (ER11)
HSK-A 63	1 - 10	70	22	22	46	27 - 34 (14 - 20)	426E (ER16)
HSK-A 63	1 - 10	100	22	22	62	27 - 44 (14 - 30)	426E (ER16)
HSK-A 63	1 - 10	130	22	22	87	27 - 52 (14 - 38)	426E (ER16)
HSK-A 63	1 - 10	160	22	22	97	27 - 52 (14 - 38)	426E (ER16)

CT

84 719 ...

407

507

607

707

608

610

710

810

910



LSCX = Clamping depth without stop screw

I_2 = Clamping depth with stop screw type 1, dimension in brackets (I_2) = Clamping depth with stop screw type 2

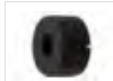
Dimension LPR is 4 mm longer when using lock nuts with sealing discs



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
for collet

4008E (ER11)				
426E (ER16)				

			
Mini lock nut IK	Mini lock nut	Stop screw 2	Stop screw 1
CT	CT	CT	CT
84 950 ...	84 950 ...	83 950 ...	83 950 ...
	041	340	336
035	034	341	337

Accessories

						
ER collet	Sealing disc	Removal aid	Roll key	Roll key device	Coolant transfer pipe	Others
→	→	→	→	→	→	→

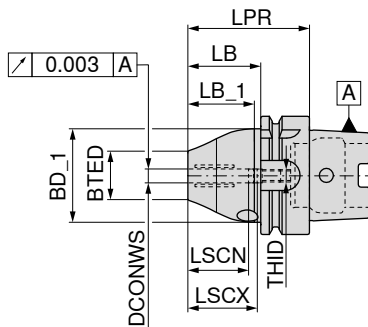
HyPower – High pressure chuck – Rough

- ▲ High pressure chuck – especially for milling
- ▲ Ideal for HSC and HPC applications
- ▲ High temperature resistance
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with backstop screw and pressure screw

Rough



G 2.5 n_{max} 25000

Adapter	DCONWS mm	LPR mm	BTED mm	BD_1 mm	LB_1 mm	LB mm	LSCX mm	LSCN mm	THID
HSK-A 63	6	65	26.0	50.0	35.20	39	37	27	M5
HSK-A 63	8	65	28.0	50.0	35.20	39	37	27	M6
HSK-A 63	10	75	30.0	50.0	45.20	49	41	31	M8x1
HSK-A 63	12	75	32.0	52.5	45.20	49	46	36	M8x1
HSK-A 63	16	79	38.0	52.5	49.20	53	49	39	M8x1
HSK-A 63	20	79	38.0	52.5	49.20	53	51	41	M8x1
HSK-A 63	25	95	48.0	57.0	45.00	69	57	47	M10X1
HSK-A 63	32	110	58.5	62.5	50.00	84	61	51	M10X1
HSK-A 100	6	73	26.0	50.0	40.20	44	37	27	M5
HSK-A 100	8	73	28.0	50.0	40.20	44	37	27	M6
HSK-A 100	10	83	30.0	50.0	50.20	54	41	31	M8x1
HSK-A 100	12	83	32.0	52.5	50.20	54	46	36	M8x1
HSK-A 100	16	87	38.0	52.5	54.20	58	49	39	M8x1
HSK-A 100	20	87	38.0	52.5	54.20	58	51	41	M8x1
HSK-A 100	25	95	56.0	70.0	62.25	66	57	47	M10X1
HSK-A 100	32	100	60.0	75.0	67.25	71	61	51	M10X1

CT

84 254 ...

10657
10857
11057
11257
11657
12057
12557
13257

10655
10855
11055
11255
11655
12055
12555
13255



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

		<div> Clamping key T</div>		<div> Pressure screw</div>		<div> Backstop screw with internal cooling</div>	
		AS		CT		CT	
Spare parts DCONWS		80 397 ...		83 950 ...		83 950 ...	
6	SW5	050	M10x12	55000	M5x12,5 - SW2,5	418	
8	SW5	050	M10x12	55000	M6x12,5 - SW3	419	
10	SW5	050	M10x12	55000	M8x1x13,5 - SW3	420	
12	SW5	050	M10x12	55000	M8x1x13,5 - SW3	420	
16	SW5	050	M10x12	55000	M8x1x13,5 - SW3	420	
20	SW5	050	M10x12	55000	M8x1x13,5 - SW3	420	
25	SW5	050	M10x12	55000	M10x1x13,5 - SW5	421	
32	SW5	050	M10x12	55000	M10x1x13,5 - SW5	421	

Accessories

		
Reduction sleeve	Coolant transfer pipe	Others
→	→	→

HyPower – High pressure chuck – Complus

- ▲ High pressure chuck, short and stable version
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body with stop screw and pressure screw

Complus

Adapter	DCONWS mm	LPR mm	BTED mm	BD_1 mm	BD_2 mm	LB mm	LB_1 mm	LSCX mm	LSCN mm	THID
HSK-A 63	20	80	36	49	52.5	54	36	51	40	M8x1
HSK-A 63	32	105	54	63	52.5	79	55	61	51	M16x1
HSK-A 100	20	85	38	49	52.5	56	36	51	41	M8x1
HSK-A 100	32	100	57	68	72.0	71	42	61	51	M8x1

CT

83 722 ...

120

13257

12055

13255

LSCX = maximum insertion depth
LSCN = minimum insertion depth

→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts for article number			
	AS	CT	CT
	80 397 ...	83 950 ...	83 950 ...
	050	158	420
	050	158	424
83 722 120	050	158	420
83 722 13257	050	158	420
83 722 12055	050	158	420
83 722 13255	050	158	420

Accessories

Reduction sleeveCoolant transfer pipeOthers

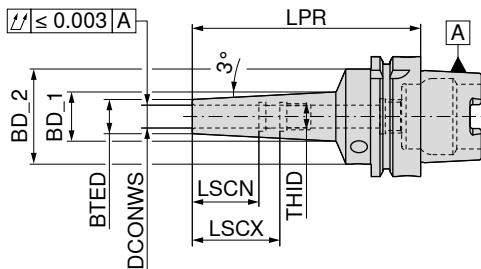
HyPower – High pressure chuck – Access 3°

- ▲ High pressure chuck, slim version 3°
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with backstop screw and pressure screw

Access
3°



G 2.5 n_{max} 25000

	Adapter	DCONWS mm	LPR mm	BTED mm	BD_1 mm	BD_2 mm	LSCX mm	LSCN mm	THID	
Medium length	HSK-A 63	3	120	9	16.65	50	28	12	M3	83 727 ...
	HSK-A 63	4	120	10	17.65	50	28	16	M3	603
	HSK-A 63	5	120	11	18.65	50	28	20	M3	604
	HSK-A 63	6	120	12	19.75	50	37	27	M5	605
	HSK-A 63	8	120	14	21.75	50	37	27	M6	606
	HSK-A 63	10	120	16	23.75	50	41	31	M8x1	608
	HSK-A 63	12	120	18	25.86	50	46	36	M10x1	610
	HSK-A 63	16	120	24	31.50	50	49	39	M12x1	612
Extended	HSK-A 63	20	120	28	35.55	50	51	41	M16x1	616
										620
	HSK-A 63	6	160	16	33.53	50	37	27	M5	706
	HSK-A 63	8	160	18	34.55	50	37	27	M6	708
Extra long	HSK-A 63	10	160	20	36.27	50	41	31	M8x1	710
	HSK-A 63	12	160	22	37.78	50	46	36	M10x1	712
	HSK-A 63	6	200	16	37.83	50	37	27	M5	806
	HSK-A 63	8	200	18	38.85	50	37	27	M6	808
	HSK-A 63	10	200	20	40.57	50	41	31	M8x1	810
	HSK-A 63	12	200	22	42.07	50	46	36	M10x1	812



LSCX = maximum insertion depth
LSCN = minimum insertion depth



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

		<div> Clamping key T</div>		<div> Pressure screw</div>		<div> Backstop screw with internal cooling</div>	
		AS		CT		CT	
Spare parts DCONWS		80 397 ...		83 950 ...		83 950 ...	
3	SW5	050	M10x1x10	158	M3x20 - SW1,5	172	
4	SW5	050	M10x1x10	158	M3x20 - SW1,5	172	
5	SW5	050	M10x1x10	158	M3x20 - SW1,5	172	
6	SW5	050	M10x1x10	158	M5x12,5 - SW2,5	418	
6	SW5	050	M10x1x10	158	M6x12,5 - SW3	419	
8	SW5	050	M10x1x10	158	M6x12,5 - SW3	419	
10	SW5	050	M10x1x12	159	M8x1x13,5 - SW3	420	
12	SW5	050	M10x1x12	159	M10x1x13,5 - SW5	421	
16	SW5	050	M10x1x12	159	M12x1x13,5 - SW5	422	
20	SW5	050	M10x1x12	159	M16x1x13,5 - SW8	424	

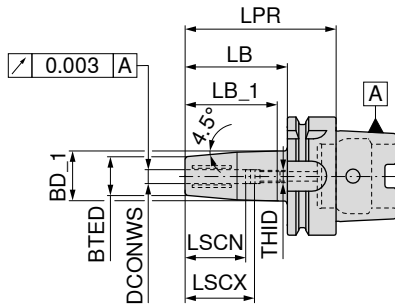
HyPower – High pressure chuck – Access 4,5°

- ▲ High pressure chuck with slim contour, original dimensions of a 4.5° shrink contour
- ▲ Especially for reaming and drilling applications
- ▲ Ideal for tool and die production
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with backstop screw and pressure screw

Access
4,5°



G 2.5 n_{max} 25000

Adapter	DCONWS mm	LPR mm	BTED mm	BD_1 mm	LB_1 mm	LB mm	LSCX mm	LSCN mm	THID	CT
HSK-A 63	6	120	21	27	48.9	94	37	27	M5	84 255 ...
HSK-A 63	6	80	21	27	48.9	54	37	27	M5	20657
HSK-A 63	8	120	21	27	48.9	94	37	27	M6	10657
HSK-A 63	8	80	21	27	48.9	54	37	27	M6	20857
HSK-A 63	10	120	24	32	61.6	94	41	31	M8x1	10857
HSK-A 63	10	85	24	32	53.7	59	41	31	M8x1	21057
HSK-A 63	12	120	24	32	61.6	94	46	36	M10x1	11057
HSK-A 63	12	90	24	32	58.6	64	46	36	M10x1	21257
HSK-A 63	16	120	27	34	56.2	94	49	39	M12x1	11257
HSK-A 63	16	95	27	34	63.1	69	49	39	M12x1	21657
HSK-A 63	20	120	33	42	68.9	94	51	41	M16x1	11657
HSK-A 63	20	100	33	42	68.9	74	51	41	M16x1	22057
HSK-A 100	6	120	21	27	48.9	91	37	27	M5	12057
HSK-A 100	6	85	21	27	38.7	56	37	27	M5	20655
HSK-A 100	8	120	21	27	48.9	91	37	27	M6	10655
HSK-A 100	8	85	21	27	38.7	56	37	27	M6	20855
HSK-A 100	10	120	24	32	61.6	91	41	31	M8x1	10855
HSK-A 100	10	90	24	32	53.7	61	41	31	M8x1	21055
HSK-A 100	12	120	24	32	61.6	91	46	36	M10x1	11055
HSK-A 100	12	95	24	32	58.6	66	46	36	M10x1	21255
HSK-A 100	16	120	27	34	56.2	91	49	39	M12x1	11255
HSK-A 100	16	100	27	34	63.1	71	49	39	M12x1	21655
HSK-A 100	20	120	33	42	68.9	91	51	41	M16x1	11655
HSK-A 100	20	105	33	42	68.9	76	51	41	M16x1	22055
										12055



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

		 Clamping key T		 Pressure screw		 Backstop screw with internal cooling	
		AS		CT		CT	
Spare parts DCONWS		80 397 ...		83 950 ...		83 950 ...	
6	SW5	050	M10x10	55100	M5x12,5 - SW2,5	418	
6	SW5	050	M10x12	55000	M5x12,5 - SW2,5	418	
8	SW5	050	M10x10	55100	M6x12,5 - SW3	419	
8	SW5	050	M10x12	55000	M6x12,5 - SW3	419	
10	SW5	050	M10x10	55000	M8x1x13,5 - SW3	420	
10	SW5	050	M10x10	55100	M8x1x13,5 - SW3	420	
12	SW5	050	M10x12	55000	M10x1x13,5 - SW5	421	
12	SW5	050	M10x10	55100	M10x1x13,5 - SW5	421	
16	SW5	050	M10x10	55100	M12x1x13,5 - SW5	422	
16	SW5	050	M10x12	55000	M12x1x13,5 - SW5	422	
20	SW5	050	M10x10	55100	M16x1x13,5 - SW5	423	
20	SW5	050	M10x12	55000	M16x1x13,5 - SW5	423	
20	SW5	050	M10x12	55000	M16x1x13,5 - SW8	424	
20	SW5	050	M10x10	55100	M16x1x13,5 - SW8	424	

Accessories

		
Reduction sleeve	Coolant transfer pipe	Others
→	→	→

CoreLine – Hydraulic chuck – Fit

- ▲ Hydraulic chuck, short and slim version
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body with stop screw and pressure screw

Fit

G 2.5 n_{max} 25000

	Adapter	DCONWS mm	LPR mm	BD_1 mm	BD_2 mm	LB_1 mm	LB mm	LSCX mm	LSCN mm	THID	
Short	HSK-A 63	6	70	26	49.5	24	44	37	27	M5	83 726 ...
	HSK-A 63	8	70	28	49.5	24	44	37	27	M6	606
	HSK-A 63	10	80	30	49.5	32	54	41	31	M8x1	608
	HSK-A 63	12	85	32	49.5	40	59	46	36	M10x1	610
	HSK-A 63	16	90	38	49.5	46	64	49	39	M12x1	612
	HSK-A 63	20	90	42	49.5	48	64	51	41	M16x1	616
	HSK-A 63	25	120	57	52.0	63	94	57	47	M16x1	620
	HSK-A 63	32	125	63	53.0	61	99	61	51	M16x1	625
	HSK-A 100	6	75	26	50.0	26	46	37	27	M5	632
	HSK-A 100	8	75	28	50.0	26	46	37	27	M6	10655
	HSK-A 100	10	90	30	50.0	42	61	41	31	M8x1	10855
	HSK-A 100	12	95	32	50.0	47	66	46	36	M10x1	11055
	HSK-A 100	16	100	38	50.0	53	71	49	39	M12x1	11255
	HSK-A 100	20	105	42	50.0	59	76	51	41	M16x1	11655
	HSK-A 100	25	110	57	63.0	62	81	57	47	M16x1	12055
	HSK-A 100	32	110	63	67.0	62	81	61	51	M16x1	12555

LSCX = maximum insertion depth
LSCN = minimum insertion depth

→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

		 Pressure screw		 Backstop screw with internal cooling	
		CT		CT	
Spare parts DCONWS		83 950 ...		83 950 ...	
6	M10x1x12	440	M5x12,5 - SW2,5	418	
8	M10x1x12	440	M6x12,5 - SW3	419	
10	M10x1x12	440	M8x1x13,5 - SW3	420	
12	M10x1x12	440	M10x1x13,5 - SW5	421	
16	M10x1x12	440	M12x1x13,5 - SW5	422	
20	M10x1x12	440	M16x1x13,5 - SW8	424	
20	M10x1x12	440	M16x1x13,5 - SW5	423	
25	M10x1x12	440	M16x1x13,5 - SW8	424	
25	M10x1x12	440	M16x1x13,5 - SW5	423	
32	M10x1x12	440	M16x1x13,5 - SW5	423	
32	M10x1x12	440	M16x1x13,5 - SW8	424	

Accessories


Reduction sleeve
→


Coolant transfer pipe
→


Others
→

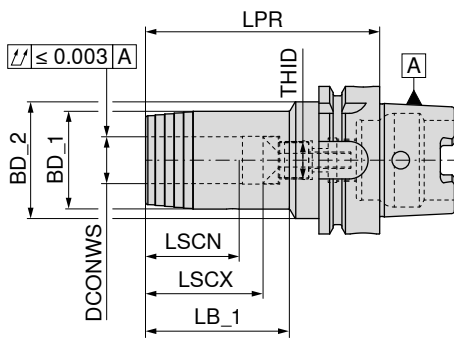
CoreLine – 1-channel MMS hydraulic chuck – Fit

- ▲ 1-channel MMS hydraulic chuck, short
- ▲ MMS = minimum quantity lubrication
- ▲ For automatic tool changing

Scope of supply:

Base body including length adjustment screw and coolant transfer unit

Fit



G 2.5 n_{max} 25000

	Adapter	DCONWS mm	LPR mm	BD_1 mm	BD_2 mm	LB_1 mm	LSCX mm	LSCN mm	THID		CT
Short	HSK-A 63	6	80	26	45	37.0	36	26	M10x1		83 432 ...
	HSK-A 63	8	80	28	45	37.5	36	26	M10x1	00657 ¹⁾	
	HSK-A 63	10	85	30	45	43.5	40	30	M10x1	00857 ¹⁾	
	HSK-A 63	12	90	32	45	49.0	45	35	M10x1	01057 ¹⁾	
	HSK-A 63	14	90	34	45	49.5	45	35	M10x1	01257 ¹⁾	
	HSK-A 63	16	95	38	45	55.5	48	38	M12x1	01457 ¹⁾	
	HSK-A 63	18	95	40	45	56.0	48	38	M12x1	01657 ¹⁾	
	HSK-A 63	20	100	42	50	60.5	50	40	M16x1	01857 ¹⁾	
	HSK-A 63	25	115	57		89.0	56	46	M16x1	02057 ¹⁾	
	HSK-A 63	32	120	63		94.0	60	50	M16x1	02557 ¹⁾	
										03257 ¹⁾	
	HSK-A 100	6	85	26	45	36.5	36	26	M10x1		00655 ¹⁾
	HSK-A 100	8	85	28	45	37.0	36	26	M10x1	00855 ¹⁾	
	HSK-A 100	10	90	30	45	43.0	40	30	M10x1	01055 ¹⁾	
	HSK-A 100	12	95	32	45	48.5	45	35	M10x1	01255 ¹⁾	
	HSK-A 100	14	95	34	45	49.0	45	35	M10x1	01455 ¹⁾	
	HSK-A 100	16	100	38	45	55.0	48	38	M12x1	01655 ¹⁾	
	HSK-A 100	18	100	40	45	55.5	48	38	M12x1	01855 ¹⁾	
	HSK-A 100	20	105	42	50	60.0	50	40	M16x1	02055 ¹⁾	
	HSK-A 100	25	115	57		86.0	56	46	M16x1	02555 ¹⁾	
	HSK-A 100	32	120	63		91.0	60	50	M16x1	03255 ¹⁾	

1) Not in stock



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
DCONWS

	 Clamping key T	 Pressure screw	 1-channel MMS coolant insert	 1-channel MMS adjustment screw
	AS	CT	CT	CT
	80 397 ...	83 950 ...	83 950 ...	83 950 ...
6	040	439	54100	52100
6	040	439	54200	52100
8	040	439	54100	52200
8	040	439	54200	52200
10	040	440	54200	52300
10	040	440	54100	52300
12	050	440	54200	52400
12	050	440	54100	52400
14	050	440	54200	52500
14	050	440	54100	52500
16	050	440	54200	52600
16	050	440	54100	52600
18	050	440	54200	52700
18	050	440	54100	52700
20	050	440	54100	52800
20	050	440	54200	52800
25	050	440	54200	52900
25	050	440	54100	52900
32	050	440	54100	53000
32	050	440	54200	53000

Accessories



Coolant transfer pipe



Others



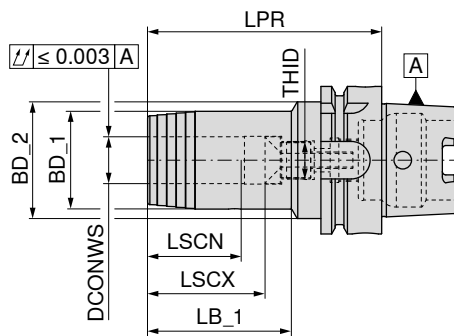
CoreLine – 2-channel MMS hydraulic chuck – Fit

- ▲ 2-channel MMS hydraulic chuck, short
- ▲ MMS = minimum quantity lubrication
- ▲ For automatic tool changing

Scope of supply:

Base body including length adjustment screw and coolant transfer unit

Fit



G 2.5 n_{max} 25000

	Adapter	DCONWS mm	LPR mm	BD_1 mm	BD_2 mm	LB_1 mm	LSCX mm	LSCN mm	THID		CT
Short	HSK-A 63	6	80	26	45	37.0	36	26	M10x1		83 433 ...
	HSK-A 63	8	80	28	45	37.5	36	26	M10x1	00657 ¹⁾	
	HSK-A 63	10	85	30	45	43.5	40	30	M10x1	00857 ¹⁾	
	HSK-A 63	12	90	32	45	49.0	45	35	M10x1	01057 ¹⁾	
	HSK-A 63	14	90	34	45	49.5	45	35	M10x1	01257 ¹⁾	
	HSK-A 63	16	95	38	45	55.5	48	38	M12x1	01457 ¹⁾	
	HSK-A 63	18	95	40	45	56.0	48	38	M12x1	01657 ¹⁾	
	HSK-A 63	20	100	42	50	60.5	50	40	M16x1	01857 ¹⁾	
	HSK-A 63	25	115	57		89.0	56	46	M16x1	02057 ¹⁾	
	HSK-A 63	32	120	63		94.0	60	50	M16x1	02557 ¹⁾	
										03257 ¹⁾	
	HSK-A 100	6	85	26	45	36.5	36	26	M10x1		00655 ¹⁾
	HSK-A 100	8	85	28	45	37.0	36	26	M10x1		00855 ¹⁾
	HSK-A 100	10	90	30	45	43.0	40	30	M10x1		01055 ¹⁾
	HSK-A 100	12	95	32	45	48.5	45	35	M10x1		01255 ¹⁾
	HSK-A 100	14	95	34	45	49.0	45	35	M10x1		01455 ¹⁾
	HSK-A 100	16	100	38	45	55.0	48	38	M12x1		01655 ¹⁾
	HSK-A 100	18	100	40	45	55.5	48	38	M12x1		01855 ¹⁾
	HSK-A 100	20	105	42	50	60.0	50	40	M16x1		02055 ¹⁾
	HSK-A 100	25	115	57		86.0	56	46	M16x1		02555 ¹⁾
	HSK-A 100	32	120	63		91.0	60	50	M16x1		03255 ¹⁾

1) Not in stock



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
DCONWS

	 Clamping key T	 Pressure screw	 2-channel MMS coolant insert	 2-channel MMS adjustment screw
	AS	CT	CT	CT
	80 397 ...	83 950 ...	83 950 ...	83 950 ...
6	020	439	54300	53100
6	020	439	54600	53100
8	020	439	54300	53200
8	020	439	54600	53200
10	020	440	54600	53300
10	020	440	54300	53300
12	030	440	54700	53400
12	030	440	54400	53400
14	030	440	54700	53500
14	030	440	54400	53500
16	030	440	54700	53600
16	030	440	54400	53600
18	030	440	54700	53700
18	030	440	54400	53700
20	040	440	54500	53800
20	040	440	54800	53800
25	040	440	54800	53900
25	040	440	54500	53900
32	040	440	54500	54000
32	040	440	54800	54000

Accessories


Coolant transfer pipe
→


Others
→

CoreLine – Hydraulic chuck – Compact

- ▲ Hydraulic chuck, short and stable version
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body with stop screw and pressure screw

Compact

G 2.5 n_{max} 25000

Adapter	DCONWS	LPR	BD_1	BD_2	BTED	LB	LB_1	LSCN	LSCX	THID
	mm	mm	mm	mm	mm	mm	mm	mm	mm	
HSK-A 63	12	80	42	52.5	32	54	34	36	46	M8x1
HSK-A 63	20	80	49	52.5	38	54	36	41	51	M8x1
HSK-A 100	12	85	42	52.5	32	51	34	36	46	M8x1
HSK-A 100	20	85	49	52.5	38	51	36	41	51	M8x1

CT

83 430 ...

01257

02057

01255

02055

→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
DCONWS

12 - 20	SW5	050	M10x1x10	158	M8x1x13,5 - SW3	420
---------	-----	-----	----------	-----	-----------------	-----

Clamping key T

AS

80 397 ...

Pressure screw

CT

83 950 ...

Backstop screw with internal cooling

CT

83 950 ...

Accessories

Reduction sleeve

→

Coolant transfer pipe

→

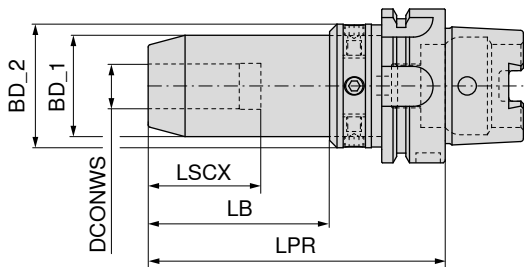
Others

→

HyPower – Compensation holder – DAH

- ▲ Tried-and-tested hydraulic expansion clamping technology
- ▲ Maximum radial run-out accuracy and repeatability < 1 µ ensures consistent cutting action
- ▲ Very simple run-out adjustment
- ▲ Compact design
- ▲ Unbeatable vibration damping, meaning outstanding surface quality
- ▲ Flexible clamping range with reduction sleeves
- ▲ Speeds of up to 25,000 rpm
- ▲ Suitable for minimum quantity lubrication (MMS)

DAH



AD
G 2.5 n_{max} 25000

Adapter	DCONWS	BD_1	BD_2	LB	LSCX	LPR	OAL
	mm	mm	mm	mm	mm	mm	mm
HSK-A 63	20	41.0	50.0	63.1	52.5	110	142
HSK-A 63	25	50.5	60.5	72.1	57.0	135	167

CT
84 326 ...
02057
02557



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Accessories



Reduction sleeve

→



Coolant transfer pipe

→



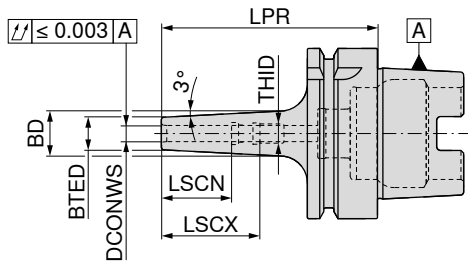
Others

→

CoreLine – Heat shrink adapter, slim 3° – TG

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
 ▲ **By request:** Also available with Balluff chip

TG

G 2.5 n_{max} 25000

		Adapter	DCONWS mm	LPR mm	BTED mm	BD mm	LSCX mm	LSCN mm	THID		
Short	HSK-A 63	3	80	9	14	28	12	M6		CT	84 324 ...
	HSK-A 63	4	80	10	15	28	16	M6			103
	HSK-A 63	5	80	11	16	30	20	M6			104
	HSK-A 63	6	80	12	17	36	26	M5			105
	HSK-A 63	8	80	14	19	36	26	M6			106
	HSK-A 63	10	85	16	21	41	31	M8x1			108
	HSK-A 63	12	90	18	24	47	37	M10x1			110
	HSK-A 63	14	90	20	26	47	37	M10x1			112
	HSK-A 63	16	95	22	28	50	40	M12x1			114
	HSK-A 63	18	95	24	30	50	40	M12x1			116
Medium length	HSK-A 63	20	100	26	33	52	42	M16x1			118
	HSK-A 63	3	120	9	16	12	12				120
	HSK-A 63	4	120	10	17	16	16				203
	HSK-A 63	5	120	11	18	20	20				204
	HSK-A 63	6	120	12	21	36	26	M5			205
	HSK-A 63	8	120	14	23	36	26	M6			206
	HSK-A 63	10	120	16	25	41	31	M8x1			208
	HSK-A 63	12	120	18	27	47	37	M10x1			210
	HSK-A 63	14	120	20	29	47	37	M10x1			212
	HSK-A 63	16	120	22	31	50	40	M12x1			214
Extended	HSK-A 63	18	120	24	33	50	40	M12x1			216
	HSK-A 63	20	120	26	35	52	42	M16x1			218
	HSK-A 63	3	160	9	19	12	12				220
	HSK-A 63	4	160	10	20	16	16				303
	HSK-A 63	5	160	11	21	20	20				304
	HSK-A 63	6	160	12	24	36	26	M5			305
	HSK-A 63	8	160	14	26	36	26	M6			306
	HSK-A 63	10	160	16	28	41	31	M8x1			308
	HSK-A 63	12	160	18	30	47	37	M10x1			310
	HSK-A 63	14	160	20	32	47	37	M10x1			312
	HSK-A 63	16	160	22	34	50	40	M12x1			314
	HSK-A 63	18	160	24	36	50	40	M12x1			316
	HSK-A 63	20	160	26	38	52	42	M16x1			318
											320



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
DCONWS

3 - 5	
6	
8	
10	
12 - 14	
16 - 18	
20	

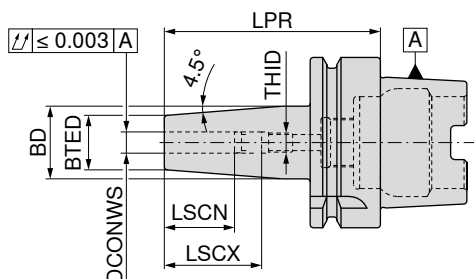
	
Stop screw IK	Backstop screw with internal cooling
CT	CT
83 950 ...	83 950 ...
417	418
	419
	420
	421
	422
	424

CoreLine – Heat shrink adapter 4.5° – TG

▲ For solid carbide and HSS shanks with h6 tolerance or higher

▲ **By request:** Also available with Balluff chip

TG



G 2.5 n_{max}.25000

		Adapter	DCONWS mm	LPR mm	BTED mm	BD mm	LSCX mm	LSCN mm	THID		
										CT	84 304 ...
Short	HSK-A 63	3	80	10	15	22	12	M6			103
	HSK-A 63	4	80	15	22	26	16	M6			104
	HSK-A 63	5	80	15	22	30	20	M6			105
	HSK-A 63	6	80	21	27	36	26	M5			106
	HSK-A 63	8	80	21	27	36	26	M6			108
	HSK-A 63	10	85	24	32	41	31	M8x1			110
	HSK-A 63	12	90	24	32	47	37	M10x1			112
	HSK-A 63	14	90	27	34	47	37	M10x1			114
	HSK-A 63	16	95	27	34	50	40	M12x1			116
	HSK-A 63	18	95	33	42	50	40	M12x1			118
	HSK-A 63	20	100	33	42	52	42	M16x1			120
	HSK-A 63	25	115	44	53	58	48	M16x1			125
	HSK-A 63	32	120	44	53	62	52	M16x1			132
Medium length	HSK-A 63	3	120	10	20	12	12				203
	HSK-A 63	4	120	15	22	16	16				204
	HSK-A 63	5	120	15	22	20	20				205
	HSK-A 63	6	120	21	27	36	26	M5			206
	HSK-A 63	8	120	21	27	36	26	M6			208
	HSK-A 63	10	120	24	32	41	31	M8x1			210
	HSK-A 63	12	120	24	32	47	37	M10x1			212
	HSK-A 63	14	120	27	34	47	37	M10x1			214
	HSK-A 63	16	120	27	34	50	40	M12x1			216
	HSK-A 63	18	120	33	42	50	40	M12x1			218
	HSK-A 63	20	120	33	42	52	42	M16x1			220
	HSK-A 63	25	120	44	53	58	48	M16x1			225
Extended	HSK-A 63	3	160	10	20	12	12				303
	HSK-A 63	4	160	15	22	16	16				304
	HSK-A 63	5	160	15	22	20	20				305
	HSK-A 63	6	160	21	27	36	26	M5			306
	HSK-A 63	8	160	21	27	36	26	M6			308
	HSK-A 63	10	160	24	32	41	31	M8x1			310
	HSK-A 63	12	160	24	32	47	37	M10x1			312
	HSK-A 63	14	160	27	34	47	37	M10x1			314
	HSK-A 63	16	160	27	34	50	40	M12x1			316
	HSK-A 63	18	160	33	42	50	40	M12x1			318
	HSK-A 63	20	160	33	42	52	42	M16x1			320
	HSK-A 63	25	160	44	53	62	52	M16x1			325

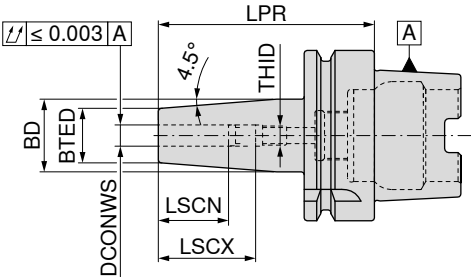


→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

CoreLine – Heat shrink adapter 4.5° – TG

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

TG



G 2.5 n_{max} 25000

		Adapter	DCONWS mm	LPR mm	BTED mm	BD mm	LSCX mm	LSCN mm	THID		
										CT	84 304 ...
Extra long	HSK-A 63	6	200	21	27	36	26	M5			406
	HSK-A 63	8	200	21	27	36	26	M6			408
	HSK-A 63	10	200	24	32	41	31	M8x1			410
	HSK-A 63	12	200	24	32	47	37	M10x1			412
	HSK-A 63	14	200	27	34	47	37	M10x1			414
	HSK-A 63	16	200	27	34	50	40	M12x1			416
	HSK-A 63	18	200	33	42	50	40	M12x1			418
	HSK-A 63	20	200	33	42	52	42	M16x1			420
	HSK-A 63	25	200	44	53	62	52	M16x1			425
	HSK-A 63	32	200	44	53	62	52	M16x1			432



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts DCONWS

3 - 5		
6		
8		
10		
12 - 14		
16 - 18		
20 - 32		

Accessories



Shrink fit extension

→



Others

→



Stop screw IK

CT

83 950 ...

417



Backstop screw with internal cooling

CT

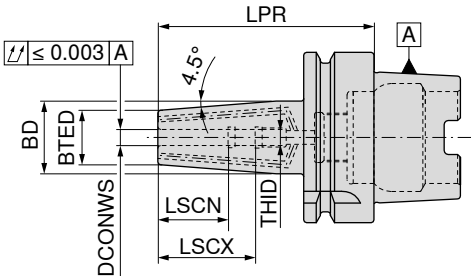
83 950 ...

418
419
420
421
422
423

CoreLine – Heat shrink adapter 4.5° – TG

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

TG



G 2.5 n_{max}.25000

	Adapter	DCONWS	LPR	BTED	BD	LSCX	LSCN	THID	
		mm	mm	mm	mm	mm	mm		
Short	HSK-A 63	3	80	10	15	28	12	M6	84 316 ...
	HSK-A 63	4	80	15	22	28	16	M6	103
	HSK-A 63	5	80	15	22	30	20	M6	104
	HSK-A 63	6	80	21	27	36	26	M5	105
	HSK-A 63	8	80	21	27	36	26	M6	106
	HSK-A 63	10	85	24	32	41	31	M8x1	108
	HSK-A 63	12	90	24	32	47	37	M10x1	110
	HSK-A 63	14	90	27	34	47	37	M10x1	112
	HSK-A 63	16	95	27	34	50	40	M12x1	114
	HSK-A 63	18	95	33	42	50	40	M12x1	116
	HSK-A 63	20	100	33	42	52	42	M16x1	118
	HSK-A 63	25	115	44	53	58	48	M16x1	120
	HSK-A 63	32	120	44	53	62	52	M16x1	125
									132

LSCX = maximum insertion depth
LSCN = minimum insertion depth

→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
DCONWS

3 - 5			
6			
8			
10			
12 - 14			
16 - 18			
20 - 32			

		
Stop screw IK	Backstop screw with internal cooling	Sealing screw
CT	CT	CT
83 950 ...	83 950 ...	83 950 ...
417		512
	418	512
	419	512
	420	512
	421	512
510		512
511		512

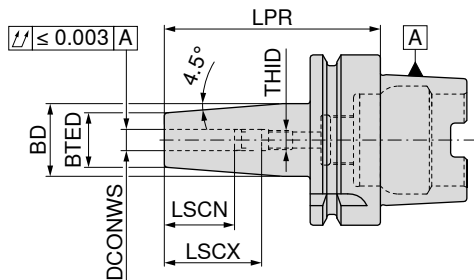
Accessories

		
Shrink fit extension	Coolant transfer pipe	Others
→	→	→

CoreLine – Heat shrink adapter 4.5° – TG

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
 ▲ **By request:** Also available with Balluff chip

TG

G 2.5 n_{max} 25000

		Adapter	DCONWS	LPR	BTED	BD	LSCX	LSCN	THID		
			mm	mm	mm	mm	mm	mm			
Short	HSK-A 100	6	85	21	27	36	26	M5		84 305 ...	106
	HSK-A 100	8	85	21	27	36	26	M6			108
	HSK-A 100	10	90	24	32	41	31	M8x1			110
	HSK-A 100	12	95	24	32	47	37	M10x1			112
	HSK-A 100	14	95	27	34	47	37	M10x1			114
	HSK-A 100	16	100	27	34	50	40	M12x1			116
	HSK-A 100	18	100	33	42	50	40	M12x1			118
	HSK-A 100	20	105	33	42	52	42	M16x1			120
	HSK-A 100	25	115	44	53	58	48	M16x1			125
	HSK-A 100	32	120	44	53	62	52	M16x1			132
Medium length	HSK-A 100	6	120	21	27	36	26	M5			206
	HSK-A 100	8	120	21	27	36	26	M6			208
	HSK-A 100	10	120	24	32	41	31	M8x1			210
	HSK-A 100	12	120	24	32	47	37	M10x1			212
	HSK-A 100	14	120	27	34	47	37	M10x1			214
	HSK-A 100	16	120	27	34	50	40	M12x1			216
	HSK-A 100	18	120	33	42	50	40	M12x1			218
	HSK-A 100	20	120	33	42	52	42	M16x1			220
	HSK-A 100	25	120	44	53	58	48	M16x1			225
Extended	HSK-A 100	6	160	21	27	36	26	M5			306
	HSK-A 100	8	160	21	27	36	26	M6			308
	HSK-A 100	10	160	24	32	41	31	M8x1			310
	HSK-A 100	12	160	24	32	47	37	M10x1			312
	HSK-A 100	14	160	27	34	47	37	M10x1			314
	HSK-A 100	16	160	27	34	50	40	M12x1			316
	HSK-A 100	18	160	33	42	50	40	M12x1			318
	HSK-A 100	20	160	33	42	52	42	M16x1			320
	HSK-A 100	25	160	44	53	58	48	M16x1			325
	HSK-A 100	32	160	44	53	62	52	M16x1			332



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.



CT

Spare parts
DCONWS

6	418
8	419
10	420
12 - 14	421
16 - 18	422
20 - 32	424

83 950 ...

Accessories

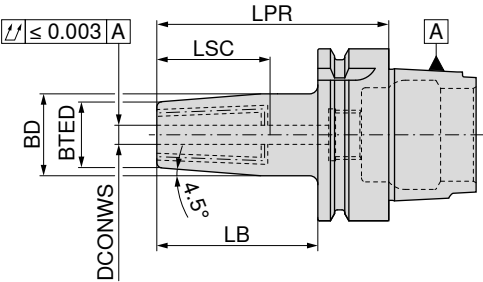
		
Shrink fit extension	Coolant transfer pipe	Others
→	→	→

CoreLine – Heat shrink adapter 4.5° – TG

- ▲ Version for high clamping force
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body including stop screw

TG



G 2.5 n_{max} 25000

		Adapter	DCONWS mm	LPR mm	BTED mm	BD mm	LB mm	LSC mm		
Short	HSK-A 63	HSK-A 63	6	80	21	26	54	36.5	84 717 ...	606
		HSK-A 63	8	80	21	26	54	36.5		608
		HSK-A 63	10	85	24	30	59	41.5		610
		HSK-A 63	12	90	24	30	64	46.5		612
		HSK-A 63	14	90	27	34	64	46.5		614
		HSK-A 63	16	95	27	34	69	49.5		616
		HSK-A 63	18	95	33	41	69	49.5		618
		HSK-A 63	20	100	33	41	74	51.5		620
		HSK-A 63	25	115	44	52	89	57.5		625
		HSK-A 63	32	120	44	52	94	61.5		632
	HSK-A 100	HSK-A 100	6	85	21	26	56	36.5		106
		HSK-A 100	8	85	21	26	56	36.5		108
		HSK-A 100	10	90	24	30	56	41.5		110
		HSK-A 100	12	95	24	30	66	46.5		112
		HSK-A 100	14	95	27	34	66	46.5		114
		HSK-A 100	16	100	27	34	71	49.5		116
		HSK-A 100	18	100	33	42	71	49.5		118
		HSK-A 100	20	105	33	42	76	51.5		120
		HSK-A 100	25	115	44	53	86	57.5		125
		HSK-A 100	32	120	44	53	91	61.5		132



Use sealing screw the close the two additional coolant holes.



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
DCONWS

6	
8	
10	
12 - 18	
20 - 32	

	
Stop screw IK	Sealing screw
CT	CT
62 950 ...	62 950 ...
402	411
403	411
404	411
405	411
406	412

Accessories

		
Shrink fit extension	Coolant transfer pipe	Others
→	→	→

CoreLine – Heat shrink adapter 4.5° – TG

- ▲ Version for high clamping force
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body including stop screw



		Adapter	DCONWS mm	LPR mm	BTED mm	BD_1 mm	LB mm	LSC mm		
Long	HSK-A 63	6	130	21	27	104	36.5		CT	84 720 ...
	HSK-A 63	8	130	21	27	104	36.5			606
	HSK-A 63	10	130	24	32	104	41.5			608
	HSK-A 63	12	130	24	32	104	46.5			610
	HSK-A 63	14	130	27	34	104	46.5			612
	HSK-A 63	16	130	27	34	104	49.5			614
	HSK-A 63	18	130	33	41	104	49.5			616
	HSK-A 63	20	130	33	41	104	51.5			618
										620
	HSK-A 100	6	130	21	27	101	36.5			106
	HSK-A 100	8	130	21	27	101	36.5			108
	HSK-A 100	10	130	24	32	101	41.5			110
	HSK-A 100	12	130	24	32	101	46.5			112
	HSK-A 100	14	130	27	34	101	46.5			114
	HSK-A 100	16	130	27	34	101	49.5			116
	HSK-A 100	18	130	33	41	101	49.5			118
	HSK-A 100	20	130	33	41	101	51.5			120

→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.



Spare parts
DCONWS

6	402
8	403
10	404
12	405
14	405
16	405
18	405
20	406

CT

62 950 ...

Accessories

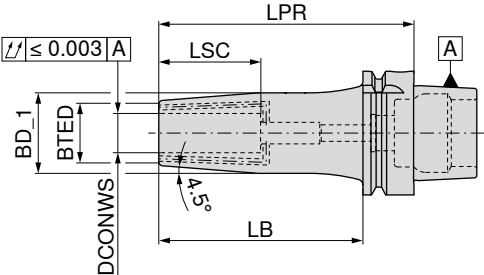
		
Shrink fit extension	Coolant transfer pipe	Others
→	→	→

CoreLine – Heat shrink adapter 4.5° – TG

- ▲ Version for high clamping force
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body including stop screw

TG



G 2.5 n_{max} 25000

								CT	
								84 723 ...	
Extended	Adapter	DCONWS mm	LPR mm	BTED mm	BD_1 mm	LB mm	LSC mm		
	HSK-A 63	6	160	21	27	134	36.5	606	
	HSK-A 63	8	160	21	27	134	36.5	608	
	HSK-A 63	10	160	24	32	134	41.5	610	
	HSK-A 63	12	160	24	32	134	46.5	612	
	HSK-A 63	14	160	27	34	134	46.5	614	
	HSK-A 63	16	160	27	34	134	49.5	616	
	HSK-A 63	18	160	33	41	134	49.5	618	
	HSK-A 63	20	160	33	41	134	51.5	620	
	HSK-A 63	25	160	44	52	134	57.5	625	
	HSK-A 100	6	160	21	27	131	36.5	106	
	HSK-A 100	8	160	21	27	131	36.5	108	
	HSK-A 100	10	160	24	32	131	41.5	110	
	HSK-A 100	12	160	24	32	131	46.5	112	
	HSK-A 100	14	160	27	34	131	46.5	114	
	HSK-A 100	16	160	27	34	131	49.5	116	
	HSK-A 100	18	160	33	41	131	49.5	118	
	HSK-A 100	20	160	33	41	131	51.5	120	
	HSK-A 100	25	160	44	53	131	57.5	125	
	HSK-A 100	32	160	44	53	131	61.5	132	



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

				
			Stop screw IK	Sealing screw
			CT	CT
Spare parts			62 950 ...	62 950 ...
DCONWS				
6	M5x0,8x14	402	M3x6	411
8	M6x1x16	403	M3x6	411
10	M8x1x20	404	M3x6	411
12	M10x1x20	405	M3x6	411
14	M10x1x20	405	M3x6	411
16	M10x1x20	405	M3x6	411
18	M10x1x20	405	M3x6	411
20	M12x1x20	406	M3x6	411
25	M12x1x20	406	M4x8	412
32	M12x1x20	406	M4x8	412

Accessories







Shrink fit extension

Coolant transfer pipe

Others

→

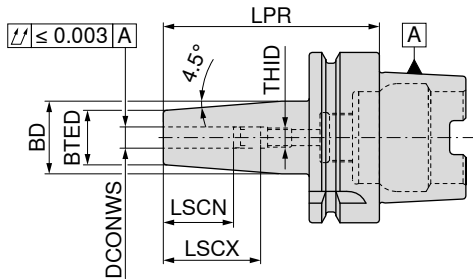
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→

CoreLine – Heat shrink adapter 4.5° – TG

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
 ▲ **By request:** Also available with Balluff chip

TG



G 2.5 n_{max} 25000

	Adapter	DCONWS mm	LPR mm	BTED mm	BD mm	LSCX mm	LSCN mm	THID	
Short	HSK-A 63	3	80	10	15	22	12		82 310 ...
	HSK-A 63	4	80	15	22	26	16		10357
	HSK-A 63	5	80	15	22	30	20		10457
	HSK-A 63	6	80	21	27	36	26	M5	10557
	HSK-A 63	8	80	21	27	36	26	M6	10657
	HSK-A 63	10	85	24	32	41	31	M8x1	10857
	HSK-A 63	12	90	24	32	47	37	M10x1	11057
	HSK-A 63	14	90	27	34	47	37	M10x1	11257
	HSK-A 63	16	95	27	34	50	40	M12x1	11457
	HSK-A 63	18	95	33	42	50	40	M12x1	11657
	HSK-A 63	20	100	33	42	52	42	M16x1	11857
	HSK-A 63	25	115	44	53	58	48	M16x1	12057
Medium length	HSK-A 63	32	120	44	53	62	52	M16x1	12557
	HSK-A 63	3	120	10	20	12	12		13257
	HSK-A 63	4	120	15	22	16	16		20357
	HSK-A 63	5	120	15	22	20	20		20457
	HSK-A 63	6	120	21	27	36	26	M5	20557
	HSK-A 63	8	120	21	27	36	26	M6	20657
	HSK-A 63	10	120	24	32	41	31	M8x1	20857
	HSK-A 63	12	120	24	32	47	37	M10x1	21057
	HSK-A 63	14	120	27	34	47	37	M10x1	21257
	HSK-A 63	16	120	27	34	50	40	M12x1	21457
	HSK-A 63	18	120	33	42	50	40	M12x1	21657
	HSK-A 63	20	120	33	42	52	42	M16x1	21857
Extended	HSK-A 63	25	120	44	53	58	48	M16x1	22057
	HSK-A 63	3	160	10	20	12	12		22557
	HSK-A 63	4	160	15	22	16	16		30357
	HSK-A 63	5	160	15	22	20	20		30457
	HSK-A 63	6	160	21	27	36	26	M5	30557
	HSK-A 63	8	160	21	27	36	26	M6	30657
	HSK-A 63	10	160	24	32	41	31	M8x1	30857
	HSK-A 63	12	160	24	32	47	37	M10x1	31057
	HSK-A 63	14	160	27	34	47	37	M10x1	31257
	HSK-A 63	16	160	27	34	50	40	M12x1	31457
	HSK-A 63	18	160	33	42	50	40	M12x1	31657
	HSK-A 63	20	160	33	42	52	42	M16x1	31857
	HSK-A 63	25	160	44	53	62	52	M16x1	32057
	HSK-A 63								32557



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
DCONWS

3 - 5	M6x16 - SW3	30100
6	M5x16 - SW2,5	30000
8	M6x16 - SW3	30100
10	M8x1x16 - SW4	30200
12 - 14	M10x1x14 - SW5	30300
16 - 18	M12x1x16 - SW6	30400
20 - 32	M16x1x16 - SW8	30500



Stop screw IK

CX

82 950 ...

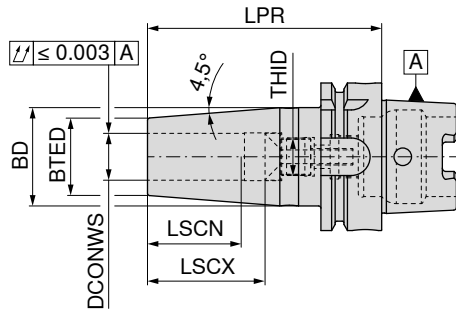
CoreLine – 1-channel MMS heat shrink adapter 4.5° – TG

- ▲ For automatic tool changing
- ▲ MMS = minimum quantity lubrication
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher

Scope of supply:

Base body including length adjustment screw and coolant transfer unit

TG



G 2.5 n_{max} 25000

Adapter	DCONWS mm	LPR mm	BTED mm	BD mm	LSCX mm	LSCN mm	THID
HSK-A 63	6	80	21	27	36	26	M10x1
HSK-A 63	8	80	21	27	36	26	M10x1
HSK-A 63	10	85	24	32	40	30	M10x1
HSK-A 63	12	90	24	32	45	35	M10x1
HSK-A 63	14	90	27	34	45	35	M10x1
HSK-A 63	16	95	27	34	48	38	M12x1
HSK-A 63	18	95	33	42	48	38	M12x1
HSK-A 63	20	100	33	42	50	40	M16x1
HSK-A 63	25	115	44	53	56	46	M16x1
HSK-A 63	32	120	44	53	60	50	M16x1
HSK-A 100	6	85	21	27	36	26	M10x1
HSK-A 100	8	85	21	27	36	26	M10x1
HSK-A 100	10	90	24	32	40	30	M10x1
HSK-A 100	12	95	24	32	45	35	M10x1
HSK-A 100	14	95	27	34	45	35	M10x1
HSK-A 100	16	100	27	34	48	38	M12x1
HSK-A 100	18	100	33	42	48	38	M12x1
HSK-A 100	20	105	33	42	50	40	M16x1
HSK-A 100	25	115	44	53	56	46	M16x1
HSK-A 100	32	120	44	53	60	50	M16x1

CT

84 318 ...

00657 ¹⁾
00857 ¹⁾
01057 ¹⁾
01257 ¹⁾
01457 ¹⁾
01657 ¹⁾
01857 ¹⁾
02057 ¹⁾
02557 ¹⁾
03257 ¹⁾

00655 ¹⁾
00855 ¹⁾
01055 ¹⁾
01255 ¹⁾
01455 ¹⁾
01655 ¹⁾
01855 ¹⁾
02055 ¹⁾
02555 ¹⁾
03255 ¹⁾

1) Not in stock



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts DCONWS	<div><div> Clamping key T</div><div> 1-channel MMS coolant insert</div><div> 1-channel MMS adjustment screw</div></div>		
	AS	CT	CT
	80 397 ...	83 950 ...	83 950 ...
6	040	54200	52100
6	040	54100	52100
8	040	54200	52200
8	040	54100	52200
10	040	54100	52300
10	040	54200	52300
12	050	54100	52400
12	050	54200	52400
14	050	54100	52500
14	050	54200	52500
16	050	54100	52600
16	050	54200	52600
18	050	54100	52700
18	050	54200	52700
20	050	54200	52800
20	050	54100	52800
25	050	54100	52900
25	050	54200	52900
32	050	54200	53000
32	050	54100	53000

Accessories





Coolant transfer pipe

Others

→

→

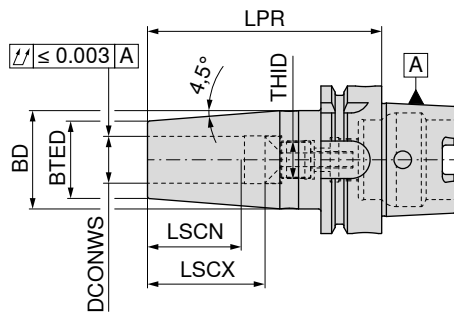
CoreLine – 2-channel MMS heat shrink adapter 4.5° – TG

- ▲ For automatic tool changing
- ▲ MMS = minimum quantity lubrication
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher

Scope of supply:

Base body including length adjustment screw and coolant transfer unit

TG



G 2.5 n_{max} 25000

Adapter	DCONWS mm	LPR mm	BTED mm	BD mm	LSCX mm	LSCN mm	THID
HSK-A 63	6	80	21	27	36	26	M10x1
HSK-A 63	8	80	21	27	36	26	M10x1
HSK-A 63	10	85	24	32	40	30	M10x1
HSK-A 63	12	90	24	32	45	35	M10x1
HSK-A 63	14	90	27	34	45	35	M10x1
HSK-A 63	16	95	27	34	48	38	M12x1
HSK-A 63	18	95	33	42	48	38	M12x1
HSK-A 63	20	100	33	42	50	40	M16x1
HSK-A 63	25	115	44	53	56	46	M16x1
HSK-A 63	32	120	44	53	60	50	M16x1
HSK-A 100	6	85	21	27	36	26	M10x1
HSK-A 100	8	85	21	27	36	26	M10x1
HSK-A 100	10	90	24	32	40	30	M10x1
HSK-A 100	12	95	24	32	45	35	M10x1
HSK-A 100	14	95	27	34	45	35	M10x1
HSK-A 100	16	100	27	34	48	38	M12x1
HSK-A 100	18	100	33	42	48	38	M12x1
HSK-A 100	20	105	33	42	50	40	M16x1
HSK-A 100	25	115	44	53	56	46	M16x1
HSK-A 100	32	120	44	53	60	50	M16x1

CT

84 319 ...

00657 ¹⁾
00857 ¹⁾
01057 ¹⁾
01257 ¹⁾
01457 ¹⁾
01657 ¹⁾
01857 ¹⁾
02057 ¹⁾
02557 ¹⁾
03257 ¹⁾

00655 ¹⁾
00855 ¹⁾
01055 ¹⁾
01255 ¹⁾
01455 ¹⁾
01655 ¹⁾
01855 ¹⁾
02055 ¹⁾
02555 ¹⁾
03255 ¹⁾

1) Not in stock



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts DCONWS	<div><div><div>Clamping key T</div></div><div><div>2-channel MMS coolant insert</div></div><div><div>2-channel MMS adjustment screw</div></div></div>		
	AS	CT	CT
	80 397 ...	83 950 ...	83 950 ...
6	020	54300	53100
6	020	54600	53100
8	020	54300	53200
8	020	54600	53200
10	020	54600	53300
10	020	54300	53300
12	030	54700	53400
12	030	54400	53400
14	030	54700	53500
14	030	54400	53500
16	030	54700	53600
16	030	54400	53600
18	030	54700	53700
18	030	54400	53700
20	040	54500	53800
20	040	54800	53800
25	040	54800	53900
25	040	54500	53900
32	040	54500	54000
32	040	54800	54000

Accessories





Coolant transfer pipe

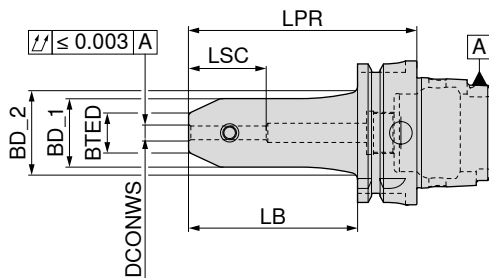
Others

→

→

CoreLine – Cylindrical shank adapter Weldon

- ▲ For shanks according to DIN 6535 HB / 1835 B with lateral clamping flat
 ▲ **By request:** Also available with Balluff chip

G 2.5 n_{max} 25000G 2.5 n_{max} 25000

	Adapter	DCONWS _{H5} mm	LPR mm	BTED mm	BD_1 mm	LB mm	LSC mm	CX	
								82 740 ...	82 741 ...
Short	HSK-A 63	6	65	17	30	39	34	10657	10657
	HSK-A 63	8	65	20	32	39	34	10857	10857
	HSK-A 63	10	65	25	35	39	39	11057	11057
	HSK-A 63	12	80	30	42	54	44	11257	11257
	HSK-A 63	14	80	32	45	54	44	11457	11457
	HSK-A 63	16	80	36	48	54	47	11657	11657
	HSK-A 63	18	80	38	48	54	47	11857	11857
	HSK-A 63	20	80	40	52	54	49	12057	12057
	HSK-A 63	25	110	45	63	84	54	12557 ¹⁾	12557 ¹⁾
	HSK-A 63	32	110	52	72	84	58	13257 ¹⁾	13257 ¹⁾
	HSK-A 63	40	120	60	80	94	68		14057
	HSK-A 63	40	120	60	80	94	68	14057	
	HSK-A 100	6	80	17	30	51	34	10655	10655
	HSK-A 100	8	80	20	32	51	34	10855	10855
	HSK-A 100	10	80	25	35	51	39	11055	11055
	HSK-A 100	12	80	30	42	51	44	11255	11255
	HSK-A 100	14	80	32	45	51	44	11455	11455
	HSK-A 100	16	100	36	48	71	47	11655	11655
	HSK-A 100	18	100	38	48	71	47	11855	11855
	HSK-A 100	20	100	40	52	71	49	12055	12055
	HSK-A 100	25	100	45	65	71	54	12555 ¹⁾	12555 ¹⁾
Medium length	HSK-A 63	6	100	17	30	74	34	20657	20657
	HSK-A 63	8	100	20	32	74	34	20857	20857
	HSK-A 63	10	100	25	35	74	39	21057	21057
	HSK-A 63	12	100	30	42	74	44	21257	21257
	HSK-A 63	14	100	32	45	74	44	21457	21457
	HSK-A 63	16	100	36	48	74	47	21657	21657
	HSK-A 63	18	100	38	48	74	47	21857	21857
	HSK-A 63	20	100	40	52	74	49	22057	22057

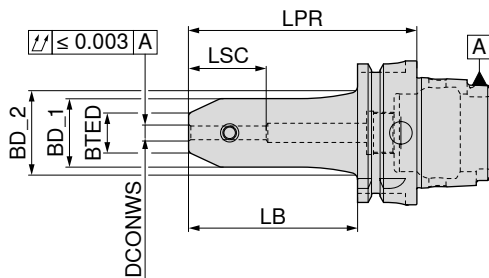
1) Version with two clamping screws



The M3 screws supplied with WAF 1.5 mm can be used to seal the two additional coolant holes.

CoreLine – Cylindrical shank adapter Weldon

- ▲ For shanks according to DIN 6535 HB / 1835 B with lateral clamping flat
 ▲ **By request:** Also available with Balluff chip

G 2.5 n_{max} 25000G 2.5 n_{max} 25000

	Adapter	DCONWS _{H5} mm	LPR mm	BTED mm	BD_1 mm	LB mm	LSC mm
Long	HSK-A 63	6	130	17	30	104	34
	HSK-A 63	8	130	20	32	104	34
	HSK-A 63	10	130	25	35	104	39
	HSK-A 63	12	130	30	42	104	44
	HSK-A 63	14	130	32	45	104	44
	HSK-A 63	16	130	36	48	104	47
	HSK-A 63	18	130	38	48	104	47
	HSK-A 63	20	130	40	52	104	49
	HSK-A 63	25	130	45	63	104	54
	HSK-A 63	32	130	52	72	104	58

Extended	HSK-A 63	6	160	17	30	134	34
	HSK-A 63	8	160	20	32	134	34
	HSK-A 63	10	160	25	35	134	39
	HSK-A 63	12	160	30	42	134	44
	HSK-A 63	14	160	32	45	134	44
	HSK-A 63	16	160	36	48	134	47
	HSK-A 63	18	160	38	48	134	47
	HSK-A 63	20	160	40	52	134	49
	HSK-A 63	25	160	45	63	134	54
	HSK-A 100	6	160	17	30	131	34
	HSK-A 100	8	160	20	32	131	34
	HSK-A 100	10	160	25	35	131	39
	HSK-A 100	12	160	30	42	131	44
	HSK-A 100	14	160	32	45	131	44
	HSK-A 100	16	160	36	48	131	47
	HSK-A 100	18	160	38	48	131	47
	HSK-A 100	20	160	40	52	131	49
	HSK-A 100	25	160	45	65	131	54
	HSK-A 100	32	160	52	72	134	58

CX	CX
82 740 ...	82 741 ...
30657	30657
30857	30857
31057	31057
31257	31257
31457	31457
31657	31657
31857	31857
32057	32057
32557 ¹⁾	32557 ¹⁾
33257 ¹⁾	33257 ¹⁾
40657	40657
40857	40857
41057	41057
41257	41257
41457	41457
41657	41657
41857	41857
42057	42057
42557 ¹⁾	42557 ¹⁾
40655	40655
40855	40855
41055	41055
41255	41255
41455	41455
41655	41655
41855	41855
42055	42055
42555 ¹⁾	42555 ¹⁾
43255 ¹⁾	43255 ¹⁾

1) Version with two clamping screws



The M3 screws supplied with WAF 1.5 mm can be used to seal the two additional coolant holes.

Spare parts
DCONWS_{HS}

6
8
10
12 - 14
16 - 18
20
25
32 - 40

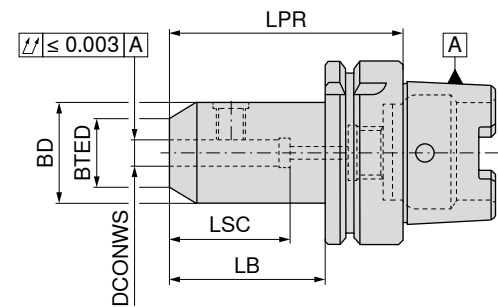
 Set Screw
CT
62 950 ...
006
008
010
012
016
020
025
032

Accessories

	
Coolant transfer pipe	Others
→	→

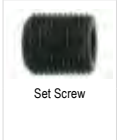
CoreLine – Cylindrical shank adapter Weldon

- ▲ For shanks according to DIN 6535 HB / 1835 B with lateral clamping flat
- ▲ With eroded coolant channels
- ▲ **By request:** Also available with Balluff chip



G 2.5 n_{max} 25000

	Adapter	DCONWS _{H4} mm	LPR mm	BD mm	BTED mm	LB mm	LSC mm	CX 82 404 ...
Short	HSK-A 63	6	65	25	15	39	37	10657
	HSK-A 63	8	65	28	20	39	37	10857
	HSK-A 63	10	65	35	25	39	41	11057
	HSK-A 63	12	80	42	30	54	46	11257
	HSK-A 63	14	80	44	32	54	46	11457
	HSK-A 63	16	80	48	36	54	49	11657
	HSK-A 63	18	80	50	38	54	49	11857
	HSK-A 63	20	80	52	40	54	51	12057
	HSK-A 63	25	110	65	45	84	57	12557
	HSK-A 63	32	110	72	52	84	61	13257
	HSK-A 63	40	125	80	60	99	73	14057
	HSK-A 100	6	80	25	15	51	37	10655
	HSK-A 100	8	80	28	20	51	37	10855
	HSK-A 100	10	80	35	25	51	41	11055
	HSK-A 100	12	80	42	30	51	46	11255
	HSK-A 100	14	80	44	32	51	46	11455
	HSK-A 100	16	100	48	36	71	49	11655
	HSK-A 100	18	100	50	38	71	49	11855
	HSK-A 100	20	100	52	40	71	51	12055
	HSK-A 100	25	100	65	45	71	57	12555
	HSK-A 100	32	100	72	52	71	61	13255
	HSK-A 100	40	110	80	60	81	73	14055



Set Screw

CT

Spare parts
DCONWS_{H4}

62 950 ...

6	M6x10	006
8	M8x10	008
10	M10x12	010
12 - 14	M12x16	012
16 - 18	M14x16	016
20	M16x16	020
25	M18x2x20	025
32 - 40	M20x2x20	032

Accessories



Coolant transfer pipe

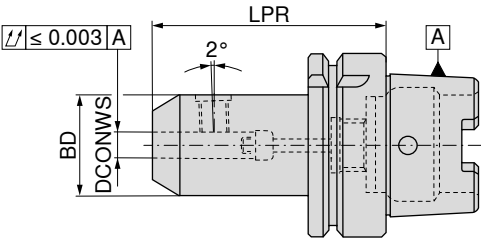


Others



CoreLine – Cylindrical shank adapter Whistle Notch

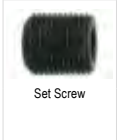
- ▲ For shanks according to DIN 6535 HE / 1835 E with angled clamping flat
- ▲ **By request:** Also available with Balluff chip



G 2.5 n_{max} 25000

	Adapter	DCONWS _{H4} mm	LPR mm	BD mm	
Short	HSK-A 63	6	80	25	CX 82 742 ... 10657 10857 11057 11257 11457 11657 11857 12057 12557 ¹⁾ 13257 ¹⁾ 10655 10855 11055 11255 11455 11655 11855 12055 12555 ¹⁾ 13255 ¹⁾ 14055 ¹⁾
	HSK-A 63	8	80	28	
	HSK-A 63	10	80	35	
	HSK-A 63	12	90	42	
	HSK-A 63	14	90	44	
	HSK-A 63	16	100	48	
	HSK-A 63	18	100	50	
	HSK-A 63	20	100	52	
	HSK-A 63	25	110	65	
	HSK-A 63	32	110	72	
	HSK-A 100	6	90	25	
	HSK-A 100	8	90	28	
	HSK-A 100	10	90	35	
	HSK-A 100	12	100	42	
	HSK-A 100	14	100	44	
	HSK-A 100	16	100	48	
	HSK-A 100	18	100	50	
	HSK-A 100	20	110	52	
	HSK-A 100	25	120	65	
	HSK-A 100	32	120	72	
	HSK-A 100	40	120	80	

1) Version with two clamping screws



Set Screw

CT

62 950 ...

Spare parts
DCONWS_{H4}

6	M6x10	006
8	M8x10	008
10	M10x12	010
12 - 14	M12x16	012
16 - 18	M14x16	016
20	M16x16	020
25	M18x2x20	025
32 - 40	M20x2x20	032

Accessories



Coolant transfer pipe

→

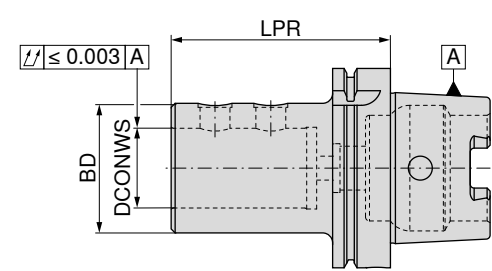
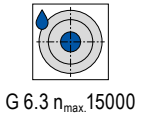


Others

→

CoreLine – Indexable insert drill adapter

▲ **By request:** Also available with Balluff chip



Adapter	DCONWS mm	LPR mm	BD mm
HSK-A 63	20	80	40
HSK-A 63	25	90	45
HSK-A 63	32	90	52
HSK-A 63	40	110	65
HSK-A 100	20	90	40
HSK-A 100	25	100	45
HSK-A 100	32	100	52
HSK-A 100	40	110	65
HSK-A 100	50	120	75

CX
10 842 ...
320
325
332
340
420
425
432
440
450

Spare parts

DCONWS

20	M10x1x10	001
25 - 32	M12x1x10	002
40 - 50	M16x1x12	003



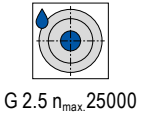
Accessories



CoreLine – ER precision collet chucks – PCC

- ▲ For standard or sealing disc lock nuts
- ▲ Maximum clamping range covered according to ISO tolerance field H10
- ▲ Roll key required for clamping
- ▲ $p_{max} = 100 \text{ bar}$
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body with lock nut and stop screws



Adapter	DCONWS mm	LPR mm	DLN mm	for collet	Tightening torque / clamping force Nm
HSK-A 63	1 - 10	75	30	426E (ER16)	40 / 2-70
HSK-A 63	1 - 10	100	30	426E (ER16)	40 / 2-70
HSK-A 63	2 - 16	75	40	430E (ER25)	80 / 10-160
HSK-A 63	2 - 16	100	40	430E (ER25)	80 / 10-160
HSK-A 63	2 - 20	75	50	470E (ER32)	125 / 15-250
HSK-A 63	2 - 20	100	50	470E (ER32)	125 / 15-250
HSK-A 100	2 - 16	100	40	430E (ER25)	80 / 10-160
HSK-A 100	2 - 16	160	40	430E (ER25)	80 / 10-160
HSK-A 100	2 - 20	100	50	470E (ER32)	125 / 15-250
HSK-A 100	2 - 20	160	50	470E (ER32)	125 / 15-250

CX
82 700 ...
11057
21057
11657
21657
12057
22057
21655
41655
22055
42055



Dimension LPR is 4.5 mm longer for ER16 and ER32 and 5.0 mm longer for ER25 when using thru coolant lock nut

Spare parts
for collet

426E (ER16)	11000	01000			M8X3,0	00100
430E (ER25)	11600	01600	M18x1,5	00200	M8x8	00300
470E (ER32)	12000	02000	M18x1,5	00200	M8x8	00300

 Lock nut IK	 Lock nut	 Stop screw PCC 2	 Stop screw PCC 1
CX	CX	CX	CX
82 950 ...	82 950 ...	82 950 ...	82 950 ...

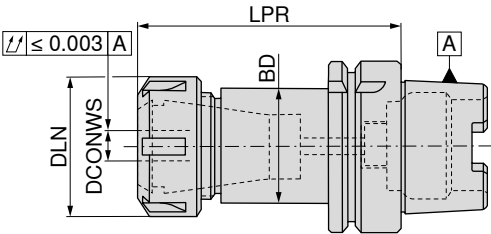
Accessories

		
ER collet	Sealing disc	Roll key
→	→	→

CoreLine – ER collet chuck

▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body including lock nut



G 2.5 n_{max} 25000

	Adapter	DCONWS mm	LPR mm	DLN mm	TQX Nm	for collet	
Medium length	HSK-A 63	1 - 10	100	22	8 - 56	426E (ER16 mini)	82 743 ...
	HSK-A 63	1 - 10	100	32	8 - 56	426E (ER16)	21157
	HSK-A 63	1 - 16	100	42	24 - 104	430E (ER25)	21057
	HSK-A 63	2 - 20	100	50	24 - 136	470E (ER32)	21657
	HSK-A 63	3 - 26	100	63	176	472E (ER40)	22057
Long	HSK-A 100	1 - 10	100	32	8 - 56	426E (ER16)	22657
	HSK-A 100	1 - 16	100	42	24 - 104	430E (ER25)	21055
	HSK-A 100	2 - 20	100	50	24 - 136	470E (ER32)	21655
	HSK-A 100	3 - 26	100	63	176	472E (ER40)	22055
Extended	HSK-A 63	1 - 10	160	22	8 - 56	426E (ER16 mini)	22655
	HSK-A 63	1 - 10	160	32	8 - 56	426E (ER16)	41157
	HSK-A 63	1 - 16	160	42	24 - 104	430E (ER25)	41057
	HSK-A 63	2 - 20	160	50	24 - 136	470E (ER32)	41657
	HSK-A 63	3 - 26	160	63	176	472E (ER40)	42057
	HSK-A 100	1 - 10	160	32	8 - 56	426E (ER16)	42657
	HSK-A 100	1 - 16	160	42	24 - 104	430E (ER25)	41055
	HSK-A 100	2 - 20	160	50	24 - 136	470E (ER32)	41655
Extra long	HSK-A 100	3 - 26	160	63	176	472E (ER40)	42055
	HSK-A 100	1 - 10	200	32	8 - 56	426E (ER16)	42655
	HSK-A 100	1 - 16	200	42	24 - 104	430E (ER25)	51055
	HSK-A 100	2 - 20	200	50	24 - 136	470E (ER32)	51655
	HSK-A 100	3 - 26	200	63	176	472E (ER40)	52055
							52655



Dimension LPR is 5.0 mm longer for ER16, ER25 and ER32, and 5.5 mm for ER40 when using thru coolant lock nuts.

Spare parts for collet							
	Lock nut IK	Lock nut	Y clamping key	ER-Mini clamping key	Mini lock nut	Mini lock nut IK	Stop screw IK
	CT	CT	CX	CT	CT	CT	CX
	83 950 ...	62 950 ...	83 357 ...	83 950 ...	62 950 ...	83 950 ...	82 950 ...
	426E (ER16 mini)			101	066	058	30000
	426E (ER16)	054	054	116			
	430E (ER25)	055	055	125			
	470E (ER32)	056	65600	132			
	472E (ER40)	057	65700	140			

Accessories

		
ER collet	Coolant transfer pipe	Others
→	→	→

CoreLine – Short drill chuck – NC 2010

- ▲ Independent of direction of rotation
- ▲ Tightening torque = 12 Nm
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body including clamping key SW4

NC
2010

G 6.3 n_{max} 10000

Adapter	DCONWS mm	BD_1 mm	BD_2 mm	LB_1 mm	LB mm	LPR mm	LF mm
HSK-A 63	0,5 - 13	48.5	56	50.9		126.0	116.9
HSK-A 63	2,5 - 16	51.0	56	50.9		127.5	116.9
HSK-A 100	0,5 - 13	48.5	56	50.9	86	129.0	120.0
HSK-A 100	2,5 - 16	51.0	56	50.9	86	130.5	120.0

CX

84 716 ...

613

616

113

116

Can be used with G 2.5 to 30,000 rpm by subsequent balancing!

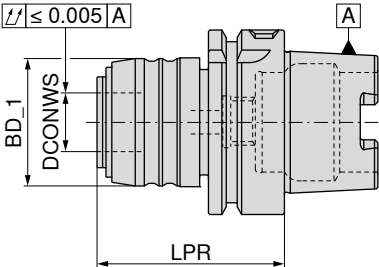
Accessories

Others

→

CoreLine – Synchro quick change tapping chuck with minimum length compensation

- ▲ With length compensation under tension and compression (LZD)
- ▲ For collets according to DIN 6499
- ▲ $p_{max.} = 50 \text{ bar}$
- ▲ **By request:** Also available with Balluff chip



Adapter	Cutting range	SZID	DCONWS mm	LPR mm	BD_1 mm	LZD± mm
HSK-A 63	M3 - M12	1	20	64	43	1,0 / 0,2
HSK-A 63	M6 - M20	2	32	97	60	1,0 / 0,2
HSK-A 100	M3 - M12	1	20	70	43	1,0 / 0,2
HSK-A 100	M6 - M20	2	32	91	60	1,0 / 0,2

CT
83 724 ...
612
620
112
120

Accessories



Coolant transfer pipe

→



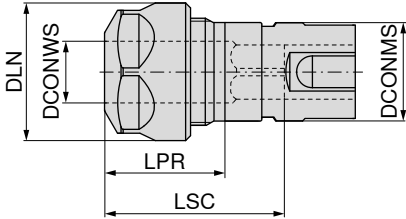
Others

→

Insert for synchro quick change tapping chuck with minimum length compensation

▲ SZID = for insert size

Scope of supply:
Includes lock nut

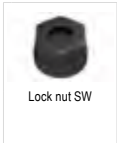


SZID	DCONWS mm	Cutting range	LPR mm	DLN mm	LSC mm	for collet	DCONMS mm	CT 83 608 ... 012 ¹⁾ 020
1	2 - 10	M3 - M12	24	28	42	426E (ER16)	20	
2	2 - 16	M6 - M20	28	42	59	430E (ER25)	32	

1) With hex nut

Spare parts
for article number

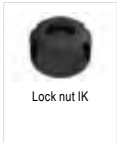
83 608 012	M22x1,5 - SW25	044	M22x1,5	054	M22x1,5	054	116
83 608 020			M32x1,5	055	M32x1,5	055	125



Lock nut SW

CT

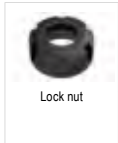
62 950 ...



Lock nut IK

CT

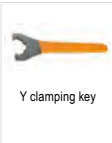
83 950 ...



Lock nut

CT

62 950 ...



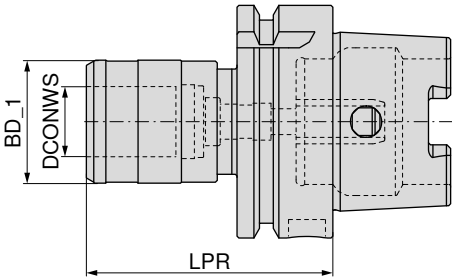
Y clamping key

CX

83 357 ...

CoreLine – Quick change tapping chuck with length compensation

- ▲ With length compensation under tension and compression (LZD)
- ▲ **By request:** Also available with Balluff chip



Adapter	SZID	LPR mm	BD_1 mm	DCONWS mm	LZD± mm
HSK-A 63	01	72	41	19	7,5
HSK-A 63	02	110	60	31	10
HSK-A 100	01	80	41	19	7,5
HSK-A 100	02	100	60	31	10

CT
83 712 ...
612
620
112
120

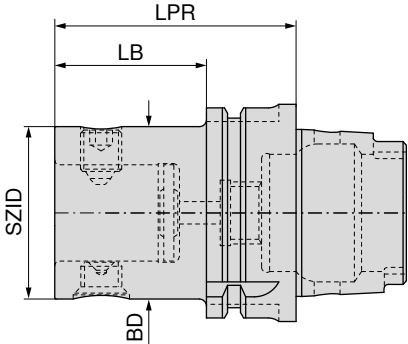
Accessories

		
Insert	Coolant transfer pipe	Others
→	→	→

HyPower – Adapter – ABS

▲ **By request:** Also available with Balluff chip

ABS







G 6.3 n_{max} 10000

Adapter	SZID	BD mm	LPR mm	LB mm
HSK-A 50	ABS 50	50	70	
HSK-A 63	ABS 25	25	50	24
HSK-A 63	ABS 32	32	50	24
HSK-A 63	ABS 40	40	60	34
HSK-A 63	ABS 50	50	42	
HSK-A 63	ABS 50	50	70	44
HSK-A 63	ABS 63	63	80	54
HSK-A 63	ABS 80	80	100	74
HSK-A 100	ABS 100	100	100	71
HSK-A 100	ABS 25	25	60	31
HSK-A 100	ABS 32	32	60	31
HSK-A 100	ABS 40	40	80	51
HSK-A 100	ABS 50	50	80	51
HSK-A 100	ABS 63	63	80	51
HSK-A 100	ABS 80	80	90	61

CT

84 200 ...

05058

06390

06389

06388

05057 ¹⁾

06397

06396

06392

10091

10090

10089

10088

10097

10096

10092

1) Only suitable for fine machining

						
		Clamping screw	Clamping screw	Set	Taper screw	Sealing disc – ABS
		CT	CT	CT	CT	CT
Spare parts		62 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...
SZID						
ABS 25			26800	99700	27000	
ABS 32	M8x1x12/SW4	13989		99600	27100	
ABS 40			26900	99500	27200	
ABS 50			20300	99800	20400	30700
ABS 50			20300	99800	20400	
ABS 63			25500	99400	27300	
ABS 80			25600	99300	25100	
ABS 100			25700	99200	25200	

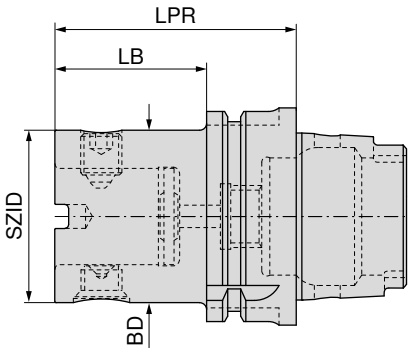
Accessories

		
Coolant transfer pipe	Extension	Others
→	→	→

HyPower – Adapter – ABS N

▲ By request: Also available with Balluff chip

ABS N



G 6.3 n_{max} 10000

Adapter	SZID	BD mm	LPR mm	LB mm
HSK-A 63	ABS 50 N	50	70	44
HSK-A 100	ABS 50 N	50	80	51
HSK-A 100	ABS 63 N	63	80	51
HSK-A 100	ABS 80 N	80	90	61

CT
84 200 ...
25057
25055
26355
28055

Spare parts for article number

	CT	CT	CT	CT	CT	CT
84 200 25057	20300	99800	31800	20200	20400	30700
84 200 25055	20300	99800	31800	20200	20400	30700
84 200 26355	25500	99400	31900	23900	27300	30800
84 200 28055	25600	99300	32000	24000	25100	30900

					
Clamping screw	Set	Positioning pin	Positioning pin	Taper screw	Sealing disc – ABS
CT	CT	CT	CT	CT	CT
84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...

Accessories



Coolant transfer pipe

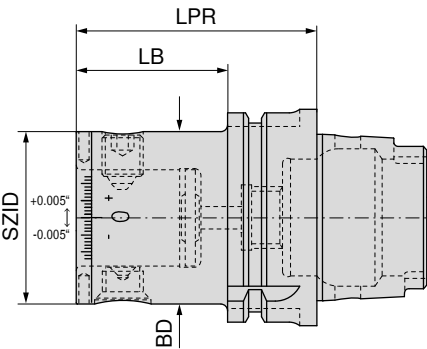


HyPower – Eccentric adjuster – ABS

- ▲ Adjustment ±0.010 inch on diameter
- ▲ also available with Balluff chip **on request**

Scope of supply:
Eccentric adjuster with adjuster key Ø 2.8 mm

ABS





Adapter	SZID	BD mm	LPR mm	LB mm
HSK-A 63	ABS 50	50	70.0	39.5
HSK-A 100	ABS 50	50	75.5	46.5
HSK-A 100	ABS 63	63	80.0	51.0

CT

84 203 ...

06397

10097

10096

Spare parts
SZID

ABS 50	20300	99800	20400
ABS 63	25500	99400	27300

 Clamping screw	 Set	 Taper screw
CT	CT	CT
84 950 ...	84 950 ...	84 950 ...
20300	99800	20400
25500	99400	27300

Accessories


Coolant transfer pipe
→


Extension
→


Others
→

HyPower – Torsional vibration damper – ABS

▲ **By request:** Also available with Balluff chip



Adapter	SZID	BD mm	LPR mm	LB mm
HSK-A 63	ABS 50	50	70	44
HSK-A 63	ABS 63	63	80	54
HSK-A 63	ABS 80	80	100	74
HSK-A 100	ABS 50	50	80	51
HSK-A 100	ABS 63	63	80	51
HSK-A 100	ABS 80	80	90	61

CT

84 206 ...

06397

06396

06392

10097

10096

10092

Spare parts
SZID

ABS 50	20300	99800	20400
ABS 63	25500	99400	27300
ABS 80	25600	99300	25100

 Clamping screw	 Set	 Taper screw
CT	CT	CT
84 950 ...	84 950 ...	84 950 ...

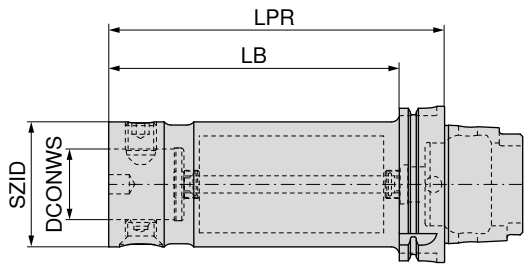
Accessories



HyPower – Adapter – Lightweight – ABS

▲ **By request:** Also available with Balluff chip

ABS

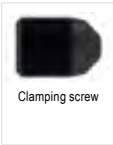
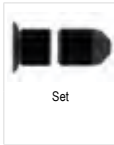
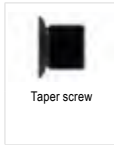
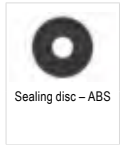


Adapter	SZID	DCONWS mm	LB mm	LPR mm
HSK-A 100	ABS 80	46	186	215

84 200 ...
18055

Spare parts
SZID

ABS 80

			
Clamping screw	Set	Taper screw	Sealing disc – ABS
CT	CT	CT	CT
84 950 ...	84 950 ...	84 950 ...	84 950 ...
25600	99300	25100	30900

Accessories



HyPower – Compensation holder – DAH

- ▲ Compensation systems for μ-precision run-out
- ▲ Simple correction of run-out and axis errors
- ▲ Optimized for high rpm
- ▲ Designed for internal coolant supply
- ▲ Rotary tools provide long tool life

Scope of supply:
DAH compensation holder complete with assembly screws

DAH

Adapter	SZID	DCONWS mm	LSC mm	LPR mm	LF mm
HSK-A 63	DAH 63	50	12	78	66
HSK-A 63	DAH 81	65	12	78	66
HSK-A 80	DAH 81	65	12	88	76
HSK-A 100	DAH 81	65	12	88	76
HSK-A 100	DAH 115	100	16	95	79

CT

84 329 ...

06357

08157

08156

08155

11555

					
			Grub screw	Spring washer	DAH adjustment ring
			CT	CT	CT
Spare parts SZID			84 950 ...	84 950 ...	84 950 ...
DAH 63	M6x8	42700	Ø5,3 - M5	42300	DAH 63 42200
DAH 81	M6x10	42800	Ø5,3 - M5	42300	DAH 81 42000
DAH 115	M8x10	43000	Ø8,4 - M8	42400	DAH 115 42100

			
		Cylindrical screw	Clamping screw
		CT	AS
Spare parts SZID		84 950 ...	62 950 ...
DAH 63	M5x22	42500	M8x6 - SW4 53400
DAH 81	M5x22	42500	M8x6 - SW4 53400
DAH 115	M8X30	42600	M8x8 - SW4 14700

Accessories





Coolant transfer pipe

Others

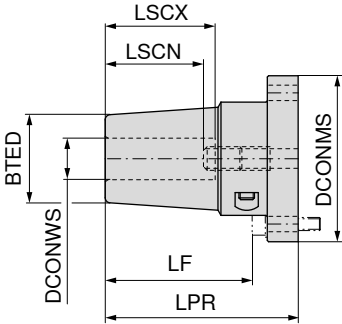
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→

HyPower – Adapter – DAH

- ▲ Compensation systems for μ-precision run-out
- ▲ Simple correction of run-out and axis errors
- ▲ Optimized for high rpm
- ▲ Designed for internal coolant supply
- ▲ Rotary tools provide long tool life

DAH



AD

Adapter	DCONWS mm	DCONMS mm	BD mm	BTED mm	LB mm	LF mm	LPR mm	LSCN mm	LSCX mm
DAH 63	12	49.5	27	21.0	45	52	70	35	45
DAH 81	12	64.5	32	24.0	45	52	70	35	45
DAH 81	16	64.5	44	34.0	45	57	75	39	49
DAH 81	20	64.5	40	37.0	50	57	75	41	51
DAH 81	25	64.5	50	46.5	52		110	46	56
DAH 81	32	64.5	60	56.5	59		115	51	61

CT

84 327 ...
12600
12800
16800
20800
25800
32800

Accessories

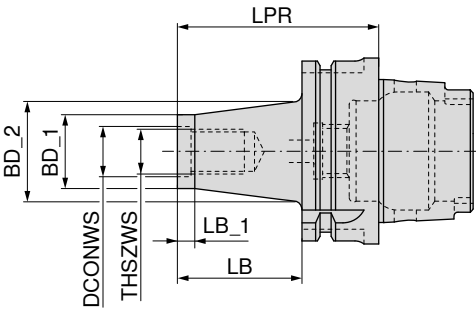


Reduction sleeve



CoreLine – Adapter for screw-in cutter – Conical

▲ By request: Also available with Balluff chip



G 2.5 n_{max} 25000

Adapter	THSZWS	DCONWS mm	LB mm	BD_1 mm	BD_2 mm	LB_1 mm	LPR mm
HSK-A 63	M8	8.5	25	13.8	15	12	51
HSK-A 63	M8	8.5	50	13.8	23	12	76
HSK-A 63	M8	8.5	75	13.8	25	12	101
HSK-A 63	M8	8.5	100	13.8	30	12	126
HSK-A 63	M10	10.5	25	18.0	23	12	51
HSK-A 63	M10	10.5	50	18.0	25	12	76
HSK-A 63	M10	10.5	75	18.0	30	12	101
HSK-A 63	M10	10.5	100	18.0	35	12	126
HSK-A 63	M12	12.5	25	21.0	24	12	51
HSK-A 63	M12	12.5	50	21.0	30	12	76
HSK-A 63	M12	12.5	75	21.0	35	12	101
HSK-A 63	M12	12.5	100	21.0	38	12	126
HSK-A 63	M12	12.5	125	21.0	43	12	151
HSK-A 63	M12	12.5	150	21.0	45	12	176
HSK-A 63	M16	17.0	25	29.0	29	12	51
HSK-A 63	M16	17.0	50	29.0	34	12	76
HSK-A 63	M16	17.0	75	29.0	35	12	101
HSK-A 63	M16	17.0	100	29.0	40	12	126
HSK-A 63	M16	17.0	125	29.0	44	12	151
HSK-A 63	M16	17.0	150	29.0	48	12	176

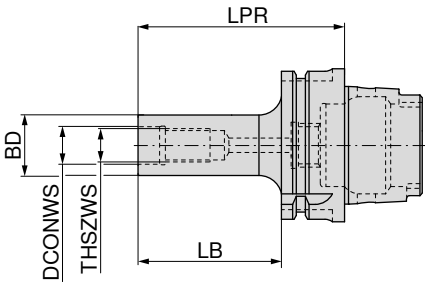
CX
82 749 ...
08157
08257
08357
08457
10157
10257
10357
10457
12157
12257
12357
12457
12557
12657
16157
16257
16357
16457
16557
16657

Accessories

Extension/reduction	Coolant transfer pipe	Others
→	→	→

CoreLine – Adapter for screw-in cutter – Cylindrical

▲ **By request:** Also available with Balluff chip



G 2.5 n_{max} 25000

Adapter	THSZWS	DCONWS mm	BD mm	LB mm	LPR mm
HSK-A 63	M8	8.5	13.8	50	76
HSK-A 63	M10	10.5	18.0	50	76
HSK-A 63	M10	10.5	18.0	75	101
HSK-A 63	M10	10.5	18.0	100	126
HSK-A 63	M12	12.5	21.0	50	76
HSK-A 63	M12	12.5	21.0	75	101
HSK-A 63	M12	12.5	21.0	100	126
HSK-A 63	M16	17.0	29.0	50	76
HSK-A 63	M16	17.0	29.0	75	101
HSK-A 63	M16	17.0	29.0	100	126

CX
82 750 ...
08257
10257
10357
10457
12257
12357
12457
16257
16357
16457

Accessories



Extension/reduction

→



Coolant transfer pipe

→



Others

→

These combination shell mill adapters are prebalanced without drive ring, parallel key, and clamping screw!

Spare parts
DCONWS

		<div> Parallel key</div> <div>CT</div> <div>83 950 ...</div>	<div> Drive ring</div> <div>CX</div> <div>83 370 ...</div>	<div> Tightening screw</div> <div>CT</div> <div>83 950 ...</div>
16	4 x 4 x 20	284	116	M8x25113
22	6 x 6 x 25	285	122	M10x25124
27	7 x 7 x 25	286	127	M12x30125
32	8 x 7 x 28	287	132	M16x35126
40	10 x 8 x 32	288	140	M20x40 - SW17112

Accessories

<div></div> <div>Milling adapter ring</div> <div>→</div>	<div></div> <div>Coolant transfer pipe</div> <div>→</div>	<div></div> <div>Others</div> <div>→</div>
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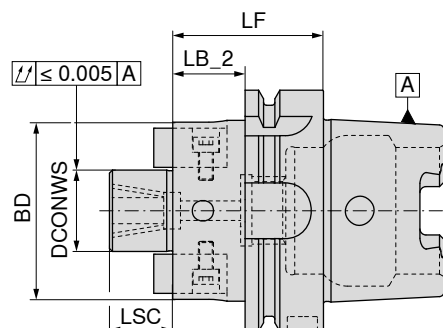
CoreLine – Shell mill adapter with reduced flange diameter

▲ Screwed in drive keys

▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with retaining screw and drive key



G 2.5 n_{max} 25000

	Adapter	DCONWS mm	LB_2 mm	LF mm	BD mm	LSC mm	
Short	HSK-A 63	22	34	60	38	19	82 315 ... 12257 12757
	HSK-A 63	27	34	60	48	21	
	HSK-A 100	22	31	60	38	19	
	HSK-A 100	27	31	60	48	21	
Medium length	HSK-A 63	22	74	100	38	19	22257 22757
	HSK-A 63	27	74	100	48	21	
	HSK-A 100	22	71	100	38	19	
	HSK-A 100	27	71	100	48	21	
Long	HSK-A 63	22	104	130	38	19	32257 32757
	HSK-A 63	27	104	130	48	21	
	HSK-A 100	22	101	130	38	19	
	HSK-A 100	27	101	130	48	21	



These shell mill adapters have been specially developed for MaxiMill 211-KN porcupine cutters. Now they can be clamped perfectly, due to the adapted flange diameters.

Spare parts DCONWS

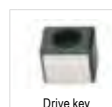
22	M4x8	51700	10x7x20,5	51500	M10x25	124
27	M5x8	51800	12x9x24,3	51600	M12x30	125



Carrier screws

CT

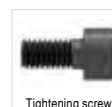
83 950 ...



Drive key

CT

83 950 ...



Tightening screw

CT

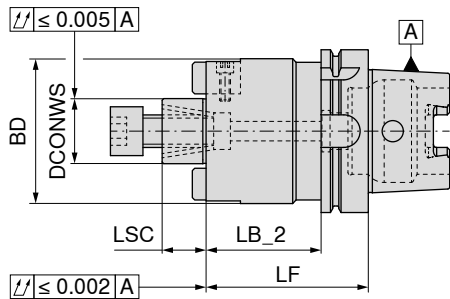
83 950 ...

CoreLine – Shell mill adapter

- ▲ For milling cutters with transverse slot ISO 3937
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with clamping screw and drive dogs



G 2.5 n_{max} 25000

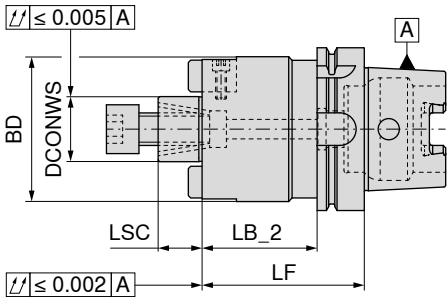
	Adapter	DCONWS mm	LB_2 mm	LF mm	BD mm	BD_1 mm	BD_2 mm	LSC mm	
Short	HSK-A 63	16	34	60	38			17	82 745 ...
	HSK-A 63	22	34	60	48			19	11657
	HSK-A 63	27	34	60	58			21	12257
	HSK-A 63	32	34	60	78			24	12757
	HSK-A 63	40	34	70	88			27	13257
									14057 ¹⁾
	HSK-A 100	16	31	60	38			17	11655
	HSK-A 100	22	31	60	48			19	12255
	HSK-A 100	27	31	60	58			21	12755
	HSK-A 100	32	31	60	78			24	13255
Medium length	HSK-A 63	16	74	100		38	44.3	17	21657
	HSK-A 63	22	74	100		48	50.3	19	22257
	HSK-A 63	27	74	100	58			21	22757
	HSK-A 63	32	74	100	78			24	23257
	HSK-A 63	40	74	100	88			27	24057 ¹⁾
	HSK-A 100	16	71	100		38	46.3	17	21655
	HSK-A 100	22	71	100		48	56.3	19	22255
	HSK-A 100	27	71	100		58	66.3	21	22755
	HSK-A 100	32	71	100		78	80.3	24	23255
Long	HSK-A 63	16	104	130		38	44.3	17	31657
	HSK-A 63	22	104	130		48	50.3	19	32257
	HSK-A 63	27	104	130	58			21	32757
	HSK-A 63	32	104	130	78			24	33257
	HSK-A 63	40	104	130	88			27	34057 ¹⁾
	HSK-A 100	16	101	130		38	46.3	17	31655
	HSK-A 100	22	101	130		48	56.3	19	32255
	HSK-A 100	27	101	130		58	66.3	21	32755
	HSK-A 100	32	101	130		78	80.3	24	33255

1) With cross screw and 4 threaded holes M12 front face, pitch circle diameter = 66.7 mm, coolant outlet on the outer diameter of the spigot (DCONWS)!

CoreLine – Shell mill adapter

- ▲ For milling cutters with transverse slot ISO 3937
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body with clamping screw and drive dogs



Extended	Adapter	DCONWS mm	LB_2 mm	LF mm	BD mm	BD_1 mm	BD_2 mm	LSC mm	CX 82 745 ... 41657 42257 42757 43257 44057 ¹⁾ 41655 42255 42755 43255 44055 ¹⁾
	HSK-A 63	16	134	160		38	44.3	17	
	HSK-A 63	22	134	160		48	50.3	19	
	HSK-A 63	27	134	160	58			21	
	HSK-A 63	32	134	160	78			24	
	HSK-A 63	40	134	160	88			27	
	HSK-A 100	16	131	160		38	46.3	17	
	HSK-A 100	22	131	160		48	56.3	19	
	HSK-A 100	27	131	160		58	66.3	21	
	HSK-A 100	32	131	160		78	80.3	24	
	HSK-A 100	40	131	160	88			27	

1) With cross screw and 4 threaded holes M12 front face, pitch circle diameter = 66.7 mm, coolant outlet on the outer diameter of the spigot (DCONWS)!

						
		Cross nut key		Retaining screws		Tightening screw
		CX		CX		CT
Spare parts DCONWS		83 368 ...		83 367 ...		83 950 ...
16		116	M8	016	M8x25	113
22		122	M10	022	M10x25	124
27		127	M12	027	M12x30	125
32		132	M16	032	M16x35	126
40		140	M20	040	M20x40 - SW17	112
						
				Carrier screws		Drive key
				CT		CT
Spare parts DCONWS				83 950 ...		83 950 ...
16			M3x8	296	8x9x17,5	120
22			M4x12	297	10x11x20,5	121
27			M5x12	136	12x13x24,3	122
32			M5x20	137	14x21x21,2	123
40			M6x16	138	15,9x16,3x19,5	295

Accessories

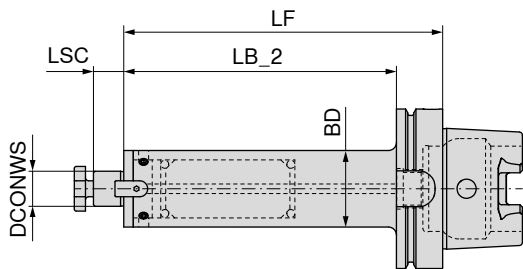
		
Extension	Coolant transfer pipe	Others
→	→	→

HyPower – Actively vibration-damped shell mill adapter

- ▲ The specially mounted damping core enables perfect machining results even with longer tool overhangs
- ▲ Reduction in machining times due to optimum machining parameters
- ▲ Damped machining and therefore perfect surface qualities
- ▲ Protection of the machine spindle and increased tool life
- ▲ Screwed in drive keys
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body with retaining screw and drive key

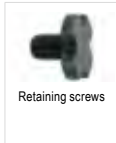


Adapter	DCONWS mm	LB_2 mm	LF mm	BD mm	LSC mm
HSK-A 63	16	174	200	39	17
HSK-A 63	22	174	200	48	19
HSK-A 100	16	171	200	39	17
HSK-A 100	22	171	200	48	19
HSK-A 100	27	171	200	58	21

CT
84 752 ...
51657
52257
51655
52255
52755

Spare parts
DCONWS

16
22
27

			
CT	CT	CX	CT
83 950 ...	83 950 ...	83 367 ...	83 950 ...
296	120	016	113
297	121	022	124
136	122	027	125

Accessories



Coolant transfer pipe

→

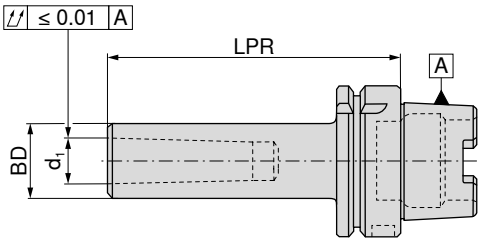


Others

→

CoreLine – Taper sleeve adapter for DIN 228-2D Morse taper shanks

▲ **By request:** Also available with Balluff chip



G 6.3 n_{max} 8000

Adapter	d ₁	LPR mm	BD mm
HSK-A 63	MK1	100	25
HSK-A 63	MK2	120	32
HSK-A 63	MK3	140	40
HSK-A 63	MK4	160	48
HSK-A 100	MK2	120	32
HSK-A 100	MK3	150	40
HSK-A 100	MK4	170	48

CX

82 746 ...

01057

02057

03057

04057

02055

03055

04055

Accessories



Morse taper adapter sleeve
→



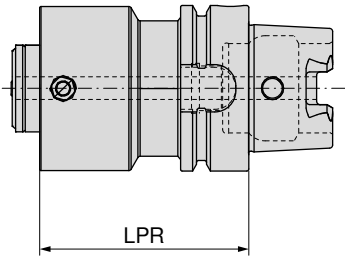
Coolant transfer pipe
→



Others
→

CoreLine – HSK-T extension

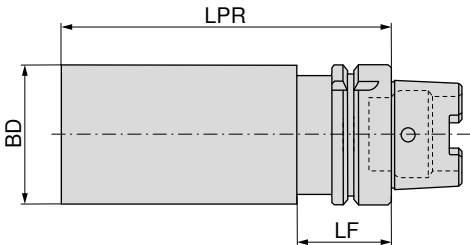
- ▲ For mounting HSK-T adapters according to ISO 12164-3
- ▲ Also suitable for HSK-A and HSK-C
- ▲ **On request:** Also available with Balluff chip



Adapter		LPR mm	<div>CT</div> <div>84 621 ...</div> <div>08037</div> <div>12037</div> <div>12535</div> <div>16035</div> <div>20035</div>
HSK-T 63		80	
HSK-T 63		120	
HSK-T 100		125	
HSK-T 100		160	
HSK-T 100		200	

CoreLine – Blank

- ▲ Material: 1.7131
- ▲ For the production of special tools
- ▲ Taper hardened and ground
- ▲ Tool 27±1 HRC
- ▲ **On request:** Also available with Balluff chip



Adapter	BD mm	LPR mm	LF mm
HSK-A 63	63.0	200	42
HSK-A 63	80.0	250	42
HSK-A 100	63.0	200	
HSK-A 100	80.0	250	
HSK-A 100	97.5	250	45

CX
82 747 ...
16357
18057
16355
18055
19755

Accessories



Coolant transfer pipe

→

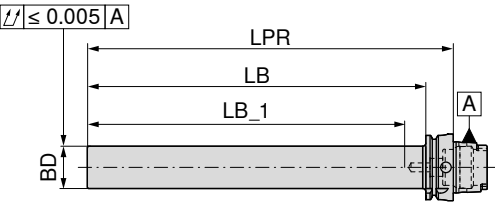


Others

→

CoreLine – Test arbor

Scope of supply:
In wooden box



Adapter	BD mm	LPR mm	LB_1 mm	LB mm
HSK-A 63	40	346	300	320
HSK-A 100	40	349	300	320

CT

81 746 ...

063

100

CoreLine – ER precision collet chucks – Centro-P

- ▲ For standard or sealing disc lock nuts
- ▲ Maximum clamping range covered according to ISO tolerance field H10
- ▲ Roll key required for clamping
- ▲ $p_{max} = 80 \text{ bar}$

Scope of supply:
Base body **without** lock nut, **without** stop screw

Centro-P

G 2.5 n_{max} 30000

Adapter	DCONWS mm	LPR mm	DLN mm	LSCX mm	l ₂ mm	for collet
HSK-E 40	2 - 16	60	40	39		430E (ER25)
HSK-E 50	2 - 16	70	40	49	30 - 39	430E (ER25)

CT

84 776 ...

417

516

LSCX = Clamping depth without stop screw
l₂ = Clamping depth with stop screw type 1
Dimension LPR is 4 mm longer when using lock nuts with sealing discs

→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
for collet

430E (ER25)

Lock nut IK

CT

84 950 ...

013

Lock nut

CT

84 950 ...

003

Accessories

ER collet

→

Sealing disc

→

Roll key

→

Roll key device

→

Coolant transfer pipe

→

Others

→

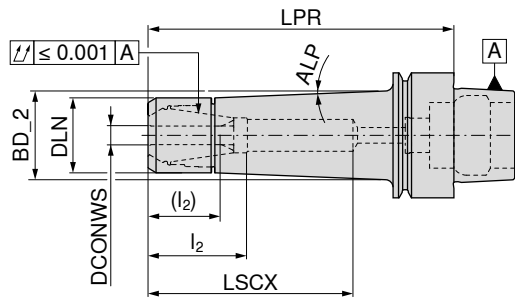
CoreLine – ER precision tapered collet chuck – Centro-P

- ▲ For mini lock nuts
- ▲ Maximum clamping range covered according to ISO tolerance field H10
- ▲ Roll key required for clamping
- ▲ $p_{\max} = 80$ bar

Scope of supply:

Base body **without** lock nut, **without** stop screw

Centro-P



G 2.5 $n_{\max}$ 30000

	Adapter	DCONWS mm	LPR mm	DLN mm	BD_2 mm	LSCX mm	l_2 (l_2) mm	ALP	for collet	CT
Short	HSK-E 25	1 - 7	35	16		22			4008E (ER11 mini)	84 774 ...
	HSK-E 32	1 - 7	50	16	17.5	31	18 - 20	4.5°	4008E (ER11 mini)	07200
	HSK-E 40	1 - 7	50	16	17.5	31	18 - 20	4.5°	4008E (ER11 mini)	307
										407
	HSK-E 25	1 - 10	45	22		30			426E (ER16 mini)	101
	HSK-E 32	1 - 10	55	22	25.8	40	28 - 32 (12 - 22)	4.5°	426E (ER16 mini)	310
	HSK-E 40	1 - 10	55	22	25.8	38	28 - 30 (12 - 20)	4.5°	426E (ER16 mini)	410
	HSK-E 50	1 - 10	60	22	25.4	39	28 - 31 (12 - 21)	4.5°	426E (ER16 mini)	510
Medium length	HSK-E 40	1 - 7	100	16	25.4	64	18 - 36 (12 - 26)	4.5°	4008E (ER11 mini)	408
	HSK-E 40	1 - 10	100	22	29.0	66	28 - 48 (12 - 38)	2.5°	426E (ER16 mini)	411
	HSK-E 50	1 - 10	100	22	28.2	72	28 - 48 (12 - 38)	2.5°	426E (ER16 mini)	511



LSCX = Clamping depth without stop screw

l_2 = Clamping depth with stop screw type 1, dimension in brackets (l_2) = Clamping depth with stop screw type 2

Dimension LPR is 4 mm longer when using lock nuts with sealing discs



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
for collet

4008E (ER11 mini)				
426E (ER16 mini)				

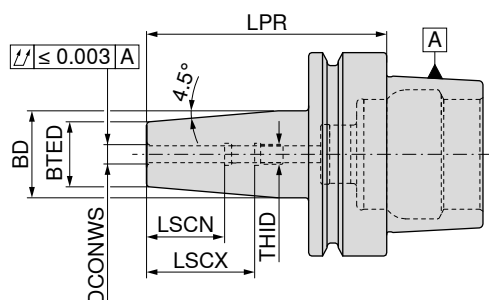
			
Mini lock nut IK	Mini lock nut	Stop screw 2	Stop screw 1
CT	CT	CT	CT
84 950 ...	84 950 ...	83 950 ...	83 950 ...
	041	340	336
035	034	341	337

Accessories

						
ER collet	Sealing disc	Removal aid	Roll key	Roll key device	Coolant transfer pipe	Others
→	→	→	→	→	→	→

CoreLine – Heat shrink adapter 4.5°

▲ For solid carbide and HSS shanks with h6 tolerance or higher



G 2.5 n_{max} 25000



G 2.5 n_{max} 25000

	Adapter	DCONWS mm	LPR mm	BTED mm	BD mm	LSCX mm	LSCN mm	THID
Short	HSK-E 40	3	60	10	15	28	12	M6
	HSK-E 40	4	60	10	15	28	16	M6
	HSK-E 40	5	60	10	15	30	20	M6
	HSK-E 40	6	80	21	27	36	26	M5
	HSK-E 40	8	80	21	27	36	26	M6
	HSK-E 40	10	80	24	32	41	31	M8x1
	HSK-E 40	12	90	24	32	47	37	M10x1
	HSK-E 40	14	90	27	34	47	37	M10x1
	HSK-E 40	16	90	27	34	50	40	M12x1
	HSK-E 50	3	80	10	15	22	12	M6
	HSK-E 50	4	80	15	22	26	16	M6
	HSK-E 50	5	80	15	22	30	20	M6
	HSK-E 50	6	80	21	27	36	26	M5
	HSK-E 50	8	80	21	27	36	26	M6
	HSK-E 50	10	85	24	32	41	31	M8x1
	HSK-E 50	12	90	24	32	47	37	M10x1
	HSK-E 50	14	90	27	34	47	37	M10x1
	HSK-E 50	16	95	27	34	50	40	M12x1
	HSK-E 50	18	95	33	42	50	40	M12x1
	HSK-E 50	20	100	33	42	52	42	M16x1

CT	CT
84 308 ...	84 309 ...
103	
104	
105	
106	
108	
110	
112	
114	
116	
	103
	104
	105
	106
	108
	110
	112
	114
	116
	118
	120



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

							
			CT		CT		CT
Spare parts DCONWS			83 950 ...		83 950 ...		83 950 ...
3 - 5	M6x14 - SW2	417		M5x14 - SW2	411		
6						M5x12,5 - SW2,5	418
8						M6x12,5 - SW3	419
10						M8x1x13,5 - SW3	420
12 - 14						M10x1x13,5 - SW5	421
16 - 18						M12x1x13,5 - SW5	422
20						M16x1x13,5 - SW5	423



Spare part**83 950 411**only for HSK-E 32. Spare part**83 950 417**for HSK-E 40/HSK-E 50.

Accessories





Shrink fit extension

Others

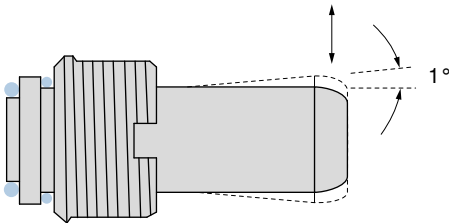
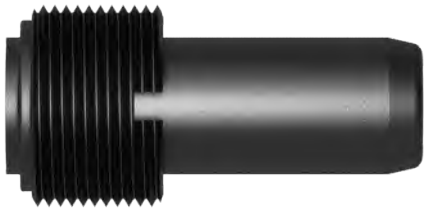
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Coolant transfer pipe – HSK

▲ Can be used up to 100 bar

Scope of supply:
Complete, including sealing rings

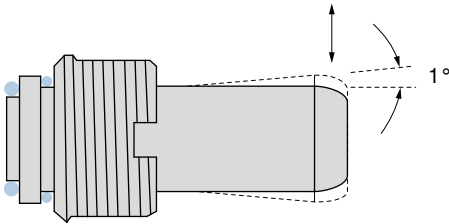


Adapter		THOD	CT 83 760 ... 032 040 050 063 080 100
HSK 32		M10 x 1	
HSK 40		M12 x 1	
HSK 50		M16 x 1	
HSK 63		M18 x 1	
HSK 80		M20 x 1,5	
HSK 100		M24 x 1,5	

Coolant transfer pipe with filter screen – HSK

▲ 75 µ filter screen can be used up to 80 bar

Scope of supply:
Complete, including sealing rings and filter screen



Adapter		THOD	CT 83 760 ... 16300 20000
HSK 63		M18 x 1	
HSK 100		M24 x 1,5	



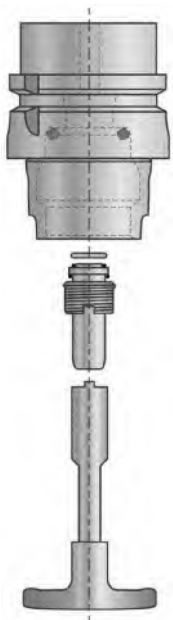
For usage with micro tools with thru coolant, improved tool life due to reduced contamination of the coolant hole.

Key – HSK



Adapter		CT
		83 758 ...
HSK 32		032
HSK 40		040
HSK 50		050
HSK 63		063
HSK 80		080
HSK 100		100

Coolant pipe for HSK tools



The coolant pipe is ideally mounted in the vertical direction – from the bottom to the top. In this manner, the sealing ring is prevented from being displaced or compressed during locating, which would cause the loss of its sealing function. After mounting, the coolant pipe can be moved only to a minimum degree according to DIN ($\pm 1^\circ$).



Flexibility

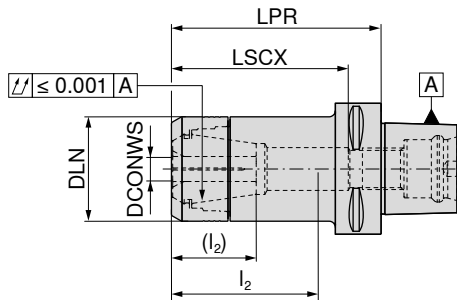
CoreLine – ER precision collet chucks – Centro-P

- ▲ For standard or sealing disc lock nuts
- ▲ Maximum clamping range covered according to ISO tolerance field H10
- ▲ Roll key required for clamping
- ▲ $p_{\max} = 80$ bar
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body **without** lock nut, **without** stop screw

Centro-P



G 2.5 $n_{\max}$ 25000

Adapter	DCONWS mm	LPR mm	DLN mm	LSCX mm	I_2 (I_2) mm	for collet	CT 84 112 ...
PSC 40	1 - 10	55	30	47	29 - 38	426E (ER16)	402
PSC 50	1 - 10	60	30	47	29 - 38	426E (ER16)	501
PSC 50	1 - 10	100	30	87	29 - 51 (29 - 37)	426E (ER16)	502
PSC 50	1 - 16	60	40	48		430E (ER25)	505
PSC 50	2 - 20	60	50	49		470E (ER32)	507
PSC 63	1 - 10	60	30	44		426E (ER16)	601
PSC 63	1 - 10	100	30	83	29 - 53 (25 - 39)	426E (ER16)	602
PSC 63	1 - 16	60	40	38		430E (ER25)	605
PSC 63	1 - 16	100	40	78	36 - 62 (30 - 45)	430E (ER25)	606
PSC 63	1 - 16	130	40	99	34 - 70 (30 - 50)	430E (ER25)	607
PSC 63	1 - 16	160	40	118	34 - 70 (30 - 50)	430E (ER25)	608
PSC 63	2 - 20	60	50	42		470E (ER32)	609
PSC 63	2 - 20	100	50	79	45 - 63 (25 - 45)	470E (ER32)	610
PSC 63	2 - 20	130	50	99	45 - 63 (25 - 53)	470E (ER32)	611
PSC 63	3 - 26	65	63	51		472E (ER40)	612



LSCX = Clamping depth without stop screw

I_2 = Clamping depth with stop screw type 1, dimension in brackets (I_2) = Clamping depth with stop screw type 2

Dimension LPR is 4 mm longer when using lock nuts with sealing discs

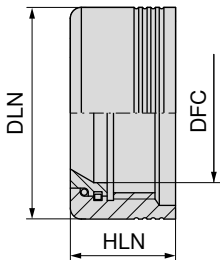


→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

HyPower – ER lock nut for precision collet chucks – Centro-P

- ▲ with thrust collar and angular contact ball bearing
- ▲ Excellent damping and clamping force
- ▲ High-precision lock nut for a perfect fit
- ▲ Run-out ≤ 3 µm with ER precision collets (blue ring)

Centro-P



for collet	DCONWS mm	HLN mm	DFC mm	DLN mm	CT
470E (ER32)	2 - 20	26.5	32	50	84 728 ...
472E (ER40)	3 - 26	31.0	40	63	05000
					06300

Spare parts for collet

	HyPower – Lock nuts	Lock nut IK	Lock nut	Stop screw 2	Stop screw 1
	CT	CT	CT	CT	CT
	84 728 ...	84 950 ...	84 950 ...	83 950 ...	83 950 ...
426E (ER16)		011	001	M11x1 - SW6	337
430E (ER25)		013	003	M18x1,5 - SW6	431
470E (ER32)	05000	015	005	M22x1,5 - SW6	401
472E (ER40)	06300	017	007	M28x1,5 - SW6	400

Accessories



HyPower – High pressure chuck – Complus

- ▲ High pressure chuck, short and stable version
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body with stop screw and pressure screw

Complus

Adapter	DCONWS mm	LPR mm	LB_1 mm	BD_1 mm	BD_2 mm	LSCX mm	LSCN mm	THID
PSC 63	20	80	41	49	52.5	51	41	M8x1

CT

84 108 ...

62000

LSCX = maximum insertion depth
LSCN = minimum insertion depth

→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts for article number		Cylindrical screw	
		CT	AS
		83 950 ...	80 397 ...
		157	050
84 108 62000		Clamping key T	
		SW5	M10x1x14
		429	424
		M16x1x13,5 - SW8	
		Pressure screw	
		CT	AS
		83 950 ...	80 397 ...
		157	050
		Backstop screw with internal cooling	
		CT	AS
		83 950 ...	80 397 ...
		157	050

Accessories

Reduction sleeve
→

Coolant transfer pipe
→

Others
→

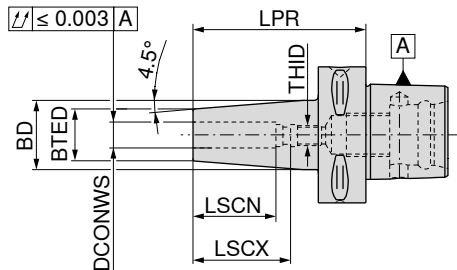
CoreLine – Heat shrink adapter 4.5° – TG

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body **without** stop screw with internal cooling

TG



G 2.5 n_{max} 25000

	Adapter	LPR mm	DCONWS mm	BTED mm	BD mm	LSCX mm	LSCN mm	THID	
Short	PSC 40	75	6	21	27	36	26	M5	10695
	PSC 40	75	8	21	27	36	26	M6	10895
	PSC 40	75	10	24	32	41	31	M8x1	11095
	PSC 40	75	12	24	32	47	37	M10x1	11295
	PSC 40	80	14	27	34	47	37	M10x1	11495
	PSC 40	80	16	27	34	50	40	M12x1	11695
	PSC 40	80	18	33	42	50	40	M12x1	11895
	PSC 40	85	20	33	42	52	42	M16x1	12095
	PSC 50	65	3	12	17				10394
	PSC 50	65	4	12	17				10494
	PSC 50	65	5	12	17				10594
	PSC 50	75	6	21	30	36	26	M5	10694
	PSC 50	75	8	21	30	36	26	M6	10894
	PSC 50	75	10	24	33	41	31	M8x1	11094
	PSC 50	75	12	24	33	47	37	M10x1	11294
	PSC 50	80	14	27	34	47	37	M10x1	11494
	PSC 50	80	16	27	34	50	40	M12x1	11694
	PSC 50	80	18	33	42	50	40	M12x1	11894
	PSC 50	85	20	33	42	52	42	M16x1	12094
	PSC 50	90	25	44	53	58	48	M16x1	12594
	PSC 63	80	3	12	17				10393
	PSC 63	80	4	12	17				10493
	PSC 63	80	5	12	17				10593
	PSC 63	80	6	21	27	36	26	M5	10693
	PSC 63	80	8	21	27	36	26	M6	10893
	PSC 63	80	10	24	32	41	31	M8x1	11093
	PSC 63	80	12	24	32	47	37	M10x1	11293
	PSC 63	85	14	27	34	47	37	M10x1	11493
	PSC 63	85	16	27	34	50	40	M12x1	11693
	PSC 63	85	18	33	42	50	40	M12x1	11893
	PSC 63	85	20	33	42	52	42	M16x1	12093
	PSC 63	90	25	44	53	58	48	M16x1	12593
	PSC 63	95	32	44	53	61	51	M16x1	13293



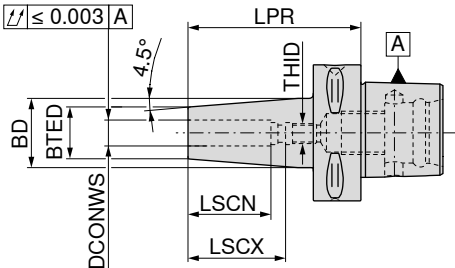
→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

CoreLine – Heat shrink adapter 4.5° – TG

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body **without** stop screw with internal cooling

TG



G 2.5 n_{max} 25000

Short	Adapter	LPR mm	DCONWS mm	BTED mm	BD mm	LSCX mm	LSCN mm	THID	CT	
	PSC 80	85	6	21	27	36	26	M5	82 310 ...	10686
	PSC 80	85	8	21	27	36	26	M6		10886
	PSC 80	85	10	24	32	41	31	M8x1		11086
	PSC 80	85	12	24	32	47	37	M10x1		11286
	PSC 80	90	14	27	34	47	37	M10x1		11486
	PSC 80	90	16	27	34	50	40	M12x1		11686
	PSC 80	90	18	33	42	50	40	M12x1		11886
	PSC 80	90	20	33	42	52	42	M16x1		12086
	PSC 80	95	25	44	53	58	48	M16x1		12586
	PSC 80	100	32	44	53	61	51	M16x1		13286



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

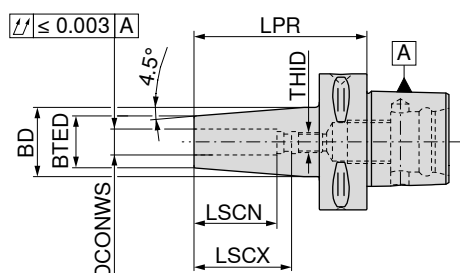
CoreLine – Heat shrink adapter 4.5° – TG

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:

Base body **without** stop screw with internal cooling

TG



G 2.5 n_{max} 25000

		Adapter	LPR	DCONWS	BTED	BD	LSCX	LSCN	THID		
		mm	mm	mm	mm	mm	mm	mm			
Medium length	PSC 50	120	6	21	32	36	26	M5		82 310 ...	20694
	PSC 50	120	8	21	32	36	26	M6			20894
	PSC 50	120	10	24	34	41	31	M8x1			21094
	PSC 50	120	12	24	34	47	37	M10x1			21294
	PSC 50	120	14	27	36	47	37	M10x1			21494
	PSC 50	120	16	27	36	50	40	M12x1			21694
	PSC 50	120	18	33	42	50	40	M12x1			21894
	PSC 50	120	20	33	42	52	42	M16x1			22094
	PSC 50	120	25	44	53	58	48	M16x1			22594
	PSC 63	120	6	21	32	36	26	M5			20693
	PSC 63	120	8	21	32	36	26	M6			20893
	PSC 63	120	10	24	32	41	31	M8x1			21093
	PSC 63	120	12	24	32	47	37	M10x1			21293
	PSC 63	120	14	27	36	47	37	M10x1			21493
	PSC 63	120	16	27	36	50	40	M12x1			21693
	PSC 63	120	18	33	44	50	40	M12x1			21893
	PSC 63	120	20	33	44	52	42	M16x1			22093
	PSC 63	120	25	44	53	58	48	M16x1			22593
	PSC 63	120	32	44	53	61	51	M16x1			23293
	PSC 80	120	6	21	32	36	26	M5			20686
	PSC 80	120	8	21	32	36	26	M6			20886
	PSC 80	120	10	24	34	41	31	M8x1			21086
	PSC 80	120	12	24	34	47	37	M10x1			21286
	PSC 80	120	14	27	36	47	37	M10x1			21486
	PSC 80	120	16	27	36	50	40	M12x1			21686
	PSC 80	120	18	33	44	50	40	M12x1			21886
	PSC 80	120	20	33	44	52	42	M16x1			22086
	PSC 80	120	25	44	53	58	48	M16x1			22586
	PSC 80	120	32	44	53	61	51	M16x1			23286

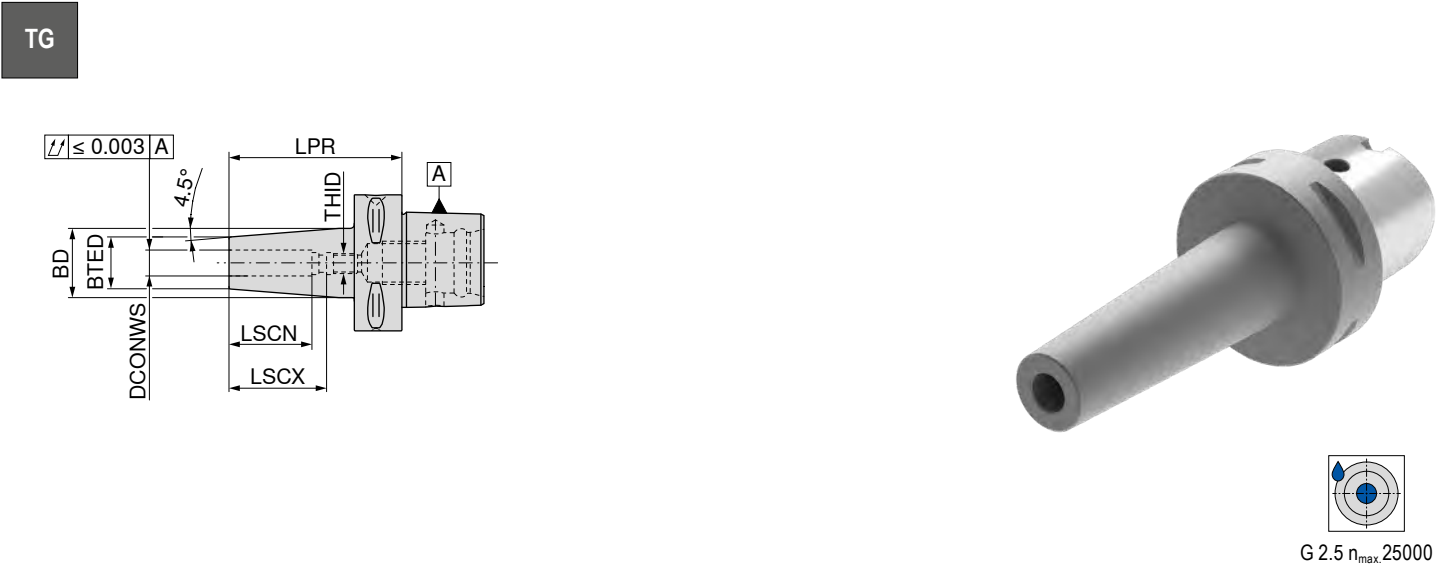


→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

CoreLine – Heat shrink adapter 4.5° – TG

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body **without** stop screw with internal cooling



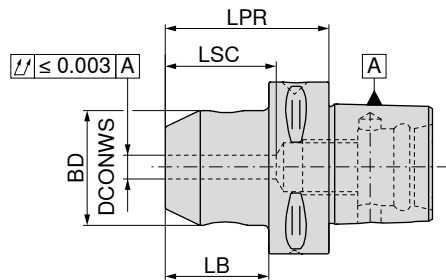
Extended	Adapter	LPR mm	DCONWS mm	BTED mm	BD mm	LSCX mm	LSCN mm	THID	CT 82 310 ... 40693 40893 41093 41293 41493 41693 41893 42093 42593 43293
	PSC 63	160	6	21	32	36	26	M5	
	PSC 63	160	8	21	32	36	26	M6	
	PSC 63	160	10	24	34	41	31	M8x1	
	PSC 63	160	12	24	34	47	37	M10x1	
	PSC 63	160	14	27	36	47	37	M10x1	
	PSC 63	160	16	27	36	50	40	M12x1	
	PSC 63	160	18	33	44	50	40	M12x1	
	PSC 63	160	20	33	44	52	42	M16x1	
	PSC 63	160	25	44	53	58	48	M16x1	
	PSC 63	160	32	44	53	61	51	M16x1	

→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts		82 950 ...
DCONWS		
6	M5x16 - SW2,5	30000
8	M6x16 - SW3	30100
10	M8x1x16 - SW4	30200
12 - 14	M10x1x14 - SW5	30300
16 - 18	M12x1x16 - SW6	30400
20 - 32	M16x1x16 - SW8	30500

CoreLine – Cylindrical shank adapter Weldon

- ▲ For shanks according to DIN 6535 HB / 1835 B with lateral clamping flat
 ▲ **By request:** Also available with Balluff chip

G 2.5 n_{max} 25000

							CT	
	Adapter	DCONWS mm	LPR mm	BD mm	LB mm	LSC mm	82 741 ...	
Short	PSC 40	6	50	25	30	35	10695	
	PSC 40	8	50	28	30	35	10895	
	PSC 40	10	50	35	30	39	11095	
	PSC 40	12	55	42	35	44	11295	
	PSC 40	14	55	44	35	44	11495	
	PSC 40	16	55	48	35	47	11695	
	PSC 50	6	50	25	30	35	10694	
	PSC 50	8	50	28	30	35	10894	
	PSC 50	10	55	35	35	39	11094	
	PSC 50	12	60	42	40	44	11294	
	PSC 50	14	60	44	40	44	11494	
	PSC 50	16	60	48	40	47	11694	
	PSC 50	18	60	50	40	47	11894	
	PSC 50	20	60	52	40	47	12094	
	PSC 50	25	80	65	60	61	12594 ¹⁾	
	PSC 63	6	55	25	33	35	10693	
	PSC 63	8	55	28	33	35	10893	
	PSC 63	10	60	35	38	39	11093	
	PSC 63	12	60	42	38	44	11293	
	PSC 63	14	60	44	38	44	11493	
	PSC 63	16	65	48	43	47	11693	
	PSC 63	18	65	50	43	47	11893	
	PSC 63	20	65	52	43	49	12093	
	PSC 63	25	80	65	58	61	12593 ¹⁾	
	PSC 63	32	90	72	68	65	13293 ¹⁾	
	PSC 63	40	100	80	78	75	14093 ¹⁾	
	PSC 80	6	70	25	40	35	10686	
	PSC 80	8	70	28	40	35	10886	
	PSC 80	10	70	35	40	39	11086	
	PSC 80	12	70	42	40	44	11286	
	PSC 80	14	70	44	40	44	11486	
	PSC 80	16	70	48	40	47	11686	
	PSC 80	18	70	50	40	47	11886	
	PSC 80	20	70	52	40	49	12086	
	PSC 80	25	80	65	50	61	12586 ¹⁾	
	PSC 80	32	80	72	50	65	13286 ¹⁾	
PSC 80	40	110	80	80	75	14086 ¹⁾		
PSC 80	50	120	100	90	83	15086 ¹⁾		

1) Version with two clamping screws

Spare parts
DCONWS

6
8
10
12 - 14
16 - 18
20
25
32 - 40



Set Screw

CT

62 950 ...

006
008
010
012
016
020
025
032

Accessories



Coolant transfer pipe

→

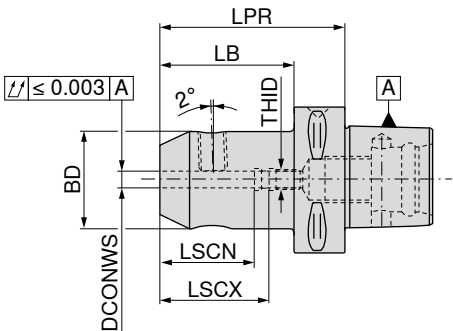


Others

→

CoreLine – Cylindrical shank adapter Whistle Notch

- ▲ For shanks according to DIN 6535 HE / 1835 E with angled clamping flat
- ▲ **By request:** Also available with Balluff chip



G 2.5 n_{max} 25000

Adapter	DCONWS mm	LPR mm	BD mm	LB mm	LSCX mm	LSCN mm	THID
PSC 50	6	70	25	50	38	28	M5
PSC 50	8	70	28	50	38	28	M6
PSC 50	10	70	35	50	41	31	M8
PSC 50	12	75	42	55	47	37	M10
PSC 50	14	75	44	55	47	37	M10
PSC 50	16	80	48	60	50	40	M12
PSC 50	18	80	50	60	50	40	M12
PSC 50	20	85	52	65	52	42	M16
PSC 63	6	75	25	53	38	28	M5
PSC 63	8	75	28	53	38	28	M6
PSC 63	10	75	35	53	41	31	M8
PSC 63	12	80	42	58	47	37	M10
PSC 63	14	80	44	58	47	37	M10
PSC 63	16	80	48	58	50	40	M12
PSC 63	18	80	50	58	50	40	M12
PSC 63	20	85	52	63	52	42	M16
PSC 63	25	90	65	68	58	48	M16
PSC 63	32	95	72	73	61	51	M16

CT
82 742 ...
10694
10894
11094
11294
11494
11694
11894
12094
10693
10893
11093
11293
11493
11693
11893
12093
12593 ¹⁾
13293 ¹⁾

1) Version with two clamping screws

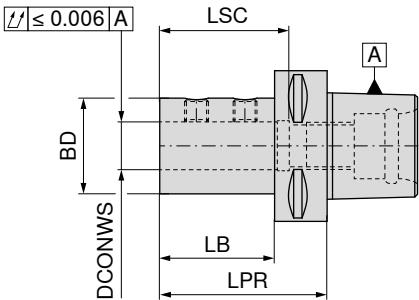
		
		Set Screw
		CT
Spare parts		62 950 ...
DCONWS		
6		006
8		008
10		010
12 - 14		012
16 - 18		016
20		020
25		025
32		032

Accessories

	
Coolant transfer pipe	Others
→	→

CoreLine – Indexable insert drill adapter

- ▲ Run-out ≤ 0.005 mm
- ▲ Max. speed 5,000 rpm
- ▲ **By request:** Also available with Balluff chip



Adapter	DCONWS mm	LPR mm	BD mm	LB mm	LSC mm
PSC 40	16	60	36	40	49
PSC 40	20	60	40	40	54
PSC 40	25	70	45	50	59
PSC 50	16	65	36	45	49
PSC 50	20	65	40	45	54
PSC 50	25	70	45	50	59
PSC 50	32	75	52	55	63
PSC 63	16	70	36	48	49
PSC 63	20	70	40	48	54
PSC 63	25	75	45	53	59
PSC 63	32	75	52	53	63
PSC 63	40	85	65	63	73
PSC 63	50	115	75	93	83
PSC 80	16	80	36	50	49
PSC 80	20	80	40	50	54
PSC 80	25	85	45	55	59
PSC 80	32	90	52	60	63
PSC 80	40	95	65	65	73
PSC 80	50	100	75	70	83

CT
82 274 ...
11695
12095
12595
11694
12094
12594
13294
11693
12093
12593
13293
14093
15093
11686
12086
12586
13286
14086
15086

		
		Set Screw
		CT
Spare parts DCONWS		83 950 ...
16 - 20	M10x1x10	180
25	M16x1x13	182
25	M12x1x12	181
32	M16x1x13	182
32	M12x1x12	181
40 - 50	M16x1x13	182

Accessories



Coolant transfer pipe

→

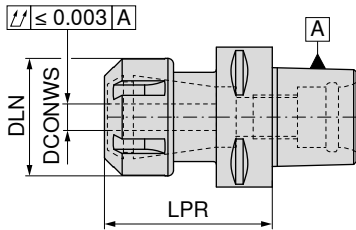


Others

→

CoreLine – ER collet chuck

▲ **By request:** Also available with Balluff chip



							CT
							82 743 ...
Short	Adapter	DCONWS mm	LPR mm	DLN mm	TQX Nm	for collet	
	PSC 40	1 - 10	55	32	8 - 56	426E (ER16)	11095
	PSC 40	1 - 16	55	42	24 - 104	430E (ER25)	11695
	PSC 40	2 - 20	55	50	24 - 136	470E (ER32)	12095
	PSC 50	1 - 10	60	32	8 - 56	426E (ER16)	11094
	PSC 50	1 - 16	60	42	24 - 104	430E (ER25)	11694
	PSC 50	2 - 20	60	50	24 - 136	470E (ER32)	12094
	PSC 50	3 - 26	65	63	176	472E (ER40)	12694
	PSC 63	1 - 10	60	32	8 - 56	426E (ER16)	11093
	PSC 63	1 - 16	60	42	24 - 104	430E (ER25)	11693
	PSC 63	2 - 20	60	50	24 - 136	470E (ER32)	12093
	PSC 63	3 - 26	65	63	176	472E (ER40)	12693
	PSC 80	1 - 16	70	42	24 - 104	430E (ER25)	11686
	PSC 80	2 - 20	70	50	24 - 136	470E (ER32)	12086
	PSC 80	3 - 26	80	63	176	472E (ER40)	12686
Medium length	PSC 50	1 - 10	100	32	8 - 56	426E (ER16)	21094
	PSC 50	1 - 16	100	42	24 - 104	430E (ER25)	21694
	PSC 50	2 - 20	100	50	24 - 136	470E (ER32)	22094
	PSC 50	3 - 26	100	63	176	472E (ER40)	22694
	PSC 63	1 - 10	100	32	8 - 56	426E (ER16)	21093
	PSC 63	1 - 16	100	42	24 - 104	430E (ER25)	21693
	PSC 63	2 - 20	100	50	24 - 136	470E (ER32)	22093
	PSC 63	3 - 26	100	63	176	472E (ER40)	22693
	PSC 80	1 - 16	100	42	24 - 104	430E (ER25)	21686
	PSC 80	2 - 20	100	50	24 - 136	470E (ER32)	22086
	PSC 80	3 - 26	100	63	176	472E (ER40)	22686



Dimension LPR is 5.0 mm longer for ER16, ER25 and ER32, and 5.5 mm for ER40 when using thru coolant lock nuts.

		<div> Lock nut IK</div>		<div> Lock nut</div>		<div> Y clamping key</div>	
		CT		CT		CX	
Spare parts for collet		83 950 ...		62 950 ...		83 357 ...	
426E (ER16)	M22x1,5	054		M22x1,5	054		116
430E (ER25)	M32x1,5	055		M32x1,5	055		125
470E (ER32)	M40x1,5	056		M40x1,5	65600		132
472E (ER40)	M50x1,5	057		M50x1,5	65700		140

Accessories

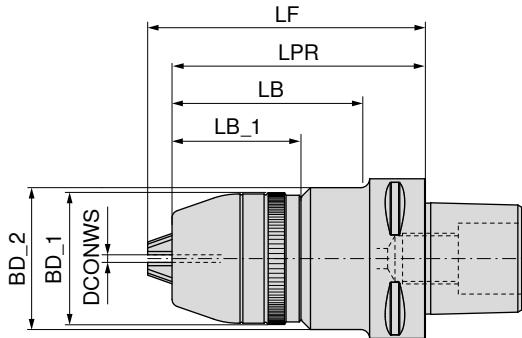
		
ER collet	Coolant transfer pipe	Others
→	→	→

CoreLine – Short drill chuck – NC 2010

- ▲ Independent of direction of rotation
- ▲ Tightening torque = 12 Nm
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body including clamping key SW4

NC
2010







G 2.5 n_{max} 10000

Adapter	DCONWS mm	BD_1 mm	BD_2 mm	LB_1 mm	LB mm	LPR mm	LF mm
PSC 40	0,5 - 13	48.5	56	50.90	78.0	100	109.0
PSC 40	2,5 - 16	51.0	56	52.15	78.0	100	110.5
PSC 50	0,5 - 13	48.5	56	50.90	77.0	100	109.0
PSC 50	2,5 - 16	51.0	56	52.15	77.0	100	110.5
PSC 63	0,5 - 13	48.5	56	50.90	74.5	100	109.0
PSC 63	2,5 - 16	51.0	56	52.15	74.5	100	110.5

CT

84 111 ...

01395

01695

01394

01694

01393

01693



Can be used with G 2.5 to 30,000 rpm by subsequent balancing!

Accessories

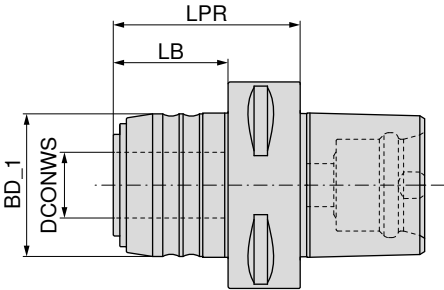


Others



CoreLine – Synchro quick change tapping chuck with minimum length compensation

- ▲ With length compensation under tension and compression (LZD)
- ▲ For collets according to DIN 6499
- ▲ $p_{max.} = 50 \text{ bar}$
- ▲ **By request:** Also available with Balluff chip



Adapter	Cutting range	SZID	LPR	BD_1	DCONWS	LB	LZD±
			mm	mm	mm	mm	mm
PSC 63	M3 - M12	1	57	43	20	35	1,0 / 0,2
PSC 63	M6 - M20	2	77	60	32	55	1,0 / 0,2

CT

84 140 ...

612

620

Accessories



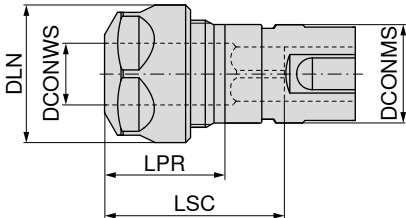
Insert



Insert for synchro quick change tapping chuck with minimum length compensation

▲ SZID = for insert size

Scope of supply:
Includes lock nut



SZID	DCONWS mm	Cutting range	LPR mm	DLN mm	LSC mm	for collet	DCONMS mm	CT 83 608 ... 012 ¹⁾ 020	
1	2 - 10	M3 - M12	24	28	42	426E (ER16)	20		
2	2 - 16	M6 - M20	28	42	59	430E (ER25)	32		

1) With hex nut

Spare parts
for article number

83 608 012	M22x1,5 - SW25	044	M22x1,5	054	M22x1,5	054	116
83 608 020			M32x1,5	055	M32x1,5	055	125



Lock nut SW

CT

62 950 ...



Lock nut IK

CT

83 950 ...



Lock nut

CT

62 950 ...



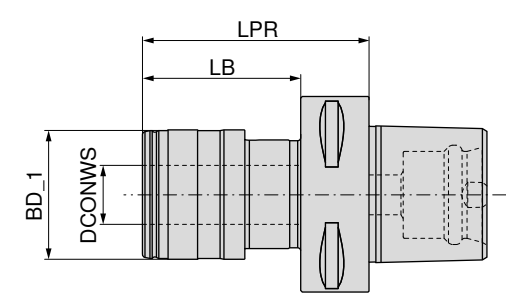
Y clamping key

CX

83 357 ...

CoreLine – Quick change tapping chuck with length compensation

- ▲ With length compensation under tension and compression (LZD)
- ▲ **By request:** Also available with Balluff chip



Adapter	Cutting range	SZID	LPR mm	BD_1 mm	DCONWS mm	LB mm	LZD± mm
PSC 63	M3 - M12	01	73	41	19	51	7,5
PSC 63	M6 - M20	02	97	60	31	75	10

CT

84 142 ...

612

620

Accessories

Insert

→

HyPower – Adapter – ABS

▲ **By request:** Also available with Balluff chip



Adapter	SZID	BD mm	LPR mm	LB mm	CT 84 215 ...
PSC 40	ABS 50	50	50	30	04097
PSC 50	ABS 50	50	50	30	05097
PSC 63	ABS 50	50	50	28	06397
PSC 63	ABS 63	63	60	36	06396
PSC 80	ABS 50	50	50	23	08097
PSC 80	ABS 63	63	60	30	08096
PSC 80	ABS 80	80	80	50	08092

Spare parts
SZID

SZID	CT 84 950 ...	CT 84 950 ...	CT 84 950 ...
ABS 50	20300	99800	20400
ABS 63	25500	99400	27300
ABS 80	25600	99300	25100


Clamping screw
CT
84 950 ...
20300


Set
CT
84 950 ...
99800


Taper screw
CT
84 950 ...
20400

HyPower – Torsional vibration damper – ABS

▲ **By request:** Also available with Balluff chip



Adapter	SZID	BD mm	LPR mm	LB mm	<div>CT</div> <div>84 206 ...</div> <div>05094</div> <div>05093</div> <div>06393</div> <div>05086</div> <div>06386</div> <div>08086</div>
PSC 50	ABS 50	50	50	30	
PSC 63	ABS 50	50	50	28	
PSC 63	ABS 63	63	60	38	
PSC 80	ABS 50	50	50	23	
PSC 80	ABS 63	63	60	30	
PSC 80	ABS 80	80	80	50	

Spare parts
SZID

ABS 50	20300	99800	20400
ABS 63	25500	99400	27300
ABS 80	25600	99300	25100

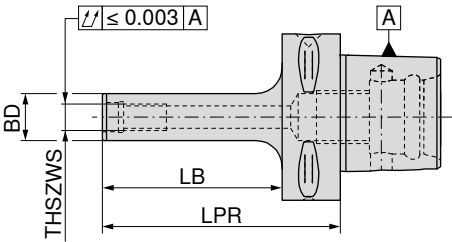
 Clamping screw	 Set	 Taper screw
<div>CT</div> <div>84 950 ...</div>	<div>CT</div> <div>84 950 ...</div>	<div>CT</div> <div>84 950 ...</div>

Accessories



CoreLine – Adapter for screw-in cutter – Cylindrical

▲ **By request:** Also available with Balluff chip



G 2.5 n_{max} 20000

Adapter	THSZWS	LPR mm	BD mm	LB mm
PSC 63	M8	70	13	48
PSC 63	M10	90	18	68
PSC 63	M12	100	21	78
PSC 63	M16	100	29	78

CT

82 750 ...

20893

21093

21293

21693

Accessories

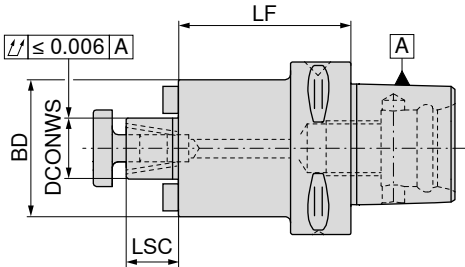

Coolant transfer pipe
→


Others
→

CoreLine – Shell mill adapter

- ▲ For milling cutters with transverse slot ISO 3937
- ▲ **By request:** Also available with Balluff chip

Scope of supply:
Base body with clamping screw and drive dogs



G 2.5 n_{max} 25000

		Adapter	DCONWS mm	LF mm	BD mm	LSC mm		
Extra short	PSC 40	22	40	50	19	CT	82 745 ...	02295
	PSC 40	16	28	40	17			01695
	PSC 50	32	40	63	24			03294
	PSC 50	16	28	40	17			01694
	PSC 50	22	28	50	19			02294
	PSC 50	27	32	58	21			02794
	PSC 63	27	32	58	21			02793
	PSC 63	22	28	50	19			02293
	PSC 63	32	40	63	24			03293
	PSC 63	40	40	70	27			04093
	PSC 80	27	40	58	21			02786
	PSC 80	22	40	50	19			02286
	PSC 80	32	40	63	24			03286
	PSC 80	40	40	70	27			04086
Short	PSC 40	22	63	50	19	CT	82 745 ...	12295
	PSC 40	16	63	40	17			11695
	PSC 50	32	63	63	24			13294
	PSC 50	16	63	40	17			11694
	PSC 50	22	63	50	19			12294
	PSC 50	27	63	58	21			12794
	PSC 63	22	63	50	19			12293
	PSC 63	16	63	40	17			11693
	PSC 63	27	63	58	21			12793
	PSC 63	32	86	63	24			13293
	PSC 80	27	63	58	21			12786
	PSC 80	16	63	40	17			11686
	PSC 80	22	63	50	19			12286
	PSC 80	32	86	63	24			13286

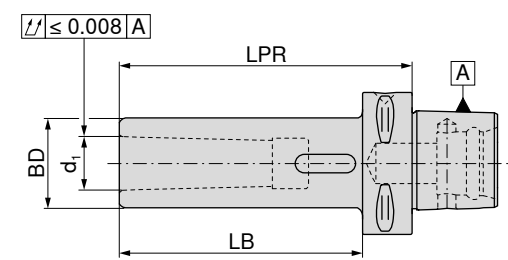
						
		Cross nut key		Retaining screws		Tightening screw
		CX		CX		CT
Spare parts		83 368 ...		83 367 ...		83 950 ...
DCONWS						
16		116	M8	016	M8x25	113
22		122	M10	022	M10x25	124
27		127	M12	027	M12x30	125
32		132	M16	032	M16x35	126
40		140	M20	040	M20x40 - SW17	112
						
				Carrier screws		Drive key
				CT		CT
Spare parts				83 950 ...		83 950 ...
DCONWS						
16			M3x8	296	8x9x17,5	120
22			M4x12	297	10x11x20,5	121
27			M5x12	136	12x13x24,3	122
32			M5x20	137	14x21x21,2	123
40			M6x16	138	15,9x16,3x19,5	295

Accessories

	
Coolant transfer pipe	Others
→	→

CoreLine – Taper sleeve adapter DIN 6383 for DIN 228-2D Morse taper shanks

▲ **By request:** Also available with Balluff chip



Adapter	d ₁	LPR mm	BD mm	LB mm	CT 82 746 ...
PSC 40	MK2	110	32	90	02095
PSC 40	MK3	130	40	110	03095
PSC 50	MK2	110	32	90	02094
PSC 50	MK3	130	40	110	03094
PSC 50	MK4	155	48	135	04094
PSC 63	MK2	110	32	88	02093
PSC 63	MK3	130	40	108	03093
PSC 63	MK4	157	48	135	04093
PSC 80	MK2	120	32	90	02086
PSC 80	MK3	140	40	110	03086
PSC 80	MK4	165	48	135	04086

Accessories



Coolant transfer pipe

→

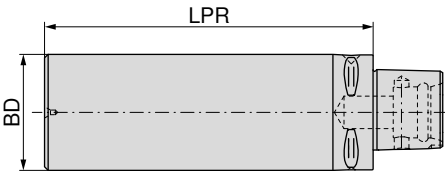


Others

→

CoreLine – Blank

- ▲ Material: 1.7131
- ▲ For the production of special tools
- ▲ Taper hardened and ground
- ▲ Tool 27±1 HRC
- ▲ **On request:** Also available with Balluff chip

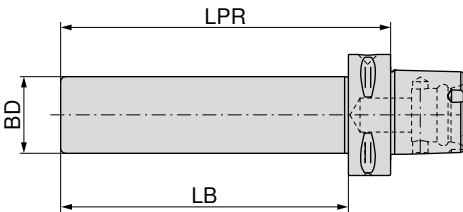


Adapter	BD mm	LPR mm
PSC 40	40	95
PSC 40	40	120
PSC 40	60	165
PSC 40	80	75
PSC 40	80	120
PSC 40	100	85
PSC 50	50	125
PSC 50	50	150
PSC 50	75	175
PSC 50	90	80
PSC 50	95	150
PSC 50	110	90
PSC 63	63	180
PSC 63	75	195
PSC 63	110	85
PSC 63	120	180
PSC 63	130	95
PSC 80	80	200
PSC 80	120	160
PSC 80	130	90
PSC 80	145	200

CT
82 747 ...
04095
04195
06095
08095
08195
10095
05094
05194
07594
09094
09594
11094
06393
07593
11093
12093
13093
08086
12086
13086
14586

CoreLine – Test arbor

▲ **By request:** Also available with Balluff chip



Adapter	LPR mm	BD mm	LB mm
PSC 40	180	25	160
PSC 50	235	32	215
PSC 63	322	40	300
PSC 80	330	40	300

CT
81 746 ...
12595
13294
14093
14086

Accessories



Coolant transfer pipe

→

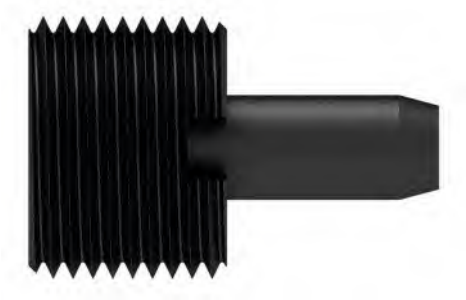


Others

→

Coolant transfer pipe – PSC

Scope of supply:
Complete, including sealing rings



Adapter		THOD	CT	
PSC 40		M14 x 1,5	84 116 ...	
PSC 50		M16 x 1,5	04000	
PSC 63		M20 x 2,0	05000	
PSC 80		M20 x 2,0	06300	
			08000	

Key – PSC

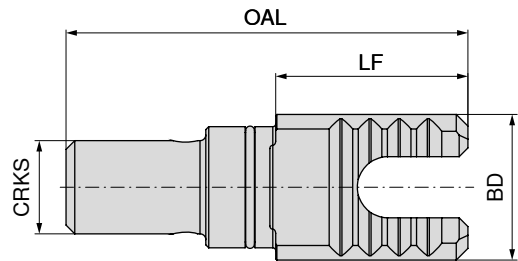


Adapter		CT	
PSC 40		84 117 ...	
PSC 50		04000	
PSC 63		05000	
PSC 80		06300	
		08000	

Pull stud for PSC adapter

▲ For front clamping

Scope of supply:
Including O ring



Adapter	LF mm	OAL mm	BD mm	CRKS
PSC 40	26.3	56	20	M14x1,5
PSC 50	33.0	69	25	M16x1,5
PSC 63	33.0	79	31	M20x2

CX

83 235 ...

04000

05000

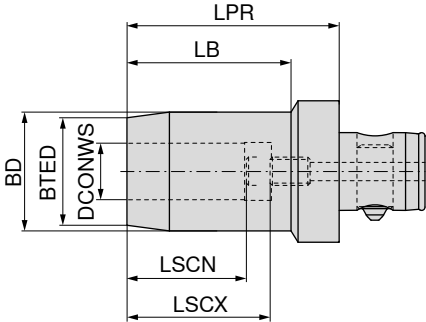
06300

HyPower – Hydraulic chuck – Fit

- ▲ Hydraulic chuck with ABS connection
- ▲ For solid carbide and HSS shanks with h6 tolerance or higher

Scope of supply:
Base body including stop screw

Fit



Adapter	DCONWS mm	BTED mm	BD mm	LPR mm	LB mm	LSCX mm	LSCN mm
ABS 40	6	22	26	55	36.5	37	27
ABS 40	8	24	28	60	42.0	37	27
ABS 40	10	26	30	65	47.5	41	31
ABS 40	12	28	32	65	48.0	46	36
ABS 50	6	22	26	55	33.5	37	27
ABS 50	8	24	28	55	34.0	37	27
ABS 50	10	26	30	65	45.0	41	31
ABS 50	12	28	32	65	45.5	46	36
ABS 50	14	30	34	65	46.0	46	36
ABS 50	16	34	38	70	52.0	49	39
ABS 50	18	36	40	70	52.5	49	39
ABS 50	20	38	42	75	58.0	51	41
ABS 63	20	38	42	78	56.0	51	41
ABS 63	25	53	57	85	60.0	57	47
ABS 63	32	60	64	90	61.0	61	51

CT
84 253 ...
00688
00888
01088
01288
00697
00897
01097
01297
01497
01697
01897
02097
02096
02596
03296

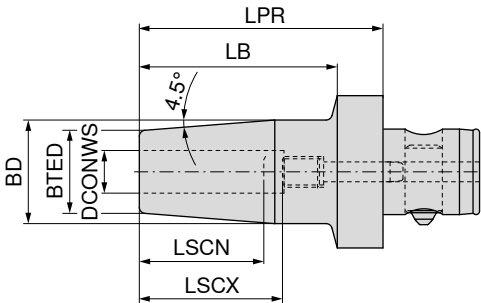
Spare parts
DCONWS

				
		Set		Backstop screw with internal cooling
		CT		CT
		84 950 ...		83 950 ...
6		98700	M5x12,5 - SW2,5	418
6		99900	M5x12,5 - SW2,5	418
8		98700	M6x12,5 - SW3	419
8		99900	M6x12,5 - SW3	419
10		99900	M8x1x13,5 - SW3	420
10		98700	M8x1x13,5 - SW3	420
12		99900	M10x1x13,5 - SW5	421
12		98700	M10x1x13,5 - SW5	421
14		99900	M10x1x13,5 - SW5	421
16		99900	M10x1x13,5 - SW5	421
18		99900	M10x1x13,5 - SW5	421
20		98600	M16x1x13,5 - SW5	423
20		99900	M16x1x13,5 - SW5	423
25		98600	M16x1x13,5 - SW5	423
32		98600	M16x1x13,5 - SW5	423

HyPower – Heat shrink adapter 4.5° – ABS

▲ For solid carbide and HSS shanks with h6 tolerance or higher

ABS



G 6.3 n_{max} 15000

Adapter	DCONWS mm	LPR mm	BD mm	BTED mm	LB mm	LSCX mm	LSCN mm
ABS 32	6	70	27	21	56	36	26
ABS 32	8	70	27	21	56	36	26
ABS 32	10	70	32	24	56	42	32
ABS 32	12	80	32	24	66	47	37
ABS 40	8	70	27	21	56	36	26
ABS 40	10	70	32	24	56	42	32
ABS 40	12	80	32	24	66	47	37
ABS 40	16	90	34	27	76	50	40
ABS 50	6	75	27	21	56	36	26
ABS 50	8	75	27	21	56	36	26
ABS 50	10	80	32	24	61	42	32
ABS 50	12	80	32	24	61	47	37
ABS 50	14	80	34	27	61	47	37
ABS 50	16	85	34	27	66	50	40
ABS 50	18	85	42	33	66	50	40
ABS 50	20	90	42	33	71	52	42
ABS 63	20	90	42	33	71	52	42
ABS 63	25	95	53	44	76	58	48
ABS 63	32	95	53	44	76	58	48

CT
84 222 ...
00689
00889
01089
01289
00888
01088
01288
01688
00697
00897
01097
01297
01497
01697
01897
02097
02096
02596
03296

Spare parts
DCONWS

6	99900	M5x18	21400
6	98800	M5x18	21400
8	98800	M6x20	21500
8	98700	M6x20	21500
8	99900	M6x20	21500
10	98700	M8x1x20	21600
10	98800	M8x1x20	21600
10	99900	M8x1x20	21600
12	99900	M10x1x20	21700
12	98800	M10x1x20	21700
12	98700	M10x1x20	21700
14	99900	M10x1x20	21700
16	98700	M12x1x20	21800
16	99900	M12x1x20	21800
18	99900	M12x1x20	21800
20	98600	M8x1x20	21900
20	99900	M8x1x20	21900
25	98600	M8x1x20	21900
32	98600	M8x1x20	21900



Set

CT

84 950 ...



Stop screw

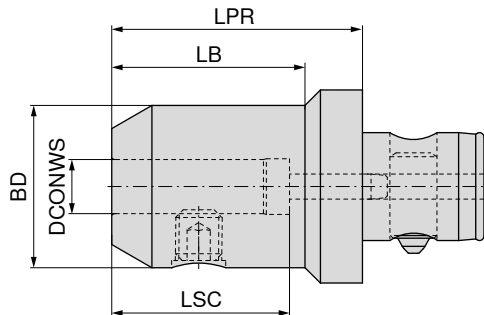
CT

84 950 ...

HyPower – Cylindrical shank adapter Weldon – ABS

▲ For shanks according to DIN 6535 HB / 1835 B with lateral clamping flat

ABS



Adapter	DCONWS mm	LPR mm	BD mm	LB mm	LSC mm
ABS 50	6	45	25.0	27	40
ABS 50	8	45	28.0	27	40
ABS 50	10	55	35.0	37	44
ABS 50	12	65	42.0	50	49
ABS 50	14	65	44.0	50	49
ABS 50	16	65	48.0	50	52
ABS 50	18	65	49.9	50	52
ABS 50	20	65	52.0	50	54
ABS 50	25	75	65.0	60	60
ABS 63	12	65	42.0	50	49
ABS 63	14	65	44.0	50	49
ABS 63	16	65	48.0	50	52
ABS 63	18	65	50.0	50	52
ABS 63	20	65	52.0	45	54
ABS 63	25	75	65.0	60	60
ABS 63	32	80	72.0	65	64
ABS 80	20	65	52.0	45	54
ABS 80	25	75	65.0	55	60
ABS 80	32	80	72.0	66	64

CT

84 221 ...

00697
00897
01097
01297
01497
01697
01897
02097
02597 ¹⁾

01296
01496
01696
01896
02096
02596 ¹⁾
03296 ¹⁾

02092
02592 ¹⁾
03292 ¹⁾

1) Version with two clamping screws

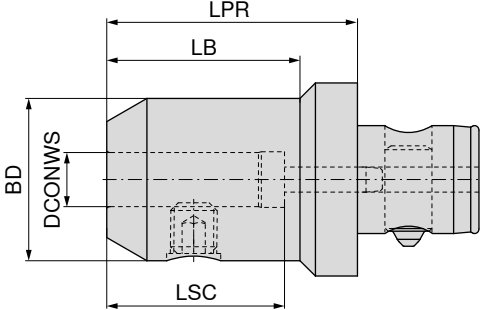
Spare parts
DCONWS

			
	Set		Set Screw
	CT		CT
	84 950 ...		62 950 ...
6	99900	M6x10	006
8	99900	M8x10	008
10	99900	M10x12	010
12	98600	M12x16	012
12	99900	M12x16	012
14	99900	M12x16	012
14	98600	M12x16	012
16	99900	M14x16	016
16	98600	M14x16	016
18	98600	M14x16	016
18	99900	M14x16	016
20	99900	M16x16	020
20	98600	M16x16	020
20	98500	M16x16	020
25	98500	M18x2x20	025
25	99900	M18x2x20	025
25	98600	M18x2x20	025
32	98500	M20x2x20	032
32	98600	M20x2x20	032

HyPower – Cylindrical shank adapter Weldon – ABS

▲ For shanks according to DIN 6535 HB / 1835 B with lateral clamping flat

ABS







Adapter	DCONWS inch	LPR inch	BD inch	LB inch	LSC inch
ABS 50	0.375	2.000	1.126	1.250	1.811
ABS 50	0.500	2.000	1.126	1.486	1.900
ABS 50	0.625	2.626	1.969		2.189
ABS 50	0.750	2.626	1.969		2.313
ABS 50	0.875	2.626	1.969		2.313
ABS 63	1.000	3.000	2.480		2.563
ABS 63	1.250	3.000	2.480		2.563
ABS 80	1.500	3.600	2.480	2.622	2.896

CT

87 221 ...

10997

11297

11597

11997

12297

12596

13196

13892

Spare parts

DCONWS

0.375	3/8"-16 UNC	00031
0.500	7/16"-14 UNC	00032
0.625	9/16"-12 UNC	00033
0.750	5/8"-11 UNC	00034
0.875	5/8"-11 UNC	00034
1.000	3/4"-10 UNC	00035
1.250	3/4"-10 UNC	00035
1.500	3/4"-10 UNC	00035


set screw

AS

87 950 ...

00031

00032

00033

00034

00034

00035

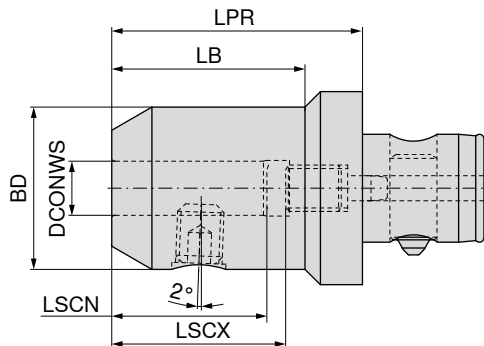
00035

00035

HyPower – Cylindrical shank adapter Whistle Notch – ABS

▲ For shanks according to DIN 6535 HE / 1835 E with angled clamping flat

ABS



Adapter	DCONWS mm	LPR mm	LB mm	BD mm	LSCX mm	LSCN mm
ABS 25	6	55	40	24.9	36	26
ABS 25	8	55	40	28.0	36	26
ABS 25	10	60	45	35.0	40	30
ABS 32	6	55	40	25.0	36	26
ABS 32	8	55	40	28.0	36	26
ABS 32	9	55	40	28.0	36	26
ABS 32	10	60	45	35.0	40	30
ABS 32	12	65	50	42.0	45	35
ABS 32	14	65		42.0	45	35
ABS 40	6	55	35	25.0	36	26
ABS 40	8	55	35	28.0	36	26
ABS 40	10	60	45	35.0	40	30
ABS 40	12	65	50	42.0	45	35
ABS 40	14	65	50	42.0	45	35
ABS 40	16	70	55	48.0	48	38
ABS 40	18	70	55	48.0	48	38
ABS 50	6	55	30	25.0	36	26
ABS 50	8	55	30	28.0	36	26
ABS 50	10	60	40	35.0	40	30
ABS 50	12	65	50	42.0	45	35
ABS 50	13	65	50	42.0	45	35
ABS 50	14	65	50	42.0	45	35
ABS 50	16	70	55	48.0	48	38
ABS 50	18	70	55	48.0	48	38
ABS 50	20	75	60	52.0	50	40
ABS 50	22	75	60	52.0	50	40
ABS 50	25	75	60	52.0	50	40
ABS 63	10	60	35	35.0	40	30
ABS 63	12	65	45	42.0	45	35
ABS 63	14	65	45	42.0	45	35
ABS 63	16	70	50	48.0	48	38
ABS 63	18	70	50	48.0	48	38
ABS 63	20	75	55	52.0	50	40
ABS 63	25	80	65	65.0	56	46
ABS 63	28	80	65	65.0	56	46
ABS 80	25	80	60	65.0	56	46
ABS 80	32	90	70	72.0	60	50

CT

84 220 ...

00690
00890
01090

00689
00889
00989
01089
01289
01489

00688
00888
01088
01288
01488
01688
01888

00697
00897
01097
01297
01397
01497
01697
01897
02097
02297
02597¹⁾

01096
01296
01496
01696
01896
02096
02596¹⁾
02896¹⁾

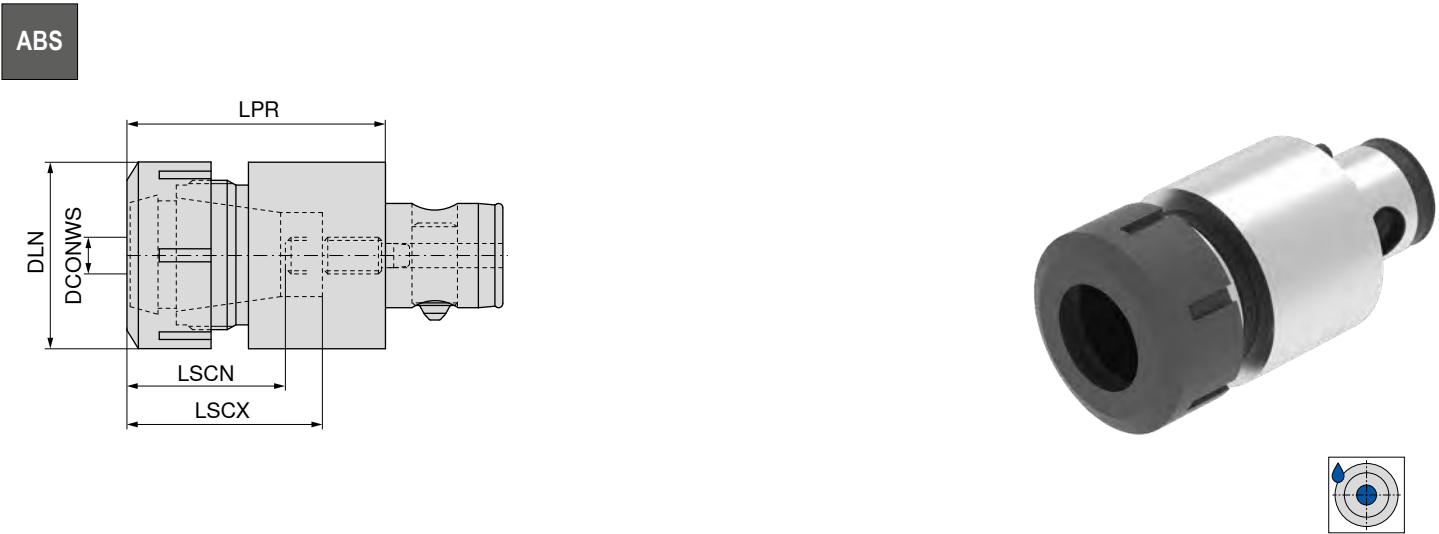
02592¹⁾
03292¹⁾

1) Version with two clamping screws

Spare parts DCONWS	<div>Set</div>			<div>Set Screw</div>			<div>Stop screw</div>		
	CT			CT			CT		
	84 950 ...			62 950 ...			84 950 ...		
6	98900	M6x10	006	M5x16	20500				
6	98800	M6x10	006	M5x16	20500				
6	98700	M6x10	006	M5x16	20500				
6	99900	M6x10	006	M5x16	20500				
8	98900	M8x10	008	M6x16 - SW2,5	20600				
8	98800	M8x10	008	M6x16 - SW2,5	20600				
8	98700	M8x10	008	M6x16 - SW2,5	20600				
8	99900	M8x10	008	M6x16 - SW2,5	20600				
9	98800	M8x10	008	M8x1x16 - SW3	20800				
10	99900	M10x12	010	M8x1x16 - SW2,5	20700				
10	98900	M10x12	010	M8x1x16 - SW2,5	20700				
10	98800	M10x12	010	M8x1x16 - SW2,5	20700				
10	98700	M10x12	010	M8x1x16 - SW2,5	20700				
10	98600	M10x12	010	M8x1x16 - SW2,5	20700				
12	99900	M12x16	012	M10x1x18 - SW3	20900				
12	98800	M12x16	012	M10x1x18 - SW3	20900				
12	98700	M12x16	012	M10x1x18 - SW3	20900				
12	98600	M12x16	012	M10x1x18 - SW3	20900				
13	99900	M12x16	012	M12x1x17 - SW3	21000				
14	98600	M12x16	012	M12x1x17 - SW3	21000				
14	98800	M12x16	012	M12x1x17 - SW3	21000				
14	98700	M12x16	012	M12x1x17 - SW3	21000				
14	99900	M12x16	012	M12x1x17 - SW3	21000				
16	99900	M14x16	016	M14x1x19 - SW4	21100				
16	98700	M14x16	016	M14x1x19 - SW4	21100				
16	98600	M14x16	016	M14x1x19 - SW4	21100				
18	99900	M14x16	016	M14x1x19 - SW4	21100				
18	98700	M14x16	016	M14x1x19 - SW4	21100				
18	98600	M14x16	016	M14x1x19 - SW4	21100				
20	98600	M16x16	020	M16x1x21 - SW5	21200				
20	99900	M16x16	020	M16x1x21 - SW5	21200				
22	99900	M16x16	020	M16x1x21 - SW5	21200				
25	98600	M16x16	020	M16x1x21 - SW5	21200				
25	99900	M16x16	020	M16x1x21 - SW5	21200				
25	98500	M16x16	020	M16x1x21 - SW5	21200				
28	98600	M18x2x20	025	M16x1x21 - SW5	21200				
32	98500	M20x2x20	032	M20x1x27 - SW8	21300				

HyPower – ER collet chuck – ABS

Scope of supply:
Base body with lock nut and stop screw



Adapter	for collet	DCONWS mm	LPR mm	DLN mm	LSCX mm	LSCN mm
ABS 25	426E (ER16)	1 - 10	40.1	28	31	28
ABS 32	428E (ER20)	1 - 13	52.5	34	39	35
ABS 40	430E (ER25)	1 - 16	62.0	42	46	43
ABS 50	470E (ER32)	2 - 20	69.3	50	51	48
ABS 63	472E (ER40)	3 - 26	78.3	63	55	52

CT

84 224 ...

01690 ¹⁾

02089 ¹⁾

02588

03297

04096

1) With hex nut

Spare parts
for collet

426E (ER16)					
428E (ER20)					
430E (ER25)	M32x1,5	055	98900	M5x8 - SW2	22500
470E (ER32)	M40x1,5	65600	98800	M6x12 - SW2,5	22000
472E (ER40)	M50x1,5	65700	98700	M8x1x14 - SW4	22600
			99900	M10x1x14 - SW5	22700
			98600	M12x1x18 - SW8	22800

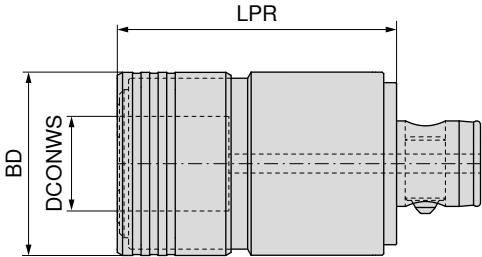
Spare parts
for collet

426E (ER16)	M22x1,5 - SW25	044	M22x1,5	054
428E (ER20)	M25x1,5 - SW30	045	M25x1,5	053
430E (ER25)			M32x1,5	055
470E (ER32)			M40x1,5	056
472E (ER40)			M50x1,5	057

HyPower – Quick change tapping chuck with length compensation – ABS

▲ With length compensation under tension and compression (LZD)

ABS



Adapter	DCONWS mm	BD mm	LPR mm	SZID
ABS 32	19	39	69	01
ABS 40	19	39	73	01
ABS 50	19	39	72	01
ABS 50	31	60	98	02
ABS 63	31	60	111	02
ABS 63	48	86	160	

CT
84 225 ...
01989
01988
01997
03197
03196
04896

Spare parts
for article number

84 225 01989
84 225 01988
84 225 01997
84 225 03197
84 225 03196
84 225 04896



CT
84 950 ...
98800
98700
99900
99900
98600
98600

Accessories



Insert

→



Pull stud

→



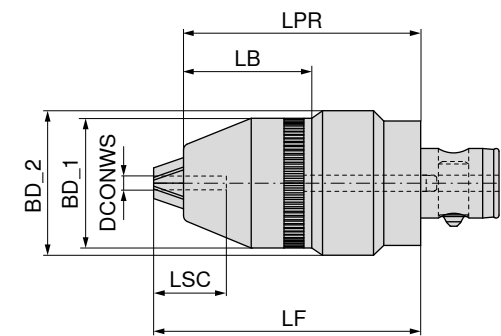
Others

→

HyPower – Short drill chuck – ABS

Scope of supply:
Base body including clamping key SW4

ABS



G 6.3 n_{max} 10000

Adapter	DCONWS mm	BD_1 mm	BD_2 mm	LPR mm	LSC mm	LF mm	LB mm
ABS 50	0,5 - 13	49	57.5	95	29	104.0	51.5
ABS 50	2,5 - 16	52	57.5	95	29	105.5	52.0

CT

84 247 ...

01397

01697

Spare parts
for article number

84 247 01397
84 247 01697



Set

CT

84 950 ...

99900
99900



Positioning pin

CT

84 950 ...

20200
20200



Pendulum bolt

CT

84 950 ...

20000
20000



Coolant pipe

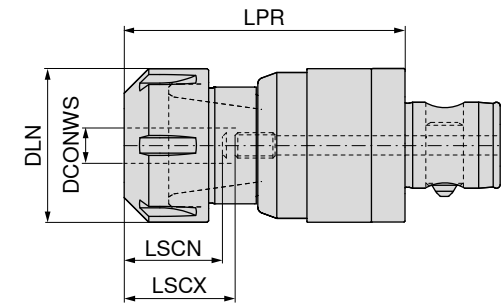
CT

84 950 ...

20100
20100

HyPower – Synchro tapping chuck – ABS

ABS



Adapter	for collet	DCONWS mm	LPR mm	DLN mm	LSCX mm	LSCN mm	CT 84 226 ... 02089 02097 03297
ABS 32	ER 20	1 - 13	78.0	34	42	29	
ABS 50	ER 20	1 - 13	85.0	34	42	29	
ABS 50	ER 32	2 - 20	90.5	50	45	31	

Spare parts for collet

ER 20
ER 20
ER 32

 Lock nut SW	 Lock nut SW	 Lock nut IK	 Lock nut	 Set
CT 62 950 ... 045 045	CT 83 950 ... 51900 51900	CT 83 950 ... 51400	CT 62 950 ... 65600	CT 84 950 ... 99900 98800 99900

Accessories



HyPower – Combination shell mill adapter – ABS

▲ For milling cutters with transverse or longitudinal slot according to DIN 6358

Scope of supply:

Base body including retaining screw, drive ring, and parallel key

ABS

Adapter	DCONWS mm	BD mm	LF_1 mm	LF_2 mm	LSCX mm	LSCN mm
ABS 50	16	32	32	22	27	17
ABS 50	22	40	34	22	31	19
ABS 63	16	32	36	26	27	17
ABS 63	22	40	38	26	31	19
ABS 63	27	48	38	26	33	21
ABS 80	22	40	45	33	31	19
ABS 80	27	48	45	33	33	21
ABS 80	32	58	47	33	38	24
ABS 80	40	70	47	33	41	27

CT

84 229 ...

01697
02297

01696
02296
02796

02292
02792
03292
04092

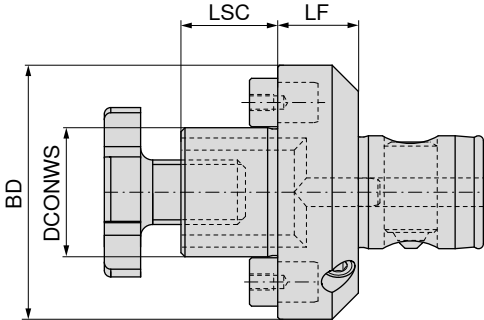
Spare parts
DCONWS

16	99900	4 x 4 x 20	284	116	M8	016
16	98600	4 x 4 x 20	284	116	M8	016
22	98500	6 x 6 x 25	285	122	M10	022
22	99900	6 x 6 x 25	285	122	M10	022
22	98600	6 x 6 x 25	285	122	M10	022
27	98500	7 x 7 x 25	286	127	M12	027
27	98600	7 x 7 x 25	286	127	M12	027
32	98500	8 x 7 x 28	287	132	M16	032
40	98500	10 x 8 x 32	288	140	M20	040

HyPower – Shell mill adapter – ABS

Scope of supply:
Base body including drive dogs and retaining screw

ABS







Adapter	DCONWS mm	LSC mm	LF mm	BD mm
ABS 50	16	17	20	50
ABS 50	22	19	20	50
ABS 50	27	21	20	50
ABS 50	32	24	20	63
ABS 63	22	19	22	63
ABS 63	27	21	22	63
ABS 63	32	24	22	63
ABS 63	40	27	22	80
ABS 80	27	21	25	80
ABS 80	32	24	25	80
ABS 80	40	27	25	80
ABS 80	40	30	43	88
ABS 100	32	24	25	100
ABS 100	40	30	38	88
ABS 100	40	27	25	100
ABS 100	60	40	56	130

CT

84 228 ...

14092

14091

06091

CT

84 228 ...

01697

02297

02797

03297

02296

02796

03296

04096

02792

03292

04092

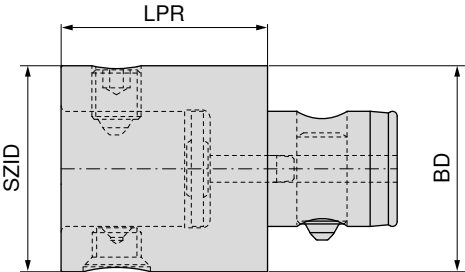
03291

04091

					
		Set	Driver	Drive key	Retaining screws
		CT	CT	CT	CX
Spare parts		84 950 ...	84 950 ...	83 950 ...	83 367 ...
DCONWS					
16		99900			016
22		99900	22900		022
27		98600	23000		027
32		98500	23100		032
32		98400	23100		032
40		98400			040
27		99900	23000		027
32		99900	23100		032
22		98600	22900		022
32		98600	23100		032
40		98600			040
27		98500	23000		027
40		98500			040
40		98400		295	
60		98400		298	
40		98500		295	

HyPower – Extension – ABS

ABS



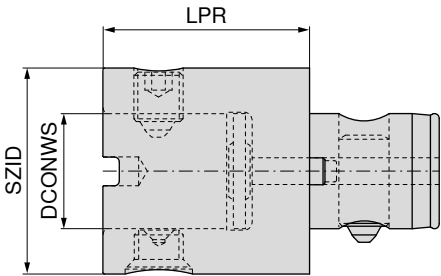
Adapter	SZID	BD mm	LPR mm
ABS 25	ABS 25	25	45
ABS 25	ABS 25	25	60
ABS 32	ABS 32	32	35
ABS 32	ABS 32	32	50
ABS 32	ABS 32	32	70
ABS 40	ABS 40	40	40
ABS 40	ABS 40	40	60
ABS 40	ABS 40	40	90
ABS 50	ABS 50	50	50
ABS 50	ABS 50	50	65
ABS 50	ABS 50	50	100
ABS 50	ABS 50	50	150
ABS 63	ABS 63	63	60
ABS 63	ABS 63	63	85
ABS 63	ABS 63	63	125
ABS 63	ABS 63	63	190
ABS 80	ABS 80	80	70
ABS 80	ABS 80	80	85
ABS 80	ABS 80	80	125
ABS 80	ABS 80	80	240
ABS 100	ABS 100	100	85
ABS 100	ABS 100	100	125
ABS 100	ABS 100	100	160
ABS 125	ABS 125	125	160
ABS 125	ABS 125	125	200

CT
84 209 ...
04590
06090
03589
05089
07089
04088
06088
09088
05097
06597
10097
15097
06096
08596
12596
19096
07092
08592
12592
24092
08591
12591
16091
16085
20085

	 Clamping screw	 Clamping screw	 Set	 Set	 Positioning pin	 Pendulum bolt	 Coolant pipe	 Taper screw
	CT	CT	CT	CT	CT	CT	CT	CT
Spare parts	62 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...
Adapter								
ABS 25		26800	98900	99700	23600	26000	24400	27000
ABS 32	13989		98800	99600	23700	26100	24500	27100
ABS 40		26900	98700	99500	23800	26200	24600	27200
ABS 50		20300	99900	99800	20200	20000	20100	20400
ABS 63		25500	98600	99400	23900	26300	24700	27300
ABS 80		25600	98500	99300	24000	26400	24800	25100
ABS 100		25700	98400	99200	24100	26500	24900	25200
ABS 125		25800	98300	99100	24200	26600	25000	25300

HyPower – Extension – ABS N

ABS N

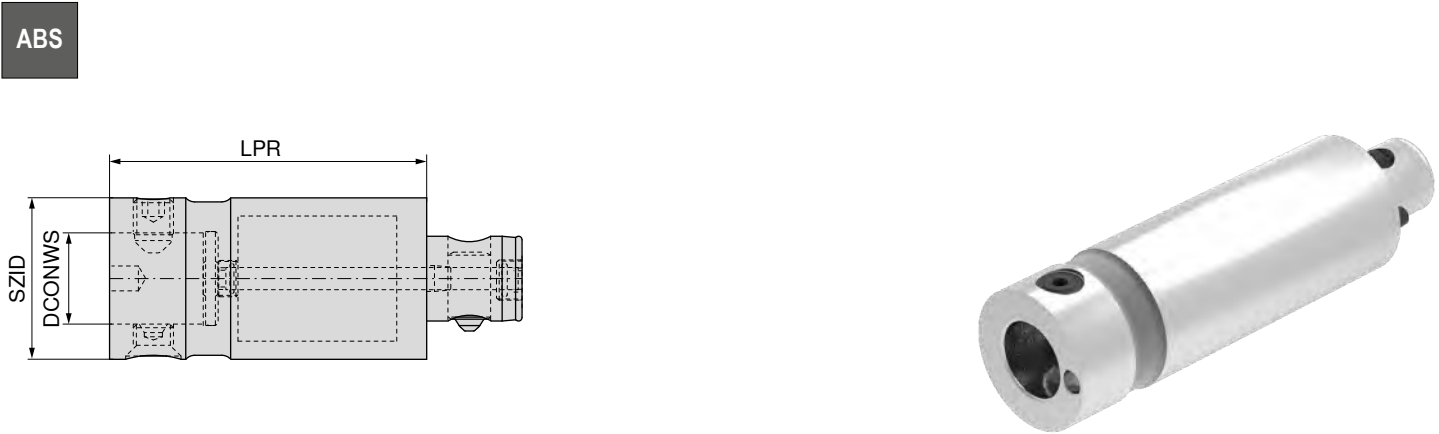


Adapter	SZID	BD mm	LPR mm	CT 84 236 ...
ABS 40 N	ABS 40 N	40	90	09013
ABS 50 N	ABS 50 N	50	65	06512
ABS 63 N	ABS 63 N	63	85	08511
ABS 80 N	ABS 80 N	80	85	08510
ABS 100 N	ABS 100 N	100	125	12509
ABS 100 N	ABS 100 N	100	160	16009

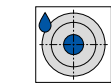
Spare parts Adapter

	Clamping screw CT 84 950 ...	Set CT 84 950 ...	Set CT 84 950 ...	Positioning pin CT 84 950 ...	Positioning pin CT 84 950 ...	Taper screw CT 84 950 ...	Sealing disc – ABS CT 84 950 ...
ABS 40 N	26900	98700	99500	32300	23800	27200	30600
ABS 50 N	20300	99900	99800	31800	20200	20400	30700
ABS 63 N	25500	98600	99400	31900	23900	27300	30800
ABS 80 N	25600	98500	99300	32000	24000	25100	30900
ABS 100 N	25700	98400	99200	32100	24100	25200	31000

HyPower – Extension lightweight construction – ABS



Adapter	SZID	BD mm	LPR mm
ABS 63	ABS 63	63	125
ABS 63	ABS 63	63	190
ABS 80	ABS 80	80	170
ABS 100	ABS 100	100	200
ABS 100	ABS 100	100	300



CT
84 237 ...
12596
19096
17092
20091
30091

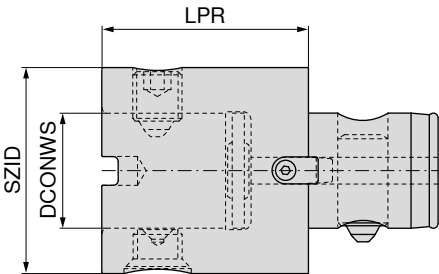
Spare parts
Adapter

ABS 63	25500	98600	99400	27300	30800
ABS 80	25600	98500	99300	25100	30900
ABS 100	25700	98400	99200	25200	31000

 Clamping screw	 Set	 Set	 Taper screw	 Sealing disc – ABS
CT	CT	CT	CT	CT
84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...

HyPower – Extension – ABS N/-T

ABS
N/-T



Adapter	SZID	LPR mm	CT
ABS 50 T	ABS 50 N	100	84 239 ...
ABS 50 T	ABS 50 N	150	10005
			15005
ABS 63 T	ABS 63 N	125	12504
ABS 63 T	ABS 63 N	190	19004
ABS 80 T	ABS 80 N	125	12503
ABS 80 T	ABS 80 N	240	24003

Spare parts
Adapter

	Positioning pin	Positioning pin	Drive dog	Taper screw	Sealing disc – ABS
ABS 50 T	31800	20200	31500	20400	30700
ABS 63 T	31900	23900	31600	27300	30800
ABS 80 T	32000	24000	31700	25100	30900

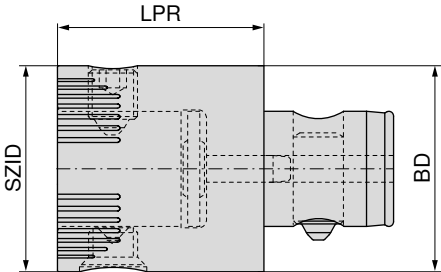
Spare parts
Adapter

	Cylindrical screw	Clamping screw	Set	Set
ABS 50 T	M3x10	00001	20300	99900
ABS 63 T	M4x12	00002	25500	98600
ABS 80 T	M5x16	00000	25600	98500

HyPower – Torsional vibration damper with ABS connection – ABS

Scope of supply:
Base body with sealing disc

ABS

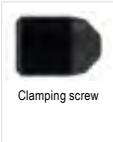
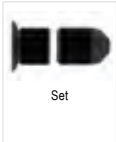
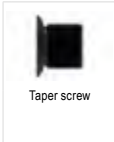


Adapter	SZID	BD mm	LPR mm
ABS 50	ABS 50	50	50
ABS 63	ABS 63	63	60
ABS 80	ABS 80	80	70

CT
84 216 ...
05097
06096
07092

Spare parts
Adapter

ABS 50
ABS 63
ABS 80

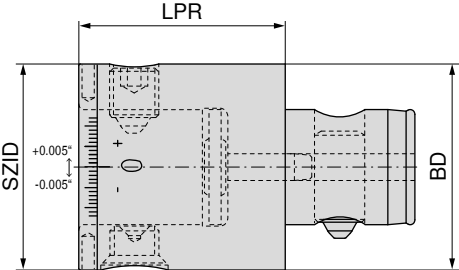
 Clamping screw	 Set	 Set	 Taper screw
CT	CT	CT	CT
84 950 ...	84 950 ...	84 950 ...	84 950 ...
20300	99900	99800	20400
25500	98600	99400	27300
25600	98500	99300	25100

HyPower – Eccentric adjuster – ABS

▲ Adjustment ±0.010 inch on diameter

Scope of supply:
Eccentric adjuster with adjuster key Ø 2.8 mm

ABS







Adapter	SZID	BD mm	LPR mm
ABS 50	ABS 50	50	50
ABS 63	ABS 63	63	60

CT

84 217 ...

05097

06096

Spare parts
Adapter

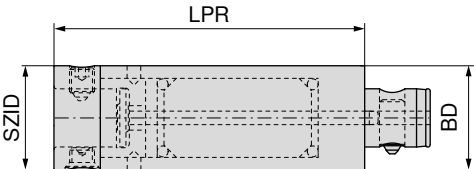
ABS 50				
ABS 63				

 Clamping screw	 Set	 Set	 Taper screw
CT	CT	CT	CT
84 950 ...	84 950 ...	84 950 ...	84 950 ...
20300	99900	99800	20400
25500	98600	99400	27300

HyPower – Damping element – ABS

- ▲ The specially mounted damping core enables perfect machining results even with longer tool overhangs
- ▲ Reduction in machining times due to optimum machining parameters
- ▲ Damped machining and therefore perfect surface qualities
- ▲ Protection of the machine spindle and increased tool service life

ABS



Adapter	SZID	BD	LPR	RPMX
		mm	mm	1/min.
ABS 40	ABS 40	40	120	8000
ABS 50	ABS 50	50	150	6300
ABS 63	ABS 63	63	190	5000
ABS 80	ABS 80	80	240	4000

CT
84 218 ...
12088
15097
19096
24092

Spare parts
Adapter

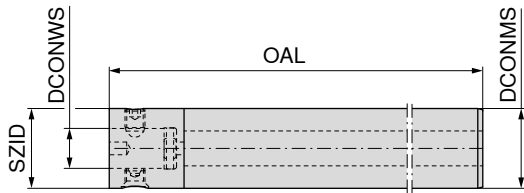
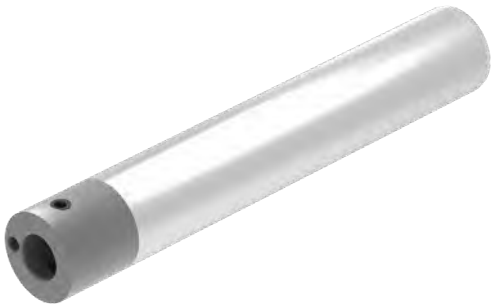
ABS 40	26900	98700	99500	27200
ABS 50	20300	99900	99800	20400
ABS 63	25500	98600	99400	27300
ABS 80	25600	98500	99300	25100

 Clamping screw	 Set	 Set	 Taper screw
CT	CT	CT	CT
84 950 ...	84 950 ...	84 950 ...	84 950 ...

HyPower – Damping element – ABS

- ▲ Suitable for preventing unwanted vibrations in the tool
- ▲ Suitable for shrinking

ABS



DCONWS	DCONMS	OAL	LS	LSC	SZID
mm	mm	mm	mm	mm	
13	25	185	56	20	ABS 25
13	25	160	56	20	ABS 25
13	25	210	56	20	ABS 25
16	32	230	60	23	ABS 32
16	32	200	60	23	ABS 32
16	32	260	60	23	ABS 32

CT
84 238 ...
18599
16099
21099
23099
20099
26099

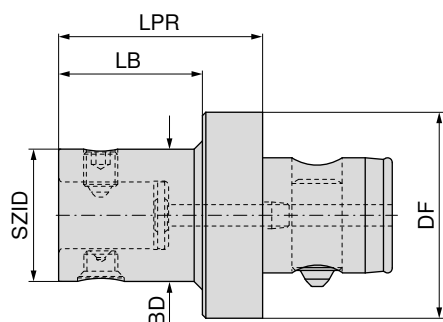
Spare parts
DCONWS

13	
16	M8x1x12/SW4

Clamping screw	Clamping screw	Set	Taper screw	Sealing disc – ABS
CT	CT	CT	CT	CT
62 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...
	26800	99700	27000	30400
	13989	99600	27100	30500

HyPower – Reduction – ABS

ABS



Adapter	SZID	BD mm	DF mm	LPR mm	LB mm
ABS 32	ABS 25	25	32	40	30
ABS 40	ABS 25	25	40	40	28
ABS 40	ABS 32	32	40	40	28
ABS 50	ABS 25	25	50	50	35
ABS 50	ABS 32	32	50	50	35
ABS 50	ABS 40	40	50	50	35
ABS 63	ABS 25	25	63	60	40
ABS 63	ABS 32	32	63	60	40
ABS 63	ABS 40	40	63	60	40
ABS 63	ABS 50	50	63	60	40
ABS 80	ABS 32	32	80	60	35
ABS 80	ABS 40	40	80	60	35
ABS 80	ABS 50	50	80	60	35
ABS 80	ABS 63	63	80	60	35
ABS 100	ABS 50	50	100	80	50
ABS 100	ABS 63	63	100	80	50
ABS 100	ABS 80	80	100	80	50
ABS 125	ABS 80	80	125	100	50
ABS 125	ABS 100	100	125	100	50

CT

84 219 ...

03290

04090

04089

05090

05089

05088

06390

06389

06388

06397

08089

08088

08097

08096

10097

10096

10092

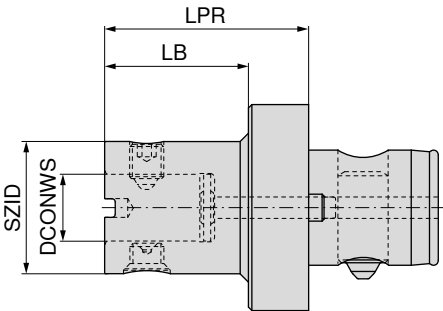
12592

12591

						
		Clamping screw	Clamping screw	Set	Set	Taper screw
		CT	CT	CT	CT	CT
Spare parts		62 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...
SZID						
ABS 25			26800	98800	99700	27000
ABS 25			26800	98700	99700	27000
ABS 32	M8x1x12/SW4	13989		98700	99600	27100
ABS 25			26800	99900	99700	27000
ABS 32	M8x1x12/SW4	13989		99900	99600	27100
ABS 40			26900	99900	99500	27200
ABS 25			26800	98600	99700	27000
ABS 32	M8x1x12/SW4	13989		98600	99600	27100
ABS 40			26900	98600	99500	27200
ABS 50			20300	98600	99800	20400
ABS 32	M8x1x12/SW4	13989		98500	99600	27100
ABS 40			26900	98500	99500	27200
ABS 50			20300	98500	99800	20400
ABS 63			25500	98500	99400	27300
ABS 50			20300	98400	99800	20400
ABS 63			25500	98400	99400	27300
ABS 80			25600	98400	99300	25100
ABS 80			25600	98300	99300	25100
ABS 100			25700	98300	99200	25200

HyPower – Reduction – ABS N

ABS N



Adapter	SZID	BD mm	DF mm	LPR mm	LB mm
ABS 50 N	ABS 40 N	40	50	50	35
ABS 63 N	ABS 50 N	50	63	60	40
ABS 80 N	ABS 50 N	50	80	60	35
ABS 80 N	ABS 63 N	63	80	60	35
ABS 100 N	ABS 50 N	50	100	80	50
ABS 100 N	ABS 80 N	80	100	80	50

CT
84 240 ...
04012
05011
05010
06310
05009
08009

Spare parts
SZID

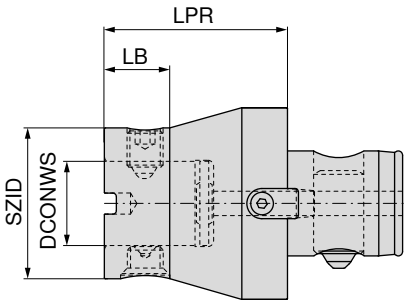
	Positioning pin	Pendulum bolt	Coolant pipe	Taper screw	Sealing disc – ABS
ABS 40 N	20200	20000	20100	27200	30600
ABS 50 N	20200	26500	24900	20400	30700
ABS 50 N	20200	26300	24700	20400	30700
ABS 50 N	20200	26400	24800	20400	30700
ABS 63 N	24000	26400	24800	27300	30800
ABS 80 N	24000	26500	24900	25100	30900

Spare parts
SZID

	Clamping screw	Set	Set	Positioning pin
ABS 40 N	26900	99900	99500	32300
ABS 50 N	20300	98400	99800	31800
ABS 50 N	20300	98600	99800	31800
ABS 50 N	20300	98500	99800	31800
ABS 63 N	25500	98500	99400	31900
ABS 80 N	25600	98400	99300	32000

HyPower – Reduction – ABS N/-T

ABS
N/-T



Adapter	SZID	BD mm	DF mm	LPR mm	LB mm
ABS 63 T	ABS 50 N	50	63	60	21
ABS 80 T	ABS 63 N	63	80	60	21

CT
84 240 ...
05004
06303

Spare parts
SZID

ABS 50 N	20200	26300	31600	24700	20400	30700
ABS 63 N	24000	26400	31700	24800	27300	30800

					
Positioning pin	Pendulum bolt	Drive dog	Coolant pipe	Taper screw	Sealing disc – ABS
CT	CT	CT	CT	CT	CT
84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...

Spare parts
SZID

ABS 50 N	M4x12	00002	20300	98600	99800	31800
ABS 63 N	M5x16	00000	25500	98500	99400	31900

				
Cylindrical screw	Clamping screw	Set	Set	Positioning pin
CT	CT	CT	CT	CT
62 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...

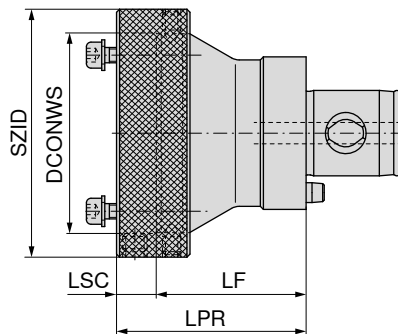
HyPower – Compensation holder – DAH

- ▲ Compensation systems for μ -precision run-out
- ▲ Simple correction of run-out and axis errors
- ▲ Optimized for high rpm
- ▲ Designed for internal coolant supply
- ▲ Rotary tools provide long tool life

Scope of supply:

DAH compensation holder complete with assembly screws

DAH



Adapter	SZID	DCONWS mm	LSC mm	LPR mm	LF mm	CT
ABS 63	DAH 115	100	16	70	54	84 329 ... 11596
ABS 40	DAH 81	65	12	62	50	08188
ABS 50	DAH 81	65	12	62	50	08197

Spare parts for article number

	Coolant pipe	Grub screw	Spring washer	DAH adjustment ring
84 329 11596	24700	M8x10 43000	Ø8,4 - M8 42400	DAH 115 42100
84 329 08188	24600	M6x10 42800	Ø5,3 - M5 42300	DAH 81 42000
84 329 08197	20100	M6x10 42800	Ø5,3 - M5 42300	DAH 81 42000

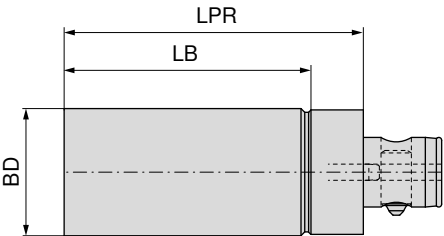
Spare parts for article number

	Cylindrical screw	Clamping screw	Set	Positioning pin	Pendulum bolt
84 329 11596	M8X30 42600	M8x8 - SW4 14700	98600	23900	26300
84 329 08188	M5x22 42500	M8x6 - SW4 53400	98700	23800	26200
84 329 08197	M5x22 42500	M8x6 - SW4 53400	99900	20200	20000

HyPower – Blank – ABS

- ▲ Connection area hardened and ground
- ▲ Dimension BD x dimension LB = unhardened area for further processing

ABS



Adapter	LPR mm	BD mm	LB mm
ABS 25	70	26	55
ABS 32	80	33	65
ABS 40	100	41	82
ABS 50	120	51	99
ABS 63	150	64	124
ABS 80	180	81	145
ABS 100	200	101	158

CT
84 230 ...
02690
03389
04188
05197
06496
08192
10191

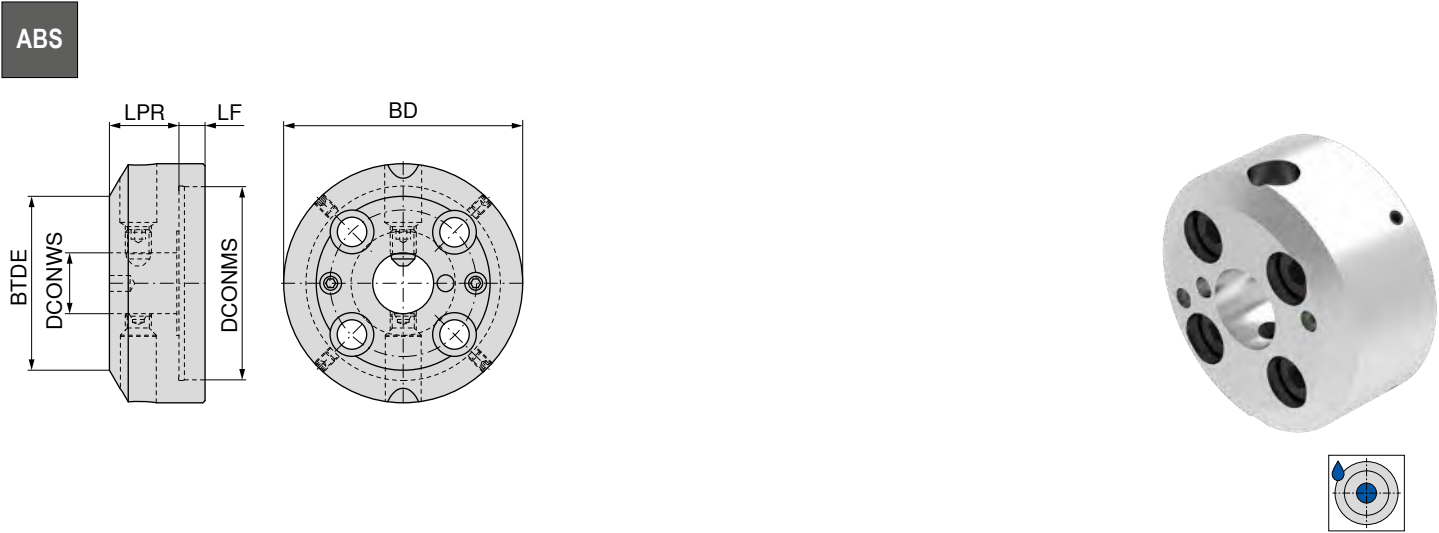
Spare parts
Adapter

- ABS 25
- ABS 32
- ABS 40
- ABS 50
- ABS 63
- ABS 80
- ABS 100


Set
CT
84 950 ...
98900
98800
98700
99900
98600
98500
98400

HyPower – Spindle attachment flange – ABS

- ▲ For spindle head according to DIN 2079
- ▲ This attachment flange does not have any keyways. Inserted drive dogs on the spindle head must be removed



Adapter	DCONWS	DCONMS	LPR	LF	OAL	BD	BTED	CT
	mm	mm	mm	mm	mm	mm	mm	
SK 30	34	69.83	40	11	51	90	70	84 242 ...
								06380
SK 40	28	88.88	32	12	44	110	80	05079
SK 40	34	88.88	40	12	52	110	80	06379

Spare parts
SZID

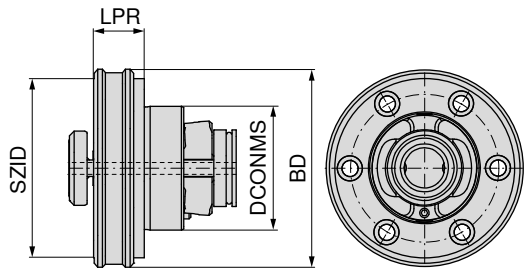
ABS 50	20300	99800	20400	30700
ABS 63	25500	99400	27300	30800

 Clamping screw	 Set	 Taper screw	 Sealing disc – ABS
CT	CT	CT	CT
84 950 ...	84 950 ...	84 950 ...	84 950 ...

CoreLine – Mounting flange HSK-REF

▲ Radially adjustable using adjustment screw in the machine spindle

Scope of supply:
Complete mounting flange with KOMloc clamping set, lock ring, and plunger



AD

SZID	DCONWS	DCONMS	BD	LPR	OAL
mm	mm	mm	mm	mm	mm
HSK-A 50	50	42	69.2	17.5	51.6

CT

84 241 ...

00258

Spare parts
for article number

84 241 00258


Lock ring for twisting

CT

84 243 ...

35000


Ball plunger

CT

84 243 ...

55000

HSK50 - SW4


KOMloc clamp

CT

84 243 ...

15000


Fixing screw

CT

10 950 ...

17700

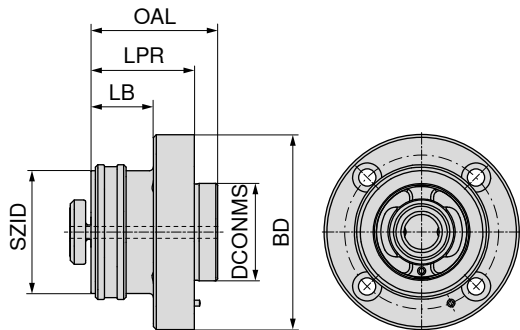
M5x20

CoreLine – Attachment flange HSK-RVF

▲ Radially adjustable using adjustment screws in the machine spindle

Scope of supply:

Complete attachment flange with KOMloc clamping set and lock ring



AD

SZID	DCONWS	DCONMS	LB	BD	LPR	OAL
	mm	mm	mm	mm	mm	mm
HSK-A 50 / HSK-C 50	50	40	26	80	43	53
HSK-A 63 / HSK-C 63	63	50	32	100	53	65

CT
84 241 ...
50058
50157

**Spare parts
for article number**

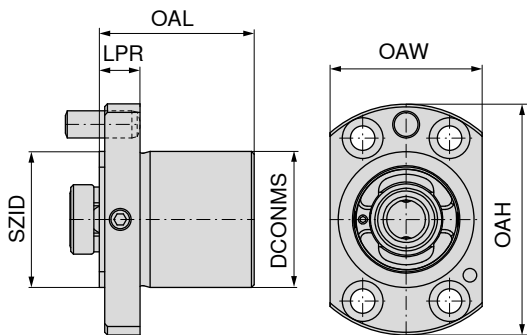
84 241 50058
84 241 50157

			
Lock ring for sliding	KOMloc clamp	Fixing screw	Fixing screw
CT	CT	FI	CT
84 243 ...	84 243 ...	10 950 ...	10 950 ...
45000	15000	17600	
46300	16300		17800

CoreLine – Mounting flange HSK-SEFR

Scope of supply:

Mounting flange with KOMloc clamping set, spring screw, and cylindrical pin. Please order cylindrical screws for mounting separately



SZID	DCONWS	DCONMS	LB	LPR	OAW	OAH	OAL
mm	mm	mm	mm	mm	mm	mm	mm
HSK-A 50	50	50	2	15	56	85	57

CT

84 241 ...

00158

**Spare parts
for article number**

84 241 00158

		
Cylindrical pin	KOMloc clamp	Fixing screw
CT	CT	AS
84 950 ...	84 243 ...	10 950 ...
32200	15000	16800

Lock ring for twisting



Adapter	BD mm
HSK 50	53.4
HSK 63	69.2

CT
84 243 ...
35000
36300

Lock ring for sliding



Adapter	BD mm
HSK 50	55.0
HSK 63	69.2

CT
84 243 ...
45000
46300

CoreLine – HSK vice



YES

Adapter	MXC kN	TQX Nm	DRVS mm
HSK 50	31	10	4
HSK 63	40	15	5

CT

84 243 ...

15000

16300

Spare parts
for article number

84 243 15000
84 243 16300



Threaded spindle

CT

84 950 ...

31100

31200

Ball plunger



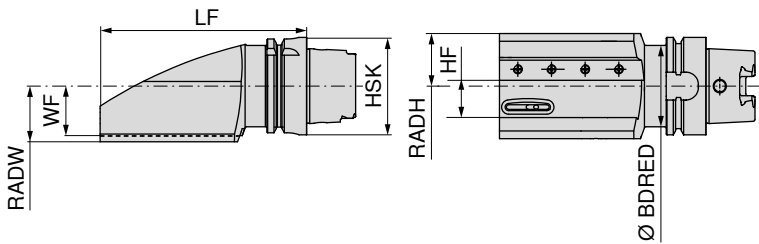
Adapter	for
HSK 50	HSK 50

CT

84 243 ...

55000

CoreLine – Parting blade holder GX/LX/FX/SX



Illustrations show right-hand versions



Left

Right

Adapter	LF mm	BDRED mm	WF mm	HF mm	RADW mm	RADH mm	for parting blades	CT	
								74 585 ...	74 584 ...
HSK-T 63	155	52.6	32	26	36.0	34	XLCF R/L 26...	02637	02637
HSK-T 63	155	52.6	32	32	37.5	35	XLCF R/L 32...	03237	03237

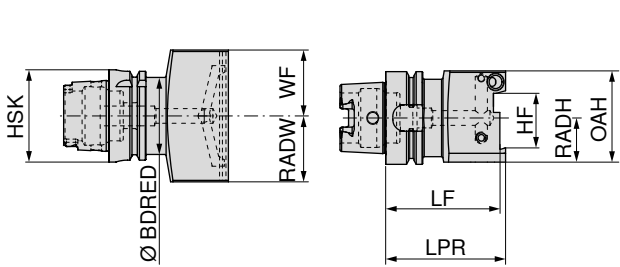
Spare parts
for parting blades

XLCF R/L 26...	23x2,5	292	KU1.U12.005.010	92800	860	M6x12	861
XLCF R/L 32...	23x2,5	292	KU1.U12.005.010	92800	860	M6x12	861

Spare parts
for parting blades

XLCF R/L 26...			KU1.U12.ER1.020	92900	19x2,5	293
XLCF R/L 32...			KU1.U12.ER1.020	92900	19x2,5	293

CoreLine – Parting blade holder GX/LX/FX/SX



Radial

Adapter	LPR	LF	BDRED	WF	HF	OAH	RADW	RADH	for parting blades	CT
HSK-T 63	84.0	80	52.6	45	26	62	45	30	XLCF N 26...	74 586 ...
HSK-T 63	85.5	80	52.6	45	32	68	45	34	XLCF N 32...	02637 03237

Spare parts
for parting blades

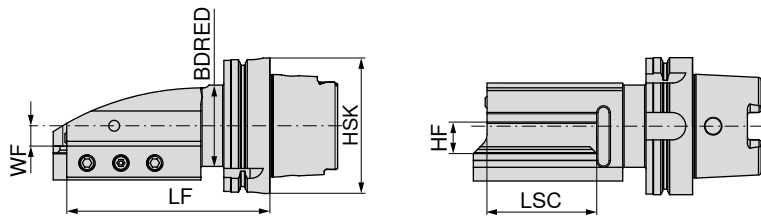
XLCF N 26...	23x2,5	292	KU1.U12.005.010	92800	860	M6x12	861
XLCF N 32...	23x2,5	292	KU1.U12.005.010	92800	860	M6x12	861

Spare parts
for parting blades

XLCF N 26...			KU1.U12.ER1.020	92900	19x2,5	293
XLCF N 32...			KU1.U12.ER1.020	92900	19x2,5	293

CoreLine – Square shank holder 0°

- ▲ Suitable for rotating tool holders with HF = 20 / 25 / 32 mm
- ▲ These HF values can be achieved by removing the mounting adapter and clamping block



Illustrations show right-hand versions



Left

Right

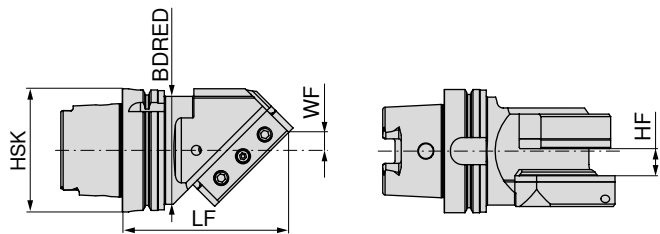
Adapter	LF mm	BDRED mm	WF mm	LSC mm	HF mm	CT	
						74 571 ...	74 570 ...
HSK-T 63	145	52.6	15	80	20 / 25 / 32	02537	02537
HSK-T 100	150	60.0	15	80	20 / 25 / 32	02535	02535

Spare parts Adapter

		Cylindrical screw		Clamping screw		Key KU		Coolant nozzle KU	
		CT		CT		CT		CT	
		83 950 ...		62 950 ...		70 950 ...		70 950 ...	
HSK-T 63	M5x5 - SW2,5	157	M12x16 - SW6	51100	KU1.U12.ER1.020	92900	KU1.U12.005.010	92800	92800
HSK-T 100	M5x5 - SW2,5	157	M12x16 - SW6	51100	KU1.U12.ER1.020	92900	KU1.U12.005.010	92800	92800

CoreLine – Square shank holder 45°

- ▲ Suitable for rotating tool holders with HF = 20 / 25 / 32 mm
- ▲ These HF values can be achieved by removing the mounting adapter and clamping block



Illustrations show right-hand versions



Left



Right

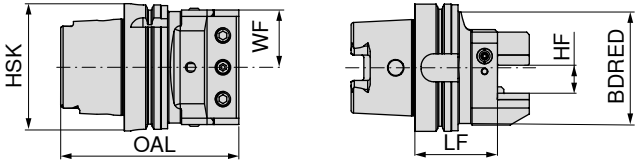
Adapter	LF mm	BDRED mm	WF mm	HF mm	CT	
					74 573 ...	74 572 ...
HSK-T 63	130	52.6	14.6	20 / 25 / 32	02537	02537
HSK-T 100	135	87.6	14.6	20 / 25 / 32	02535	02535

Spare parts
Adapter

		Cylindrical screw		Clamping screw		Key KU		Coolant nozzle KU	
		CT		CT		CT		CT	
		83 950 ...		62 950 ...		70 950 ...		70 950 ...	
HSK-T 63	M5x5 - SW2,5	157	M12x16 - SW6	51100	KU1.U12.ER1.020	92900	KU1.U12.005.010	92800	92800
HSK-T 100	M5x5 - SW2,5	157	M12x16 - SW6	51100	KU1.U12.ER1.020	92900	KU1.U12.005.010	92800	92800

CoreLine – Square shank holder 90°

- ▲ Suitable for rotating tool holders with HF = 20 / 25 / 32 mm
- ▲ These HF values can be achieved by removing the mounting adapter and clamping block



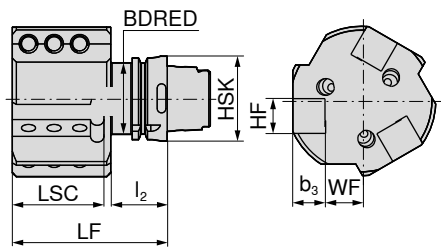
Neutral

Adapter	LF mm	BDRED mm	WF mm	OAL mm	HF mm	CT 74 575 ... 02537 02535	
HSK-T 63	60	52.6	45	117	20 / 25 / 32		
HSK-T 100	65	87.6	45	140	20 / 25 / 32		

Spare parts
Adapter

		Cylindrical screw CT 83 950 ...		Clamping screw CT 62 950 ...		Key KU CT 70 950 ...		Coolant nozzle KU CT 70 950 ...	
HSK-T 63	M5x5 - SW2,5	157	M12x16 - SW6	51100	KU1.U12.ER1.020	92900	KU1.U12.005.010	92800	
HSK-T 100	M5x5 - SW2,5	157	M12x16 - SW6	51100	KU1.U12.ER1.020	92900	KU1.U12.005.010	92800	

CoreLine – Square shank holder 3 face 0°

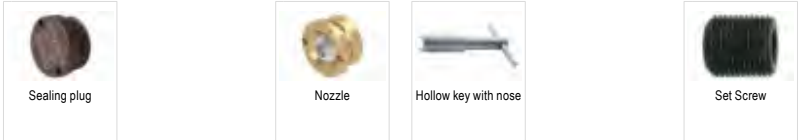


Left

Designation	Adapter	LF mm	l ₂ mm	BDRED mm	WF mm	LSC mm	b ₃ mm	HF mm	CT 74 576 ... 525 725
HSK T63 SH3 L 00 2525	HSK-T 63	115	42	53	28	68	25	25	
HSK T100 SH3 L 00 2525	HSK-T 100	120	45	88	33	70	25	25	

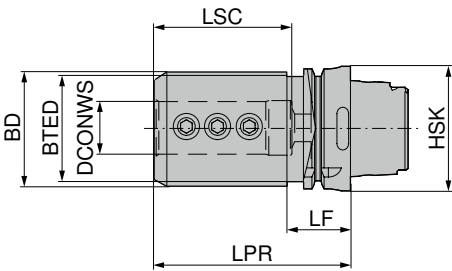
Spare parts
Adapter

HSK-T 63	UNJF 7/16"-20	05600	UNJF 7/16"-20	05500	05700	M12x1,75x25	851
HSK-T 100	UNJF 7/16"-20	05600	UNJF 7/16"-20	05500	05700	M12x1,75x25	851



AS 70 950 ...	AS 70 950 ...	CT 70 950 ...	CT 70 950 ...
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CoreLine – Boring bar holder



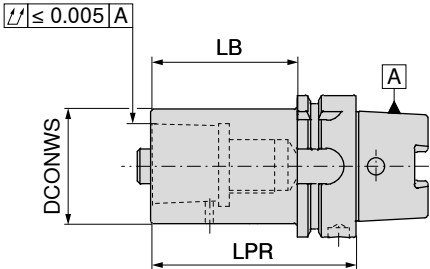
Designation	Adapter	LPR mm	DCONWS mm	BD mm	LSC mm	LF mm	BTED mm
HSK T63 BH08 80	HSK-T 63	80	8	32	41		
HSK T63 BH10 80	HSK-T 63	80	10	40	41		
HSK T63 BH12 80	HSK-T 63	80	12	40	41		
HSK T63 BH16 80	HSK-T 63	80	16	40	51		
HSK T63 BH20 80	HSK-T 63	80	20	50	51		
HSK T63 BH25 90	HSK-T 63	90	25	53	61		
HSK T63 BH32 95	HSK-T 63	95	32	68	61	42	53
HSK T100 BH20 90	HSK-T 100	90	20	55	56		
HSK T100 BH25 95	HSK-T 100	95	25	55	61		
HSK T100 BH32 110	HSK-T 100	110	32	68	61		
HSK T100 BH40 120	HSK-T 100	120	40	83	81		
HSK T100 BH50 125	HSK-T 100	125	50	98	91	45	88

CT
74 577 ...
508
510
512
516
520
525
532
720
725
732
740
750

CoreLine – HSK-T/PSC adapter

- ▲ For mounting PSC adapters according to ISO 26623-1
- ▲ Also available with Balluff chip **on request**

Scope of supply:
with clamping screw and threaded ring



Adapter	LPR mm	DCONWS mm	LSC mm
HSK-T 63	80	28	24
HSK-T 63	90	35	30
HSK-T 100	90	28	24
HSK-T 100	100	35	30
HSK-T 100	110	44	38
HSK-T 100	125	55	48

CT
84 018 ...
06395
06394
10095
10094
10093
10086

Spare parts
DCONWS

28
35
44
55



Threaded ring

CT
84 950 ...
53900
54000
54100
54100



Clamping screw

CT
84 950 ...
53400
53500
53600
53600

Accessories



Coolant transfer pipe

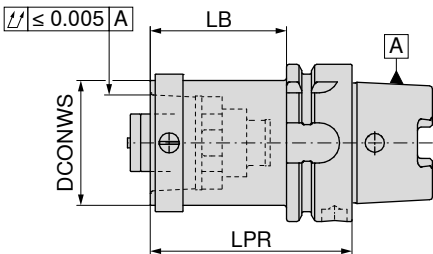


Others

CoreLine – HSK-T reduction

- ▲ For mounting HSK-T adapters according to ISO 12164-3
- ▲ Also suitable for HSK-A and HSK-C
- ▲ **On request:** Also available with Balluff chip

Scope of supply:
with clamping cartridge



Adapter	LPR mm	DCONWS mm	LSC mm
HSK-T 100	100	48.01	32

CT

84 041 ...

10057

Accessories



Coolant transfer pipe

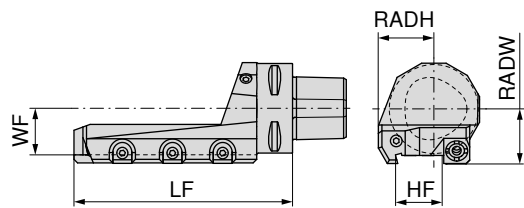
→



Others

→

CoreLine – Parting blade holder GX/LX/FX/SX



Illustrations show right-hand versions



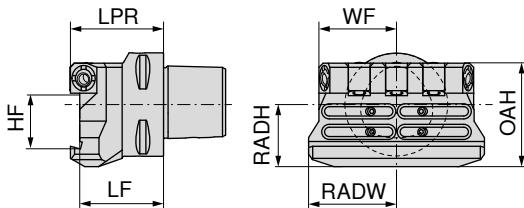
Left

Right

Adapter	LF mm	WF mm	HF mm	RADW mm	RADH mm	for parting blades
PSC 40	122	21	26	25.5	31	XLCF N 26...
PSC 50	122	26	26	30.5	31	XLCF N 26...
PSC 63	160	32	32	36.5	37	XLCF N 32...

CT	CT
84 617 ... 32695	84 617 ... 22695
32694	22694
33293	23293

CoreLine – Parting blade holder GX/LX/FX/SX



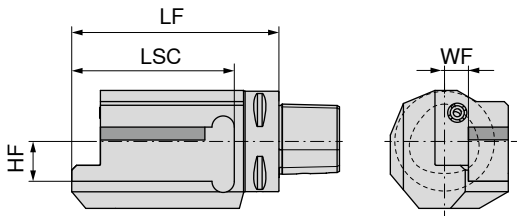
Radial

Adapter	LF mm	LPR mm	WF mm	HF mm	OAH mm	RADW mm	RADH mm	for parting blades
PSC 40	40.5	45	37.5	26	50	42.5	30	XLCF N 26...
PSC 50	40.5	45	37.5	26	50	42.5	30	XLCF N 26...
PSC 63	45.5	50	40.0	32	57	45.0	35	XLCF N 32...

CT
84 617 ... 62695
62694
63293

CoreLine – Square shank holder 0°

- ▲ Suitable for tool holders with PSC 63 – HF = 20 / 25 mm / PSC 80 – HF = 25 mm
- ▲ These HF values can be achieved by removing the clamping block



Illustrations show right-hand versions



Left



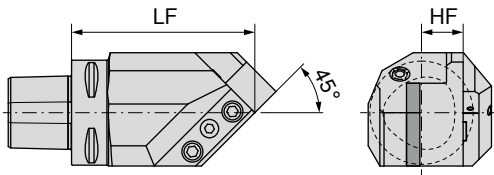
Right

Adapter	LF mm	WF mm	LSC mm	HF mm
PSC 63	130	15	102	20 / 25
PSC 80	130	15	88	25

CT	CT
84 616 ... 32593	84 616 ... 22593
32586	22586

CoreLine – Square shank holder 45°

- ▲ Suitable for tool holders with PSC 50 – HF = 20 mm / PSC 63 – HF = 20 / 25 mm
- ▲ These HF values can be achieved by removing the clamping block



Illustrations show right-hand versions



Left



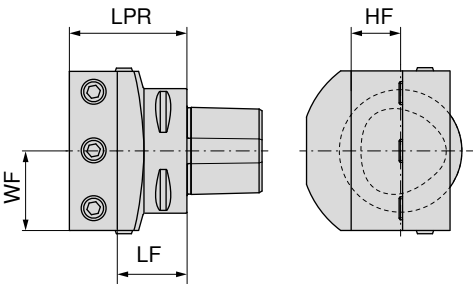
Right

Adapter	LF mm	HF mm
PSC 50	85	20
PSC 63	110	20 / 25

CT	CT
84 616 ... 02094	84 616 ... 12094
02593	12593

CoreLine – Square shank holder 90°

- ▲ Suitable for tool holders with PSC 40 – HF = 20 mm / PSC 63 – HF = 20 / 25 mm
- ▲ These HF values can be achieved by removing the clamping block



Neutral

Adapter	LF mm	WF mm	HF mm
PSC 40	35	30	20
PSC 63	46	40	20 / 25

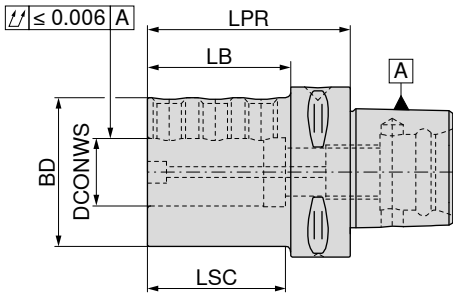
CT

84 616 ...

62095

62593

CoreLine – Boring bar holder



Adapter	DCONWS mm	LPR mm	BD mm	LB mm	LSC mm
PSC 50	6	70	40	50	40
PSC 50	8	70	44	50	40
PSC 50	10	70	44	50	45
PSC 50	12	70	44	50	45
PSC 50	16	75	44	55	45
PSC 50	20	75	50	55	51
PSC 50	25	80	55	60	51
PSC 50	32	90	63	70	60
PSC 63	6	75	40	53	40
PSC 63	8	75	44	53	40
PSC 63	10	75	44	53	45
PSC 63	12	75	44	53	45
PSC 63	16	75	44	53	45
PSC 63	20	75	50	53	51
PSC 63	25	75	55	53	51
PSC 63	32	75	72	52	60
PSC 63	40	105	70	82	90

CT

82 268 ...

- 10694
- 10894
- 11094
- 11294
- 11694
- 12094
- 12594
- 13294

- 10693
- 10893
- 11093
- 11293
- 11693
- 12093
- 12593
- 13293
- 14093

Spare parts
DCONWS

- 6
- 8
- 10
- 12 - 40



Set Screw

CT

83 950 ...

- 461
- 466
- 470
- 475

Accessories



Coolant transfer pipe

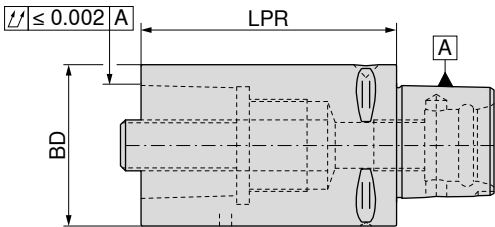


Others



CoreLine – Extension

- ▲ Run-out ≤ 0.002 mm
- ▲ Max. speed 8,000 rpm



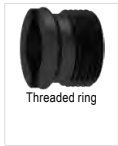
Adapter	BD mm	LPR mm
PSC 40	40	60
PSC 40	40	80
PSC 50	50	80
PSC 50	50	100
PSC 63	63	100
PSC 63	63	140
PSC 80	80	100
PSC 80	80	125

CT
84 620 ...
06095
08095
08094
10094
10093
14093
10086
12586

Spare parts

Adapter

PSC 40
PSC 50
PSC 63
PSC 80



Threaded ring

CT
84 950 ...
53900
54000
54100
54100



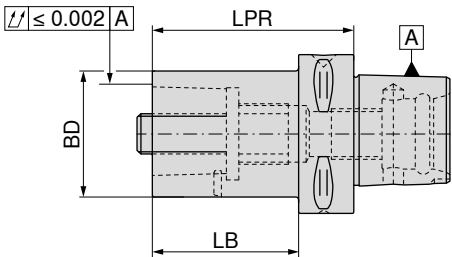
Clamping screw

CT
84 950 ...
SW8
SW14
SW14
SW14

53400
53500
53600
53600

CoreLine – Cylindrical reduction

- ▲ Run-out ≤ 0.002 mm
- ▲ Max. speed 8,000 rpm



Adapter	BD mm	LPR mm	LB mm	CT	
PSC 40	32	55	28	84 624 ...	03295
PSC 50	40	65	36		04094
PSC 63	40	80	53		04093
PSC 63	50	80	51		05093
PSC 80	40	70	30		04086
PSC 80	50	80	43		05086
PSC 80	63	80	50		06386

Spare parts
for article number

84 624 03295
84 624 04094
84 624 04093
84 624 05093
84 624 04086
84 624 05086
84 624 06386



Threaded ring

CT
84 950 ...

54200
53900
53900
54000
53900
54000
54100

SW8
SW8
SW8
SW14
SW8
SW14
SW14



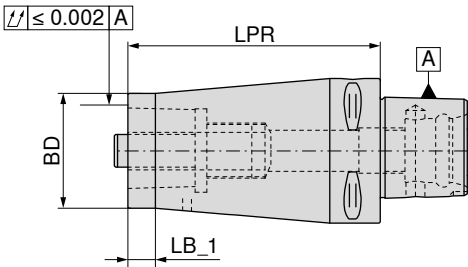
Clamping screw

CT
84 950 ...

53800
53400
53400
53500
53400
53500
53600

CoreLine – Tapered reduction

- ▲ Run-out ≤ 0.002 mm
- ▲ Max. speed 8,000 rpm



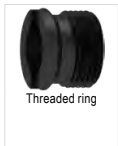
Adapter	BD mm	LPR mm	LB_1 mm
PSC 40	32	70	8
PSC 50	40	85	10
PSC 63	50	110	10
PSC 80	63	120	10

CT
84 625 ...
03295
04094
05093
06386

Spare parts

Adapter

PSC 40
PSC 50
PSC 63
PSC 80



Threaded ring

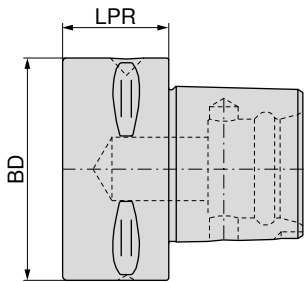
CT
84 950 ...
54200
53900
54000
54100



Clamping screw

CT
84 950 ...
53800
53400
53500
53600

CoreLine – Sealing plug



Adapter	BD mm	LPR mm
PSC 40	40	28
PSC 50	50	28
PSC 63	63	30
PSC 80	80	38

CT
82 317 ...
04095
05094
06393
08086

Accessories



Coolant transfer pipe

→

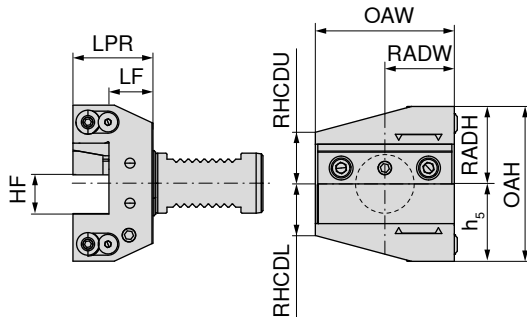


Others

→

CoreLine – Radial square section tool holder – B1 / B2 / B3 / B4

- ▲ Double tooth profile for normal and overhead applications
- ▲ The clamping rails can be attached at the top or bottom (left or right application).
- ▲ For turning tool holders with DirectCooling
- ▲ Can be used up to 100 bar



Double

Adapter	HF 0/-0,1 mm	LF 0/+0,5 mm	LPR mm	OAW mm	RADH mm	RADW mm	h ₅ mm	OAH mm	RHCDL mm	RHCDU mm
VDI 20	16	16	30	55	30	30.0	30	60	22.0	22.0
VDI 20	16	26	40	55	30	30.0	30	60	22.0	22.0
VDI 25	16	16	30	55	30	30.0	30	60	22.5	22.5
VDI 30	20	22	40	70	39	35.0	39	78	26.0	26.0
VDI 40	25	22	44	85	47	42.5	47	94	33.0	33.0
VDI 50	25	22	44	98	55	50.0	55	110	42.0	42.0

CT

82 245 ...

01629

51629

01628

02027

02526

02525

Spare parts Adapter

VDI 20
VDI 25
VDI 30
VDI 40
VDI 50



Screw for nozzle

CX

82 950 ...

31000

31000

31100

31100

31200



O ring

CX

82 950 ...

31400

31400

31500

31500

31600



O ring

CX

82 950 ...

32600

32600

32700

32800

32800



Ball-shaped spray nozzle

CX

82 950 ...

30600

30600

30700

30700

30800



Clamping wedge

CT

82 250 ...

05300

05300

06750

08300

09000

Spare parts Adapter

VDI 20
VDI 25
VDI 30
VDI 40
VDI 50



Cylindrical screw

CX

82 950 ...

32900

32900

33000

33000

33000



Shim

CT

82 250 ...

15300

15300

16750

18300

19000



Clamping wedge screw

CX

82 950 ...

31800

31800



Clamping wedge screw

CX

82 950 ...

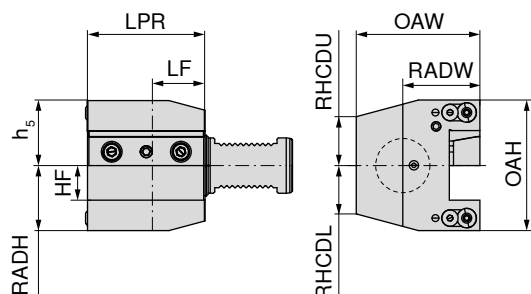
31900

32100

32100

CoreLine – Axial square section tool holder – C1 / C2 / C3 / C4

- ▲ Double tooth profile for normal and overhead applications
- ▲ The clamping rails can be attached at the top or bottom (left or right application).
- ▲ For turning tool holders with DirectCooling
- ▲ Can be used up to 100 bar



Double

Adapter	HF 0/-0,1 mm	LF mm	LPR mm	OAW mm	RADH mm	RADW mm	h _s mm	OAH mm	RHCDL mm	RHCDU mm
VDI 30	20	30	70	74	39	39.0	39	78	26	26
VDI 40	25	30	85	89	47	47.5	47	94	35	35
VDI 50	25	30	85	97	50	55.0	50	100	42	42

CT

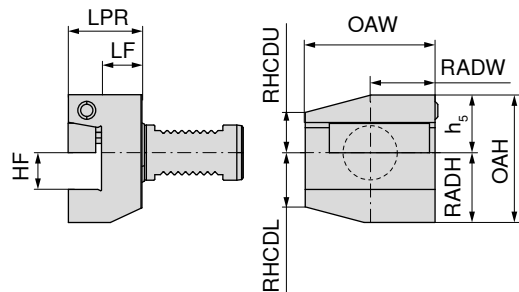
82 246 ...
02027
02526
02525

Spare parts
Adapter

	Cylindrical screw CX 82 950 ...	Shim CT 82 250 ...	Clamping wedge screw CX 82 950 ...	Screw for nozzle CX 82 950 ...	O ring CX 82 950 ...	O ring CX 82 950 ...	Ball-shaped spray nozzle CX 82 950 ...	Clamping wedge CT 82 250 ...
VDI 30	33000	16750	31900	31100	31500	32700	30700	06750
VDI 40	33000	18300	32100	31200	31600	32800	30800	08300
VDI 50	33000	18300	32100	31200	31600	32800	30800	08300

CoreLine – Radial square section tool holder – B1 / B4

- ▲ Double tooth profile for normal and overhead applications
- ▲ For turning tool holders with DirectCooling
- ▲ Can be used up to 100 bar



Double

Adapter	HF _{0/-0,1} mm	LF _{0/+0,5} mm	LPR mm	OAW mm	RADH mm	RADW mm	h ₅ mm	OAH mm	RHCDL mm	RHCDU mm
VDI 30	20	22	40	70.0	38	35.0	31.5	69.5	29.5	22
VDI 40	25	22	44	85.0	48	42.5	38.0	86.0	35.0	30
VDI 50	25	22	44	92.5	48	50.0	43.0	91.0	43.0	30

CT

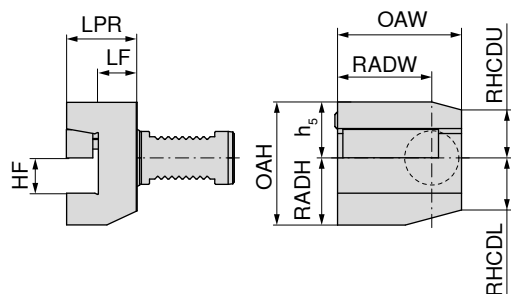
82 247 ...
02027
02526
02525

Spare parts Adapter

	Cylindrical screw	Clamping wedge screw	Screw for nozzle	O ring	Ball-shaped spray nozzle	Clamping wedge
	CX	CX	CX	CX	CX	CT
	82 950 ...	82 950 ...	82 950 ...	82 950 ...	82 950 ...	82 250 ...
VDI 30	33000	32200	31100	31500	30700	05400
VDI 40	33000	32100	31200	31600	30800	06800
VDI 50	33000	32100	31200	31600	30800	06800

CoreLine – Radial square section tool holder – B2 / B3

- ▲ Double tooth profile for normal and overhead applications
- ▲ For turning tool holders with DirectCooling
- ▲ Can be used up to 100 bar



Double

Adapter	HF _{0/-0,1} mm	LF _{0/+0,5} mm	LPR mm	OAW mm	RADH mm	RADW mm	h _s mm	OAH mm	RHCDL mm	RHCDU mm
VDI 30	20	22	40	70.0	38	35.0	31.5	69.5	29.5	27
VDI 40	25	22	44	85.0	48	42.5	38.0	86.0	35.0	30
VDI 50	25	22	44	92.5	48	50.0	43.0	91.0	35.0	38

CT

82 247 ...

12027

12526

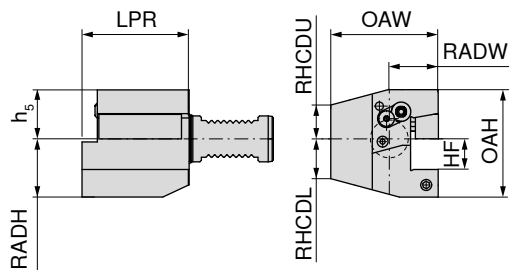
12525

Spare parts Adapter

					
Cylindrical screw	Clamping wedge screw	Screw for nozzle	O ring	Ball-shaped spray nozzle	Clamping wedge
CX	CX	CX	CX	CX	CT
82 950 ...	82 950 ...	82 950 ...	82 950 ...	82 950 ...	82 250 ...
VDI 30	33000	31900	31100	31500	05400
VDI 40	33000	32100	31200	31600	06800
VDI 50	33000	32100	31200	31600	06800

CoreLine – Axial square section tool holder – C1 / C4

- ▲ Double tooth profile for normal and overhead applications
- ▲ For turning tool holders with DirectCooling
- ▲ Can be used up to 100 bar



Double

Adapter	HF _{0/-0,1} mm	LPR mm	OAW mm	RADH mm	RADW mm	h ₅ mm	OAH mm	RHCDL mm	RHCDU mm
VDI 30	20	70	70.0	38	35.0	32	70	26	22
VDI 40	25	85	85.0	48	42.5	38	86	35	30
VDI 50	25	85	90.5	48	48.0	44	92	42	35

CT

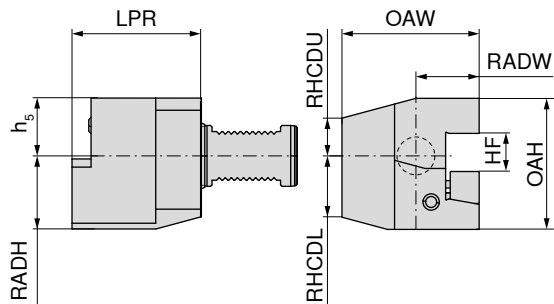
82 248 ...
02027
02526
02525

Spare parts Adapter

					
Cylindrical screw	Clamping wedge screw	Screw for nozzle	O ring	Ball-shaped spray nozzle	Clamping wedge
CX	CX	CX	CX	CX	CT
82 950 ...	82 950 ...	82 950 ...	82 950 ...	82 950 ...	82 250 ...
33000	31900	31100	31500	30700	05400
33000	32100	31200	31600	30800	06800
33000	32100	31200	31600	30800	06800

CoreLine – Axial square section tool holder – C2 / C3

- ▲ Double tooth profile for normal and overhead applications
- ▲ For turning tool holders with DirectCooling
- ▲ Can be used up to 100 bar



Double

Adapter	HF _{0±0,1} mm	LPR mm	OAW mm	RADH mm	RADW mm	h ₅ mm	OAH mm	RHCDL mm	RHCDU mm	CT 82 248 ...
VDI 30	20	70	76	38	41.0	32	70	26	26	12027
VDI 40	25	85	90	48	47.5	38	86	35	30	12526
VDI 50	25	85	95	48	52.5	44	92	42	37	12525

Spare parts Adapter

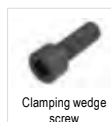
	CX 82 950 ...	CX 82 950 ...	CX 82 950 ...	CX 82 950 ...	CX 82 950 ...	CT 82 250 ...
VDI 30	33000	31900	31100	31500	30700	05400
VDI 40	33000	32100	31200	31600	30800	06800
VDI 50	33000	32100	31200	31600	30800	06800



Cylindrical screw

CX

82 950 ...



Clamping wedge screw

CX

82 950 ...



Screw for nozzle

CX

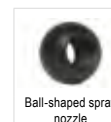
82 950 ...



O ring

CX

82 950 ...



Ball-shaped spray nozzle

CX

82 950 ...



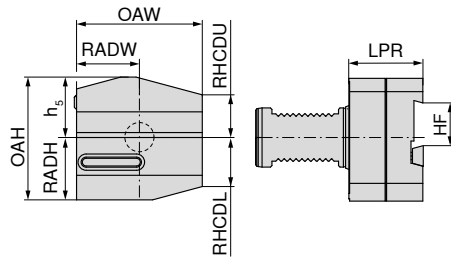
Clamping wedge

CT

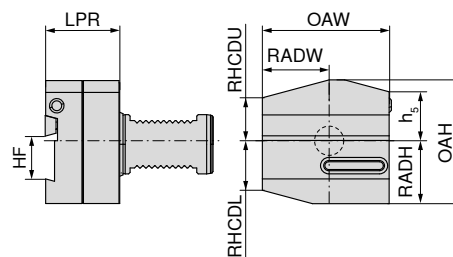
82 250 ...

CoreLine – Parting blade holders for parting blades

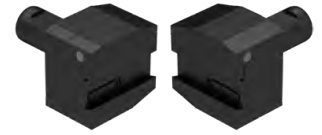
- ▲ Double tooth profile for normal and overhead applications
- ▲ For parting blades with DirectCooling
- ▲ Can be used up to 100 bar



Left



Right



Left



Right

Adapter	HF mm	LPR mm	OAW mm	RADH mm	RADW mm	h ₅ mm	OAH mm	RHCDL mm	RHCDU mm
VDI 30	26	50	70	37	35.0	32	69	30	25
VDI 40	32	50	85	40	42.5	43	83	31	31
VDI 40	26	50	85	40	42.5	43	83	31	31
VDI 50	32	50	100	45	50.0	43	88	37	35

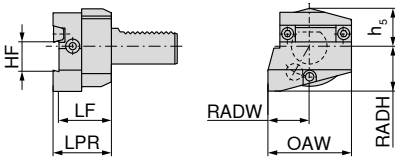
CT	CT
82 249 ... 12627	82 249 ... 02627
13226 12626	03226 02626
13225	03225

Spare parts for article number

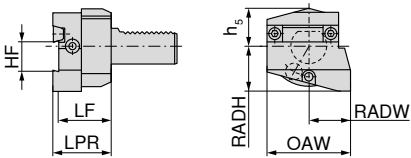
	Cylindrical screw	Clamping wedge screw	Clamping wedge screw	Screw for nozzle	Quad ring	O ring	Ball-shaped spray nozzle	Clamping wedge
	CX	CX	CX	CX	CX	CX	CX	CT
	82 950 ...	82 950 ...	82 950 ...	82 950 ...	82 950 ...	82 950 ...	82 950 ...	82 250 ...
82 249 02627 / 82 249 12627	33000	31800	32100	31300	32400	31700	30900	07000
82 249 03226	33000	31800	32300	31100	32500	31500	30700	08500
82 249 13226	33000	31800	32100	31100	32500	31500	30700	08500
82 249 02626 / 82 249 12626	33000	31800	32300	31100	32400	31500	30700	08500
82 249 03225	33000	31800	32100	31200	32500	31600	30800	10000
82 249 13225	33000	31800	32100	31100	32500	31500	30700	10000

CoreLine – Parting blade holder, height adjustable

- ▲ Vertical adjustment ± 1 mm
- ▲ Suitable for internal cooling through the blade carrier (DC)
- ▲ Axially parallel, adjustable external coolant supply



Left



Right



Left



Right

Adapter	OAW mm	RADW mm	HF mm	h _s mm	RADH mm	LF mm	LPR mm
VDI 30	70	35.0	26	28.0	38	44	49
VDI 30	70	35.0	32	30.5	38	44	49
VDI 40	73	42.5	26	32.0	48	44	49
VDI 40	85	42.5	32	32.0	48	44	49

CX	CX
82 237 ...	82 236 ...
300	300
302	302
040	040
400	400

Spare parts
for article number

82 236 300 / 82 237 300
82 236 400 / 82 237 400



O ring

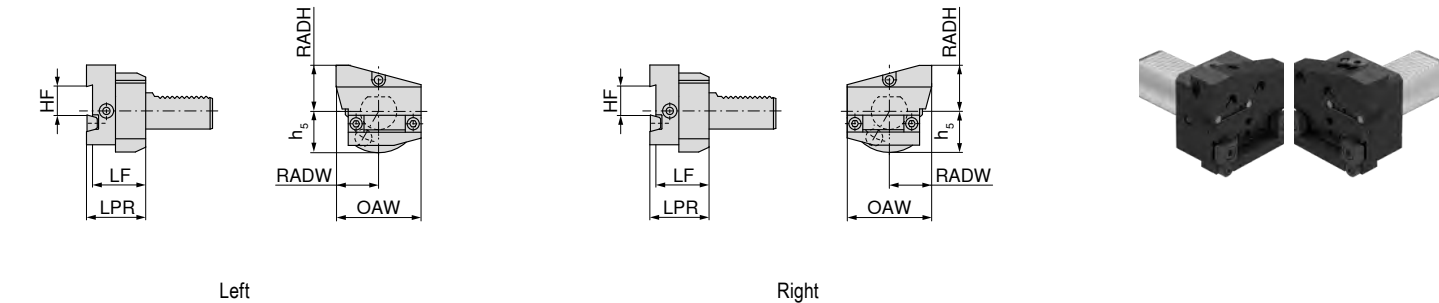
CT

83 950 ...

207
208

CoreLine – Parting blade holder, height adjustable, overhead

- ▲ Vertical adjustment ± 1 mm
- ▲ Suitable for internal cooling through the blade carrier (DC)
- ▲ Axially parallel, adjustable external coolant supply



Left

Right

Adapter	OAW mm	RADW mm	HF mm	h _s mm	RADH mm	LF mm	LPR mm
VDI 30	70	35.0	26	34.0	38	44	49
VDI 30	70	35.0	32	30.5	38	44	49
VDI 40	73	42.5	26	32.0	48	44	49
VDI 40	85	42.5	32	32.0	48	44	49

CX	CX
82 243 ...	82 242 ...
300	300
302	302
040	040
400	400

Spare parts
for article number

82 242 300 / 82 243 300
82 242 400 / 82 243 400



O ring

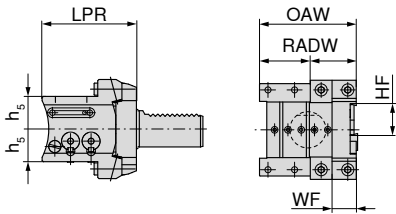
CT

83 950 ...

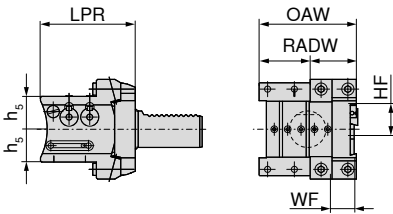
207
208

CoreLine – Parting blade holder, height adjustable

- ▲ Vertical adjustment ± 1 mm
- ▲ Suitable for internal cooling through the blade carrier (DC)
- ▲ Axially parallel, adjustable external coolant supply



Universal – overhead



Universal



Universal – overhead



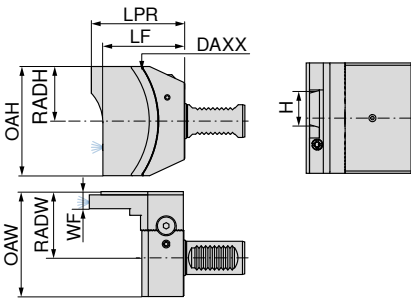
Universal

Adapter	OAW mm	RADW mm	HF mm	h _s mm	WF mm	LPR mm
VDI 30	80	40	26	27	20	78
VDI 40	80	40	26	27	20	88
VDI 40	80	40	32	32	20	88

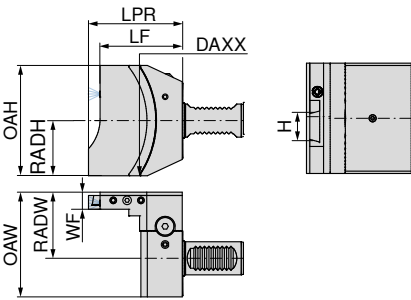
CX	CX
82 244 ...	82 238 ...
300	300
400	400
402	402

CoreLine – Parting blade holders for parting blades

▲ Double = reciprocally interlocked VDI shank



Double – overhead



Double





Double – overhead



Double

Adapter	LPR mm	LF mm	OAH mm	RADH mm	OAW mm	RADW mm	WF mm	DAXX mm	H mm
VDI 20	85.5	75	94	47	85	60	15.5	176	26
VDI 30	85.5	75	100	50	95	60	15.5	176	32
VDI 30	85.5	75	100	50	95	60	15.5	176	26
VDI 40	88.5	78	100	50	95	60	15.5	176	32
VDI 40	88.5	78	100	50	95	60	15.5	176	26

CX

83 227 ...

02629 ¹⁾

03227 ¹⁾

02627 ¹⁾

03226 ¹⁾

02626 ¹⁾

CX

83 226 ...

02629 ¹⁾

03227 ¹⁾

02627 ¹⁾

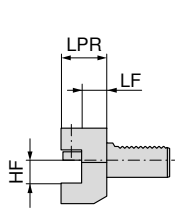
03226 ¹⁾

02626 ¹⁾

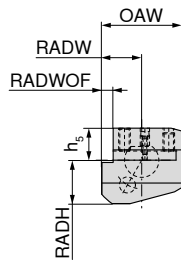
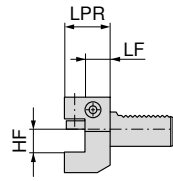
1) Not in stock

With star turrets, there is a risk of collision if the maximum nominal height specified by the machine (LPR) is not observed.

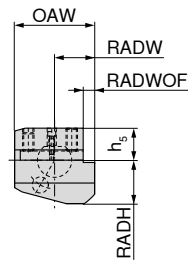
CoreLine – Radial square section tool holder, short



B2



B1



B2

Left

B1

Right

Adapter	HF _{0/-0,1} mm	OAW mm	RADW mm	RADWOF mm	h ₅ mm	RADH mm	LF _{0/+0,5} mm	LPR mm
VDI 16	12	42	23.0	5.0	20.0	22	13.0	24
VDI 20	16	55	30.0	7.0	25.0	30	26.0	40
VDI 20	16	55	30.0	7.0	25.0	30	16.0	30
VDI 20	16	55	30.0	7.0	25.0	30	18.0	30
VDI 20	16	55	30.0	7.0	25.0	30	25.5	40
VDI 30	20	70	35.0	10.0	28.0	38	18.5	40
VDI 30	20	70	35.0	10.0	28.0	38	42.0	60
VDI 30	20	70	35.0	10.0	28.0	35	32.0	50
VDI 40	25	85	42.5	12.5	32.5	48	18.5	44
VDI 50	32	100	50.0	16.0	35.0	60	30.0	55

CX	CX
82 189 ...	82 185 ...
160	160
201	201
200	200
202 ¹⁾	202 ¹⁾
	203 ¹⁾
300	300
301	301
	302 ¹⁾
400	400
500	500

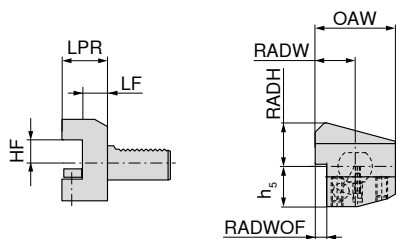
1) Height adjustable +/- 1 mm

Spare parts for article number

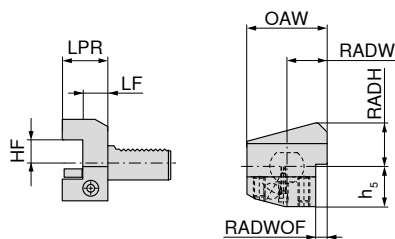
82 185 160 / 82 189 160
82 185 201 / 82 189 201
82 185 200 / 82 189 200
82 185 202
82 189 202
82 185 203
82 185 300 / 82 189 300
82 185 301 / 82 189 301
82 185 302
82 185 400 / 82 189 400
82 185 500 / 82 189 500

Shim	O ring
CT	CT
83 950 ...	83 950 ...
	205
212	206
212	206
212	206
213	206
212	206
214	207
214	207
214	207
218	208
220	209

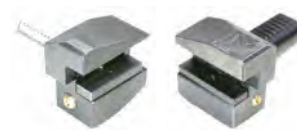
CoreLine – Radial square section tool holder, overhead, short



B4



B3



B4

Left

B3

Right

Adapter	HF _{0/-0,1} mm	OAW mm	RADW mm	RADWOF mm	h ₅ mm	RADH mm	LF _{0/+0,5} mm	LPR mm
VDI 16	12	42	23.0	5.0	20.0	22	13.0	24
VDI 20	16	55	30.0	7.0	25.0	30	26.0	40
VDI 20	16	55	30.0	7.0	25.0	30	18.5	30
VDI 20	16	55	30.0	7.0	25.0	30	26.0	40
VDI 30	20	70	35.0	10.0	35.0	38	18.5	40
VDI 40	25	85	42.5	12.5	42.5	48	18.5	44
VDI 50	32	100	50.0	16.0	50.0	60	30.0	55

CX	CX
82 196 ...	82 193 ...
	160
201	201
202 ¹⁾	202 ¹⁾
203 ¹⁾	203 ¹⁾
300	300
400	400
500	500

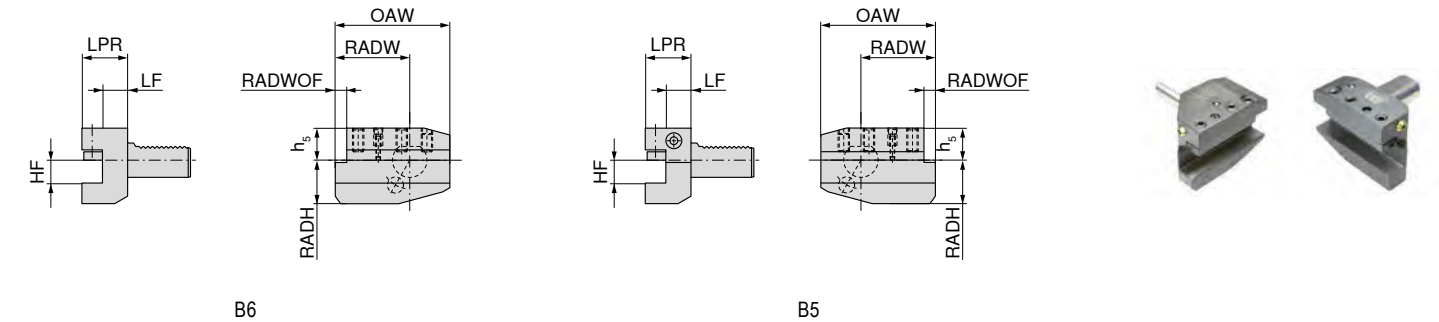
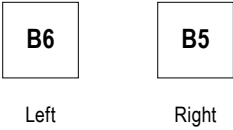
¹⁾ Height adjustable +/- 1 mm

Spare parts for article number

82 193 160
82 193 201 / 82 196 201
82 193 202 / 82 196 202
82 193 203 / 82 196 203
82 193 300 / 82 196 300
82 193 400 / 82 196 400
82 193 500 / 82 196 500

Shim	O ring
CT	CT
83 950 ...	83 950 ...
212	205
212	206
212	206
214	207
218	208
220	209

CoreLine – Radial square section tool holder, long

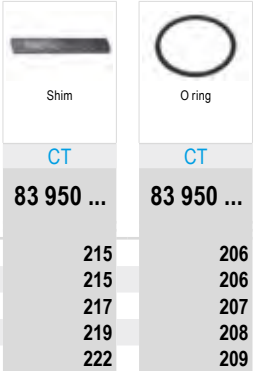


Adapter	HF _{0/-0,1} mm	OAW mm	RADW mm	RADWOF mm	h ₅ mm	RADH mm	LF _{0/+0,5} mm	LPR mm		CX 82 202 ...	CX 82 199 ...
VDI 20	16	75	50.0	7.0	25.0	30	26.0	40		201	201
VDI 20	16	75	50.0	7.0	25.0	30	18.0	30			202 ¹⁾
VDI 30	20	100	65.0	10.0	28.0	38	18.5	40		300	300
VDI 40	25	118	75.5	12.5	32.5	48	18.5	44		400	400
VDI 50	32	130	80.0	16.0	35.0	60	30.0	55		500	500

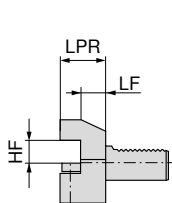
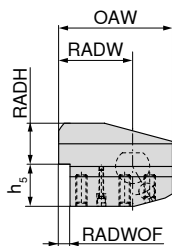
1) Height adjustable +/- 1 mm

Spare parts
for article number

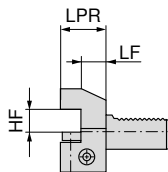
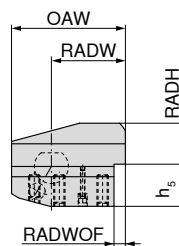
82 199 201 / 82 202 201											
82 199 202											
82 199 300 / 82 202 300											
82 199 400 / 82 202 400											
82 199 500 / 82 202 500											



CoreLine – Radial square section tool holder, overhead, long



B8



B7



B8

B7

Left

Right

Adapter	HF _{0/-0,1} mm	OAW mm	RADW mm	RADWOF mm	h ₅ mm	RADH mm	LF _{0/+0,5} mm	LPR mm
VDI 20	16	75	50.0	7.0	25.0	30	16.0	30
VDI 20	16	75	50.0	7.0	25.0	30	18.0	30
VDI 30	20	100	65.0	10.0	35.0	38	42.0	60
VDI 30	20	100	65.0	10.0	35.0	38	18.5	40
VDI 40	25	118	75.5	12.5	42.5	48	18.5	44
VDI 50	32	130	80.0	16.0	50.0	60	30.0	55

CX	CX
82 208 ...	82 205 ...
200	200
	202 ¹⁾
	301
300	300
400	400
500	500

1) Height adjustable +/- 1 mm

Spare parts for article number

82 205 200 / 82 208 200
82 205 202
82 205 301
82 205 300 / 82 208 300
82 205 400 / 82 208 400
82 205 500 / 82 208 500



Shim



O ring

CT

CT

83 950 ...

83 950 ...

215

206

215

206

217

207

217

207

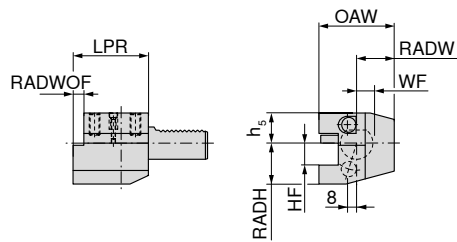
219

208

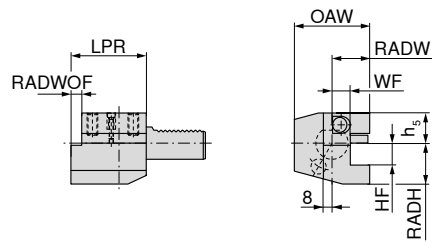
222

209

CoreLine – Axial square section tool holder



C2



C1



C2

Left

C1

Right

Adapter	HF _{0/-0,1} mm	OAW mm	RADW mm	WF _{0/+0,3} mm	h ₅ mm	RADH mm	LPR mm
VDI 16	12	43	24.0	13.0	20.0	22	44
VDI 20	16	65	40.0	25.5	25.0	30	50
VDI 20	16	65	40.0	26.0	25.0	30	50
VDI 30	20	76	41.0	23.0	28.0	38	70
VDI 30	20	70	35.0	17.0	28.0	38	70
VDI 40	25	85	42.5	20.5	32.5	48	85
VDI 40	25	90	47.5	25.5	32.5	48	85
VDI 50	32	105	55.0	30.5	35.0	60	100
VDI 50	32	100	50.0	25.5	35.0	60	100

CX	CX
82 214 ...	82 211 ...
	160
	202 ¹⁾
200	201
300	300
	400
400	
500	500

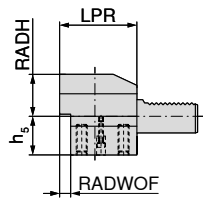
1) Height adjustable +/- 1 mm

Spare parts for article number

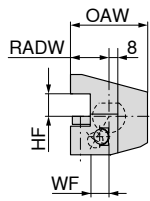
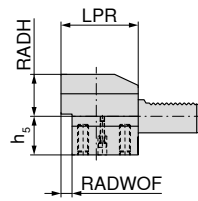
82 211 160
82 211 202
82 211 201 / 82 214 200
82 214 300
82 211 300
82 211 400
82 214 400
82 214 500
82 211 500

	
Shim	O ring
CT	CT
83 950 ...	83 950 ...
	205
210	206
211	206
214	207
214	207
218	208
218	208
220	209
220	209

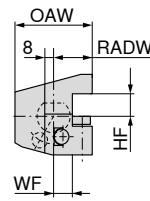
CoreLine – Axial square section tool holder, overhead



C4



C3



C4

C3

Left

Right

Adapter	HF _{0/-0,1} mm	OAW mm	RADW mm	WF _{0/+0,3} mm	h ₅ mm	RADH mm	LPR mm
VDI 16	12	43	24.0	13.0	20.0	22	44
VDI 20	16	65	40.0	25.5	30.0	25	50
VDI 20	16	65	40.0	26.0	25.0	30	50
VDI 20	16	65	40.0	25.5	25.0	30	50
VDI 30	20	70	35.0	17.0	35.0	38	70
VDI 30	20	76	41.0	23.0	35.0	38	70
VDI 40	25	85	42.5	20.5	42.5	48	85
VDI 40	25	90	47.5	25.5	42.5	48	85
VDI 50	32	100	50.0	25.5	50.0	60	100
VDI 50	32	105	55.0	30.5	50.0	60	100

CX	CX
82 220 ...	82 217 ...
	160
	202 ¹⁾
200	201
201 ¹⁾	
	300
300	
	400
400	
	500
500	

1) Height adjustable +/- 1 mm

Spare parts for article number

82 217 160
82 217 202
82 217 201
82 220 200
82 220 201
82 217 300
82 220 300
82 217 400
82 220 400
82 217 500
82 220 500



Shim



O ring

CT

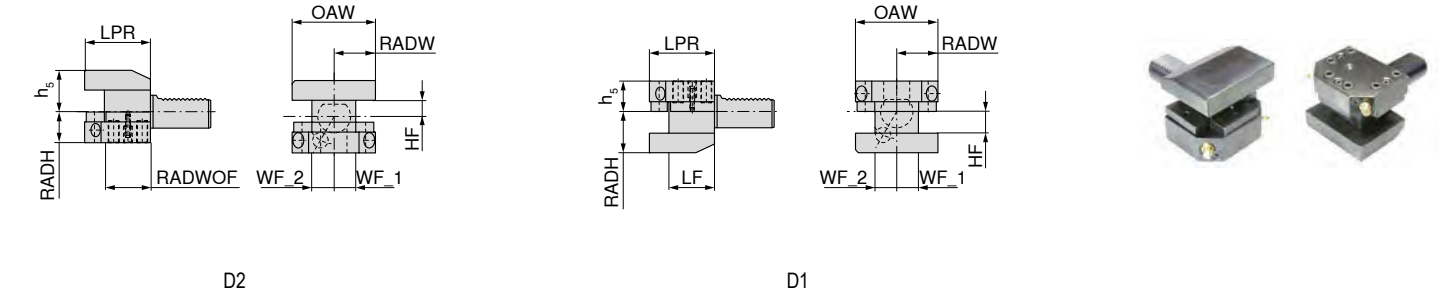
83 950 ...

CT

83 950 ...

205
210 206
211 206
211 206
211 206
214 207
214 207
218 208
218 208
220 209
220 209

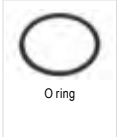
CoreLine – Multi square section tool holders



										<div>D2</div> <div>D1</div>	
										<div>CX</div> <div>CX</div>	
Adapter	HF _{0/-0,1} mm	RADW mm	WF_1 _{0/+0,3} mm	WF_2 _{0/+0,3} mm	OAW mm	h ₅ mm	RADH mm	LF _{0/+0,5} mm	LPR mm	82 224 ...	82 222 ...
VDI 30	20	35.0	17.0	23.0	76	28.0	38	42	60	300	300
VDI 30	20	35.0	17.0	23.0	76	35.0	38	42	60		
VDI 40	25	42.5	20.5	25.5	90	32.5	48	50	72	400	400
VDI 40	25	42.5	20.5	25.5	90	42.5	48	50	72		

Spare parts
for article number

82 222 300	207
82 224 300	207
82 222 400	208
82 224 400	208

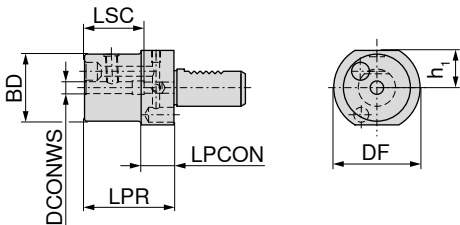
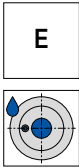


O ring

CT
83 950 ...

CoreLine – Cylindrical tool holders

- ▲ For tools with cylindrical shank to DIN 6535 and DIN 1835 shape E (Whistle Notch)
- ▲ Coolant supply either centrally through the tool or via the adjustable ball-shaped spray nozzles



Coolant nozzle

Adapter	DCONWS	DF	BD	h ₁	LPR	LPCON	LSC
	mm	mm	mm	mm	mm	mm	mm
VDI 20	6	50	45	23.0	60	22	40
VDI 20	8	50	45	23.0	60	22	40
VDI 20	10	50	45	23.0	60	22	44
VDI 20	12	50	45	23.0	60	22	49
VDI 20	14	50	45	23.0	62	22	49
VDI 20	16	50	45	23.0	67	22	52
VDI 20	18	50	45	23.0	67	22	52
VDI 20	20	50	45	23.0	67	22	52
VDI 30	6	68	52	28.0	67	22	35
VDI 30	8	68	52	28.0	67	22	35
VDI 30	10	68	52	28.0	67	22	39
VDI 30	12	68	52	28.0	67	22	44
VDI 30	14	68	52	28.0	67	22	44
VDI 30	16	68	52	28.0	67	22	47
VDI 30	18	68	52	28.0	67	22	47
VDI 30	20	68	52	28.0	67	22	52
VDI 40	6	83	52	32.5	67	22	35
VDI 40	8	83	52	32.5	67	22	35
VDI 40	10	83	52	32.5	67	22	39
VDI 40	12	83	52	32.5	67	22	44
VDI 40	14	83	52	32.5	67	22	44
VDI 40	16	83	52	32.5	67	22	47
VDI 40	18	83	52	32.5	67	22	47
VDI 40	20	83	52	32.5	67	22	52

CX
83 269 ...
206
208
210
212
214
216
218
220
306
308
310
312
314
316
318
320
406
408
410
412
414
416
418
420

Spare parts
Adapter

VDI 20
VDI 30
VDI 40

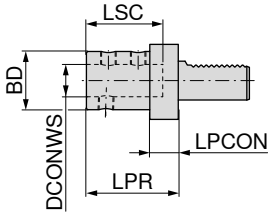
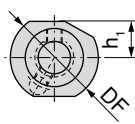


O ring

CT
83 950 ...
206
207
208

CoreLine – Tool holder for indexable insert drills

▲ For drilling tools with internal coolant supply





E1



AD

Adapter	DCONWS <small>H6</small> mm	DF mm	BD mm	h ₁ mm	LPR mm	LPCON mm	LSC mm
VDI 20	16	50	36	23.0	67	18	54
VDI 20	20	50	40	23.0	67	18	54
VDI 20	25	50	45	23.0	71	18	59
VDI 30	16	68	36	28.0	67	22	54
VDI 30	20	68	40	28.0	67	22	54
VDI 30	25	68	45	28.0	71	22	59
VDI 30	32	68	52	28.0	75	22	63
VDI 30	40	68	60	28.0	87	22	73
VDI 40	16	83	36	32.5	67	22	54
VDI 40	20	83	40	32.5	67	22	54
VDI 40	25	83	45	32.5	75	22	59
VDI 40	32	83	52	32.5	75	22	63
VDI 40	40	83	60	32.5	90	22	73
VDI 50	20	98	40	35.0	80	30	54
VDI 50	25	98	45	35.0	80	30	59
VDI 50	32	98	52	35.0	80	30	63
VDI 50	40	98	60	35.0	90	30	73
VDI 50	50	98	70	35.0	100	30	83

CX

82 274 ...

200

201

202

300

301

302

303

304

400

401

402

403

404

500

501

502

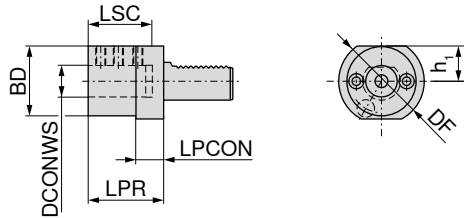
503

504

			
		O ring	Set Screw
		CT	CT
Spare parts for article number		83 950 ...	83 950 ...
82 274 200		206	180
82 274 201		206	180
82 274 202		206	181
82 274 300		207	180
82 274 301		207	180
82 274 302		207	181
82 274 303		207	181
82 274 304		207	182
82 274 400		208	180
82 274 401		208	180
82 274 402		208	181
82 274 403		208	181
82 274 404		208	180
82 274 500		209	180
82 274 501		209	181
82 274 502		209	181
82 274 503		209	182
82 274 504		209	182

CoreLine – Boring bar holder

- ▲ For turning tools with cylindrical shank
- ▲ Coolant supply either centrally through the tool or via the ball-shaped spray nozzle



E2



Coolant nozzle

Adapter	DCONWS _{H7} mm	DF mm	BD mm	h ₁ mm	LPR mm	LPCON mm	LSC mm	
VDI 16	6	40	32	18.0	44	13	34	
VDI 16	8	40	32	18.0	44	13	34	
VDI 16	10	40	32	18.0	44	13	34	
VDI 16	12	40	40	18.0	44	13	34	
VDI 16	16	40	40	18.0	44	13	34	
VDI 20	8	50	40	23.0	50	18	41	
VDI 20	10	50	40	23.0	50	18	41	
VDI 20	12	50	40	23.0	50	18	41	
VDI 20	16	50	40	23.0	50	18	41	
VDI 20	20	50	50	23.0	50	18	41	
VDI 20	25	50	50	23.0	60	18	51	
VDI 30	8	68	55	28.0	60	22	51	
VDI 30	10	68	55	28.0	60	22	51	
VDI 30	12	68	55	28.0	60	22	51	
VDI 30	16	68	55	28.0	60	22	51	
VDI 30	20	68	55	28.0	60	22	51	
VDI 30	25	68	55	28.0	60	22	51	
VDI 30	32	68	68	28.0	75	22	61	
VDI 40	8	83	55	32.5	75	22	61	
VDI 40	10	83	55	32.5	75	22	61	
VDI 40	12	83	55	32.5	75	22	61	
VDI 40	16	83	55	32.5	75	22	61	
VDI 40	20	83	55	32.5	75	22	61	
VDI 40	25	83	55	32.5	75	22	61	
VDI 40	32	83	83	32.5	75	22	61	
VDI 40	40	83	83	32.5	90	22	76	
VDI 50	12	98	68	35.0	90	30	76	
VDI 50	16	98	68	35.0	90	30	76	
VDI 50	20	98	68	35.0	90	30	76	
VDI 50	25	98	68	35.0	90	30	76	
VDI 50	32	98	68	35.0	90	30	76	
VDI 50	40	98	98	35.0	90	30	76	
VDI 50	50	98	98	35.0	100	30	86	

CX

82 268 ...

160¹⁾161¹⁾162¹⁾163¹⁾164¹⁾

200

201

202

203

204

205

300

301

302

303

304

305

306

400

401

402

403

404

405

406

407

500

501

502

503

504

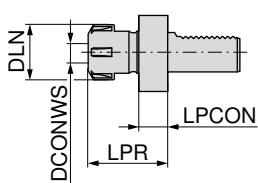
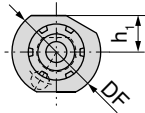
505

506

1) Coolant supply through pipe joint

Spare parts for article number	<div><div> O ring</div><div> Set Screw</div></div>	
	CT	CT
	83 950 ...	83 950 ...
82 268 160	205	
82 268 161	205	461
82 268 162	205	461
82 268 163	205	465
82 268 164	205	465
82 268 200	206	462
82 268 201	206	466
82 268 202	206	466
82 268 203	206	465
82 268 204	206	465
82 268 205	206	464
82 268 300	207	463
82 268 301	207	463
82 268 302	207	467
82 268 303	207	467
82 268 304	207	467
82 268 305	207	466
82 268 306	207	466
82 268 400	208	468
82 268 401	208	468
82 268 402	208	468
82 268 403	208	472
82 268 404	208	471
82 268 405	208	471
82 268 406	208	471
82 268 407	208	470
82 268 500	209	469
82 268 501	209	473
82 268 502	209	477
82 268 503	209	477
82 268 504	209	476
82 268 505	209	476
82 268 506	209	474

CoreLine – ER collet chuck



E4

Adapter	DCONWS mm	DF mm	DLN mm	h ₁ mm	LPR mm	LPCON mm	for collet
VDI 16	1 - 10	40	28	18.0	43.5	14	426E (ER16)
VDI 16	1 - 13	40	34	18.0	44.0	14	428E (ER20)
VDI 20	1 - 16	50	42	23.0	57.0	18	430E (ER25)
VDI 20	2 - 20	50	50	23.0	62.0	18	470E (ER32)
VDI 30	1 - 16	68	42	28.0	57.0	22	430E (ER25)
VDI 30	2 - 20	68	50	28.0	75.0	22	470E (ER32)
VDI 40	1 - 16	83	42	32.5	75.0	22	430E (ER25)
VDI 40	2 - 20	83	50	32.5	75.0	22	470E (ER32)
VDI 40	3 - 26	83	63	32.5	75.0	22	472E (ER40)
VDI 50	2 - 20	94	50	35.0	75.0	30	470E (ER32)
VDI 50	3 - 26	94	63	35.0	63.0	30	472E (ER40)

CX

82 286 ...
160
161
202
203
300
301
400
401
402
500
501

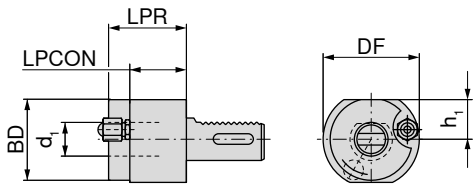
Spare parts
for article number

82 286 160
82 286 161
82 286 202
82 286 203
82 286 300
82 286 301
82 286 400
82 286 401
82 286 402
82 286 500
82 286 501

			
Lock nut SW	Lock nut	Y clamping key	O ring
CT	CT	CX	CT
62 950 ...	62 950 ...	83 357 ...	83 950 ...
044	054	116	205
045	055	12000	205
	055	125	206
	055	132	206
	055	125	207
	055	132	207
	055	125	208
	65700	132	208
	65700	140	208
		132	209
		140	209

CoreLine – Morse taper adapter

▲ For taper shanks with ejector tang



F1

Adapter	d ₁	BD mm	DF mm	h ₁ mm	LPR mm	LPCON mm
VDI 20	MK1		50	23.0	23	
VDI 20	MK2		50	23.0	87	
VDI 30	MK1		68	28.0	27	
VDI 30	MK2		68	28.0	27	
VDI 30	MK3	58	68	28.0	55	40
VDI 40	MK2	55	83	32.5	36	22
VDI 40	MK3	58	83	32.5	36	22
VDI 40	MK4	68	83	32.5	80	22
VDI 50	MK2	55	98	35.0	36	30
VDI 50	MK3	58	98	35.0	36	30
VDI 50	MK4	68	98	35.0	50	30

CX
82 277 ...
200
201
300
301
302
401
402
403
500
501
502

Spare parts
Adapter

VDI 20
VDI 30
VDI 40
VDI 50



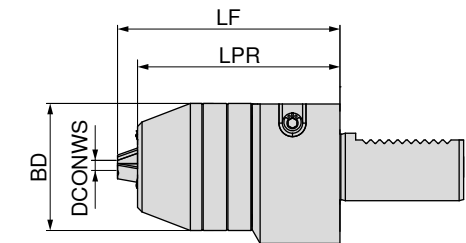
O ring

CT
83 950 ...
206
207
208
209

CoreLine – Short drill chuck – NC 2010

- ▲ Coolant supply via 3 adjustable ball-shaped spray nozzles in the housing
- ▲ Independent of direction of rotation

Scope of supply:
Base body including clamping key SW 4



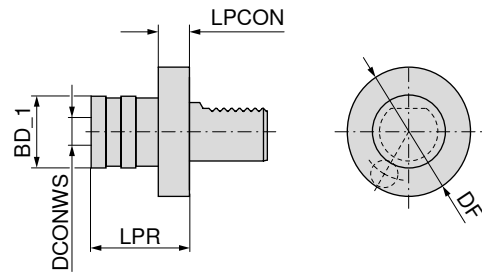
Adapter	DCONWS mm	BD mm	LPR mm	LF mm
VDI 20	0,5 - 10	48.5	40	50
VDI 30	0,5 - 13	56.5	90	99
VDI 30	2,5 - 16	56.5	90	99
VDI 40	0,5 - 13	56.5	90	99
VDI 40	2,5 - 16	56.5	90	99

CX
84 297 ...
210 ¹⁾
313
316
413
416

1) Without through coolant supply

CoreLine – Quick change tapping chuck GSF

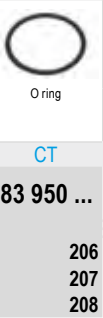
▲ LZD = Length compensation under tension and compression



							CT	
Adapter	Cutting range	SZID	DCONWS mm	BD_1 mm	LPR mm	LZD± mm	83 307 ...	
VDI 20	M3 - M12	01	19	38	55	9	112	
VDI 30	M3 - M12	01	19	38	55	9	312	
VDI 40	M3 - M12	01	19	38	55	9	412	
VDI 20	M6 - M20	02	31	55	77	15	120	
VDI 30	M6 - M20	02	31	55	77	15	320	
VDI 40	M6 - M20	02	31	55	77	15	420	

Spare parts
Adapter

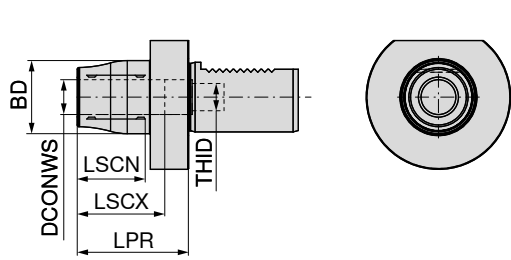
VDI 20	206
VDI 30	207
VDI 40	208



CoreLine – Hydraulic chuck – Turn

- ▲ Hydraulic chuck
- ▲ For the hydraulic clamping of cylindrical tool shanks tol. h6, boring bars, and cylindrical tool holders tol. h7, g6 in fixed base holders
- ▲ One screw for locking the boring bar
- ▲ High-precision clamping with a repeatability of 3 µm

Scope of supply:
Base body with stop screw and pressure screw



AD

Adapter	DCONWS mm	BD mm	LPR mm	LSCX mm	LSCN mm	THID
VDI 30	20	42	64	51	41	M16x1
VDI 40	20	42	64	51	41	M16x1

CT

83 402 ...

02027
02026

Spare parts
DCONWS



Backstop screw with
internal cooling

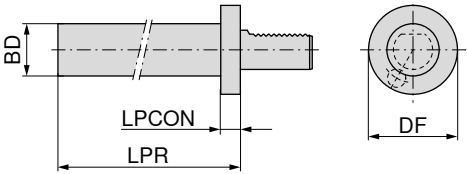
CT

83 950 ...

48700

CoreLine – Test arbor

▲ Radial run-out accuracy ≤ 0.02 mm



Adapter	BD _{h5} mm	DF mm	LPR mm	LPCON mm
VDI 16	30	40	120	15
VDI 20	40	50	150	15
VDI 30	40	68	200	15
VDI 40	40	83	200	15
VDI 50	40	98	200	15

CX

83 324 ...

016

020

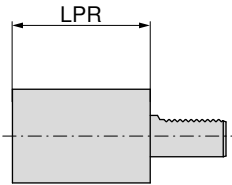
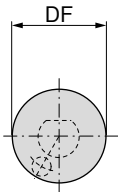
030

040

050

CoreLine – Blank

▲ Manufactured from C45



A2

Adapter	LPR mm	DF mm
VDI 16	60	40
VDI 20	70	50
VDI 30	100	68
VDI 30	240	68
VDI 40	120	83
VDI 40	320	83
VDI 50	135	98
VDI 50	400	98

CX
82 330 ...
160
200
300
303
400
403
500
502

Spare parts
Adapter

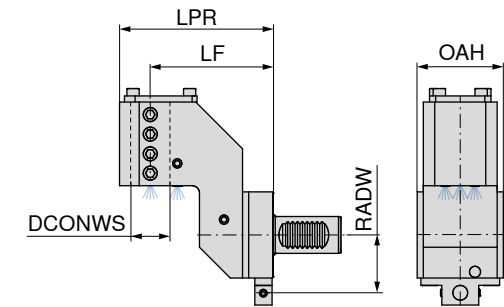
VDI 16
VDI 20
VDI 30
VDI 40
VDI 50



CT
83 950 ...
205
206
207
208
209

CoreLine – Boring bar holder, with offset, with through coolant supply

- ▲ Double = reciprocally interlocked VDI shank
- ▲ External coolant supply available



Through coolant
Double

Adapter	DCONWS mm	LPR mm	LF mm	OAH mm	RADW mm
VDI 25	25	99.5	75	30	40
VDI 30	32	125.0	100	70	47
VDI 40	40	133.0	100	85	56

CX
83 229 ...
02528 ¹⁾
03227 ¹⁾
04026 ¹⁾

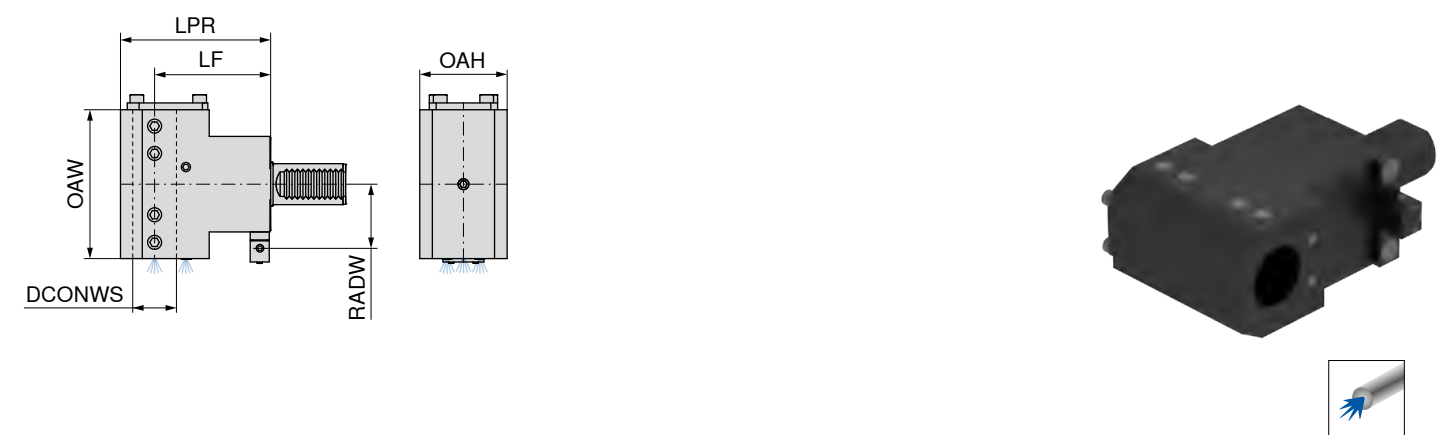
1) Not in stock



With star turrets, there is a risk of collision if the maximum nominal height specified by the machine (LPR) is not observed.

CoreLine – Double boring bar holder with through coolant supply

- ▲ For use of two boring bars for main and sub-spindle machining
- ▲ External coolant supply available



Adapter	DCONWS mm	LPR mm	LF mm	OAH mm	RADW mm	OAW mm
VDI 25	25	99.5	75	54	40	104
VDI 30	32	110.0	85	62	47	109
VDI 30	32	125.0	100	62	47	118
VDI 40	40	152.0	120	76	56	116

CX

83 230 ...

02528 ¹⁾

03227 ¹⁾

13227 ¹⁾

04026 ¹⁾

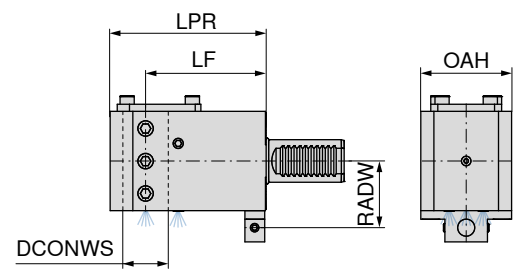
1) Not in stock



With star turrets, there is a risk of collision if the maximum nominal height specified by the machine (LPR) is not observed.

CoreLine – Boring bar holder with through coolant supply

▲ External coolant supply available



Through coolant

Adapter	DCONWS mm	LPR mm	LF mm	OAH mm	RADW mm
VDI 25	25	100	75	60	40
VDI 30	32	110	85	64	47
VDI 30	32	125	100	64	47
VDI 40	40	130	100	76	56
VDI 40	40	152	120	76	56
VDI 50	50	155	120	98	64

CX
83 228 ...
02528 ¹⁾
03227 ¹⁾
13227 ¹⁾
04026 ¹⁾
14026 ¹⁾
05025 ¹⁾

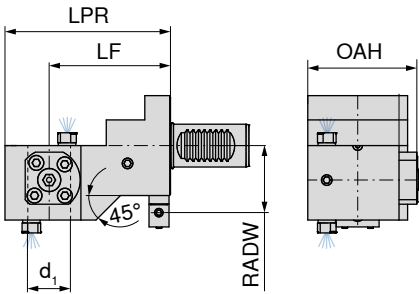
1) Not in stock



With star turrets, there is a risk of collision if the maximum nominal height specified by the machine (LPR) is not observed.

CoreLine – 90° VDI to VDI adapter, double sided

▲ For rotating tool holder



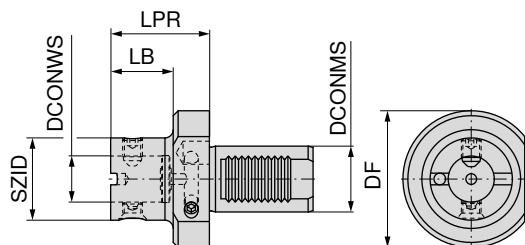
Through coolant

Adapter	DCONWS mm	LPR mm	LF mm	OAH mm	RADW mm
VDI 25	25	104	75	38.0	40
VDI 25	20	104	75	67.5	40
VDI 30	30	116	85	76.5	47
VDI 30	30	131	100	76.5	47
VDI 40	40	133	100	89.0	56
VDI 40	40	153	120	89.0	56

CX
83 225 ...
02528 ¹⁾
02028 ¹⁾
03027 ¹⁾
13027 ¹⁾
04026 ¹⁾
14026 ¹⁾

1) Not in stock

HyPower – VDI adapter – ABS N

ABS N


AD

CT

Adapter	SZID	DCONWS mm	DCONMS mm	LB mm	LPR mm	DF mm
VDI 30	ABS 50 N	28	30	38	60	68
VDI 40	ABS 63 N	34	40	48	70	83
VDI 40	ABS 50 N	28	40	38	60	83
VDI 40	ABS 80 N	46	40	53	75	83
VDI 50	ABS 80 N	46	50	45	75	98
VDI 50	ABS 50 N	28	50	35	65	98
VDI 50	ABS 63 N	34	50	45	75	98
VDI 60	ABS 50 N	28	60	35	65	123
VDI 60	ABS 63 N	34	60	45	75	123
VDI 60	ABS 80 N	46	60	45	75	123
VDI 60	ABS 100 N	56	60	60	90	123

84 231 ...

25027

26326

25026

28026

28025

25025

26325

25024

26324

28024

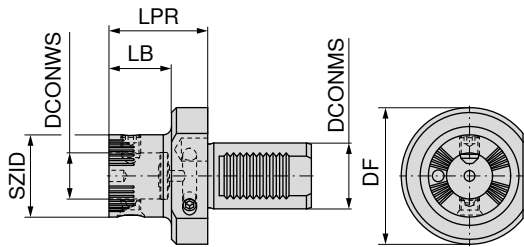
30024

**Spare parts
SZID**

Clamping screw	Set	Positioning pin	Positioning pin	Taper screw	Sealing disc – ABS
CT	CT	CT	CT	CT	CT
84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...
20300	99800	31800	20200	20400	30700
25500	99400	31900	23900	27300	30800
25600	99300	32000	24000	25100	30900
25700	99200	32100	24100	25200	31000

HyPower – VDI torsional vibration damper – ABS N

ABS N



AD

Adapter	SZID	DCONWS	DCONMS	LB	LPR	DF
VDI 40	ABS 50	28 mm	40 mm	38 mm	60 mm	83 mm

CT

84 231 ...

55026

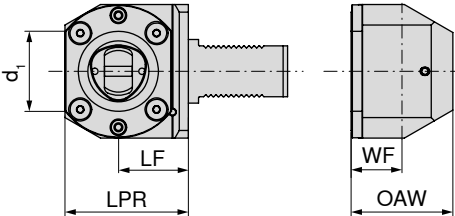
Spare parts
SZID

ABS 50

			
Clamping screw	Set	Taper screw	Sealing disc – ABS
CT	CT	CT	CT
84 950 ...	84 950 ...	84 950 ...	84 950 ...
20300	99800	20400	30700

CoreLine – 90° VDI to PSC adapter

Scope of supply:
Including pull stud



90°

Adapter	d ₁	LF mm	LPR mm	WF mm	OAW mm
VDI 30	PSC 40	41	65	21	56
VDI 40	PSC 40	51	75	30	86
VDI 40	PSC 50	53	85	40	80
VDI 40	PSC 63	53	95	40	80
VDI 50	PSC 50	53	85	40	80
VDI 50	PSC 63	55	97	40	80

CX
83 231 ...
04027 ¹⁾
04026 ¹⁾
05026 ¹⁾
06326 ¹⁾
05025 ¹⁾
06325 ¹⁾

1) Not in stock

Accessories

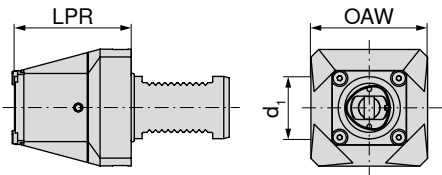


Pull stud PSC



CoreLine – VDI to PSC adapter

Scope of supply:
Including pull stud



Adapter	d ₁	LPR mm	OAW mm	<div>CX</div> <div>83 232 ...</div> <div>04027 ¹⁾</div> <div>04026 ¹⁾</div> <div>05026 ¹⁾</div> <div>06326 ¹⁾</div> <div>05025 ¹⁾</div> <div>06325 ¹⁾</div>
VDI 30	PSC 40	70	60	
VDI 40	PSC 40	75	75	
VDI 40	PSC 50	85	82	
VDI 40	PSC 63	90	105	
VDI 50	PSC 50	85	91	
VDI 50	PSC 63	100	105	

1) Not in stock

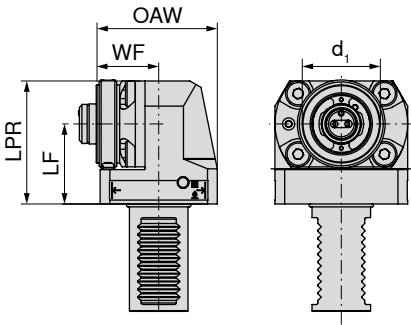
Accessories



Pull stud PSC



CoreLine – 90° VDI to HSK-T adapter



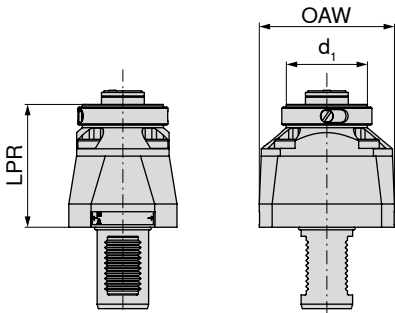
90°

Adapter	d ₁	LF mm	LPR mm	WF mm	OAW mm
VDI 30	HSK-T 40	41	65	25	60
VDI 40	HSK-T 40	51	75	34	90
VDI 40	HSK-T 63	53	90	45	85
VDI 50	HSK-T 63	55	97	45	85

CX
83 233 ...
04027 ¹⁾
04026 ¹⁾
06326 ¹⁾
06325 ¹⁾

1) Not in stock

CoreLine – VDI to HSK-T adapter

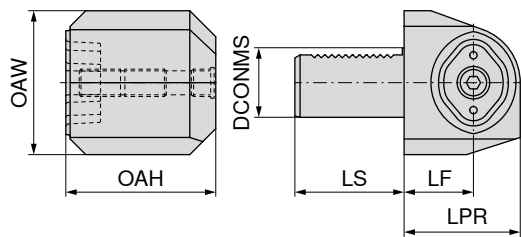


Adapter	d ₁	LPR mm	OAW mm
VDI 30	HSK-T 40	74	60
VDI 40	HSK-T 40	79	75
VDI 40	HSK-T 63	95	105
VDI 50	HSK-T 63	105	105

CX
83 234 ...
04027 ¹⁾
04026 ¹⁾
06326 ¹⁾
06325 ¹⁾

¹⁾ Not in stock

HyPower – 90° VDI to OC50 adapter – OvalFlex



YES
ER

Adapter	d ₁	DCONMS mm	LF mm	OAH mm	LS mm	LPR mm	OAW mm
VDI 40	OC50	40	40	86.5	63	67	83
VDI 40	OC50	40	150	86.5	63	177	83
VDI 50	OC50	50	50	104.0	78	77	98
VDI 50	OC50	50	150	104.0	78	177	98

CT
74 592 ...
04026
15026
05025
15025

Spare parts
Adapter

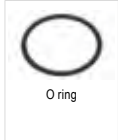
VDI 40	M16x65 - SW8	90900	4,3x2,4	90700	303
VDI 50	M16x65 - SW8	90900	4,3x2,4	90700	303



Power screw

AS

70 950 ...



O ring

AS

70 950 ...



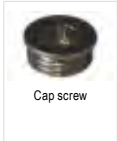
Molykote

AS

70 950 ...

Spare parts
Adapter

VDI 40	M16x7,5x1,5 - SW8	91000	SW8	188
VDI 50	M16x7,5x1,5 - SW8	91000	SW8	188



Cap screw

AS

70 950 ...

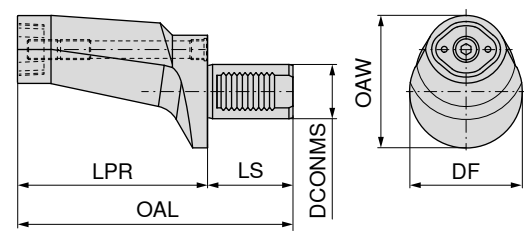


Hexagonal key

AS

80 950 ...

HyPower – VDI to OC50 adapter – OvalFlex



YES
IL

Adapter	d ₁	DCONMS mm	DF mm	LF mm	OAL mm	LS mm	LPR mm	OAW mm	CT 74 593 ... 14126	
VDI 40	OC50	40	83	140	203	63	140	97.5		

Spare parts
Adapter

VDI 40	M16x65 - SW8	90900	4,3x2,4	90700	303
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Power screw

AS

70 950 ...



O ring

AS

70 950 ...



Molykote

AS

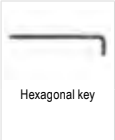
70 950 ...



Cap screw

AS

70 950 ...



Hexagonal key

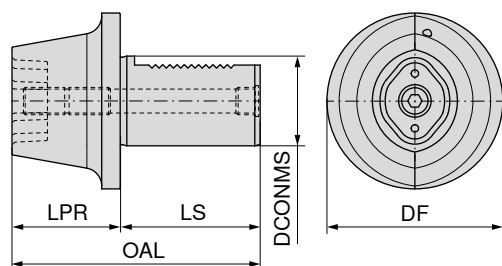
AS

80 950 ...

Spare parts
Adapter

VDI 40	M16x7,5x1,5 - SW8	91000	SW8	188
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HyPower – VDI to OC50 adapter – OvalFlex



YES

IN

Adapter	d ₁	DCONMS mm	DF mm	LF mm	OAL mm	LS mm	LPR mm
VDI 40	OC50	40	83	60	123	63	60
VDI 40	OC50	40	83	110	173	63	110
VDI 40	OC50	40	83	140	203	63	140
VDI 40	OC50	40	83	175	238	63	175
VDI 50	OC50	50	98	60	138	78	60
VDI 50	OC50	50	98	130	208	78	130
VDI 50	OC50	50	98	170	248	78	170
VDI 50	OC50	50	98	210	288	78	210

CT

74 593 ...

06026

11026

14026

17526

06025

13025

17025

21025

Spare parts Adapter

	Power screw	O ring	Molykote
VDI 40	M16x65 - SW8	4,3x2,4	303
VDI 40	M16x65 - SW8	4,3x2,4	303
VDI 50	M16x65 - SW8	4,3x2,4	303



Power screw

AS

70 950 ...

90900

90900

90900



O ring

AS

70 950 ...

90700

90700

90700



Molykote

AS

70 950 ...

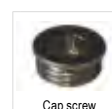
303

303

303

Spare parts Adapter

	Cap screw	Hexagonal key
VDI 40	M16x7,5x1,5 - SW8	SW8
VDI 40	M16x7,5x1,5 - SW8	SW8
VDI 50	M16x7,5x1,5 - SW8	SW8



Cap screw

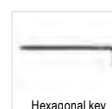
AS

70 950 ...

91000

91000

91000



Hexagonal key

AS

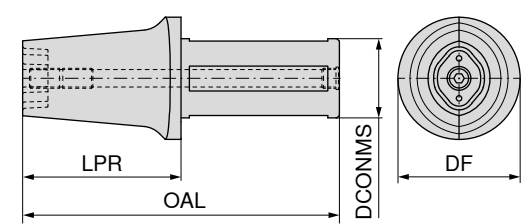
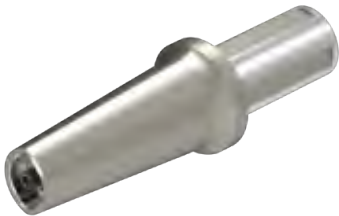
80 950 ...

188

188

188

HyPower – Base holder with cylindrical shank – OvalFlex



YES

Adapter	d ₁	DCONMS mm	LF mm	OAL mm	LPR mm
2,500 "	OC50	63.5	127.0	254.0	127.0
2,500 "	OC50	63.5	203.2	330.2	203.2

CT
78 593 ...
12799
20399

CoreLine – Bar puller for disc turrets, radial

- ▲ Two adjustable, spring-mounted, replaceable grippers are fitted to the base body. Each of these is equipped with a carbide insert. The grippers are set to a slightly smaller diameter than the bar and then pressed onto the bar in an axial direction (x axis) by the tool turret.
- ▲ GA = Gripper set

Scope of supply:

Bar puller incl. GA 1 for VDI 16, and GA 3 from VDI 20



Adapter	DCONWS mm	LF mm	OAH mm	RADW mm	GA
VDI 16	2 - 22	28	74	35	1
VDI 20	2 - 42	34	85	61	3
VDI 30	2 - 42	34	105	61	3 - 4
VDI 40	2 - 65	34	125	61	3 - 4

Left

CX

80 309 ...

03000

04000

Right

CX

80 306 ...

01600

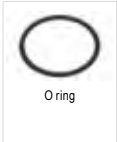
02000

03000

04000

Spare parts
for article number

80 306 01600	205
80 306 02000	205
80 306 03000	205
80 309 03000	207
80 306 04000	205
80 309 04000	208

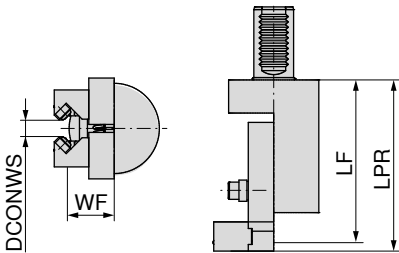


CT
83 950 ...
205
205
205
207
205
208

CoreLine – Bar pullers for star turrets

- ▲ Two adjustable, spring-mounted, replaceable grippers are fitted to the base body. Each of these is equipped with a carbide insert. The grippers are set to a slightly smaller diameter than the bar and then pressed onto the bar in an axial direction (x axis) by the tool turret.
- ▲ 90° angle head
- ▲ GA = Gripper set

Scope of supply:
Bar puller with GA 3



Left

Adapter	DCONWS mm	LF mm	LPR mm	WF mm	GA	CX 80 310 ... 03000 04000
VDI 30	2 - 42	122.5	129	37.0	3 - 4	
VDI 40	2 - 65	142.5	149	41.5	3 - 4	

Spare parts
for article number

80 310 03000	207
80 310 04000	208

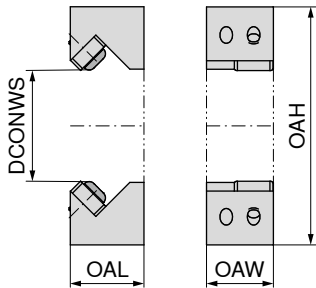


O ring

CT
83 950 ...

Gripper accessories

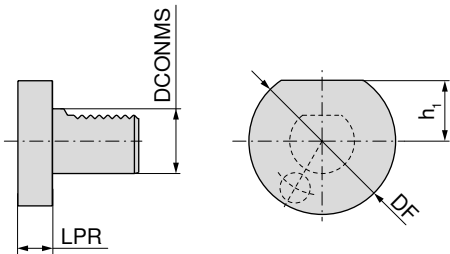
- ▲ For bar pullers 80 306 ... / 80 309 ... / 80 310 ...
- ▲ Price per pair
- ▲ Use replacement insert ISO SNMA 1204..



GA	DCONWS mm	OAL mm	OAW mm	OAH mm
1	2 - 22	24.5	13	58
3	2 - 42	26.0	22	86
4	42 - 65	29.5	22	102

CT
80 312 ...
12200
14200
16500

CoreLine – Sealing plugs



Plastic



Z2

Steel

Z2

Plastic

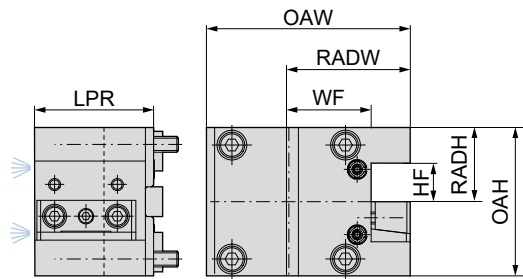
DCONMS _{h8} mm	DF mm	h ₁ mm	LPR mm
16	40	18.0	16
20	50	23.0	16
30	68	28.0	16
40	83	32.5	20
50	98	35.0	20

CX
82 317 ...
160
200
300
400
500

CX
83 318 ...
160
200
300
400
500

CoreLine – Doosan/Spinner – BMT 45 – Axial square section tool holder

▲ Directly screwed version



Left

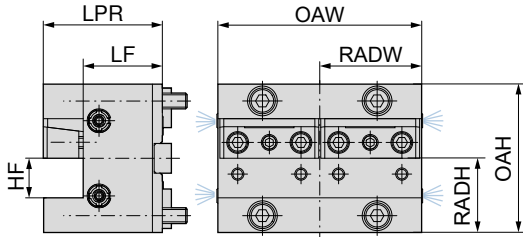
Left

Adapter	Hole pattern	HF mm	WF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 45	58 x 58	20	42	60	75	37.5	99.5	62

CT	CT
82 480 ... 00001	82 480 ... 00006

CoreLine – Doosan/Spinner – BMT 45 – Radial square section tool holder

▲ Directly screwed version



Left

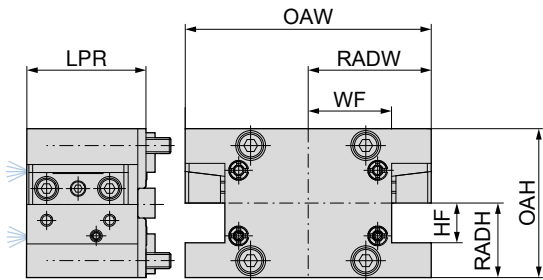
Left

Adapter	Hole pattern	HF mm	LF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 45	58 x 58	20	40	60	75	37.5	103	51.5
BMT 45	58 x 58	20	40	60	75	37.5	80	40.0

CT	CT
82 480 ... 01002	82 480 ... 01007

CoreLine – Doosan/Spinner – BMT 45 – Multi square section tool holder

▲ Directly screwed version

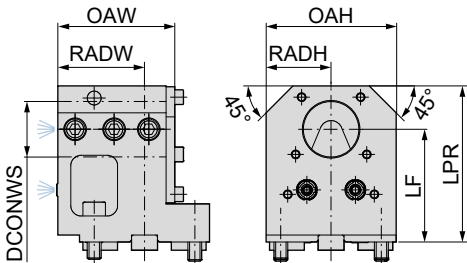


Adapter	Hole pattern	HF mm	WF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 45	58 x 58	20	42	60	75	37.5	124	62

CT	CT
82 480 ... 02003	82 480 ... 02008

CoreLine – Doosan – BMT 45 – Combi tool holder

▲ Directly screwed version



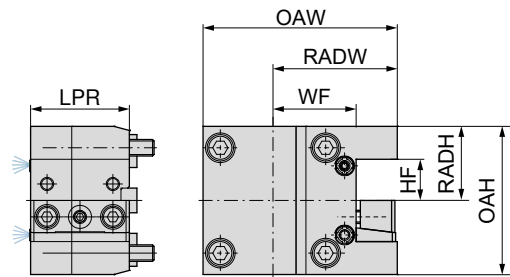
Through coolant

Adapter	Hole pattern	DCONWS mm	LF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 45	58 x 58	32	65	90	75	37.5	67.5	50
BMT 45	58 x 58	32	85	110	75	37.5	67.5	50

CT
82 480 ... 03004 03005

CoreLine – Doosan – BMT 55 – Axial square section tool holder

▲ Directly screwed version



Left

Left

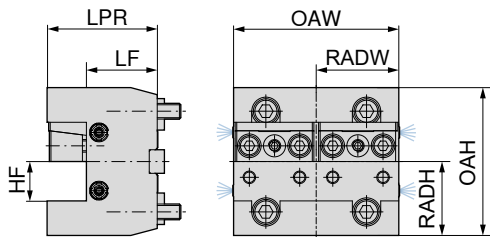
Adapter	Hole pattern	HF mm	WF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 55	64 x 64	25	50.5	60	90	45	118	75.5

CT
82 481 ...
00001

CT
82 481 ...
00005

CoreLine – Doosan – BMT 55 – Radial square section tool holder

▲ Directly screwed version



Left

Left

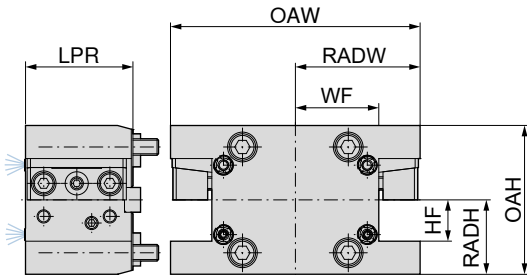
Adapter	Hole pattern	HF mm	LF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 55	64 x 64	25	45	70	94	47	105	52.5
BMT 55	64 x 64	25	70	95	94	47	105	52.5

CT
82 481 ...
01002

CT
82 481 ...
01006

CoreLine – Doosan – BMT 55 – Multi square section tool holder

▲ Directly screwed version

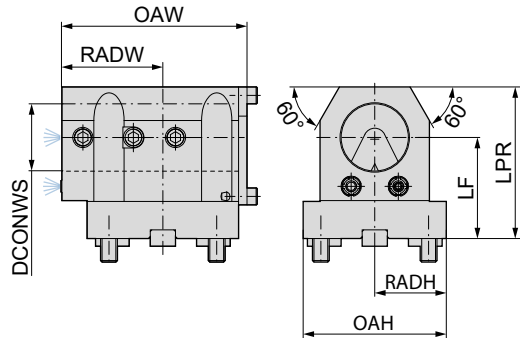


Adapter	Hole pattern	HF mm	WF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 55	64 x 64	25	50.5	65	90	45	151	75.5
BMT 55	64 x 64	25	50.5	60	90	45	151	75.5

CT	CT
82 481 ... 02003	82 481 ... 02007

CoreLine – Doosan – BMT 55 – Boring bar holder

▲ Directly screwed version



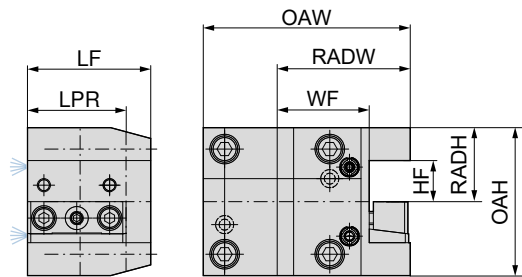
Through coolant

Adapter	Hole pattern	DCONWS mm	LF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT55	64 x 64	40	60	90	85	42.5	110	60

CT
82 481 ... 04004

CoreLine – EMAG – BMT 55 – Axial square section tool holder

▲ Directly screwed version



Left

Left

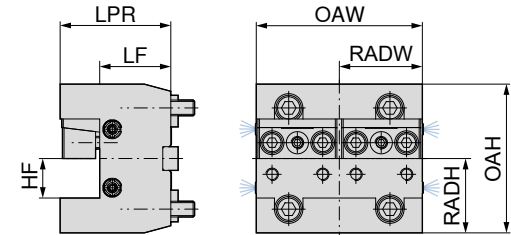
Adapter	Hole pattern	HF mm	LF mm	WF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 55	64 X 64	25	75	56	60	90	45	126	81

CT
82 482 ...
00001

CT
82 482 ...
00004

CoreLine – EMAG – BMT 55 – Radial square section tool holder

▲ Directly screwed version



Through coolant

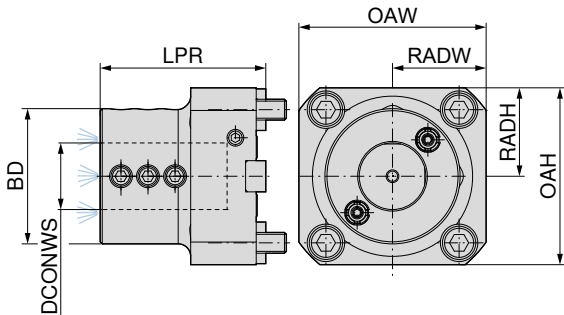
Left

Adapter	Hole pattern	HF mm	LF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 55	64 x 64	25	45	70	94	47	105	52.5

CT
82 482 ...
01002

CoreLine – EMAG – BMT 55 – Boring bar holder

▲ Directly screwed version



Through coolant

Adapter	Hole pattern	DCONWS mm	BD mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT55	64 x 64	32	65	75	90	45	85	42.5

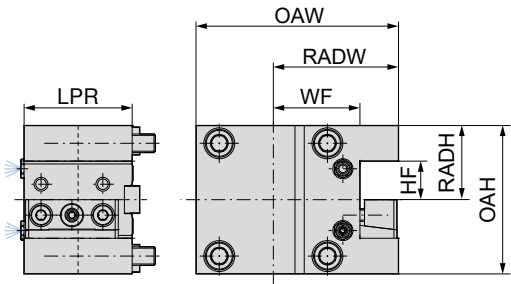
CT

82 482 ...

04003

CoreLine – HAAS/Doosan – BMT 65 – axial square section tool holder

▲ Directly screwed version



Left

Left

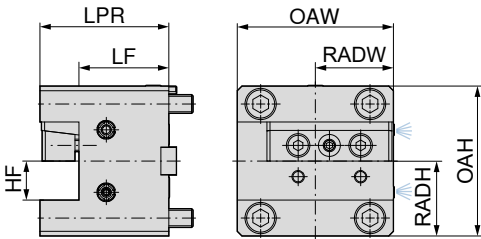
Adapter	Hole pattern	HF mm	WF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 65	70 x 73	25	56	75	97	48.5	131	81

CT
82 483 ...
00008

CT
82 483 ...
00005

CoreLine – HAAS/Doosan – BMT 65 – Radial square section tool holder

▲ Directly screwed version



Right

Right

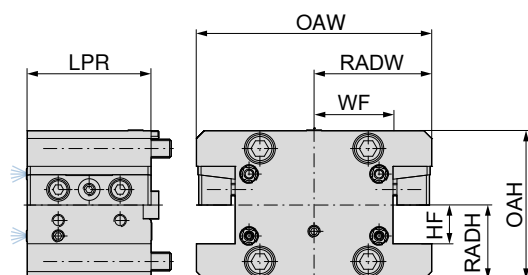
Adapter	Hole pattern	HF mm	LF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 65	70 x 73	25	57.5	82.5	96	48	100	50

CT
82 483 ...
05002

CT
82 483 ...
05006

CoreLine – HAAS/Doosan – BMT 65 – Multi square section tool holder

- ▲ Directly screwed version
- ▲ For right and left direction of rotation

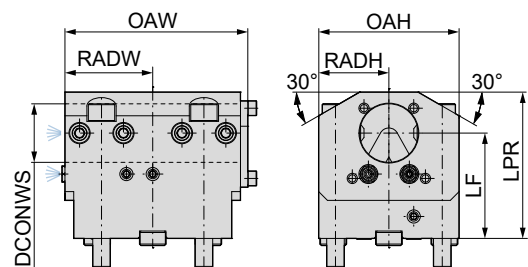


Adapter	Hole pattern	HF mm	WF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 65	70 x 73	25	51	80	96	48	152	76

CT	CT
82 483 ... 02003	82 483 ... 02007

CoreLine – HAAS/Doosan – BMT 65 – combi tool holder

- ▲ Directly screwed version
- ▲ Double-sided version



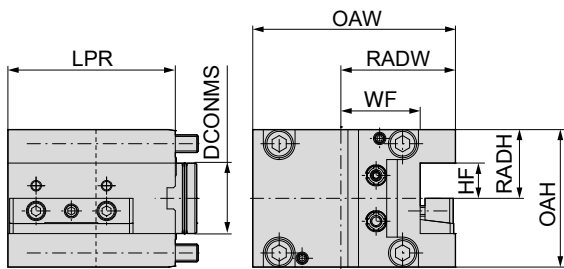
Through coolant

Adapter	Hole pattern	DCONWS mm	LF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 65	70 x 73	40	72	106	96	48	132	77

CT
82 483 ... 03009

CoreLine – Mori/Seiki – BMT 40 – Axial square section tool holder

- ▲ Directly screwed version
- ▲ For right and left direction of rotation



Left

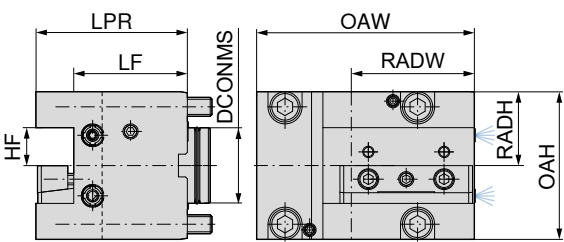
Left

Adapter	Hole pattern	DCONMS mm	HF mm	WF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 40	70 x 62	40	20	45	95	78	39	115	65

CT	CT
82 484 ... 00001	82 484 ... 00005

CoreLine – Mori/Seiki – BMT 40 – Radial square section tool holder

- ▲ Directly screwed version
- ▲ For right and left direction of rotation



Left

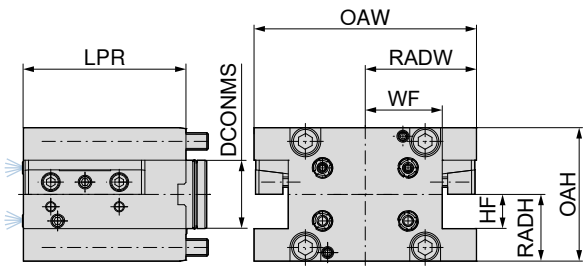
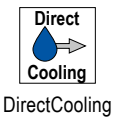
Left

Adapter	Hole pattern	DCONMS mm	HF mm	LF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 40	70 x 62	40	20	60	80	78	39	115	65

CT	CT
82 484 ... 01002	82 484 ... 01006

CoreLine – Mori/Seiki – BMT 40 – Multi square section tool holder

- ▲ Directly screwed version
- ▲ For right and left direction of rotation



DirectCooling

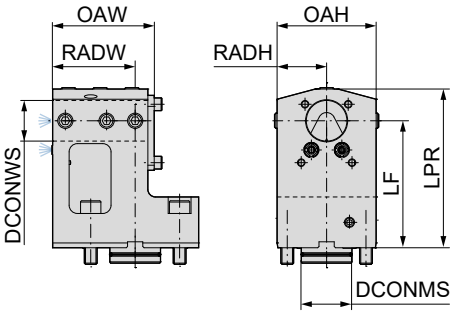
Adapter	Hole pattern	DCONMS	HF	WF	LPR	OAH	RADH	OAW	RADW
BMT 40	70 x 62	40	20	45	95	78	39	130	65

CT
82 484 ...
02003

CT
82 484 ...
02007

CoreLine – Mori/Seiki – BMT 40 – Combi tool holder

- ▲ Directly screwed version

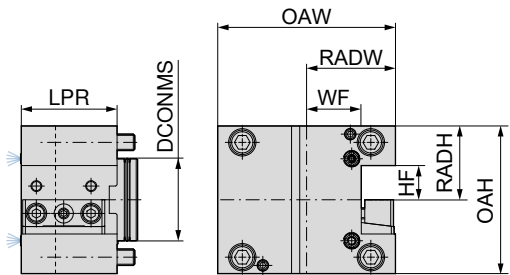


Adapter	Hole pattern	DCONMS	DCONWS	LF	LPR	OAH	RADH	OAW	RADW
BMT 40	70 x 62	40	32	100	125	78	39	80	65

CT
82 484 ...
03004

CoreLine – Mori/Seiki – BMT 60 – Axial square section tool holder

- ▲ Directly screwed version
- ▲ For right and left direction of rotation



Left

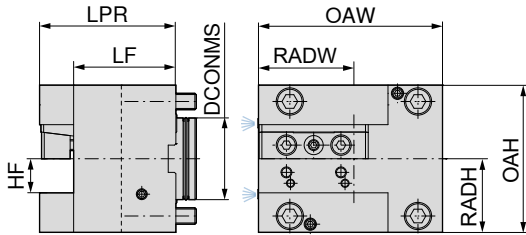
Left

Adapter	Hole pattern	DCONMS mm	HF mm	WF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 60	94 x 84	60	25	40	70	108	54	130	65

CT	CT
82 485 ... 00001	82 485 ... 00005

CoreLine – Mori/Seiki – BMT 60 – Radial square section tool holder

- ▲ Directly screwed version
- ▲ For right and left direction of rotation



Left

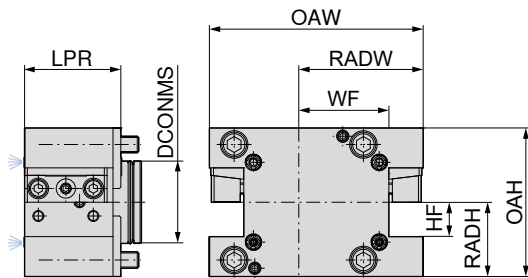
Left

Adapter	Hole pattern	DCONMS mm	HF mm	LF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 60	94 x 84	60	25	75	100	108	54	135	70

CT	CT
82 485 ... 01002	82 485 ... 01006

CoreLine – Mori/Seiki – BMT 60 – Multi square section tool holder

- ▲ Directly screwed version
- ▲ For right and left direction of rotation

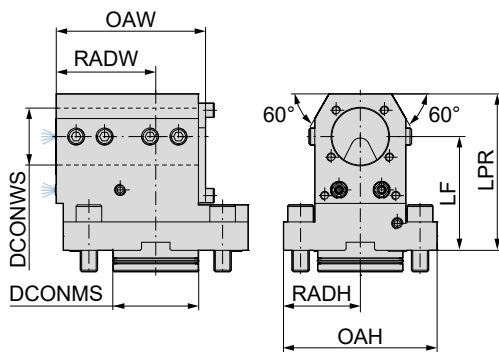


Adapter	Hole pattern	DCONMS mm	HF mm	WF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 60	94 x 84	60	25	40	70	108	54	155.5	65

CT	CT
82 485 ... 02003	82 485 ... 02007

CoreLine – Mori/Seiki – BMT 60 – Combi tool holder

- ▲ Directly screwed version



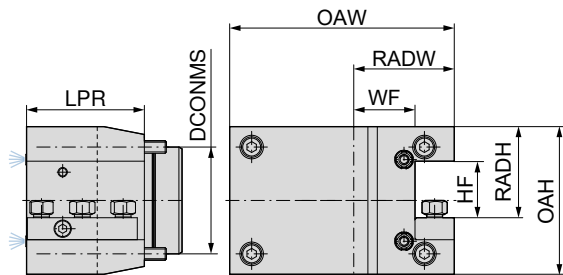
Through coolant

Adapter	Hole pattern	DCONMS mm	DCONWS mm	LF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 60	94 x 84	60	40	80	110	108	54	105	70

CT
82 485 ... 03004

CoreLine – Mazak – BMT 68 – Axial square section tool holder

- ▲ Directly screwed version
- ▲ For right and left direction of rotation



Left

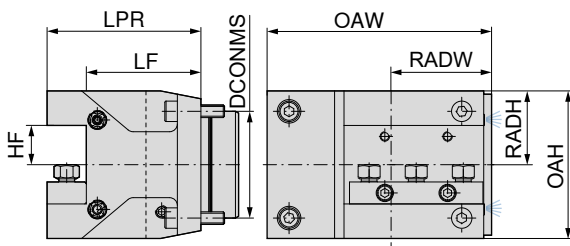
Left

Adapter	Hole pattern	DCONMS mm	HF mm	WF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 68	110 x 68	68	25	39	75	94	47	143	64
BMT 68	110 x 68	68	25	39	75	94	47	143	65

CT	CT
82 486 ... 00001	82 486 ... 00005

CoreLine – Mazak – BMT 68 – Radial square section tool holder

- ▲ Directly screwed version
- ▲ For right and left direction of rotation



Left

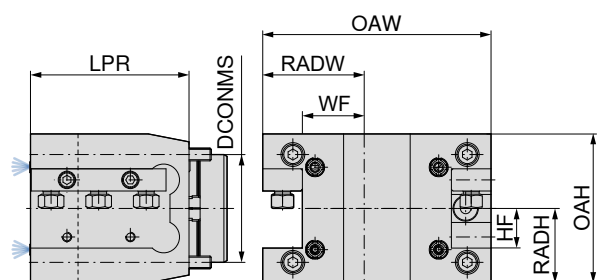
Left

Adapter	Hole pattern	DCONMS mm	HF mm	LF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 68	110 x 68	68	25	73	98	94	47	143	64

CT	CT
82 486 ... 01002	82 486 ... 01006

CoreLine – EMAG – BMT 68 – Multi square section tool holder

▲ Directly screwed version

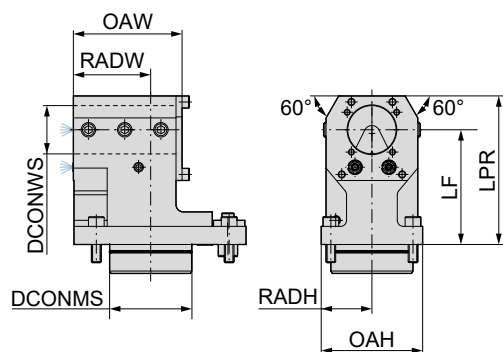


Adapter	Hole pattern	DCONMS mm	HF mm	WF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 68	110 x 68	68	25	39	100	94	47	144	64
BMT 68	110 x 68	68	25	39	100	94	47	144	65

CT	CT
82 486 ... 02003	82 486 ... 02007

CoreLine – Mazak – BMT 68 – Combi tool holder

▲ Directly screwed version



Through coolant

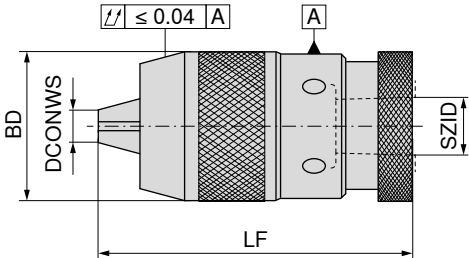
Adapter	Hole pattern	DCONMS mm	DCONWS mm	LF mm	LPR mm	OAH mm	RADH mm	OAW mm	RADW mm
BMT 68	110 x 68	68	40	95	123	84	42	90	64

CT
82 486 ... 03004

CoreLine – Drill chuck

- ▲ For manual and key clamping
- ▲ Through-hardened and ground

Scope of supply:
Base body with clamping key



SZID	DCONWS mm	LF mm	BD mm
B12	0 - 8	73	35
B12	0 - 10	92	43
B16	1 - 13	106	50
B16	3 - 16	110	57
B18	3 - 16	110	57

CX
83 636 ...
012
112
016
116
018

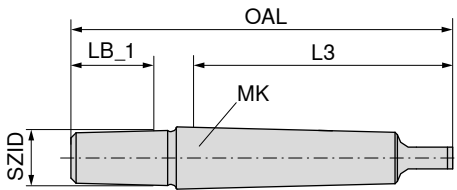
Spare parts
DCONWS

0 - 8
0 - 10
1 - 13
3 - 16


NC clamping key
CX
83 302 ...
008
010
013
016

CoreLine – Drill chuck adapter DIN 238

▲ Through-hardened and ground

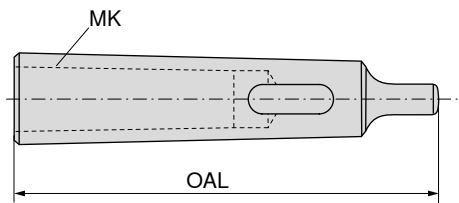


Adapter	SZID	l ₃ mm	LB_1 mm	OAL mm
MK1	B12	62.0	18.5	89.0
MK1	B16	62.0	24.0	97.0
MK1	B18	62.0	32.0	106.0
MK2	B12	75.0	18.5	106.5
MK2	B16	75.0	24.0	110.5
MK2	B18	75.0	32.0	117.5
MK3	B12	94.0	18.5	125.0
MK3	B16	94.0	24.0	134.0
MK3	B18	94.0	32.0	141.0
MK4	B16	117.5	24.0	159.0
MK4	B18	117.5	32.0	168.0
MK5	B16	149.5	24.0	196.0
MK5	B18	149.5	32.0	204.5

CX
83 642 ...
120
160
180
121
161
181
122
162
182
163
183
164
184

CoreLine – Reduction sleeve DIN 2185

▲ Through-hardened, ground internally and externally



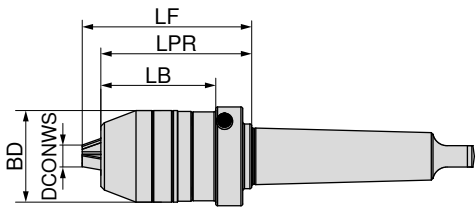
			CX
Adapter	d ₁	OAL mm	83 644 ...
MK1	MK0	80	010
MK2	MK1	92	020
MK3	MK1	99	130
MK3	MK2	112	030
MK4	MK1	124	240
MK4	MK2	124	140
MK4	MK3	140	040
MK5	MK2	156	250
MK5	MK3	156	150
MK5	MK4	171	050

CoreLine – Short drill chuck – NC 2010

- ▲ Independent of direction of rotation
- ▲ Tightening torque = 12 Nm
- ▲ With Morse taper

Scope of supply:
Base body with clamping key

NC
2010



Adapter	DCONWS mm	BD mm	LB mm	LPR mm	LF mm
MK3	0,5 - 13	48.5	64	84	93.0
MK3	2,5 - 16	51.0	64	84	94.5
MK4	2,5 - 16	51.0	64	84	94.5

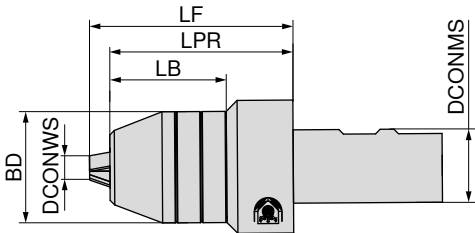
CX
84 314 ...
313
316
416

CoreLine – Short drill chuck – NC 2010

- ▲ Independent of direction of rotation
- ▲ Tightening torque = 12 Nm
- ▲ With cylindrical shank

Scope of supply:
Base body with clamping key

NC
2010



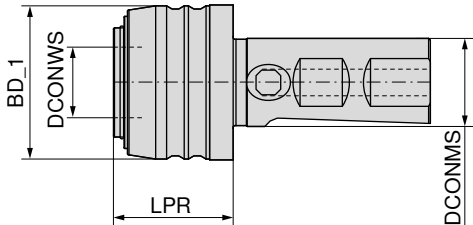
G 6.3 n_{max} 10000

DCONMS mm	DCONWS mm	BD mm	LB mm	LPR mm	LF mm
25	0,5 - 13	48.5	50.9	80	89.0
32	0,5 - 13	48.5	50.9	80	89.0
32	2,5 - 16	51.0	50.9	80	90.5

CX
84 311 ...
213
313
316

CoreLine – Synchro quick change tapping chuck with minimum length compensation

- ▲ With length compensation under tension and under compression (LZD)
- ▲ For collets 83 608 ... DIN 6499 ER16/ER25
- ▲ $p_{max.} = 50 \text{ bar}$



DCONWS mm	Cutting range	SZID	LPR mm	BD_1 mm	DCONMS mm	LZD± mm
20	M3 - M12	1	35	43.5	25	1,0 / 0,2
32	M6 - M20	2	56	60.0	25	1,0 / 0,2

CT

83 641 ...

012

020

Accessories



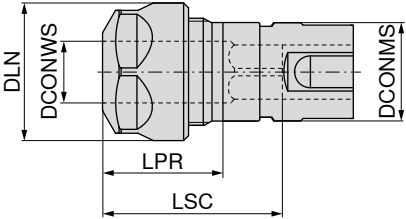
Insert



Insert for synchro quick change tapping chuck with minimum length compensation

▲ SZID = for insert size

Scope of supply:
Includes lock nut



DCONWS mm	Cutting range	SZID	LPR mm	DLN mm	LSC mm	DCONMS mm	for collet
2 - 10	M3 - M12	1	24	28	42	20	426E (ER16)
2 - 16	M6 - M20	2	28	42	59	32	430E (ER25)

CT
83 608 ...
012 ¹⁾
020

1) With hex nut

Spare parts
for article number

83 608 012	M22x1,5 - SW25	044	M22x1,5	054	M22x1,5	054	116
83 608 020			M32x1,5	055	M32x1,5	055	125



Lock nut SW

CT

62 950 ...



Lock nut IK

CT

83 950 ...



Lock nut

CT

62 950 ...



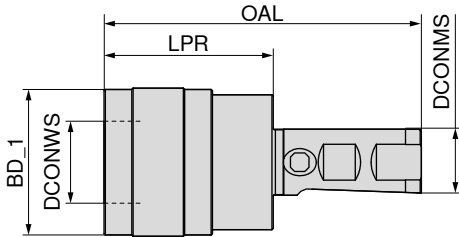
Y clamping key

CX

83 357 ...

CoreLine – Quick change tapping chuck with length compensation

- ▲ With length compensation under tension and compression (LZD)
- ▲ With cylindrical shank



DCONMS mm	Cutting range	SZID	LPR mm	BD_1 mm	DCONWS mm	OAL mm	LZD± mm
20	M3 - M12	01	41	38	19	91	9
20	M6 - M20	02	63	55	31	138	15
25	M3 - M12	01	41	38	19	97	9
25	M6 - M20	02	63	55	31	119	15
32	M3 - M12	01	41	38	19	102	9
32	M6 - M20	02	63	55	31	124	15

CT
83 648 ...
112
120
212
220
312
320

Accessories

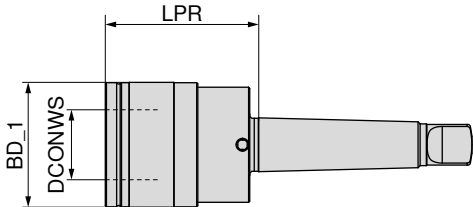


Insert



CoreLine – DIN 228B – Quick change tapping chuck with length compensation

- ▲ With length compensation under tension and compression (LZD)
- ▲ With Morse taper shank



Adapter	Cutting range	SZID	LPR mm	BD_1 mm	DCONWS mm	LZD± mm
MK 2	M3 - M12	01	46	38	19	9
MK 3	M3 - M12	01	46	38	19	9
MK 3	M6 - M20	02	69	55	31	15
MK 4	M6 - M20	02	70	55	31	15

CT
83 646 ...
212
312
320
420

Accessories



Insert

→

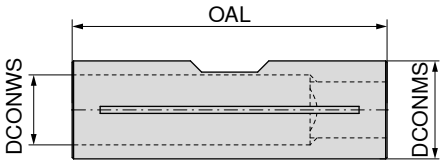


Others

→

CoreLine – Clamping sleeve for taps in Weldon chucks

- ▲ For machines with rigid tapping
- ▲ For safe clamping of taps

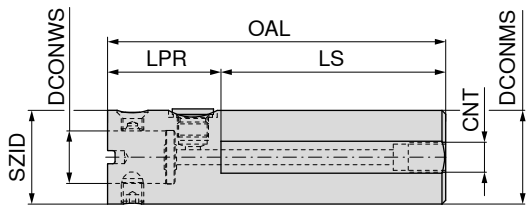


DCONWS _{H7} mm	DCONMS _{H6} mm	OAL mm
3.5	6	26
4.0	8	32
4.5	8	26
6.0	10	30
7.0	10	31
8.0	12	38
9.0	12	38
10.0	14	42
11.0	14	42
12.0	16	44
14.0	18	45
16.0	20	46

CT
80 699 ...
03500
04000
04500
06000
07000
08000
09000
10000
11000
12000
14000
16000

HyPower – Cylindrical shank adapter – ABS N

ABS N



AD

DCONWS	DCONMS	OAL	CNT	SZID	LS	LSC
mm	mm	mm			mm	mm
28	50	180	G3/8"	ABS 50 N	120	31
28	40	160	G3/8"	ABS 50 N	100	31
34	40	165	G3/8"	ABS 63 N	100	38
34	50	185	G3/8"	ABS 63 N	120	38
46	50	190	G3/8"	ABS 80 N	120	43
46	60	190	G3/8"	ABS 80 N	120	43

CT
84 232 ...
55099
45099
46399
56399
58099
68099

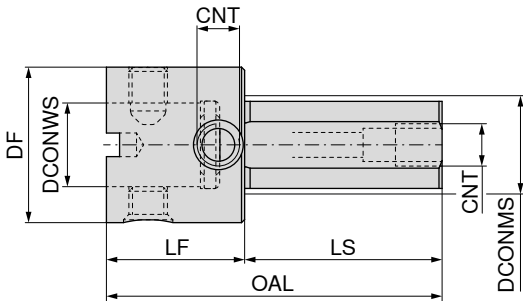
Spare parts
for article number

	CT	CT	CT	CT	CT	CT
	84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...
84 232 55099	20300	99800	31800	20200	20400	30700
84 232 45099	20300	99800	31800	20200	20400	30700
84 232 46399	25500	99400	31900	23900	27300	30800
84 232 56399	25500	99400	31900	23900	27300	30800
84 232 58099	25600	99300	32000	24000	25100	30900
84 232 68099	25600	99300	32000	24000	25100	30900

					
Clamping screw	Set	Positioning pin	Positioning pin	Taper screw	Sealing disc – ABS
CT	CT	CT	CT	CT	CT
84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...

HyPower – Cylindrical shank adapter – ABS N

ABS N



AD

DCONWS	DCONMS	OAL	CNT	SZID	LS	LPR
inch	inch	inch			inch	inch
1.102	2.000	6.362	1/4" NPT ABS 50 N	4.675	1.687	
1.102	1.250	4.250	1/4" NPT ABS 50 N	2.500	1.750	
1.102	1.500	4.250	1/4" NPT ABS 50 N	2.500	1.750	
1.102	2.500	7.362	1/4" NPT ABS 50 N	5.675	1.687	
1.339	2.000	6.559	1/4" NPT ABS 63 N	4.559	2.000	
1.339	2.500	7.559	1/4" NPT ABS 63 N	5.559	2.000	
1.811	2.000	6.756	1/4" NPT ABS 80 N	4.256	2.500	
1.811	2.500	7.756	1/4" NPT ABS 80 N	5.256	2.500	

CT

87 232 ...

32899
12899
22899
42899
33499
43499
34699
44699

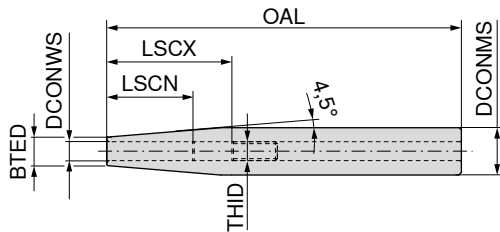
Spare parts
for article number

87 232 32899
87 232 12899
87 232 22899
87 232 42899
87 232 33499
87 232 43499
87 232 34699
87 232 44699

			
Clamping screw	Set	Taper screw	Sealing disc – ABS
CT	CT	CT	CT
84 950 ...	84 950 ...	84 950 ...	84 950 ...
20300	99800	20400	30700
20300	99800	20400	30700
20300	99800	20400	30700
20300	99800	20400	30700
25500	99400	27300	30800
25500	99400	27300	30800
25600	99300	25100	30900
25600	99300	25100	30900

CoreLine – Shrink fit extension

- ▲ For solid carbide and HSS shanks with h6 tolerance or higher
- ▲ DRVS = Key size of the adjustment screw



DCONMS _{h6} mm	DCONWS mm	BTED mm	OAL mm	LSCX mm	LSCN mm	THID	DRVS mm
12	3	8	150				
12	4	8	150				
12	5	10	150				
12	6	10	150	36	26	M5	2.5
16	3	10	150				
16	4	10	150				
16	5	10	150				
16	6	10	150	36	26	M5	2.5
16	8	12	150	36	26	M6	3.0
20	3	10	150				
20	4	10	150				
20	5	10	150				
20	6	10	150	36	26	M5	2.5
20	8	12	150	36	26	M6	3.0
20	10	14	150	42	32	M8x1	3.0
20	12	16	150	47	37	M10x1	5.0
25	6	20	150	36	26	M5	2.5
25	8	20	150	36	26	M6	3.0
25	10	20	150	42	32	M8x1	3.0
25	12	20	150	47	37	M10x1	5.0
25	14	20	150	47	37	M10x1	5.0
25	16	22	150	50	40	M10x1	5.0
32	6	20	150	36	26	M5	2.5
32	8	20	150	36	26	M6	3.0
32	10	24	150	42	32	M8x1	3.0
32	12	24	150	47	37	M10x1	5.0
32	14	27	150	47	37	M10x1	5.0
32	16	27	150	50	40	M10x1	5.0
32	18	27	150	50	40	M10x1	5.0
32	20	27	150	52	42	M10x1	5.0

CT

84 310 ...

003
004
005
006

103
104
105
106
108

203
204
205
206
208
210
212

306
308
310
312
314
316

406
408
410
412
414
416
418
420



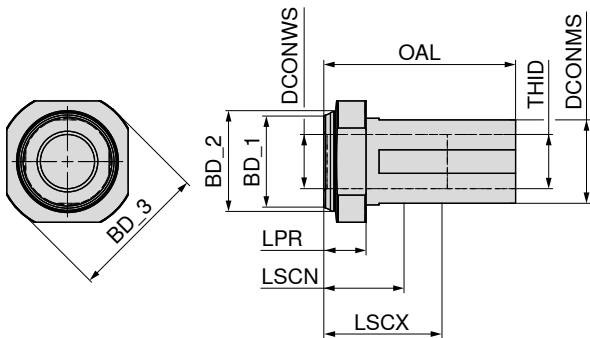
→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

CoreLine – Hydraulic chuck

- ▲ Hydraulic chuck with cylindrical shank
- ▲ For the hydraulic clamping of cylindrical tool shanks tol. h6, boring bars, and cylindrical tool holders tol. h7, g6 in fixed base holders
- ▲ One screw for locking the boring bar
- ▲ With length setting screw – can also be removed to enable the boring bar to be slid through
- ▲ High-precision clamping with a repeatability of 3 µm

Scope of supply:

Base body with stop screw and pressure screw



DCONMS	DCONWS	BD_1	BD_2	BD_3	LPR	OAL	LSCX	LSCN	THID
mm	mm	mm	mm	mm	mm	mm	mm	mm	
32	16	38	41	59	19.5	78.5	51	41	M22x1
32	20	38	41	59	19.5	78.5	51	41	M22x1
40	16	43	46	64	19.5	88.5	51	41	M22x1
40	20	43	46	64	19.5	88.5	51	41	M22x1
40	25	43	46	64	19.5	88.5	57	47	M27x1

CT
83 402 ...
31699
32099
41699
42099
42599



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
DCONWS

16 - 20
25



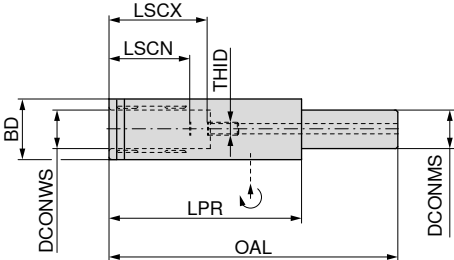
Backstop screw with internal cooling

CT
83 950 ...
48500
48600

CoreLine – Hydraulic expansion extension especially for hydraulic chucks

▲ For solid carbide and HSS shanks with h6 tolerance or higher

Scope of supply:
Base body with stop screw and pressure screw



G 2.5 n_{max} 25000

DCONMS	DCONWS	BD	LPR	OAL	LSCX	LSCN	THID
mm	mm	mm	mm	mm	mm	mm	
20	12	25.0	100	150	46	36	M6
20	20	31.5	100	150	51	41	M10x1
32	20	31.5	90	150	51	41	M10x1
32	20	31.5	90	200	51	41	M10x1

CT
84 313 ...
112
120
132
232



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
for article number

84 313 112	
84 313 120	
84 313 132	
84 313 232	



Backstop screw with internal cooling

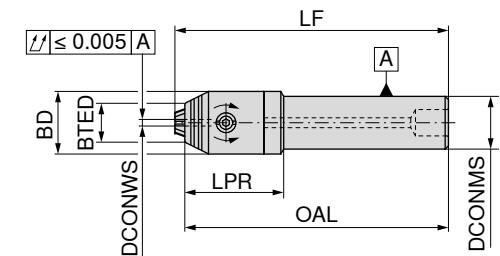
CT
83 950 ...
419
421
421
421

CoreLine – Micro-precision collet chuck

- ▲ Independent of direction of rotation
- ▲ For speeds up to 60,000 rpm

Scope of supply:

Base body including clamping key SW 2 x 60 mm





G 2.5 n_{max} 18000

CT

84 315 ...

161

162

163

201

202

203

DCONMS mm	DCONWS mm	LPR mm	OAL mm	LF mm	BD mm	BTED mm	TQX Nm
16	0,2 - 3,4	30	80	83	19	12	2
16	0,2 - 3,4	30	100	103	19	12	2
16	0,2 - 3,4	30	160	163	19	12	2
20	0,2 - 3,4	28	80	83	19	12	2
20	0,2 - 3,4	28	100	103	19	12	2
20	0,2 - 3,4	28	160	163	19	12	2

**Spare parts
for article number**

84 315 161	152	0,5 - 2,0 Nm	191
84 315 162	152	0,5 - 2,0 Nm	191
84 315 163	152	0,5 - 2,0 Nm	191
84 315 201	152	0,5 - 2,0 Nm	191
84 315 202	152	0,5 - 2,0 Nm	191
84 315 203	152	0,5 - 2,0 Nm	191



Interchangeable blade

AS

80 950 ...



Torque screwdriver

AS

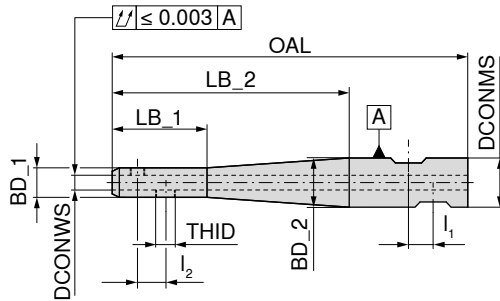
80 950 ...

CoreLine – Micro extension

▲ For shanks with lateral clamping flat according to DIN 6535 HB / 1835 B

Scope of supply:

Base body with shank clamping screw



DCONWS mm	BD_1 mm	LB_1 mm	LB_2 mm	OAL mm	DCONMS mm	BD_2 mm	I ₁ mm	I ₂ mm	THID	TQX Nm
6	12	40	40	85	12	12	10	10	M6 x 0,5	7
6	12	40	100	150	20	20	10	10	M6 x 0,5	7
8	15	40	40	88	16	15	10	10	M8 x 0,75	8
8	15	40	100	150	20	20	10	10	M8 x 0,75	8
10	18	40	40	90	20	18	10	10	M10 x 1	12
10	18	40	100	150	20	20	10	10	M10 x 1	12
12	21	40	40	90	20	21	10	10	M12 x 1	15
12	21	40	100	150	20	21	10	10	M12 x 1	15
14	23	40	40	90	20	23	10	10	M12 x 1	15
14	23	40	100	150	20	23	10	10	M12 x 1	15
16	26	40	50	106	25	26	10	12	M14 x 1	18
16	26	40	100	156	25	26	10	12	M14 x 1	18
18	28	40	50	106	25	28	10	12	M14 x 1	18
18	28	40	100	156	25	28	10	12	M14 x 1	18
20	31	40	50	110	32	31	10	14	M16 x 1	20
20	31	40	100	160	32	31	10	14	M16 x 1	20

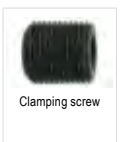
1) Only pre-balanced design

CT
80 642 ...
00600
10600
00800
10800
01000
11000
01200
11200
01400
11400
01600 ¹⁾
11600 ¹⁾
01800 ¹⁾
11800 ¹⁾
02000 ¹⁾
12000 ¹⁾

Spare parts

DCONWS

6
8
10
12 - 14
16 - 18
20



Clamping screw

CT
80 950 ...
21700
21800
21900
30000
31000
32000

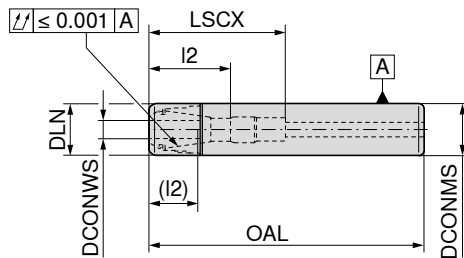
CoreLine – ER-Mini precision collet chuck – Centro-P

- ▲ Maximum clamping range covered according to ISO tolerance field H10
- ▲ Roll key required for clamping

Scope of supply:

Base body **without** lock nut, **without** stop screw

Centro-P



DCONMS mm	DCONWS mm	DLN mm	OAL mm	LSCX mm	l ₂ (l ₂) mm	for collet	CT
10	1 - 5	10	80	16		4004E (ER08)	84 456 ...
10	1 - 5	10	150	16		4004E (ER08)	00400
10	1 - 5	10	200	16		4004E (ER08)	005
							006
12	1 - 5	10	120	16		4004E (ER08)	11000
12	1 - 5	10	160	16		4004E (ER08)	11200
12	1 - 5	10	200	16		4004E (ER08)	11400
16	1 - 7	16	150	68	18 - 36 (12 - 26)	4008E (ER11)	007
16	1 - 7	16	200	68	18 - 36 (12 - 26)	4008E (ER11)	008
16	1 - 10	22	150	68	28 - 48 (16 - 35)	426E (ER16)	010
16	1 - 10	22	200	68	28 - 48 (16 - 35)	426E (ER16)	12000
20	1 - 10	22	150	68	28 - 48 (16 - 35)	426E (ER16)	102
20	1 - 10	22	200	68	28 - 48 (16 - 35)	426E (ER16)	104



LSCX = Clamping depth without stop screw

l₂ = Clamping depth with stop screw type 1, dimension in brackets (l₂) = Clamping depth with stop screw type 2

Dimension OAL is 4 mm longer when using lock nuts with sealing discs



→ Here you will find information about the permitted transmissible torques and minimum shank clamping depths.

Spare parts
for collet

4004E (ER08)						
4008E (ER11)			M8x1 - SW4		M8x1 - SW4	
426E (ER16)			M11x1 - SW6		M11x1 - SW6	

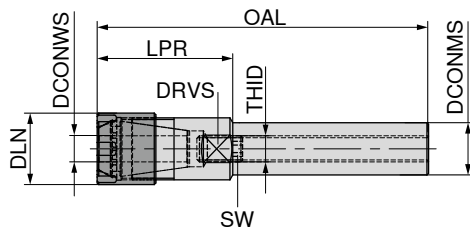
			
Mini lock nut IK	Mini lock nut	Stop screw 2	Stop screw 1
CT	CT	CT	CT
84 950 ...	84 950 ...	83 950 ...	83 950 ...
	040		
	041	340	336
035	034	341	337

Accessories

			
ER collet	Removal aid	Roll key	Roll key device
→	→	→	→

CoreLine – ER collet chuck with mini lock nut

▲ With cylindrical shank



DCONMS _{h6} mm	DCONWS mm	OAL mm	LPR mm	DLN mm	THID	DRVS mm	SW mm	for collet
8	1 - 5	81	26	12		9		4004E (ER08)
12	1 - 5	157	20	12	M5x0,8	10	2.5	4004E (ER08)
16	1 - 7	185	25	16	M7,5x0,5	14	3.0	4008E (ER11)
16	1 - 10	117	37	22	M11x1	17	5.0	426E (ER16)
16	1 - 10	199	39	22	M8x1,25	17	4.0	426E (ER16)
20	1 - 10	168	28	22	M11x1	17	5.0	426E (ER16)
25	1 - 13	168	28	28	M14x1	22	5.0	428E (ER20)
25	1 - 16	189	39	35	M18x1	27	5.0	430E (ER25)

CX
83 453 ...
081 ¹⁾
122
163
164
165
204
254
256

1) Without coolant supply (shape A)

Spare parts for collet	ER-Mini clamping key		Mini lock nut		Mini lock nut IK		Stop screw IK	
	CT		CT		CT		CT	
4004E (ER08)	83 950 ...	099	M10x0,75	067	83 950 ...		83 950 ...	003
4004E (ER08)		099	M10x0,75	067				
4008E (ER11)		100	M13x0,75	065				004
426E (ER16)		101	M19x1	066	M19x1	058	M11x1 SW 5	006
426E (ER16)		101	M19x1	066	M19x1	058	M8x1,25 SW 4	005
428E (ER20)		102	M24x1	068	M24x1	059	M14x1 SW 5	007
430E (ER25)		103	M30x1	069	M30x1	060	M18x1 SW 5	008

Accessories

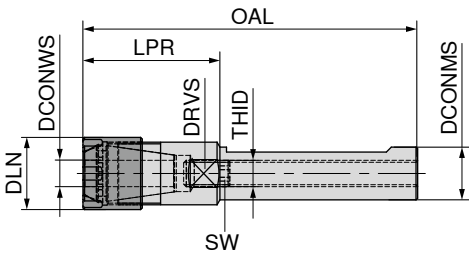


ER collet

Others

CoreLine – ER collet chuck with mini lock nut

▲ With cylindrical shank and clamping flat



DCONMS _{h6} mm	DCONWS mm	OAL mm	LPR mm	DLN mm	THID	DRVS mm	SW mm	for collet	CX	
20	1 - 10	168	28	22	M11x1	17	5	426E (ER16)	83 454 ...	204
20	1 - 13	138	38	28	M11x1	22	5	428E (ER20)		206
20	1 - 16	146	46	35	M14x1	27	5	430E (ER25)		208
25	1 - 13	168	28	28	M14x1	22	5	428E (ER20)		254
25	1 - 16	189	39	35	M18x1	27	5	430E (ER25)		256

Spare parts for collet

	CT		CT		CT		CT
426E (ER16)	101	M19x1	066	M19x1	058	M11x1 SW 5	006
428E (ER20)	102	M24x1	068	M24x1	059	M14x1 SW 5	007
428E (ER20)	102	M24x1	068	M24x1	059	M11x1 SW 5	006
430E (ER25)	103	M30x1	069	M30x1	060	M18x1 SW 5	008
430E (ER25)	103	M30x1	069	M30x1	060	M14x1 SW 5	007



ER-Mini clamping key



Mini lock nut



Mini lock nut IK



Stop screw IK

Accessories

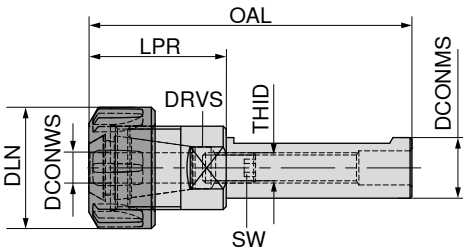


ER collet

Others

CoreLine – ER collet chuck

▲ With cylindrical shank and clamping flat



DCONMS _{h6} mm	DCONWS mm	OAL mm	LPR mm	DLN mm	THID	DRVS mm	SW mm	for collet	CX 83 455 ...		
40	2 - 20	100	35	50	M22x1,5	36	5	470E (ER32)	401		
40	2 - 20	160	35	50	M22x1,5	36	5	470E (ER32)	402		
40	3 - 30	139	59	63	M28x1,5	40	6	472E (ER40)	405		

Spare parts for collet

470E (ER32)	132	M28x1,5x25 SW 6	096	M22x1,5x20 SW 5	095
472E (ER40)	140				


Y clamping key

CX

83 357 ...


Stop screw IK

CT

83 950 ...


Stop screw

CT

83 950 ...

Spare parts for collet

470E (ER32)	M40x1,5	056	M40x1,5	65600
472E (ER40)	M50x1,5	057	M50x1,5	65700


Lock nut IK

CT

83 950 ...


Lock nut

CT

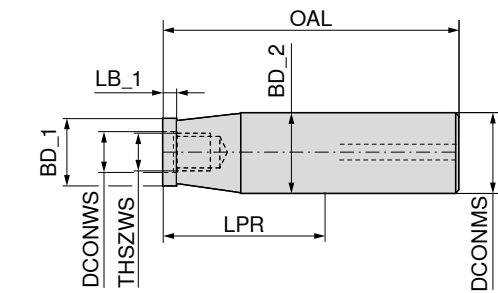
62 950 ...

Accessories


ER collet

→

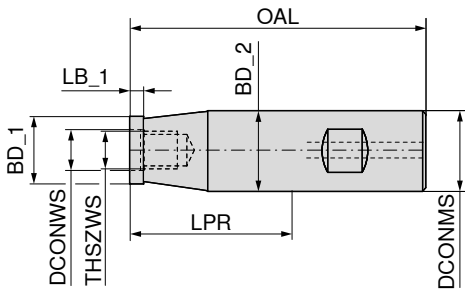
CoreLine – Adapter for screw-in cutter with cylindrical shank



DCONWS _{h6} mm	THSZWS	DCONWS mm	LPR mm	BD_1 mm	LB_1 mm	BD_2 mm	OAL mm
12	M5	5.5	20	9.5	7.8	11.8	65
12	M6	6.5	20	11.5	7.8	11.5	65
12	M6	6.5	40	11.5	7.8	11.5	85
16	M8	8.5	20	13.8	7.8	15.8	68
16	M8	8.5	40	13.8	7.8	15.8	88
20	M10	10.5	25	18.0	7.8	19.8	75
20	M10	10.5	45	18.0	7.8	19.8	95
25	M12	12.5	50	21.0	7.8	24.8	106
32	M16	17.0	50	29.0	7.8	31.8	110

CX
82 750 ...
05266
06066
06266
08166
08266
10166
10266
12266
16266

CoreLine – Screw-in adapter with cylindrical shank Weldon



DCONWS _{h6} mm	THSZWS	DCONWS mm	LPR mm	BD_1 mm	LB_1 mm	BD_2 mm	OAL mm
16	M8	8.5	20	13.8	7.8	15.8	68
16	M8	8.5	40	13.8	7.8	15.8	88
20	M10	10.5	25	18.0	7.8	19.8	75
20	M10	10.5	45	18.0	7.8	19.8	95
25	M12	12.5	30	21.0	7.8	24.8	86
25	M12	12.5	50	21.0	7.8	24.8	106
32	M16	17.0	50	29.0	7.8	31.8	110

CX
82 750 ...
08199
08299
10199
10299
12199
12299
16299

Accessories

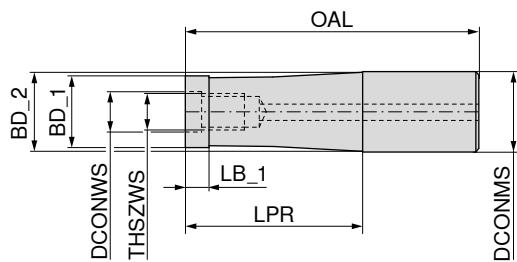


Extension/reduction



CoreLine – Screw-in cutter adapter with cylindrical shank Densimet

- ▲ Vibration-damped
- ▲ Densimet



DCONMS _{h6} mm	THSZWS	DCONWS mm	LPR mm	BD_1 mm	LB_1 mm	BD_2 mm	OAL mm
12	M5	5.5	40	9.5	9	11.3	85
12	M5	5.5	60	9.5	9	11.3	105
12	M5	5.5	80	9.5	9	11.3	125
16	M8	8.5	40	14.2	9	15.3	88
16	M8	8.5	60	14.2	9	15.3	108
16	M8	8.5	80	14.2	9	15.3	128
16	M8	8.5	100	14.2	9	15.3	148
16	M8	8.5	120	14.2	9	15.3	168
16	M8	8.5	150	14.2	9	15.3	198
20	M10	10.5	60	18.5	9	19.3	110
20	M10	10.5	80	18.5	9	19.3	130
20	M10	10.5	100	18.5	9	19.3	150
20	M10	10.5	120	18.5	9	19.3	170
20	M10	10.5	140	18.5	9	19.3	190
25	M12	12.5	75	23.0	9	24.3	131
25	M12	12.5	100	23.0	9	24.3	156
25	M12	12.5	125	23.0	9	24.3	181
25	M12	12.5	150	23.0	9	24.3	206
25	M12	12.5	175	23.0	9	24.3	231

CT
82 751 ...
05266
05366
05466
08266
08366
08466
08566
08666
08766
10366
10466
10566
10666
10766
12466
12566
12666
12766
12866

Accessories



Extension/reduction



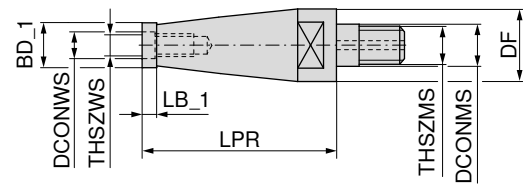
CoreLine – Extensions for screw-in cutters



THSZWS	THSZMS	DCONWS mm	DCONMS mm	LPR mm	BD mm
M10	M10	10.5	10.5	60	18.0
M10	M10	10.5	10.5	40	18.0
M12	M12	12.5	12.5	40	21.0
M12	M12	12.5	12.5	60	21.0
M16	M16	17.0	17.0	40	29.0
M16	M16	17.0	17.0	60	29.0
M8	M8	8.5	8.5	60	13.8
M8	M8	8.5	8.5	40	13.8

CX
82 752 ...
10200
10100
12100
12200
16100
16200
08200
08100

CoreLine – Reductions for screw-in cutters



THSZWS	THSZMS	DCONMS mm	DCONWS mm	LPR mm	BD_1 mm	DF mm	LB_1 mm
M6	M8	8.5	6.5	20	9.5	13.8	7.8
M8	M10	10.5	8.5	40	13.8	18.0	7.8
M8	M12	12.5	8.5	60	13.8	21.0	7.8
M10	M12	12.5	10.5	40	18.0	21.0	7.8
M10	M16	17.0	10.5	60	18.0	29.0	7.8
M12	M16	17.0	12.5	40	21.0	29.0	7.8

CX

82 753 ...

06000

08100

08200

10100

10200

12100

MultiChange – Program Overview

The "MultiChange" exchangeable head system enables an extremely fast and problem-free tool change. Provides maximum changeover and radial run-out accuracy with maximum stability at the same time. The following chapters contain suitable exchangeable heads for a multitude of applications.

Exchangeable heads

→ Solid carbide drills

Solid carbide NC spot drills

Ø 8, 10, 12, 16, 20 mm
NOF 2



SIG 90°



SIG 120°



SIG 142°

→ Reamers and countersinks

Exchangeable reaming heads

Ø 8,00 – 30,20 mm



Through hole

Ø 12,20 – 30,20 mm



Blind hole

→ Solid carbide milling cutters

Solid carbide shoulder mills

Ø 8, 10, 12, 16, 20 mm /
ZEFP 3+4



Type PCR UNI



Type PCR ALU



Type N

Solid carbide torus cutters

Ø 8, 10, 12, 16, 20 mm / ZEFP 3+4



Type W



Type N

Solid carbide roughing-finishing milling cutters

Ø 8, 10, 12, 16, 20 mm / ZEFP 4+6



Type NF

Solid carbide finish milling cutters

Ø 8, 10, 12, 16, 20 mm / ZEFP 6



Type N

Solid carbide ball-nosed end mills

Ø 10, 12, 16, 20 mm / ZEFP 4



Type N

Solid carbide high-feed cutters

Ø 8, 10, 12, 16, 20 mm / ZEFP 6



Type N

Solid carbide quarter round cutters

Ø 8, 10, 12, 16, 20 mm / ZEFP 6



Type N

Solid carbide deburring cutters

Ø 10, 12, 16, 20 mm / ZEFP 4+6



Type N



Type N

NOF / ZEFP = Number of cutting edges

Holders

→ Adapters and accessories

OAL 60 – 90 mm



Conical 87° / steel



Cylindrical* / steel

OAL 85 – 120 mm



Conical 87° / steel



Cylindrical* / steel



Conical 87° / solid carbide



Cylindrical* / solid carbide

OAL 110 – 150 mm



Conical 87° / solid carbide



Cylindrical* / solid carbide

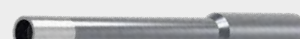
OAL 150 – 200 mm



Conical 87° / solid carbide



Cylindrical* / steel

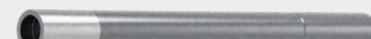


Cylindrical* / solid carbide

OAL 200 – 250 mm



Cylindrical* / steel



Cylindrical* / solid carbide

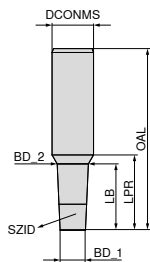
* Only suitable for milling to a certain degree

CoreLine – Holders – MultiChange

- ▲ Conical 87°
- ▲ SZID = Coupling size

Scope of supply:

Base body without mounting key



Steel



Steel



Solid carbide



Solid carbide



Solid carbide



SZID	BD_1 mm	BD_2 mm	DCONMS mm	OAL mm	LB mm	LPR mm
06	7.8	9.4	10	60	18	19
06	7.8	9.4	10	85	43	44
06	7.8	9.4	10	110	68	69
06	7.8	9.4	10	150	108	109
08	9.8	12.0	16	70	25	29
08	9.8	13.0	16	90	38	41
08	9.8	14.9	16	110	60	61
08	9.8	15.4	16	150	100	101
10	11.8	14.2	16	70	27	29
10	11.8	15.2	16	90	40	41
10	11.8	16.6	20	110	56	59
10	11.8	19.5	20	150	98	99
12	15.8	18.2	20	80	27	29
12	15.8	19.5	20	105	53	54
12	15.8	19.5	20	130	78	79
12	15.8	19.5	20	150	98	99
16	19.8	23.2	25	90	39	41
16	19.8	24.5	25	120	60	61
16	19.8	24.5	25	150	90	91
16	19.8	24.5	25	200	140	141

CT

84 001 ...

080

100

120

160

200

CT

84 004 ...

080

100

120

160

200

CT

84 005 ...

080

100

120

160

200

CT

84 007 ...

080

100

120

160

200

CT

84 010 ...

080

100

120

160

200



→ Find the assembly instructions here.

Accessories



Spanner head



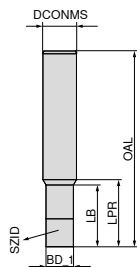
Spanner

CoreLine – Holders – MultiChange

- ▲ Cylindrical
- ▲ Only suitable for milling to a certain degree
- ▲ SZID = Coupling size

Scope of supply:

Base body without mounting key



SZID	BD_1 mm	DCONMS mm	OAL mm	LB mm	LPR mm
06	7.8	10	60	17	19
06	7.8	10	85	42	44
06	7.8	10	150	107	109
08	9.8	12	70	22	24
08	9.8	12	90	42	44
08	9.8	12	150	102	104
10	11.8	16	70	17	21
10	11.8	16	90	37	41
10	11.8	16	150	97	101
12	15.8	16	80	30	31
12	15.8	16	105	55	56
12	15.8	16	150	100	101
12	15.8	16	200	150	151
16	19.8	25	90	26	31
16	19.8	25	120	56	61
16	19.8	25	200	136	141
16	19.8	25	250	186	191



Steel



Steel



Steel



Steel



CT	CT	CT	CT
84 000 ...	84 002 ...	84 008 ...	84 011 ...
080	080	080	
100	100	100	
120	120	120	
160	160	160	160
200	200	200	200



→ Find the assembly instructions here.

Accessories



Spanner head



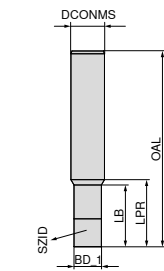
Spanner



CoreLine – Holders – MultiChange

- ▲ Cylindrical
- ▲ Only suitable for milling to a certain degree
- ▲ SZID = Coupling size

Scope of supply:
Base body without mounting key



SZID	BD_1 mm	DCONMS mm	OAL mm	LB mm	LPR mm
06	7.8	10	85	42	44
06	7.8	10	110	67	69
06	7.8	10	150	107	109
08	9.8	12	90	42	44
08	9.8	12	110	62	64
08	9.8	12	150	102	104
10	11.8	16	90	37	41
10	11.8	16	110	57	61
10	11.8	16	150	97	101
12	15.8	16	105	55	56
12	15.8	16	130	80	81
12	15.8	16	150	100	101
12	15.8	16	200	150	151
16	19.8	25	120	56	61
16	19.8	25	150	86	91
16	19.8	25	200	136	141
16	19.8	25	250	186	191



Solid carbide	Solid carbide	Solid carbide	Solid carbide
CT	CT	CT	CT
84 003 ...	84 006 ...	84 009 ...	84 012 ...
080	080	080	
100	100	100	
120	120	120	
160	160	160	160
200	200	200	200

→Find the assembly instructions here.

Accessories

Spanner head

→

Spanner

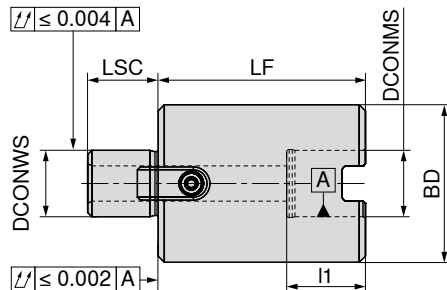
→

CoreLine – Extensions for shell mill adaptors

▲ Variable applications through usage of one or two extensions (max. 2 x 50 mm possible)

Scope of supply:

Base body without clamping screw



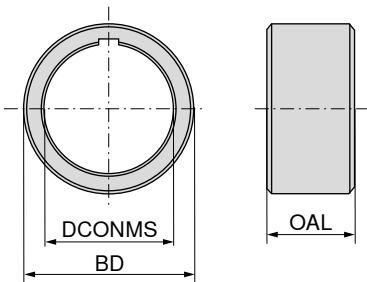
						CX	
DCONWS _{h5}	DCONMS _{h5}	LF	BD	LSC	I ₁	82 648 ...	
mm	mm	mm	mm	mm	mm		
16	16	50	38	17	19	050	
16	16	75	38	17	19	075	
22	22	50	48	19	21	150	
22	22	75	48	19	21	175	
27	27	50	58	21	23	250	
27	27	75	58	21	23	275	
32	32	50	78	24	26	350	
32	32	75	78	24	26	375	
40	40	50	88	27	29	450	
40	40	75	88	27	29	475	



When using two extensions (max. 2 x 50 mm), please use a retaining screw with a length of 125 mm.

		Carrier screws		Drive key		Retaining screw		Retaining screw	
		CT		CT		CX		CX	
Spare parts for article number		83 950 ...		83 950 ...		82 649 ...		82 649 ...	
82 648 050	M3x8	296	8x9x17,5	120	M8x125	001	M8x80	050	
82 648 075	M3x8	296	8x9x17,5	120			M8x100	075	
82 648 150	M4x12	297	10x11x20,5	121	M10x125	100	M10x80	150	
82 648 175	M4x12	297	10x11x20,5	121			M10x100	175	
82 648 250	M5x12	136	12x13x24,3	122	M12x125	200	M12x80	250	
82 648 275	M5x12	136	12x13x24,3	122			M12x100	275	
82 648 350	M5x20	137	14x21x21,2	123	M16x125	300	M16x80	350	
82 648 375	M5x20	137	14x21x21,2	123			M16x100	375	
82 648 450	M6x16	138	15,9x16,3x19,5	295					
82 648 475	M6x16	138	15,9x16,3x19,5	295					

Milling adapter ring DIN 2084 shape B

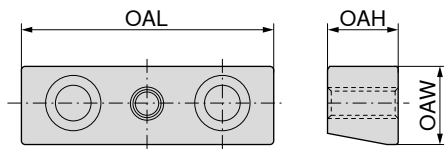


DCONMS mm	BD mm	OAL mm
13	22	2
13	22	3
13	22	4
13	22	5
13	22	6
13	22	10
16	26	2
16	26	3
16	26	4
16	26	5
16	26	6
16	26	10
16	26	20
16	26	30
22	34	2
22	34	3
22	34	4
22	34	5
22	34	6
22	34	10
22	34	20
22	34	30
27	41	2
27	41	3
27	41	4
27	41	5
27	41	6
27	41	10
27	41	20
27	41	30
32	47	2
32	47	3
32	47	4
32	47	5
32	47	6
32	47	10
32	47	20
32	47	30
40	55	2
40	55	3
40	55	4
40	55	5
40	55	6
40	55	10
40	55	20
40	55	30

CX
83 385 ...
013
113
213
313
413
513
016
116
216
316
416
516
616
716
022
122
222
322
422
522
622
722
027
127
227
327
427
527
627
727
032
132
232
332
432
532
632
732
040
140
240
340
440
540
640
740

Clamping rail

▲ Spare parts for VDI holders with DirectCooling

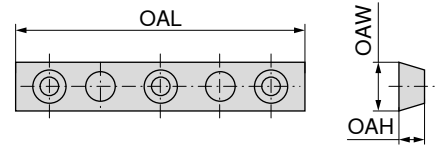


OAL mm	OAW mm	OAH mm
53.0	12.7	11.5
54.0	16.0	15.0
67.5	16.0	15.0
68.0	21.0	19.0
83.0	20.5	19.0
90.0	20.5	19.0

CT
82 250 ...
05300
05400
06750
06800
08300
09000

Clamping wedge

▲ Spare parts for VDI holders with DirectCooling

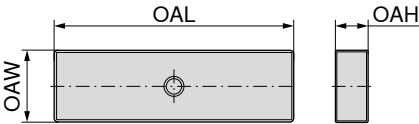


OAL mm	OAW mm	OAH mm
70	14	7.3
85	14	7.3
100	14	7.3

CT
82 250 ...
07000
08500
10000

Shim

▲ Spare parts for VDI holders with DirectCooling



OAL	OAW	OAH
mm	mm	mm
53.0	14	6.1
67.5	18	6.3
83.0	22	7.5
90.0	22	7.5

CT

82 250 ...

15300

16750

18300

19000

Screw for ball-shaped spray nozzle

▲ Spare parts for VDI holders with DirectCooling



THOD
M3x10
M4x10
M5x12
M6x12

CX

82 950 ...

31000

31300

31100

31200

Ball-shaped spray nozzle

▲ Spare parts for VDI holders with DirectCooling



THID	BD mm
M5	8
M6	10
M6	12
M6	14

CX
82 950 ...
30600
30900
30700
30800

O ring for clamping wedge

▲ Spare parts for VDI holders with DirectCooling



Size
Ø13 x Ø2
Ø18 x Ø2
Ø22 x Ø2

CX
82 950 ...
32600
32700
32800

O ring for ball-shaped spray nozzle

▲ Spare parts for VDI holders with DirectCooling



Size	CX
	82 950 ...
Ø10 x Ø2	31600
Ø5 x Ø1,5	31400
Ø7 x Ø1,5	31700
Ø7 x Ø2,5	31500

Quad ring

▲ Spare parts for VDI holders with DirectCooling



Size	CX
	82 950 ...
Ø21,95 x Ø1,78	32400
Ø28,3 x Ø1,78	32500

Screw plug for ball-shaped spray nozzle

▲ Spare parts for VDI holders with DirectCooling



THOD		OAL mm	CX	
M5		6	82 950 ...	32900
M6		6		33000

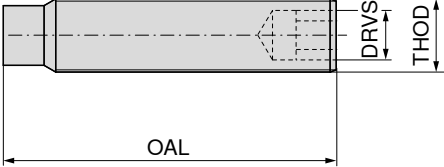
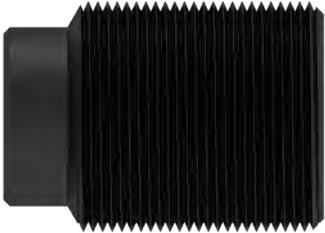
Screw for clamping wedge

▲ Spare parts for VDI holders with DirectCooling



THOD		CX	
M5x12		82 950 ...	31800
M6x16			32200
M6x20			31900
M8x20			32300
M8x25			32100

Grub screw for cylindrical adapters E2



THOD	OAL mm	DRVS mm	CT 83 950 ...	
M6	12	3	461	
M6	16	3	462	
M6	25	3	463	
M8	10	4	464	
M8	12	4	465	
M8	16	4	466	
M8	20	4	467	
M8	25	4	468	
M8	30	4	469	
M10	16	5	470	
M10	20	5	471	
M10	25	5	472	
M10	30	5	473	
M12	12	6	474	
M12	16	6	475	
M12	20	6	476	
M12	25	6	477	

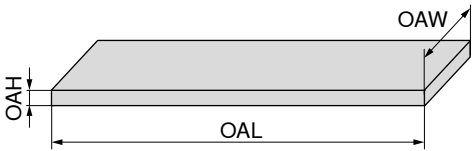
Clamping screw for cylindrical adapters E1



THOD	CT 83 950 ...	
M10x1x10	180	
M12x1x12	181	
M16x1x13	182	

Shim

- ▲ For axial and radial tool holders
- ▲ Without mounting thread



			CT	
OAH mm	OAL mm	OAW mm	83 950 ...	
4	38	14		210
4	48	14		211
4	54	14		212
4	55	12		213
4	69	16		214
4	72	14		215
4	75	12		216
4	99	16		217
5	84	20		218
5	117	20		219
7	99	25		220
7	120	25		221
7	129	25		222
7	143	25		223

Coolant nozzle

▲ For square shank holders and parting blade holders with DirectCooling



Size
M12x1

CT
70 950 ...
92800

Key

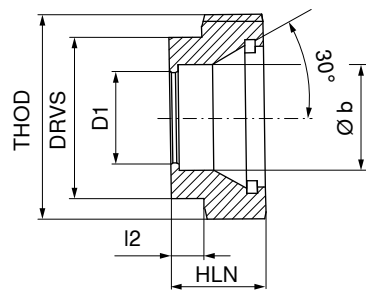
▲ For square shank holders and parting blade holders with DirectCooling



Size	OAL mm	DRVS mm
12	11	13

CT
70 950 ...
92900

Lock nut with external thread shape ER for sealing discs with internal cooling



for collet	THOD	DRVS mm	CT	
ER 16	M24x1	19	83 950 ...	45600
ER 20	M28x1,5	22		45700
ER 25	M32x1,5	24		45800
ER 32	M40x1,5	32		45900

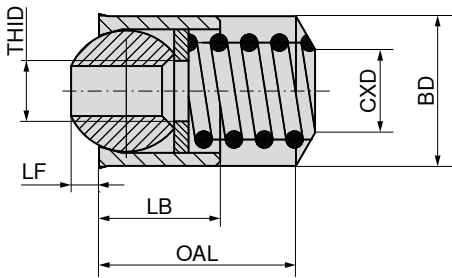
Pipe joints

▲ Steel pipe



THOD	CXD mm	Type	CT	
M8x1	5	A	83 950 ...	372
M10x1	6	A		373
M10x1	8	A		374
M8x1	5	B		375
M10x1	6	B		376
M10x1	8	B		377

Spray nozzle element



BD mm	THID	OAL mm	LB mm	LF mm	CXD mm
9.88	M4	13	8	2.2	5.5
11.88	M6	15	10	3.0	6.8
13.88	M6	17	12	4.0	6.8

CT
83 950 ...
247
248
249

Ball-shaped spray nozzle



THID
M5
M6
M8

CT
83 950 ...
200
201
202

O ring



Adapter		Size	CT	
VDI 16		15 x 1,5	83 950 ...	205
VDI 20		18,77 x 1,78		206
VDI 30		28,3 x 1,78		207
VDI 40		37,77 x 2,62		208
VDI 50		47,29 x 2,62		209

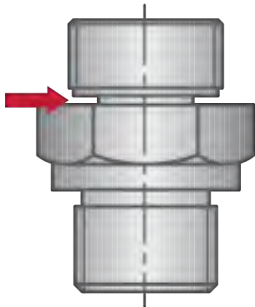
Sealing ring for coolant ring



DCONWS mm	DCONMS mm	for	OAW mm
56	50	KRD 50	4
66	60	KRD 60	4
76	70	KRD 70	4
86	80	KRD 80	4

CT
84 244 ...
00500
01600
01700
01800

Coolant connection with break section

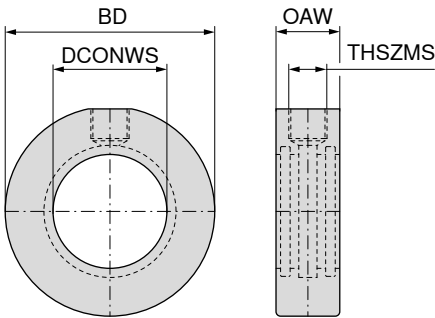


for	THOD	DRVS mm
KRD	NPT 1/8"	3/8"

CT
84 244 ...
00300

Coolant ring for rotating adaptors

- ▲ Circumferential speed 15–20 m/s
- ▲ Coolant pressure up to approx. 10 bar



DCONWS mm	THSZMS	for	OAW mm	BD mm
50	3/8"	Ø50	28	91
70	3/8"	Ø70	28	110
80	3/8"	Ø80	28	120
100	3/8"	Ø100	28	140

CT
84 244 ...
00700
00800
00900
01000

Circlip DIN 471



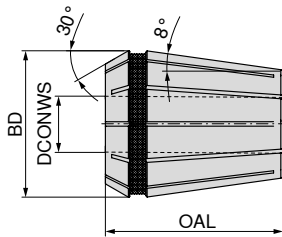
Size	BD mm
Ø50x2	50

CT
84 244 ...
00100

ER precision collet for precision collet chucks

- ▲ DIN ISO 15488-B (old DIN 6499-B)
- ▲ 12 times slotted
- ▲ Double taper collet
- ▲ Colored ring as identification of precision collet
- ▲ ER08: 5 µm radial run-out accuracy and repeatability
- ▲ Coated precision collet

ER-B
2 µm



DCONWS mm	BD = 8.5 OAL = 13.6 4004 E / ER08	BD = 11.5 OAL = 18 4008 E / ER11	BD = 17 OAL = 27.5 426 E / ER16	BD = 26 OAL = 34 430 E / ER25	BD = 33 OAL = 40 470 E / ER32	BD = 41 OAL = 46 472 E / ER40
	CT 84 577 ...	CT 84 585 ...	CT 84 596 ...	CT 84 597 ...	CT 84 598 ...	CT 84 599 ...
1.0	010	010	010			
1.1			011			
1.2			012			
1.4			014			
1.5	015	015	015			
1.6			016			
1.8			018			
2.0	020	020	020	020	020	
2.2			022			
2.4			024			
2.5	025	025	025	025		
2.6			026			
2.8			028			
3.0	030	030	030 ¹⁾	030	030	030
3.2			032			
3.4			034			
3.5	035	035	035	035		
3.6			036			
3.8			038			
4.0	040	040	040 ¹⁾	040	040 ¹⁾	040
4.5	045	045	045	045		
5.0	050	050	050 ¹⁾	050	050	050
5.5		055	055	055		
5.6			056			
6.0		060	060 ¹⁾	060 ¹⁾	060 ¹⁾	060
6.3			063			
6.5		065	065	065		
7.0		070	070	070	070	070
7.1			071			
7.5			075	075		
8.0			080 ¹⁾	080 ¹⁾	080 ¹⁾	080
8.5			085			
9.0			090	090	090	090
9.5			095	095		
10.0			100 ¹⁾	100 ¹⁾	100 ¹⁾	100
10.5				105		
11.0				110	110	110
11.5				115		
12.0				120 ¹⁾	120 ¹⁾	120
12.5				125		

1) Included in the set



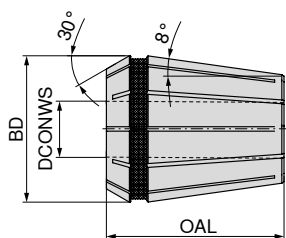
Clamping range covered: H10 corresponding to shank Ø DCONWS

Continued on next page

ER precision collet for precision collet chucks

- ▲ DIN ISO 15488-B (old DIN 6499-B)
- ▲ 12 times slotted
- ▲ Double taper collet
- ▲ Colored ring as identification of precision collet
- ▲ ER08: 5 µm radial run-out accuracy and repeatability
- ▲ Coated precision collet

ER-B
2 µm



DCONWS mm	BD = 8.5 OAL = 13.6 4004 E / ER08	BD = 11.5 OAL = 18 4008 E / ER11	BD = 17 OAL = 27.5 426 E / ER16	BD = 26 OAL = 34 430 E / ER25	BD = 33 OAL = 40 470 E / ER32	BD = 41 OAL = 46 472 E / ER40
	CT 84 577 ...	CT 84 585 ...	CT 84 596 ...	CT 84 597 ...	CT 84 598 ...	CT 84 599 ...
13.0				130	130	130
13.5				135		
14.0				140 ¹⁾	140 ¹⁾	140
14.5				145		
15.0				150	150	150
15.5				155		
16.0				160 ¹⁾	160 ¹⁾	160
17.0					170	170
18.0					180	180
19.0					190	190
20.0					200 ¹⁾	200
21.0						210
22.0						220
23.0						230
24.0						240
25.0						250
26.0						260
Set in wooden box			999	999	999	

1) Included in the set



Clamping range covered: H10 corresponding to shank Ø DCONWS

- ▲ Similar to DIN ISO 15488-A
- ▲ 8 times slotted
- ▲ Colored ring as identification of precision collet
- ▲ $p_{\max.} = 60 \text{ bar}$
- ▲ Coated precision collet

Technical drawing of a tapered roller bearing cross-section. The drawing shows the internal structure with rollers and a cage. Key dimensions and features are labeled: BD (Bore Diameter), $DCONWS$ (Distance from Bore to Roller Center), 30° (Bore Taper Angle), 8° (Roller Taper Angle), and OAL (Overall Assembly Length).

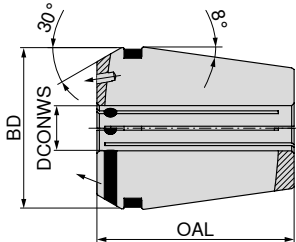


		BD = 11.3 OAL = 18 425 E / ER11	BD = 16.7 OAL = 27.5 425 E / ER16	BD = 25.7 OAL = 34 429 E / ER25	BD = 32.7 OAL = 40 469 E / ER32	BD = 40.7 OAL = 46 471 E / ER40
		CT	CT	CT	CT	CT
DCONWS		84 536 ...	84 537 ...	84 538 ...	84 539 ...	84 540 ...
mm						
3		030	030	030	030	
4			040	040	040	
5		050	050	050	050	
6		060	060	060	060	060
7			070	070	070	
8			080	080	080	080
9			090	090	090	
10			100	100	100	100
11				110	110	
12				120	120	120
13				130	130	
14				140	140	140
15				150	150	
16				160	160	160
17					170	
18					180	180
19					190	
20					200	200
22						220
25						250

ER precision collet, sealed with coolant channels, for precision collet chucks

- ▲ Similar to DIN ISO 15488-A
- ▲ 8 times slotted
- ▲ Colored ring as identification of precision collet
- ▲ Coated precision collet

ER-A
2 µm

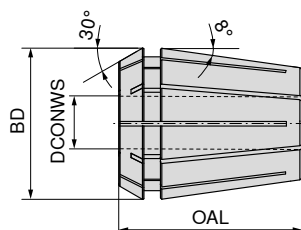


DCONWS mm	BD = 11.3 OAL = 18 4012 E / ER11	BD = 16.7 OAL = 27.5 425 E / ER16	BD = 25.7 OAL = 34 429 E / ER25	BD = 32.7 OAL = 40 469 E / ER32	BD = 40.7 OAL = 46 471 E / ER40
	CT	CT	CT	CT	CT
	84 547 ...	84 548 ...	84 549 ...	84 550 ...	84 551 ...
3	03000	03000			
4	04000	040	040	040	
6	06000	060	060	060	06000
8		080	080	080	08000
10		10000	100	100	100
12			120	120	120
14			140	140	
16			16000	160	160
18				180	
20				200	200
25					250

ER precision collet

- ▲ DIN ISO 15488-B (old DIN 6499-B)
- ▲ 12 times slotted
- ▲ Double taper collet
- ▲ Coated collet

ER-B
5 µm



		BD = 11.5 OAL = 18 4008 E / ER11	BD = 17 OAL = 27.5 426 E / ER16	BD = 21 OAL = 31.5 428 E / ER20	BD = 26 OAL = 34 430 E / ER25	BD = 33 OAL = 40 470 E / ER32	BD = 41 OAL = 46 472 E / ER40
		CX	CX	CX	CX	CX	CX
DCONWS mm	DCONWS inch	84 576 ...	84 578 ...	84 579 ...	84 580 ...	84 581 ...	84 582 ...
1.000		010	010	010 ¹⁾	010 ¹⁾		
1.500		015	015 ¹⁾	015 ¹⁾	015 ¹⁾		
2.000		020	020	020	020	020 ¹⁾	
2.500		025	025 ¹⁾	025 ¹⁾	025 ¹⁾	025 ¹⁾	
3.000		030	030	030	030	030	030 ¹⁾
3.175	1/8		12500 ¹⁾		12500 ¹⁾	12500 ¹⁾	
3.500		035					
3.970	5/32		15600 ¹⁾				
4.000		040	040	040	040	040	040
4.500		045					
4.750	3/16		18700 ¹⁾		18700 ¹⁾	18700 ¹⁾	
5.000		050	050	050	050	050	050
5.500		055					
5.556	7/32		21900 ¹⁾				
6.000		060	060	060	060	060	060
6.350	1/4		25000 ¹⁾		25000 ¹⁾	25000 ¹⁾	
6.500		065					
7.000		070	070	070	070	070	070
7.925	5/16		31200 ¹⁾		31200 ¹⁾	31200 ¹⁾	
8.000			080	080	080	080	080
9.000			090	090	090	090	090
9.525	3/8		37500 ¹⁾		37500 ¹⁾	37500 ¹⁾	
10.000			100	100	100	100	100
11.000				110	110	110	110
11.100	7/16				43700 ¹⁾	43700 ¹⁾	
12.000				120	120	120	120
12.700	1/2				50000 ¹⁾	50000 ¹⁾	
13.000				130	130	130	130
14.000					140	140	140
14.275	9/16				56200 ¹⁾	56200 ¹⁾	
15.000					150	150	150
15.875	5/8				62500 ¹⁾	62500 ¹⁾	
16.000					160	160	160
17.000						170	170
18.000						180	180
19.000						190	190
19.050	3/4					75000 ¹⁾	
20.000						200	200
21.000							210
22.000							220
23.000							230
24.000							240
25.000							250
26.000							260
Set in wooden box		999	999	999	999	999	999

1) Not included in the set

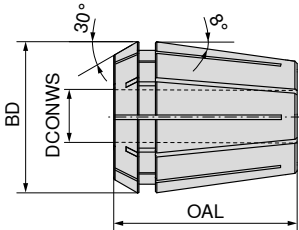


Clamping range covered: up to Ø 2 mm = 0.5 mm, from Ø 2.5 mm = 1 mm

ER collet

- ▲ DIN ISO 15488-B (old DIN 6499-B)
- ▲ 16 times slotted
- ▲ Double taper collet

ER-B
10 µm



DCONWS mm	BD = 8.5 OAL = 13.6 4004 E / ER08	BD = 17 OAL = 27.5 426 E / ER16	BD = 26 OAL = 34 430 E / ER25	BD = 33 OAL = 40 470 E / ER32
	CX	CX	CX	CX
1.0	82 683 ...	82 684 ...	82 685 ...	82 686 ...
1.5	01000	01000		
2.0	01500	02000	02000	
2.5	02000			
3.0	02500	03000	03000	03000
3.5	03000			
4.0	03500	04000	04000	04000
4.5	04000			
5.0	04500	05000	05000	05000
6.0	05000	06000	06000	06000
7.0		07000	07000	07000
8.0		08000	08000	08000
9.0		09000	09000	09000
10.0		10000	10000	10000
11.0			11000	11000
12.0			12000	12000
13.0			13000	13000
14.0			14000	14000
15.0			15000	15000
16.0			16000	16000
17.0				17000
18.0				18000
19.0				19000
20.0				20000
Set in plastic case	99900	99900	99900	99900

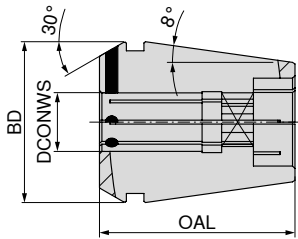


Clamping range covered: up to Ø 3 mm = 0.5 mm, from Ø 4 mm = 1 mm

ER precision tap collet, sealed

- ▲ Similar to DIN ISO 15488-A
- ▲ 8 times slotted
- ▲ For Centro-P and standard chucks
- ▲ $p_{max.} = 60 \text{ bar}$
- ▲ Coated collet

ER-A
10 µm



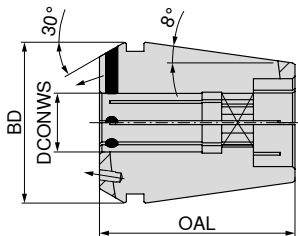
DCONWS
mm
2.8
3.5
4.0
4.5
6.0
7.0
8.0
9.0
10.0
11.0
12.0
14.0
16.0
18.0
20.0

BD = 16.7 OAL = 27.5 4031 E / ER16	BD = 25.7 OAL = 34 4282 E / ER25	BD = 32.7 OAL = 40 4537 E / ER32
CT	CT	CT
84 531 ...	84 533 ...	84 534 ...
028		
035	035	
040	040	040
045	045	045
060	060	060
070	070	070
080	080	080
090	090	090
	100	100
	110	110
	120	120
	140	140
	160	160
		180
		200

ER precision tap collet, sealed with coolant channels

- ▲ Similar to DIN ISO 15488-A
- ▲ 8 times slotted
- ▲ For Centro-P and standard chucks
- ▲ Coated collet

ER-A
10 µm

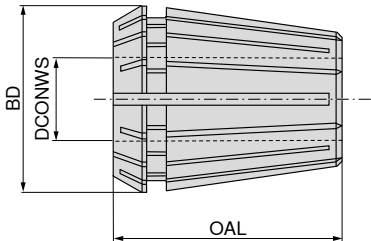


DCONWS mm	BD = 16.7 OAL = 27.5 4537 E / ER16		BD = 25.7 OAL = 34 4537 E / ER25		BD = 32.7 OAL = 40 4537 E / ER32	
	CT		CT		CT	
3.5	84 567 ...		84 568 ...		84 569 ...	
4.5	035					
6.0	045		045		045	
7.0	060		060		060	
8.0	070		070		070	
9.0	080		080		080	
10.0	09000		090		090	
11.0			100		100	
12.0			110		110	
14.0			120		120	
16.0			140		140	
18.0			16000		160	
20.0					180	
					200	

ER collet

- ▲ DIN ISO 15488-B (old DIN 6499-B)
- ▲ Double taper collet
- ▲ 16 times slotted

ER-B
20 µm



DCONWS mm	BD = 17 OAL = 27.5 426 E / ER16		BD = 21 OAL = 31.5 428 E / ER20		BD = 26 OAL = 34 430 E / ER25		BD = 33 OAL = 40 470 E / ER32		BD = 41 OAL = 46 472 E / ER40	
	CX		CX		CX		CX		CX	
1	82 687 ...		82 688 ...		82 689 ...		82 690 ...		82 691 ...	
2	01000		01000		02000		03000		03000	
3	02000		02000		03000		04000		04000	
4	03000		03000		04000		05000		05000	
5	04000		04000		05000		06000		06000	
6	05000		05000		06000		07000		07000	
7	06000		06000		07000		08000		08000	
8	07000		07000		08000		09000		09000	
9	08000		08000		09000		10000		10000	
10	09000		09000		10000		11000		11000	
11	10000		10000		11000		12000		12000	
12			11000		12000		13000		13000	
13			12000		13000		14000		14000	
14			13000		14000		15000		15000	
15					15000		16000		16000	
16					16000		17000		17000	
17							18000		18000	
18							19000		19000	
19							20000		20000	
20									21000	
21									22000	
22									23000	
23									24000	
24									25000	
25									26000	
26									99900	
Set in plastic case		99900	99900		99900		99900		99900	

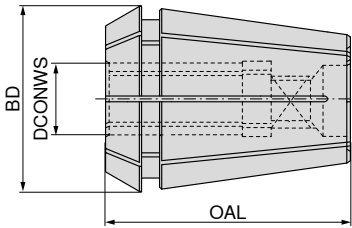


Clamping range covered: up to Ø 2 mm = 0.5 mm, from Ø 2.5 mm = 1 mm

ER collet with internal square

- ▲ Similar DIN ISO 15488-A (old DIN 6499-A)
- ▲ 8 times slotted
- ▲ Double taper collets for holding taps on synchronized spindle machines, without compensating lengths

ER-A
15 µm

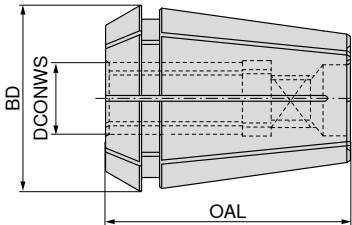


DCONWS mm	BD = 16.7 OAL = 27.5 426 E / ER16	BD = 25.7 OAL = 34 430 E / ER25	BD = 32.7 OAL = 40 470 E / ER32	BD = 40.7 OAL = 46 472 E / ER40
	CX	CX	CX	CX
2.8	82 695 ...			
3.5	02800			
4.0	03500			
4.5	04000			
5.0	04500	04500	04500	
5.5	05000			
6.0	05500	05500	05500	
6.0	06000	06000	06000	
7.0	07000	07000	07000	07000
8.0	08000	08000	08000	08000
9.0	09000	09000	09000	09000
10.0		10000	10000	10000
11.0		11000	11000	11000
12.0		12000	12000	12000
14.0			14000	14000
16.0			16000	16000
18.0				18000
20.0				20000

ER collet with internal square

- ▲ Similar DIN ISO 15488-A (old DIN 6499-A)
- ▲ 8 times slotted
- ▲ Double taper collets for holding taps on synchronized spindle machines, without compensating lengths

ER-A
15 µm



BD = 20.7
OAL = 31.5
428 E / ER20

DCONWS
mm
4.5
6.0
7.0
8.0
9.0
10.0
11.0

CT
84 333 ...
04500
06000
07000
08000
09000
10000
11000

Wooden box for collets

▲ For collets shape ER

Scope of supply:
Empty wooden box

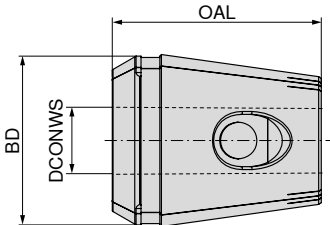


		CT	
for collet	Capacity	83 689 ...	
4004E (ER08)	9		008
426E (ER16)	10		116
428E (ER20)	11		020
4008E (ER11)	13		011
430E (ER25)	14		025
470E (ER32)	18		032
472E (ER40)	24		040

CoreLine – ER wedge collet with pull out protection, for precision collet chucks – Centro-P

- ▲ Similar to DIN ISO 15488-A
- ▲ Slotted
- ▲ Double taper collet

ER
5 µm



DCONWS		BD = 32.7 OAL = 40 ER 32		BD = 40.7 OAL = 46 ER 40	
mm	inch	CT		CT	
12.00		83 629 ...		83 630 ...	
12.70	1/2	120			
15.88	5/8	50000			
16.00		62500		62500	
19.05	3/4	160		16000	
20.00				75000	
25.00		20000		20000	
				25000	

Spare parts DCONWS

12	CP 32	455
12.7	CP 32	455
15.88	CP 32	455
16	CP 32	455
20	CP 32	455



Conical spring

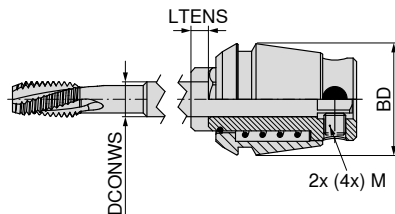
CT

83 950 ...

Precision tap collet, shape ET (ER) with length compensation

- ▲ DIN ISO 15488 (alt DIN 6499)
- ▲ With length compensation under tension (LTENS)
- ▲ The spring force is adapted to the thread size
- ▲ Anti-rotation by 2 and/or 4 clamping screws on the shank square drive

ER
10 µm



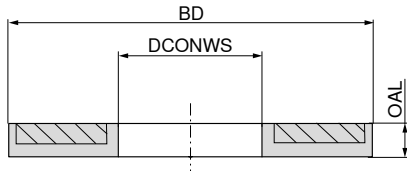
DCONWS mm	BD = 17 OAL = 30 426 E / ER16	BD = 21 OAL = 33.5 428 E / ER20	BD = 26 OAL = 33.5 430 E / ER25	BD = 33 OAL = 46 470 E / ER32	BD = 41 OAL = 58 472 E / ER40
	CT	CT	CT	CT	CT
2.2	80 661 ... 022	80 662 ... 022			
2.5	025	025	025		
2.8	028	028	028		
3.0	030	030	030		
3.5	035	035	035		
4.0	040	040	040		
4.5	045	045	045	045	
5.0				050	
5.5	055	055	055	055	
6.0	060	060	060	060	060
7.0		070	070	070	070
8.0			080	080	080
9.0			090	090	090
10.0			100	100	100
11.0				110	110
12.0				120	120
14.0					140
16.0					160



Length compensation only possible under tension. When using CNC machines apply canned cycles with a feed rate or pitch of only 95% with small threads and up to 99% with large threads. In this way when reversing the rotation of the spindle an optimum length compensation in both directions is guaranteed.

Sealing discs for precision collet chucks – Centro-P, ER-Standard and ER-Mini with thru coolant

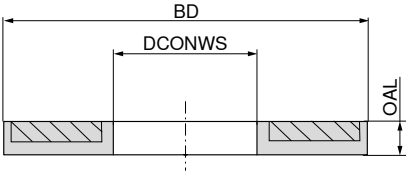
- ▲ For sealing when using tools with internal cooling
- ▲ Sealing range: nominal diameter -0.1 mm / +0.4 mm
- ▲ Can be applied up to 80 bar



DCONWS mm	BD = 12.6 OAL = 2 426E (ER16)	BD = 15.8 OAL = 2 428E (ER20)	BD = 20.2 OAL = 2 430E (ER25)	BD = 26.2 OAL = 2 444E / OZ (ER32)	BD = 34.2 OAL = 2 472E (ER40)
	CT	CT	CT	CT	CT
1.0	83 690 ... 010				
1.5	015				
2.0	020	020	020	020	
2.5	025	025	025	025	
3.0	030	030	030	030	030
3.5	035	035	035	035	035
4.0	040	040	040	040	040
4.5	045	045	045	045	045
5.0	050	050	050	050	050
5.5	055	055	055	055	055
6.0	060	060	060	060	060
6.5	065	065	065	065	065
7.0	070	070	070	070	070
7.5	075	075	075	075	075
8.0	080	080	080	080	080
8.5	085	085	085	085	085
9.0	090	090	090	090	090
9.5	095	095	095	095	095
10.0	100	100	100	100	100
10.5		105	105	105	105
11.0		110	110	110	110
11.5		115	115	115	115
12.0		120	120	120	120
12.5		125	125	125	125
13.0		130	130	130	130
13.5			135	135	135
14.0			140	140	140
14.5			145	145	145
15.0			150	150	150
15.5			155	155	155
16.0			160	160	160
16.5				165	165
17.0				170	170
17.5				175	175
18.0				180	180
18.5				185	185
19.0				190	190
19.5				195	195
20.0				200	200
20.5					205
21.0					210
21.5					215
22.0					220
22.5					225
23.0					230
23.5					235
24.0					240
24.5					245
25.0					250
25.5					255
26.0					260

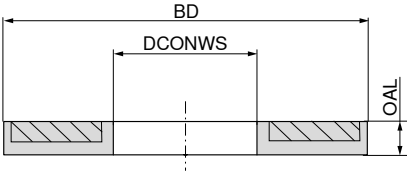
Sealing discs for precision collet chucks – PCC

- ▲ For sealing when using tools with internal cooling
- ▲ Sealing range: nominal diameter -0.1 mm / +0.4 mm
- ▲ Can be applied up to 100 bar



DCONWS mm	BD = 13 OAL = 4 426E (ER16)			BD = 21 OAL = 4 430E (ER25)			BD = 27 OAL = 4 470E (ER32)		
	CX			CX			CX		
	82 630 ...			82 631 ...			82 632 ...		
3.0	03000			03000			03000		
3.5	03500			03500			03500		
4.0	04000			04000			04000		
4.5	04500			04500			04500		
5.0	05000			05000			05000		
5.5	05500			05500			05500		
6.0	06000			06000			06000		
6.5	06500			06500			06500		
7.0	07000			07000			07000		
7.5	07500			07500			07500		
8.0	08000			08000			08000		
8.5	08500			08500			08500		
9.0	09000			09000			09000		
9.5	09500			09500			09500		
10.0	10000			10000			10000		
10.5				10500			10500		
11.0				11000			11000		
11.5				11500			11500		
12.0				12000			12000		
12.5				12500			12500		
13.0				13000			13000		
13.5				13500			13500		
14.0				14000			14000		
14.5				14500			14500		
15.0				15000			15000		
15.5				15500			15500		
16.0				16000			16000		
16.5							16500		
17.0							17000		
17.5							17500		
18.0							18000		
18.5							18500		
19.0							19000		
19.5							19500		
20.0							20000		

Sealing discs for synchro tapping chuck – ABS

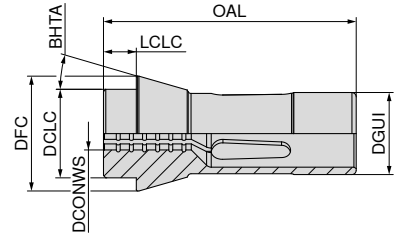


DCONWS mm
3.0
3.5
4.0
4.5
5.0
5.5
6.0
6.5
7.0
7.5
8.0
8.5
9.0
9.5
10.0
10.5
11.0
11.5
12.0
12.5
13.0
13.5
14.0
14.5
15.0
15.5
16.0
16.5
17.0
17.5
18.0
18.5
19.0
19.5
20.0

BD = 27 OAL = 4 470E (ER32)	BD = 16 OAL = 4 428E (ER20)
CT 84 331 ...	CT 84 334 ...
03000	
03500	
04000	
	04500
05000	
05500	
06000	06000
06500	
07000	07000
07500	
08000	08000
08500	
09000	09000
09500	
10000	10000
10500	
11000	11000
11500	
12000	
12500	
13000	
13500	
14000	
14500	
15000	
15500	
16000	
16500	
17000	
17500	
18000	
18500	
19000	
19500	
20000	

Pressure collets

Designation	DGUI mm	DFC mm	DCLC mm	LCLC mm	OAL mm	BHTA °
116 E / F 13	13	19	13	6	64	16



Pressure collet 116 E / F 13



Grooved
116 E / F 13

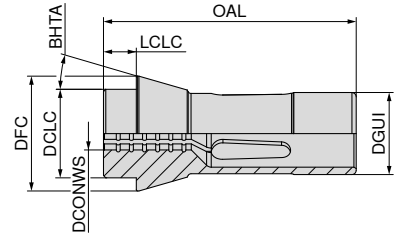
Smooth
116 E / F 13

DCONWS mm
1.0
1.5
2.0
2.5
3.0
3.5
4.0
4.5
5.0
5.5
6.0
6.5
7.0
7.5
8.0
8.5
9.0
9.5
10.0

CW	CW
81 000 ...	81 002 ...
	01000
	01500
	02000
	02500
	03000
	03500
	04000
	04500
	05000
	05500
06000	06000
06500	06500
07000	07000
07500	07500
08000	08000
08500	08500
09000	09000
09500	09500
10000	10000

Pressure collets

Designation	DGUI mm	DFC mm	DCLC mm	LCLC mm	OAL mm	BHTA °
120 E / F 15	15	21	15	6	64	16



Pressure collet 120 E / F 15



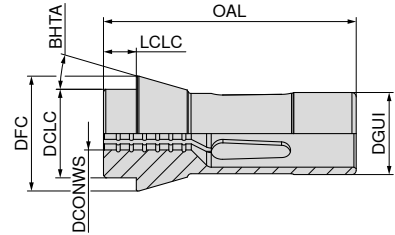
DCONWS mm	DCONWS inch
1.000	
1.500	
2.000	
2.500	
3.000	
3.175	1/8
3.500	
4.000	
4.500	
5.000	
5.500	
6.000	
6.350	1/4
6.500	
7.000	
7.500	
8.000	
8.500	
9.000	
9.500	
10.000	
10.500	
11.000	
11.500	
12.000	

Grooved 120 E / F 15	Smooth 120 E / F 15	Grooved 120 E / F 15
CW	CW	CW
81 003 ...	81 005 ...	81 031 ...
	01000	
	01500	
	02000	02000 ¹⁾
	02500	
	03000	03000 ¹⁾
		03175 ¹⁾
	03500	
	04000	04000 ¹⁾
	04500	
	05000	05000 ¹⁾
	05500	
06000	06000	06000 ¹⁾
		06350 ¹⁾
06500	06500	
07000	07000	07000 ¹⁾
07500	07500	
08000	08000	08000
08500	08500	
09000	09000	09000
	09500	
10000	10000	10000
10500	10500	
11000	11000	11000
11500	11500	
12000	12000	

1) Without transverse grooves

Pressure collets

Designation	DGUI mm	DFC mm	DCLC mm	LCLC mm	OAL mm	BHTA °
F 16 / 1212 E	16	21	16	6	64	16



Pressure collet F 16 / 1212 E



Grooved
F 16 / 1212 E

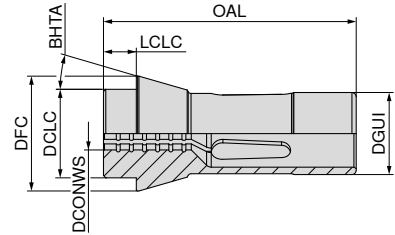
Smooth
F 16 / 1212 E

DCONWS mm
1.0
1.5
2.0
2.5
3.0
3.5
4.0
4.5
5.0
5.5
6.0
6.5
7.0
7.5
8.0
8.5
9.0
9.5
10.0
10.5
11.0
11.5
12.0
12.5
13.0

CW	CW
81 019 ...	81 021 ...
	01000
	01500
	02000
	02500
	03000
	03500
	04000
	04500
	05000
	05500
06000	06000
06500	06500
07000	07000
07500	07500
08000	08000
08500	08500
09000	09000
09500	09500
10000	10000
10500	10500
11000	11000
11500	11500
12000	12000
12500	12500
13000	13000

Pressure collets

Designation	DGUI mm	DFC mm	DCLC mm	LCLC mm	OAL mm	BHTA °
136 E / F 20-201	20	26	19	5	54	15



Pressure collet 136 E / F 20-201



- Grooved

136 E / F 20-201
- Smooth

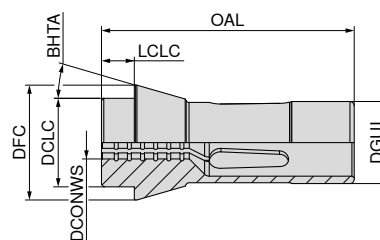
136 E / F 20-201

DCONWS mm
1.0
1.5
2.0
2.5
3.0
3.5
4.0
4.5
5.0
5.5
6.0
6.5
7.0
7.5
8.0
8.5
9.0
9.5
10.0
10.5
11.0
11.5
12.0
12.5
13.0
13.5
14.0
14.5
15.0
15.5
16.0

CW	CW
81 007 ...	81 009 ...
	01000
	01500
	02000
	02500
	03000
	03500
	04000
	04500
	05000
	05500
06000	06000
06500	06500
07000	07000
07500	07500
08000	08000
08500	08500
09000	09000
09500	09500
10000	10000
10500	10500
11000	11000
11500	11500
12000	12000
12500	12500
13000	13000
13500	13500
14000	14000
14500	14500
15000	15000
15500	15500
16000	16000

Pressure collets

Designation	DGUI mm	DFC mm	DCLC mm	LCLC mm	OAL mm	BHTA °
138 E / F20-87	20	28	21	7	67	16



Pressure collet 138 E / F 20-87



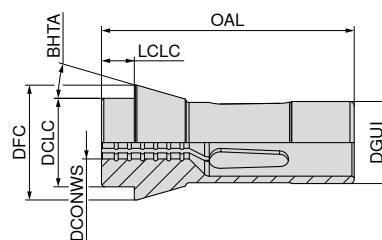
 Grooved
138 E / F20-87
  Smooth
138 E / F20-87
  Grooved
138 E / F20-87

DCONWS mm	DCONWS inch	CW 81 011 ...	CW 81 013 ...	CW 81 026 ...
1.00			01000	
1.50			01500	
2.00			02000	02000 ¹⁾
2.50			02500	
3.00			03000	03000 ¹⁾
3.50			03500	
4.00			04000	04000 ¹⁾
4.50			04500	
5.00			05000	05000 ¹⁾
5.50			05500	
6.00		06000	06000	06000 ¹⁾
6.35	1/4			06350 ¹⁾
6.50		06500	06500	
7.00		07000	07000	07000 ¹⁾
7.50		07500	07500	
8.00		08000	08000	08000
8.50		08500	08500	
9.00		09000	09000	09000
9.50		09500	09500	
10.00		10000	10000	10000
10.50		10500	10500	
11.00		11000	11000	11000
11.50		11500	11500	
12.00		12000	12000	12000
12.50		12500	12500	
13.00		13000	13000	13000
13.50		13500	13500	
14.00		14000	14000	14000
14.50		14500	14500	
15.00		15000	15000	
15.50		15500	15500	
16.00		16000	16000	

¹⁾ Without transverse grooves

Pressure collets

Designation	DGUI mm	DFC mm	DCLC mm	LCLC mm	OAL mm	BHTA °
145 E / F 25	25	35	27	10	77	16



Pressure collet 145 E / F 25



DCONWS mm	DCONWS inch	Grooved 145 E / F 25	Smooth 145 E / F 25	Grooved 145 E / F 25	Grooved 145 E / F 25
1,500		CW 81 015 ...	CW 81 017 ...	CW 81 027 ...	CW 81 029 ...
1,501 - 1,999			01500		
2,000			xxxxx ²⁾	02000 ¹⁾	02000 ¹⁾
2,001 - 2,499			02000		
2,500			xxxxx ²⁾		
2,501 - 2,999			02500		
3,000			xxxxx ²⁾		
3,001 - 3,499			03000	03000 ¹⁾	03000 ¹⁾
3,500			xxxxx ²⁾		
3,501 - 3,999			03500		
4,000			xxxxx ²⁾		
4,001 - 4,499			04000	04000 ¹⁾	04000 ¹⁾
4,500			xxxxx ²⁾		
4,501 - 4,999			04500		
5,000			xxxxx ²⁾		
5,001 - 5,499			05000	05000 ¹⁾	05000 ¹⁾
5,500			xxxxx ²⁾		
5,501 - 5,999			05500		
6,000			xxxxx ²⁾		
6,001 - 6,349		06000	06000	06000 ¹⁾	06000 ¹⁾
6,350	1/4	xxxxx ²⁾			
6,351 - 6,499		06350	06350	06350 ¹⁾	
6,500		xxxxx ²⁾			
6,501 - 6,999		06500	06500		
7,000		xxxxx ²⁾			
7,001 - 7,499		07000	07000	07000 ¹⁾	07000 ¹⁾
7,500		xxxxx ²⁾			
7,501 - 7,937		07500	07500		
7,938	5/16	xxxxx ²⁾			
7,939 - 7,999		07938	07938		
8,000		xxxxx ²⁾			
8,001 - 8,499		08000	08000	08000	08000
8,500		xxxxx ²⁾			
8,501 - 8,999		08500	08500		
9,000		xxxxx ²⁾			
9,001 - 9,499		09000	09000	09000	09000
9,500		xxxxx ²⁾			
		09500	09500		

¹⁾ Without transverse grooves

²⁾ Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 01506789)!

Pressure collet 145 E / F 25



DCONWS mm	DCONWS inch	 Grooved 145 E / F 25	 Smooth 145 E / F 25	 Grooved 145 E / F 25	 Grooved 145 E / F 25
		CW 81 015 ...	CW 81 017 ...	CW 81 027 ...	CW 81 029 ...
9,501 - 9,999		xxxxx ²⁾			
10,000		10000	10000	10000	10000
10,001 - 10,499		xxxxx ²⁾			
10,500		10500	10500		
10,501 - 10,999		xxxxx ²⁾			
11,000		11000	11000	11000	11000
11,001 - 11,112		xxxxx ²⁾			
11,113	7/16	11113	11113		
11,114 - 11,499		xxxxx ²⁾			
11,500		11500	11500		
11,501 - 11,999		xxxxx ²⁾			
12,000		12000	12000	12000	12000
12,001 - 12,499		xxxxx ²⁾			
12,500		12500	12500		
12,501 - 12,699		xxxxx ²⁾			
12,700	1/2	12700	12700	12700	
12,701 - 12,999		xxxxx ²⁾			
13,000		13000	13000	13000	13000
13,001 - 13,499		xxxxx ²⁾			
13,500		13500	13500		
13,501 - 13,999		xxxxx ²⁾			
14,000		14000	14000	14000	14000
14,001 - 14,499		xxxxx ²⁾			
14,500		14500	14500		
14,501 - 14,999		xxxxx ²⁾			
15,000		15000	15000	15000	15000
15,001 - 15,499		xxxxx ²⁾			
15,500		15500	15500		
15,501 - 15,999		xxxxx ²⁾			
16,000		16000	16000	16000	
16,001 - 16,499		xxxxx ²⁾			
16,500		16500	16500		
16,501 - 16,999		xxxxx ²⁾			
17,000		17000	17000	17000	
17,001 - 17,499		xxxxx ²⁾			
17,500		17500	17500		
17,501 - 17,999		xxxxx ²⁾			
18,000		18000	18000	18000	
18,001 - 18,499		xxxxx ²⁾			
18,500		18500	18500		
18,501 - 18,999		xxxxx ²⁾			
19,000		19000	19000	19000	
19,001 - 19,049		xxxxx ²⁾			
19,050	3/4	19050			
19,051 - 19,499		xxxxx ²⁾			
19,500		19500	19500		
19,501 - 19,999		xxxxx ²⁾			
20,000		20000	20000		

1) Without transverse grooves

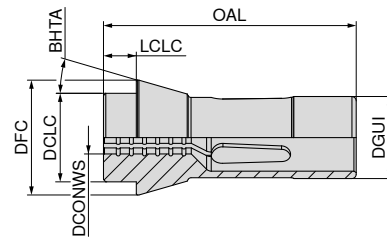
2) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 01506789)!

Pressure collets

Designation	DGUI mm	DFC mm	DCLC mm	LCLC mm	OAL mm	BHTA °
F 37 / 1536 E	37	47	40	10	92	16



Pressure collet F 37 / 1536 E



DCONWS mm	DCONWS inch	Grooved F 37 / 1536 E	Smooth F 37 / 1536 E	Grooved F 37 / 1536 E	Grooved F 37 / 1536 E
1,000		CW 81 023 ...	CW 81 025 ...	CW 81 028 ...	CW 81 030 ...
1,001 - 1,499			01000		
1,500			xxxxx ²⁾		
1,501 - 1,999			01500		
2,000			xxxxx ²⁾		
2,001 - 2,499			02000		
2,500			xxxxx ²⁾		
2,501 - 2,999			02500		
3,000			xxxxx ²⁾		
3,001 - 3,499			03000	03000 ¹⁾	03000 ¹⁾
3,500			xxxxx ²⁾		
3,501 - 3,999			03500		
4,000			xxxxx ²⁾		
4,001 - 4,499			04000	04000 ¹⁾	04000 ¹⁾
4,500			xxxxx ²⁾		
4,501 - 4,999			04500		
5,000			xxxxx ²⁾		
5,001 - 5,499			05000	05000 ¹⁾	05000 ¹⁾
5,500			xxxxx ²⁾		
5,501 - 5,999			05500		
6,000			xxxxx ²⁾		
6,001 - 6,349		06000	06000	06000 ¹⁾	06000 ¹⁾
6,350	1/4	xxxxx ²⁾			
6,351 - 6,499		06350	06350	06350 ¹⁾	06350 ¹⁾
6,500		xxxxx ²⁾			
6,501 - 6,999		06500	06500		
7,000		xxxxx ²⁾			
7,001 - 7,499		07000	07000	07000 ¹⁾	07000 ¹⁾
7,500		xxxxx ²⁾			
7,501 - 7,999		07500	07500		
8,000		xxxxx ²⁾			
8,001 - 8,499		08000	08000	08000	08000
8,500		xxxxx ²⁾			
8,501 - 8,999		08500	08500		
9,000		xxxxx ²⁾			
9,001 - 9,499		09000	09000	09000	09000
9,500		xxxxx ²⁾			
		09500	09500		

¹⁾ Without transverse grooves

²⁾ Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 02306789)!

Pressure collet F 37 / 1536 E



DCONWS mm	DCONWS inch	 Grooved F 37 / 1536 E	 Smooth F 37 / 1536 E	 Grooved F 37 / 1536 E	 Grooved F 37 / 1536 E
		CW 81 023 ...	CW 81 025 ...	CW 81 028 ...	CW 81 030 ...
9,501 - 9,524		xxxxx ²⁾			
9,525	3/8	09525			
9,526 - 9,999		xxxxx ²⁾			
10,000		10000	10000	10000	10000
10,001 - 10,499		xxxxx ²⁾			
10,500		10500	10500		
10,501 - 10,999		xxxxx ²⁾			
11,000		11000	11000	11000	11000
11,001 - 11,499		xxxxx ²⁾			
11,500		11500	11500		
11,501 - 11,999		xxxxx ²⁾			
12,000		12000	12000	12000	12000
12,001 - 12,499		xxxxx ²⁾			
12,500		12500	12500		
12,501 - 12,699		xxxxx ²⁾			
12,700	1/2	12700	12700	12700	12700
12,701 - 12,999		xxxxx ²⁾			
13,000		13000	13000	13000	13000
13,001 - 13,499		xxxxx ²⁾			
13,500		13500	13500		
13,501 - 13,999		xxxxx ²⁾			
14,000		14000	14000	14000	14000
14,001 - 14,499		xxxxx ²⁾			
14,500		14500	14500		
14,501 - 14,999		xxxxx ²⁾			
15,000		15000	15000	15000	15000
15,001 - 15,499		xxxxx ²⁾			
15,500		15500	15500		
15,501 - 15,999		xxxxx ²⁾			
16,000		16000	16000	16000	16000
16,001 - 16,499		xxxxx ²⁾			
16,500		16500	16500		
16,501 - 16,999		xxxxx ²⁾			
17,000		17000	17000	17000	17000
17,001 - 17,499		xxxxx ²⁾			
17,500		17500	17500		
17,501 - 17,999		xxxxx ²⁾			
18,000		18000	18000	18000	18000
18,001 - 18,499		xxxxx ²⁾			
18,500		18500	18500		
18,501 - 18,999		xxxxx ²⁾			
19,000		19000	19000	19000	19000
19,001 - 19,049		xxxxx ²⁾			
19,050	3/4	19050	19050		
19,051 - 19,499		xxxxx ²⁾			
19,500		19500	19500		
19,501 - 19,999		xxxxx ²⁾			
20,000		20000	20000	20000	20000
20,001 - 20,499		xxxxx ²⁾			
20,500		20500	20500		

1) Without transverse grooves

2) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 02306789)!

Pressure collet F 37 / 1536 E



DCONWS mm	DCONWS inch	<div> <div></div> <div>Grooved F 37 / 1536 E</div> </div>	<div> <div></div> <div>Smooth F 37 / 1536 E</div> </div>	<div> <div></div> <div>Grooved F 37 / 1536 E</div> </div>	<div> <div></div> <div>Grooved F 37 / 1536 E</div> </div>
		CW 81 023 ...	CW 81 025 ...	CW 81 028 ...	CW 81 030 ...
20,501 - 20,999		xxxxx ²⁾			
21,000		21000	21000	21000	21000
21,001 - 21,499		xxxxx ²⁾			
21,500		21500	21500		
21,501 - 21,999		xxxxx ²⁾			
22,000		22000	22000	22000	22000
22,001 - 22,224		xxxxx ²⁾			
22,225	7/8	22225			
22,226 - 22,499		xxxxx ²⁾			
22,500		22500	22500		
22,501 - 22,999		xxxxx ²⁾			
23,000		23000	23000	23000	23000
23,001 - 23,499		xxxxx ²⁾			
23,500		23500	23500		
23,501 - 23,999		xxxxx ²⁾			
24,000		24000	24000	24000	
24,001 - 24,499		xxxxx ²⁾			
24,500		24500	24500		
24,501 - 24,999		xxxxx ²⁾			
25,000		25000	25000	25000	
25,001 - 25,499		xxxxx ²⁾			
25,400	1/1			25400	
25,500		25500	25500		
25,501 - 25,999		xxxxx ²⁾			
26,000		26000	26000	26000	
26,001 - 26,499		xxxxx ²⁾			
26,500		26500	26500		
26,501 - 26,999		xxxxx ²⁾			
27,000		27000	27000	27000	
27,001 - 27,499		xxxxx ²⁾			
27,500		27500	27500		
27,501 - 27,999		xxxxx ²⁾			
28,000		28000	28000		
28,001 - 28,499		xxxxx ²⁾			
28,500		28500	28500		
28,501 - 28,999		xxxxx ²⁾			
29,000		29000	29000		
29,001 - 29,499		xxxxx ²⁾			
29,500		29500	29500		
29,501 - 29,999		xxxxx ²⁾			
30,000		30000	30000		
30,001 - 30,499		xxxxx ²⁾			
30,500		30500	30500		
30,501 - 30,999		xxxxx ²⁾			
31,000		31000	31000		
31,001 - 31,499		xxxxx ²⁾			
31,500		31500	31500		
31,501 - 31,999		xxxxx ²⁾			
32,000		32000	32000		

1) Without transverse grooves

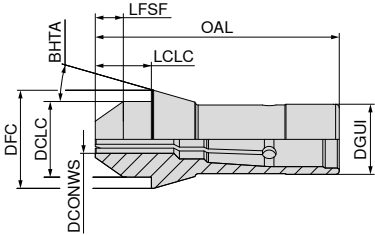
2) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 02306789)!

Stem collets

Designation	DGUI mm	DFC mm	DCLC mm	LCLC mm	OAL mm	BHTA °	LFSF mm
116 E / F 13	13	19	13	12	70	16	6
120 E / F 15	15	21	15	13	71	16	7
120 E / F 15	15	21	15	15	73	16	9



Stem collet 116 E / F 13



Smooth
116 E / F 13

DCONWS mm
1
2
3
4
5
6
7

CW
81 001 ...
01000
02000
03000
04000
05000
06000
07000

Stem collet 120 E / F 15



Smooth
120 E / F 15
LFSF = 7 mm

Smooth
120 E / F 15
LFSF = 9 mm

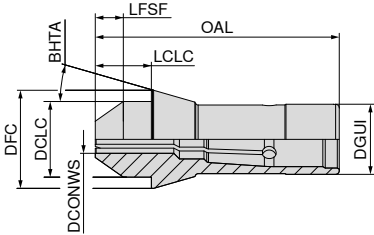
DCONWS mm
1
2
3
4
5
6
7
8

CW
81 004 ...
01000
02000
03000
04000
05000
06000
07000
08000

CW
81 006 ...
01000
02000
03000
04000
05000
06000
07000
08000

Stem collets

Designation	DGUI mm	DFC mm	DCLC mm	LCLC mm	OAL mm	BHTA °	LFSF mm
136 E / F 20-201	20	26	19	13	62	15	8
136 E / F 20-201	20	26	19	15	64	15	10



Stem collet 136 E / F 20-201



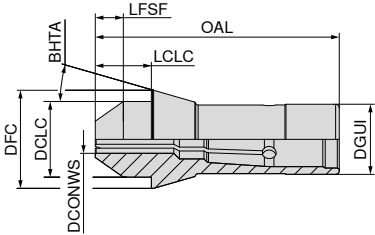
● Smooth	● Smooth
136 E / F 20-201	136 E / F 20-201
LFSF = 8 mm	LFSF = 10 mm

DCONWS mm
1
2
3
4
5
6
7
8
9
10
11
12
13
14

CW	CW
81 008 ...	81 010 ...
01000	01000
02000	02000
03000	03000
04000	04000
05000	05000
06000	06000
07000	07000
08000	08000
09000	09000
10000	10000
11000	11000
12000	12000
	13000
	14000

Stem collets

Designation	DGUI mm	DFC mm	DCLC mm	LCLC mm	OAL mm	BHTA °	LFSF mm
145 E / F 25	25	35	27	20	87	16	10
145 E / F 25	25	35	27	25	92	16	15



Stem collet 145 E / F 25

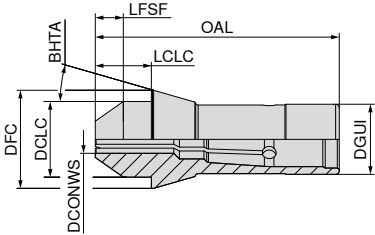


	
Smooth	Smooth
145 E / F 25	145 E / F 25
LFSF = 10 mm	LFSF = 15 mm

DCONWS mm	CW	CW
1	81 016 ...	81 018 ...
2	01000	01000
3	02000	02000
4	03000	03000
5	04000	04000
6	05000	05000
7	06000	06000
8	07000	07000
9	08000	08000
10	09000	09000
11	10000	10000
12	11000	11000
13	12000	12000
14	13000	13000
15	14000	14000
16	15000	15000
17	16000	16000
18	17000	17000
19	18000	18000
20	19000	19000
	20000	20000

Stem collets

Designation	DGUI mm	DFC mm	DCLC mm	LCLC mm	OAL mm	BHTA °	LFSF mm
F 16 / 1212 E	16	21	16	13	71	16	7
F 16 / 1212 E	16	21	16	15	73	16	9
138 E / F20-87	20	28	21	15	78	16	8
138 E / F20-87	20	28	21	20	80	16	13



Stem collet F 16 / 1212 E



● Smooth	● Smooth
F 16 / 1212 E	F 16 / 1212 E
LFSF = 7 mm	LFSF = 9 mm
CW	CW
81 020 ...	81 022 ...
01000	01000
02000	02000
03000	03000
04000	04000
05000	05000
06000	06000
07000	07000
08000	08000
09000	09000

DCONWS mm
1
2
3
4
5
6
7
8
9

Stem collet 138 E / F 20-87



● Smooth	● Smooth
138 E / F20-87	138 E / F20-87
LFSF = 8 mm	LFSF = 13 mm
CW	CW
81 012 ...	81 014 ...
01000	01000
02000	02000
03000	03000
04000	04000
05000	05000
06000	06000
07000	07000
08000	08000

DCONWS mm
1
2
3
4
5
6
7
8

Stem collet 138 E / F 20-87

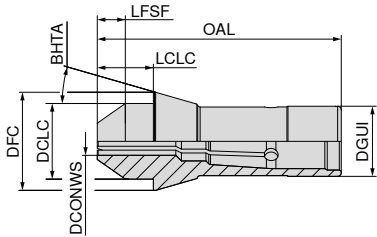


	
Smooth	Smooth
138 E / F20-87	138 E / F20-87
LFSF = 8 mm	LFSF = 13 mm

DCONWS		CW	CW
mm		81 012 ...	81 014 ...
9		09000	09000
10		10000	10000
11		11000	11000
12		12000	12000

Stem collets

Designation	DGUI	DFC	DCLC	LCLC	OAL	BHTA	LFSF
F 37 / 1536 E	mm37	mm47	mm40	mm25	mm107	°16	mm15



Stem collet F 37 / 1536 E



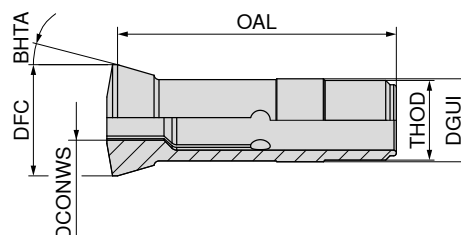
Smooth
F 37 / 1536 E

DCONWS mm
1
2
3
4
5
6
7
8
9
10
11
12
13
14
15
16
17
18
19
20
21
22
23
24
25
26
27
28

CW
81 024 ...
01000
02000
03000
04000
05000
06000
07000
08000
09000
10000
11000
12000
13000
14000
15000
16000
17000
18000
19000
20000
21000
22000
23000
24000
25000
26000
27000
28000

Adjustable guide bushes

Designation	DGUI mm	DFC mm	OAL mm	BHTA °	THOD
T 223	28	34	82	16	M25 x 1



Adjustable guide bush T 223

▲ With carbide insert



DCONWS mm	DCONWS inch	T 223 CW	T 223 CW	T 223 CW
1,000		81 037 ... 01000		
1,001 - 1,499		xxxxx ¹⁾ 01500		
1,500		xxxxx ¹⁾ 02000		
1,501 - 1,999		xxxxx ¹⁾ 02500		
2,000		xxxxx ¹⁾ 03000		
2,001 - 2,499		xxxxx ¹⁾ 03500		
2,500		xxxxx ¹⁾ 04000		
2,501 - 2,999		xxxxx ¹⁾ 04500		
3,000		xxxxx ¹⁾ 05000		
3,001 - 3,499		xxxxx ¹⁾ 05500		
3,500		xxxxx ¹⁾ 06000		
3,501 - 3,999		xxxxx ¹⁾ 06350		
4,000		xxxxx ¹⁾ 06500		
4,001 - 4,499		xxxxx ¹⁾ 07000		
4,500		xxxxx ¹⁾ 07500		
4,501 - 4,999		xxxxx ¹⁾ 08000		
5,000		xxxxx ¹⁾ 08500		
5,001 - 5,499		xxxxx ¹⁾ 09000		
5,500		xxxxx ¹⁾ 09500		
5,501 - 5,999		xxxxx ¹⁾ 09525		
6,000		xxxxx ¹⁾ 10000		
6,001 - 6,349		xxxxx ¹⁾ 10500		
6,350	1/4	xxxxx ¹⁾		
6,351 - 6,499		xxxxx ¹⁾		
6,500		xxxxx ¹⁾		
6,501 - 6,999		xxxxx ¹⁾		
7,000		xxxxx ¹⁾		
7,001 - 7,499		xxxxx ¹⁾		
7,500		xxxxx ¹⁾		
7,501 - 7,999		xxxxx ¹⁾		
7,938	5/16	xxxxx ¹⁾		
8,000		xxxxx ¹⁾		
8,001 - 8,499		xxxxx ¹⁾		
8,500		xxxxx ¹⁾		
8,501 - 8,999		xxxxx ¹⁾		
9,000		xxxxx ¹⁾		
9,001 - 9,499		xxxxx ¹⁾		
9,500		xxxxx ¹⁾		
9,501 - 9,999		xxxxx ¹⁾		
9,525	3/8	xxxxx ¹⁾		
10,000		xxxxx ¹⁾		
10,001 - 10,499		xxxxx ¹⁾		
10,500		xxxxx ¹⁾		
10,501 - 10,999		xxxxx ¹⁾		

1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 03706789)!

Adjustable guide bush T 223

▲ With carbide insert



DCONWS mm	DCONWS inch	T 223	T 223	T 223
		CW	CW	CW
11,000		81 037 ...	81 038 ...	81 039 ...
11,001 - 11,499		11000	11000	11000
11,500		xxxxx ¹⁾		
11,501 - 11,999		11500		
12,000		xxxxx ¹⁾		
12,001 - 12,499		12000	12000	12000
12,500		xxxxx ¹⁾		
12,501 - 12,699		12500		
12,700	1/2	xxxxx ¹⁾		
12,701 - 12,999		12700	12700	
13,000		xxxxx ¹⁾		
13,001 - 13,499		13000	13000	13000
13,500		xxxxx ¹⁾		
13,501 - 13,999		13500		
14,000		xxxxx ¹⁾		
14,001 - 14,499		14000	14000	14000
14,500		xxxxx ¹⁾		
14,501 - 14,999		14500		
15,000		xxxxx ¹⁾		
15,001 - 15,499		15000	15000	
15,500		xxxxx ¹⁾		
15,501 - 15,999		15500		
16,000		xxxxx ¹⁾		
16,001 - 16,499		16000	16000	
16,500		xxxxx ¹⁾		
16,501 - 16,999		16500		
17,000		xxxxx ¹⁾		
17,001 - 17,499		17000	17000	
17,500		xxxxx ¹⁾		
17,501 - 17,999		17500		
18,000		xxxxx ¹⁾		
18,001 - 18,499		18000		
18,500		xxxxx ¹⁾		
18,501 - 18,999		18500		
19,000		xxxxx ¹⁾		
19,001 - 19,499		19000		
19,500		xxxxx ¹⁾		
19,501 - 19,999		19500		
20,000		xxxxx ¹⁾		
20,001 - 20,499		20000		
20,500		xxxxx ¹⁾		
20,501 - 20,999		20500		
21,000		xxxxx ¹⁾		
21,001 - 21,499		21000		
21,500		xxxxx ¹⁾		
21,501 - 21,999		21500		
22,000		xxxxx ¹⁾		
		22000		

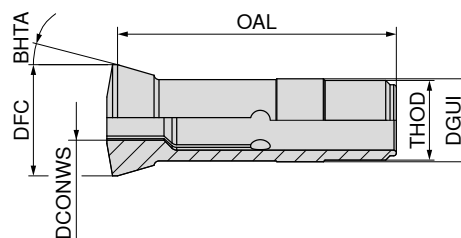
1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 03706789)!

Adjustable guide bushes

Designation	DGUI mm	DFC mm	OAL mm	BHTA °	THOD
T 227	34	41	87.5	10	M34 x 1



Adjustable guide bush T 227

▲ With carbide insert



T 227

DCONWS mm	DCONWS inch		CW
1,000			81 040 ...
1,001 - 1,499			01000
1,500			xxxxx ¹⁾
1,501 - 1,999			01500
2,000			xxxxx ¹⁾
2,001 - 2,499			02000
2,500			xxxxx ¹⁾
2,501 - 2,999			02500
3,000			xxxxx ¹⁾
3,001 - 3,499			03000
3,500			xxxxx ¹⁾
3,501 - 3,999			03500
4,000			xxxxx ¹⁾
4,001 - 4,499			04000
4,500			xxxxx ¹⁾
4,501 - 4,999			04500
5,000			xxxxx ¹⁾
5,001 - 5,499			05000
5,500			xxxxx ¹⁾
5,501 - 5,999			05500
6,000			xxxxx ¹⁾
6,001 - 6,349			06000
6,350	1/4		xxxxx ¹⁾
6,351 - 6,499			06350
6,500			xxxxx ¹⁾
6,501 - 6,999			06500
7,000			xxxxx ¹⁾
7,001 - 7,499			07000
7,500			xxxxx ¹⁾
7,501 - 7,999			07500
8,000			xxxxx ¹⁾
8,001 - 8,499			08000
8,500			xxxxx ¹⁾
8,501 - 8,999			08500
9,000			xxxxx ¹⁾
9,001 - 9,499			09000
9,500			xxxxx ¹⁾
9,501 - 9,999			09500
10,000			xxxxx ¹⁾
10,001 - 10,499			10000
10,500			xxxxx ¹⁾
10,501 - 10,999			10500
11,000			xxxxx ¹⁾
11,001 - 11,499			11000
			xxxxx ¹⁾

1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 04006789)!

Adjustable guide bush T 227

▲ With carbide insert



T 227

DCONWS mm	DCONWS inch	CW 81 040 ...
11,500		11500
11,501 - 11,999		xxxxx ¹⁾
12,000		12000
12,001 - 12,499		xxxxx ¹⁾
12,500		12500
12,501 - 12,699		xxxxx ¹⁾
12,700	1/2	12700
12,701 - 12,999		xxxxx ¹⁾
13,000		13000
13,001 - 13,499		xxxxx ¹⁾
13,500		13500
13,501 - 13,999		xxxxx ¹⁾
14,000		14000
14,001 - 14,499		xxxxx ¹⁾
14,500		14500
14,501 - 14,999		xxxxx ¹⁾
15,000		15000
15,001 - 15,499		xxxxx ¹⁾
15,500		15500
15,501 - 15,999		xxxxx ¹⁾
16,000		16000
16,001 - 16,499		xxxxx ¹⁾
16,500		16500
16,501 - 16,999		xxxxx ¹⁾
17,000		17000
17,001 - 17,499		xxxxx ¹⁾
17,500		17500
17,501 - 17,999		xxxxx ¹⁾
18,000		18000
18,001 - 18,499		xxxxx ¹⁾
18,500		18500
18,501 - 18,999		xxxxx ¹⁾
19,000		19000
19,001 - 19,499		xxxxx ¹⁾
19,500		19500
19,501 - 19,999		xxxxx ¹⁾
20,000		20000
20,001 - 20,499		xxxxx ¹⁾
20,500		20500
20,501 - 20,999		xxxxx ¹⁾
21,000		21000
21,001 - 21,499		xxxxx ¹⁾
21,500		21500
21,501 - 21,999		xxxxx ¹⁾
22,000		22000
22,001 - 22,499		xxxxx ¹⁾
22,500		22500
22,501 - 22,999		xxxxx ¹⁾
23,000		23000
23,001 - 23,499		xxxxx ¹⁾
23,500		23500
23,501 - 23,999		xxxxx ¹⁾
24,000		24000
24,001 - 24,499		xxxxx ¹⁾
24,500		24500
24,501 - 24,999		xxxxx ¹⁾
25,000		25000

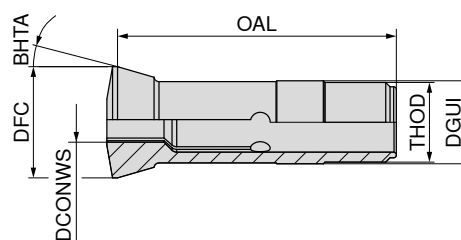
1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 04006789)!

Adjustable guide bushes

Designation	DGUI mm	DFC mm	OAL mm	BHTA °	THOD
T 229	42	49	82	16	M40 x 1



Adjustable guide bush T 229

▲ With carbide insert



●
T 229

⬡
T 229

DCONWS mm	DCONWS inch	CW 81 041 ...	CW 81 042 ...
2,000		02000	
2,001 - 2,499		xxxxx ¹⁾	
2,500		02500	
2,501 - 2,999		xxxxx ¹⁾	
3,000		03000	
3,001 - 3,499		xxxxx ¹⁾	
3,500		03500	
3,501 - 3,999		xxxxx ¹⁾	
4,000		04000	04000
4,001 - 4,499		xxxxx ¹⁾	
4,500		04500	
4,501 - 4,999		xxxxx ¹⁾	
5,000		05000	05000
5,001 - 5,499		xxxxx ¹⁾	
5,500		05500	
5,501 - 5,999		xxxxx ¹⁾	
6,000		06000	06000
6,001 - 6,349		xxxxx ¹⁾	
6,350	1/4	06350	06350
6,351 - 6,499		xxxxx ¹⁾	
6,500		06500	
6,501 - 6,999		xxxxx ¹⁾	
7,000		07000	07000
7,001 - 7,499		xxxxx ¹⁾	
7,500		07500	
7,501 - 7,999		xxxxx ¹⁾	
8,000		08000	08000
8,001 - 8,499		xxxxx ¹⁾	
8,500		08500	
8,501 - 8,999		xxxxx ¹⁾	
9,000		09000	09000
9,001 - 9,499		xxxxx ¹⁾	
9,500		09500	
9,501 - 9,524		xxxxx ¹⁾	
9,525	3/8	09525	
9,526 - 9,999		xxxxx ¹⁾	
10,000		10000	10000
10,001 - 10,499		xxxxx ¹⁾	
10,500		10500	
10,501 - 10,999		xxxxx ¹⁾	
11,000		11000	11000
11,001 - 11,499		xxxxx ¹⁾	
11,500		11500	
11,501 - 11,999		xxxxx ¹⁾	

¹⁾ Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., **Ø 6.789** – article number 81 041**06789**)!

Adjustable guide bush T 229

▲ With carbide insert



T 229

T 229

DCONWS mm	DCONWS inch	CW 81 041 ...	CW 81 042 ...
12,000		12000	12000
12,001 - 12,499		xxxxx ¹⁾	
12,500		12500	
12,501 - 12,699		xxxxx ¹⁾	
12,700	1/2	12700	
12,701 - 12,999		xxxxx ¹⁾	
13,000		13000	13000
13,001 - 13,499		xxxxx ¹⁾	
13,500		13500	
13,501 - 13,999		xxxxx ¹⁾	
14,000		14000	14000
14,001 - 14,499		xxxxx ¹⁾	
14,500		14500	
14,501 - 14,999		xxxxx ¹⁾	
15,000		15000	15000
15,001 - 15,499		xxxxx ¹⁾	
15,500		15500	
15,501 - 15,999		xxxxx ¹⁾	
16,000		16000	16000
16,001 - 16,499		xxxxx ¹⁾	
16,500		16500	
16,501 - 16,999		xxxxx ¹⁾	
17,000		17000	17000
17,001 - 17,499		xxxxx ¹⁾	
17,500		17500	
17,501 - 17,999		xxxxx ¹⁾	
18,000		18000	18000
18,001 - 18,499		xxxxx ¹⁾	
18,500		18500	
18,501 - 18,999		xxxxx ¹⁾	
19,000		19000	19000
19,001 - 19,049		xxxxx ¹⁾	
19,050	3/4	19050	
19,051 - 19,499		xxxxx ¹⁾	
19,500		19500	
19,501 - 19,999		xxxxx ¹⁾	
20,000		20000	20000
20,001 - 20,499		xxxxx ¹⁾	
20,500		20500	
20,501 - 20,999		xxxxx ¹⁾	
21,000		21000	21000
21,001 - 21,499		xxxxx ¹⁾	
21,500		21500	
21,501 - 21,999		xxxxx ¹⁾	
22,000		22000	22000
22,001 - 22,224		xxxxx ¹⁾	
22,225	7/8	22225	
22,226 - 22,499		xxxxx ¹⁾	
22,500		22500	
22,501 - 22,999		xxxxx ¹⁾	
23,000		23000	23000
23,001 - 23,499		xxxxx ¹⁾	
23,500		23500	
23,501 - 23,999		xxxxx ¹⁾	
24,000		24000	24000
24,001 - 24,499		xxxxx ¹⁾	
24,500		24500	
24,501 - 24,999		xxxxx ¹⁾	
25,000		25000	25000

1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 04106789)!

Adjustable guide bush T 229

▲ With carbide insert



T 229

T 229

DCONWS		CW	
mm	inch	81 041 ...	81 042 ...
25,001 - 25,499		xxxxx ¹⁾	
25,500		25500	
25,501 - 25,999		xxxxx ¹⁾	
26,000		26000	26000
26,001 - 26,499		xxxxx ¹⁾	
26,500		26500	
26,501 - 26,999		xxxxx ¹⁾	
27,000		27000	27000
27,001 - 27,499		xxxxx ¹⁾	
27,500		27500	
27,501 - 27,999		xxxxx ¹⁾	
28,000		28000	
28,001 - 28,499		xxxxx ¹⁾	
28,500		28500	
28,501 - 28,999		xxxxx ¹⁾	
29,000		29000	
29,001 - 29,499		xxxxx ¹⁾	
29,500		29500	
29,501 - 29,999		xxxxx ¹⁾	
30,000		30000	
30,001 - 30,499		xxxxx ¹⁾	
30,500		30500	
30,501 - 30,999		xxxxx ¹⁾	
31,000		31000	
31,001 - 31,499		xxxxx ¹⁾	
31,500		31500	
31,501 - 31,999		xxxxx ¹⁾	
32,000		32000	

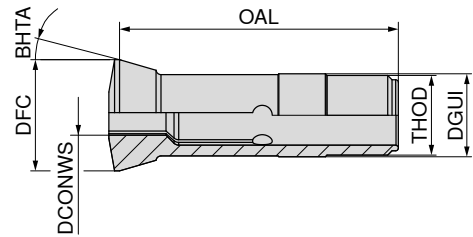
1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g.,Ø 6.789– article number 81 04106789)!

Adjustable guide bushes

Designation	DGUI mm	DFC mm	OAL mm	BHTA °	THOD
I 353 SR	16	19.5	56.79	16	M14 x 1



Adjustable guide bush I 353 SR

- ▲ For Star* CNC sliding head lathes
- ▲ With carbide insert



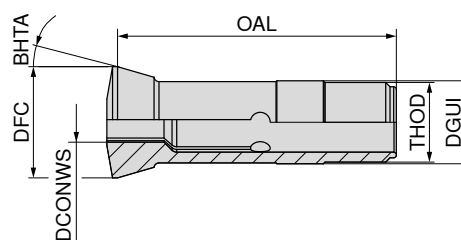
I 353 SR

DCONWS mm
1.0
1.5
2.0
2.5
3.0
3.5
4.0
4.5
5.0
5.5
6.0
6.5
7.0
7.5
8.0
8.5
9.0
9.5
10.0
10.5

CW
81 035 ...
01000
01500
02000
02500
03000
03500
04000
04500
05000
05500
06000
06500
07000
07500
08000
08500
09000
09500
10000
10500

Adjustable guide bushes

Designation	DGUI mm	DFC mm	OAL mm	BHTA °	THOD
I 357	28	38	81	30	M25 x 1



Adjustable guide bush I 357

▲ With carbide insert



I 357

DCONWS mm	DCONWS inch	CW
2,000		81 036 ... 02000
2,001 - 2,499		xxxxx ¹⁾
2,500		02500
2,501 - 2,999		xxxxx ¹⁾
3,000		03000
3,001 - 3,174		xxxxx ¹⁾
3,175	1/8	03175
3,176 - 3,499		xxxxx ¹⁾
3,500		03500
3,501 - 3,999		xxxxx ¹⁾
4,000		04000
4,001 - 4,499		xxxxx ¹⁾
4,500		04500
4,501 - 4,999		xxxxx ¹⁾
5,000		05000
5,001 - 5,499		xxxxx ¹⁾
5,500		05500
5,501 - 5,999		xxxxx ¹⁾
6,000		06000
6,001 - 6,499		xxxxx ¹⁾
6,500		06500
6,501 - 6,999		xxxxx ¹⁾
7,000		07000
7,001 - 7,143		xxxxx ¹⁾
7,144	9/32	07144
7,145 - 7,499		xxxxx ¹⁾
7,500		07500
7,501 - 7,999		xxxxx ¹⁾
8,000		08000
8,001 - 8,499		xxxxx ¹⁾
8,500		08500
8,501 - 8,999		xxxxx ¹⁾
9,000		09000
9,001 - 9,499		xxxxx ¹⁾
9,500		09500
9,501 - 9,999		xxxxx ¹⁾
10,000		10000
10,001 - 10,499		xxxxx ¹⁾

¹⁾ Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 03606789)!

Adjustable guide bush I 357

▲ With carbide insert



I 357

DCONWS mm	DCONWS inch	CW 81 036 ...
10,500		10500
10,501 - 10,999		xxxxx ¹⁾
11,000		11000
11,001 - 11,499		xxxxx ¹⁾
11,500		11500
11,501 - 11,999		xxxxx ¹⁾
12,000		12000
12,001 - 12,499		xxxxx ¹⁾
12,500		12500
12,501 - 12,699		xxxxx ¹⁾
12,700	1/2	12700
12,701 - 12,999		xxxxx ¹⁾
13,000		13000
13,001 - 13,499		xxxxx ¹⁾
13,500		13500
13,501 - 13,999		xxxxx ¹⁾
14,000		14000
14,001 - 14,499		xxxxx ¹⁾
14,500		14500
14,501 - 14,999		xxxxx ¹⁾
15,000		15000
15,001 - 15,499		xxxxx ¹⁾
15,500		15500
15,501 - 15,999		xxxxx ¹⁾
16,000		16000
16,001 - 16,499		xxxxx ¹⁾
16,500		16500
16,501 - 16,999		xxxxx ¹⁾
17,000		17000
17,001 - 17,499		xxxxx ¹⁾
17,500		17500
17,501 - 17,999		xxxxx ¹⁾
18,000		18000
18,001 - 18,499		xxxxx ¹⁾
18,500		18500
18,501 - 18,999		xxxxx ¹⁾
19,000		19000
19,001 - 19,499		xxxxx ¹⁾
19,500		19500
19,501 - 19,999		xxxxx ¹⁾
20,000		20000
20,001 - 20,499		xxxxx ¹⁾
20,500		20500
20,501 - 20,999		xxxxx ¹⁾
21,000		21000
21,001 - 21,499		xxxxx ¹⁾
21,500		21500
21,501 - 21,999		xxxxx ¹⁾
22,000		22000

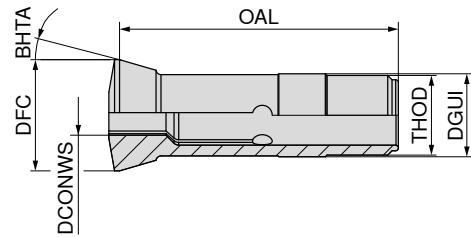
1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 03606789)!

Adjustable guide bushes

Designation	DGUI mm	DFC mm	OAL mm	BHTA °	THOD
F 391	22	29	68	16	M22 x 1



Adjustable guide bush F 391

▲ With carbide insert



F 391

DCONWS mm	DCONWS inch
1,000	
1,001 - 1,499	
1,500	
1,501 - 1,999	
2,000	
2,001 - 2,499	
2,500	
2,501 - 2,999	
3,000	
3,001 - 3,499	
3,500	
3,501 - 3,999	
4,000	
4,001 - 4,499	
4,500	
4,501 - 4,999	
5,000	
5,001 - 5,499	
5,500	
5,501 - 5,999	
6,000	
6,001 - 6,349	
6,350	1/4
6,351 - 6,499	
6,500	
6,501 - 6,999	
7,000	
7,001 - 7,499	
7,500	
7,501 - 7,999	
8,000	
8,001 - 8,499	
8,500	
8,501 - 8,999	
9,000	
9,001 - 9,499	
9,500	
9,501 - 9,999	

CW
81 032 ...
01000
xxxxx ¹⁾
01500
xxxxx ¹⁾
02000
xxxxx ¹⁾
02500
xxxxx ¹⁾
03000
xxxxx ¹⁾
03500
xxxxx ¹⁾
04000
xxxxx ¹⁾
04500
xxxxx ¹⁾
05000
xxxxx ¹⁾
05500
xxxxx ¹⁾
06000
xxxxx ¹⁾
06350
xxxxx ¹⁾
06500
xxxxx ¹⁾
07000
xxxxx ¹⁾
07500
xxxxx ¹⁾
08000
xxxxx ¹⁾
08500
xxxxx ¹⁾
09000
xxxxx ¹⁾
09500
xxxxx ¹⁾

1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 03206789)!

Adjustable guide bush F 391

▲ With carbide insert



F 391

DCONWS mm	DCONWS inch	CW 81 032 ...
10,000		10000
10,001 - 10,499		xxxxx ¹⁾
10,500		10500
10,501 - 10,999		xxxxx ¹⁾
11,000		11000
11,001 - 11,499		xxxxx ¹⁾
11,500		11500
11,501 - 11,999		xxxxx ¹⁾
12,000		12000
12,001 - 12,499		xxxxx ¹⁾
12,500		12500
12,501 - 12,699		xxxxx ¹⁾
12,700	1/2	12700
12,701 - 12,999		xxxxx ¹⁾
13,000		13000
13,001 - 13,499		xxxxx ¹⁾
13,500		13500
13,501 - 13,999		xxxxx ¹⁾
14,000		14000
14,001 - 14,499		xxxxx ¹⁾
14,500		14500
14,501 - 14,999		xxxxx ¹⁾
15,000		15000
15,001 - 15,499		xxxxx ¹⁾
15,500		15500
15,501 - 15,999		xxxxx ¹⁾
16,000		16000
16,001 - 16,499		xxxxx ¹⁾
16,500		16500
16,501 - 16,999		xxxxx ¹⁾
17,000		17000
17,001 - 17,499		xxxxx ¹⁾
17,500		17500
17,501 - 17,999		xxxxx ¹⁾
18,000		18000

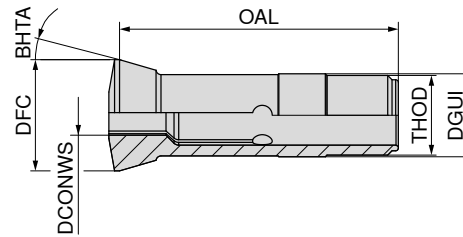
1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 03206789)!

Adjustable guide bushes

Designation	DGUI mm	DFC mm	OAL mm	BHTA °	THOD
F 605	24	29.5	61	30	M24 x 1



Adjustable guide bush F 605

▲ With carbide insert



F 605

DCONWS mm	DCONWS inch	CW
1,000		81 033 ... 01000
1,001 - 1,499		xxxxx ¹⁾
1,500		01500
1,501 - 1,999		xxxxx ¹⁾
2,000		02000
2,001 - 2,499		xxxxx ¹⁾
2,500		02500
2,501 - 2,999		xxxxx ¹⁾
3,000		03000
3,001 - 3,174		xxxxx ¹⁾
3,175	1/8	03175
3,176 - 3,499		xxxxx ¹⁾
3,500		03500
3,501 - 3,999		xxxxx ¹⁾
4,000		04000
4,001 - 4,499		xxxxx ¹⁾
4,500		04500
4,501 - 4,762		xxxxx ¹⁾
4,763	3/16	04763
4,764 - 4,999		xxxxx ¹⁾
5,000		05000
5,001 - 5,499		xxxxx ¹⁾
5,500		05500
5,501 - 5,999		xxxxx ¹⁾
6,000		06000
6,001 - 6,349		xxxxx ¹⁾
6,350	1/4	06350
6,351 - 6,499		xxxxx ¹⁾
6,500		06500
6,501 - 6,999		xxxxx ¹⁾
7,000		07000
7,001 - 7,499		xxxxx ¹⁾
7,500		07500
7,501 - 7,999		xxxxx ¹⁾
8,000		08000
8,001 - 8,499		xxxxx ¹⁾
8,500		08500
8,501 - 8,999		xxxxx ¹⁾

¹⁾ Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 03306789)!

Adjustable guide bush F 605

▲ With carbide insert



F 605

DCONWS mm	DCONWS inch	CW 81 033 ...
9,000		09000
9,001 - 9,499		xxxxx ¹⁾
9,500		09500
9,501 - 9,999		xxxxx ¹⁾
10,000		10000
10,001 - 10,499		xxxxx ¹⁾
10,500		10500
10,501 - 10,999		xxxxx ¹⁾
11,000		11000
11,001 - 11,499		xxxxx ¹⁾
11,500		11500
11,501 - 11,999		xxxxx ¹⁾
12,000		12000
12,001 - 12,499		xxxxx ¹⁾
12,500		12500
12,501 - 12,699		xxxxx ¹⁾
12,700	1/2	12700
12,701 - 12,999		xxxxx ¹⁾
13,000		13000
13,001 - 13,499		xxxxx ¹⁾
13,500		13500
13,501 - 13,999		xxxxx ¹⁾
14,000		14000
14,001 - 14,499		xxxxx ¹⁾
14,500		14500
14,501 - 14,999		xxxxx ¹⁾
15,000		15000
15,001 - 15,499		xxxxx ¹⁾
15,500		15500
15,501 - 15,999		xxxxx ¹⁾
16,000		16000
16,001 - 16,499		xxxxx ¹⁾
16,500		16500
16,501 - 16,999		xxxxx ¹⁾
17,000		17000

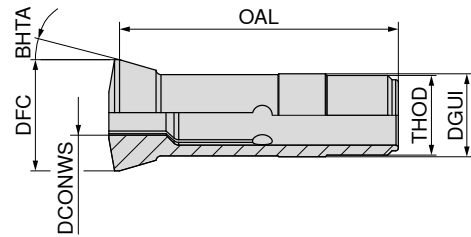
1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g.,Ø 6.789– article number 81 03306789)!

Adjustable guide bushes

Designation	DGUI mm	DFC mm	OAL mm	BHTA °	THOD
F 853	18	22	60	30	M16 x 1



Adjustable guide bush F 853

▲ With carbide insert



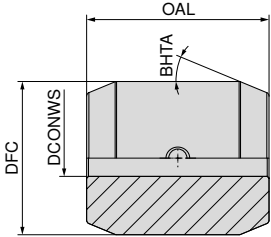
F 853

DCONWS mm
1.0
1.5
2.0
2.5
3.0
3.5
4.0
4.5
5.0
5.5
6.0
6.5
7.0
7.5
8.0
8.5
9.0
9.5
10.0
10.5
11.0
11.5
12.0
12.5
13.0

CW
81 034 ...
01000
01500
02000
02500
03000
03500
04000
04500
05000
05500
06000
06500
07000
07500
08000
08500
09000
09500
10000
10500
11000
11500
12000
12500
13000

Flexible guide bushes

Designation	DFC mm	OAL mm	BHTA °
GBE 28	28	40	22.5



Guide bush GBE 28



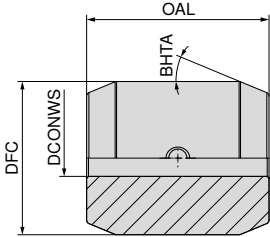
GBE 28

DCONWS mm	DCONWS inch
3.000	
4.000	
5.000	
6.000	
6.350	1/4
7.000	
8.000	
9.000	
9.525	3/8
10.000	
11.000	
12.000	
12.700	1/2
13.000	
14.000	
15.000	
16.000	
17.000	
18.000	
19.000	
19.050	3/4
20.000	

CW
81 059 ...
03000
04000
05000
06000
06350
07000
08000
09000
09525
10000
11000
12000
12700
13000
14000
15000
16000
17000
18000
19000
19050
20000

Flexible guide bushes

Designation	DFC mm	OAL mm	BHTA °
GBE 42	42	50	22.5



Guide bush GBE 42



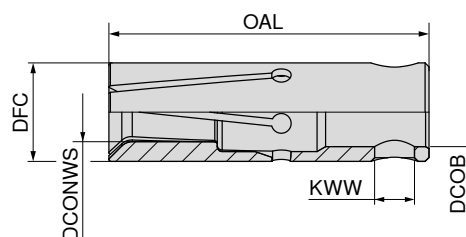
GBE 42

DCONWS mm	DCONWS inch
3.000	
4.000	
5.000	
6.000	
6.350	1/4
7.000	
8.000	
9.000	
10.000	
11.000	
12.000	
12.700	1/2
13.000	
14.000	
15.000	
15.875	5/8
16.000	
17.000	
18.000	
19.000	
19.050	3/4
20.000	
21.000	
22.000	
22.225	7/8
23.000	
24.000	
25.000	
25.400	1/1
26.000	
27.000	
28.000	
29.000	
30.000	
31.000	
32.000	

CW
81 060 ...
03000
04000
05000
06000
06350
07000
08000
09000
10000
11000
12000
12700
13000
14000
15000
15880
16000
17000
18000
19000
19050
20000
21000
22000
22225
23000
24000
25000
25400
26000
27000
28000
29000
30000
31000
32000

Clamping sleeves

Designation	Slide Ø	DFC mm	KWW mm	DCOB _{H7} mm	OAL mm
S 10 / 210 E	D 10	10	4	7	40



Clamping sleeve S 10 / 210 E

▲ Also suitable for all INDEX multi-spindle machines



● S 10 / 210 E

⬡ S 10 / 210 E

DCONWS mm	DCONWS inch	CW 81 043 ...	CW 81 044 ...
3,000		03000	03000
3,001 - 3,499		xxxxx ¹⁾	
3,500		03500	
3,501 - 3,999		xxxxx ¹⁾	
4,000		04000	04000
4,001 - 4,499		xxxxx ¹⁾	
4,500		04500	
4,501 - 4,999		xxxxx ¹⁾	
5,000		05000	05000
5,001 - 5,499		xxxxx ¹⁾	
5,500		05500	
5,501 - 5,999		xxxxx ¹⁾	
6,000		06000	06000
6,001 - 6,349		xxxxx ¹⁾	
6,350	1/4	06350	
6,351 - 6,499		xxxxx ¹⁾	
6,500		06500	
6,501 - 6,999		xxxxx ¹⁾	
7,000		07000	07000
7,001 - 7,143		xxxxx ¹⁾	
7,144	9/32	07144	
7,145 - 7,499		xxxxx ¹⁾	
7,500		07500	
7,501 - 7,937		xxxxx ¹⁾	
7,938	5/16	07938	
7,939 - 7,999		xxxxx ¹⁾	
8,000		08000	08000
8,001 - 8,499		xxxxx ¹⁾	
8,500		08500	
8,501 - 8,999		xxxxx ¹⁾	
9,000		09000	
9,001 - 9,499		xxxxx ¹⁾	
9,500		09500	
9,501 - 9,999		xxxxx ¹⁾	
10,000		10000	

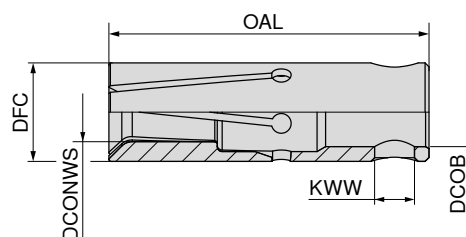
1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 04306789)!

Clamping sleeves

Designation	Slide Ø	DFC mm	KWW mm	DCOB _{H7} mm	OAL mm
S 12 / 212 E	D 12	12	4	8	40



Clamping sleeve S 12 / 212 E

▲ Also suitable for all INDEX multi-spindle machines



● S 12 / 212 E

⬡ S 12 / 212 E

DCONWS mm	DCONWS inch	CW 81 045 ...	CW 81 046 ...
3,000		03000	03000
3,001 - 3,499		xxxxx ¹⁾	
3,500		03500	
3,501 - 3,999		xxxxx ¹⁾	
4,000		04000	04000
4,001 - 4,499		xxxxx ¹⁾	
4,500		04500	
4,501 - 4,762		xxxxx ¹⁾	
4,763	3/16	04763	
4,764 - 4,999		xxxxx ¹⁾	
5,000		05000	05000
5,001 - 5,499		xxxxx ¹⁾	
5,500		05500	
5,501 - 5,999		xxxxx ¹⁾	
6,000		06000	06000
6,001 - 6,349		xxxxx ¹⁾	
6,350	1/4	06350	06350
6,351 - 6,499		xxxxx ¹⁾	
6,500		06500	
6,501 - 6,999		xxxxx ¹⁾	
7,000		07000	07000
7,001 - 7,499		xxxxx ¹⁾	
7,500		07500	
7,501 - 7,937		xxxxx ¹⁾	
7,938	5/16	07938	
7,939 - 7,999		xxxxx ¹⁾	
8,000		08000	08000
8,001 - 8,499		xxxxx ¹⁾	
8,500		08500	
8,501 - 8,999		xxxxx ¹⁾	
9,000		09000	09000
9,001 - 9,499		xxxxx ¹⁾	
9,500		09500	
9,501 - 9,524		xxxxx ¹⁾	
9,525	3/8	09525	
9,526 - 9,999		xxxxx ¹⁾	
10,000		10000	
10,001 - 10,499		xxxxx ¹⁾	

1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 04506789)!

Clamping sleeve S 12 / 212 E

▲ Also suitable for all INDEX multi-spindle machines



S 12 / 212 E



S 12 / 212 E

DCONWS mm	DCONWS inch
10,500	
10,501 - 10,999	
11,000	

CW	CW
81 045 ...	81 046 ...
10500	
xxxxx ¹⁾	
11000	

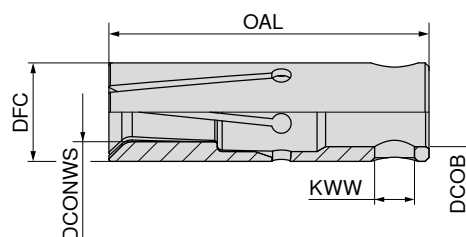
1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 04506789)!

Clamping sleeves

Designation	Slide Ø	DFC mm	KWW mm	DCOB _{H7} mm	OAL mm
S 15 / 203 E	D 15	15	6	11	40



Clamping sleeve S 15 / 203 E

▲ Also suitable for all INDEX multi-spindle machines



S 15 / 203 E

S 15 / 203 E

DCONWS mm	DCONWS inch	CW 81 047 ...	CW 81 048 ...
3,000		03000	03000
3,001 - 3,174		xxxxx ¹⁾	
3,175	1/8	03175	
3,176 - 3,499		xxxxx ¹⁾	
3,500		03500	
3,501 - 3,999		xxxxx ¹⁾	
4,000		04000	04000
4,001 - 4,499		xxxxx ¹⁾	
4,500		04500	
4,501 - 4,999		xxxxx ¹⁾	
5,000		05000	05000
5,001 - 5,499		xxxxx ¹⁾	
5,500		05500	
5,501 - 5,999		xxxxx ¹⁾	
6,000		06000	06000
6,001 - 6,349		xxxxx ¹⁾	
6,350	1/4	06350	06350
6,351 - 6,499		xxxxx ¹⁾	
6,500		06500	
6,501 - 6,999		xxxxx ¹⁾	
7,000		07000	07000
7,001 - 7,499		xxxxx ¹⁾	
7,500		07500	
7,501 - 7,937		xxxxx ¹⁾	
7,938	5/16	07938	07938
7,939 - 7,999		xxxxx ¹⁾	
8,000		08000	08000
8,001 - 8,499		xxxxx ¹⁾	
8,500		08500	
8,501 - 8,999		xxxxx ¹⁾	
9,000		09000	09000
9,001 - 9,499		xxxxx ¹⁾	
9,500		09500	
9,501 - 9,524		xxxxx ¹⁾	
9,525	3/8	09525	
9,526 - 9,999		xxxxx ¹⁾	
10,000		10000	10000
10,001 - 10,499		xxxxx ¹⁾	

1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 04706789)!

Clamping sleeve S 15 / 203 E

▲ Also suitable for all INDEX multi-spindle machines



S 15 / 203 E



S 15 / 203 E

DCONWS mm	DCONWS inch
10,500	
10,501 - 10,999	
11,000	
11,001 - 11,112	
11,113	7/16
11,114 - 11,499	
11,500	
11,501 - 11,999	
12,000	
12,001 - 12,499	
12,500	
12,501 - 12,699	
12,700	1/2
12,701 - 12,999	
13,000	
13,001 - 13,499	
13,500	
13,501 - 13,999	
14,000	

CW	CW
81 047 ...	81 048 ...
10500	
xxxxx ¹⁾	
11000	11000
xxxxx ¹⁾	
11113	
xxxxx ¹⁾	
11500	
xxxxx ¹⁾	
12000	12000
xxxxx ¹⁾	
12500	
xxxxx ¹⁾	
12700	
xxxxx ¹⁾	
13000	
xxxxx ¹⁾	
13500	
xxxxx ¹⁾	
14000	

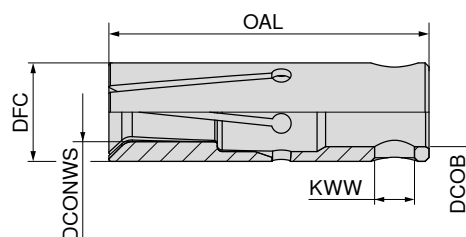
1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 04706789)!

Clamping sleeves

Designation	Slide Ø	DFC mm	KWW mm	DCOB _{H7} mm	OAL mm
S 16	D 16	16	6	11	40



Clamping sleeve S 16

▲ Also suitable for all INDEX multi-spindle machines



●
S 16

●
S 16

DCONWS mm	DCONWS inch	CW 81 049 ...	CW 81 050 ...
3,000		03000	03000
3,001 - 3,499		xxxxx ¹⁾	
3,500		03500	
3,501 - 3,999		xxxxx ¹⁾	
4,000		04000	04000
4,001 - 4,499		xxxxx ¹⁾	
4,500		04500	
4,501 - 4,999		xxxxx ¹⁾	
5,000		05000	05000
5,001 - 5,499		xxxxx ¹⁾	
5,500		05500	
5,501 - 5,999		xxxxx ¹⁾	
6,000		06000	06000
6,001 - 6,349		xxxxx ¹⁾	
6,350	1/4	06350	
6,351 - 6,499		xxxxx ¹⁾	
6,500		06500	
6,501 - 6,999		xxxxx ¹⁾	
7,000		07000	07000
7,001 - 7,499		xxxxx ¹⁾	
7,500		07500	
7,501 - 7,999		xxxxx ¹⁾	
8,000		08000	08000
8,001 - 8,499		xxxxx ¹⁾	
8,500		08500	
8,501 - 8,999		xxxxx ¹⁾	
9,000		09000	09000
9,001 - 9,499		xxxxx ¹⁾	
9,500		09500	
9,501 - 9,524		xxxxx ¹⁾	
9,525	3/8	09525	
9,526 - 9,999		xxxxx ¹⁾	
10,000		10000	10000
10,001 - 10,499		xxxxx ¹⁾	
10,500		10500	
10,501 - 10,999		xxxxx ¹⁾	
11,000		11000	11000
11,001 - 11,112		xxxxx ¹⁾	

1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 04906789)!

Clamping sleeve S 16

▲ Also suitable for all INDEX multi-spindle machines



S 16

S 16

DCONWS mm	DCONWS inch
11,113	7/16
11,114 - 11,499	
11,500	
11,501 - 11,999	
12,000	
12,001 - 12,499	
12,500	
12,501 - 12,699	
12,700	1/2
12,701 - 12,999	
13,000	
13,001 - 13,499	
13,500	
13,501 - 13,999	
14,000	
14,001 - 14,287	
14,288	9/16
14,289 - 14,499	
14,500	
14,501 - 14,999	
15,000	

CW	CW
81 049 ...	81 050 ...
11113	
xxxxx ¹⁾	
11500	
xxxxx ¹⁾	
12000	12000
xxxxx ¹⁾	
12500	
xxxxx ¹⁾	
12700	
xxxxx ¹⁾	
13000	13000
xxxxx ¹⁾	
13500	
xxxxx ¹⁾	
14000	
xxxxx ¹⁾	
14288	
xxxxx ¹⁾	
14500	
xxxxx ¹⁾	
15000	

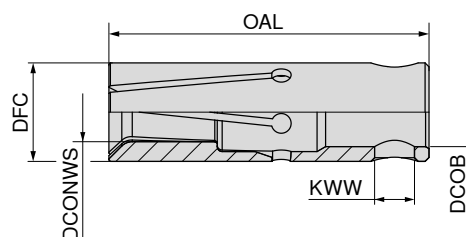
1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 04906789)!

Clamping sleeves

Designation	Slide Ø	DFC mm	KWW mm	DCOB _{H7} mm	OAL mm
S 18 / 218 E	D 18	18	6	11	40



Clamping sleeve S 18 / 218 E

▲ Also suitable for all INDEX multi-spindle machines



● S 18 / 218 E

⬡ S 18 / 218 E

DCONWS mm	DCONWS inch	CW	CW
3,000		81 051 ...	81 052 ...
3,001 - 3,174		03000	
3,175	1/8	xxxxx ¹⁾	
3,176 - 3,499		03175	
3,500		xxxxx ¹⁾	
3,501 - 3,999		03500	
4,000		xxxxx ¹⁾	
4,001 - 4,499		04000	
4,500		xxxxx ¹⁾	
4,501 - 4,762		04500	
4,763	3/16	xxxxx ¹⁾	
4,764 - 4,999		04763	
5,000		xxxxx ¹⁾	
5,001 - 5,499		05000	05000
5,500		xxxxx ¹⁾	
5,501 - 5,999		05500	
6,000		xxxxx ¹⁾	
6,001 - 6,499		06000	06000
6,500		xxxxx ¹⁾	
6,501 - 6,999		06500	
7,000		xxxxx ¹⁾	
7,001 - 7,499		07000	07000
7,500		xxxxx ¹⁾	
7,501 - 7,937		07500	
7,938	5/16	xxxxx ¹⁾	
7,939 - 7,999		07938	
8,000		xxxxx ¹⁾	
8,001 - 8,499		08000	08000
8,500		xxxxx ¹⁾	
8,501 - 8,999		08500	
9,000		xxxxx ¹⁾	
9,001 - 9,499		09000	09000
9,500		xxxxx ¹⁾	
9,501 - 9,524		09500	
9,525	3/8	xxxxx ¹⁾	
9,526 - 9,999		09525	
10,000		xxxxx ¹⁾	
10,001 - 10,499		10000	10000
		xxxxx ¹⁾	

1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 05106789)!

Clamping sleeve S 18 / 218 E

▲ Also suitable for all INDEX multi-spindle machines



● S 18 / 218 E

⬡ S 18 / 218 E

DCONWS mm	DCONWS inch	CW 81 051 ...	CW 81 052 ...
10,500		10500	
10,501 - 10,999		xxxxx ¹⁾	
11,000		11000	11000
11,001 - 11,112		xxxxx ¹⁾	
11,113	7/16	11113	
11,114 - 11,499		xxxxx ¹⁾	
11,500		11500	
11,501 - 11,999		xxxxx ¹⁾	
12,000		12000	12000
12,001 - 12,499		xxxxx ¹⁾	
12,500		12500	
12,501 - 12,699		xxxxx ¹⁾	
12,700	1/2	12700	12700
12,701 - 12,999		xxxxx ¹⁾	
13,000		13000	13000
13,001 - 13,499		xxxxx ¹⁾	
13,500		13500	
13,501 - 13,999		xxxxx ¹⁾	
14,000		14000	14000
14,001 - 14,287		xxxxx ¹⁾	
14,288	9/16	14288	
14,289 - 14,499		xxxxx ¹⁾	
14,500		14500	
14,501 - 14,999		xxxxx ¹⁾	
15,000		15000	
15,001 - 15,499		xxxxx ¹⁾	
15,500		15500	
15,501 - 15,874		xxxxx ¹⁾	
15,875	5/8	15875	
15,876 - 15,999		xxxxx ¹⁾	
16,000		16000	

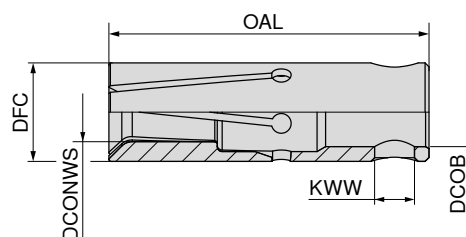
1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 05106789)!

Clamping sleeves

Designation	Slide Ø	DFC mm	KWW mm	DCOB _{H7} mm	OAL mm
S 20 / 225 E	D 20	20	8	14	65



Clamping sleeve S 20 / 225 E

▲ Also suitable for all INDEX multi-spindle machines



S 20 / 225 E

S 20 / 225 E

DCONWS mm	DCONWS inch	CW 81 053 ...	CW 81 054 ...
4,000		04000	
4,001 - 4,499		xxxxx ¹⁾	
4,500		04500	
4,501 - 4,762		xxxxx ¹⁾	
4,763	3/16	04763	
4,764 - 4,999		xxxxx ¹⁾	
5,000		05000	05000
5,001 - 5,499		xxxxx ¹⁾	
5,500		05500	
5,501 - 5,999		xxxxx ¹⁾	
6,000		06000	06000
6,001 - 6,349		xxxxx ¹⁾	
6,350	1/4	06350	06350
6,351 - 6,499		xxxxx ¹⁾	
6,500		06500	
6,501 - 6,999		xxxxx ¹⁾	
7,000		07000	07000
7,001 - 7,499		xxxxx ¹⁾	
7,500		07500	
7,501 - 7,937		xxxxx ¹⁾	
7,938	5/16	07938	
7,939 - 7,999		xxxxx ¹⁾	
8,000		08000	08000
8,001 - 8,499		xxxxx ¹⁾	
8,500		08500	
8,501 - 8,999		xxxxx ¹⁾	
9,000		09000	09000
9,001 - 9,499		xxxxx ¹⁾	
9,500		09500	
9,501 - 9,524		xxxxx ¹⁾	
9,525	3/8	09525	
9,526 - 9,999		xxxxx ¹⁾	
10,000		10000	10000
10,001 - 10,499		xxxxx ¹⁾	
10,500		10500	
10,501 - 10,999		xxxxx ¹⁾	
11,000		11000	11000
11,001 - 11,112		xxxxx ¹⁾	

1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 05306789)!

Clamping sleeve S 20 / 225 E

▲ Also suitable for all INDEX multi-spindle machines



● S 20 / 225 E

⬡ S 20 / 225 E

DCONWS mm	DCONWS inch	CW 81 053 ...	CW 81 054 ...
11,113	7/16	11113	
11,114 - 11,499		xxxxx ¹⁾	
11,500		11500	
11,501 - 11,999		xxxxx ¹⁾	
12,000		12000	12000
12,001 - 12,499		xxxxx ¹⁾	
12,500		12500	
12,501 - 12,699		xxxxx ¹⁾	
12,700	1/2	12700	12700
12,701 - 12,999		xxxxx ¹⁾	
13,000		13000	13000
13,001 - 13,499		xxxxx ¹⁾	
13,500		13500	
13,501 - 13,999		xxxxx ¹⁾	
14,000		14000	14000
14,001 - 14,499		xxxxx ¹⁾	
14,500		14500	
14,501 - 14,999		xxxxx ¹⁾	
15,000		15000	15000
15,001 - 15,499		xxxxx ¹⁾	
15,500		15500	
15,501 - 15,999		xxxxx ¹⁾	
16,000		16000	16000
16,001 - 16,499		xxxxx ¹⁾	
16,500		16500	
16,501 - 16,999		xxxxx ¹⁾	
17,000		17000	
17,001 - 17,499		xxxxx ¹⁾	
17,500		17500	
17,501 - 17,999		xxxxx ¹⁾	
18,000		18000	
18,001 - 18,499		xxxxx ¹⁾	
18,500		18500	
18,501 - 18,999		xxxxx ¹⁾	
19,000		19000	

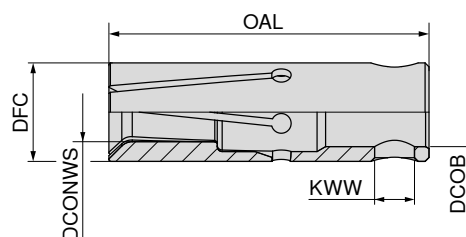
1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 05306789)!

Clamping sleeves

Designation	Slide Ø	DFC mm	KWW mm	DCOB _{H7} mm	OAL mm
S 25 / 222 E	D 25	25	8	20	65



Clamping sleeve S 25 / 222 E

▲ Also suitable for all INDEX multi-spindle machines



Hexagon
S 25 / 222 E

Circle
S 25 / 222 E

DCONWS mm	DCONWS inch	CW 81 056 ...	CW 81 055 ...
4,000			04000
4,001 - 4,499			xxxxx ¹⁾
4,500			04500
4,501 - 4,999			xxxxx ¹⁾
5,000		05000	05000
5,001 - 5,499			xxxxx ¹⁾
5,500			05500
5,501 - 5,999			xxxxx ¹⁾
6,000		06000	06000
6,001 - 6,349			xxxxx ¹⁾
6,350	1/4	06350	06350
6,351 - 6,499			xxxxx ¹⁾
6,500			06500
6,501 - 6,999			xxxxx ¹⁾
7,000		07000	07000
7,001 - 7,499			xxxxx ¹⁾
7,500			07500
7,501 - 7,999			xxxxx ¹⁾
8,000		08000	08000
8,001 - 8,499			xxxxx ¹⁾
8,500			08500
8,501 - 8,999			xxxxx ¹⁾
9,000		09000	09000
9,001 - 9,499			xxxxx ¹⁾
9,500			09500
9,501 - 9,999			xxxxx ¹⁾
10,000		10000	10000
10,001 - 10,499			xxxxx ¹⁾
10,500			10500
10,501 - 10,999			xxxxx ¹⁾
11,000		11000	11000
11,001 - 11,499			xxxxx ¹⁾
11,500			11500
11,501 - 11,999			xxxxx ¹⁾
12,000		12000	12000
12,001 - 12,499			xxxxx ¹⁾
12,500			12500
12,501 - 12,699			xxxxx ¹⁾

1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 05606789)!

Clamping sleeve S 25 / 222 E

▲ Also suitable for all INDEX multi-spindle machines



⬡ S 25 / 222 E

● S 25 / 222 E

DCONWS mm	DCONWS inch	CW 81 056 ...	CW 81 055 ...
12,700	1/2		12700
12,701 - 12,999			xxxxx ¹⁾
13,000		13000	13000
13,001 - 13,499			xxxxx ¹⁾
13,500			13500
13,501 - 13,999			xxxxx ¹⁾
14,000		14000	14000
14,001 - 14,499			xxxxx ¹⁾
14,500			14500
14,501 - 14,999			xxxxx ¹⁾
15,000		15000	15000
15,001 - 15,499			xxxxx ¹⁾
15,500			15500
15,501 - 15,999			xxxxx ¹⁾
16,000		16000	16000
16,001 - 16,499			xxxxx ¹⁾
16,500			16500
16,501 - 16,999			xxxxx ¹⁾
17,000		17000	17000
17,001 - 17,499			xxxxx ¹⁾
17,500			17500
17,501 - 17,999			xxxxx ¹⁾
18,000		18000	18000
18,001 - 18,499			xxxxx ¹⁾
18,500			18500
18,501 - 18,999			xxxxx ¹⁾
19,000		19000	19000
19,001 - 19,049			xxxxx ¹⁾
19,050	3/4		19050
19,051 - 19,499			xxxxx ¹⁾
19,500			19500
19,501 - 19,999			xxxxx ¹⁾
20,000		20000	20000
20,001 - 20,499			xxxxx ¹⁾
20,500			20500
20,501 - 20,999			xxxxx ¹⁾
21,000			21000
21,001 - 21,499			xxxxx ¹⁾
21,500			21500
21,501 - 21,999			xxxxx ¹⁾
22,000			22000
22,001 - 22,499			xxxxx ¹⁾
22,500			22500
22,501 - 22,999			xxxxx ¹⁾
23,000			23000
23,001 - 23,499			xxxxx ¹⁾
23,500			23500
23,501 - 23,999			xxxxx ¹⁾
24,000			24000

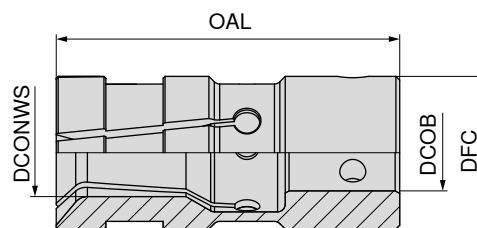
1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 05606789)!

Clamping sleeves

Designation	Slide Ø	DFC mm	DCOB _{HT} mm	OAL mm
ST 32	D 32	32	20	90



Clamping sleeve ST 32 (turbo version)

▲ Also suitable for all INDEX multi-spindle machines



ST 32

ST 32

DCONWS mm	DCONWS inch	CW 81 057 ...	CW 81 058 ...
5,000		05000	05000
5,001 - 5,499		xxxxx ¹⁾	
5,500		05500	
5,501 - 5,999		xxxxx ¹⁾	
6,000		06000	06000
6,001 - 6,349		xxxxx ¹⁾	
6,350	1/4	06350	
6,351 - 6,499		xxxxx ¹⁾	
6,500		06500	
6,501 - 6,999		xxxxx ¹⁾	
7,000		07000	07000
7,001 - 7,499		xxxxx ¹⁾	
7,500		07500	
7,501 - 7,999		xxxxx ¹⁾	
8,000		08000	08000
8,001 - 8,499		xxxxx ¹⁾	
8,500		08500	
8,501 - 8,999		xxxxx ¹⁾	
9,000		09000	09000
9,001 - 9,499		xxxxx ¹⁾	
9,500		09500	
9,501 - 9,524		xxxxx ¹⁾	
9,525	3/8	09525	
9,526 - 9,999		xxxxx ¹⁾	
10,000		10000	10000
10,001 - 10,499		xxxxx ¹⁾	
10,500		10500	
10,501 - 10,999		xxxxx ¹⁾	
11,000		11000	11000
11,001 - 11,499		xxxxx ¹⁾	
11,500		11500	
11,501 - 11,999		xxxxx ¹⁾	
12,000		12000	12000
12,001 - 12,499		xxxxx ¹⁾	
12,500		12500	
12,501 - 12,699		xxxxx ¹⁾	
12,700	1/2	12700	
12,701 - 12,999		xxxxx ¹⁾	

1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 05706789)!

Clamping sleeve ST 32 (turbo version)

▲ Also suitable for all INDEX multi-spindle machines



ST 32

ST 32

DCONWS mm	DCONWS inch	CW 81 057 ...	CW 81 058 ...
13,000		13000	13000
13,001 - 13,499		xxxxx ¹⁾	
13,500		13500	
13,501 - 13,999		xxxxx ¹⁾	
14,000		14000	14000
14,001 - 14,499		xxxxx ¹⁾	
14,500		14500	
14,501 - 14,999		xxxxx ¹⁾	
15,000		15000	15000
15,001 - 15,499		xxxxx ¹⁾	
15,500		15500	
15,501 - 15,874		xxxxx ¹⁾	
15,875	5/8	15875	
15,876 - 15,999		xxxxx ¹⁾	
16,000		16000	16000
16,001 - 16,499		xxxxx ¹⁾	
16,500		16500	
16,501 - 16,999		xxxxx ¹⁾	
17,000		17000	17000
17,001 - 17,462		xxxxx ¹⁾	
17,463	11/16	17463	
17,464 - 17,499		xxxxx ¹⁾	
17,500		17500	
17,501 - 17,999		xxxxx ¹⁾	
18,000		18000	18000
18,001 - 18,499		xxxxx ¹⁾	
18,500		18500	
18,501 - 18,999		xxxxx ¹⁾	
19,000		19000	19000
19,001 - 19,049		xxxxx ¹⁾	
19,050	3/4	19050	
19,051 - 19,499		xxxxx ¹⁾	
19,500		19500	
19,501 - 19,999		xxxxx ¹⁾	
20,000		20000	20000
20,001 - 20,499		xxxxx ¹⁾	
20,500		20500	
20,501 - 20,999		xxxxx ¹⁾	
21,000		21000	21000
21,001 - 21,499		xxxxx ¹⁾	
21,500		21500	
21,501 - 21,999		xxxxx ¹⁾	
22,000		22000	22000
22,001 - 22,224		xxxxx ¹⁾	
22,225	7/8	22225	
22,226 - 22,499		xxxxx ¹⁾	
22,500		22500	
22,501 - 22,999		xxxxx ¹⁾	
23,000		23000	23000
23,001 - 23,499		xxxxx ¹⁾	
23,500		23500	

1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 05706789)!

Clamping sleeve ST 32 (turbo version)

▲ Also suitable for all INDEX multi-spindle machines



ST 32

ST 32

DCONWS mm	DCONWS inch	CW 81 057 ...	CW 81 058 ...
23,501 - 23,999		xxxxx ¹⁾	
24,000		24000	24000
24,001 - 24,499		xxxxx ¹⁾	
24,500		24500	
24,501 - 24,999		xxxxx ¹⁾	
25,000		25000	25000
25,001 - 25,399		xxxxx ¹⁾	
25,400	1/1	25400	
25,401 - 25,499		xxxxx ¹⁾	
25,500		25500	
25,501 - 25,999		xxxxx ¹⁾	
26,000		26000	26000
26,001 - 26,499		xxxxx ¹⁾	
26,500		26500	
26,501 - 26,999		xxxxx ¹⁾	
27,000		27000	
27,001 - 27,499		xxxxx ¹⁾	
27,500		27500	
27,501 - 27,999		xxxxx ¹⁾	
28,000		28000	
28,001 - 28,499		xxxxx ¹⁾	
28,500		28500	
28,501 - 28,574		xxxxx ¹⁾	
28,575	1 1/8	28575	
28,576 - 28,999		xxxxx ¹⁾	
29,000		29000	
29,001 - 29,499		xxxxx ¹⁾	
29,500		29500	
29,501 - 29,999		xxxxx ¹⁾	
30,000		30000	

1) Not available from stock, articles are non-returnable and cannot be exchanged / Delivery time on request



For xxxxx please specify the required diameter when ordering (e.g., Ø 6.789 – article number 81 05706789)!

Reduction sleeve

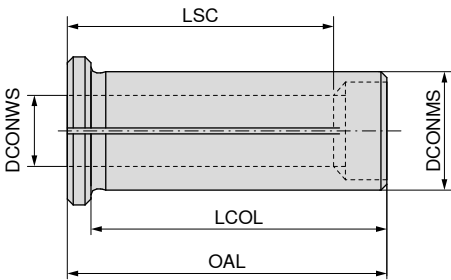
- ▲ For tools with cylindrical shank
- ▲ Radial run-out accuracy < 0.01 mm



				CW
DCONMS _{g6}	DCONMS _{g6}	DCONWS _{H7}	OAL	81 427 ...
mm	inch	mm	mm	
15.875	5/8	12	30	15912
16.000		12	30	16012
19.050	3/4	8	40	19108
19.050	3/4	10	40	19110
19.050	3/4	12	40	19112
19.050	3/4	14	40	19114
19.050	3/4	16	40	19116
20.000		10	40	20010
20.000		12	40	20012
20.000		16	40	20016
22.000		12	40	22012
22.000		16	40	22016
25.000		12	40	25012
25.000		16	40	25016
25.000		20	40	25020
25.400	1	12	40	25412
25.400	1	16	40	25416
25.400	1	20	40	25420
33.000		20	40	33020
33.000		22	40	33022
33.000		25	40	33025

Reduction sleeves for hydraulic and high pressure chucks

▲ Thru coolant to 80 bar



					CT	
DCONMS	DCONWS	OAL	LCOL	LSC	83 609 ...	
mm	mm	mm	mm	mm		
12	3	40	36	29	103	
12	4	40	36	29	104	
12	5	40	36	29	105	
12	6	40	36	36	106	
12	8	40	36	37	108	
20	3	54	50	28	203	
20	4	54	50	28	204	
20	5	54	50	28	205	
20	6	54	50	36	206	
20	8	54	50	37	208	
20	10	54	50	40	210	
20	12	54	50	45	212	
20	14	54	50	45	214	
20	16	54	50	48	216	
25	6	60	56	37	256	
25	8	60	56	37	258	
25	10	60	56	40	260	
25	12	60	56	46	262	
25	14	60	56	47	264	
25	16	60	56	48	266	
25	18	60	56	48	268	
25	20	60	56	50	270	
32	6	64	60	36	306	
32	8	64	60	36	308	
32	10	64	60	40	310	
32	12	64	60	45	312	
32	14	64	60	46	314	
32	16	64	60	48	316	
32	18	64	60	49	318	
32	20	64	60	50	320	
32	25	64	60	56	325	

Reducing sleeves for hydraulic and high pressure chucks – Metric to Inch

▲ Thru coolant to 69 bar (1.000 psi)

Scope of supply:

Reduction Collets are supplied with Rubber and Aluminum Coolant seals that are removable but not desired

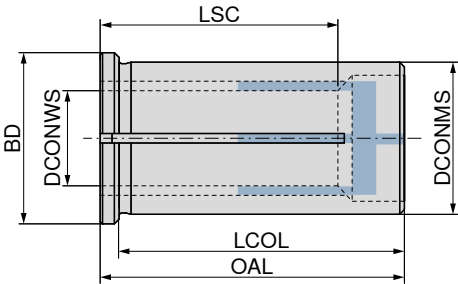


DCONMS	DCONWS	BD
inch	inch	inch
0.787	0.125	0.945
0.787	0.187	0.945
0.787	0.250	0.945
0.787	0.312	0.945
0.787	0.375	0.945
0.787	0.437	0.945
0.787	0.500	0.945
0.787	0.562	0.945
0.787	0.625	0.945
1.260	0.875	1.417
1.260	1.000	1.417

CT
87 609 ...
12500
18700
25000
31200
37500
43700
50000
56200
62500
87500
99900

Reduction sleeves with coolant channel for hydraulic and high pressure chucks

▲ With coolant holes, for flexible diameter application



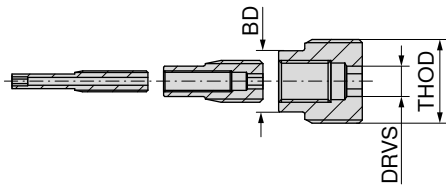
DCONMS	DCONWS	BD	OAL	LCOL	LSC
mm	mm	mm	mm	mm	mm
12	3	16	44	40	29
12	4	16	44	40	29
12	5	16	44	40	29
12	6	16	44	40	36
12	8	16	44	40	37
20	3	25	54	50	28
20	4	25	54	50	28
20	5	25	54	50	28
20	6	25	54	50	36
20	8	25	54	50	37
20	10	25	54	50	40
20	12	25	54	50	45
20	14	25	54	50	45
20	16	25	54	50	48
32	6	36	64	60	36
32	8	36	64	60	36
32	10	36	64	60	40
32	12	36	64	60	45
32	14	36	64	60	46
32	16	36	64	60	48
32	18	36	64	60	49
32	20	36	64	60	50
32	25	36	64	60	56

CT
83 611 ...
10300
10400
10500
10600
10800
20300
20400
20500
20600
20800
21000
21200
21400
21600
30600
30800
31000
31200
31400
31600
31800
32000
32500

Adaptation for the use of stop screws for reduction sleeves

DCONMS in mm			
12		83950425	83950426
20	83950425	83950428	83950427
25	83950425	83950428	83950427
32		83950428	83950427

Stop screw for use with reduction sleeves in hydraulic chucks

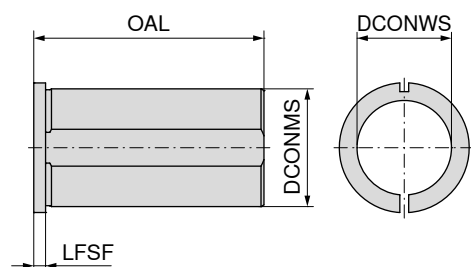


THOD	BD mm	DRVS mm
M4x0,5x26	2.8	2
M8x1x19	5.8	2,5
M10x1x16	5.8	3
M16x1x16	11.7	5

CT
83 950 ...
425
428
426
427

Slotted reduction sleeves

- ▲ For cylindrical adaptors and other tool holders
- ▲ For tools with cylindrical shank



DCONMS mm	DCONWS mm	OAL mm	LFSF mm
20	6	30	4
20	8	30	4
20	10	30	4
20	12	30	4
20	15	30	4
20	16	30	4
25	6	40	4
25	8	40	4
25	10	40	4
25	12	40	4
25	15	40	4
25	16	40	4
25	20	40	4
32	6	50	4
32	8	50	4
32	10	50	4
32	12	50	4
32	15	50	4
32	16	50	4
32	20	50	4
40	10	78	4
40	12	78	4
40	15	78	4
40	16	78	4
40	20	78	4
40	25	78	4
40	32	78	4
50	20	88	4
50	25	88	4
50	32	88	4
50	40	88	4

CX

83 271 ...

206

208

210

212

215

216

256

258

260

262

265

266

270

326

328

330

332

335

336

340

410

412

415

416

420

425

432

520

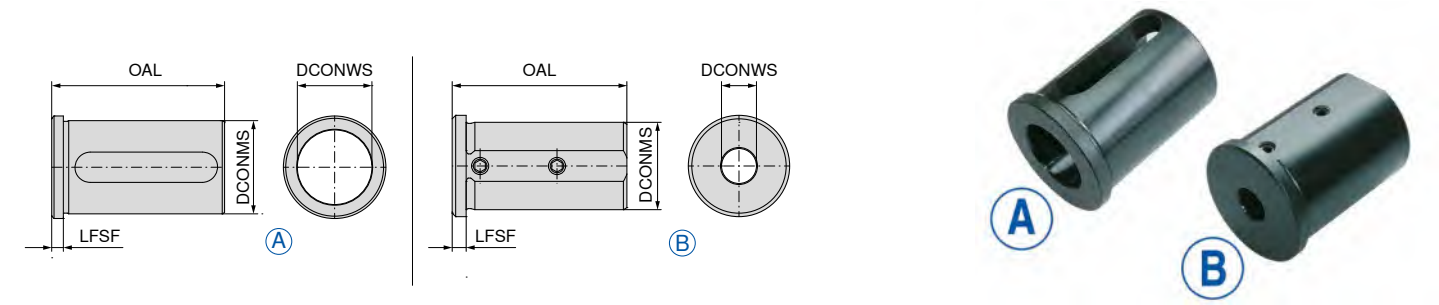
525

532

540

Reduction sleeves for direct clamping

▲ For tools with cylindrical shank



DCONMS	DCONWS	OAL	LFSF	Fig.	CX	
mm	mm	mm	mm		83 272 ...	
25	6	50	4	B		256
25	8	50	4	B		258
25	10	50	4	B		260
25	12	50	4	B		262
25	14	50	4	A		264
25	16	50	4	A		266
25	20	50	4	A		270
32	6	58	5	B		326
32	8	58	5	B		328
32	10	58	5	B		330
32	12	58	5	B		332
32	16	58	5	A		336
32	20	58	5	A		340
32	25	58	5	A		345
40	8	58	5	B		408
40	10	58	5	B		410
40	12	58	5	B		412
40	16	58	5	A		416
40	20	58	5	A		420
40	25	58	5	A		425
40	32	58	5	A		432
50	12	75	5	B		512
50	16	75	5	A		516
50	20	75	5	A		520
50	25	75	5	A		525
50	32	75	5	A		532
50	40	75	5	A		540

Taper wiper

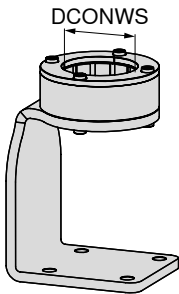
▲ Version made from hard wood with felt inserts



Adapter		CX
		83 715 ...
MK 1		001
MK 2		002
MK 3		003
MK 4		004
MK 5		005
HSK 32		320
HSK 40		400
HSK 50		500
HSK 63		630
HSK 80		800
HSK 100		100
SK 30		130
SK 40		140
SK 50		150

Assembly device for adaptors

- ▲ Gripping by roller
- ▲ Secure clamping
- ▲ Quick assembly, no additional clamping necessary



Adapter type		DCONWS	CT
		mm	80 722 ...
HSK 32, PSC 32		32.0	032
HSK 40, PSC 40		40.0	040
MAS-BT 30		46.0	046
ISO 7388-1 / DIN 2080 - SK 30, HSK 50, PSC 50		50.0	050
ISO 7388-1 / DIN 2080 - SK 40, HSK 63, PSC 63, MAS-BT 40, ANSI-CAT 40		63.0	063
ISO 7388-1 - SK 50		97.5	097
HSK 100, MAS-BT 50, ANSI-CAT 50		100.0	100



Safety note: The clamping devices must be free of oil and grease to avoid slipping!

Assembly device for steep taper adaptors

▲ Aluminum

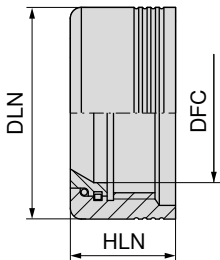


Adapter		CT
SK 30		80 720 ... 030
SK 40		040
SK 50		050

HyPower – ER lock nut for precision collet chucks – Centro-P

- ▲ with thrust collar and angular contact ball bearing
- ▲ Excellent damping and clamping force
- ▲ High-precision lock nut for a perfect fit
- ▲ Run-out ≤ 3 µm with ER precision collets (blue ring)

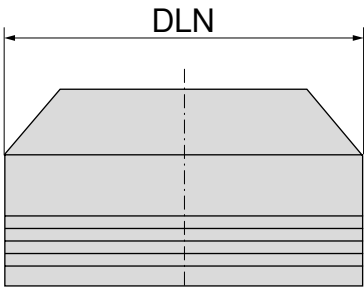
Centro-P



for collet	DCONWS mm	HLN mm	DFC mm	DLN mm	CT 84 728 ...	
470E (ER32)	2 - 20	26.5	32	50	05000	
472E (ER40)	3 - 26	31.0	40	63	06300	

CoreLine – ER lock nut for precision collet chucks – Centro-P

Centro-P

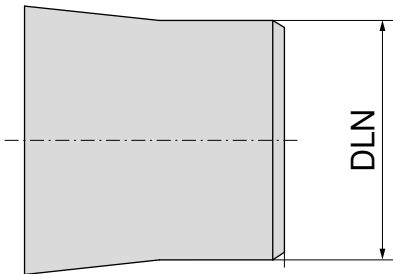


For sealing discs

for collet	DCONWS mm	DLN mm	TQX Nm	CT 84 950 ...	CT 84 950 ...
426E (ER16)	1 - 10	30	80	001	011
430E (ER25)	2 - 16	40	90	003	013
470E (ER32)	2 - 20	50	180	005	015
472E (ER40)	3 - 26	63	200	007	017

CoreLine – Tapered lock nut for precision collet chucks – Centro-P

Centro-P



For sealing discs

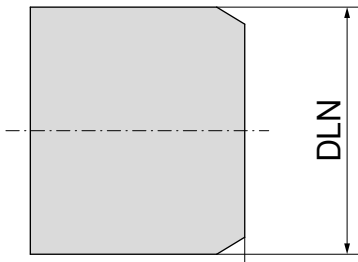
for collet	DCONWS mm	DLN mm	TQX Nm
426E (ER16)	1 - 10	24	80

CT
84 950 ...
031

CT
84 950 ...
033

Mini lock nut for precision collet chucks

Centro-P



For sealing discs

for collet	DCONWS mm	DLN mm	TQX Nm
4004E (ER08)	1 - 5	10	5 - 8
4008E (ER11)	1 - 7	16	10
4008E (ER11)	Ø 3,0	16	10
4008E (ER11)	Ø 4,0	16	10
4008E (ER11)	Ø 5,0	16	10
4008E (ER11)	Ø 6,0	16	10
4008E (ER11)	Ø 7,0	16	10
426E (ER16)	1 - 10	22	30
426E (ER16)	1 - 10	22	28

CT
84 950 ...
040
041
042 ¹⁾
043 ¹⁾
044 ¹⁾
045 ¹⁾
046 ¹⁾
034

CT
84 950 ...
035

1) Directly sealed

Collet removal aid for mini lock nuts for precision collet chucks

Centro-P



for collet	CT
4004E (ER08)	84 950 ...
4008E (ER11)	070
	072

Roll key

- ▲ Version CP = for Centro-P lock nuts
- ▲ Version STD = for standard lock nuts
- ▲ Version HDC = for HDC lock nuts



For lock nuts	DLN mm
4008E / ER 11 CP mini	16
426E / ER 16 CP / ER 16 mini	22
426E / ER 16 CP Conical	24
426E / ER 16 CP	30
426E / ER 16 STD	32
430E / ER 25 CP	40
470E / ER 32 CP + STD	50
470E / ER 32 HDC	53
472E / ER 40 CP + STD	63

CT
84 950 ...
080 ¹⁾
026 ¹⁾
082 ²⁾
027
028
054
056
30200
057

- 1) Special key for mini lock nuts
- 2) Key for tapered lock nuts

Additional roll key device for torque key

- ▲ Version CP = for Centro-P lock nuts
- ▲ Version STD = for standard lock nuts
- ▲ Version HDC = for HDC lock nuts



For lock nuts	DLN mm	TQX Nm	Square mm
4004E / ER08 CP mini	10	5 - 30	9 x 12
4008E / ER 11 CP mini	16	5 - 30	9 x 12
426E / ER 16 CP / ER 16 mini	22	5 - 30	9 x 12
426E / ER 16 CP Conical	24	10 - 80	9 x 12
426E / ER 16 CP	30	20 - 200	14 x 18
426E / ER 16 STD	32	20 - 200	14 x 18
430E / ER 25 CP	40	20 - 200	14 x 18
470E / ER 32 CP + STD	50	20 - 200	14 x 18
470E / ER 32 HDC	53	20 - 200	14 x 18
472E / ER 40 CP + STD	63	20 - 200	14 x 18

CT
84 950 ...
53300 ¹⁾
060 ¹⁾
170 ¹⁾
061 ²⁾
171
172
065
067
30300
068

- 1) For mini lock nuts
- 2) For tapered lock nuts

Torque key



TQX Nm	Square mm
5 - 30	9 x 12
10 - 80	9 x 12
20 - 200	14 x 18

AS
84 435 ...
030
080
200

ER-Mini clamping key



for collet
4004E (ER08)
4008E (ER11)
426E (ER16)
428E (ER20)
430E (ER25)

CT
83 950 ...
099
100
101
102
103

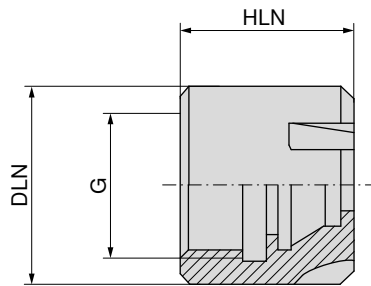
Y clamping key



For lock nuts
ER 16
ER 20
ER 25
ER 32
ER 40

CX
83 357 ...
116
12000
125
132
140

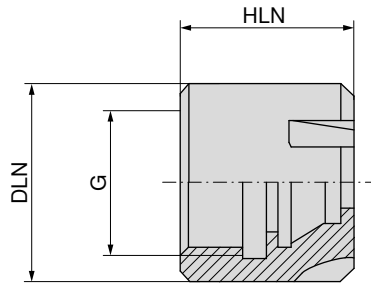
Mini ER lock nut



for collet	THSZMS	DLN mm	HLN mm	TQX Nm
4004E (ER08)	M10x0,75	12	11.0	8
4008E (ER11)	M13x0,75	16	12.0	18
426E (ER16)	M19x1	22	18.0	28
428E (ER20)	M24x1	28	19.5	35
430E (ER25)	M30x1	35	21.0	40

CT
62 950 ...
067
065
066
068
069

Mini ER lock nut for sealing discs

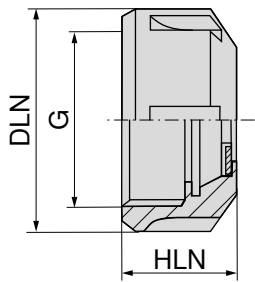


For sealing discs

for collet	THSZMS	DLN mm	HLN mm	TQX Nm
426E (ER16-DS)	M19x1	22	22.0	28
428E (ER20-DS)	M24x1	28	23.2	35
430E (ER25-DS)	M30x1	35	24.7	40

CT
83 950 ...
058
059
060

ER lock nut



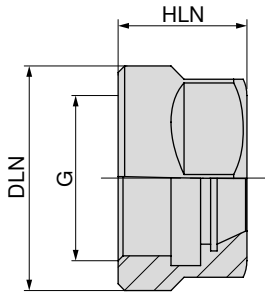
For sealing discs

for collet	THSZMS	DLN mm	HLN mm
426E (ER16)	M22x1,5	32.0	17.0
426E (ER16)	M22x1,5	32.0	22.0
428E (ER20)	M25x1,5	33.7	24.0
428E (ER20)	M25x1,5	35.0	23.2
430E (ER25)	M32x1,5	42.0	20.0
430E (ER25)	M32x1,5	42.0	24.7
470E (ER32)	M40x1,5	49.7	27.5
470E (ER32)	M40x1,5	50.0	22.3
470E (ER32)	M40x1,5	50.0	27.0
472E (ER40)	M50x1,5	63.0	25.3
472E (ER40)	M50x1,5	63.0	30.7

CT	CT
62 950 ...	83 950 ...
054	054
	51900
	053
055	055
	51400
65600	056
65700	057

ER lock nut

▲ DRVS = Drive size

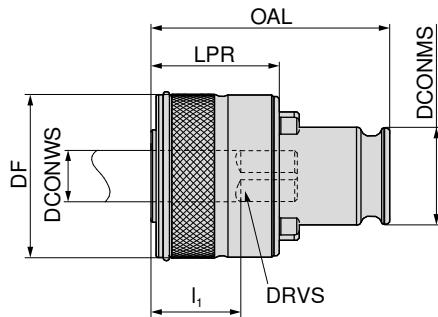


for collet	THSZMS	DRVS mm	DLN mm	HLN mm
426E (ER16)	M22x1,5	25	28	18.0
428E (ER20)	M25x1,5	30	34	19.5

CT
62 950 ...
044
045

Quick change tap adapter with overload clutch

- ▲ Adapter with adjustable overload clutch
- ▲ For use with taps



SZID	DCONWS mm	DRVS mm	DIN 371	DIN 374 / 376	DF mm	DCONMS mm	OAL mm	I ₁ mm	LPR mm
01	2.8	2.1	M2		33	19	46.5	17	25
01	2.8	2.1	M2,5		33	19	46.5	17	25
01	3.5	2.7	M3		33	19	46.5	17	25
01	4.0	3.0	M3,5		33	19	46.5	17	25
01	4.5	3.4	M4		33	19	46.5	17	25
01	6.0	4.9	M4,5		33	19	46.5	17	25
01	6.0	4.9	M5		33	19	46.5	17	25
01	4.5	3.4		M6	33	19	46.5	17	25
01	6.0	4.9	M6		33	19	46.5	17	25
01	5.5	4.3		M7	33	19	46.5	17	25
01	7.0	5.5	M7		33	19	46.5	17	25
01	6.0	4.9		M8	33	19	46.5	17	25
01	8.0	6.2	M8		33	19	46.5	17	25
01	9.0	7.0	M9		33	19	46.5	17	25
01	7.0	5.5		M10	33	19	46.5	17	25
01	10.0	8.0	M10		33	19	46.5	17	25
01	8.0	6.2		M11	33	19	46.5	17	25
01	9.0	7.0		M12	33	19	46.5	17	25
02	6.0	4.9	M4,5 - M6		50	31	69.0	30	34
02	6.0	4.9	M7 (DIN 352)		50	31	69.0	30	34
02	7.0	5.5	M7		50	31	69.0	30	34
02	6.0	4.9		M8	50	31	69.0	30	34
02	8.0	6.2	M8		50	31	69.0	30	34
02	9.0	7.0	M9		50	31	69.0	30	34
02	7.0	5.5		M10	50	31	69.0	30	34
02	10.0	8.0	M10		50	31	69.0	30	34
02	8.0	6.2		M11	50	31	69.0	30	34
02	9.0	7.0		M12	50	31	69.0	30	34
02	11.0	9.0		M14	50	31	69.0	30	34
02	12.0	9.0		M16	50	31	69.0	30	34
02	14.0	11.0		M18	50	31	69.0	30	34
02	16.0	12.0		M20	50	31	69.0	30	34

CT

83 612 ...

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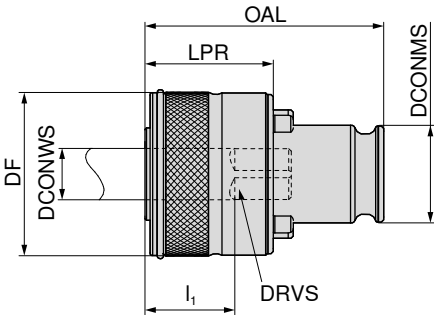
211

212

213

Quick change tap adapter with overload clutch, with through coolant

- ▲ Adapter with adjustable overload clutch
- ▲ For use with taps

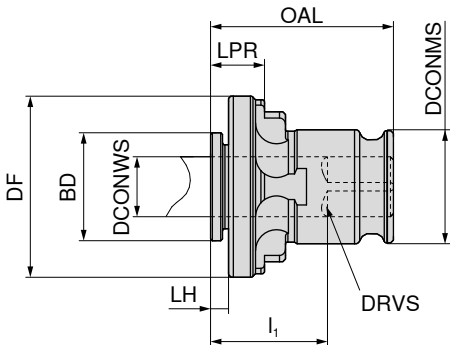


SZID	DCONWS	DRVS	DIN 371	DIN 374 / 376	DF	DCONMS	OAL	l ₁	LPR
	mm	mm			mm	mm	mm	mm	mm
01	3.5	2.7	M3	M4,5 - M5	33	19	46.5	17	25
01	4.5	3.4	M4	M6	33	19	46.5	17	25
01	5.5	4.3		M7	33	19	46.5	17	25
01	6.0	4.9	M4,5 - M6	M8	33	19	46.5	17	25
01	7.0	5.5	M7	M10	33	19	46.5	17	25
01	8.0	6.2	M8	M11	33	19	46.5	17	25
01	9.0	7.0	M9	M12	33	19	46.5	17	25
01	10.0	8.0	M10		33	19	46.5	17	25
01	11.0	9.0		M14	33	19	46.5	17	25
02	6.0	4.9	M4,5 - M6	M8	50	31	69.0	30	34
02	7.0	5.5	M7	M10	50	31	69.0	30	34
02	8.0	6.2	M8	M11	50	31	69.0	30	34
02	9.0	7.0	M9	M12	50	31	69.0	30	34
02	10.0	8.0	M10		50	31	69.0	30	34
02	11.0	9.0		M14	50	31	69.0	30	34
02	12.0	9.0	M12	M16	50	31	69.0	30	34
02	14.0	11.0		M18	50	31	69.0	30	34
02	16.0	12.0		M20	50	31	69.0	30	34

CT
83 616 ...
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Quick change tap adapter, with through coolant

- ▲ Normal version without overload clutch
- ▲ For use with taps
- ▲ For right-hand and left-hand threads

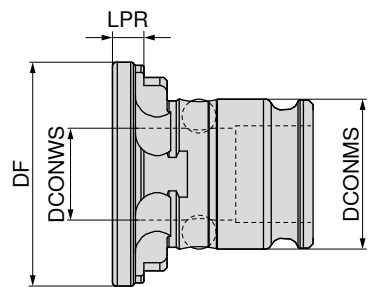


SZID	DCONWS	BD	DRVS	DIN 371	DIN 374 / 376	DF	DCONMS	OAL	LH	I ₁	LPR
	mm	mm	mm			mm	mm	mm	mm	mm	mm
01	3.5	18	2.7		M4,5 - M5	30.2	19	31	3.5	17	9.5
01	4.5	18	3.4	M4	M6	30.2	19	31	3.5	17	9.5
01	5.5	18	4.3		M7	30.2	19	31	3.5	17	9.5
01	6.0	18	4.9	M4,5 - M6	M8	30.2	19	31	3.5	17	9.5
01	7.0	18	5.5	M7	M10	30.2	19	31	3.5	17	9.5
01	8.0	18	6.2	M8	M11	30.2	19	31	3.5	17	9.5
01	9.0	18	7.0	M9	M12	30.2	19	31	3.5	17	9.5
01	10.0	18	8.0	M10		30.2	19	31	3.5	17	9.5
02	6.0	26	4.9	M4,5 - M6	M8	46.3	31	46	2.5	30	11.0
02	7.0	26	5.5	M7	M10	46.3	31	46	2.5	30	11.0
02	8.0	26	6.2	M8	M11	46.3	31	46	2.5	30	11.0
02	9.0	26	7.0	M9	M12	46.3	31	46	2.5	30	11.0
02	10.0	26	8.0	M10		46.3	31	46	2.5	30	11.0
02	11.0	26	9.0		M14	46.3	31	46	2.5	30	11.0
02	12.0	26	9.0	M12	M16	46.3	31	46	2.5	30	11.0
02	14.0	26	11.0		M18	46.3	31	46	2.5	30	11.0
02	16.0	26	12.0		M20	46.3	31	46	2.5	30	11.0

CT
83 614 ...
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Reducing adapter for quick change adapters

▲ Reducing adapter for reducing size 02 to 01. In this way the clamping ranges can be extended to smaller sizes.



SZID	DF mm	DCONMS mm	DCONWS mm	LPR mm
02	46	31	19	8.5

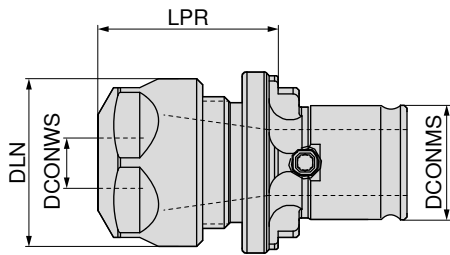
CT

83 624 ...

200

Quick change tap adapters

▲ Adapters for collets ER 16 / ER 25



SZID	DCONWS mm	DLN mm	DCONMS mm	LPR mm	for collet
01	1 - 10	28	19	29.5	ER 16
02	2 - 16	42	31	38.5	ER 25

CT

83 618 ...

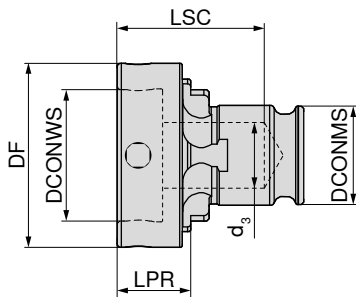
010 ¹⁾

016

1) With hex nut

Quick change adapter for dies

▲ For mounting dies according to DIN 223



SZID	For size	DF mm	DCONMS mm	DCONWS mm	LPR mm	d ₃ mm	LSC mm
01	16 x 5	25	19	16	9	12.5	23
01	20 x 5	30	19	20	9	12.5	23
01	20 x 7	30	19	20	11	12.5	25
01	25 x 9	35	19	25	14	12.5	28
01	38 x 10	48	19	38	15	14.2	29
01	30 x 11	40	19	30	16	12.5	30
01	38 x 14	48	19	38	19	14.2	33
02	20 x 5	30	31	20	22	15.0	57
02	20 x 7	30	31	20	22	15.0	57
02	25 x 9	35	31	35	22	15.0	57
02	38 x 10	48	31	38	22	22.0	57
02	30 x 11	40	31	30	22	22.0	57
02	38 x 14	48	31	38	25	22.0	60
02	45 x 14	57	31	45	29	22.0	64
02	45 x 18	57	31	45	29	22.0	64

CT

83 622 ...

116

120

121

125

138

130

139

220

221

225

238

230

239

245

246

Spanner

Multi
Change



DRVS mm	TQX Nm
6	5
8	12,5
10	15
13	20
16	25
19	25
21	25
24	25

CT
84 357 ...
006
008
010
013
016
019 ¹⁾
021 ¹⁾
024 ¹⁾

1) Only for MultiChange reamers

Spanner head

Multi
Change



DRVS mm	TQX Nm	Square mm	CT 84 358 ...
6	5	9 x 12	006
8	12,5	9 x 12	008
10	15	9 x 12	010
13	20	9 x 12	013
16	25	9 x 12	016
19	25	9 x 12	190
19	25	14 x 18	019 1)
21	25	9 x 12	210
21	25	14 x 18	021 1)
24	25	9 x 12	240
24	25	14 x 18	024 1)

1) Only for MultiChange reamers

Assembly instructions for MultiChange heads

- ▲ Clean the taper, thread, and face of the milling head.
- ▲ Clean the taper, thread, and face of the holder.
- ▲ Screw the milling head clockwise into the holder by hand (exercise caution and use gloves if necessary).
- ▲ Tighten the exchangeable milling head to the specified tightening torque using the torque key and the correct spanner (according to the table).
- ▲ The gap between the head and holder must be closed (force-fit and form-fit connection).



The torque key must be horizontally aligned with the key face; take care not to tilt the key face.



Additionally placing a hand on the exchangeable milling head is important for sensitive alignment. This helps to ensure the torque can be better maintained.

easyTorque® 2 key

- ▲ With fixed torque
- ▲ Ergonomic key handle, extremely easy to use thanks to compact design
- ▲ Specially designed for difficult-to-access screws and constricted openings
- ▲ Click signal when the set torque value is reached
- ▲ Accuracy: ± 10%, traceable to national standards



TQX Nm	DRVS mm	AS	
0,5	4	80 392 ...	10500
0,6	4		10600
0,9	4		10900
1,1	4		11100
1,2	4		11200
1,4	4		11400
1,5	4		11500
2,0	4		12000
2,2	4		12200
3,0	4		13000
3,8	4		13800
5,0	4		15000

easyTorque® 2 handle

- ▲ With fixed torque
- ▲ Accuracy: ± 10%



TQX Nm	DRVS mm	BD mm	OAL mm	WT kg	AS	
0,5	4	32.1	124.7	0.118	80 024 ...	10500
0,6	4	32.1	124.7	0.118		10600
0,9	4	32.1	124.7	0.118		10900
1,1	4	32.1	124.7	0.118		11100
1,2	4	32.1	124.7	0.118		11200
1,4	4	32.1	124.7	0.118		11400
2,0	4	32.1	124.7	0.118		12000
2,2	4	32.1	124.7	0.118		12200
3,0	4	32.1	124.7	0.118		13000
3,8	4	32.1	124.7	0.118		13800
4,2	4	32.1	124.7	0.118		14200
5,0	4	32.1	124.7	0.118		15000

Interchangeable blade for TORX®



Size	TQX Nm	Short
		AS
		80 394 ...
T06	0,6	10600
T07	0,9	10700
T08	1,3	10800
T09	2,5	10900
T10	3,8	11000
T15	5,5	11500
T20	8,0	12000
T25	8,0	12500



Suitable for easyTorque® 2 key article number 80 392 ...

Interchangeable blade for TORX PLUS®



Size	TQX Nm	Short
		AS
		80 394 ...
T06-IP	0,8	20600
T07-IP	1,3	20700
T08-IP	2,0	20800
T09-IP	3,0	20900
T10-IP	4,5	21000
T15-IP	6,6	21500
T20-IP	8,0	22000



Suitable for easyTorque® 2 key article number 80 392 ...

Interchangeable blade for hex drive



Size	TQX Nm	Short
		AS
		80 393 ...
SW1,5	0,9	11500
SW2	1,8	12000
SW2,5	3,8	12500
SW3	5,5	13000
SW4	8,0	14000



Suitable for easyTorque® 2 key article number 80 392 ...

Set – easyTorque® 2 key

▲ TORX®, TORX PLUS® 19-part fixed preset torque limitation in workbench stand

Scope of supply:

- ▲ 6 x easyTorque® 2 key handle (Nm 0.6/0.9/1.2/1.5/2.2/3.0)
- ▲ 6 x TORX® interchangeable blade (T6/T7/T8/T9/T10/T15)
- ▲ 6 x TORX PLUS® interchangeable blade (6IP/7IP/8IP/9IP/10IP/15IP)
- ▲ 1 x workbench stand



WT
kg
0.861

AS
80 392 ...
19919

Set – easyTorque® 2 key

▲ TORX®, TORX PLUS® 23-part fixed preset torque limitation in workbench stand

Scope of supply:

- ▲ 8 x easyTorque® 2 key handle (Nm 0.6/0.9/1.2/1.5/2.2/3.0/3.8/5.0)
- ▲ 7 x TORX® interchangeable blade (T6/T7/T8/T9/T10/T15/T20)
- ▲ 7 x TORX PLUS® interchangeable blade (6IP/7IP/8IP/9IP/10IP/15IP/20IP)
- ▲ 1 x workbench stand



WT
kg
1.093

AS
80 392 ...
19923

TORX® screwdriver



Size	LB mm	TQX Nm
T05	35	0,5
T06	35	0,9
T07	35	1,7
T08	40	2,6
T09	40	3,4
T10	40	4,5
T15	45	7,7
T20	45	12,7

AS
80 950 ...
082
083
084
085
086
087
088
089

TORX® screwdriver sets



Size
T06, T07, T08, T09, T10, T15, T20

AS
80 950 ...
090

TORX PLUS® screwdriver



Size	LB mm	TQX Nm
T05-IP	35	0,5
T06-IP	35	0,9
T07-IP	35	1,7
T08-IP	40	2,6
T09-IP	40	3,4
T10-IP	40	4,5
T15-IP	45	7,7
T20-IP	45	12,7

AS
80 950 ...
057
058
059
060
061
062
063
064

TORX PLUS® screwdriver sets



Size
T06IP, T07IP, T08IP, T09IP, T10IP, T15IP, T20IP

AS
80 950 ...
091

Allen key with cross handle



DRVS	TQX
mm	Nm
2	1,9
2,5	3,8
3	6,6
4	16
5	30
6	52
8	120
10	220

AS
80 397 ...
020
025
030
040
050
060
080
100

Allen keys with cross handle – Set

▲ 7-piece Allen key set in workbench stand



Size
SW2, SW2,5, SW3, SW4, SW5, SW6, SW8

AS
80 397 ...
99900

TORX® screwdriver



Size	LB mm
T06	60
T07	60
T08	60
T09	60
T10	80
T15	80
T20	100
T25	100
T30	115

AS
80 950 ...
100
101
102
103
104
105
106
107
092

TORX® MagicSpring®



Size	LB mm
MS T06	60
MS T07	60
MS T08	60
MS T09	60
MS T10	80
MS T15	80
MS T20	100
MS T25	100
MS T30	100

AS
80 950 ...
108
109
110
111
112
113
114
115
131



A stainless steel spring holds MagicSpring®, TORX®, and TORX PLUS® screws in place.



TORX PLUS® screwdriver



Size		LB	AS	
		mm	80 950 ...	
T06-IP	60			116
T07-IP	60			117
T08-IP	60			039
T09-IP	60			118
T10-IP	80			119
T15-IP	80			120
T20-IP	100			121
T25-IP	100			122

TorqueFix® handle

- ▲ With fixed torque
- ▲ Standards: EN ISO 6798, BS EN 26789, ASME B107.14M
- ▲ Accuracy: ± 6%, traceable to national standards
- ▲ Bits to be clamped in the universal holder only



TQX	AS	
Nm	80 021 ...	
0,4		00400
0,5		00500
0,6		006
0,7		007
0,8		008
0,9		00900
1		010
1,1		01100
1,2		012
1,5		01500
1,6		016
2		020
2,5		02500
3		030
3,2		032
3,8		03800
4		040
5		050
5,5		055
6		060
7,2		07200

TorqueVario®-S

▲ Patented handle

Scope of supply:
Incl. Torque-Setter setting tool



TQX Nm		AS
		80 950 ...
0,4 - 1,0		046
0,5 - 2,0		191
0,8 - 5,0		192
2,0 - 7,0		193

Interchangeable blade for TORX®



Size		Long	
TQX Nm		AS	
		80 950 ...	
T05	0,4		048
T06	0,6		031
T07	0,9		032
T08	1,3		033
T09	2,5		034
T10	3,8		035
T15	5,5		036
T20	8,0		037
T25	8,0		038



Suitable for TorqueFix® handle article number 80 021 ... and TorqueVario®-S article number 80 950 ...

Interchangeable blade for TORX PLUS®



Size		TQX Nm	Long	
			AS	
			80 950 ...	
T05-IP	0,5			049
T06-IP	0,8			050
T07-IP	1,3			051
T08-IP	2,0			043
T09-IP	3,0			052
T10-IP	4,5			053
T15-IP	6,6			054
T20-IP	8,0			055



Suitable for TorqueFix® handle article number 80 021 ... and TorqueVario®-S article number 80 950 ...

Interchangeable blade for hex drive



Size		TQX Nm	Long	
			AS	
			80 950 ...	
SW1,5	0,9			151
SW2	1,8			152
SW2,5	3,8			153
SW3	5,5			154
SW4	8,0			155



Suitable for TorqueFix® handle article number 80 021 ... and TorqueVario®-S article number 80 950 ...

Universal holder for bits

▲ 162 mm long



for
DIN3126-C/E 6,3-1/4"

AS
80 950 ...
014

TORX® short bit (25 mm)

▲ DIN3126-C 6.3 – 1/4"



Size	TQX Nm
T06	0,9
T07	1,7
T08	2,6
T09	3,4
T10	4,5
T15	7,7
T20	12,7
T25	19
T30	37,4

AS
80 950 ...
015
016
017
018
019
020
021
022
093

TORX PLUS® short bit (25 mm)

▲ DIN3126-C 6.3 – 1/4"



Size	TQX Nm
T08-IP	2,6
T10-IP	4,5
T15-IP	7,7
T20-IP	12,7
T25-IP	19

AS
80 950 ...
068
070
071
072
073

Bit – hexagonal (50 mm)

▲ DIN3126-E 6.3 – 1/4"



Size		AS
		80 398 ...
SW1,5		01500
SW2		02000
SW2,5		02500
SW3		03000
SW3,5		03500
SW4		04000
SW4,5		04500
SW5		05000
SW6		06000
SW8		08000

TORX® long bit (50 mm)

▲ DIN3126-E 6.3 – 1/4"



Size	TQX Nm	AS
		80 950 ...
T06	0,9	023
T07	1,7	024
T08	2,6	025
T09	3,4	026
T10	4,5	027
T15	7,7	028
T20	12,7	029
T25	19	030
T30	37,4	094

TORX® long bit (70 mm)

▲ DIN3126-E 6.3 – 1/4"



Size	TQX Nm	AS
		80 950 ...
T20	12,7	179

TORX PLUS® Allen key



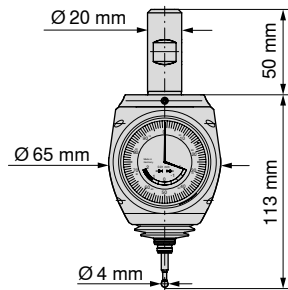
Size		OAL mm	AS 80 951 ... 01500 02000
T15-IP		58	
T20-IP		62	

CoreLine – Universal 3D tester

- ▲ Fast and accurate positioning at reference edges
- ▲ For locating and/or setting the zero point of the workpiece
- ▲ With adjustable radial run-out accuracy
- ▲ Can be used in all 3 axes (x, y, z)
- ▲ For all NC and erosion machines (insulation between stylus and case)
- ▲ Reading of actual dimensions is independent of direction
- ▲ Reading precision 0.01 mm

Scope of supply:

3D tester including short stylus and Allen key



Universal 3D tester

CT

85 290 ...

100

CoreLine – Zero height setting gage

- ▲ To determine the point of reference and/or for adjusting tools "to zero"
- ▲ Plate Ø 10 mm
- ▲ Plate is hardened, non-magnetic



OAH
mm

100

CT

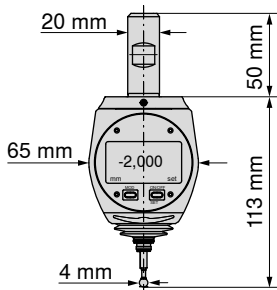
85 900 ...

018

CoreLine – Digital 3D tester

- ▲ Fast and accurate positioning at reference edges
- ▲ For locating and/or setting the zero point of the workpiece
- ▲ With adjustable radial run-out accuracy
- ▲ Can be used in all 3 axes (x, y, z)
- ▲ For all NC and erosion machines (insulation between stylus and case)
- ▲ Reading of actual dimensions is independent of direction
- ▲ Reading precision 0.001 mm

Scope of supply:
3D tester including short stylus and Allen key

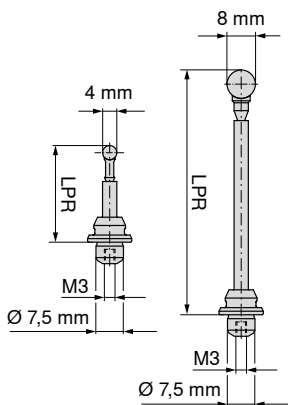


Digital 3D tester

CT
85 291 ...
100

Stylus for 3D tester

- ▲ With movement of 2 mm beyond the zero point, a break-off ceramic insert prevents damage to the unit
- ▲ If the stylus is broken, remove and insert a new stylus
- ▲ Check radial run-out accuracy and adjust if necessary



LPR
mm
25
65

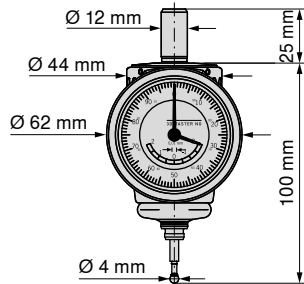
CT
85 290 ...
102
104

CoreLine – Universal 3D tester HQ

- ▲ Fast and accurate positioning at reference edges
- ▲ Development of the existing universal 3D tester
- ▲ Improved mechanics
- ▲ Compact size
- ▲ Characterized by over travel safety
- ▲ Functionality as with 85 290 100
- ▲ Reading precision 0.01 mm

Scope of supply:

3D tester including short stylus and Allen key



CT

85 292 ...

100

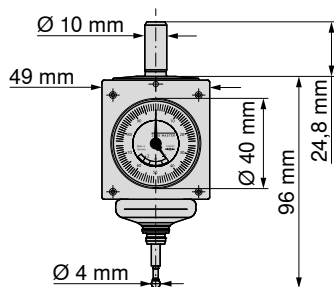
Universal 3D tester HQ

CoreLine – Universal 3D tester Mini

- ▲ Fast and accurate positioning at reference edges
- ▲ Very small universal 3D tester
- ▲ Particularly suitable for machines with small spindle taper e.g., SK 30 or HSK 32
- ▲ Low overhang length thanks to short housing
- ▲ Characterized by over travel safety
- ▲ Functionality as with 85 290 100
- ▲ Reading precision 0.01 mm

Scope of supply:

3D tester including short stylus and Allen key



CT

85 295 ...

100

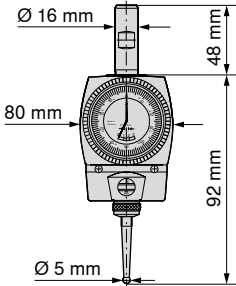
Universal 3D tester Mini

Center finder

- ▲ Centralize holes and shafts quickly and accurately
- ▲ Simple operation
- ▲ Dial gage remains in the operator's vision during process
- ▲ Centering accuracy 0.003 mm

Scope of supply:

3D tester incl. straight stylus and telescopic rod



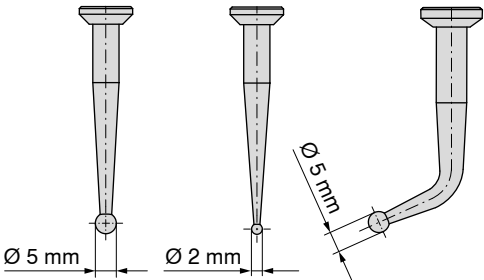
CT
85 299 ...
100

Center finder



Measuring range with stylus Ø 5 mm:
holes Ø 6–125 mm, shafts Ø 0–125 mm

Stylii for center finder



CT
85 299 ...
102
104
106

- Straight stylus / ball Ø 2 mm
- Straight stylus / ball Ø 5 mm
- Curved stylus / ball Ø 5 mm

Telescopic rod for center finder



DCONMS mm	OAL mm
6	478

CT
85 299 ...
111

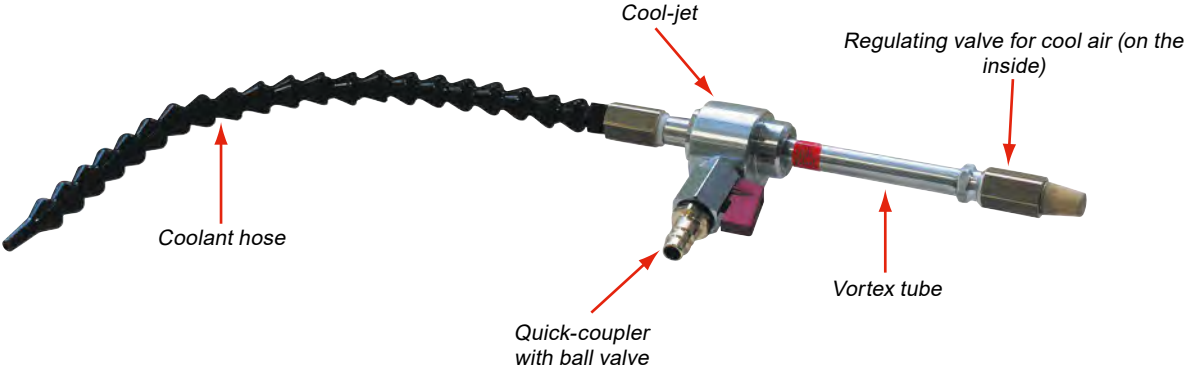
Advantages of using the cold air nozzle

The main advantages are that cooling agent disposal is not required and tool life increases by up to 100% when dry machining.

In order to improve the service life when dry machining, we recommend the use of our cooling nozzle, which can be used with a normal compressed air connection from a pressure of 6 bar.

It not only helps to **cool the tool and the workpiece**, but its main purpose is **chip removal** to prevent **chip jams**.





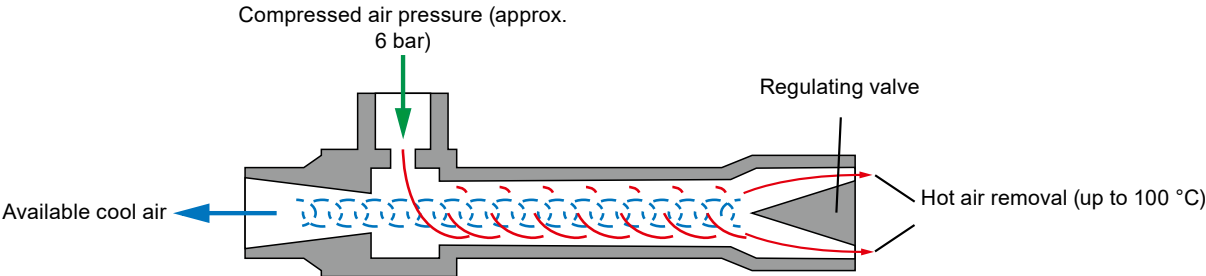
	CT		CT
	81 900 ...		81 900 ...
Cool-jet		Accessories	
3:7 bar air pressure, at -46 °C	100	Magnetic plate Ø 80 mm without clamping arm	101
		Spare tube, length 300 mm	104
		Jet silencer (air filter)	105
		Clamping arm, length 75 mm	106
		Complete set (with magnetic plate and clamping arm), weight 0.4 kg	107

Technical description – Operating instructions

The principle of the cold air nozzle is based on the use of vortex tubes. Ordinary air is divided into cold and hot air streams.

Without any additional power supply or moving parts, the cold air nozzle can deliver a **cooling performance of up to 733 W** and create **temperatures of approx. -42 °C** and it just requires operating pressure air of approx. 6 bar.

A water trap or service unit should be installed upstream of the cold air nozzle. A regulating valve in the hot air outlet regulates the temperatures and currents.





Utilizable air temperature measured at the effective discharge of the vortex tube (not the nozzle end)



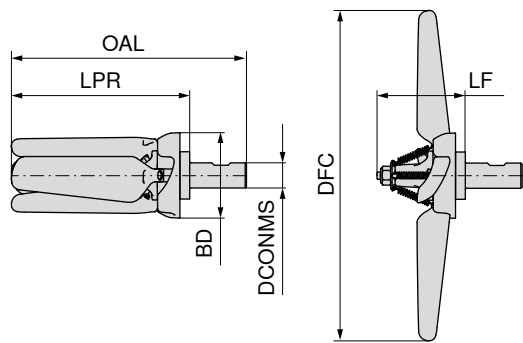
Air consumption at an inlet temperature of +21 °C and an inlet pressure of 6.9 bar: 7.08 l/sec. (25.5 m³/h)

Inlet pressure	3 bar	-31 °C	up to	-6 °C
	4 bar	-35 °C	up to	-8 °C
	5 bar	-39 °C	up to	-10 °C
	6 bar	-42 °C	up to	-11 °C
	7 bar	-46 °C	up to	-13 °C

The silencer must be unscrewed in order to operate the regulating valve and there is a risk of burns when doing this. The vortex tube on the hot air side can reach up to 100 °C, so allow it to cool before touching it.

CoreLine – Cleaning propeller – Large

- ▲ Chip and emulsion removal or drying processes via the tool spindle
- ▲ Simple replacement of the rotor blades



DCONMS	OAL	LPR	LF	DFC	BD	RPMX
mm	mm	mm	mm	mm	mm	1/min.
20	186.3	141.3	69.75	254	67.68	5000 - 8000

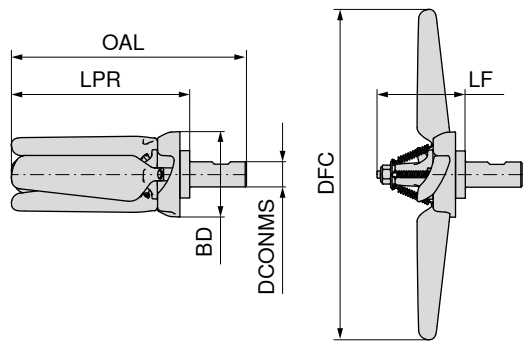
CT

80 399 ...

02000

CoreLine – Cleaning propeller – Small

- ▲ Chip and emulsion removal or drying processes via the tool spindle
- ▲ Simple replacement of the rotor blades



DCONMS	OAL	LPR	LF	DFC	BD	RPMX
mm	mm	mm	mm	mm	mm	1/min.
20	135	90	70	160	68	6000 - 12000

CT

80 399 ...

16000

Rotor blade kit

Scope of supply:
4 rotary blades and 4 tension springs



1 rotary blade and 1 tension spring 4 rotary blades and 4 tension springs

Size		CT	CT
klein		80 399 ... 36000	80 399 ... 46000
groß		30100	30200

Driven tools

CERATIZIT offers a comprehensive portfolio of driven tool holders for the turrets or machines of leading manufacturers. There is almost no limit to the range of types available. You will find a small selection of our holders here.

Examples from our driven tooling range



Axial drilling and milling head



Radial drilling and milling head



Rear offset radial drilling and milling head



Double radial drilling and milling head



Double axial drilling and milling head



Offset axial drilling and milling head



Swivel head



Modular milling

Summary of machine turret manufacturers and interfaces for which CERATIZIT can supply driven tools

- ▲ Sauter
- ▲ Baruffaldi
- ▲ Duplomatic
- ▲ DIN1809
- ▲ DIN5480
- ▲ DIN5482
- ▲ Baruffaldi Toem
- ▲ Bevel gear milling
- ▲ Spline / tooth milling
- ▲ BMT (bolt on)

Technical advice

Are you interested in our driven tools? If so, please contact your technical sales engineer, who will be glad to assist you. Alternatively, you can contact our office-based internal technical sales engineers, who can be reached on our freephone number.

Inquiry form

If you would like to submit an inquiry regarding driven tools, you can find a detailed inquiry form in the download area of our website. Please fill in this form carefully and send it to us via email or fax.

→ cutting.tools/en/download

Modular quick-change systems for driven tools

Do you want to optimize your setup times? CERATIZIT offers multiple ways of doing this! With one axial driven tool and one radial driven tool you are prepared for a wide range of machining demands as a result of the option of swapping various modules.

Varia VX

The new quick-change system for heavy duty machining

The face and taper contact interface ensures maximum radial run-out accuracy. The torque is transmitted via a form-fitting polygon, which can transmit up to 200 Nm.

Clamping and releasing takes place via a segmented gear wheel equipped with three multifunctional cams. When tightened with a radially mounted clamping screw, the 3-point clamping pulls the tool evenly into its operating position. When releasing, the tool force is applied mechanically via a sliding cam and the tool is released for removal from the adapter.



The advantages at a glance

- ▲ Cutting tools are preset off the machine
- ▲ Quick change thanks to only one clamping point
- ▲ No risk of injury when changing tools
- ▲ Transverse force-free clamping of the tools
- ▲ Safe torque transmission
- ▲ No loose parts



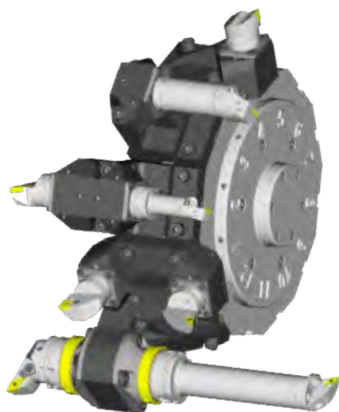
Preci-Flex® system – The stable solution for long tool life and high surface quality

The internal taper of the driven tools is suitable for any commercial type ER collets. The face and taper contact makes it possible to achieve ≤ 0.01 mm system radial run-out accuracy and ≤ 0.005 mm repeatability and the four clamping screws on the front face help to achieve maximum stability and system rigidity.



The range includes base holders for the collet sizes ER20, ER25, ER32, ER40, and ER50 and collet chucks with male or female nut, Weldon, Whistle Notch, shrink, boring bar, and shell mill adapters, hydraulic chucks, test arbors, and blanks. Also available for static VDI holders and rotating SK and HSK holders.

Quick-Change



The tool holder range comprises both innovative and technologically proven solutions for all common CNC turning centers. We offer solutions that are perfectly tailored to the make of machine, regardless of whether the machine has a BMT, VDI, or other connection type.

Every quick-change system has a standardized interface to DIN/ISO requirements and is available for HSK-T 40/63/100 and PSC 40/50/63 sizes. The tool change itself is carried out quickly and easily, minimizing idle times and thus boosting productivity.



Tool holder single and straight



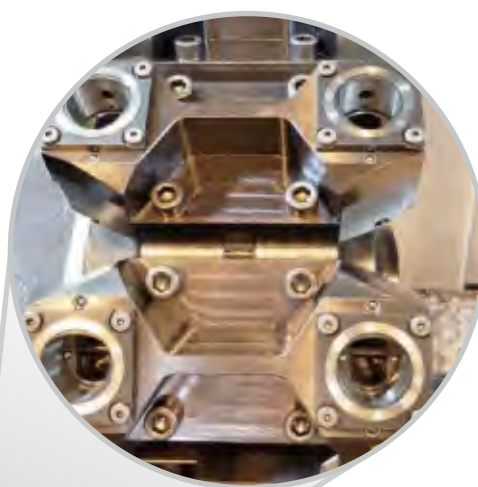
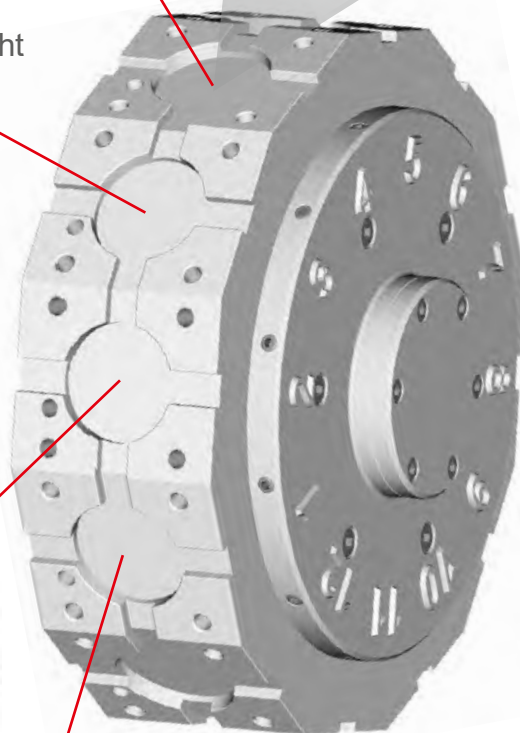
Tool holder double and straight



Single angle tool holder



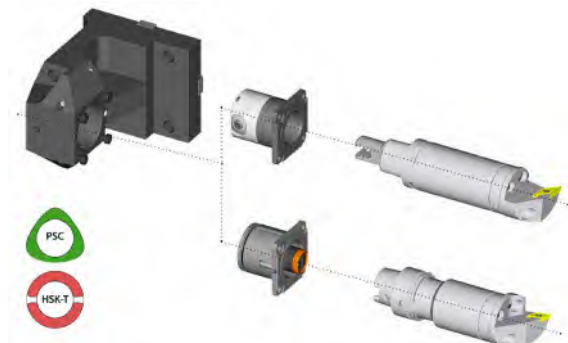
Double angle tool holder



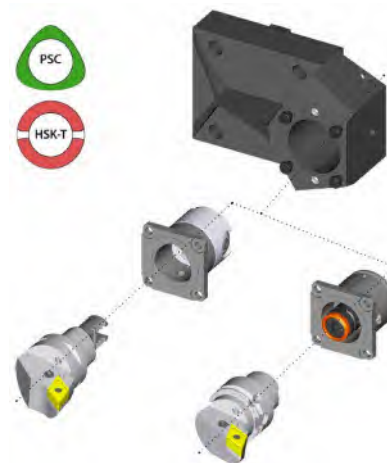
Revolver disc BMT/VDI/...

HSK/PSC clamping units

- ▲ The tool holders are fitted with either an HSK or PSC clamping unit.
- ▲ Clamping units are available in sizes HSK 40/63/100 and PSC 40/50/63.

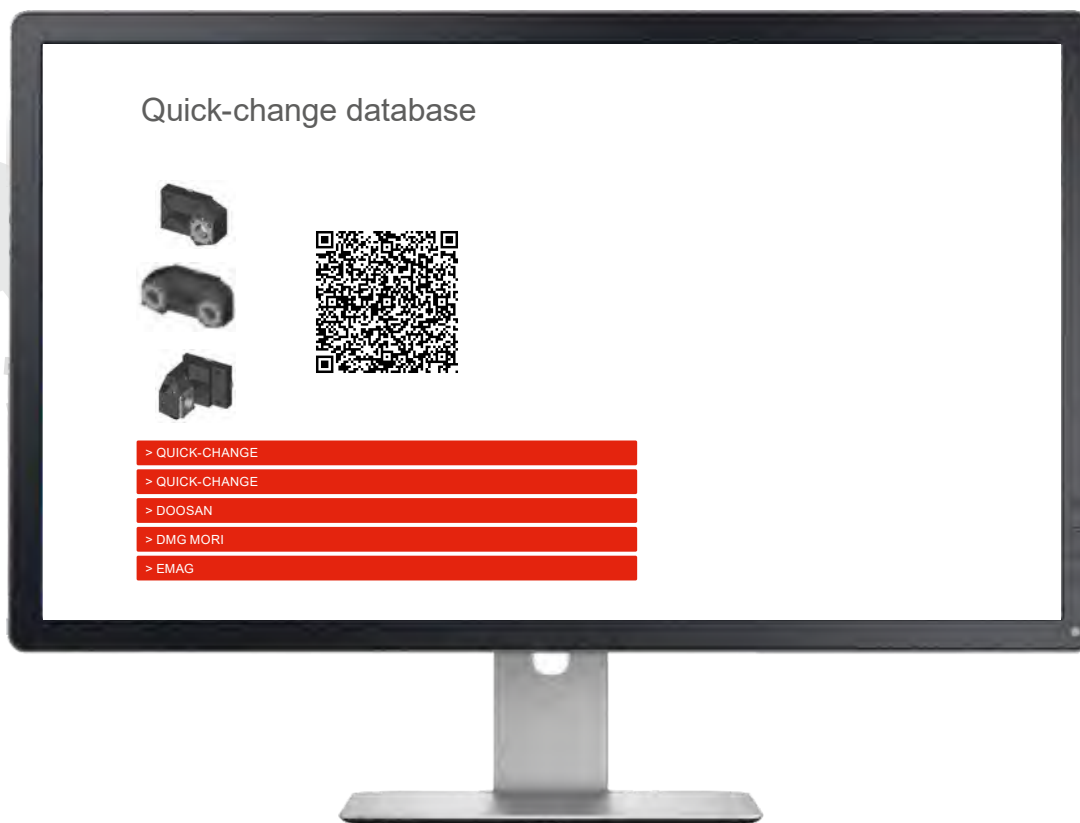


- ▲ The tool holders can therefore be flexibly adapted to the customer's requirements.



Online database

Our quick-change tool holders are individually adapted to turning machines to ensure the greatest possible levels of flexibility and efficiency. Using the online database, systems of previously specified machine types can be evaluated in order to obtain an initial overview.



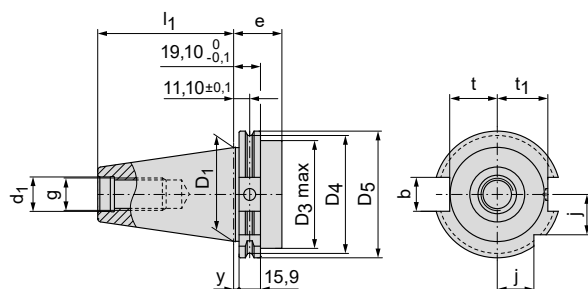
Information on inquiry process

- ▲ To make the inquiry process as easy as possible, please use our inquiry form to enter the most important machine data and information on the machining process.
Please fill in this form carefully and send it to us by email or fax.→ cutting.tools/en/download-quickchange

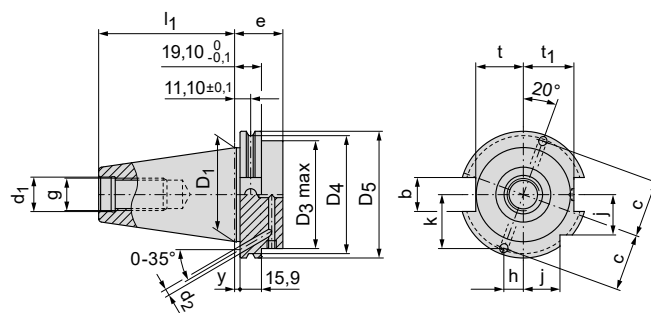
If you have any questions regarding the ordering process or the form itself, your CERATIZIT Technical Sales Engineer will be happy to help.

Technical data for steep taper tools

ISO 7388-1 – shape A

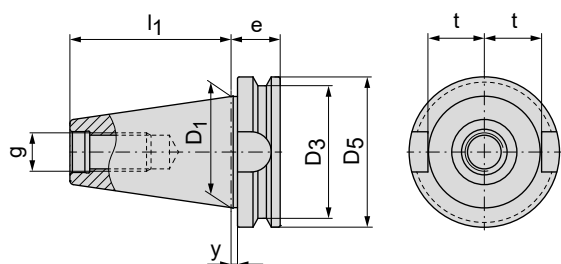


ISO 7388-1 – shape B



	D ₁ mm	D _{3 max} mm	D ₄ mm	D ₅ mm	l ₁ +0.20 mm	g	d ₁ H7 mm	e mm	y ±0.1 mm	t mm	t ₁ mm	j mm	d ₂ mm	h mm	k mm	c mm	b mm
SK 30	31,75	45	44,30	50	47,8	M 12	13	35	3,2	16,4	19	15					16,1
SK 40	44,45	50	56,25	63,55	68,4	M 16	17	35	3,2	22,8	25	18,5	4	9,2	25,4	27	16,1
SK 50	69,85	80	91,25	97,5	101,75	M 24	25	35	3,2	35,5	37,7	30	6	14,4	39,5	42	25,7

ISO 7388-2



Maximum recommended rpm for steep taper tools



SK / BT 30 up to 20,000 rpm

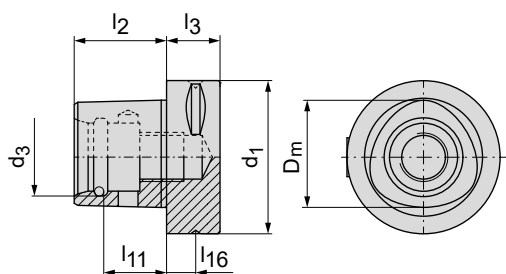
SK / BT 40 up to 20,000 rpm

SK / BT 50 up to 16,000 rpm

	D ₁ mm	D ₃ mm	D ₅ mm	l ₁ mm	g	e mm	t mm	y mm	b mm
BT 30	31,75	38	46	48,4	M 12	22	16,3	2	16,1
BT 40	44,45	53	63	65,4	M 16	27	22,5	2	16,1
BT 50	69,85	85	100	101,8	M 24	38	35,3	3,2	25,7

Technical data for polygon shank adaptors

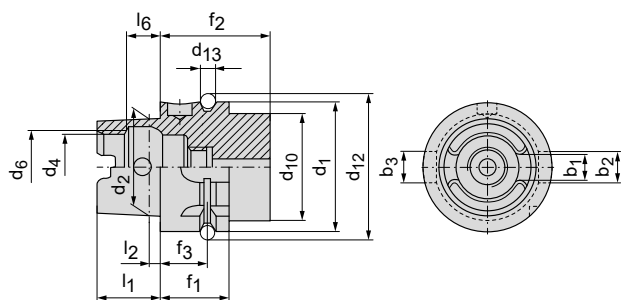
ISO 26623-1



	d ₁ mm	d _{3 ±0.05} mm	l _{2 ±0.1} mm	l ₃ mm	l _{11 ±0.1} mm	l ₁₆ mm	D _m mm
PSC 32	32	16,5	19	15	13,5	9	22
PSC 40	40	20	24	20	17,5	12	28
PSC 50	50	24	30	20	22	12	35
PSC 63	63	32	38	22	26	12	44
PSC 80	80	38	48	30	34	12	55

Technical data for HSK adapters

ISO 12164 – HSK-A / HSK-C



Maximum recommended rpm for HSK-A adapters

HSK-A 32 to 50,000 rpm
 HSK-A 40 to 42,000 rpm
 HSK-A 50 to 30,000 rpm
 HSK-A 63 to 25,000 rpm
 HSK-A 100 to 16,000 rpm

	b_1 mm	b_2 mm	b_3 mm	d_1 mm	d_2 mm	d_4 mm	d_6 mm	d_{10} mm	d_{12} mm	d_{13} mm	f_1 mm	f_2 mm	f_3 mm	l_1 mm	l_2 mm	l_6 mm
HSK 32	7,05	7	9	32	24	17	19	26	37	4	20	35	16	16	3,2	8,92
HSK 40	8,05	9	11	40	30	21	23	34	45	4	20	35	16	20	4	11,42
HSK 50	10,54	12	14	50	38	26	29	42	59,3	7	26	42	18	25	5	14,13
HSK 63	12,54	16	18	63	48	34	37	53	72,3	7	26	42	18	32	6,3	18,13
HSK 100	20,02	20	22	100	75	53	58	88	109,75	7	29	45	20	50	10	28,56

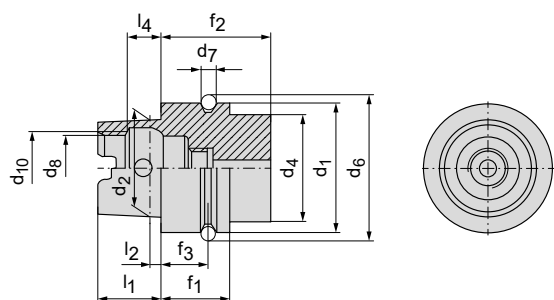
ISO 12164 – HSK-A

- ▲ Applied for machining centers, milling and special machines with automatic tool change
- ▲ **Central axial coolant supply via the coolant pipe**
- ▲ Torque transmission via 2 driving grooves at the taper end
- ▲ 2 grooves on the flange for the tool magazine, positioning notch, bore for data storage medium DIN 69873 in the flange

ISO 12164 – HSK-C

- ▲ Applied for machine spindles without automatic tool change as well as tool extensions and reducers
- ▲ **Central axial coolant supply via the coolant pipe**
- ▲ Torque transmission via two keyways at the taper end

ISO 12164 – HSK-E



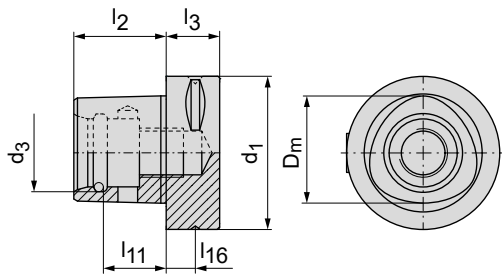
	d_1 mm	d_2 mm	d_4 mm	d_6 mm	d_7 mm	d_8 mm	d_{10} mm	f_1 mm	f_2 mm	f_3 mm	l_1 mm	l_2 mm	l_4 mm
HSK 40	40	30	34	45	4	21	23	20	35	16	20	4	11,42
HSK 50	50	38	42	59,3	7	26	29	26	42	18	25	5	14,13
HSK 63	63	48	53	72,3	7	34	37	26	42	18	32	6,3	18,13

ISO 12164 – HSK-E

- ▲ Applied for higher rpm (HSC) for high speed spindles with automatic tool change
- ▲ Rotation symmetrical, without keyways
- ▲ Torque transmission through friction
- ▲ **Possibility of central coolant supply via coolant pipe**

Technical information for polygon shank adaptors

ISO 26623-1



	d_1	$d_{3 \pm 0,05}$	$l_2 \pm 0,1$	l_3	$l_{11 \pm 0,1}$	l_{16}	D_m
PSC 32	32	16,5	19	15	13,5	9	22
PSC 40	40	20	24	20	17,5	12	28
PSC 50	50	24	30	20	22	12	35
PSC 63	63	32	38	22	26	12	44
PSC 80	80	38	48	30	34	12	55

Advantages of the PSC interface

The repeatability of the PSC shank is ± 2 microns



The tapered polygon in conjunction with the tight manufacturing tolerances provides backlash-free centering and also acts as a drive dog. The PSC taper has very high rigidity and bending strength. The main advantages of this interface are the transmittable torque stability, the resistance against radial forces acting on the tool, and the exact center height. This means large material cross sections can be machined and high feed rates achieved. The PSC interface is ideally suited to all machining operations such as drilling, turning, and milling.

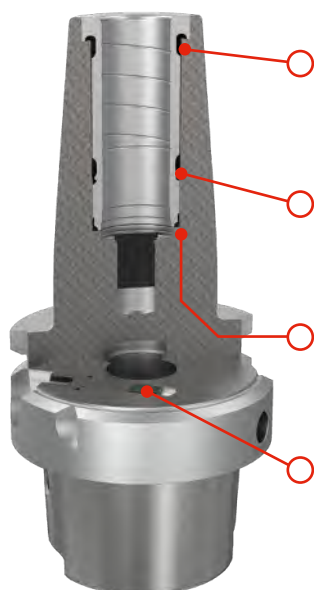
High pressure and hydraulic chucks

The right hydraulic chuck for a wide range of machining scenarios

Are you looking for higher cutting speeds to boost productivity and straightforward handling? The entire range of high pressure chucks and the range of hydraulic chucks from CERATIZIT guarantee easy, process-secure tool clamping for every application.

High pressure chuck		Application range		
Rough	Milling with strong forces > roughing	▽▽▽	▽▽	▽
Complus	First choice – general purpose	▽▽▽	▽▽	▽
Access 3°	Optimum accessibility	▽▽▽		
Access 4.5°	Optimum accessibility thanks to the same interference contour as the heat shrink adapter; state-of-the-art technology	▽▽▽	▽▽	
Hydraulic chuck		Application range		
Fit	First choice – general purpose	▽▽▽	▽▽	
Turn	Perfect for turning operations	▽▽▽	▽▽	
Compact	Affordable all-round alternative	▽▽▽	▽▽	
Main application	▽▽▽	▽▽	▽	
Secondary application	▽▽▽	▽▽	▽	

Maximum performance and productivity



New chamber design makes it possible to reverse the force at critical solder joints (from tensile to compression load), enabling significantly higher radial loads during machining.

New chamber design significantly reduces the technology's susceptibility to temperature (up to 80°C even during milling operations lasting up to 240 minutes).

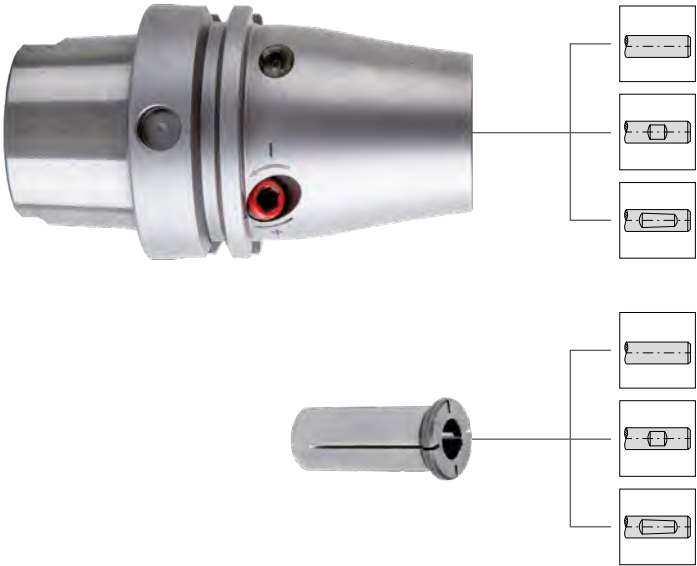
If there are multiple instances of unintended shrinking, the soldering system includes an emergency outlet to prevent potential injuries.

Double-lip sealing system dramatically increases the service life of the hydraulic chuck (over 10,000 clamping cycles under laboratory conditions).

High pressure and hydraulic chucks

Clamping of shanks with flats possible with or without reduction sleeve

HSS shanks DIN1835 and
solid carbide shanks DIN6535



Main areas of application

- ▲ HPC milling
- ▲ HSC milling
- ▲ Hard machining
- ▲ Drilling
- ▲ Reaming

Clamping force comparison with different systems

This comparison shows the higher retention forces of the high pressure chuck. A high clamping force is particularly important in the HPC machining of larger clamping diameters, as otherwise the tool may be pulled out of the adapter. The high pressure chuck now offers you this process security.

Main advantages

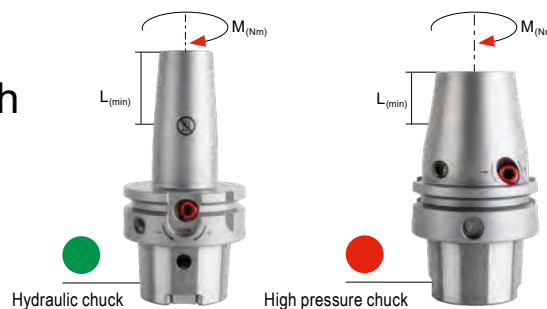
- ▲ Increased process security
- ▲ Longer tool life
- ▲ Improved surface quality
- ▲ Extended spindle life

Shank diameter	16	18	20	25	32	mm
	Maximum transmissible torque with shank tolerance h6					
Hydraulic chuck	170	240	330	400	650	Nm
High pressure chuck	350	430	520	650-750	800-890	Nm
Heat shrink adapter	200	290	450	530	700	Nm

Explanation of symbols

- Smooth cylindrical shank
- Cylindrical shank with "Weldon" lateral driving face
- Cylindrical shank with "Whistle Notch" angled clamping flat

Clamping torque values (Md) and minimum shank clamping depths for hydraulic and high pressure chucks



Minimum shank clamping depths

	Shank diameter	6	8	10	12	14	16	18	20	25	32	mm
●	Minimum clamping depth	27	27	31	36	36	39	39	41	47	51	mm
●	Minimum clamping depth						39	39	41	47	51	mm

Clamping torque values (Md) for direct clamping

	Clamping diameter (d1 h6)	6	8	10	12	14	16	18	20	25	32	mm
●	Md with shank at minimum size	20	30	47	80	100	160	200	330	400	650	Nm
●	Md with shank at maximum size	30	45	85	140	160	230	270	400	470	730	Nm
●	Md with shank at minimum size						280	360	550	650	800	Nm
●	Md with shank at maximum size						380	450	650	750	890	Nm

Clamping torque values (Md) for clamping with reduction sleeve Ø 32 mm

	Clamping diameter (d1 h6)	6	8	10	12	14	16	18	20	25	mm
●	Md with shank at minimum size	30	45	60	120	120	180	220	250	330	Nm
●	Md with shank at maximum size	45	65	110	170	170	230	300	320	440	Nm

Clamping torque values (Md) for clamping with reduction sleeve Ø 20 mm

	Clamping diameter (d1 h6)	3	4	5	6	8	10	12	14	16	mm
●	Md with shank at minimum size	6	9	16	30	55	90	120	135	190	Nm
●	Md with shank at maximum size	10	12	22	40	75	120	150	170	260	Nm

Clamping torque values (Md) for clamping with reduction sleeve Ø 12 mm

	Clamping diameter (d1 h6)	3	4	5	6	8	mm
●	Md with shank at minimum size	3	4	7	12	18	Nm
●	Md with shank at maximum size	4	8	12	20	26	Nm

For heat shrink adapters

Shank diameter	3	4	5	6	8	10	12	14	16	18	20	25	32	mm
Minimum clamping depth	12	16	20	26	26	31	37	37	40	40	42	48	52	mm
Permissible torque	4	11	17	24	45	82	145	190	200	290	450	530	700	Nm

Static clamping torques

Static clamping moments of the Centro-P ER precision collet chucks with different tightening torques measured at the lock nut.

Centro-P

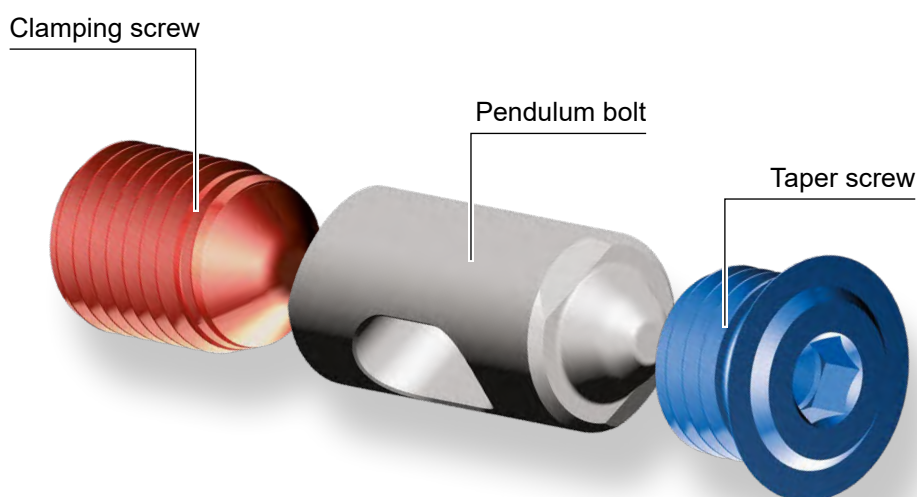
Clamping diameter (d1 h6)	2	3	3.5	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	mm	
ER 16 tightening torque 30 Nm	2	3.5	5																							Nm
ER 16 tightening torque 50 Nm				12	20	30	45	60	72	80																Nm
ER 25 tightening torque 40 Nm				10	20	40																				Nm
ER 25 tightening torque 75 Nm							62	75	85	95																Nm
ER 25 tightening torque 90 Nm											122	145	160	175	190	200										Nm
ER 32 tightening torque 60 Nm				20	30	40																				Nm
ER 32 tightening torque 120 Nm							75	90	110	120	135	150	160	180	190											Nm
ER 32 tightening torque 140 Nm																220	240	260	280	300						Nm
ER 40 tightening torque 70 Nm				60	75	90	100																			Nm
ER 40 tightening torque 110 Nm								110	125	140	150															Nm
ER 40 tightening torque 150 Nm												200	220	240	260	300	350									Nm
ER 40 tightening torque 200 Nm																			420	440	460	480	515	530		Nm

 Measurement of the specified clamping forces was performed exclusively statically. The actual clamping forces that arise during machining may deviate due to various influences (vibrations, oscillations, machining situation).

Technical information – ABS

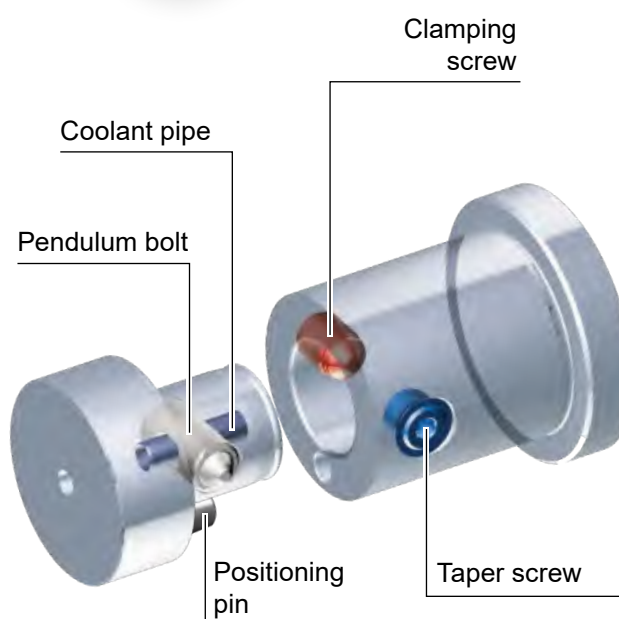
Even better connected

The extension of the proven ABS system complements the existing portfolio and continues to meet the high demands on accuracy. The adapter is an important element in tooling systems between the cutting tool and the machine. It must be able to reliably transmit the cutting forces that are produced. Adapters also have a considerable impact on the quality of the machining result. They also contribute to the cost-effectiveness of the machining process.



Advantages

- ▲ Improved force transmission
- ▲ Optimum machining result
- ▲ Higher cutting values possible
- ▲ Less noise pollution in production
- ▲ System fully compatible upwards and downwards
- ▲ Suitable for ABS, ABS N, and ABS T



Spare parts ABS	 Taper screw	 Pendulum bolt	 Clamping screw	 Set 1	 Coolant pipe	 Positioning pin	 Set 2	 Sealing disc
25	8495027000	8495026000	8495026800	8495099700	8495024400	8495023600	8495098900	8495030400
32	8495027100	8495026100	6295013989	8495099600	8495024500	8495023700	8495098800	8495030500
40	8495027200	8495026200	8495026900	8495099500	8495024600	8495023800	8495098700	8495030600
50	8495020400	8495020000	8495020300	8495099800	8495020100	8495020200	8495099900	8495030700
63	8495027300	8495026300	8495025500	8495099400	8495024700	8495023900	8495098600	8495030800
80	8495025100	8495026400	8495025600	8495099300	8495024800	8495024000	8495098500	8495030900
100	8495025200	8495026500	8495025700	8495099200	8495024900	8495024100	8495098400	8495031000
125	8495025300	8495026600	8495025800	8495099100	8495025000	8495024200	8495098300	
160	8495025400	8495026700	8495025900		8495023500	8495024300		

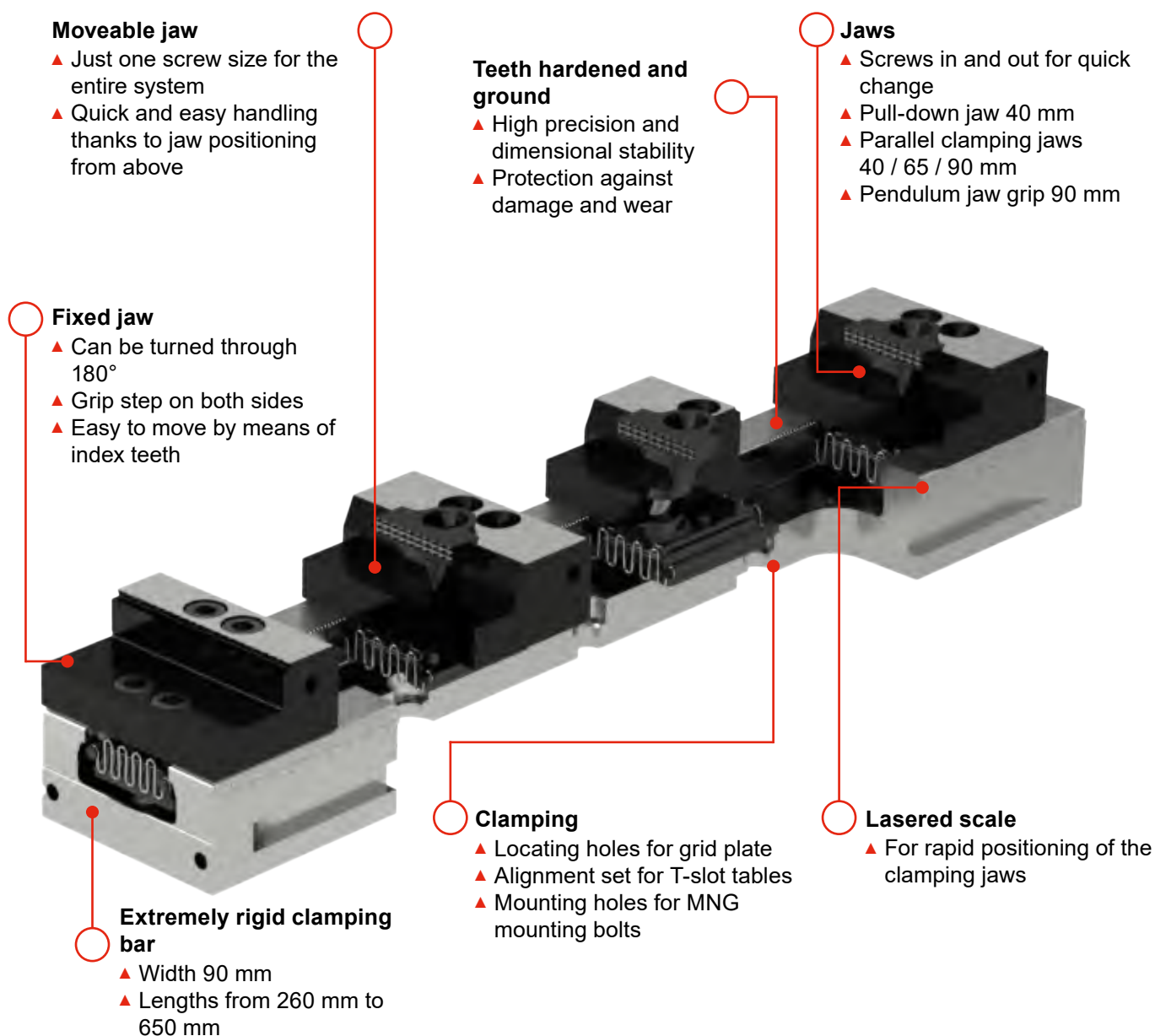


Workpiece clamping



Table of contents

- Clamping systems overview
- Toolfinder – Clamping systems
- Product programme
- General top jaws overview
- Workpiece supports overview
- Accessories General Overview
- Clamping levers overview
- Screws Overview



Clamping systems overview

Single vice

- ▲ Power-assisted systems NCG, HDG 2 and H5G
- ▲ Fixed jaws as reference
- ▲ High repeatability
- ▲ Very good angular accuracy



High precision and force amplification

Centric vice

- ▲ symmetrical clamping
- ▲ very good accessibility for 5-sided machining
- ▲ part datum always centered
- ▲ high repeatability



High process security with encapsulated system

Multiple vice

- ▲ Faster set up times
- ▲ multifunctional use
- ▲ optimum utilization of the machine table
- ▲ high repeatability



Increased machine uptime

Stationary three-jaw chuck – SBF 3

- ▲ Suitable for 3/5-axis machining of round components
- ▲ Compatible with PNG and MNG zero point clamping systems
- ▲ Wedge bar drive
- ▲ Hardened and stiff base body
- ▲ Optimised lubrication system



Ø 200 mm



Ø 315 mm



The perfect clamping situation for round components

Clamping variants

- ▲ Zero point clamping systems
- ▲ Zero point clamping system grid plates
- ▲ MNG – Mechanical zero point clamping system
- ▲ PNG – Pneumatic zero point clamping system



Reduction in setup times

Clamping Towers

- ▲ Double sided clamping tower
- ▲ Triangular clamping tower
- ▲ Cruciform clamping tower
- ▲ Cube clamping tower



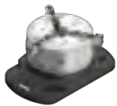
Automation made easy

Toolfinder clamping systems

Type	Description	3 axis	4 axis	5 axis	
Single vice	<div>NCG</div>  <ul style="list-style-type: none"> ▲ 160° quick clamping ▲ rapid installation and removal of the spindle assembly ▲ quick span adjustment 	✓	✓		
	<div>NCG 5A</div>  <ul style="list-style-type: none"> ▲ 160° quick clamping ▲ for 5 axis machining ▲ quick span adjustment 	✓		✓	
	<div>H5G</div>  <ul style="list-style-type: none"> ▲ fast handle clamping ▲ 5 axis high power vice ▲ 100% encapsulated 	✓		✓	
	<div>X5G -Z</div>  <ul style="list-style-type: none"> ▲ 100 % encapsulated ▲ Optimum accessibility ▲ 5- and 6-sided machining possible ▲ Fast jaw changeover without tools 	✓		✓	
	<div>ESG 4</div>  <ul style="list-style-type: none"> ▲ 100 % encapsulated ▲ Precision base body ▲ High clamping force ▲ Large clamping range 	✓	✓	✓	
	<div>ESG 5</div>  <ul style="list-style-type: none"> ▲ New version of the sealed centric vice ZSG 4 as single vice ▲ Identical dimensions and function as the ZSG 4 	✓	✓	✓	
	<div>HDG 2</div>  <ul style="list-style-type: none"> ▲ mechanical power transmission ▲ clamping force with only one turn of the handle ▲ infinitely variable clamping force setting 	✓			
Centric vice	<div>ZSG 4</div>  <ul style="list-style-type: none"> ▲ ball bearing, backlash free spindle ▲ high precision, clamping force and process security ▲ repeatability ± 0.01 mm 	✓	✓	✓	
	<div>ZSG mini</div>  <ul style="list-style-type: none"> ▲ Fast jaw changeover without tools ▲ compact and precise ▲ optimum accessibility from all sides ▲ stainless, hardened base body 	✓	✓	✓	

	Jaw width in mm	Body length in mm	max. clamping range in mm	cubic workpieces	assymetrical workpieces	round workpieces	max. clamping force in kN	Page No.
	100 125 160	305 390 530	245 343 506	✓	✓	✓	30 40 40	→
	100 125	305 390	199 269	✓		✓	18 24	→
	125	300	249	✓	✓	✓	40	→
	125	330 430 500 630 800	80-210 80-310 80-380 80-510 80-688	✓	✓	✓	40	→
	125 160	362 480	308 434	✓	✓	✓	40 50	→
	80 125 160	130+190 160+235+300 280+480	63-171 84-281 125-448	✓	✓	✓	35 35 50	→
	100 125 160	342 400 544	278 338 470	✓		✓	30 40 60	→
	80 125 160	130+190 160+235+300 280+480	121-185 163-303 134-462	✓	✓	✓	25 40 50	→
	45 70	80 100	7-77	✓	✓	✓	16	→

Toolfinder clamping systems

Type	Description	3 axis	4 axis	5 axis
Multiple vice	DSG 4  <ul style="list-style-type: none"> ▲ Quick assembly and disassembly ▲ Flexible clamping system ▲ Can be converted into single vice 	✓	✓	✓
	Verso  <ul style="list-style-type: none"> ▲ Variable clamping system ▲ Clamp several small and large components ▲ Innovative multiple vice system 	✓	✓	✓
Stationary three-jaw chuck	SBF 3  <ul style="list-style-type: none"> ▲ Suitable for 3/5-axis machining of round components ▲ Compatible with PNG and MNG zero point clamping systems 	✓		✓
	 <ul style="list-style-type: none"> ▲ Suitable for 3/5-axis machining of round components ▲ Compatible with PNG and MNG zero point clamping systems 	✓		✓

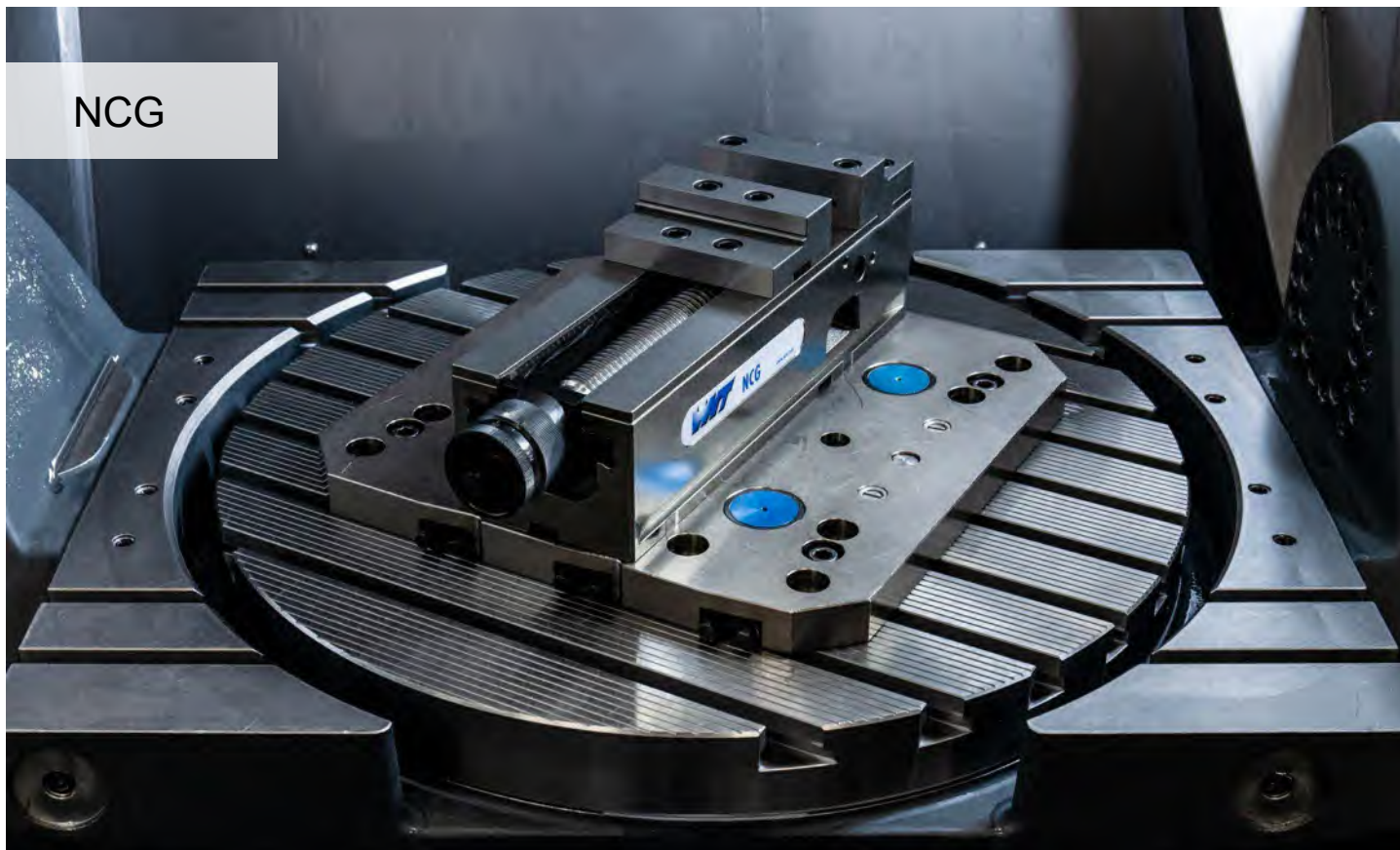
Type	Description
Zero point clamping systems	
mechanical	MNG  <ul style="list-style-type: none"> ▲ All round plate for all machine tables
	MNG mini  <ul style="list-style-type: none"> ▲ For workpiece clamping in the smaller dimension range
pneumatic	PNG  <ul style="list-style-type: none"> ▲ Process security thanks to self-locking mechanism
Clamping Towers	 <ul style="list-style-type: none"> ▲ Increased machine uptime

Manual machine vice

Drilling machine vice	
	HSG  <ul style="list-style-type: none"> ▲ fast jaw adjustment, compact and precise

	Jaw width in mm	Body length in mm	max. clamping range in mm	cubic workpieces	assymetrical workpieces	round workpieces	max. clamping force in kN	Page No.
	80	300	102				25	
	125	320+390+460 530+600+670+740	114+149+184 219+254+289+324	✓	✓	✓	40	→
	40 65 90	260 -650	524	✓	✓	✓	30	→
		Ø 200	SB-H jaws 6–180			✓	100	
		Ø 315	SB-H jaws 12–420			✓	180	→
	mechanical		pneumatic		Comments			Page No.
	✓							→
	✓							→
			✓					→
	✓							→
	✓							→

NCG



Systematic clamping

Modular machine vice as system with clamping under tension. Unique, patented fast handle clamping with mechanical power assist and minimum setup times.

Your benefits:

- ▲ Quick adjustment using a crank handle
- ▲ Quick positioning with MNG on the machine table without an intermediate pallet
- ▲ Clamping force can be continuously adjusted 4 – 40 kN
- ▲ 160° quick clamping
- ▲ Quick and easy jaw change with 4 screws
- ▲ Easy cleaning thanks to rapid disassembly of the entire spindle unit
- ▲ Extensive modular jaw range



Clamping/aligning:



Clamping with two dowel screws
dia. 12_{H7} / M12 (NCG 100)
Article no. 80 890 313 or dia. 16_{g5} / M16
(NCG 125 / 160) **Article no. 80 890 314**



Alignment through 20_{H7} precision slot
nuts in the base body and clamping with
clamping claws



Alignment and clamping with MNG zero
point clamping system (2-3 mounting bolts)

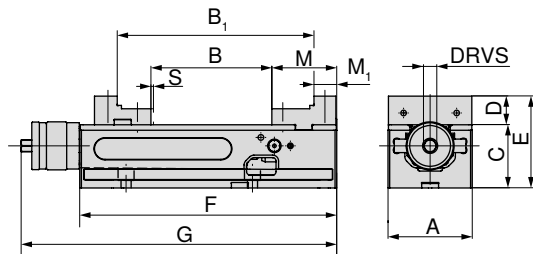
CoreLine – NC-quick clamping vice with combi reversible jaw plus – NCG

▲ thanks to additional threads, top jaws with heights of 18 mm and 40 mm can be used

Scope of supply:

NC-quick vice, including 4 clamping claws, 2 combi reversible jaw plus, clamping lever

NCG	MNG	PNG
-----	-----	-----



A	B	B ₁	C -0.02	D	E	F	G	M	M ₁	S	DRVS	MXC	WT
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kN	kg
125	0 - 212	96 - 307	100	39	139	390	457	89	39	3	14	4 - 40	34

CW

80 890 ...
12500

CoreLine – NC-quick clamping vice with combination jaw – NCG

▲ Fast 160° handle clamping

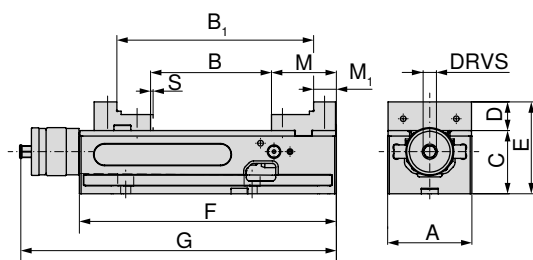
▲ Rapid installation and removal of the spindle assembly

▲ S = powerstroke

Scope of supply:

NC-quick vice, including 4 clamping claws, 2 combi reversible jaws (one side stepped, one side smooth), clamping lever

NCG	MNG	PNG
-----	-----	-----



A	B	B ₁	C -0.02	D	E	F	G	M	M ₁	S	DRVS	MXC	WT
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kN	kg
100	0 - 155	91 - 245	75	34	109	305	374	77	27	2,5	14	4 - 30	19
125	0 - 212	96 - 307	100	39	139	390	457	89	39	3	14	4 - 40	34
160	0 - 314	113 - 426	115	49	164	530	600	108	52	3	14	4 - 40	68

CW

80 890 ...
602
627
662

Vice guide

→ Underside Dimensions	→ General top jaws
→ Structural dimension tables for the different jaws	→ Workpiece location
→ System jaws	→ General accessories
→ System accessories	→ Clamping lever
→ MNG-/PNG zero point clamping system	→ Screws

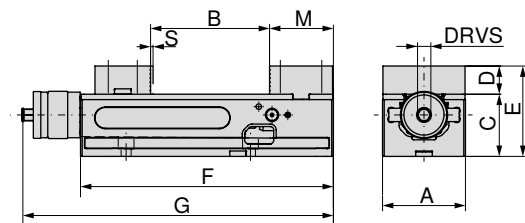
CoreLine – NC-quick clamping vice with standard jaw – NCG

- ▲ Fast 160° handle clamping
- ▲ Rapid installation and removal of the spindle assembly
- ▲ S = powerstroke

Scope of supply:

NC-quick vice, including 4 clamping claws, 2 standard reversible jaws (one side smooth, one side serrated), clamping lever

NCG	MNG	PNG
-----	-----	-----



A	B	C _{-0.02}	D	E	F	G	M	S	DRVS	MXC	WT
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kN	kg
100	0 - 155	75	34	109	305	374	77	2,5	14	4 - 30	19,5
125	0 - 212	100	39	139	390	457	89	3	14	4 - 40	35,0
160	0 - 314	115	49	164	530	600	108	3	14	4 - 40	70,0

CW

80 890 ...
600
625
660

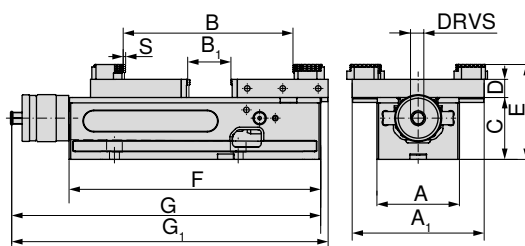
CoreLine – NC-quick clamping vice with adapter and pendulum jaws – NCG

- ▲ fast 160° lever clamping
- ▲ rapid installation and removal of the spindle assembly
- ▲ S = powerstroke
- ▲ simple raw part clamping
- ▲ free positioning of the 6-face reversible jaw which can be found in the accessories

Scope of supply:

NC-quick vice (type NCG base body) with 1 fixed adapter plate and 1 pendulum jaw, clamping lever, 4 clamping claws, without 6-face indexable jaws

NCG	MNG	PNG
-----	-----	-----



A	A ₁	B	B ₁	C _{-0.02}	D	E	F	G	G ₁	S	DRVS	MXC	WT
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kN	kg
100	160	10 - 230	0 - 77	75	22	115	305	374	383	2,5	14	4 - 30	19
125	192	16 - 343	0 - 152	100	22	140	390	457	478	3	14	4 - 40	34
160	256	15 - 506	0 - 237	115	22	155	530	600	631	3	14	4 - 40	68

CW

80 890 ...
636
637
638

Vice guide

→ Underside Dimensions	→ General top jaws
→ Structural dimension tables for the different jaws	→ Workpiece location
→ System jaws	→ General accessories
→ System accessories	→ Clamping lever
→ MNG-/PNG zero point clamping system	→ Screws

CoreLine – NC quick vice 5A with high support jaws – NCG 5A

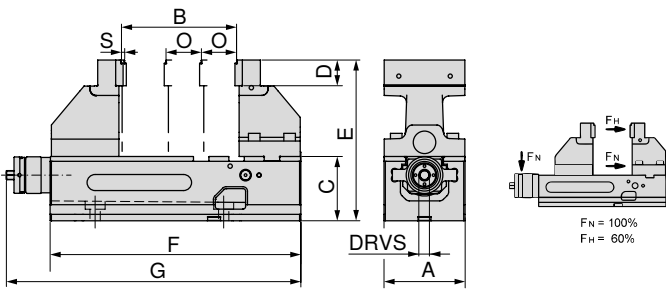
- ▲ Fast 160° handle clamping
- ▲ Rapid installation and removal of the spindle assembly
- ▲ S = powerstroke
- ▲ Ideally suited to 5-axis machining due to optimum accessibility
- ▲ Reversible jaws for clamping range extension
- ▲ 100 mm base body has 2 slots for moving the fixed jaw
- ▲ 125 mm base body has 3 slots for moving the fixed jaw

Scope of supply:
NC quick clamping vice incl. 2 high base jaws, 2 'grip' stepped jaws 5 mm, 1 clamping lever, 4 clamping claws

NCG
5A

MNG

PNG





A	B	C	D	E	F	G	O	S	DRVS	MXC	WT
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kN	kg
125	6 - 179	100	40	250	390	457	55	3	14	4 - 24 (40)	42

CW

80 890 ...

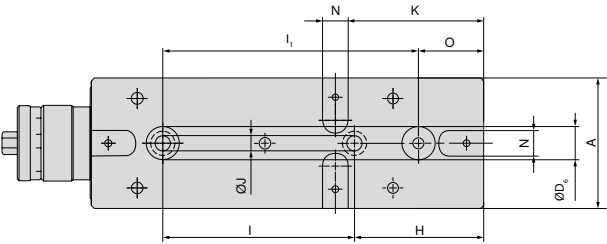
635

Vice guide

→ Underside Dimensions	→ General top jaws
→ Structural dimension tables for the different jaws	→ Workpiece location
→ System jaws	→ General accessories
→ System accessories	→ Clamping lever
→ MNG-/PNG zero point clamping system	→ Screws

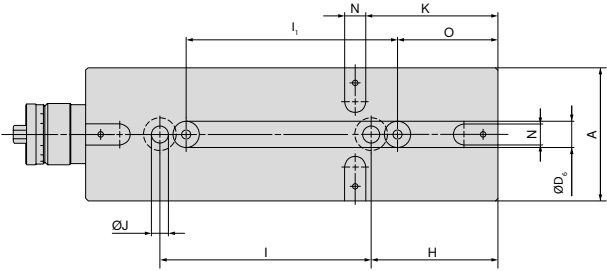
NCG underside dimensions

Base width 100 mm



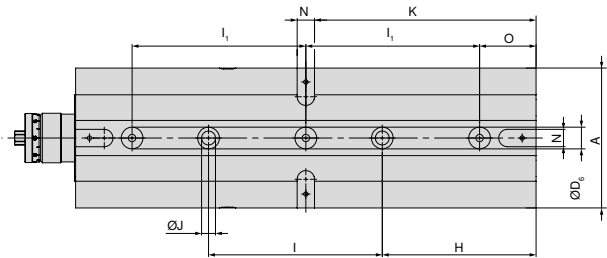
A	H	I ±0,015	J F7	K	N H7	O	I1 ±0,015	D6 H7
mm	mm	mm	mm	mm	mm	mm	mm	mm
100	100	150	12	105	20	50	200	25

Base width 125 mm



A	H	I ±0,015	J F7	K	N H7	O	I1 ±0,015	D6 H7
mm	mm	mm	mm	mm	mm	mm	mm	mm
125	120	200	16	125	20	95	200	25

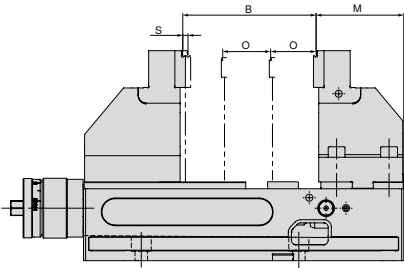
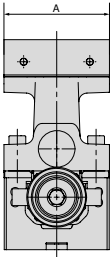
Base width 160 mm



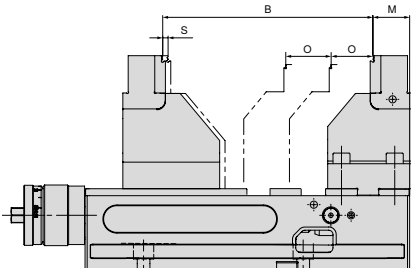
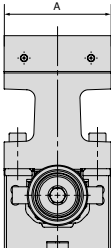
A	H	I ±0,015	J F7	K	N H7	O	I1 ±0,015	D6 H7
mm	mm	mm	mm	mm	mm	mm	mm	mm
160	177	200	16	255	20	65	200	25

NCG 5A structural dimension table for different jaw positions

NCG 5A 125 mm



A	B	M	O	S
mm	mm	mm	mm	mm
125	6 - 182	91	55	3



A	B	M	O	S
mm	mm	mm	mm	mm
125	117 - 269	36	55	3

Combi reversible jaw plus, fixed

-
- The technical drawing on the left shows a 3D perspective view of a mechanical part with the following dimensions: D (total height), D_1 (height of the base), A (width of the base), and M (width of the top flange). The part features a central slot and four mounting holes. To the right is a 3D CAD model of the same part, rendered in a light gray color.

[illegible]

	CW	●	ESG 4	ESG 5	HdG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8089035200		●	ESG 4	ESG 5	HdG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG

[illegible][illegible]

[illegible]

5A carrier jaw, fixed

-
- The technical drawing on the left shows a 3D perspective view of a mechanical component. It features a base with a central slot and two side flanges. A top plate is mounted on the base, secured by two screws. Dimension lines indicate the following measurements: A_1 for the width of the top plate, E for the height of the base, and A for the width of the base. A small circular feature is visible on the side of the top plate. To the right of the drawing is a photograph of the actual component, which is a small, blue, rectangular plastic part with a similar design to the drawing.

5A carrier jaw, movable

- 
- Technical drawing and photograph of a 1000 Series 1/2" component. The drawing shows a side view with dimensions: A_1 (width of the top flange), E (height of the top flange), and A (width of the base). The photograph shows the physical component, which is a blue plastic fitting with a white top flange.

Fixed adaptor jaw

-

Pendulum jaw, movable

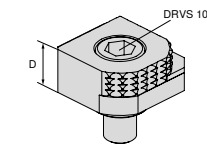
-
- The technical drawing on the left shows a rectangular plate with dimensions M (width), D (thickness), and A_1 (length). It features a central circular hole with a diameter of $\varnothing 10$ and four smaller circular holes, each with a diameter of $\varnothing 4$, arranged in a square pattern. The photograph on the right shows the physical plate, which is dark grey and has the same hole pattern as the drawing.

For vice width										CW	NCG	H5G / S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂													
100	100	160	22			110															
125	125	192	22			130															
160	160	256	22			170															

System jaws overview

6 function indexable jaw

- ▲ 1 = Smooth, carbide coated
- ▲ 2 = Grip with 3 mm step
- ▲ 3 = Grip with 8 mm step
- ▲ 4 = Grip with 18 mm step
- ▲ 5 = Rough grip with 8 mm step
- ▲ 6 = Round grip
- ▲ $M_{max} = 60\text{ Nm}$
- ▲ Including fixation screws

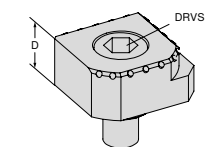
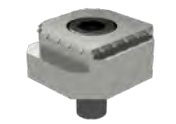


For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
18									

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80892246	●	●	●	●			●		●	●	

6x indexable jaw, carbide grip

- ▲ 1 = Smooth
- ▲ 2 = Carbide grip
- ▲ 3 = Carbide grip with 3 mm step
- ▲ 4 = Carbide grip with 8 mm step
- ▲ 5 = Round carbide grip with 8 mm step
- ▲ 6 = Round carbide grip
- ▲ Incl. fixing screws



For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
18									

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8089035300	●	●	●	●			●		●	●	

System accessories overview

Spindle body

▲ For the conversion of the NCG 5AC into an NCG vice

- NCG
- NCG 5A



for width mm	CW
100	80 890 ... 385
125	387
160	389

Cover plate set

- NCG
- NCG 5AC



for width mm	CW
100	80 890 ... 442
125	443
160	444

System accessories overview

Carrying handle

▲ for simple and safe transporting

Scope of supply:
1 piece Hand grip including fixing bolts

- NCG
- NCG
5AC



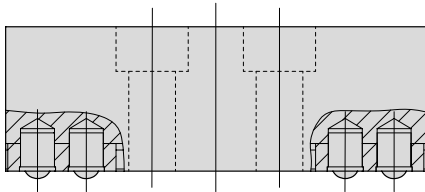
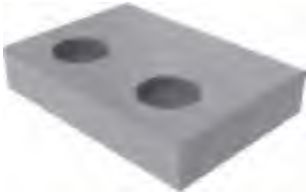
for width
mm
100/125

CW
80 890 ...
685

Protection plate

▲ For standard moving and combi reversible jaw

- NCG



for width
mm
100
125
160

CW
80 890 ...
010
012
013

System accessories overview

Spring Loaded Locator

NCG



for width mm	CW
100/125	80 890 ...
160	008 014

Clamping lever

▲ including control accessories

NCG

NCG 5A

H5G



for width mm	DRVS mm	CW
100/125/160	14	80 890 ...
		501

System accessories overview

High-speed operation device

▲ For faster span adjustment with removable grip

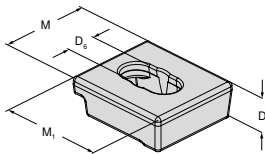
- NCG
- NCG 5AC



for width mm		CW
100		80 890 ...
125/160		550
		551

Clamping claws

▲ Price for 2 pieces



D	D ₆	M	M ₁	CW
mm	mm	mm	mm	80 890 ...
20	16	50	57	315

System accessories overview

Tenon incl. screw

▲ Price per 2 pieces

- NCG
- H5G
- H5G-S
- ESG4
- HDG2
- DSG4
- DSG
- X5G-Z



for width		CW
mm		80 898 ...
12		412
14		414
16		416
18		418

Clamping screw and T-Nuts

▲ For mounting the clamping claw
▲ Price per 2 pieces

Scope of supply:
Incl. washers

- NCG
- H5G
- ESG4
- HDG2
- ZSG4
- DSG4
- Verso



for slot width		G	CW
mm			80 890 ...
12	M10		308
14	M12		309
16	M14		310
18	M16		311

System accessories overview

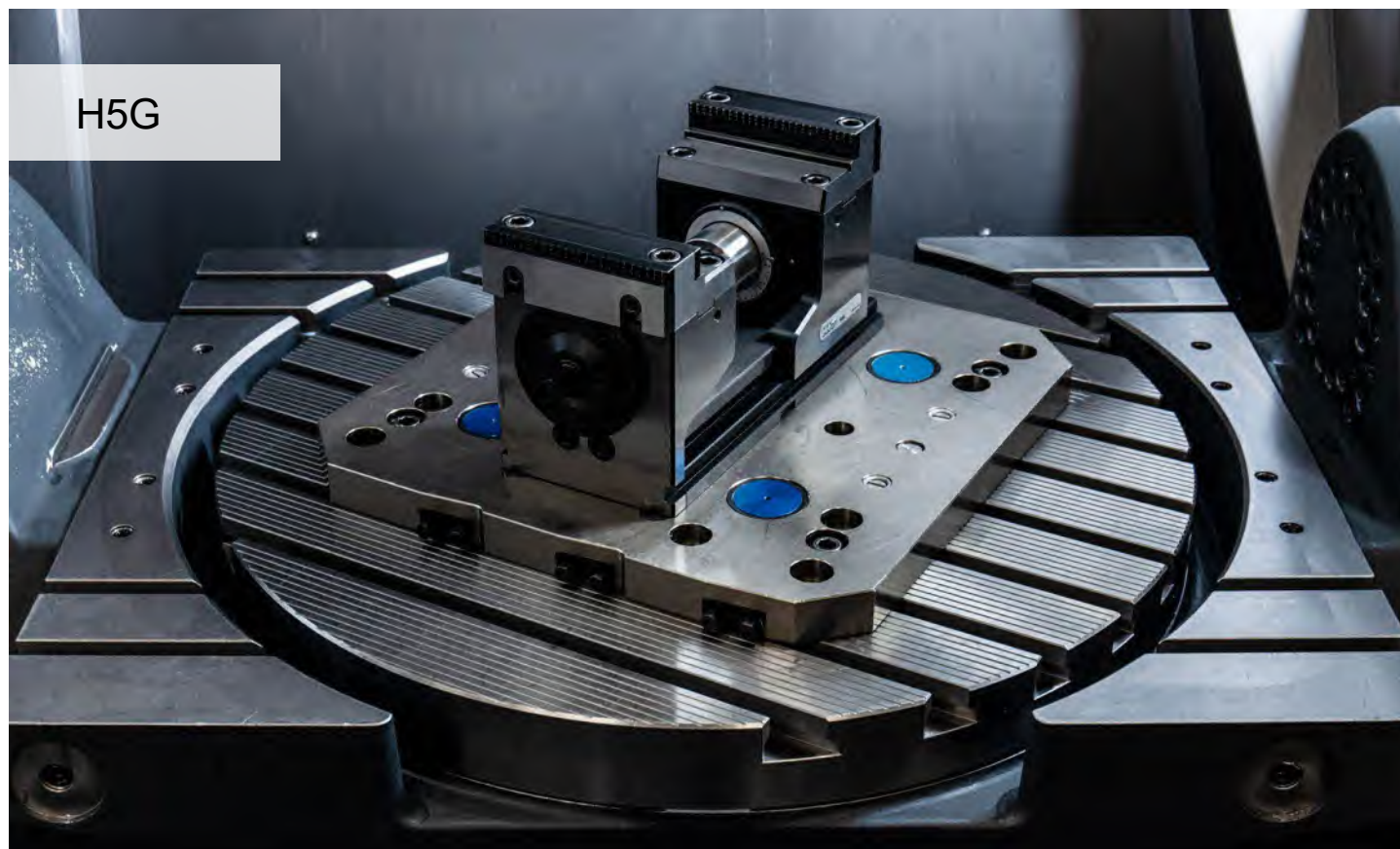
Dowel screws

▲ Price for 2 pieces

- NCG
- ESG
4



for width mm	G	J mm	CW	
100	M12x38	12	80 890 ...	313
125 / 160	M16x55	16		314



H5G

5-axis-optimised clamping system

The power-assisted clamping system for 'real' 5-axis complete and simultaneous machining. 1 and 2-sided machining with clamping under tension and 40 kN directly on the workpiece.

Your benefits:

- ▲ Quick conversion – adjustment of entire clamping range in just a few seconds
- ▲ Quick positioning with MNG on the machine table without an intermediate plate
- ▲ Clamping force can be continuously adjusted 4 – 40 kN
- ▲ 160° quick clamping
- ▲ Rotate jaws – quick and easy jaw change with 4 screws
- ▲ Easy cleaning, spindle fully protected
- ▲ Extensive modular jaw range



Clamping/aligning:



Clamping with two dowel screws dia. 12₁₇ / M12 **Article no. 80 895 019**



Alignment through 20^{H7} precision slot nuts in the base body (H5G) and alignment sets 14 / 16 / 18 in the machine table's T-slot. Clamping with clamping claws.



Alignment and clamping with MNG zero point clamping system (2-3 mounting bolts). **Optional:** Positioning and fixing holes at the customer's request.

Alignment of extension base body:



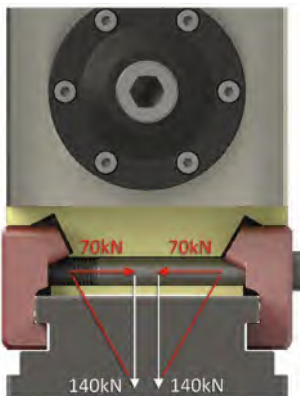
- ▲ Loosely mount the extension base body
- ▲ Distance to basic base body 0.2 – 10 mm
- ▲ Slide movable supporting jaw overlapping onto both base bodies
- ▲ Align the extension base body so it is parallel with the basic base body
- ▲ Secure the extension base body

Fitting the drawbar extension:



- ▲ Fit the extension base body (see alignment above)
- ▲ Screw the drawbar extension onto the spindle
- ▲ Insert the first anti-twist protection
- ▲ Slide the movable supporting jaw onto the extension base body
- ▲ Connect the extended drawbar to the fixed supporting jaw
- ▲ Insert the second anti-twist protection

Movable fixed jaw functional principle:



Double-acting screw = double the force
 angled surfaces = double the force

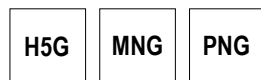
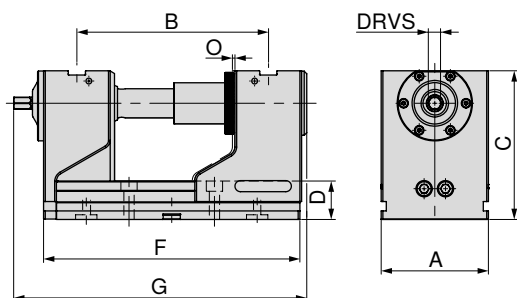
In the case of the H5G-Z and H5G-Z-S, both supporting jaws can be moved as desired. The movable fixed jaw can be clamped on any position on the base body via 1 or 2 screws (1 = H5G-Z / 2 = H5G-Z-S) (tighten screw with 90 Nm). The clamping force of the fixed jaw is almost identical to that of the H5G which is secured with four screws.

CoreLine – 5-axis vice with quick adjustment – H5G

- ▲ Crank handle quick clamping
- ▲ Vice with quick span adjustment
- ▲ 100 % encapsulated
- ▲ Vice with longitudinal and transverse grooves 20 H7 and alignment holes Ø 12 F7

Scope of supply:

Vice incl. 4 clamping claws, hand crank and clamping wrench

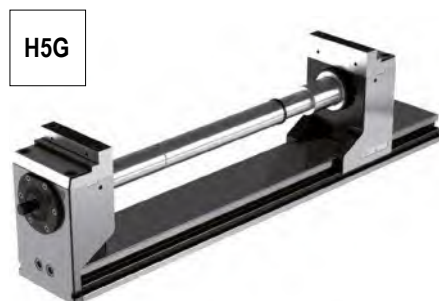
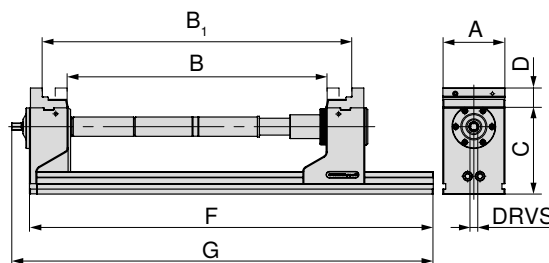


A	B	C	D	F	G	O	DRVS	MXC	WT
mm	mm	mm	mm	mm	mm	mm	mm	kN	kg
125	97 - 223	174	45	300	336,5	1	14	40	30,2

CW

80 898 ...
125

5 axis high power vice



A	C	D	F	G	DRVS	Clamping force
mm	mm	mm	mm	mm	mm	kN
125	174	40	815	851	14	40

B	B ₁	Article no.			
0 – 126	123 – 251	80898125			
125 – 252	248 – 374	80898125	+	80898826	+ 80898725
250 – 376	372 – 499	80898125	+	80898827	+ 80898725
375 – 501	498 – 624	80898125	+	80898826	+ 80898827 + 80898725
500 – 626	622 – 749	80898125	+ 2 x	80898827	+ 80898725



The H5G 125 mm can be extended by a maximum of 250 mm with 2 extensions. The extension results in approximately 10% loss of clamping force. Base plate available in long version with the desired hole pattern **on request**.

Vice guide

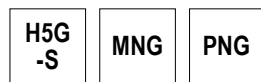
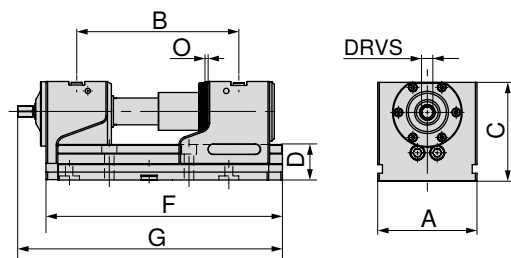
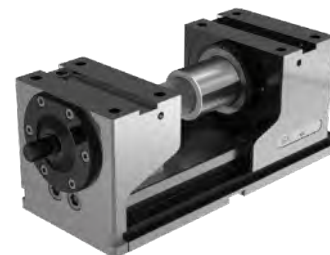
- | | |
|--|-----------------------|
| → Underside Dimensions | → General top jaws |
| → Structural dimension tables for the different jaws | → Workpiece location |
| → System jaws | → General accessories |
| → System accessories | → Clamping lever |
| → MNG-/PNG zero point clamping system | → Screws |

CoreLine – 5-Axis vice with quick adjustment – H5G-S

- ▲ Crank handle quick clamping
- ▲ Vice with quick span adjustment
- ▲ 100 % encapsulated
- ▲ Length F = 300 mm with Ø 25 H7 centering
- ▲ Length F = 265 mm with Ø 32 H6
- ▲ Vice with longitudinal and transverse grooves 20 H7 and alignment holes Ø 12 F7

Scope of supply:

Vice incl. 4 clamping claws, hand crank and clamping wrench



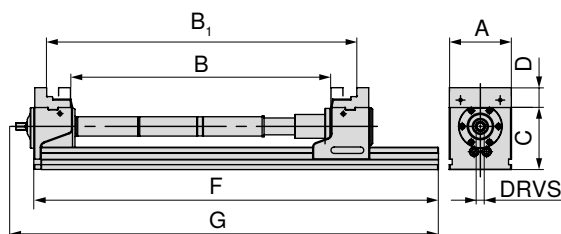
A mm	B mm	C mm	D mm	F mm	G mm	O mm	DRVS mm	MXC kN	WT kg
125	97 - 186	125	45	265	301,5	1	14	40	21,0
125	97 - 223	125	45	300	336,5	1	14	40	22,6

CW

80 898 ...
123
124

5 axis high power vice

H5G-S



A mm	C mm	D mm	F mm	G mm	DRVS mm	Clamping force kN
125	125	40	815	851	14	40

B	B ₁	Article no.			
0 – 126	123 – 250	80898124			
125 – 251	248 – 374	80898124	+	80898826	+ 80898725
250 – 376	372 – 499	80898124	+	80898827	+ 80898725
375 – 501	498 – 624	80898124	+	80898826	+ 80898827 + 80898725
500 – 626	622 – 749	80898124	+ 2 x	80898827	+ 80898725



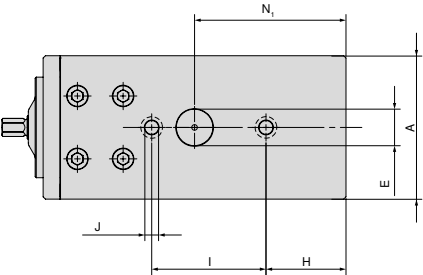
The H5G-S 125 mm can be extended by a maximum of 250 mm with 2 extensions. The extension results in approximately 10% loss of clamping force. Base plate available in long version with the desired hole pattern **on request**.

Vice guide

- Underside Dimensions
- Structural dimension tables for the different jaws
- System jaws
- System accessories
- MNG-/PNG zero point clamping system
- General top jaws
- Workpiece location
- General accessories
- Clamping lever
- Screws

H5G underside dimensions

Base width 125 mm and 265 mm length

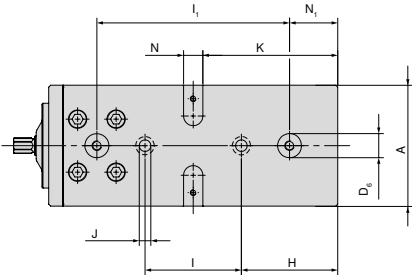


A	E _{H6}	H	I _{±0,015}	J _{F7}	N ₁
mm	mm	mm	mm	mm	mm
125	32	70	100	12	132,5



H5G with 265 mm length is not compatible with MNG

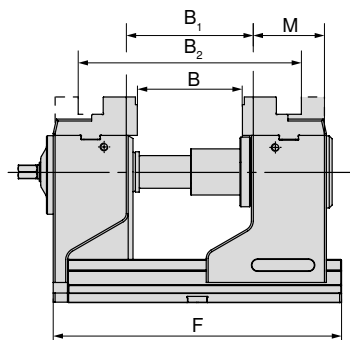
Base width 125 mm and length 300 mm



A	D ₆ _{H7}	H	I _{±0,015}	J _{F7}	K	N _{H7}	I ₁ _{±0,015}	N ₁
mm	mm	mm	mm	mm	mm	mm	mm	mm
125	25	100	100	12	140	20	200	50

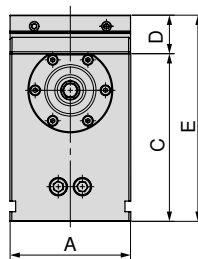
H5G/H5G-S – Structural dimension table for the different jaws

With combi jaws



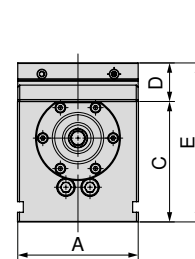
F mm	B mm	B ₁ mm	B ₂ mm	M mm	Article no. System jaws
265	0 - 89	22 - 112	123 - 212	76	80898225
300	0 - 126	22 - 149	123 - 249	76	80898225

H5G



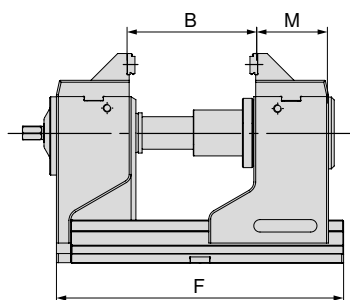
A mm	C mm	D mm	E mm
-	-	-	-
125	174	40	214

H5G-S



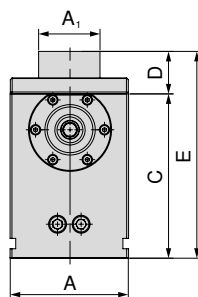
A mm	C mm	D mm	E mm
125	125	40	165
125	125	40	165

With 5A top jaws, jaw width 65 mm



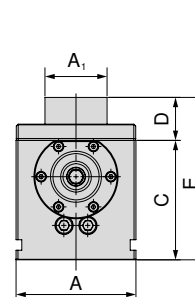
F mm	B mm	M mm	Article no. System jaws
265	16 - 105	79,5	80898325
300	16 - 142	79,5	80898325

H5G



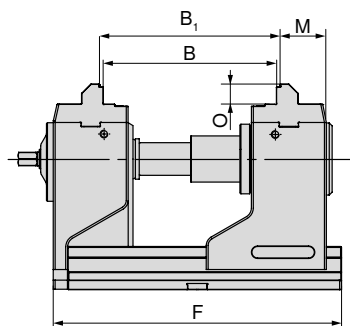
A mm	A ₁ mm	C mm	D mm	E mm
-	-	-	-	-
125	65	174	45	219

H5G-S



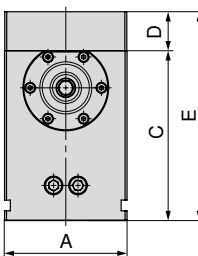
A mm	A ₁ mm	C mm	D mm	E mm
125	65	125	45	170
125	65	125	45	170

With 5A top jaws, jaw width 125 mm



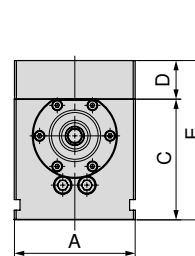
F mm	B mm	B ₁ mm	O mm	M mm	Article no. System jaws
265	74 - 162	80 - 168	21	49	80907300
300	74 - 199	80 - 205	21	49	80907300

H5G



A mm	C mm	D mm	E mm
-	-	-	-
125	174	40	214

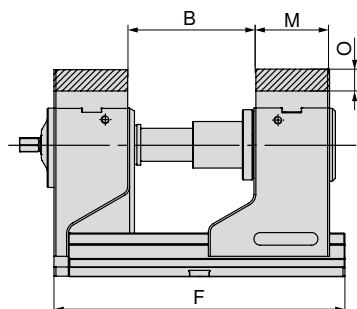
H5G-S



A mm	C mm	D mm	E mm
125	125	40	165
125	125	40	165

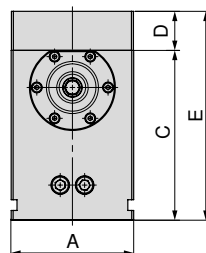
H5G/H5G-S – Structural dimension table for the different jaws

With indexable jaws, grip 3 mm



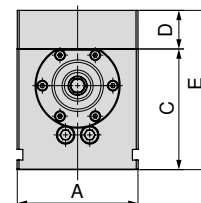
F mm	B mm	O mm	M mm	Article no. System jaws
265	23 - 112	22	76	80898625
300	23 - 149	22	76	80898625

H5G



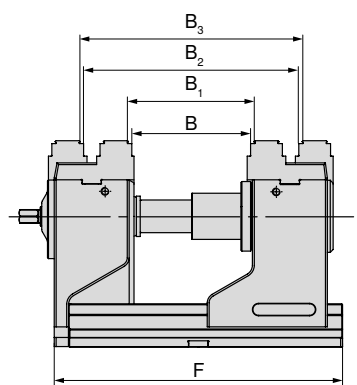
A mm	C mm	D mm	E mm
-	-	-	-
125	174	40	214

H5G-S



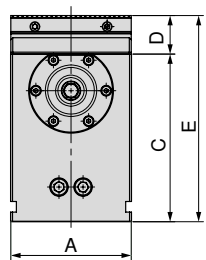
A mm	C mm	D mm	E mm
125	125	40	165
125	125	40	165

With indexable jaws, grip 3 mm



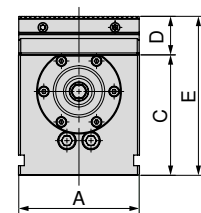
F mm	B mm	B ₁ mm	B ₂ mm	B ₃ mm	Article no. System jaws
265	17 - 106	23 - 112	117 - 206	123 - 212	8089835000
300	17 - 140	23 - 146	117 - 240	123 - 246	8089835000

H5G



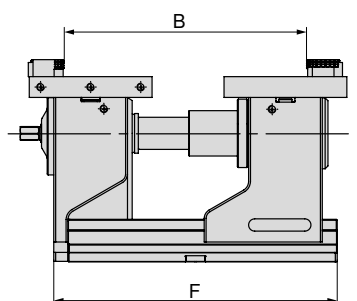
A mm	C mm	D mm	E mm
-	-	-	-
125	174	40	214

H5G-S



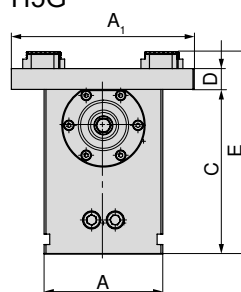
A mm	C mm	D mm	E mm
125	125	40	165
125	125	40	165

With pendulum and adapter plate



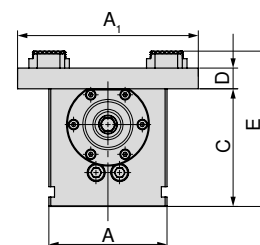
F mm	B mm	Article no. System jaws
265	17 - 236	80898525 + 80898425
300	17 - 274	80898525 + 80898425

H5G



A mm	A ₁ mm	C mm	D mm	E mm
-	-	-	-	-
125	192	174	22	214

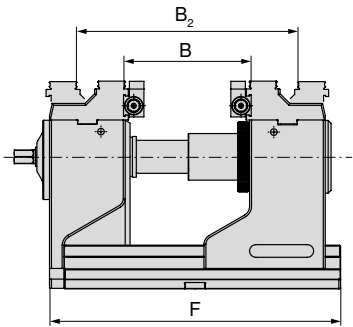
H5G-S



A mm	A ₁ mm	C mm	D mm	E mm
125	192	125	22	165
125	192	125	22	165

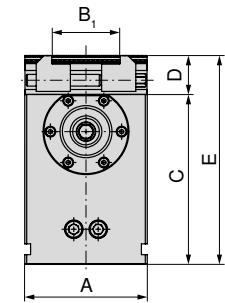
H5G/H5G-S – Structural dimension table for the different jaws

With 6-face jaw system



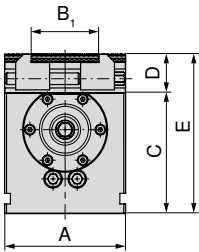
F	B	B ₂	O	M	Article no.
mm	mm	mm	mm	mm	System jaws
265	39-115	119-191	22	76	80898230
300	39-152	119-228	22	76	80898230

H5G



A	B ₁	C	D	E
mm	mm	mm	mm	mm
-	-	-	-	-
125	37-101	174	40	214

H5G-S



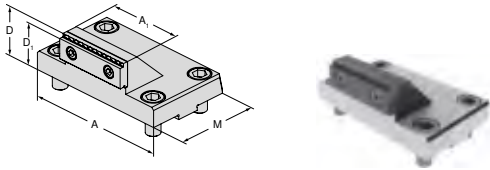
A	B ₁	C	D	E
mm	mm	mm	mm	mm
125	37-101	125	40	165
125	37-101	125	40	165

System jaws overview

5A stepped top jaw

- ▲ including 125/65 mm attachment and 3 mm grip step
- ▲ price per piece

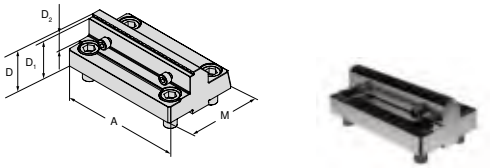
For vice width										CW										NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂																						
125	125	65	45	42		76											80898325	●												



5A – Top jaw

- ▲ Improved accessibility through tapered rear section
- ▲ Price per piece

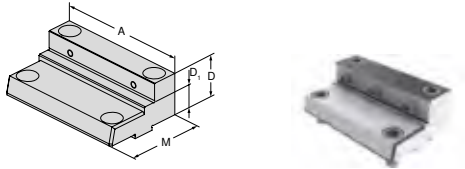
For vice width										CW										NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	80907300																					
125	125	40	37	18		78																								



Combi reversable jaw

- ▲ to extend the clamping range
- ▲ Price per piece

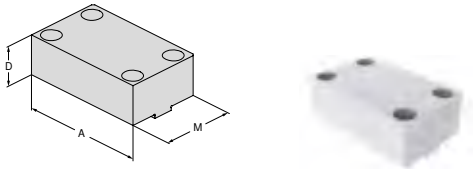
For vice width										CW										NCG									
A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂											H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG	
125	125	40	22			76													●										
80898225																													



Soft Alu-jaw

- ▲ for producing shaped jaws
- ▲ Price per piece

										CW	NCG	H5G /-S /-Z	X5G-Z/-S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂												
125	125		40				76				80898625		●								



System jaws overview

Indexable jaw, grip 3 mm, 16 mm smooth step, on both sides

▲ Price per piece

For vice width

A

A₁

D

D₁

D₂

E

M

M₁

M₂

125

125

40

37

24

82,5

CW

8089835000

NCG

H5G / -S / -Z

X5G-Z / -S

ESG 4

ESG 5

HDG 2

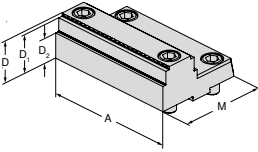
ZSG 4

ZSG mini

DSG 4

Verso

HSG



Pendulum jaw, movable

▲ to accommodate 6-way reversible jaws

▲ Price per piece

For vice width

A

A₁

D

D₁

D₂

E

M

M₁

M₂

125

192

22

130

CW

80898525

NCG

H5G / -S / -Z

X5G-Z / -S

ESG 4

ESG 5

HDG 2

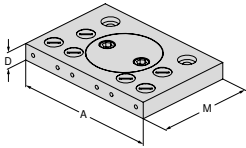
ZSG 4

ZSG mini

DSG 4

Verso

HSG



Adapter plate

▲ to accommodate 6-way reversible jaws

▲ Price per piece

For vice width

A

A₁

D

D₁

D₂

E

M

M₁

M₂

125

192

22

130

CW

80898425

NCG

H5G / -S / -Z

X5G-Z / -S

ESG 4

ESG 5

HDG 2

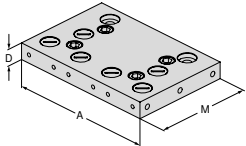
ZSG 4

ZSG mini

DSG 4

Verso

HSG



6 function indexable jaw

- ▲ 1 = Smooth, carbide coated
- ▲ 2 = Grip with 3 mm step
- ▲ 3 = Grip with 8 mm step
- ▲ 4 = Grip with 18 mm step
- ▲ 5 = Rough grip with 8 mm step
- ▲ 6 = Round grip
- ▲ M_{max} = 60 Nm
- ▲ Including fixation screws

For vice width

A

A₁

D

D₁

D₂

E

M

M₁

M₂

18

CW

80892246

NCG

H5G / -S / -Z

X5G-Z / -S

ESG 4

ESG 5

HDG 2

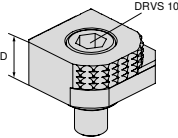
ZSG 4

ZSG mini

DSG 4

Verso

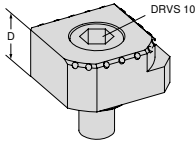
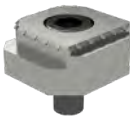
HSG



System jaws overview

6x indexable jaw, carbide grip

- ▲ 1 = Smooth
- ▲ 2 = Carbide grip
- ▲ 3 = Carbide grip with 3 mm step
- ▲ 4 = Carbide grip with 8 mm step
- ▲ 5 = Round carbide grip with 8 mm step
- ▲ 6 = Round carbide grip
- ▲ Incl. fixing screws



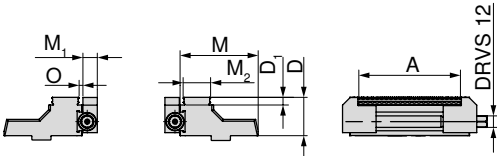
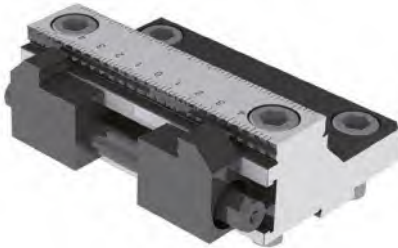
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂

18

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8089035300	●	●	●	●			●		●	●	

6 face jaw system for 125 mm jaw width

Scope of supply:
2 System jaws with 2 pairs of transverse jaws in T-slot guidance incl. fixing screws



for width mm	A mm	D mm	D ₁ mm	M mm	M ₁ mm	M ₂ mm	O mm	WT kg
125	37 - 101	40	8	81,5	15	28,7	3,2	4,5

CW
80 898 ...
230

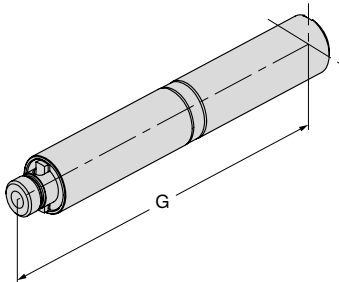
System accessories overview

Drawbar

▲ Incl. anti-rotation

H5G

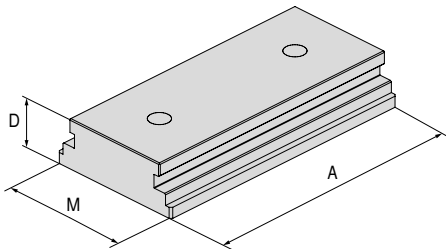
H5G
-S



G		CW	
mm		80 898 ...	
125			826
250			827

Base plate to extend

H5G



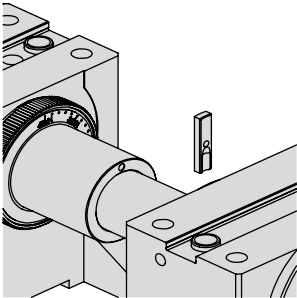
			CW	
A	D	M	80 898 ...	
mm	mm	mm		725
250	45	125,5		

System accessories overview

Anti-twist plate

H5G

H5G-S





CW

80 898 ...

024

Hand crank

▲ for fast adjustment

H5G



DRVS
mm
14

H5G-S

CW

80 898 ...

026

H5G

CW

80 898 ...

025

System accessories overview

Protection plugs

▲ Price per piece

H5G
-Z



D ₁ mm 19	CW 80 907 ... 501
----------------------------	-------------------------

Clamping lever

▲ including control accessories

NCG

NCG
5A

H5G

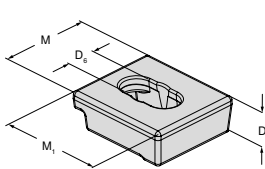


DRVS mm 14	CW 80 890 ... 501
------------------	-------------------------

System accessories overview

Clamping claws

▲ Price for 2 pieces



D	D ₆	M	M ₁
mm	mm	mm	mm
20	16	50	57

CW
80 890 ...
315

Tenon incl. screw

▲ Price per 2 pieces

NCG	H5G	H5G-S	ESG 4	HDG 2	DSG 4	DSG	X5G-Z
-----	-----	-------	-------	-------	-------	-----	-------



for width mm
12
14
16
18

CW
80 898 ...
412
414
416
418

System accessories overview

Clamping screw and T-Nuts

- ▲ For mounting the clamping claw
- ▲ Price per 2 pieces

Scope of supply:
Incl. washers

NCG

H5G

ESG
4

HDG
2

ZSG
4

DSG
4

Verso



for slot width		G		CW	
mm				80 890 ...	
12		M10			308
14		M12			309
16		M14			310
18		M16			311

Dowel screw

- ▲ Price for 2 pieces

H5G

ESG
4

ZSG
4

DSG
4

MNG

X5G
-Z



for width		G	J	CW	
mm			mm	80 895 ...	
125	M12x45		12		019

System accessories overview

Socket

▲ Suitable for 1/2" or 3/8" square drive

- H5G
-Z
- ESG
mini
- X5G
-Z



DRVS	AS
mm	80 877 ...
14	214

Clamping Handle with Joint

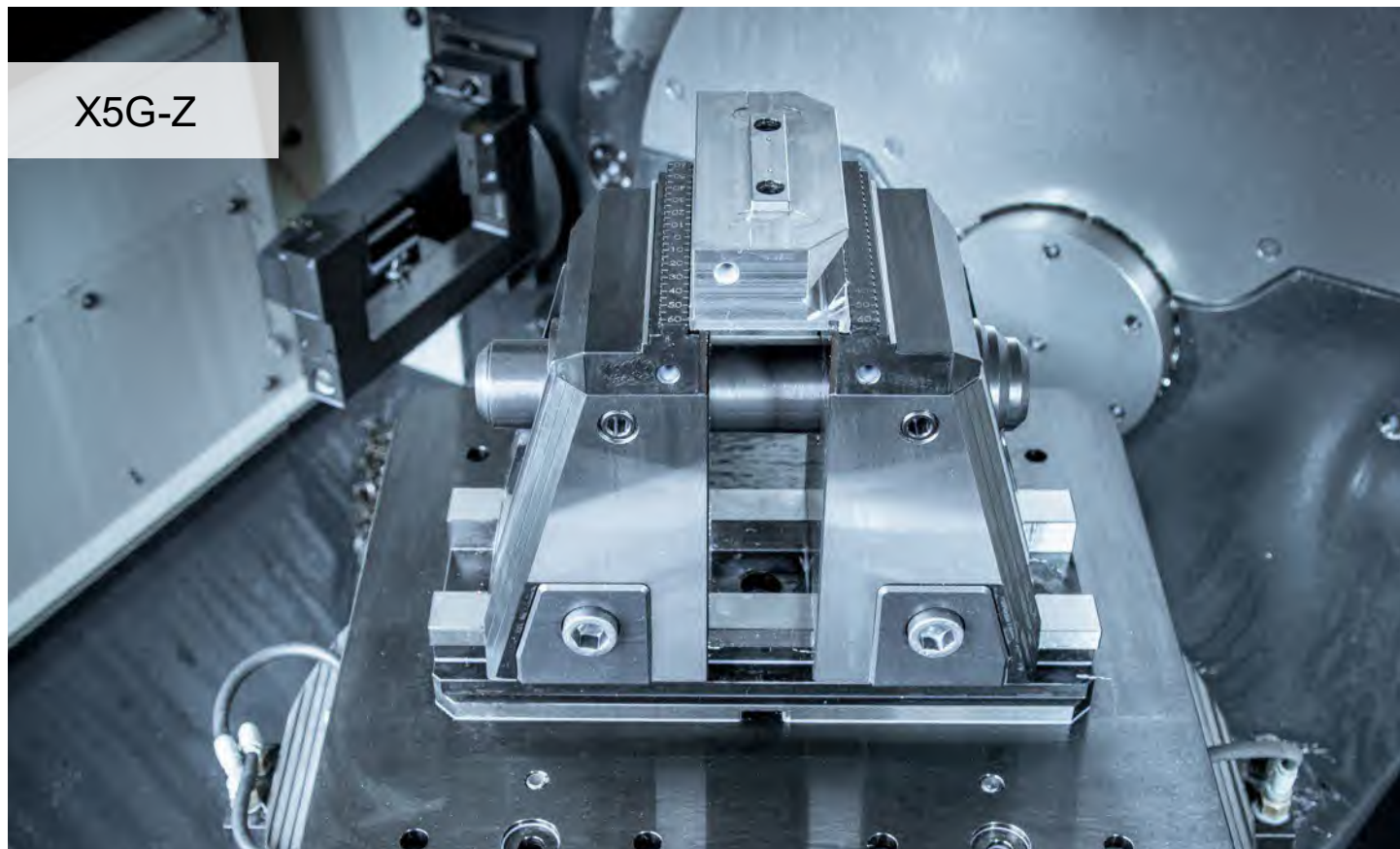
▲ without socket

- H5G
-Z
- H5G
-Z-S
- ESG
4
- ESG
mini
- ZSG
4



Square	CW
1/2"	80 891 ...
	600

X5G-Z



5-axis machining to perfection

Maximum ease of handling and integrated pull-down action for 6-sided machining. X5G-Z is the new 5-axis vice from CERATIZIT. All the advantages that ensure optimum and simple 5- and 6-sided machining combined in a single clamping device.

Your benefits:

- ▲ Either 5 and 6-axis machining thanks to clamping of one or both supporting jaws
- ▲ Fast jaw changeover without tools
- ▲ Optimum accessibility from all sides and large base clamping stroke of 130 mm
- ▲ Fully encapsulated, mechanical spindle
- ▲ Integrated, internal elastomer damping to minimise vibrations
- ▲ Extensive modular jaw range



Clamping/aligning:



Clamping with two dowel screws dia. 12_{H7} / M12 and clamping screws **Article no. 80 895 019**



Alignment through 20^{H7} precision slot nuts in the base body in the machine table's T-slot. Clamping with clamping claws.



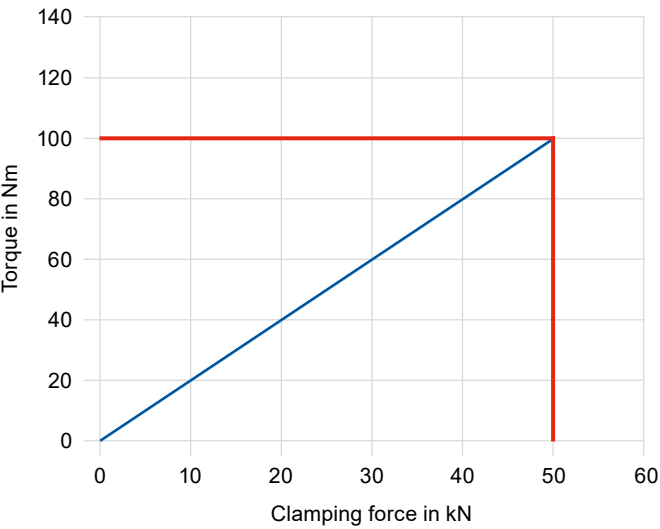
Alignment and clamping with MNG zero point clamping system (2-3 mounting bolts). **Optional:** Positioning and fixing holes at the customer's request.

Clamping force:

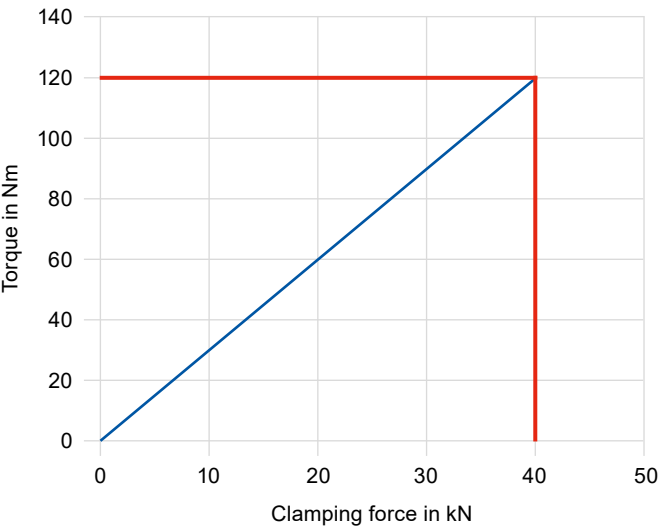
Size		Max. tightening torque in Nm	max. clamping force in kN
X5G-Z	Blank clamping	100	50
X5G-Z	Precision clamping	120	40
X5G-Z-S	Blank clamping	100	50
X5G-Z-S	Precision clamping	120	34

X5G-Z tightening torque/clamping force

Blank clamping

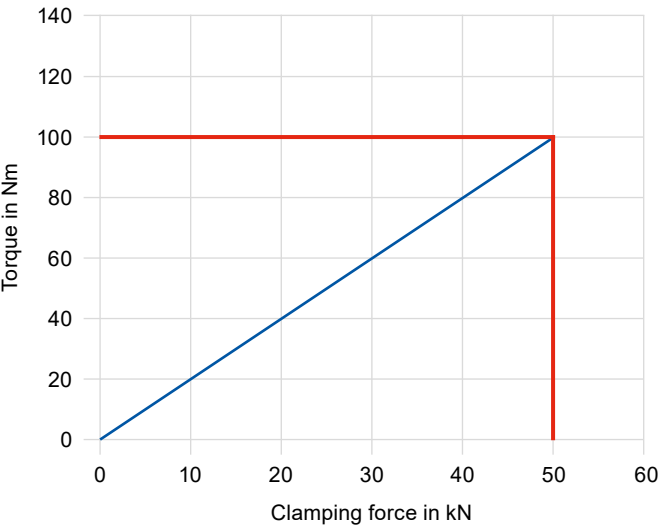


Precision clamping

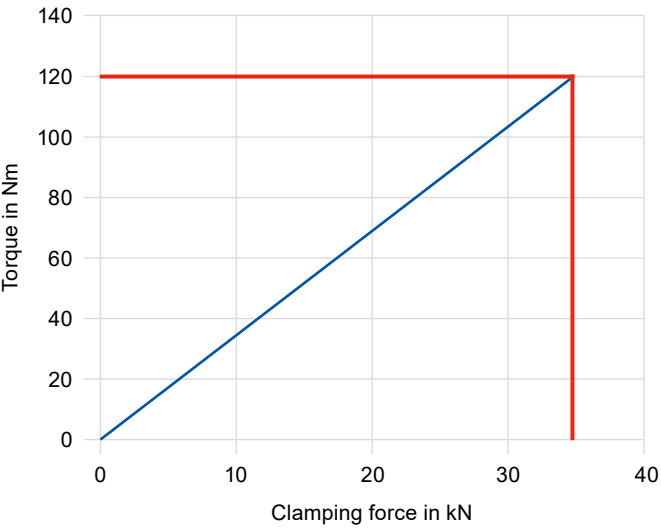


X5G-Z-S tightening torque/clamping force

Blank clamping



Precision clamping



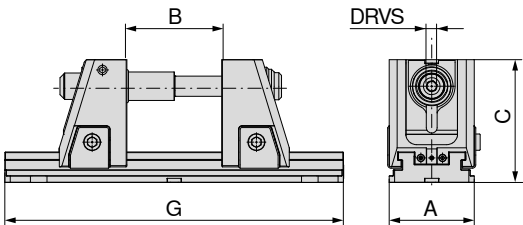
HyPower – Mechanical 5-axis vice with movable fixed jaws – X5G-Z

- ▲ Without system jaws
- ▲ Optimum accessibility
- ▲ 5- and 6-sided machining possible
- ▲ Fast jaw changeover
- ▲ Clamping on the machine table is possible with MNG/PNG, or directly through the base body

MNG

PNG

X5G-Z



A mm	B mm	C mm	G mm	DRVS mm	MXC kN	WT kg
125	4 - 134	181	330	14	40	33,2
125	4 - 234	181	430	14	40	36,1
125	4 - 304	181	500	14	40	38,1
125	4 - 434	181	630	14	40	41,8
125	4 - 604	181	800	14	40	46,6

CW
80 908 ...
52500
52600
52700
52800
52900

Basic clamping stroke 130 mm

Vice guide

→ Underside Dimensions	→ General top jaws
→ Structural dimension tables for the different jaws	→ Workpiece location
→ System jaws	→ General accessories
→ System accessories	→ Clamping lever
→ MNG-/PNG zero point clamping system	→ Screws

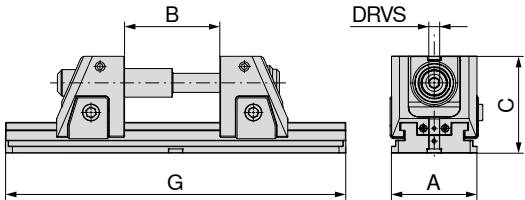
HyPower – Mechanical 5-axis vice with movable fixed jaws – X5G-Z-S

- ▲ Without system jaws
- ▲ Optimum accessibility
- ▲ 5- and 6-sided machining possible
- ▲ Fast jaw changeover
- ▲ Clamping on the machine table is possible with MNG/PNG, or directly through the base body

MNG

PNG

X5G
-Z-S



A mm	B mm	C mm	G mm	DRVS mm	MXC kN	WT kg
125	4 - 134	142	330	14	40	27,3
125	4 - 234	142	430	14	40	30,2
125	4 - 304	142	500	14	40	32,2
125	4 - 434	142	630	14	40	35,9
125	4 - 604	142	800	14	40	40,7

CW
80 908 ...
42500
42600
42700
42800
42900

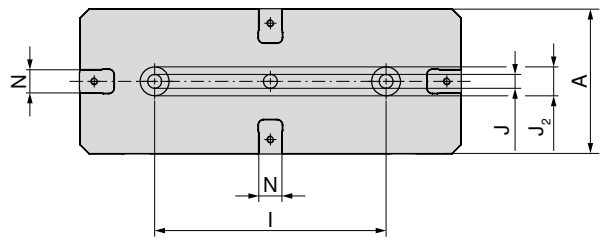
Basic clamping stroke 130 mm

Vice guide

→ Underside Dimensions	→ General top jaws
→ Structural dimension tables for the different jaws	→ Workpiece location
→ System jaws	→ General accessories
→ System accessories	→ Clamping lever
→ MNG-/PNG zero point clamping system	→ Screws

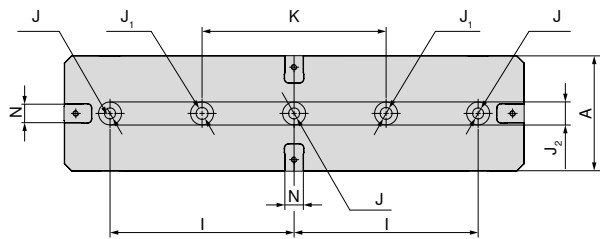
X5G-Z/-S underside dimensions

Base width 125 mm and 330 mm length



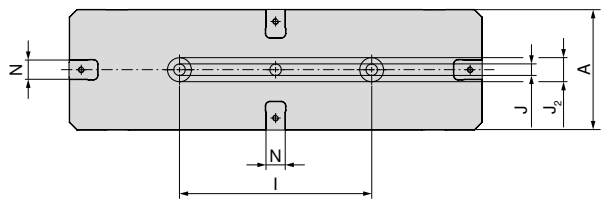
A	I	J	J ₂	N
mm	$\pm 0,02$ mm	H7 mm	H6 mm	H7 mm
125	200	12	25	20

Base width 125 mm and 630 mm length



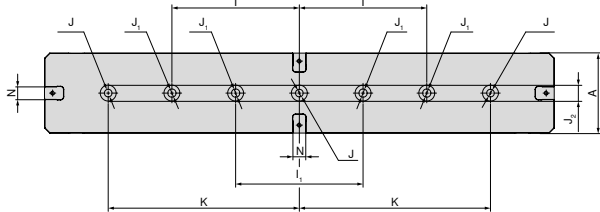
A	I	J	J ₁	J ₂	K	N
mm	$\pm 0,02$ mm	H7 mm	mm	H6 mm	$\pm 0,02$ mm	H7 mm
125	200	12	13	25	200	20

Base width 125 mm and 430 mm length



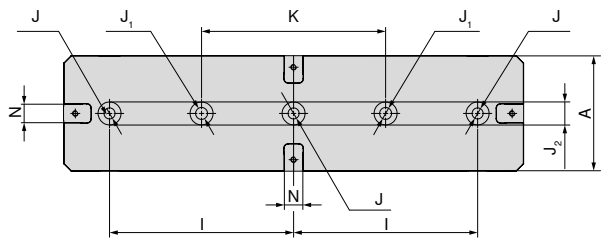
A	I	J	J ₂	N
mm	$\pm 0,02$ mm	H7 mm	H6 mm	H7 mm
125	200	12	25	20

Base width 125 mm and 800 mm length



A	I	I ₁	J	J ₁	J ₂	K	N
mm	$\pm 0,02$ mm	$\pm 0,02$ mm	H7 mm	mm	H6 mm	$\pm 0,02$ mm	H7 mm
125	200	200	12	13	25	300	20

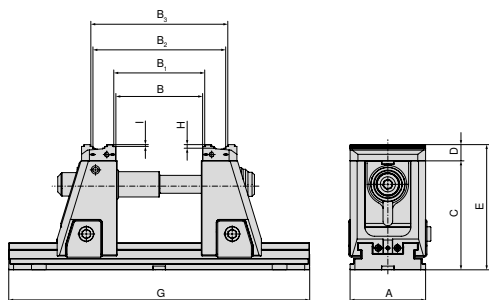
Base width 125 mm and 500 mm length



A	I	J	J ₁	J ₂
mm	$\pm 0,02$ mm	H7 mm	mm	H6 mm
125	200	12	13	25

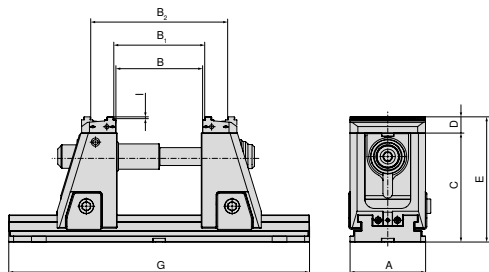
X5G-Z/-S structural dimension table for the different jaws

With indexable jaws, grip 3 mm



Type	Drawbar 430 mm 8090880000	Drawbar 500 mm 8090880100	Drawbar 630 mm 8090880200	Drawbar 800 mm 8090880300	A	B	B ₁	B ₂	B ₃	C	D	E	G	H	I
8090852500					125	5-134	12-141	80-210	88-217	181	27	208	330	6	3
8090842500					125	5-134	12-141	80-210	88-217	142	27	169	330	6	3
8090852600	1 x				125	5-234	12-241	80-310	88-317	181	27	208	430	6	3
8090842600	1 x				125	5-234	12-241	80-310	88-317	142	27	169	430	6	3
8090852700	1 x	1 x			125	5-304	12-311	80-380	88-387	181	27	208	500	6	3
8090842700	1 x	1 x			125	5-304	12-311	80-380	88-387	142	27	169	500	6	3
8090852800	1 x	1 x	1 x		125	5-434	12-441	80-510	88-517	181	27	208	630	6	3
8090842800	1 x	1 x	1 x		125	5-434	12-441	80-510	88-517	142	27	169	630	6	3
8090852900	1 x	1 x	1 x	1 x	125	5-604	12-611	80-680	88-687	181	27	208	800	6	3
8090842900	1 x	1 x	1 x	1 x	125	5-604	12-611	80-680	88-687	142	27	169	800	6	3

With indexable jaws, grip 5 mm



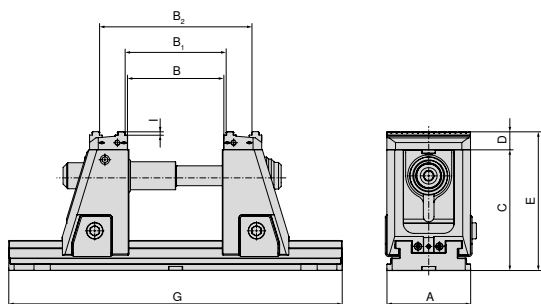
Type	Drawbar 430 mm 8090880000	Drawbar 500 mm 8090880100	Drawbar 630 mm 8090880200	Drawbar 800 mm 8090880300	A	B	B ₁	B ₂	C	D	E	G	I
8090852500					125	5-134	12-141	88-217	181	27	208	330	5
8090842500					125	5-134	12-141	88-217	142	27	169	330	5
8090852600	1 x				125	5-234	12-241	88-317	181	27	208	430	5
8090842600	1 x				125	5-234	12-241	88-317	142	27	169	430	5
8090852700	1 x	1 x			125	5-304	12-311	88-387	181	27	208	500	5
8090842700	1 x	1 x			125	5-304	12-311	88-387	142	27	169	500	5
8090852800	1 x	1 x	1 x		125	5-434	12-441	88-517	181	27	208	630	5
8090842800	1 x	1 x	1 x		125	5-434	12-441	88-517	142	27	169	630	5
8090852900	1 x	1 x	1 x	1 x	125	5-604	12-611	88-687	181	27	208	800	5
8090842900	1 x	1 x	1 x	1 x	125	5-604	12-611	88-687	142	27	169	800	5



→ Here you will find the suitable drawbar extensions.

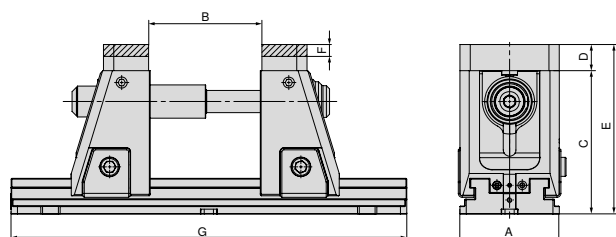
X5G-Z/-S structural dimension table for the different jaws

With stepped jaws, carbide grip 5 mm



Type	Drawbar 430 mm 8090880000	Drawbar 500 mm 8090880100	Drawbar 630 mm 8090880200	Drawbar 800 mm 8090880300	A	B	B ₁	B ₂	C	D	E	G	I
8090852500					125	5-134	12-141	88-217	181	27	208	330	5
8090842500					125	5-134	12-141	88-217	142	27	169	330	5
8090852600	1 x				125	5-234	12-241	88-317	181	27	208	430	5
8090842600	1 x				125	5-234	12-241	88-317	142	27	169	430	5
8090852700	1 x	1 x			125	5-304	12-311	88-387	181	27	208	500	5
8090842700	1 x	1 x			125	5-304	12-311	88-387	142	27	169	500	5
8090852800	1 x	1 x	1 x		125	5-434	12-441	88-517	181	27	208	630	5
8090842800	1 x	1 x	1 x		125	5-434	12-441	88-517	142	27	169	630	5
8090852900	1 x	1 x	1 x	1 x	125	5-604	12-611	88-687	181	27	208	800	5
8090842900	1 x	1 x	1 x	1 x	125	5-604	12-611	88-687	142	27	169	800	5

With soft jaws, steel



Article no.
System jaws

2 x 8090931200

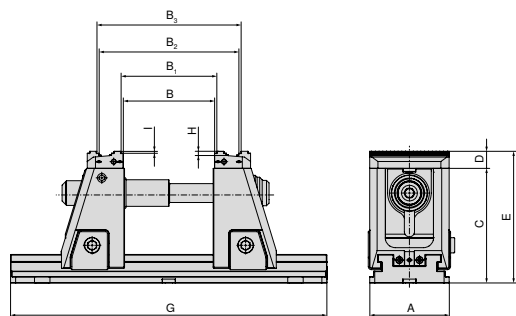
Type	Drawbar 430 mm 8090880000	Drawbar 500 mm 8090880100	Drawbar 630 mm 8090880200	Drawbar 800 mm 8090880300	A	B	C	D	E	F	G
8090852500					125	4-134	181	33	214	15	330
8090842500					125	4-134	142	33	175	15	330
8090852600	1 x				125	4-234	181	33	214	15	430
8090842600	1 x				125	4-234	142	33	175	15	430
8090852700	1 x	1 x			125	4-304	181	33	214	15	500
8090842700	1 x	1 x			125	4-304	142	33	175	15	500
8090852800	1 x	1 x	1 x		125	4-434	181	33	214	15	630
8090842800	1 x	1 x	1 x		125	4-434	142	33	175	15	630
8090852900	1 x	1 x	1 x	1 x	125	4-604	181	33	214	15	800
8090842900	1 x	1 x	1 x	1 x	125	4-604	142	33	175	15	800



→ Here you will find the suitable drawbar extensions.

X5G-Z/-S structural dimension table for the different jaws

With indexable jaws embossed profile

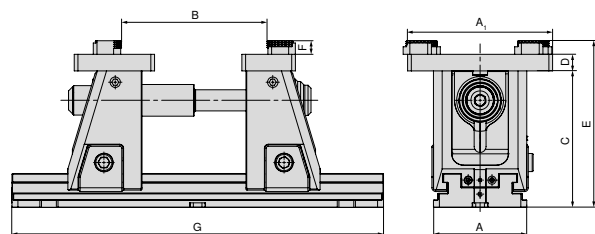


Article no.
System jaws

2 x 8090831200

Type	Drawbar 430 mm 8090880000	Drawbar 500 mm 8090880100	Drawbar 630 mm 8090880200	Drawbar 800 mm 8090880300	A	B	B ₁	B ₂	B ₃	C	D	E	G	H	I
8090852500					125	5-134	12-141	82-210	89-217	181	27	208	330	6	3
8090842500					125	5-134	12-141	82-210	89-217	142	27	169	330	6	3
8090852600	1 x				125	5-234	12-241	82-310	89-317	181	27	208	430	6	3
8090842600	1 x				125	5-234	12-241	82-310	89-317	142	27	169	430	6	3
8090852700	1 x	1 x			125	5-304	12-311	82-380	89-387	181	27	208	500	6	3
8090842700	1 x	1 x			125	5-304	12-311	82-380	89-387	142	27	169	500	6	3
8090852800	1 x	1 x	1 x		125	5-434	12-441	82-510	89-517	181	27	208	630	6	3
8090842800	1 x	1 x	1 x		125	5-434	12-441	82-510	89-517	142	27	169	630	6	3
8090852900	1 x	1 x	1 x	1 x	125	5-604	12-611	82-680	89-687	181	27	208	800	6	3
8090842900	1 x	1 x	1 x	1 x	125	5-604	12-611	82-680	89-687	142	27	169	800	6	3

With pendulum and adapter plate



Article no.
System jaws

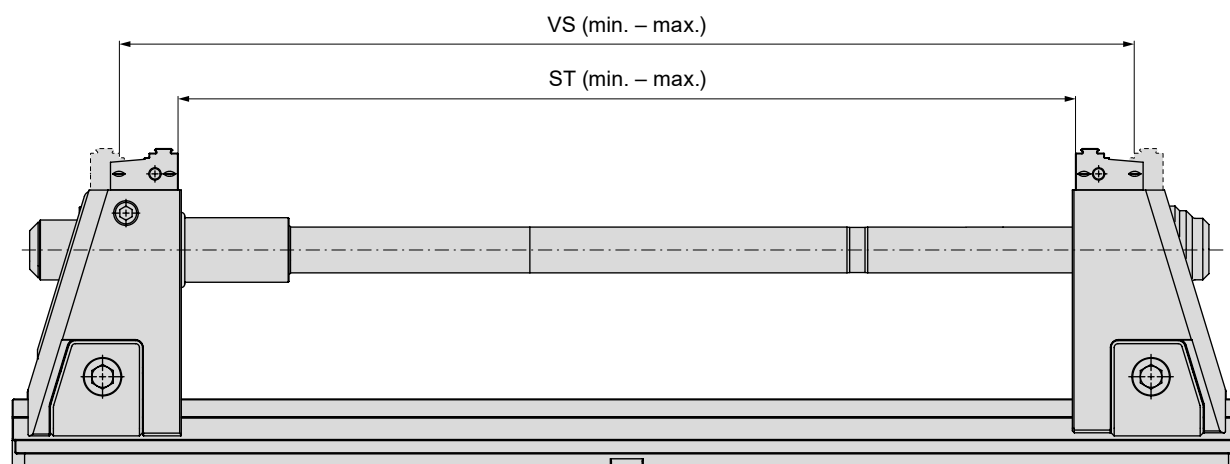
80 909 31500 + 80 909 31300

Type	Drawbar 430 mm 8090880000	Drawbar 500 mm 8090880100	Drawbar 630 mm 8090880200	Drawbar 800 mm 8090880300	A	B	C	D	E	F	G
8090852500					125	42-210	181	22	221	18	330
8090842500					125	42-210	142	22	182	18	330
8090852600	1 x				125	42-310	181	22	221	18	430
8090842600	1 x				125	42-310	142	22	182	18	430
8090852700	1 x	1 x			125	42-380	181	22	221	18	500
8090842700	1 x	1 x			125	42-380	142	22	182	18	500
8090852800	1 x	1 x	1 x		125	42-510	181	22	221	18	630
8090842800	1 x	1 x	1 x		125	42-510	142	22	182	18	630
8090852900	1 x	1 x	1 x	1 x	125	42-680	181	22	221	18	800
8090842900	1 x	1 x	1 x	1 x	125	42-680	142	22	182	18	800

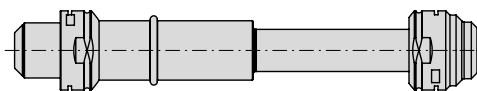


→ Here you will find the suitable drawbar extensions.

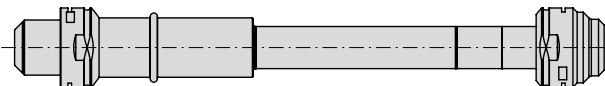
Clamping range depending on extension



ST (5 mm – 144 mm)
VS (82 mm – 220 mm)



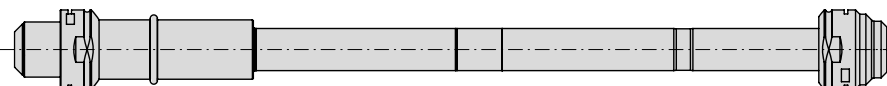
ST (94 mm – 235 mm)
VS (170 mm – 310 mm)



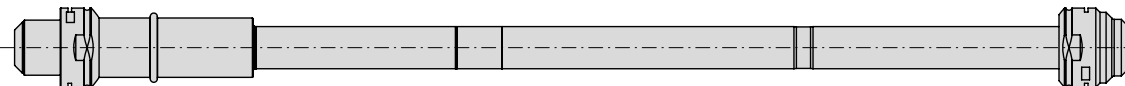
ST (164 mm – 304 mm)
VS (240 mm – 380 mm)



ST (294 mm – 434 mm)
VS (370 mm – 510 mm)



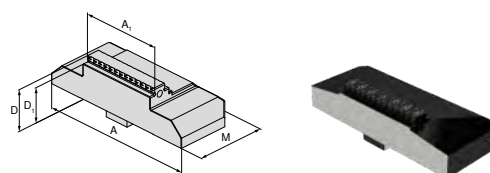
ST (464 mm – 604 mm)
VS (540 mm – 680 mm)



Indexable grip jaw, 3 mm

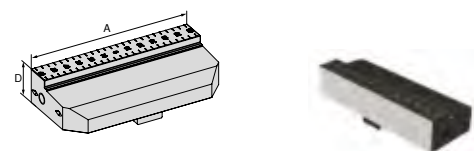
										CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂												
125	125	40	27	24			57			8090830300		●									
125	125	65	27	24			57			8090830200		●									
125	125	80	27	24			57			8090830100		●									
125	125	125	27	24			57			8090830000		●									

▲ Price per piece

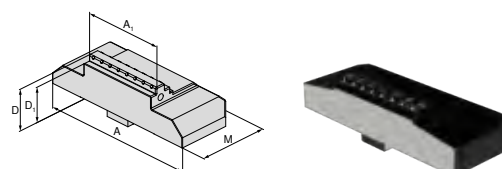


For vice width										CW	NCG	H5G /-S/-Z	X5G-Z /-S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂													
125	125	65	27	22		57															
125	125	80	27	22		57															
125	125	125	27	22		57															

▲ Price per piece

[illegible]

▲ Price per piece

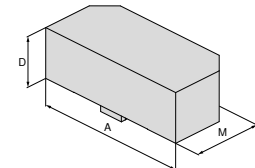
[illegible]

System jaws overview

Soft jaw, steel

- ▲ Material: 16MnCr5
- ▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
125	125		33				57		

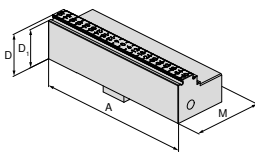
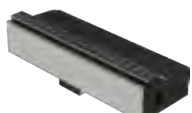


CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8090931200			●								

Indexable jaw embossed profile

- ▲ Price per piece
- ▲ suitable for LANG embossed profile

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
125	125		27	24			57		

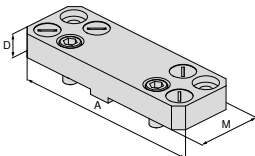


CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8090831200			●								

Adapter plate

- ▲ for holding 6-function indexable jaws
- ▲ Price per piece
- ▲ incl. cover screws

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
125	195		22				72		

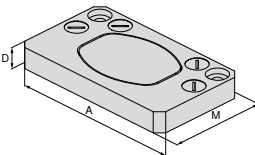
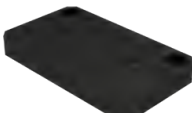


CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8090931500			●								

Floating jaw

- ▲ for holding 6-function indexable jaws
- ▲ Price per piece
- ▲ incl. cover screws

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
125	195		22				105		

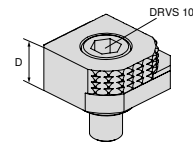


CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8090931300			●								

System jaws overview

6 function indexable jaw

- ▲ 1 = Smooth, carbide coated
- ▲ 2 = Grip with 3 mm step
- ▲ 3 = Grip with 8 mm step
- ▲ 4 = Grip with 18 mm step
- ▲ 5 = Rough grip with 8 mm step
- ▲ 6 = Round grip
- ▲ $M_{max} = 60 \text{ Nm}$
- ▲ Including fixation screws

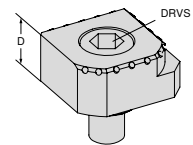
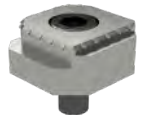


For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
			18						

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80892246	●	●	●	●			●		●	●	

6x indexable jaw, carbide grip

- ▲ 1 = Smooth
- ▲ 2 = Carbide grip
- ▲ 3 = Carbide grip with 3 mm step
- ▲ 4 = Carbide grip with 8 mm step
- ▲ 5 = Round carbide grip with 8 mm step
- ▲ 6 = Round carbide grip
- ▲ Incl. fixing screws

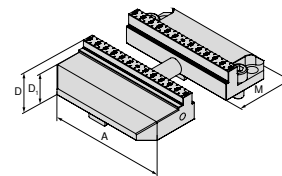


For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
			18						

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8089035300	●	●	●	●			●		●	●	

Precision jaw

- ▲ Price per set



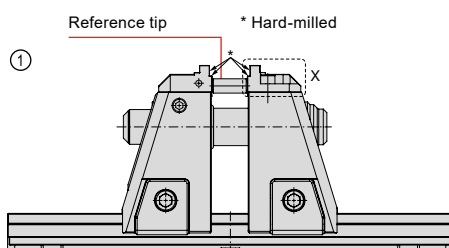
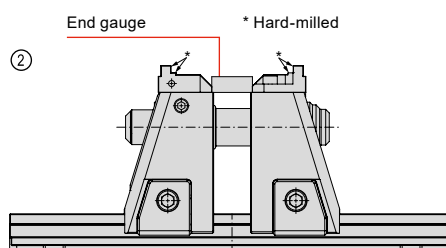
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
125	125		27	24			57		

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8090831300			●								

Procedure for hardened precision jaw set

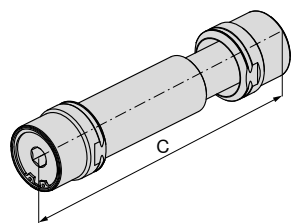
The X5G-Z impresses with its extreme accuracy. All the components have been ground or hard-milled to a high level of precision. Despite this, there are still applications whereby the precision requirements cannot be satisfied in full due to the tolerance chain of the indexable grip jaws. For these situations we offer a hardened precision jaw set (article no. **8090831300**) that can be hard-milled by the customer on the clamping flat (both sides).

Hard machining is carried out in the precision vice (both screws on the supporting jaws tightened to 140 Nm). The precision jaws must be hard-milled as per the views shown (1+2). The reference tip supplied is used for clamping in the standard position (1). An end gauge can be used for clamping in the increased clamping range position (2).



System accessories overview

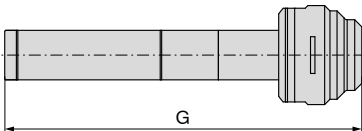
HyPower – Spindle unit – X5G-Z



C mm	WT kg
227,5	2,5

CW
80 908 ...
50100

HyPower – Drawbar – X5G-Z



for width mm	G mm
125	430
125	500
125	630
125	800

CW
80 908 ...
80000
80100
80200
80300

System accessories overview

Torque Wrench

▲ without socket

- ESG
4
- ESG
mini
- HDG
2
- ZSG
4
- ZSG
mini
- DSG
4



Square	TQX Nm
1/2"	20 - 100

AS

80 884 ...

502

Hand crank

- ▲ Version with external hex
- ▲ For quick adjustment

- H5G
-Z
- X5G
-Z



for width mm	DRVS mm
125	14

CW

80 907 ...

500

System accessories overview

Socket

▲ Suitable for 1/2" or 3/8" square drive

- H5G
-Z
- ESG
mini
- X5G
-Z



Square	DRVS mm
1/2"	14

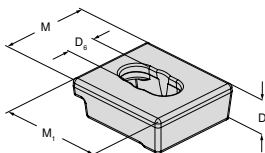
AS

80 877 ...

214

Clamping claws

▲ Price for 2 pieces



D mm	D ₆ mm	M mm	M ₁ mm
20	16	50	57

CW

80 890 ...

315

System accessories overview

Tenon incl. screw

▲ Price per 2 pieces

- NCG
- H5G
- H5G-S
- ESG4
- HDG2
- DSG4
- DSG
- X5G-Z



for width		CW
mm		80 898 ...
12		412
14		414
16		416
18		418

Clamping screw and T-Nuts

▲ For mounting the clamping claw
▲ Price per 2 pieces

Scope of supply:
Incl. washers

- NCG
- H5G
- ESG4
- HDG2
- ZSG4
- DSG4
- Verso



for slot width		G	CW
mm			80 890 ...
12		M10	308
14		M12	309
16		M14	310
18		M16	311

System accessories overview

Dowel screw

▲ Price for 2 pieces

- H5G
- ESG
4
- ZSG
4
- DSG
4
- MNG
- X5G
-Z



for width mm	G	J mm
125	M12x45	12

CW

80 895 ...

019

Clamping Handle with Joint

▲ without socket

- H5G
-Z
- H5G
-Z-S
- ESG
4
- ESG
mini
- ZSG
4



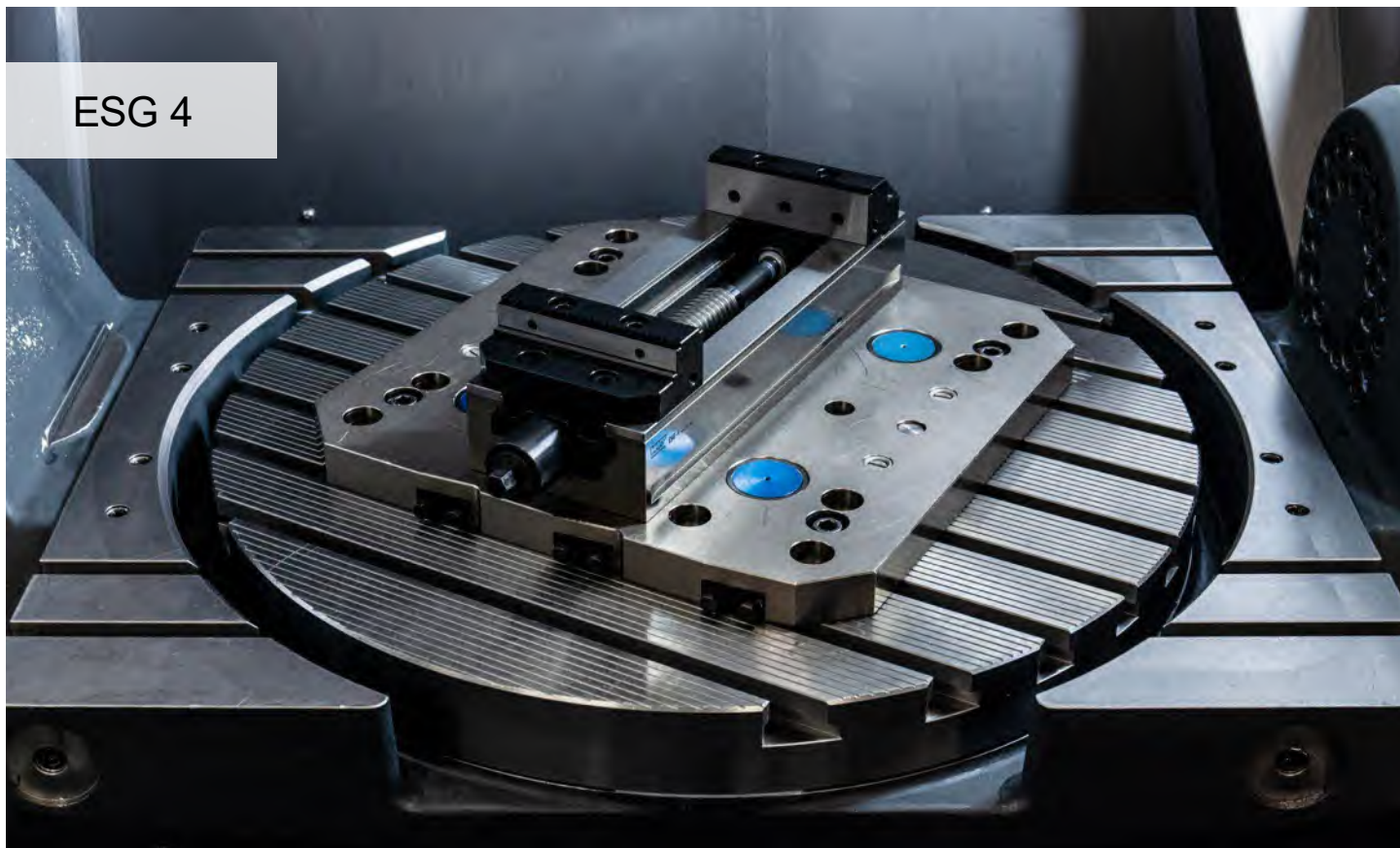
Square
1/2"

CW

80 891 ...

600

ESG 4



Highly-efficient all-rounder for machining unfinished and finished parts

The ESG 4 single vice impresses with fast handle clamping, quick setting of the clamping range, a flat design and low weight.

Your benefits:

- ▲ Several cooling lubricant flows for problem-free working and controlled outflow
- ▲ Quick and easy positioning on the MNG zero point clamping system
- ▲ High clamping force between 5 – 50 kN with low tightening torque
- ▲ Quick and easy jaw change with 2 screws
- ▲ Quick, simple disassembly of the spindle unit
- ▲ Extensive modular jaw range

Clamping/aligning:



ESG 4 – 125 mm / 160 mm = mounting with M12 screws and dowel screws through the base body



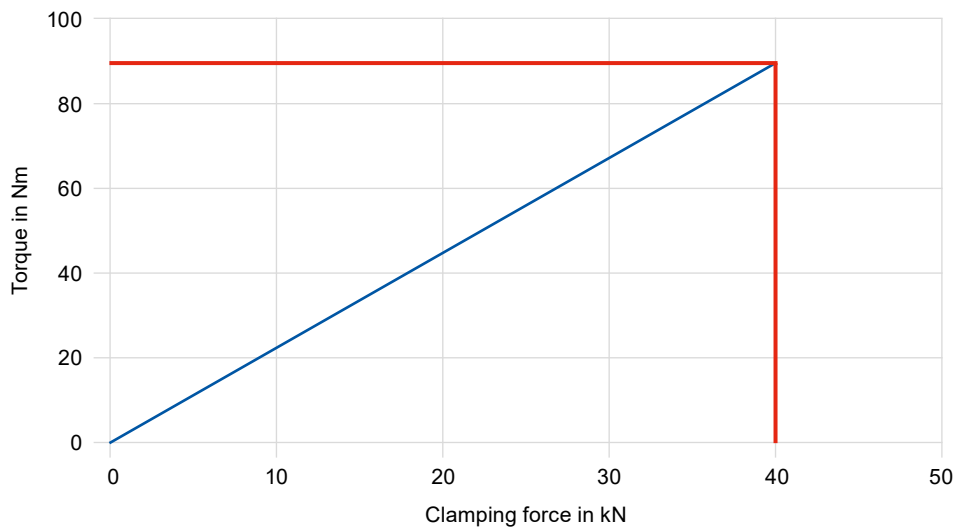
Mounting with 4 clamping claws
Article no. 80890315



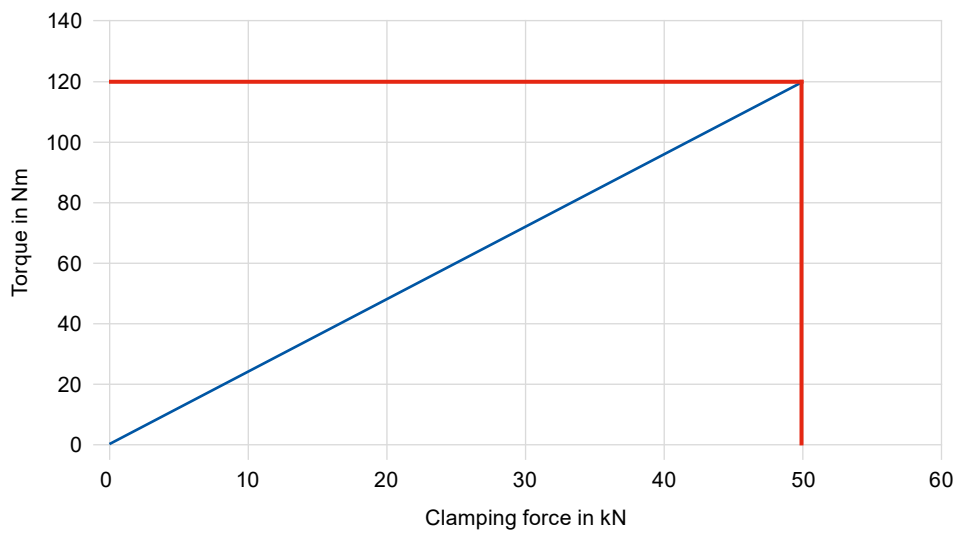
Mounting with zero point clamping systems
ESG 4 – 125 / 160 mm = 2 mounting bolts, centre distance 200 mm

Clamping force:

ESG 4 – 125 mm tightening torque/clamping force



ESG 4 – 160 mm tightening torque / clamping force



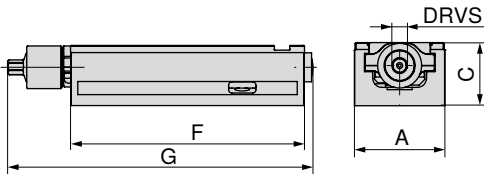
CoreLine – Single vice without system jaws – ESG 4

- ▲ Fast 160° handle clamping with torque key
- ▲ Rapid installation and removal of the spindle assembly
- ▲ ±0.01 mm repeatability (±0.015 mm when A = 160 mm)

ESG
4

MNG

PNG



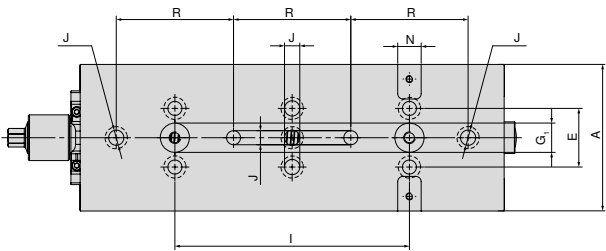
A	C _{-0.02}	F	G	DRVS	MXC	WT	clamping range	CW 80 901 ... 125 160
mm	mm	mm	mm	mm	kN	kg	mm	
125	60	362	433	14	40	15,0	0-308	
160	70	480	559	14	50	28,5	0-434	

Vice guide

→ Underside Dimensions	→ General top jaws
→ Structural dimension tables for the different jaws	→ Workpiece location
→ System jaws	→ General accessories
→ System accessories	→ Clamping lever
→ MNG-/PNG zero point clamping system	→ Screws

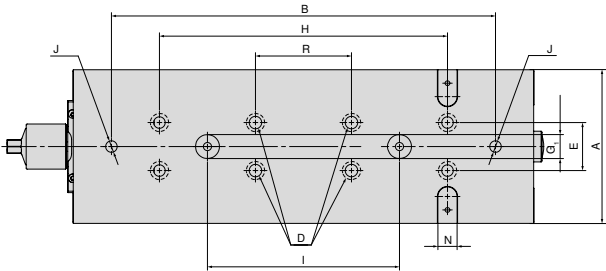
ESG 4 underside dimensions

Base width 125 mm and length 362 mm



A	E	G ₁	I	J	N _{H7}	R
mm	mm	mm	mm	mm	mm	mm
125	50	25	200	13	20	100

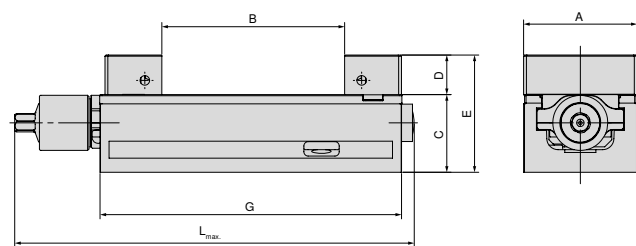
Base width 160 mm and length 480 mm



A	B	D	E	G ₁	H	I	J	N _{H7}	R
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
160	400	13	50	25	300	200	12	20	100

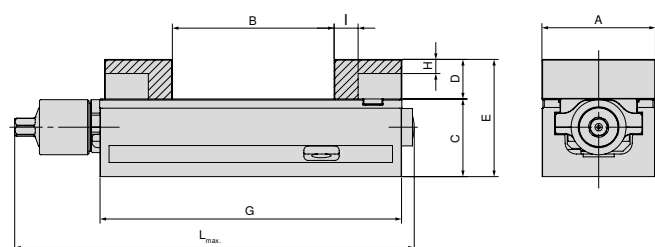
ESG 4 structural dimension table for the different jaws

With block jaws



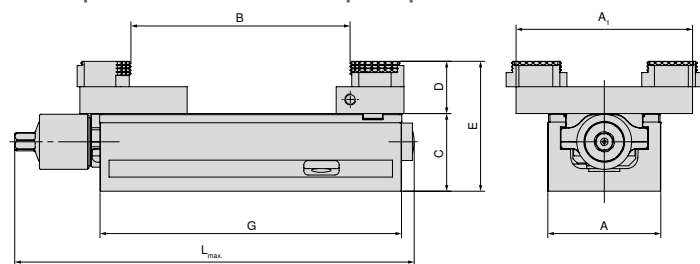
A mm	B mm	C mm	D mm	E mm	G mm	L _{max} mm	Article no. System jaws
125	0 - 231	60	40	100	362	432	8090131400 + 8090131500
160	0 - 312	70	50	120	480	559	8090131600 + 8090131700

With soft alu jaws



A mm	B mm	C mm	D mm	E mm	G mm	H mm	I mm	L _{max} mm	Article no. System jaws
125	0 - 219	60	40	100	362	23	27	432	80901304 + 80878550
160	0 - 309	70	50	120	480	23	30	559	80901301 + 80878305

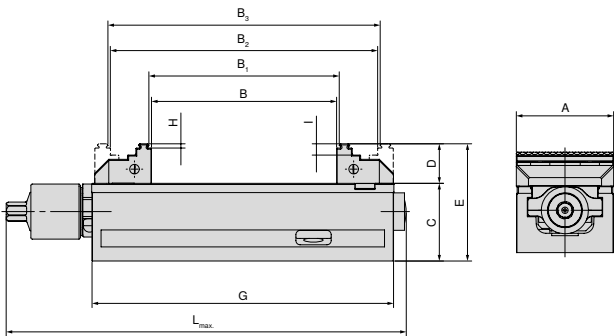
With pendulum and adapter plate



A mm	A ₁ mm	B mm	C mm	D mm	E mm	G mm	L _{max} mm	Article no. System jaws
125	180	4 - 306	60	22	100	362	432	80878570 + 80901502
160	256	11 - 463	70	22	110	480	559	80878670 + 80901503

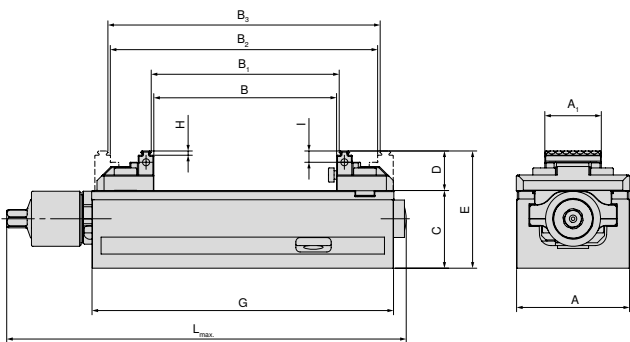
ESG 4 structural dimension table for the different jaws

With indexable jaws, grip 3 mm



A	B	B ₁	B ₂	B ₃	C	D	E	G	H	I	L _{max}	Article no. System jaws
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	
125	0 - 231	8 - 238	71 - 301	78 - 308	60	40	100	362	3	18	433	80901302 + 80901303
160	0 - 310	8 - 317	117 - 427	125 - 434	70	50	120	480	3	10	559	80901300 + 80878610

With indexable jaws, grip 3 mm, height 65 mm



A	A ₁	B	B ₁	B ₂	B ₃	C	D	E	G	H	I	L _{max}	Article no. System jaws
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	
125	65	0 - 240	8 - 247	77 - 317	84 - 324	60	33	93	362	3	9	432	80901305 + 8087851900

Indexable jaw, grip 3 mm, fixed

Technical drawing of a rectangular block. The front view shows a block with a total length A , a width D , and a height H . A circular hole with diameter $\varnothing$ is located on the front face, centered vertically and at a distance M from the right edge. A perspective view of the block is shown to the right.

										CW	NCG	HGG / S / Z	XSG-Z / S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂												
125	125		40	37			66														
160	160		50	47			81			80901302			●	●				●			
										80901300			●	●							

										CW	NCG	H5G / -S / Z	X5G-Z / -S	ESG 4	ESG 5	HOG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂												
125	125		40	37			66				80901303			●	●				●		
160	160		50	47			81			80878610			●	●		●					

The technical drawing on the left shows a rectangular block with dimensions A (length), D (height), and L (width). It features six circular holes on its top surface and four on its front face. The photograph on the right shows the physical component, which is a dark-colored rectangular block with the same hole pattern as the drawing.

										CW	NCG	HSG / S / Z	XSG-Z / S	ESG 4	ESG 5	HOG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂												
125	125		40				66			8090131400			●								
160	160		50				81			8090131600			●	●							

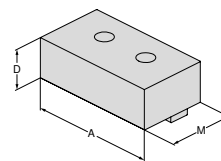
The technical drawing on the left shows a 3D perspective of a rectangular block. The top surface has three circular features arranged in a triangular pattern. The dimensions are labeled: A for the length, D for the height, and M for the width. The photograph on the right shows a physical black rectangular block with three circular features on the top surface, matching the technical drawing.

[illegible]

System jaws overview

Alu jaw, fixed

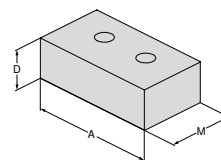
- ▲ for producing shaped jaws
- ▲ Price per piece



For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
125	125		40				68			80901304				●							
160	160		50				85			80901301				●	●						

Alu jaw, movable

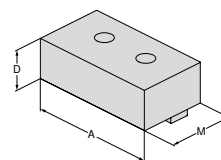
- ▲ for producing shaped jaws
- ▲ Price per piece



For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
125	125		40				68			80878550				●						●	
160	160		50				85			80878305				●	●		●				

Soft jaw, steel, fixed

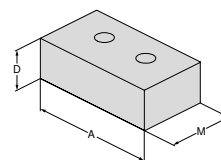
- ▲ Material: 16MnCr5
- ▲ for producing shaped jaws
- ▲ Price per piece



For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
125	125		40				68			8090131900				●	●						

Soft jaw, steel, movable

- ▲ Material: 16MnCr5
- ▲ for producing shaped jaws
- ▲ Price per piece



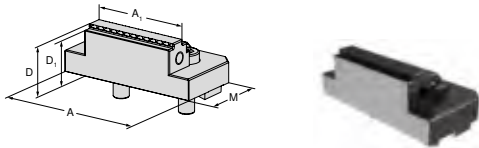
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
125	125		40				68			8087832100				●	●		●				

System jaws overview

5-axis reversible grip jaw, width 65 mm, fixed

- ▲ price per piece
- ▲ double sided grip step

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
125	95	65	33	30			57		

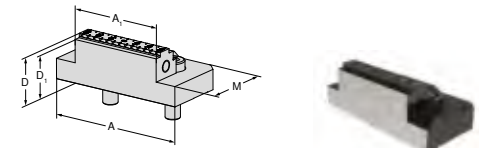


CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80901305				●							

5-axis indexable jaw, grip 3 mm, width 65 mm, movable

- ▲ double sided grip step
- ▲ price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
125	95	65	33	30			57		

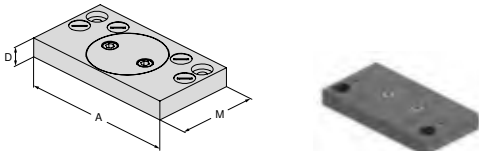


CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8087851900							●				

Pendulum jaw, movable

- ▲ to accommodate 6-way reversible jaws
- ▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
125	180		22				95		
160	256		22				170		

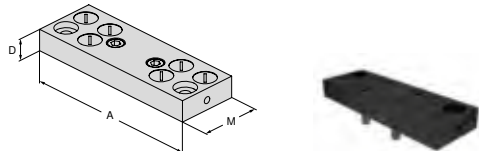


CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80878570				●			●		●		
80878670				●			●				

Adapter jaw

- ▲ to accommodate 6-way reversible jaws
- ▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
125	180		22				62		
160	256		22				125		

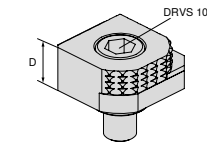


CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80901502				●							
80901503				●							

System jaws overview

6 function indexable jaw

- ▲ 1 = Smooth, carbide coated
- ▲ 2 = Grip with 3 mm step
- ▲ 3 = Grip with 8 mm step
- ▲ 4 = Grip with 18 mm step
- ▲ 5 = Rough grip with 8 mm step
- ▲ 6 = Round grip
- ▲ $M_{max} = 60\text{ Nm}$
- ▲ Including fixation screws

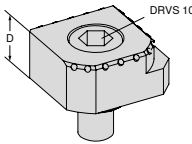


For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
18									

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80892246	●	●	●	●			●		●	●	

6x indexable jaw, carbide grip

- ▲ 1 = Smooth
- ▲ 2 = Carbide grip
- ▲ 3 = Carbide grip with 3 mm step
- ▲ 4 = Carbide grip with 8 mm step
- ▲ 5 = Round carbide grip with 8 mm step
- ▲ 6 = Round carbide grip
- ▲ Incl. fixing screws



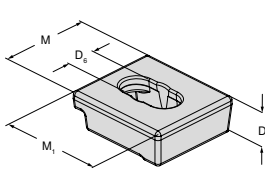
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
18									

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8089035300	●	●	●	●			●		●	●	

System accessories overview

Clamping claws

▲ Price for 2 pieces



D	D ₆	M	M ₁
mm	mm	mm	mm
20	16	50	57

CW
80 890 ...
315

Tenon incl. screw

▲ Price per 2 pieces

NCG	H5G	H5G-S	ESG 4	HDG 2	DSG 4	DSG	X5G-Z
-----	-----	-------	-------	-------	-------	-----	-------



for width mm
12
14
16
18

CW
80 898 ...
412
414
416
418

System accessories overview

Clamping screw and T-Nuts

- ▲ For mounting the clamping claw
- ▲ Price per 2 pieces

Scope of supply:
Incl. washers

NCG	H5G	ESG 4	HDG 2	ZSG 4	DSG 4	Verso
-----	-----	----------	----------	----------	----------	-------



for slot width		G		CW	
mm				80 890 ...	
12		M10			308
14		M12			309
16		M14			310
18		M16			311

Dowel screws

- ▲ Price for 2 pieces

NCG	ESG 4
-----	----------



for width		G	J	CW	
mm			mm	80 890 ...	
100	M12x38		12		313

System accessories overview

Torque Wrench

▲ without socket

- ESG
4
- ESG
mini
- HDG
2
- ZSG
4
- ZSG
mini
- DSG
4
- X5G
-Z



TQX	AS
Nm	80 884 ...
20 - 100	502
40 - 200	504

Socket

▲ Suitable for 1/2" or 3/8" square drive

- ESG
4
- ZSG
4
- DSG
4



DRVS	AS
mm	80 875 ...
12	212
14	214

System accessories overview

Clamping Handle with Joint

▲ without socket

- H5G
-Z
- H5G
-Z-S
- ESG
4
- ESG
mini
- ZSG
4



Square		CW
1/2"		80 891 ...
		600

Clamping Screw Set for T-slot for MNG

▲ Price for 2 pieces

- ESG
4
- ZSG
4
- DSG
4



for width mm	G	CW
18	M12	80 899 ...
		318

System accessories overview

Tenon incl. screw

▲ Price per 2 pieces

- NCG
- NCG
2
- H5G
- H5G
-S
- ESG
4
- HDG
2
- ZSG
- DSG
4



for width mm	G
12	M6

CW

80 898 ...

412

Dowel screw

▲ Price for 2 pieces

- H5G
- ESG
4
- ZSG
4
- DSG
4
- MNG
- X5G
-Z



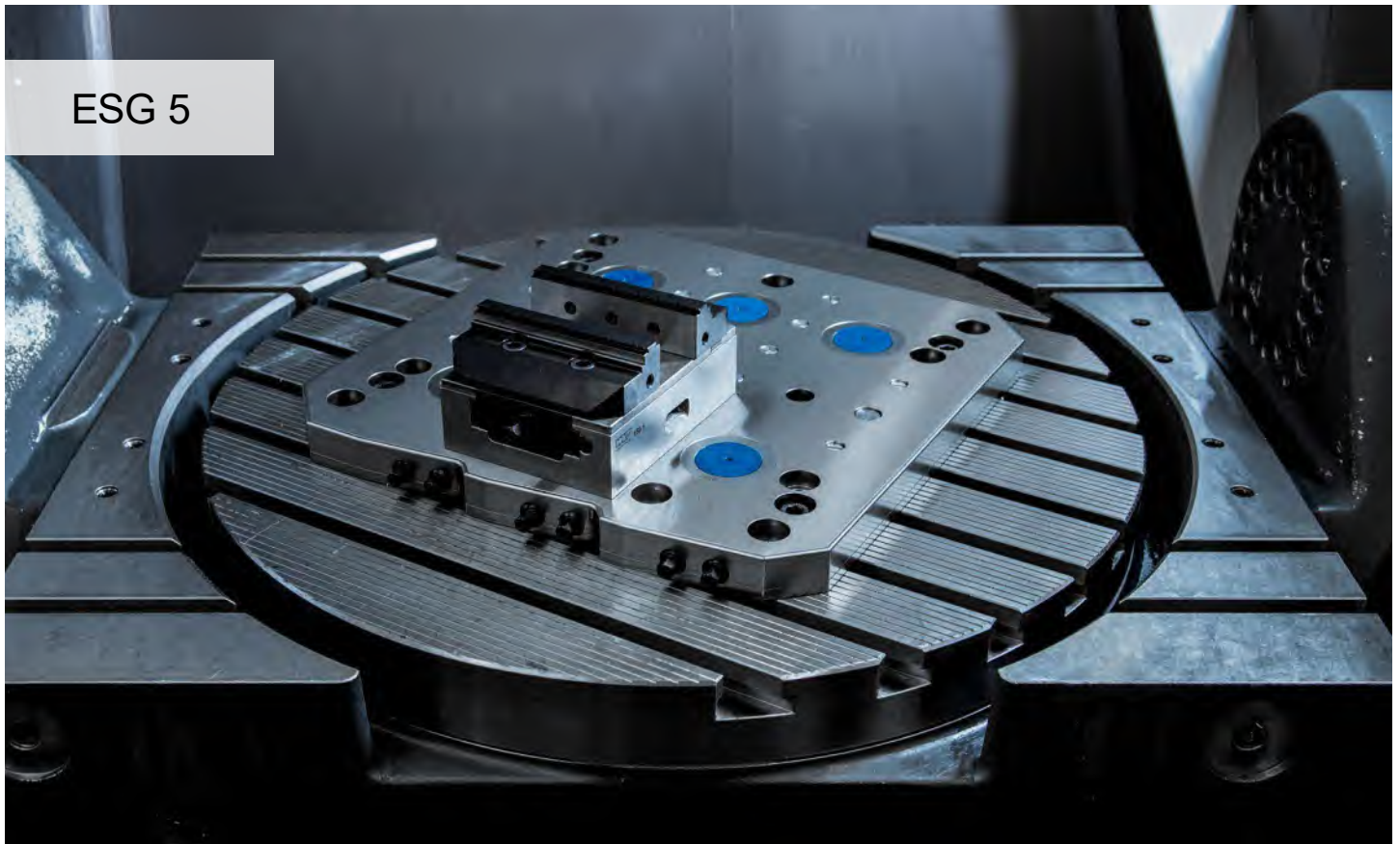
for width mm	G	J mm
125	M12x45	12

CW

80 895 ...

019

ESG 5



The optimised ESG 5 – Maximum precision and process security

The new ESG 5 retains all the cherished characteristics of its predecessor and raises the bar significantly with regard to user-friendliness and durability. Optimised handling and improved durability were top of the list in the update for the single vice.

Your benefits:

- ▲ Specially designed for second side machining through high angular accuracy
- ▲ Compact design with ideal accessibility
- ▲ Jaw change Quick and easy with two screws
- ▲ The same clamping ranges, significantly improved interference contour, comprehensive modular jaw range
- ▲ Sustainable model with nickel-plated base body ensures a long service life

Clamping/aligning:



Mounting with zero point clamping system
 ESG 5 – 80 mm L-130 mm + L-190 mm
 ESG 5 – 125 mm L-160 mm + L-235 mm

1 mounting bolt + MNG-indexing bolt



Mounting with zero point clamping system
 ESG 5 – 125 mm + L-300 mm
 ESG 5 – 160 mm + L-280 mm + L-480 mm

2 mounting bolts



Dia. 12^{JS} precision holes are present in all variants for positioning the ESG 5 with precision. All variants can be mounted with screws from above through the base body.

Clamping/aligning:

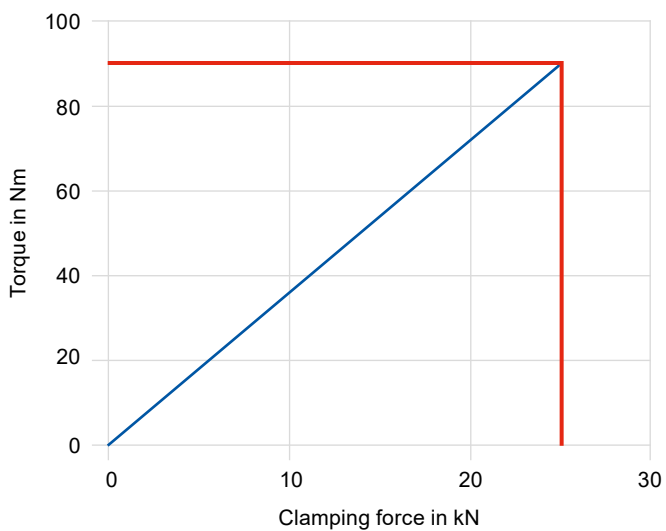


ESG 5 – 125 mm L-235 mm + L-300 mm
ESG 5 – 160 mm L-280 mm + L-480 mm

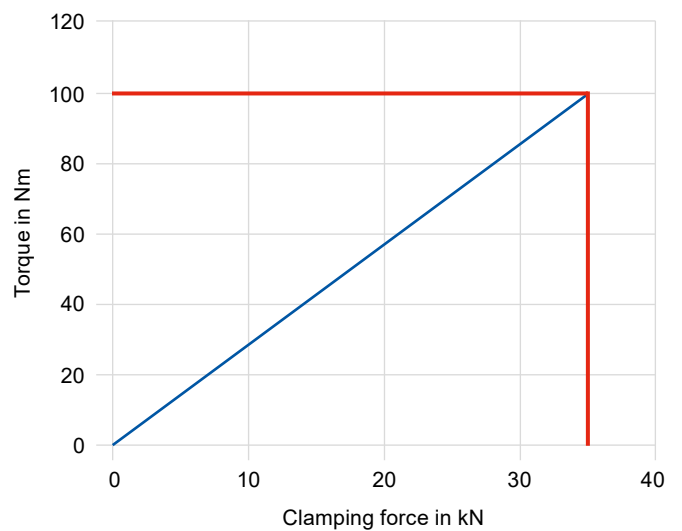
These 4 variants can also be clamped with clamping claws as an alternative.

Clamping force:

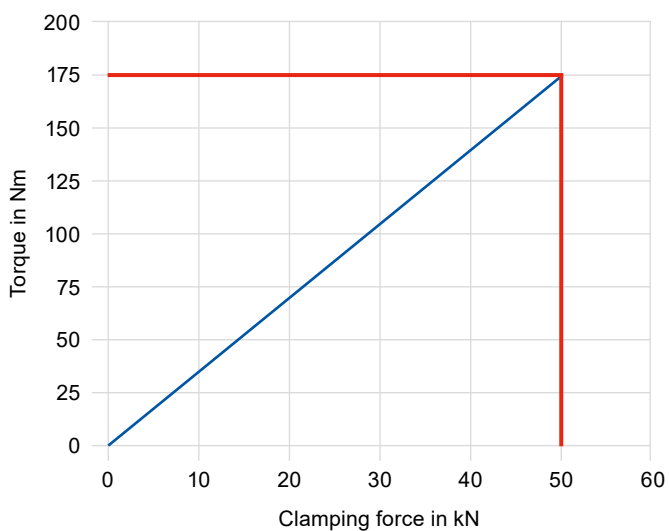
ESG 5 – 80 mm tightening torque / clamping force



ESG 5 – 125 mm tightening torque / clamping force

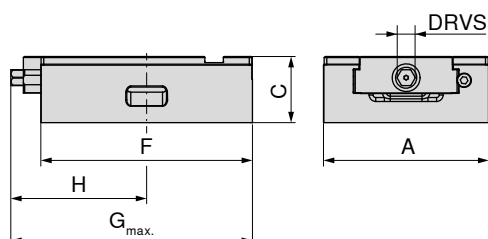


ESG 5 – 160 mm tightening torque / clamping force



CoreLine – Sealed single vice without system jaws – ESG 5

- ▲ Specially designed for second side machining through high angular accuracy
- ▲ ± 0.01 mm repeatability between the clamping processes
- ▲ Suitable for PNG and MNG



A mm	C _{±0.01} mm	F mm	G _{max.} mm	H mm	DRVS mm	MXC kN	WT kg
80	50	130	155,0	82	12	25	2,9
80	50	190	203,0	102	12	25	4,4
125	50	160	169,0	103	12	35	6,0
125	50	235	235,0	132	12	35	8,4
125	50	300	300,0	170	12	35	10,5
160	70	280	309,0	169	14	50	25,0
160	70	480	512,5	267	14	50	30,0

CW
80 857 ...
08500
08600
15000
15100
15200
26100
26200

Suitable for zero point clamping system							LANG Quick Point	LANG Quick Point
Article no.	Type	Width in mm	Height in mm	MNG	MNG mini	PNG	96 x 96	52 x 52
80 857 08500	ESG 5	80	130	✓	✓	✗	✗	✓
80 857 08600		80	190	✓	✗	✓	✗	✓
80 857 15000		125	160	✓	✗	✓	✓	✓
80 857 15100		125	235	✓	✗	✓	✓	✗
80 857 15200		125	300	✓	✗	✓	✓	✗
80 857 26100		160	280	✓	✗	✓	✓	✗
80 857 26200		160	480	✓	✗	✓	✗	✗

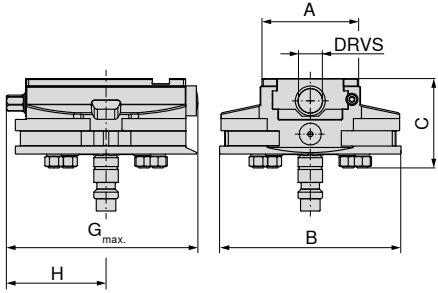
Vice guide

→ Underside Dimensions	→ General top jaws
→ Structural dimension tables for the different jaws	→ Workpiece location
→ System jaws	→ General accessories
→ System accessories	→ Clamping lever
→ MNG-/PNG zero point clamping system	→ Screws

CoreLine – Sealed single vice without system jaws – ESG 5

- ▲ for Erowa ITS 148
- ▲ Specially designed for second side machining through high angular accuracy
- ▲ ±0.01 mm repeatability between the clamping processes

ESG
5





A	B	C	G _{max}	H	DRVS	MXC	WT
mm	mm	mm	mm	mm	mm	kN	kg
80	148	73	157	81	12	25	5,6

CW

80 857 ...

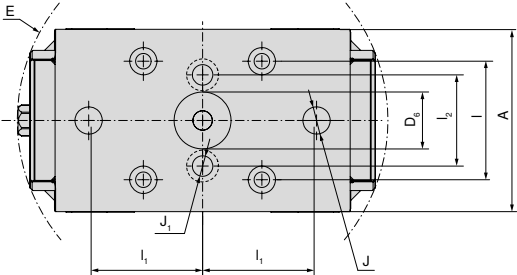
08900

Vice guide

- | | |
|--|-----------------------|
| → Underside Dimensions | → General top jaws |
| → Structural dimension tables for the different jaws | → Workpiece location |
| → System jaws | → General accessories |
| → System accessories | → Clamping lever |
| → MNG-/PNG zero point clamping system | → Screws |

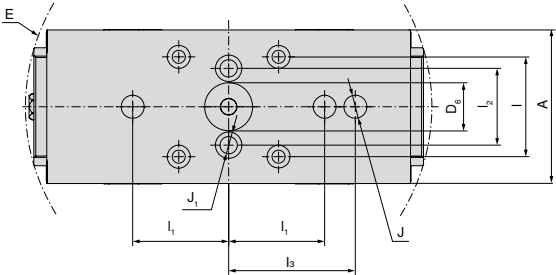
ESG 5 underside dimensions

Base width 80 mm and length 130 mm



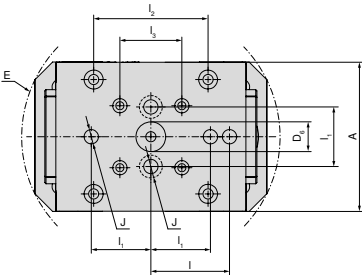
A	D ₆ H6	E	I ±0.015	I ₁ ±0.015	I ₂	J H7	J ₁
mm	mm	mm	mm	mm	mm	mm	mm
80	25	163	52	50	40	12	9

Base width 80 mm and length 190 mm



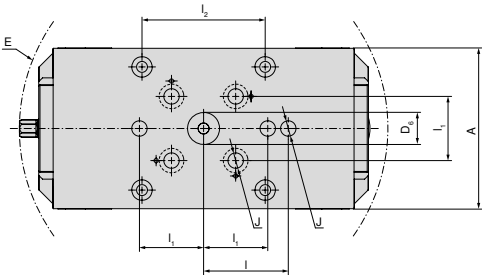
A	D ₆ H6	E	I ±0.015	I ₁ ±0.015	I ₂	I ₃ ±0.015	J H7	J ₁
mm	mm	mm	mm	mm	mm	mm	mm	mm
80	25	213	52	50	40	66	12	9

Base width 125 mm and length 160 mm



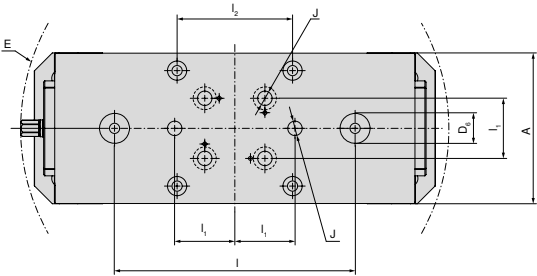
A	D ₆ H6	E	I ±0.015	I ₁ ±0.015	I ₂	I ₃ ±0.015	J H7
mm	mm	mm	mm	mm	mm	mm	mm
125	25	288	66	50	96		12
125	25	218	66	50	96	52	12

Base width 125 mm and length 235 mm



A	D ₆ H6	E	I ±0.015	I ₁ ±0.015	I ₂	J H7
mm	mm	mm	mm	mm	mm	mm
125	25	288	66	50	96	12

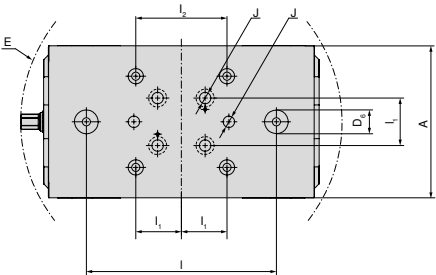
Base width 125 mm and length 300 mm



A	D ₆ H6	E	I ±0.015	I ₁ ±0.015	I ₂	J H7
mm	mm	mm	mm	mm	mm	mm
125	25	357	200	50	96	12

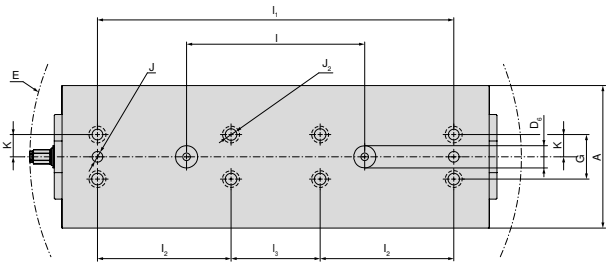
ESG 5 underside dimensions

Base width 160 mm and length 280 mm



A	D ₆ H6	E	I ±0,015	I ₁ ±0,015	I ₂	J H7
mm	mm	mm	mm	mm	mm	mm
160	25	339	200	50	96	12

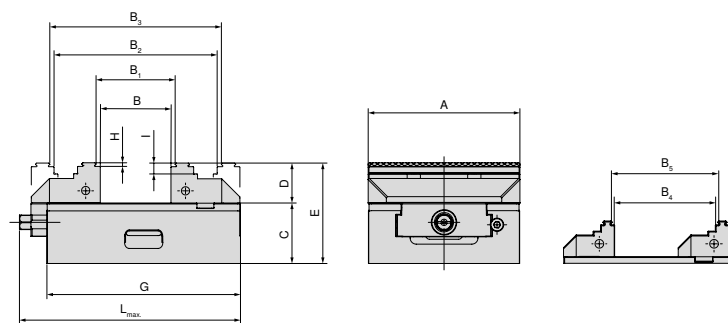
Base width 160 mm and length 480 mm



A	D ₆ H6	E	I ±0,015	I ₁ ±0,015	I ₂	I ₃ ±0,015	J H7	J ₂ F7	K ±0,02	G
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
160	25	550	200	400	150	100	13	12	25	50

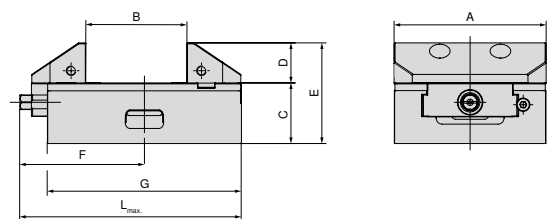
ESG 5 structural dimension table for the different jaws

With indexable jaw grip 3 mm, fixed and movable



A mm	B mm	B ₁ mm	B ₂ mm	B ₃ mm	B ₄ mm	B ₅ mm	C mm	D mm	E mm	G mm	H mm	I mm	L _{max} mm	Article no. System jaws
80	0-49	4-53	59-107	63-111	30-78	34-82	50	28	78	130	3	8	155	80901306 + 80878810
80	0-109	4-113	59-167	63-171	29-134	35-136	50	28	78	190	3	8	206	80901306 + 80878810
125	0-57	8-64	77-134	84-141	40-95	47-102	50	33	83	160	3	9	183	8085730000 + 80878510
125	0-127	8-134	77-204	84-211	40-165	47-172	50	33	83	235	3	9	250	8085730000 + 80878510
125	0-197	8-204	77-274	84-281	40-235	47-242	50	33	83	300	3	9	320	8085730000 + 80878510
160	0-121	8-128	118-238	125-245	–	–	70	50	120	280	3	10	328	80901300 + 80878610
160	0-324	8-331	118-441	125-448	–	–	70	50	120	480	3	10	506	80901300 + 80878610

With 5-axis jaws



A mm	B mm	C mm	D mm	E mm	F mm	G mm	L _{max} mm	Article no. System jaws
125	25-82	50	33	83	103	160	183	8085730200 + 8085730100
125	25-152	50	33	83	132	235	250	8085730200 + 8085730100
125	25-222	50	33	83	170	300	320	8085730200 + 8085730100

System jaws overview

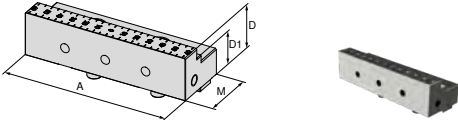
Indexable jaw, smooth, fixed

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
80	80		28	20			40		
125	125		33	25			57		

CW									
8085730400									
8085730300									

	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
					●						
					●						



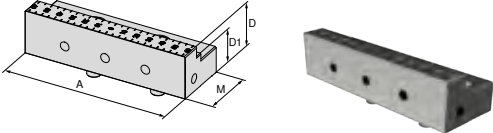
Indexable jaw, smooth, movable

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
80	80		28	20			40		
125	125		33	25			57		

CW									
8087834700									
8087834600									

	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
					●						
					●		●				



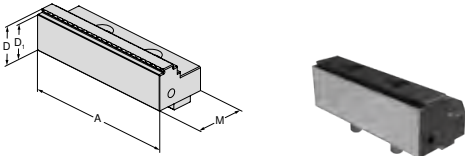
Indexable jaw, grip 3 mm, fixed

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
80	80		28	25			40		
125	125		33	30			57		
160	160		50	47			81		

CW									
80901306									
8085730000									
80901300									

	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
				●	●						
					●						
				●	●						



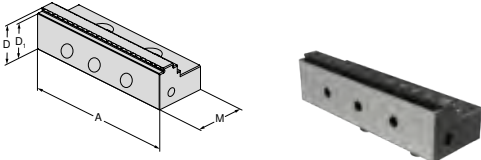
Indexable jaw, grip 3 mm, movable

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
80	80		28	25			40		
125	125		33	30			57		
160	160		50	47			81		

CW									
80878810									
80878510									
80878610									

	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
				●	●						
					●		●		●		
				●	●		●				



System jaws overview

5-axis indexable jaw, fixed

▲ Price per piece

For vice width

A

A₁

D

D₁

D₂

E

M

M₁

M₂

125

125

33

44,5

CW

8085730100

NCG

H5G / -S / -Z

X5G-Z / -S

ESG 4

ESG 5

HDG 2

ZSG 4

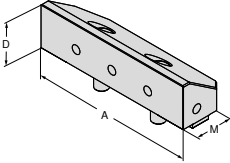
ZSG mini

DSG 4

Verso

HSG

●



5-axis indexable jaw, movable

▲ Price per piece

For vice width

A

A₁

D

D₁

D₂

E

M

M₁

M₂

125

125

33

44,5

CW

8085730200

NCG

H5G / -S / -Z

X5G-Z / -S

ESG 4

ESG 5

HDG 2

ZSG 4

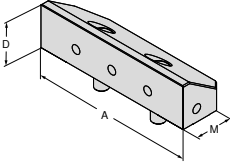
ZSG mini

DSG 4

Verso

HSG

●



Soft jaw, steel, fixed

- ▲ Material: 16MnCr5
- ▲ for producing shaped jaws
- ▲ Price per piece

For vice width

A

A₁

D

D₁

D₂

E

M

M₁

M₂

80

80

28

48

125

125

40

68

CW

8090131800

8090131900

NCG

H5G / -S / -Z

X5G-Z / -S

ESG 4

ESG 5

HDG 2

ZSG 4

ZSG mini

DSG 4

Verso

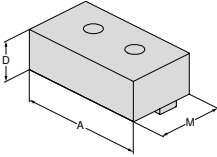
HSG

●

●

●

●



Soft jaw, steel, movable

- ▲ Material: 16MnCr5
- ▲ for producing shaped jaws
- ▲ Price per piece

For vice width

A

A₁

D

D₁

D₂

E

M

M₁

M₂

80

80

28

48

125

125

40

68

CW

8087832000

8087832100

NCG

H5G / -S / -Z

X5G-Z / -S

ESG 4

ESG 5

HDG 2

ZSG 4

ZSG mini

DSG 4

Verso

HSG

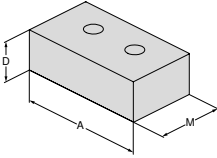
●

●

●

●

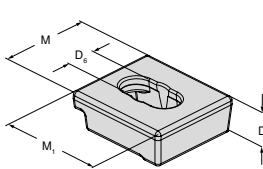
●



System accessories overview

Clamping claws

▲ Price for 2 pieces



D	D ₆	M	M ₁
mm	mm	mm	mm
20	16	50	57

CW
80 890 ...
315

Clamping Handle with Joint

▲ without socket

H5G -Z	H5G -Z-S	ESG 4	ESG mini	ZSG 4
-----------	-------------	----------	-------------	----------



Square
1/2"

CW
80 891 ...
600

System accessories overview

Clamping Screw Set for T-slot for MNG

▲ Price for 2 pieces

- ESG
4
- ZSG
4
- DSG
4



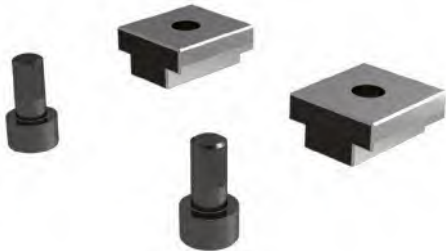
for width mm	G	CW	
		80 899 ...	
12	M10		312 ¹⁾
14	M12		314
16	M12		316
18	M12		318

1) Version with washers

Tenon incl. screw

▲ Price per 2 pieces

- NCG
- NCG
2
- H5G
- H5G
-S
- ESG
4
- HDG
2
- ZSG
- DSG
4



for width mm	G	CW	
		80 898 ...	
12	M6		412
14	M6		414
16	M6		416
18	M6		418

System accessories overview

Torque Wrench

▲ without socket

- ESG
4
- ESG
mini
- HDG
2
- ZSG
4
- ZSG
mini
- DSG
4
- X5G
-Z



TQX Nm	AS
20 - 100	80 884 ...
40 - 200	502
	504

Socket

▲ Suitable for 1/2" or 3/8" square drive

- ESG
4
- ZSG
4
- DSG
4



DRVS mm	AS
12	80 875 ...
14	212
	214

System accessories overview

Dowel screw

▲ Price for 2 pieces

- H5G
- ESG
4
- ZSG
4
- DSG
4
- MNG
- X5G
-Z



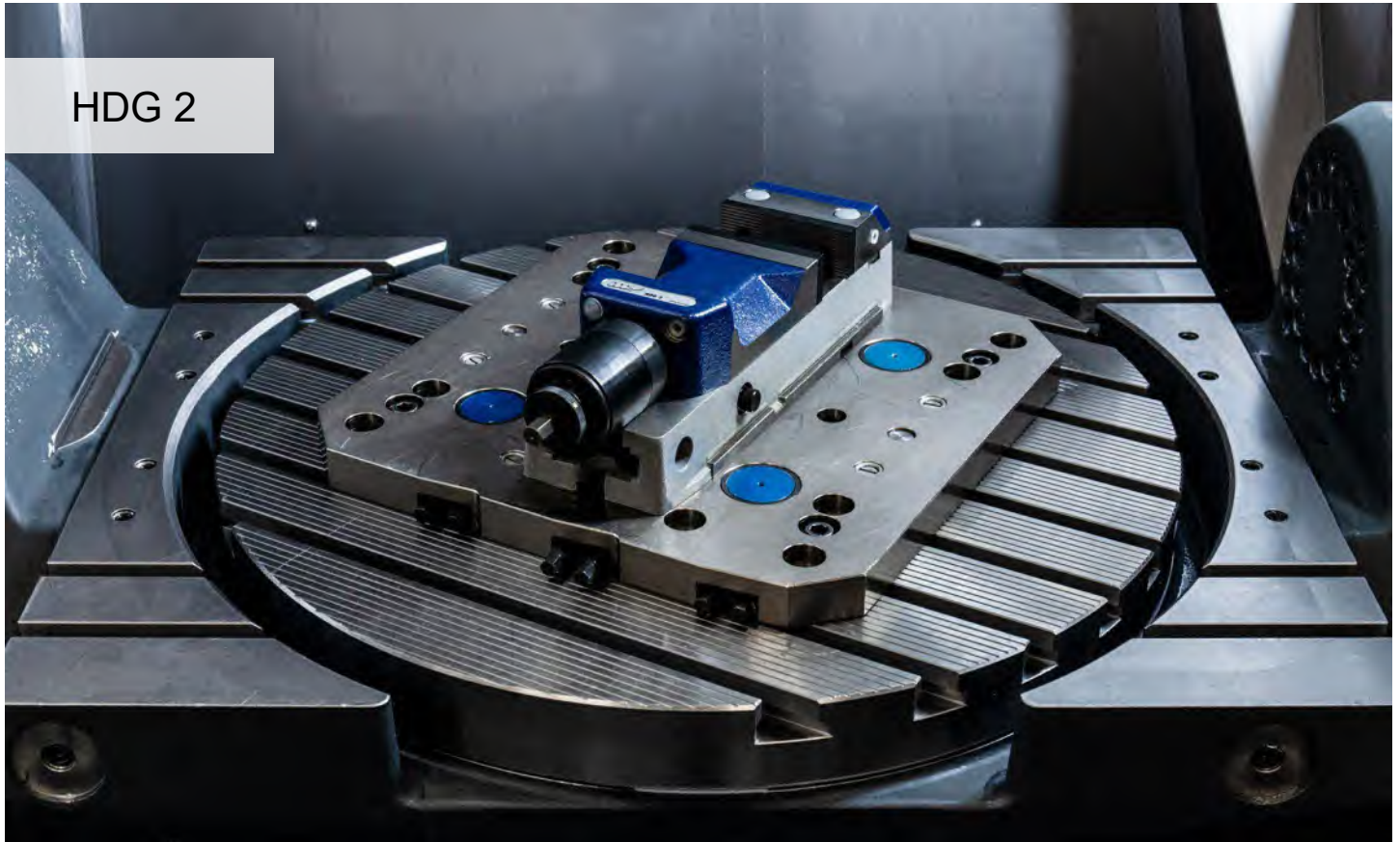
for width mm	G	J mm
125	M12x45	12

CW

80 895 ...

019

HDG 2



Tried-and-tested high pressure clamping system

Mechanical machine vice with continuous force adjustment from 10% to 100% of the clamping force with just one crank turn and always the same final crank position. Quick clamping range adjustment via locking pins.

Your benefits:

- ▲ Save time and effort – just one crank turn
- ▲ Clamping time of less than one second
- ▲ Easy handling
- ▲ Can be continuously adjusted without tools
- ▲ High machining precision

Clamping/aligning:



Alignment through precision slot nuts on the slot table with 20^{H7} longitudinal/transverse slot in the base body



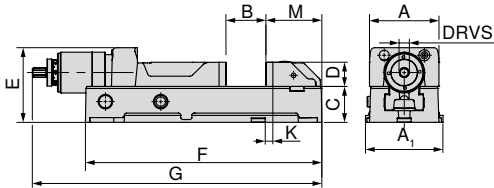
Clamp with screws through the base body or laterally with clamping claws

CoreLine – High pressure vice – HDG 2

- ▲ stepless power adjustment
- ▲ mechanical power transmission
- ▲ clamping force with only a single turn of the handle
- ▲ flexible Jaws, pre-machined to accommodate jaws for clamping range extension

Scope of supply:
High pressure vice incl. 4 clamping jaws, hand crank, 2 top jaws profiled and hardened

HDG
2



A	A ₁	B	C _{+0/-0,02}	D	E	F	G _{max.}	K _{±0,015}	M	DRVS	MXC	WT
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kN	kg
100	112	0 - 159	52	35	108	342	521	11	81	12	4 - 30	20
125	140	0 - 201	62	40	118	400	584	28	85	12	4 - 40	27
160	176	0 - 300	78	50	149	544	784	40	112	12	5 - 60	55

CW
80 892 ...
100 ¹⁾
125 ¹⁾
160 ¹⁾

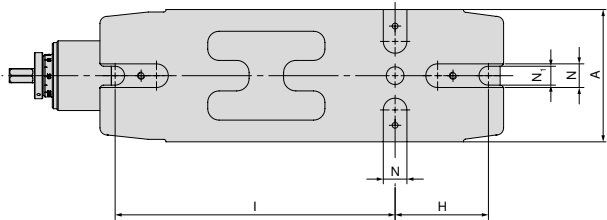
1) Not ex-stock

Vice guide

→ Underside Dimensions	→ General accessories
→ System accessories	→ Clamping lever
→ MNG-/PNG zero point clamping system	→ Screws
→ General top jaws	
→ Workpiece location	

HDG 2 underside dimensions

Base width 100 mm, 125 mm, 160 mm



A mm	H mm	I mm	N _{H7} mm	N _I mm
100	80	240	20	15
125	100	280	20	18
160	130	380	20	22

System accessories overview

Angular drive

HDG
2

for width
mm

100/125

CW

80 892 ...

314



Hand crank

▲ for fast adjustment

HDG
2

for width mm	DRVS mm
100/125	12
160	12

CW

80 892 ...

124

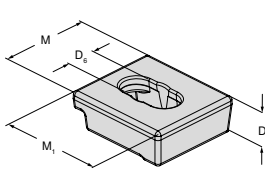
164



System accessories overview

Clamping claws

▲ Price for 2 pieces



D	D ₆	M	M ₁
mm	mm	mm	mm
20	16	50	57

CW
80 890 ...
315

Tenon incl. screw

▲ Price per 2 pieces

NCG	NCG 2	H5G	H5G -S	ESG 4	HDG 2	ZSG	DSG 4
-----	-------	-----	--------	-------	-------	-----	-------



for width mm	G
12	M6
14	M6
16	M6
18	M6

CW
80 898 ...
412
414
416
418

System accessories overview

Clamping screw and T-Nuts

- ▲ For mounting the clamping claw
- ▲ Price per 2 pieces

Scope of supply:
Incl. washers

NCG	H5G	ESG 4	HDG 2	ZSG 4	DSG 4	Verso
-----	-----	----------	----------	----------	----------	-------



for slot width		G		CW	
mm				80 890 ...	
12		M10			308
14		M12			309
16		M14			310
18		M16			311

ZSG 4



The optimised ZSG 4 – Maximum precision and process security

The new ZSG 4 retains all the cherished characteristics of its predecessor and raises the bar significantly with regard to user-friendliness and durability. Optimised handling and improved durability were top of the list in the update for the popular centric vice.

Your benefits:

- ▲ Specially designed for second side machining through high angular accuracy
- ▲ Compact design with ideal accessibility
- ▲ Jaw change Quick and easy with two screws
- ▲ The same clamping ranges, significantly improved interference contour, comprehensive modular jaw range
- ▲ Sustainable model with nickel-plated base body ensures a long service life



Clamping/aligning:



Mounting with zero point clamping system
ZSG 4 – 80 mm L-130 mm + L-190 mm
ZSG 4 – 125 mm L-160 mm + L-235 mm

1 mounting bolt + MNG-indexing bolt



Mounting with zero point clamping system
ZSG 4 – 125 mm + L-300 mm
ZSG 4 – 160 mm + L-280 mm + L-480 mm

2 mounting bolts



Dia. 12^{JS} precision holes are present in all variants for positioning the ZSG 4 with precision. All variants can be mounted with screws from above through the base body.

Clamping/aligning:



ZSG 4 – 125 mm L-235 mm + L-300 mm
ZSG 4 – 160 mm L-280 mm + L-480 mm

These 4 variants can also be clamped with clamping claws as an alternative.

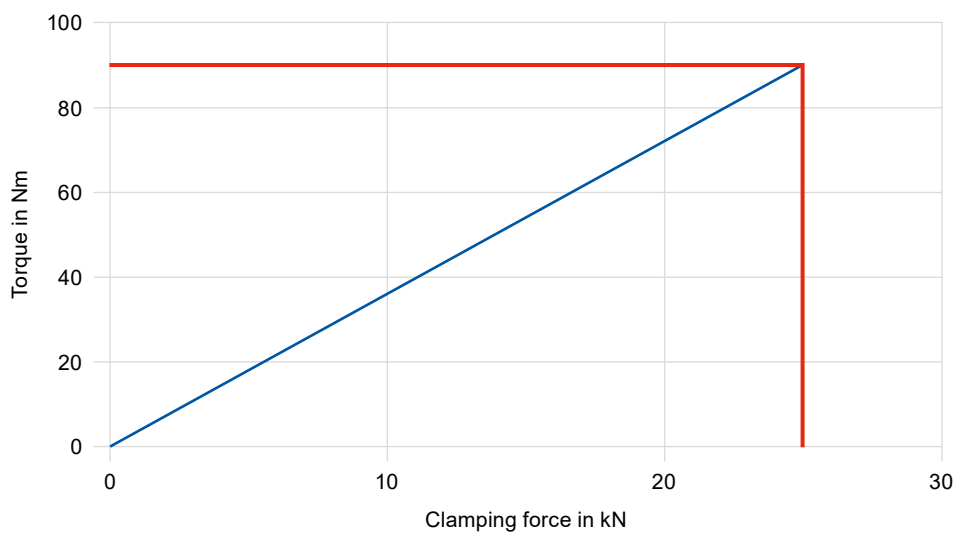


ZSG 4 – 80 mm L-130 mm + L-190 mm
ZSG 4 – 125 mm L-160 mm + L-235 mm + L-300 mm
ZSG 4 – 160 mm L-280 mm

All 5 variants are also available with mounting holes for the LANG zero point clamping system.

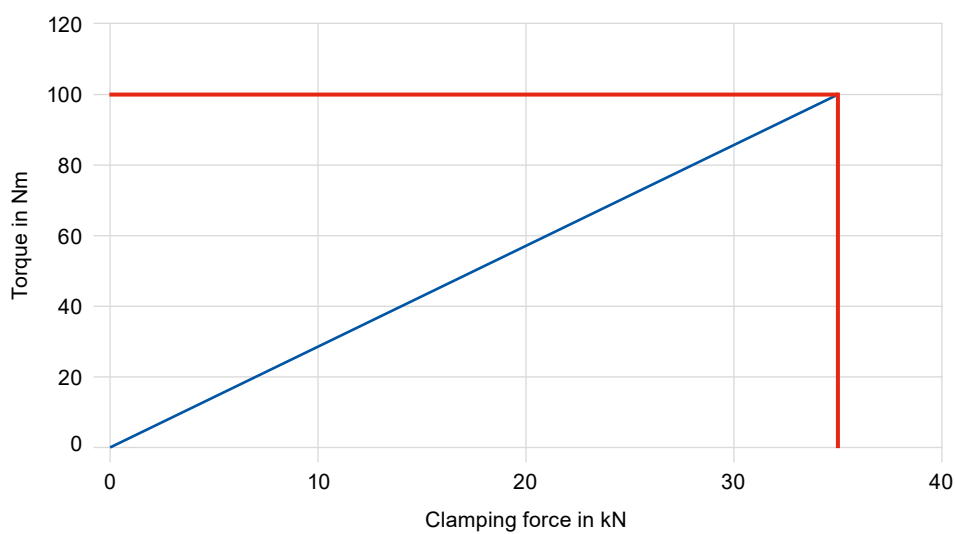
Clamping force:

ZSG 4 – 80 mm tightening torque/clamping force

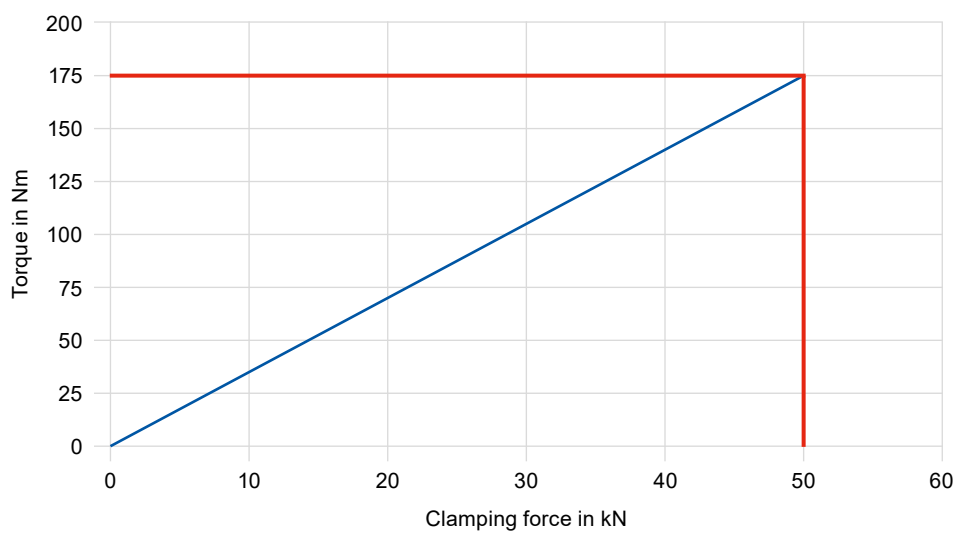


Clamping force:

ZSG 4 – 125 mm tightening torque / clamping force

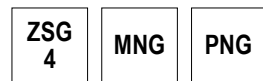
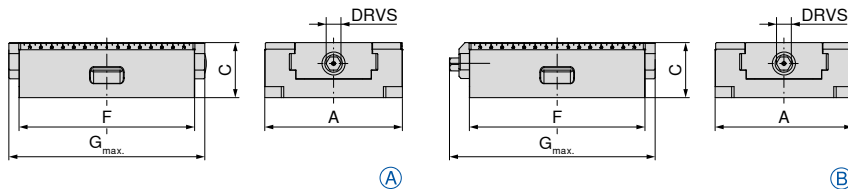


ZSG 4 – 160 mm tightening torque / clamping force



CoreLine – Sealed centric vice without system jaws – ZSG 4

- ▲ Ball bearing mounted spindle
- ▲ ± 0.01 mm repeatability between the clamping processes
- ▲ Suitable for PNG and MNG



Internal actuating spindle

External actuating spindle



A mm	C ± 0.01 mm	F mm	G _{max} mm	DRVS mm	MXC kN	WT kg	Designation	CW	
80	50	130	157	12	25	3,1	A	80 878 ...	
80	50	190	206	12	25	4,5	B	08500	
125	50	160	200	12	35	6,3	A	08600	
125	50	235	272	12	35	9,5	B	15000	
125	50	300	340	12	35	12,5	B	15100	
125	60	390	433	12	35	17,0	B	15200	
125	60	460	503	12	35	20,0	B	17000	
125	60	530	573	12	35	24,0	B	17100	
125	60	600	643	12	35	27,0	B	17200	
125	60	670	713	12	35	30,5	B	17300	
125	60	740	783	12	35	34,0	B	17400	
160	70	280	315	14	50	25,0	A	17500	
160	70	480	524	14	50	35,0	B	26100	
								26200	

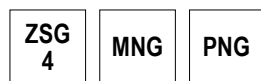
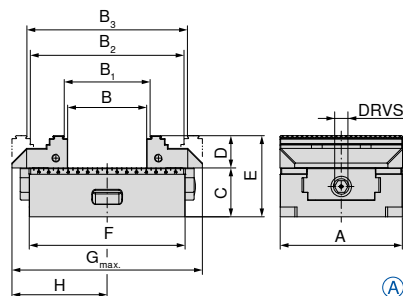
Suitable for zero point clamping system							LANG Quick Point	LANG Quick Point
Article no.	Type	Width in mm	Length in mm	MNG	MNG mini	PNG	96 x 96	52 x 52
8087808500	ZSG 4	80	130	✓	✓	✗	✓	✓
8087808600		80	190	✓	✗	✓	✓	✓
8087815000		125	160	✓	✗	✓	✓	✓
8087815100		125	235	✓	✗	✓	✓	✗
8087815200		125	300	✓	✗	✓	✓	✗
8087817000		125	390	✓	✗	✓	✗	✗
8087817100		125	460	✓	✗	✓	✗	✗
8087817200		125	530	✓	✗	✓	✗	✗
8087817300		125	600	✓	✗	✓	✗	✗
8087817400		125	670	✓	✗	✓	✗	✗
8087817500		125	740	✓	✗	✓	✗	✗
8087826200		160	480	✓	✗	✓	✗	✗

Vice guide

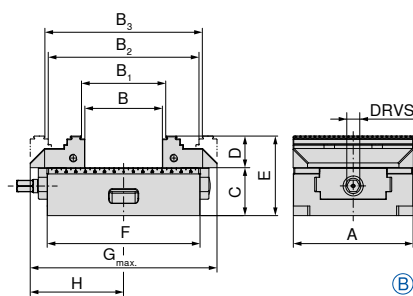
→ Underside Dimensions	→ General top jaws
→ Structural dimension tables for the different jaws	→ Workpiece location
→ System jaws	→ General accessories
→ System accessories	→ Clamping lever
→ MNG-/PNG zero point clamping system	→ Screws

CoreLine – Sealed centric vice with grip jaws – ZSG 4

- ▲ Ball bearing mounted spindle
- ▲ ± 0.01 mm repeatability between the clamping processes
- ▲ Suitable for PNG and MNG



Internal actuating spindle



External actuating spindle



A mm	B mm	B ₁ mm	B ₂ mm	B ₃ mm	C _{±0,01} mm	D mm	E mm	F mm	G _{max} mm	H mm	DRVS mm	MXC kN	WT kg	Designation
80	0 - 59	4 - 63	59 - 117	63 - 121	50	28	78	130	157	81	12	25	3,9	A
80	0 - 123	4 - 127	59 - 181	63 - 185	50	28	78	190	206	104	12	25	5,5	B
125	0 - 80	8 - 87	77 - 156	84 - 163	50	33	83	160	208	111,5	12	35	8,7	A
125	0 - 142	8 - 149	77 - 218	84 - 225	50	33	83	235	273	143,5	12	35	12,0	B
125	0 - 220	8 - 227	77 - 296	84 - 303	50	33	83	300	348	181	12	35	14,0	B

CW

80 878 ...

08700

08800

15300

15400

15500



It is not possible to fit top jaws with a height of 40 mm, if this height is required, please use the reversible jaws with D = 40 mm (Article No. 80 878 520).

Suitable for zero point clamping system				MNG	MNG mini	PNG	LANG Quick Point	
Article no.	Type	Width in mm	Length in mm				96 x 96	52 x 52
8087808700	ZSG 4	80	130	✓	✓	✗	✗	✓
8087808800		80	190	✓	✗	✓	✗	✓
8087815300		125	160	✓	✗	✓	✓	✓
8087815400		125	235	✓	✗	✓	✓	✗
8087815500		125	300	✓	✗	✓	✓	✗

Vice guide

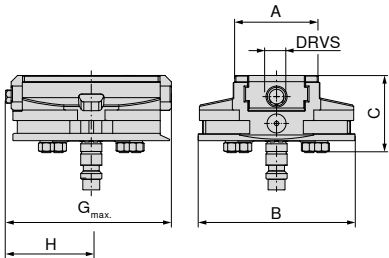
- Underside Dimensions
- Structural dimension tables for the different jaws
- System jaws
- System accessories
- MNG-/PNG zero point clamping system
- General top jaws
- Workpiece location
- General accessories
- Clamping lever
- Screws

CoreLine – Sealed centric vice without system jaws – ZSG 4

- ▲ for Erowa ITS 148
- ▲ Ball bearing mounted spindle
- ▲ ±0.01 mm repeatability between the clamping processes

ZSG
4

MNG



A	B	C	G _{max}	H	DRVS	MXC	WT
mm	mm	mm	mm	mm	mm	kN	kg
80	148	73	157	81	12	25	5,6

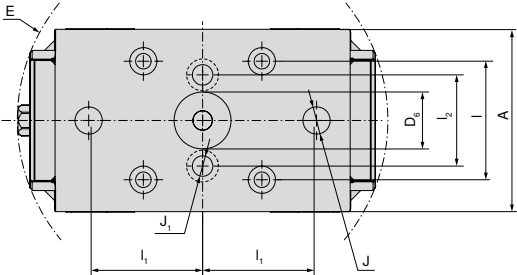
CW

80 878 ...

08900

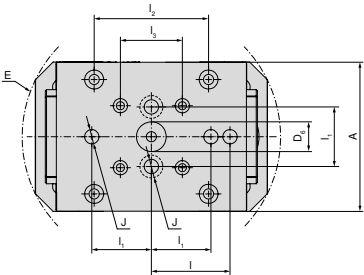
ZSG 4 underside dimensions

Base width 80 mm and length 130 mm



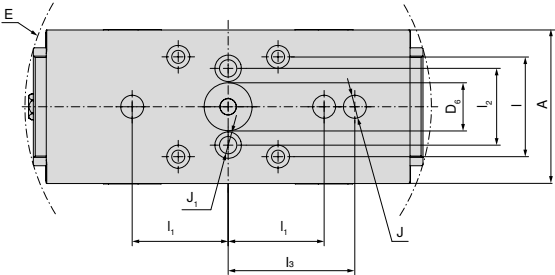
A	D6 H6	E	I ±0.015	I1 ±0.015	I2	J H7	J1
mm	mm	mm	mm	mm	mm	mm	mm
80	25	163	52	50	40	12	9

Base width 125 mm and length 160 mm



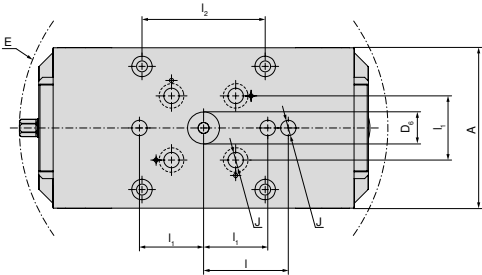
A	D6 H6	E	I ±0.015	I1 ±0.015	I2	I3 ±0.015	J H7
mm	mm	mm	mm	mm	mm	mm	mm
125	25	288	66	50	96		12
125	25	218	66	50	96	52	12

Base width 80 mm and length 190 mm



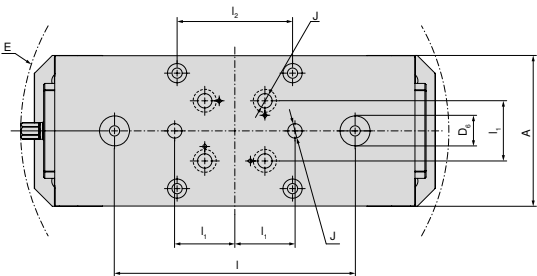
A	D6 H6	E	I ±0.015	I1 ±0.015	I2	I3 ±0.015	J H7	J1
mm	mm	mm	mm	mm	mm	mm	mm	mm
80	25	213	52	50	40	66	12	9

Base width 125 mm and length 235 mm



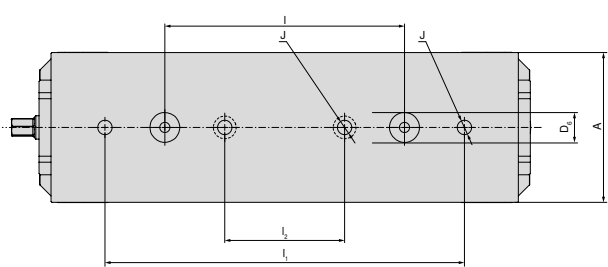
A	D6 H6	E	I ±0.015	I1 ±0.015	I2	J H7
mm	mm	mm	mm	mm	mm	mm
125	25	288	66	50	96	12

Base width 125 mm and length 300 mm



A	D6 H6	E	I ±0.015	I1 ±0.015	I2	J H7
mm	mm	mm	mm	mm	mm	mm
125	25	357	200	50	96	12

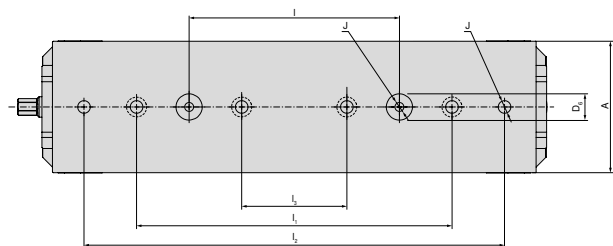
Base width 125 mm and length 390 mm



A	D6 H6	I ±0.015	I1 ±0.01	I2 ±0.02	J H7
mm	mm	mm	mm	mm	mm
125	25	200	300	100	12

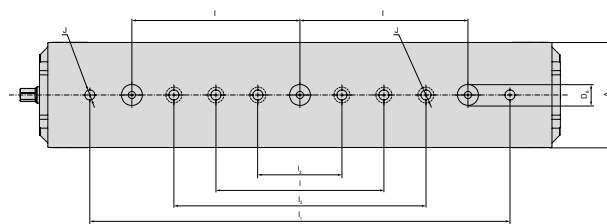
ZSG 4 underside dimensions

Base width 125 mm and length 460 mm,
530 mm



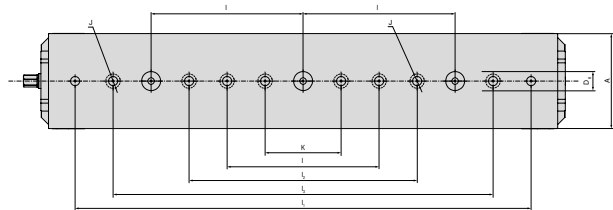
A mm	D ₆ H ₆ mm	I ±0,015 mm	I ₁ ±0,01 mm	I ₂ ±0,02 mm	I ₃ ±0,025 mm	J H ₇ mm
125	25	200	300	400	100	12
125	25	200	300	500	100	12

Base width 125 mm and length 600 mm



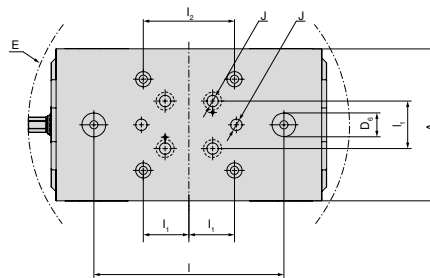
A mm	D ₆ H ₆ mm	I ±0,015 mm	I ₁ ±0,01 mm	I ₂ ±0,02 mm	I ₃ ±0,025 mm	J H ₇ mm
125	25	200	500	100	300	12

Base width 125 mm and length 670 mm,
740 mm



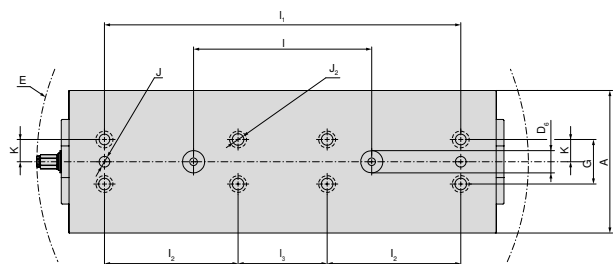
A mm	D ₆ H ₆ mm	K mm	I ±0,015 mm	I ₂ ±0,02 mm	I ₃ ±0,025 mm	I ₁ ±0,01 mm	J H ₇ mm
125	25	100	200	300	500	600	12
125	25	100	200	300	500	700	12

Base width 160 mm and length 280 mm



A mm	D ₆ H ₆ mm	E mm	I ±0,015 mm	I ₁ ±0,015 mm	I ₂ mm	J H ₇ mm
160	25	339	200	50	96	12

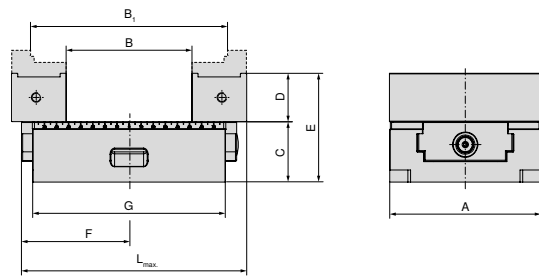
Base width 160 mm and length 480 mm



A mm	D ₆ H ₆ mm	E mm	I ±0,015 mm	I ₁ ±0,015 mm	I ₂ mm	I ₃ ±0,015 mm	J H ₇ mm	J ₂ F ₇ mm	K ±0,02 mm	G mm
160	25	550	200	400	150	100	13	12	25	50

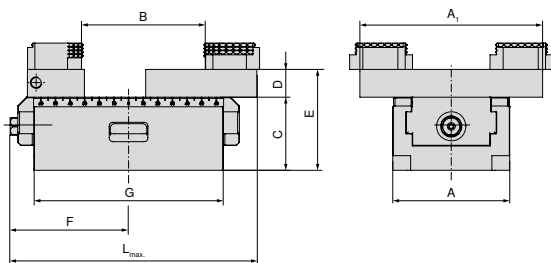
ZSG 4 structural dimension table for the different jaws

With combi jaws



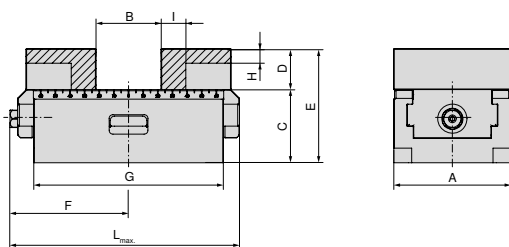
A mm	B mm	B ₁ mm	C mm	D mm	E mm	F mm	G mm	L _{max} mm	Article no. System jaws
125	23 - 103	82 - 161	50	40	90	111,5	160	208	2 x 80878530
125	23 - 165	82 - 223	50	40	90	143,5	235	272	2 x 80878530
125	23 - 241	82 - 300	50	40	90	181	300	348	2 x 80878530

With pendulum and adapter plate



A mm	A ₁ mm	B mm	C mm	D mm	E mm	F mm	G mm	L _{max} mm	Article no. System jaws
80	125	3 - 84	50	28	78	81	130	157	80878890 + 80878870
80	125	3 - 145	50	28	78	104	190	206	80878890 + 80878870
125	180	7 - 126	50	22	90	111,5	160	212	80878590 + 80878570
125	180	7 - 207	50	22	90	143,5	235	272	80878590 + 80878570
125	180	7 - 250	50	22	90	181	300	352	80878590 + 80878570
160	256	16 - 292	70	22	110	170	280	315	80878690 + 80878670
160	256	16 - 406	70	22	110	276	480	524	80878690 + 80878670

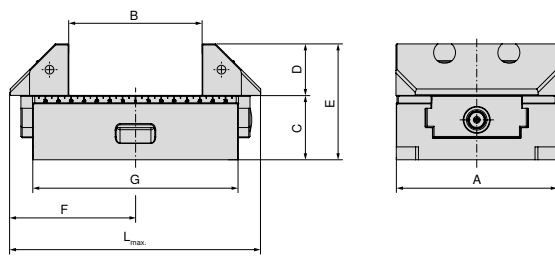
With aluminium jaws



A mm	B mm	C mm	D mm	E mm	F mm	G mm	H mm	I mm	L _{max} mm	Article no. System jaws
80	0 - 44	50	28	78	81	130	10	17	157	2 x 80878850
80	0 - 108	50	28	78	104	190	10	17	206	2 x 80878850
125	0 - 58	50	40	90	111,5	160	17	27	208	2 x 80878550
125	0 - 133	50	40	90	143,5	235	17	27	272	2 x 80878550
125	0 - 198	50	40	90	181	300	17	27	348	2 x 80878550
160	0 - 123	70	50	120	170	280	26	25	315	2 x 80878305
160	10 - 336	70	50	120	276	480	26	25	524	2 x 80878305

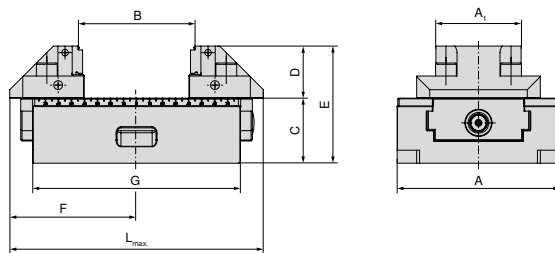
ZSG 4 structural dimension table for the different jaws

With 5-axis jaws



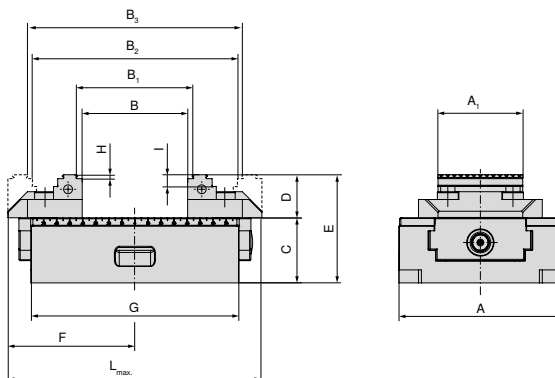
A mm	B mm	C mm	D mm	E mm	F mm	G mm	L _{max} mm	Article no. System jaws
125	22 - 102	50	40	90	115,5	160	208	2 x 80878625
125	22 - 165	50	40	90	143,5	235	272	2 x 80878625
125	22 - 242	50	40	90	181	300	348	2 x 80878625
160	15 - 140	70	50	120	170	280	315	2 x 80878660
160	28 - 354	70	50	120	276	480	524	2 x 80878660

With 5 axis jaws, grip 3 mm, width 65 mm



A mm	A ₁ mm	B mm	C mm	D mm	E mm	F mm	G mm	L _{max} mm	Article no. System jaws
125	65	8 - 87	50	40	90	115,5	160	208	2 x 80878665
125	65	8 - 162	50	40	90	143,5	235	272	2 x 80878665
125	65	8 - 227	50	40	90	181	300	348	2 x 80878665

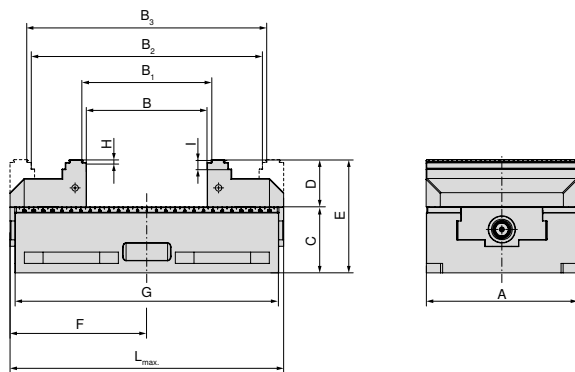
With indexable jaws, grip 3 mm, height 65 mm



A mm	A ₁ mm	B mm	B ₁ mm	B ₂ mm	B ₃ mm	C mm	D mm	E mm	F mm	G mm	H mm	I mm	L _{max} mm	Article no. System jaws
125	65	0 - 80	8 - 87	77 - 156	84 - 163	50	33	83	111,5	160	3	9	208	2 x 8087851900
125	65	0 - 142	8 - 149	77 - 218	84 - 225	50	33	83	143,5	235	3	9	272	2 x 8087851900
125	65	0 - 220	8 - 227	77 - 296	84 - 303	50	33	83	181	300	3	9	348	2 x 8087851900

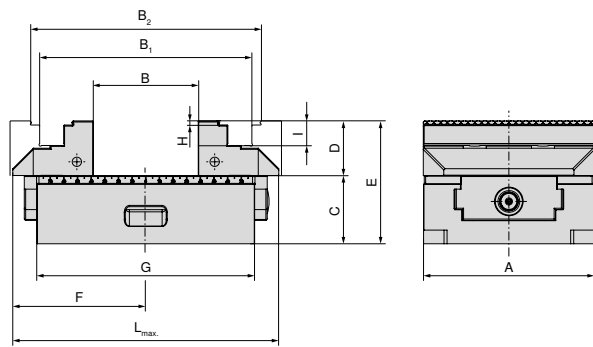
ZSG 4 structural dimension table for the different jaws

With indexable jaws, grip 3 mm



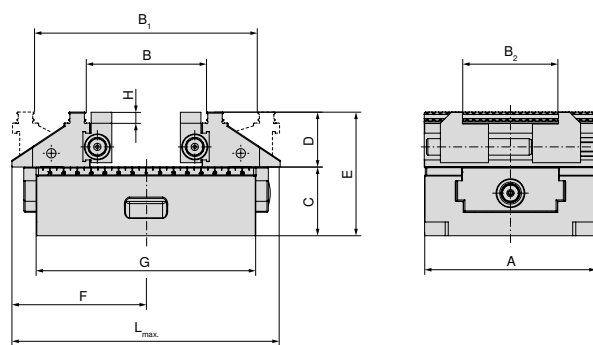
A mm	B mm	B ₁ mm	B ₂ mm	B ₃ mm	C mm	D mm	E mm	F mm	G mm	H mm	I mm	L _{max} mm	Article no. System jaws
160	0 - 127	8 - 134	118 - 244	125 - 251	70	50	120	170	280	3	10	315	2 x 80878610
160	15 - 341	22 - 348	132 - 458	139 - 465	70	50	120	276	480	3	10	524	2 x 80878610

With indexable jaws, grip, height 40 mm



A mm	B mm	B ₁ mm	B ₂ mm	C mm	D mm	E mm	F mm	G mm	H mm	I mm	L _{max} mm	Article no. System jaws
125	0 - 75	75 - 154	88 - 166	50	40	90	111,5	160	3	9	208	2 x 80878520
125	0 - 138	75 - 217	88 - 229	50	40	90	143,5	235	3	9	272	2 x 80878520
125	0 - 215	75 - 294	88 - 306	50	40	90	181	300	3	9	348	2 x 80878520

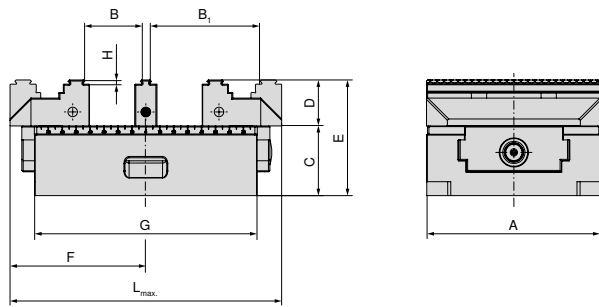
With 6 face jaw system for 125 mm jaw width



A mm	B mm	B ₁ mm	B ₂ mm	C mm	D mm	E mm	F mm	G mm	H mm	L _{max} mm	Article no. System jaws
125	39 - 86	83 - 161	37 - 101	50	40	90	111,5	160	8	209	80878525
125	39 - 149	83 - 224	37 - 101	50	40	90	143,5	235	8	272	80878525
125	39 - 226	83 - 301	37 - 101	50	40	90	181	300	8	349	80878525

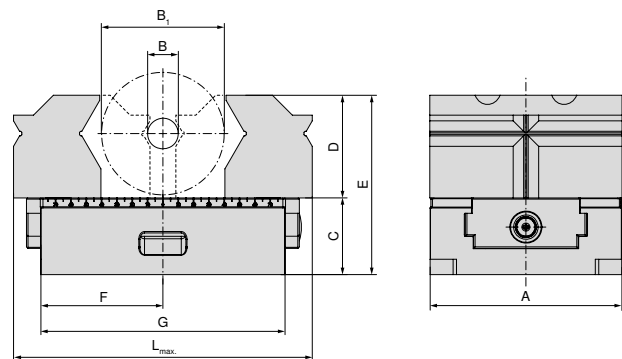
ZSG 4 structural dimension table for the different jaws

With middle jaw, grip 3 mm (height 28 mm / 33 mm) for jaw width 125 mm



A mm	B mm	B ₁ mm	C mm	D mm	E mm	F mm	G mm	H mm	L _{max} mm	Article no. System jaws	
80	8 - 28	37 - 57	50	28	78	81	130	3	157	2 x	80878810 + 8087831200
80	14 - 22	31 - 51	50	28	78	81	130	3	157	2 x	80878810 + 8087833400
80	8 - 58	37 - 87	50	28	78	104	190	3	206	2 x	80878810 + 8087831200
80	14 - 52	31 - 81	50	28	78	104	190	3	206	2 x	80878810 + 8087833400
125	9 - 40	47 - 78	50	33	83	111,5	160	3	208	2 x	80878510 + 8087831300
125	15 - 34	41 - 72	50	33	83	111,5	160	3	208	2 x	80878510 + 8087833500
125	9 - 72	47 - 110	50	33	83	143,5	235	3	272	2 x	80878510 + 8087831300
125	15 - 66	41 - 104	50	33	83	143,5	235	3	272	2 x	80878510 + 8087833500
125	9 - 110	47 - 148	50	33	83	181	300	3	348	2 x	80878510 + 8087831300
125	15 - 104	41 - 142	50	33	83	181	300	3	348	2 x	80878510 + 8087833500

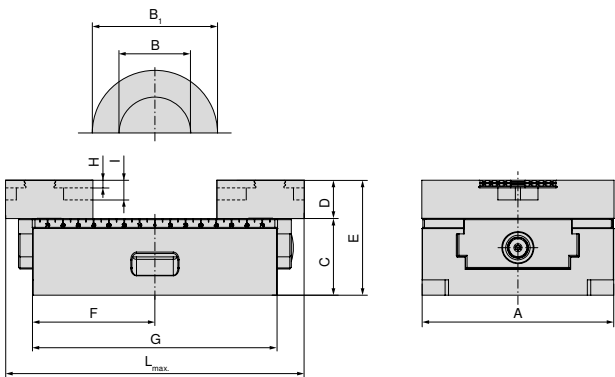
With prism jaw, movable – horizontal and vertical prism



A mm	B mm	B ₁ mm	C mm	D mm	E mm	F mm	G mm	L _{max} mm	Article no. System jaws	
80	10 - 28	20 - 60	50	52	102	81	130	157	2 x	8087831800
80	10 - 28	20 - 60	50	52	102	104	190	206	2 x	8087831800
125	10 - 28	26 - 80	50	67	117	111,5	160	200	2 x	8087831900
125	10 - 28	26 - 80	50	67	117	143,5	235	272	2 x	8087831900
125	10 - 28	26 - 80	50	67	117	181	300	348	2 x	8087831900

ZSG 4 structural dimension table for the different jaws

With prism jaw, movable – horizontal prism



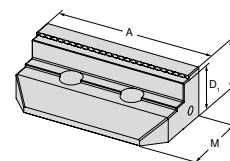
A mm	B mm	B ₁ mm	C mm	D mm	E mm	F mm	G mm	H mm	I mm	L _{max} mm	Article no. System jaws
80	8 - 55	15 - 76	50	25	75	81	130	5	13	157	2 x 8087834000
80	8 - 55	15 - 76	50	25	75	104	190	5	13	206	2 x 8087834000
125	14 - 102	25 - 112	50	25	75	111,5	160	5	13	200	2 x 8087834100
125	14 - 124	25 - 165	50	25	75	143,5	235	5	13	272	2 x 8087834100
125	14 - 124	25 - 165	50	25	75	181	300	5	13	348	2 x 8087834100
160	22 - 158	32 - 170	70	30	100	145	280	5	13	290	2 x 8087834200
160	22 - 158	32 - 170	70	30	100	273	480	5	13	521	2 x 8087834200

System jaws overview

Indexable jaw, grip 3 mm, height 40 mm, movable

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
125	125		40	37			59		

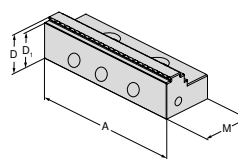


CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80878520							●				

Indexable jaw, grip 3 mm, movable

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
80	80		28	25			40		
125	125		33	30			57		
160	160		50	47			81		

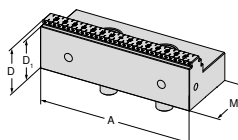


CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80878810				●	●		●		●		
80878510					●		●				
80878610				●	●		●				

Indexable jaw, grip 5 mm, movable

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
80	80		28	23			41		
125	125		33	28			57		
160	160		50	45			81		

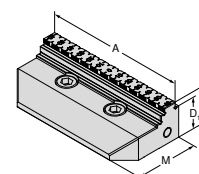


CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8087881400				●			●		●		
8087851400							●				
8087834300				●			●				

Indexable grip jaw, for aluminium and plastic

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
80	80		28	23			40		
125	125		33	28			57		

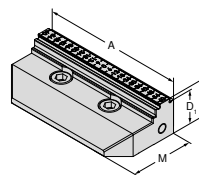


CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8087881500							●				
8087851500							●				

System jaws overview

Indexable jaw with embossed profile, movable

- ▲ Price per piece
- ▲ suitable for LANG embossed profile

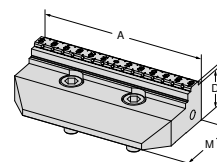


For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
80	80		28	25			40		
125	125		33	30			57		

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8087881800							●				
8087851800							●				

Indexable jaw, carbide, grip 3 mm, movable

- ▲ Price per piece

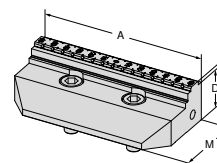


For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
80	80		28	25			40		
125	125		33	30			57		
160	160		50	47			81		

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8087881600							●				
8087851600							●				
8087831700							●				

Indexable jaw, carbide, grip 5 mm, movable

- ▲ Price per piece

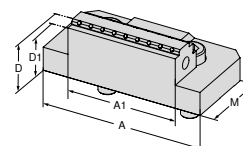


For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
80	80		28	23			40		
125	125		33	28			57		

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8087881700							●				
8087851700							●				

Indexable jaw, carbide grip 3 mm, width 40 mm, movable

- ▲ Price per piece



For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
80	80	40	28	25			40		

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8087833200							●				

System jaws overview

Indexable jaw, carbide grip 3 mm, width 65 mm, movable

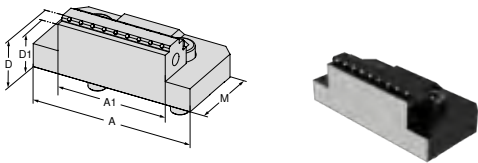
▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
125	125	65	33	30			57		

CW

8087833300

NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
						●				



Indexable jaw, smooth, movable

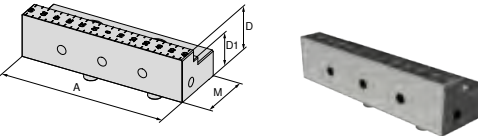
▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
80	80		28	20			40		
125	125		33	25			57		

CW

8087834700
8087834600

NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
				●		●				
				●		●				



Stepped jaw, smooth, movable

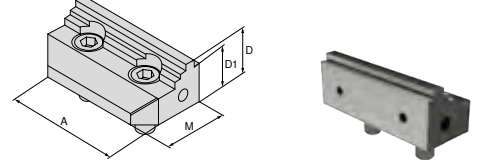
▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
80	80		28	24			40		
125	125		33	27			57		

CW

8087834400
8087834500

NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
						●				
						●				



Centre jaw, grip 3 mm, narrow

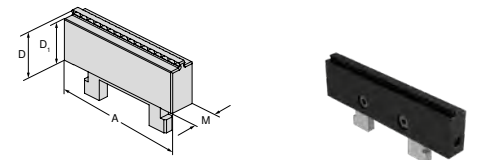
▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
80	80		28	25			16		
125	125		33	30			16		

CW

8087831200
8087831300

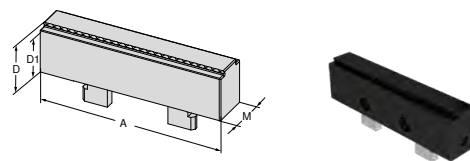
NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
						●				
						●				



System jaws overview

Centre jaw, grip 3 mm, wide

▲ Price per piece

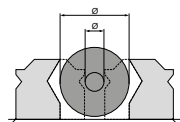
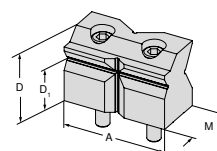


										CW	NCG	HSG / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG	
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂													
80	80		28	25			24															
125	125		33	30			26			8087833400							●					
										8087833500							●					

Prism jaw, movable

▲ With horizontal and vertical prism

▲ Price per piece

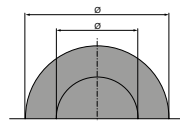
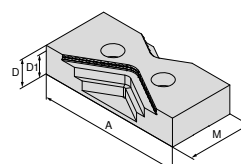


										CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG	
For clamping diameter	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂													
10 - 60	80		52	32			38,5			80 878 31800							●					
10 - 80	125		67	42			57			80 878 31900							●					

Prism jaw, movable

▲ With horizontal prism

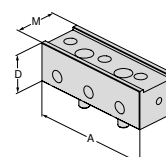
▲ Price per piece



For clamping diameter										CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂													
15 - 75	80		25	20		40			80 878 34000								●				
25 - 110	125		25	20		57			80 878 34100								●				
30 - 170	160		30	25		81			80 878 34200								●				

Combi jaw, movable

▲ Price per piece

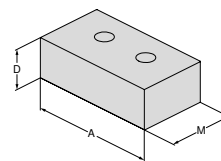


For vice width										CW													
125	125		40				45.5			80878530	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG		

System jaws overview

Alu jaw, movable

- ▲ for producing shaped jaws
- ▲ Price per piece

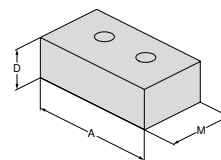


For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
80	80		28				48		
125	125		40				68		
160	160		50				85		

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80878850				●	●		●		●		
80878550				●					●		
80878305				●	●		●				

Soft jaw, steel, movable

- ▲ Material: 16MnCr5
- ▲ for producing shaped jaws
- ▲ Price per piece

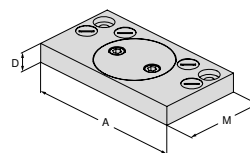


For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
80	80		28				48		
125	125		40				68		

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8087832000				●	●		●				
8087832100				●	●		●				

Pendulum jaw, movable

- ▲ to accommodate 6-way reversible jaws
- ▲ Price per piece

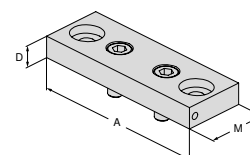


For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
80	125		19				76		
125	180		22				95		
160	256		22				170		

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80878870				●			●		●		
80878570				●			●				
80878670				●			●				

Adapter Jaw

- ▲ to accommodate 6-way reversible jaws
- ▲ Price per piece



For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
80	125		19				39		
125	180		22				62		
160	256		22				125		

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80878890							●				
80878590							●				
80878690							●				

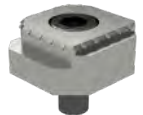
6 function indexable jaw

-
- Technical drawing of a square nut. The drawing shows a perspective view of a square nut with a central threaded hole. The thread is labeled "DRVS 10". A dimension line indicates the width of the nut, labeled "D".



6x indexable jaw, carbide grip

-



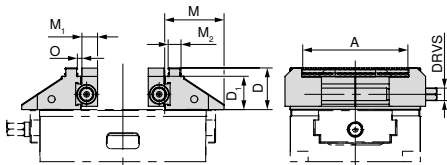
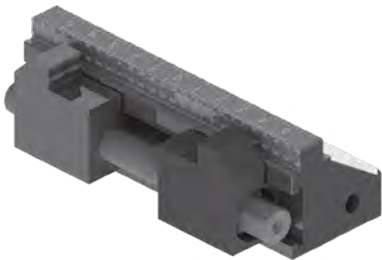
For vice width										CW		NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂			●	●	●	●			●		●	●		
18										8089035300												

System jaws overview

CoreLine – 6 face jaw system for 125 mm jaw width

Scope of supply:
2 System jaws with 2 pairs of transverse jaws in T-slot guidance incl. fixing screws

ZSG
4



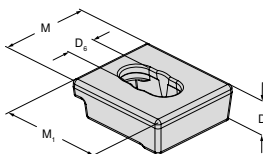
for width mm	A mm	D mm	D ₁ mm	M mm	M ₁ mm	M ₂ mm	O mm	DRVS mm	WT kg
125	37 - 101	40	32	57	15	12,4	3,3	12	3,8

CW
80 878 ...
525

System accessories overview

Clamping claws

▲ Price for 2 pieces



D	D ₆	M	M ₁
mm	mm	mm	mm
20	16	50	57

CW
80 890 ...
315

Torque Wrench

▲ without socket

- ESG
4
- ESG
mini
- HDG
2
- ZSG
4
- ZSG
mini
- DSG
4
- X5G
-Z



TQX
Nm
20 - 100
40 - 200

AS
80 884 ...
502
504

System accessories overview

Clamping Handle with Joint

▲ without socket

- H5G
-Z
- H5G
-Z-S
- ESG
4
- ESG
mini
- ZSG
4



Square	CW	
	80 891 ...	
	1/2"	600

Clamping screw and T-Nuts

▲ For mounting the clamping claw
▲ Price per 2 pieces

Scope of supply:
Incl. washers

- NCG
- H5G
- ESG
4
- HDG
2
- ZSG
4
- DSG
4
- Verso



for slot width	G	
	mm	
12	M10	CW
14	M12	
16	M14	
18	M16	
		80 890 ...
		308
		309
		310
		311

System accessories overview

Clamping Screw Set for T-slot for MNG

▲ Price for 2 pieces

ESG
4

ZSG
4

DSG
4



for width mm	G	CW	
12	M10	80 899 ...	312 ¹⁾
14	M12		314
16	M12		316
18	M12		318

1) Version with washers

Socket

▲ Suitable for 1/2" or 3/8" square drive

ESG
4

ZSG
4

DSG
4



DRVS mm	AS	
12	80 875 ...	212
14		214

System accessories overview

Dowel screw

▲ Price for 2 pieces

- H5G
- ESG
4
- ZSG
4
- DSG
4
- MNG
- X5G
-Z



for width mm	G	J mm
125	M12x45	12

CW

80 895 ...

019

ZSG mini



Centric vice for small parts

ZSG mini in mechanical version with high clamping force and quick change jaws. Ideal for blank and finished part machining, multi-clamping and automation.

Your benefits:

- ▲ Fast jaw changeover without tools
- ▲ Compact and precise
- ▲ Optimum accessibility from all sides
- ▲ Exchangeable jaw widths (45 mm and 70 mm)
- ▲ High clamping force and large clamping range
- ▲ Clamping system for automation
- ▲ Stainless, hardened base body



Clamping/aligning:



Clamping with two M6 screws from above through the base body.



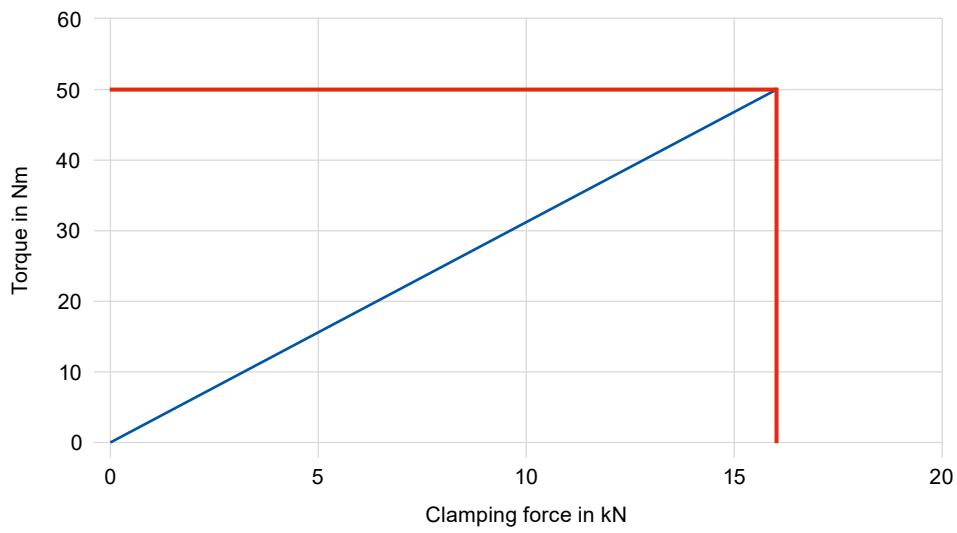
Clamping with two M6 screws from above through the base body. Alignment can be performed using $\varnothing 12^{H7}$ precision holes.



Both versions come with mounting holes for the LANG zero point clamping system, Quick Point 52 x 52.

Clamping force:

ZSG mini tightening torque/clamping force



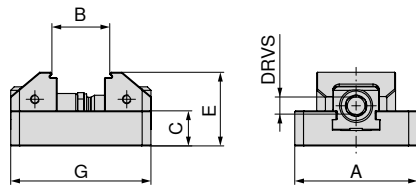
CoreLine – Centric vice for small parts without system jaws – ZSG mini

- ▲ Fast jaw changeover without tools
- ▲ Compact and precise
- ▲ Optimum accessibility from all sides
- ▲ Exchangeable jaw widths (45 mm and 70 mm)
- ▲ Stainless, hardened base body

Scope of supply:

ZSG mini base body with spindle

ZSG mini	MNG mini	52 x 52
---------------------	---------------------	----------------



A mm	B mm	C mm	E mm	G mm	MXC kN	DRVS mm	WT kg
70	7 - 57	20	42	80	16	11	0,9
70	7 - 77	20	42	100	16	11	1,1

CW

80 912 ...

07000

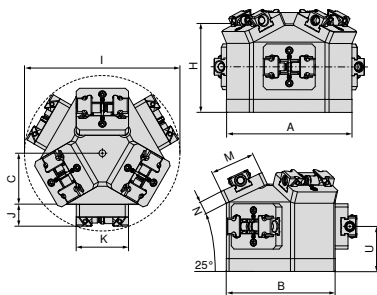
07100

CoreLine – 6-sided clamping tower – ZSG mini

Scope of supply:

6-sided clamping tower incl. ZSG mini L-80 mm without system jaws

**ZSG
mini**



A mm	B mm	C mm	H mm	I mm	J mm	K mm	M mm	N mm	U mm	WT kg
193,24	169,40	78	135,7	236	33,7	80	70,4	20	70	13,5

CW

80 912 ...

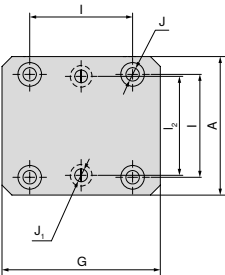
55000

Vice guide

→ Underside Dimensions	→ Workpiece location
→ Structural dimension tables for the different jaws	→ General accessories
→ System accessories	→ Clamping lever
→ MNG-/PNG zero point clamping system	→ Screws
→ General top jaws	

ZSG mini underside dimensions

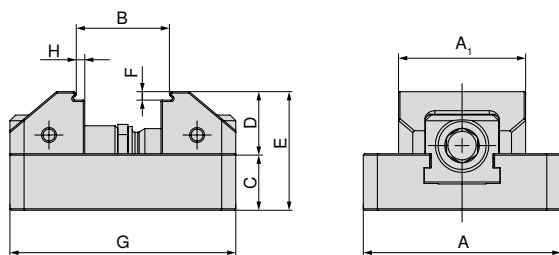
Base width 70 mm



A mm	J ₁ mm	J _{H7} mm	I ₂ ±0,01 mm	I ±0,01 mm	G mm
70	6,5	12	50	52	80
70	6,5	12	50	52	100

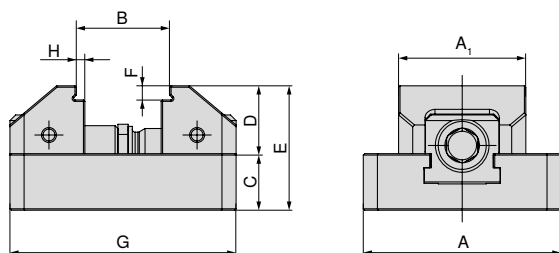
ZSG Mini – structural dimension table for the different jaws

With quick change jaw, grip 3 mm



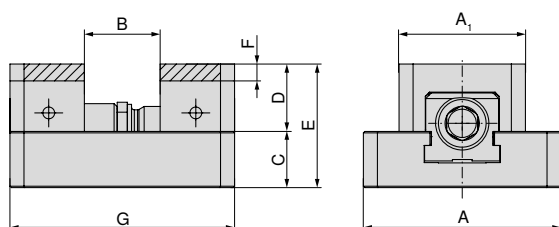
A mm	A ₁ mm	B mm	C mm	D mm	E mm	F mm	G mm	H mm	Article no. System jaws
70	45	7 - 33	20	22	42	3	80	3	2 x 8091230100
70	70	7 - 33	20	22	42	3	80	3	2 x 8091230200
70	45	7 - 53	20	22	42	3	100	3	2 x 8091230100
70	70	7 - 53	20	22	42	3	100	3	2 x 8091230200

With quick change jaw, smooth step 5 mm



A mm	A ₁ mm	B mm	C mm	D mm	E mm	F mm	G mm	H mm	Article no. System jaws
70	45	7 - 33	20	24	44	5	80	3	2 x 8091230300
70	70	7 - 33	20	24	44	5	80	3	2 x 8091230400
70	45	7 - 53	20	24	44	5	100	3	2 x 8091230300
70	70	7 - 53	20	24	44	5	100	3	2 x 8091230400

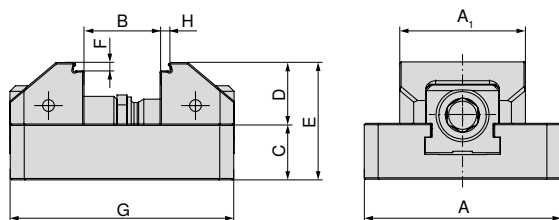
With quick change jaw, soft, steel



A mm	A ₁ mm	B mm	C mm	D mm	E mm	F mm	G mm	Article no. System jaws
70	45	0 - 26	20	24	44	6	80	2 x 8091231000
70	70	0 - 26	20	24	44	6	80	2 x 8091231100
70	45	0 - 46	20	24	44	6	80	2 x 8091231000
70	70	0 - 46	20	24	44	6	80	2 x 8091231100

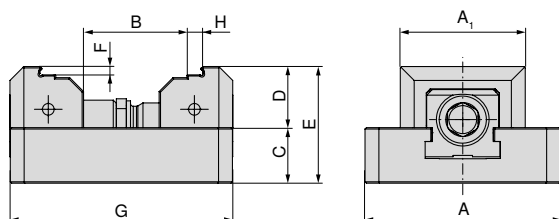
ZSG Mini – structural dimension table for the different jaws

With quick change jaw embossed profile



A mm	A ₁ mm	B mm	C mm	D mm	E mm	F mm	G mm	H mm	Article no. System jaws
70	45	7 - 32	20	22	44	3	80	3	2 x 8091231200
70	70	7 - 32	20	22	44	3	80	3	2 x 8091231300
70	45	7 - 52	20	22	44	3	100	3	2 x 8091231200
70	70	7 - 52	20	22	44	3	100	3	2 x 8091231300

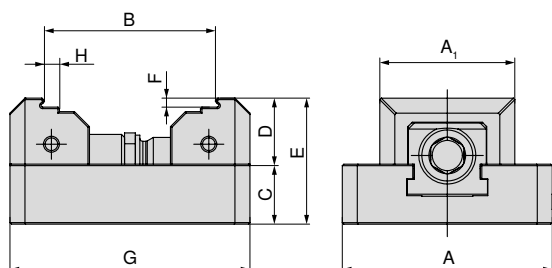
With quick change jaw embossed profile, VS



A mm	A ₁ mm	B mm	C mm	D mm	E mm	F mm	G mm	H mm	Article no. System jaws
70	45	31 - 56	20	22	44	3	80	5	2 x 8091231400
70	70	31 - 56	20	22	44	3	80	5	2 x 8091231500
70	45	31 - 76	20	22	44	3	100	5	2 x 8091231400
70	70	31 - 76	20	22	44	3	100	5	2 x 8091231500

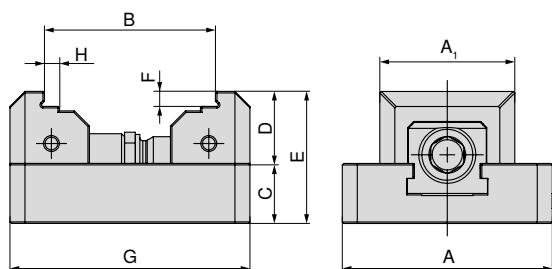
ZSG Mini – structural dimension table for the different jaws

With quick change jaw, VS, grip 3 mm



A mm	A ₁ mm	B mm	C mm	D mm	E mm	F mm	G mm	H mm	Article no. System jaws
70	45	31 - 57	20	22	42	3	80	5	2 x 8091230500
70	70	31 - 57	20	22	42	3	80	5	2 x 8091230600
70	45	31 - 77	20	22	42	3	100	5	2 x 8091230500
70	70	31 - 77	20	22	42	3	100	5	2 x 8091230600

With quick change jaw, VS, smooth 5 mm

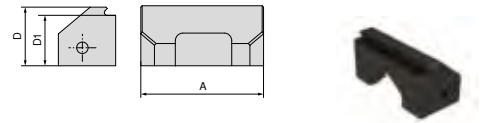


A mm	A ₁ mm	B mm	C mm	D mm	E mm	F mm	G mm	H mm	Article no. System jaws
70	45	31 - 56	20	24	44	5	80	5	2 x 8091230700
70	70	31 - 56	20	24	44	5	80	5	2 x 8091230800
70	45	31 - 76	20	24	44	5	100	5	2 x 8091230700
70	70	31 - 76	20	24	44	5	100	5	2 x 8091230800

System jaws overview

Quick change jaw, grip 3 mm

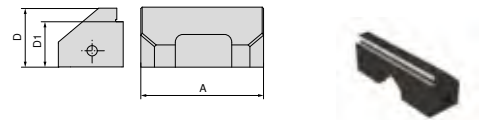
▲ Price per piece



For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
70	45		22	19						8091230100								●			
70	70		22	19						8091230200								●			

Quick change jaw, smooth step 5 mm

▲ Price per piece

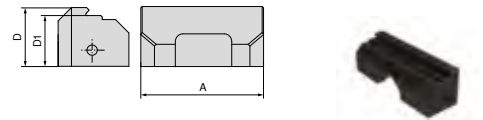


For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
70	45		24	19						8091230300								●			
70	70		24	19						8091230400								●			

Quick change jaw, VS, grip 3 mm

▲ Price per piece

▲ VS = Larger clamping range

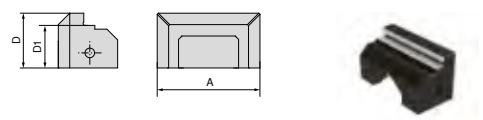


For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
70	45		22	19						8091230500								●			
70	70		22	19						8091230600								●			

Quick change jaw, VS, smooth 5 mm

▲ Price per piece

▲ VS = Larger clamping range



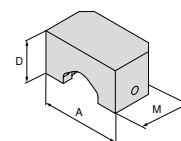
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
70	45		24	19						8091230700								●			
70	70		24	19						8091230800								●			

System jaws overview

Quick change jaw, soft, steel

▲ Material: 15NiCr13

▲ Price per piece

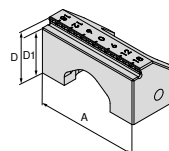


For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
70	45		24				26,5			8091231000								●			
70	70		24				26,5			8091231100								●			

Quick change jaw embossed profile

▲ Price per piece

▲ suitable for LANG embossed profile



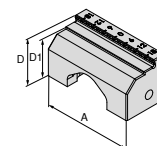
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
70	45		22	19						8091231200								●			
70	70		22	19						8091231300								●			

Quick change jaw embossed profile, VS

▲ Price per piece

▲ Suitable for LANG embossed profile

▲ VS = Larger clamping range



For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
70	45		22	19						8091231400								●			
70	70		22	19						8091231500								●			

System accessories overview

Socket

▲ Suitable for 3/8" square drive

ZSG
mini



Square	DRVS mm	AS
3/8"	11	80 875 ... 11100



→ Here you will find the suitable „magnetic workpiece stop“ and „torque key“ (article numbers **80 892 23800** and **80 884 402**).

Torque key

▲ without socket

ZSG
miniMSG
2VersoMNG



TQX Nm	Square	AS
10 - 50	3/8"	80 884 ... 402

System accessories overview

Allen cap screw

▲ Price per piece

ZSG
mini



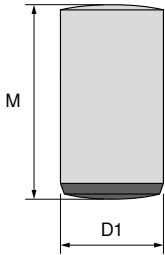
G
M6x25

CW
80 912 ...
50100

Cylindrical pin

▲ Price per piece

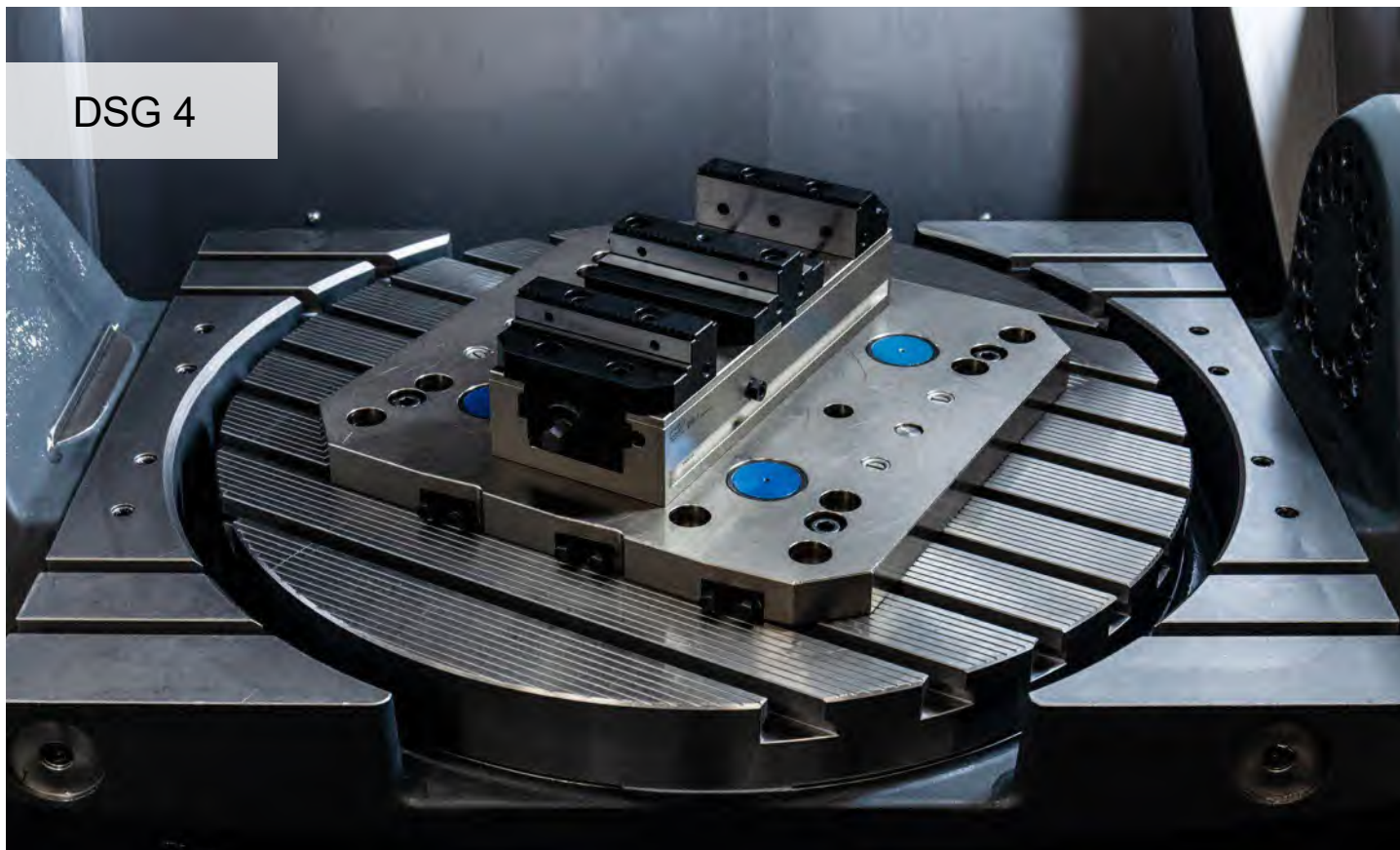
ZSG
mini



D1 m6 mm	M mm
12	18

CW
80 912 ...
50200

DSG 4



High accuracy and efficiency

The user-friendly DSG 4 clamping system guarantees consistently high precision and a wide application range.

Your benefits:

- ▲ Straightforward, stable third-hand function
- ▲ Quick and easy positioning on the MNG zero point clamping system
- ▲ High clamping force between 5 – 40 kN with low tightening torque
- ▲ Quick and easy jaw change with 2 screws
- ▲ Extensive modular jaw range

Clamping/aligning:



Mounting with MNG zero point clamping system (2-3 mounting bolts)



Mounting through the base body with four M8 screws



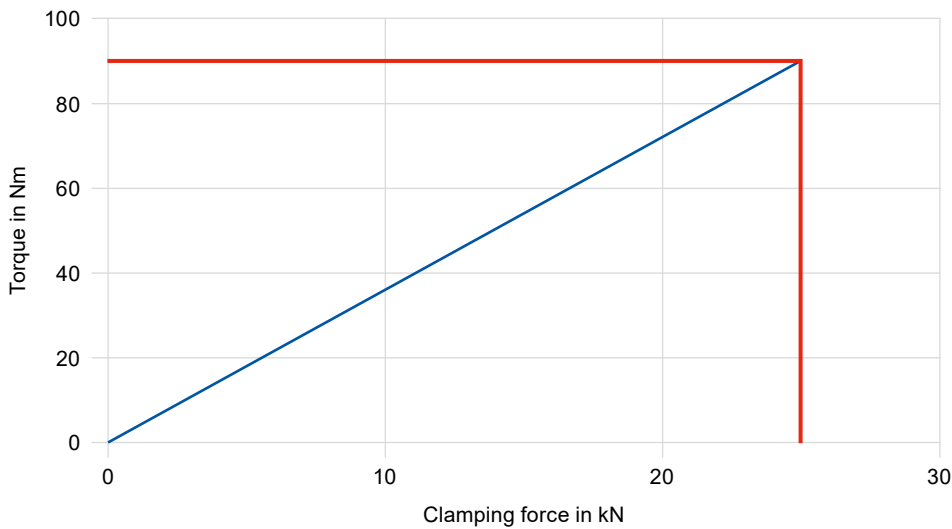
Mounting through the base body with two dowel screws **Article no. 80 895 019**



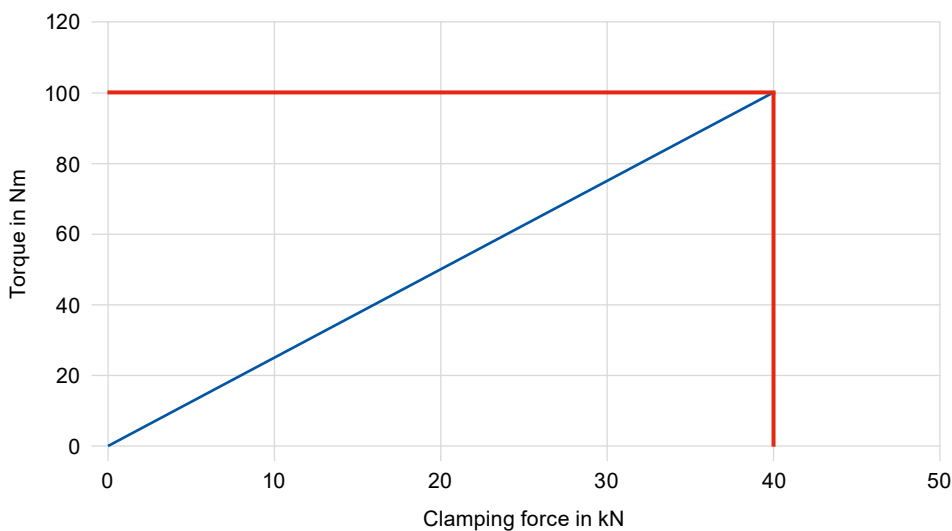
Mounting with 4-6 clamping claws **Article no. 80 890 315**

Clamping force:

DSG 4 – 80 mm tightening torque / clamping force



DSG 4 – 125 mm tightening torque / clamping force



'Third hand' operation

The third-hand operation function on the DSG 4 is ensured by pre-loading the rear slide with compression springs.



The lateral clamping screw A is not tightened, instead it is open approx. 1/2 turn. When the vice is fully open, the movable jaws B and C are to be placed in the appropriate slots of slides D and E and secured according to the workpiece size. Two workpieces of different sizes can also be clamped.

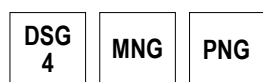
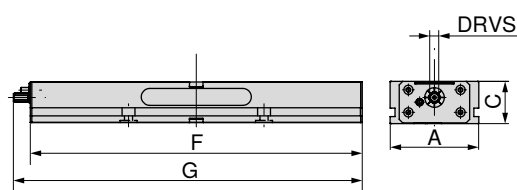
Conversion to single vice



The rear slide is blocked via the hexagon socket grub screw and the DSG 4 can also be used as a single vice. **Important note:** Not suitable for using several vices as single vice next to one another. In this case, we advise modification with additional transverse slot in the base body and suitable fixed jaw.

CoreLine – double vice without system jaws – DSG 4

- ▲ 100 % encapsulated
- ▲ fast assembly and disassembly
- ▲ flexible clamping system



A mm	C mm	F mm	G mm	TQX Nm	DRVS mm	MXC kN	WT kg
80	55	300	308	90	12	0 - 25	8
125	60	320	347	100	14	0 - 40	14
125	60	390	417	100	14	0 - 40	17
125	60	460	487	100	14	0 - 40	20
125	60	530	557	100	14	0 - 40	24
125	60	600	627	100	14	0 - 40	27
125	60	670	697	100	14	0 - 40	30
125	60	740	767	100	14	0 - 40	34

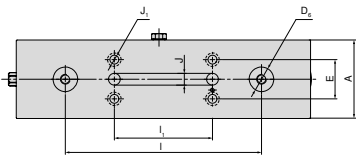
CW
80 906 ...
080
125
12700
12800
12900
13000
13100
126

Vice guide

→ Underside Dimensions	→ General top jaws
→ Structural dimension tables for the different jaws	→ Workpiece location
→ System jaws	→ General accessories
→ 'Third hand' operation	→ Clamping lever
→ Conversion to single vice	→ Screws
→ MNG-/PNG zero point clamping system	

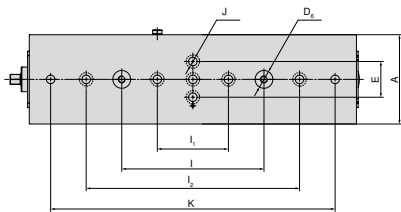
DSG 4 underside dimensions

Base width 80 mm and length 300 mm



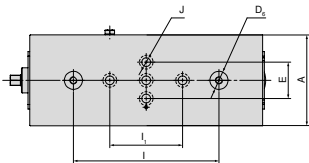
A mm	D ₆ H ₆ mm	E ±0.015 mm	I ±0.01 mm	I ₁ ±0.01 mm	J H ₇ mm	J ₁ mm
80	25	40	200	100	12	9

Base width 125 mm and length 460 mm,
530 mm



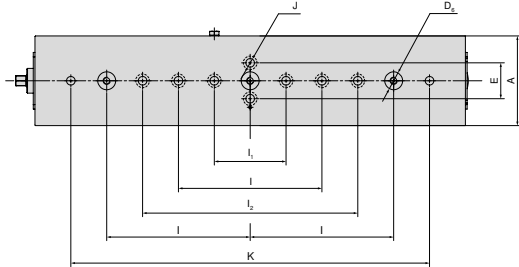
A mm	D ₆ H ₆ mm	E ±0.015 mm	I ±0.01 mm	I ₁ ±0.01 mm	I ₂ ±0.002 mm	J H ₇ mm	K ±0.002 mm
125	25	50	200	100	300	12	400
125	25	50	200	100	300	12	500

Base width 125 mm and length 320 mm



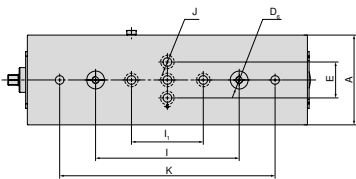
A mm	D ₆ H ₆ mm	E ±0.015 mm	I ±0.01 mm	I ₁ ±0.01 mm	J H ₇ mm
125	25	50	200	100	12

Base width 125 mm and length 600 mm



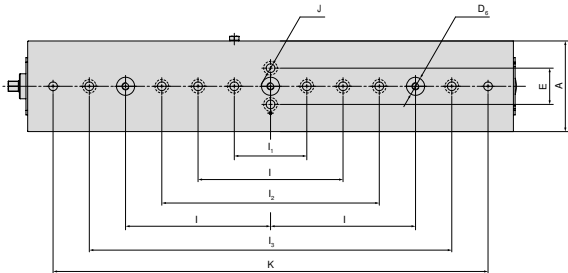
A mm	D ₆ H ₆ mm	E ±0.015 mm	I ±0.01 mm	I ₁ ±0.01 mm	I ₂ ±0.002 mm	J H ₇ mm	K ±0.002 mm
125	25	50	200	100	300	12	500

Base width 125 mm and length 390 mm



A mm	D ₆ H ₆ mm	E ±0.015 mm	I ±0.01 mm	I ₁ ±0.01 mm	J H ₇ mm	K ±0.002 mm
125	25	50	200	100	12	300

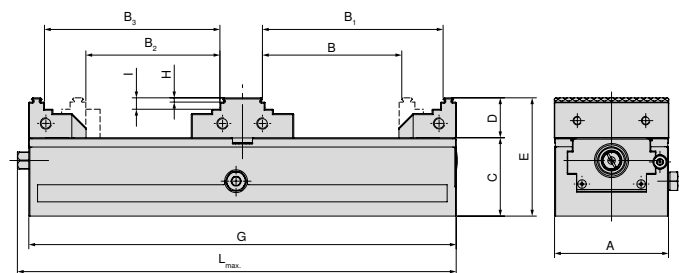
Base width 125 mm and length 670 mm,
740 mm



A mm	D ₆ H ₆ mm	E ±0.015 mm	I ±0.01 mm	I ₁ ±0.01 mm	I ₂ ±0.002 mm	I ₃ ±0.025 mm	J H ₇ mm	K ±0.002 mm
125	25	50	200	100	300	500	12	600
125	25	50	200	100	300	500	12	700

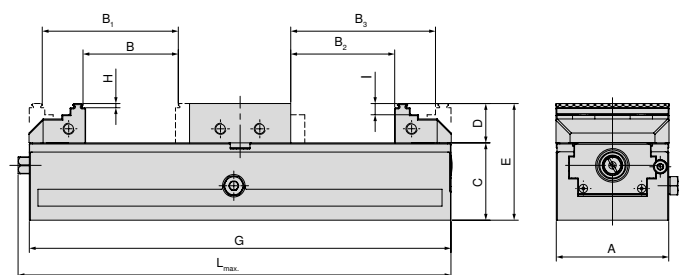
DSG 4 structural dimension table for the different jaws

With indexable jaws, grip and centre jaw, grip



A mm	B mm	B ₁ mm	B ₂ mm	B ₃	C mm	D mm	E mm	G mm	H mm	I mm	Lmax. mm	Article no. System jaws	
80	25 - 97	54 - 126	31 - 93	51 - 122	55	28	83	300	3	8	308	2 x	80878810 + 80906300
125	40 - 86	75 - 121	42 - 79	68 - 114	60	40	100	320	3	18	347	2 x	80901303 + 80906304
125	40 - 121	75 - 156	42 - 114	68 - 149	60	40	100	390	3	18	417	2 x	80901303 + 80906304
125	40 - 156	75 - 191	42 - 149	68 - 184	60	40	100	460	3	18	487	2 x	80901303 + 80906304
125	40 - 191	75 - 226	42 - 184	68 - 219	60	40	100	530	3	18	557	2 x	80901303 + 80906304
125	40 - 226	75 - 261	42 - 219	68 - 254	60	40	100	600	3	18	627	2 x	80901303 + 80906304
125	40 - 261	75 - 296	42 - 254	68 - 289	60	40	100	670	3	18	697	2 x	80901303 + 80906304
125	40 - 296	75 - 331	42 - 289	68 - 324	60	40	100	740	3	18	767	2 x	80901303 + 80906304

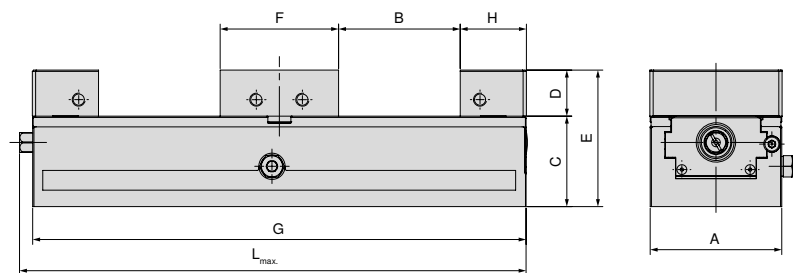
With indexable jaws, grip and centre jaw, smooth



A mm	B mm	B ₁ mm	B ₂ mm	B ₃	C mm	D mm	E mm	G mm	H mm	I mm	Lmax. mm	Article no. System jaws	
80	5 - 67	34 - 96	0 - 73	40 - 102	55	28	83	300	3	8	308	2 x	80878810 + 80906301
125	7 - 44	42 - 77	0 - 47	46 - 82	60	40	100	320	3	18	347	2 x	80901303 + 80906305
125	7 - 79	42 - 112	0 - 82	46 - 117	60	40	100	390	3	18	417	2 x	80901303 + 80906305
125	7 - 114	42 - 149	0 - 117	46 - 152	60	40	100	460	3	18	487	2 x	80901303 + 80906305
125	7 - 147	42 - 182	0 - 152	46 - 187	60	40	100	530	3	18	557	2 x	80901303 + 80906305
125	7 - 184	42 - 217	0 - 187	46 - 222	60	40	100	600	3	18	627	2 x	80901303 + 80906305
125	7 - 219	42 - 252	0 - 222	46 - 257	60	40	100	670	3	18	697	2 x	80901303 + 80906305
125	7 - 254	42 - 287	0 - 257	46 - 292	60	40	100	740	3	18	767	2 x	80901303 + 80906305

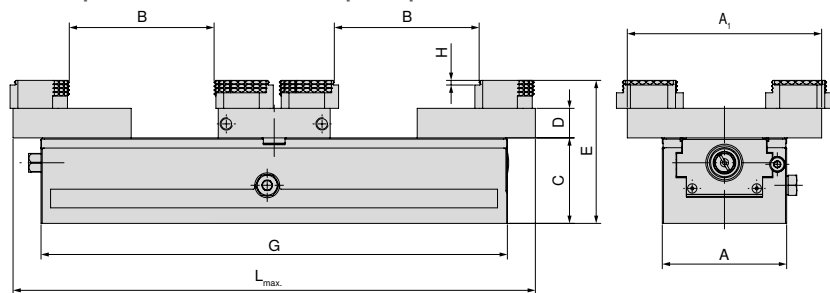
DSG 4 structural dimension table for the different jaws

With block jaws and centre jaw smooth



A mm	B mm	C mm	D mm	E mm	F mm	G mm	H mm	Lmax. mm	Article no. System jaws	
80	0 - 73	55	28	83	72	300	40	308	2 x	8090131300 + 80906301
125	0 - 46	60	40	100	98	320	66	347	2 x	8090131500 + 80906305
125	0 - 81	60	40	100	98	390	66	417	2 x	8090131500 + 80906305
125	0 - 116	60	40	100	98	460	66	487	2 x	8090131500 + 80906305
125	0 - 151	60	40	100	98	530	66	557	2 x	8090131500 + 80906305
125	0 - 186	60	40	100	98	600	66	627	2 x	8090131500 + 80906305
125	0 - 221	60	40	100	98	670	66	697	2 x	8090131500 + 80906305
125	0 - 256	60	40	100	98	740	66	767	2 x	8090131500 + 80906305

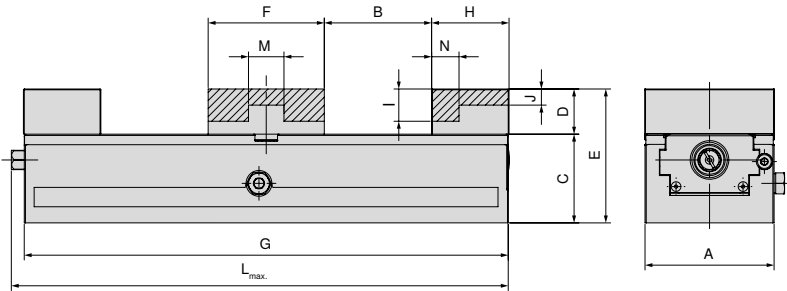
With pendulum and adapter plate



A mm	A ₁ mm	B mm	C mm	D mm	E mm	G mm	H mm	Lmax. mm	Article no. System jaws	
80	125	0 - 92	55	19	92	300	3	308	2 x	80878870 + 80906303
125	180	7 - 92	60	22	100	320	3	365	2 x	80878570 + 80906307
125	180	7 - 133	60	22	100	390	3	435	2 x	80878570 + 80906307
125	180	7 - 168	60	22	100	460	3	505	2 x	80878570 + 80906307
125	180	7 - 203	60	22	100	530	3	575	2 x	80878570 + 80906307
125	180	7 - 238	60	22	100	600	3	645	2 x	80878570 + 80906307
125	180	7 - 273	60	22	100	670	3	715	2 x	80878570 + 80906307
125	180	7 - 308	60	22	100	740	3	785	2 x	80878570 + 80906307

DSG 4 structural dimension table for the different jaws

With aluminium jaws and aluminium centre jaw



A mm	B mm	C mm	D mm	E mm	F mm	G mm	H mm	I mm	J mm	Lmax. mm	M mm	N mm	Article no. System jaws	
80	0 - 66	55	28	83	72	300	40	20	10	308	22	17	2 x	80878850 + 80906302
125	0 - 42	60	40	100	98	320	68		17	347	38	28	2 x	80878550 + 80906306
125	0 - 77	60	40	100	98	390	68		17	417	38	28	2 x	80878550 + 80906306
125	0 - 112	60	40	100	98	460	68		17	487	38	28	2 x	80878550 + 80906306
125	0 - 147	60	40	100	98	530	68		17	557	38	28	2 x	80878550 + 80906306
125	0 - 182	60	40	100	98	600	68		17	627	38	28	2 x	80878550 + 80906306
125	0 - 217	60	40	100	98	670	68		17	697	38	28	2 x	80878550 + 80906306
125	0 - 252	60	40	100	98	740	68		17	767	38	28	2 x	80878550 + 80906306

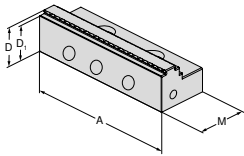
System jaws overview

Indexable jaw, grip 3 mm, movable

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
125	125		40	37			66		

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80901303				●	●				●		

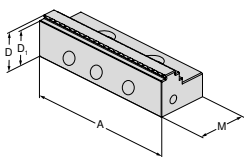


Indexable jaw, grip 3 mm, movable

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
80	80		28	25			40		

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80878810				●	●		●		●		

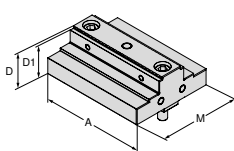


Centre jaw, grip

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
80	80		28	25			72		
125	125		40	37			98		

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80906300									●		
80906304									●		

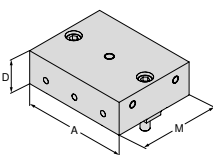


Centre jaw, smooth

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
80	80		28				72		
125	125		40				98		

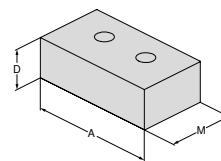
CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80906301									●		
80906305									●		



System jaws overview

Alu jaw, movable

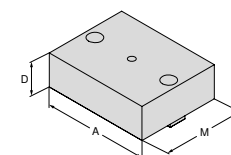
- ▲ for producing shaped jaws
- ▲ Price per piece



For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80	80		28				48			80878850				●	●		●		●		
125	125		40				68			80878550				●					●		

Centre jaw, Alu

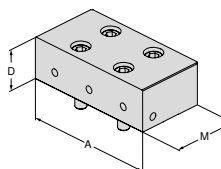
- ▲ for producing shaped jaws
- ▲ Price per piece



For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80	80		28				72			80906302									●		
125	125		40				98			80906306									●		

Block jaw, movable

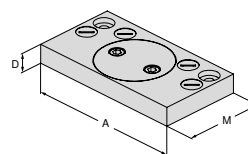
- ▲ Price per piece



For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80	80		28				40			8090131300				●	●		●		●		
125	125		40				66			8090131500				●					●		

Pendulum jaw, movable

- ▲ to accommodate 6-way reversible jaws
- ▲ Price per piece

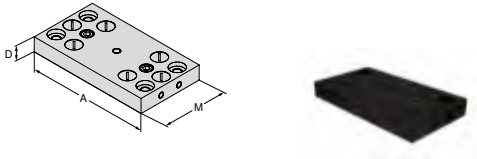


For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80	125		19				76			80878870				●			●		●		
125	180		22				95			80878570				●			●		●		

System jaws overview

Centre jaw adapter plate, fixed

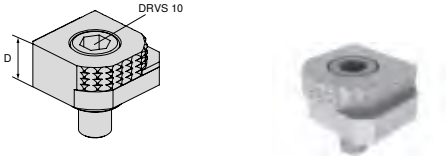
- ▲ to accommodate 6-way reversible jaws
- ▲ Price per piece



For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80	125		19				72			80906303									●		
125	180		22				98			80906307									●		

6 function indexable jaw

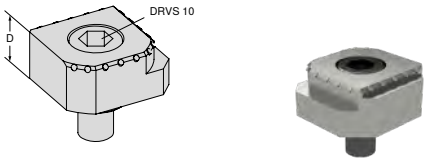
- ▲ 1 = Smooth, carbide coated
- ▲ 2 = Grip with 3 mm step
- ▲ 3 = Grip with 8 mm step
- ▲ 4 = Grip with 18 mm step
- ▲ 5 = Rough grip with 8 mm step
- ▲ 6 = Round grip
- ▲ M_{max} = 60 Nm
- ▲ Including fixation screws



For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
			18							80892246	●	●	●	●			●		●	●	

6x indexable jaw, carbide grip

- ▲ 1 = Smooth
- ▲ 2 = Carbide grip
- ▲ 3 = Carbide grip with 3 mm step
- ▲ 4 = Carbide grip with 8 mm step
- ▲ 5 = Round carbide grip with 8 mm step
- ▲ 6 = Round carbide grip
- ▲ Incl. fixing screws



For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
			18							8089035300	●	●	●	●			●		●	●	

System accessories overview

Plastic protection plugs

DSG
4



G

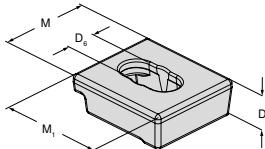
M10x12

CW

80 906 ...
500

Clamping claws

▲ Price for 2 pieces



D	D _s	M	M ₁
mm	mm	mm	mm
20	16	50	57

CW

80 890 ...
315

System accessories overview

Torque Wrench

▲ without socket

- ESG
4
- ESG
mini
- HDG
2
- ZSG
4
- ZSG
mini
- DSG
4



TQX
Nm

20 - 100

AS

80 884 ...

502

Clamping Screw Set for T-slot for MNG

▲ Price for 2 pieces

- ESG
4
- ZSG
4
- DSG
4



for width mm	G
12	M10
14	M12
16	M12
18	M12

CW

80 899 ...

312 ¹⁾

314

316

318

1) Version with washers

System accessories overview

Clamping screw and T-Nuts

- ▲ For mounting the clamping claw
- ▲ Price per 2 pieces

Scope of supply:
Incl. washers

NCG	H5G	ESG 4	HDG 2	ZSG 4	DSG 4	Verso
-----	-----	----------	----------	----------	----------	-------



for slot width		G		CW	
mm				80 890 ...	
12		M10			308
14		M12			309
16		M14			310
18		M16			311

Socket

- ▲ Suitable for 1/2" or 3/8" square drive

ESG 4	ZSG 4	DSG 4
----------	----------	----------



DRVS		AS	
mm		80 875 ...	
12			212
14			214

System accessories overview

Dowel screws

▲ Price for 2 pieces

NCG

ESG
4



for width mm	G	J mm
100	M12x38	12

CW

80 890 ...

313

Alignment and centering kit for T-slots

▲ Price per piece

H5G
-Z

ESG
4

DSG
4



I mm	for slot width mm
100	14
100	16
100	18

CW

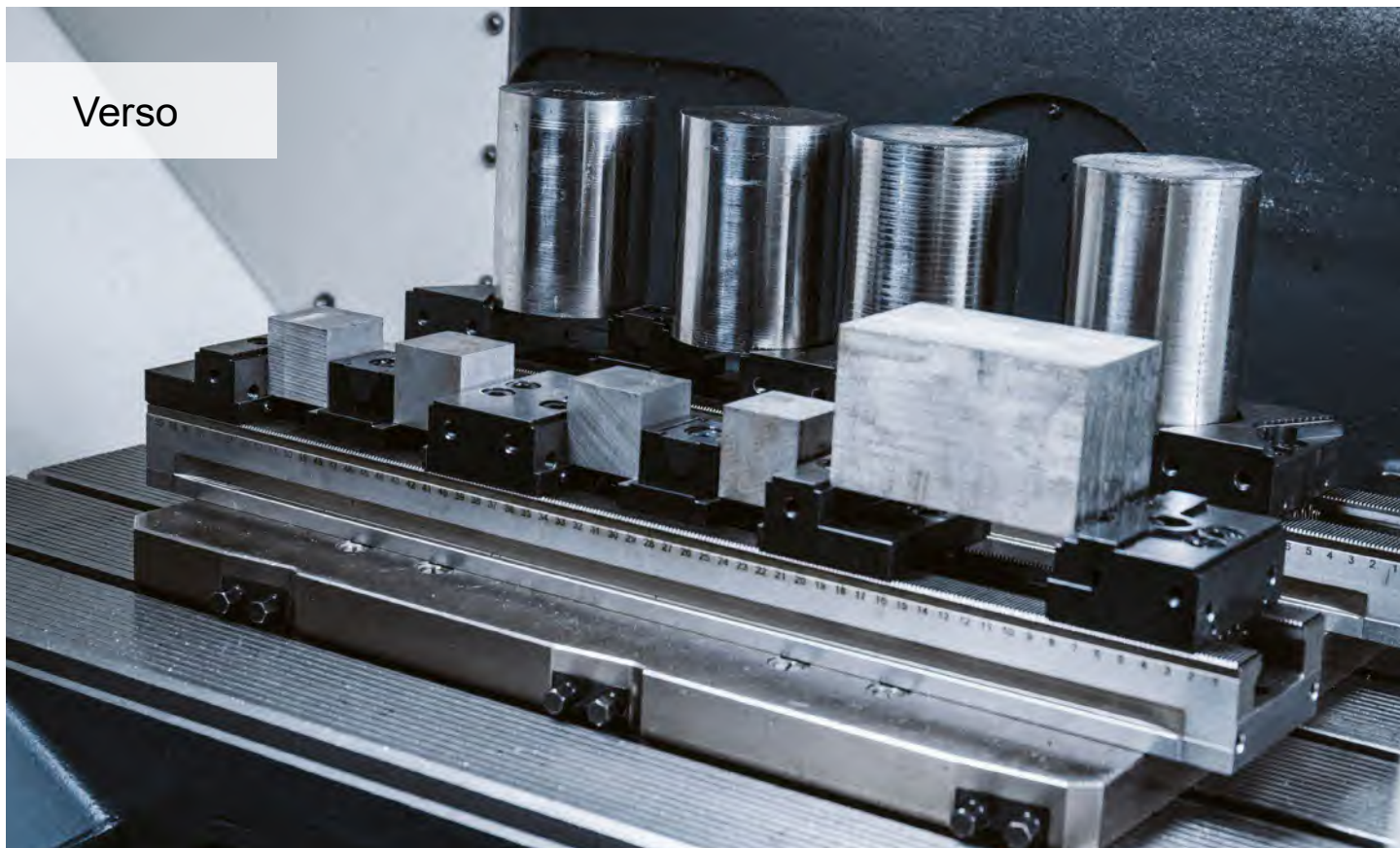
80 897 ...

114

116

118

Verso



The all-rounder for workpiece clamping

The new multiple vice enables you to easily clamp many small and large workpieces on a 3-, 4-, or 5-axis machine. Even slimmer jaws have further increased the part thickness.

Your benefits:

- ▲ Hardened and ground teeth ensure the highest level of precision and dimensional stability
- ▲ Fast jaw changeover system for fixed and adjustable jaws
- ▲ Full modular range for all types of machining centres
- ▲ Multi-clamping with wedge grip elements
- ▲ Extensive modular system jaw range
- ▲ Simple clamping bar extension with connecting element



Clamping/aligning:



Using T-slots or screws
Alignment in the T-slot (14, 16, 18 mm) with the matching alignment set for T-slots. For 12 mm T-slot: use two Ø 12 cylinder pins.



Using clamping claws
Alignment set and clamping using clamping claws attached at the side.



Using grid holes
Position and fasten the workpieces using two Ø12f7 / M12 dowel screws in the first and last holes of the clamping bar. Additional fastening using M12 cylindrical screws in the remaining holes.

Clamping/aligning:

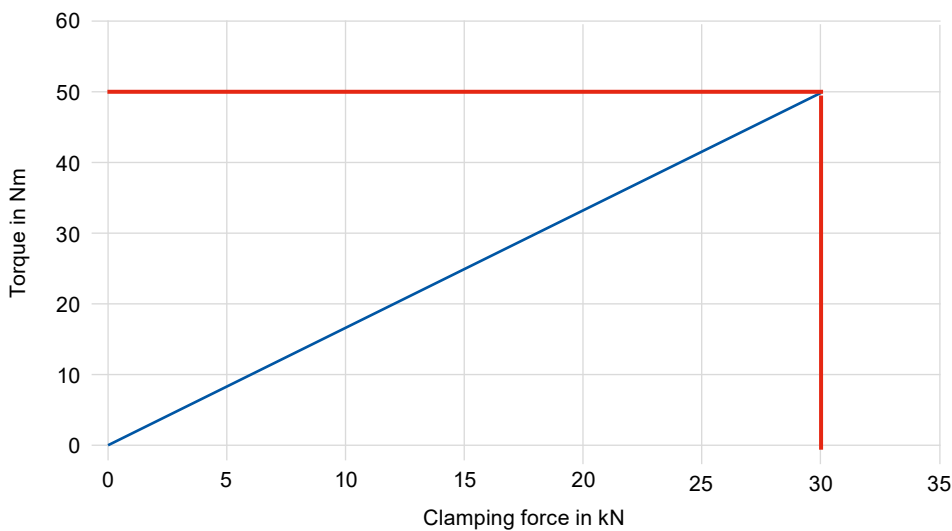


With a zero point clamping system

The clamping bar is equipped with MNG interfaces that enable MNG clamping bolts to be attached (up to a base body length of 500 mm = 2 clamping bolts / from 600 mm upwards = 3 clamping bolts).

Clamping force:

Verso tightening torque/clamping force



Quick jaw change for fixed and adjustable jaws

The Verso multiple vice is equipped with a quick jaw change system as standard. Simply use the two screws to release, remove or reposition the fixed and adjustable jaw. The jaws are removed in an upwards direction, allowing each jaw to be removed individually, without taking out any others. This reduces the set-up time significantly.



Release position



Undo screws



Take off and insert



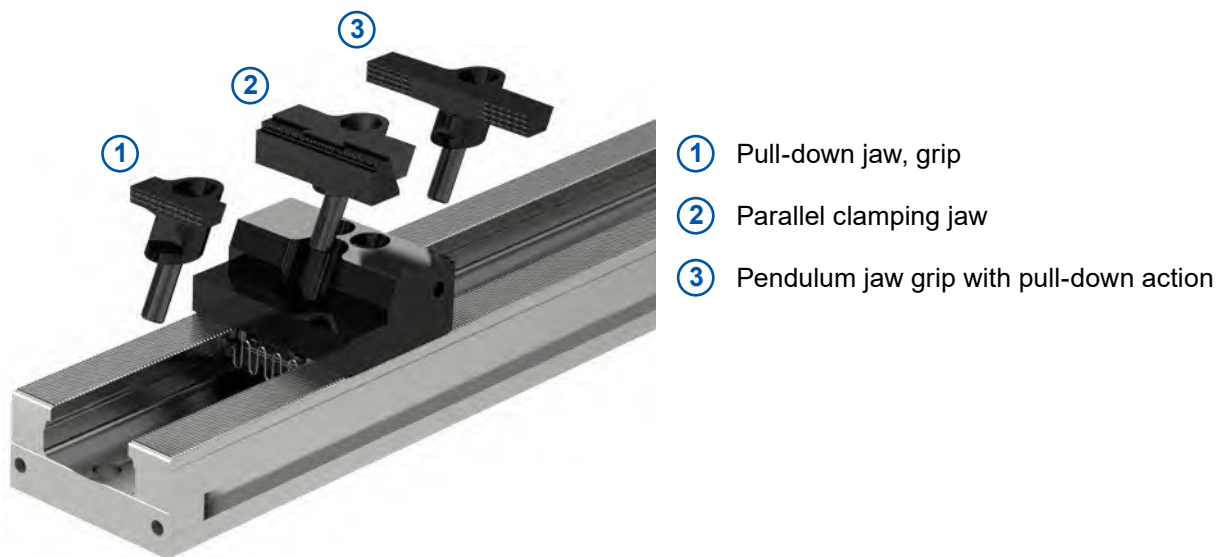
Tighten screws



Clamping position

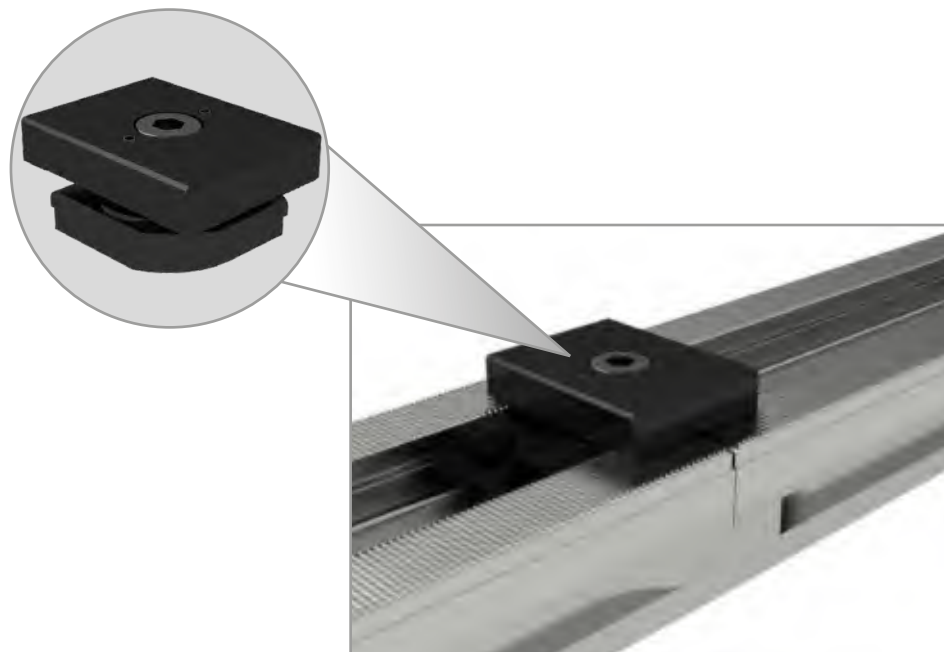
Quick jaw change

The fixed and adjustable jaws of the Verso multiple vice system are equipped with a quick jaw change system as standard. Two screws can be used to release and change the jaw, making jaw changes extremely quick.



Connecting the clamping bars

A connecting element allows two or more Verso clamping bars to be combined with one another or extended.

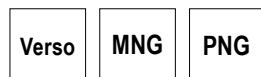
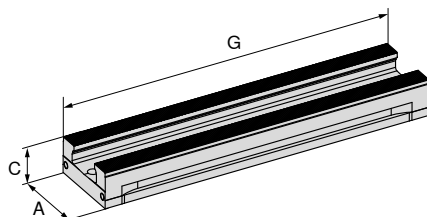


CoreLine – Multiple vice without system jaws – Verso

- ▲ For single and multi-clamping
- ▲ Multi-clamping with wedge grip elements
- ▲ Workpieces can be clamped on 3-, 4- or 5-axis machine
- ▲ Adapter plates for MNG available

Scope of supply:

Body without jaws



A mm	C mm	G mm	MXC kN	WT kg
90	45	260	0 - 50	5,0
90	45	400	0 - 50	7,7
90	45	500	0 - 50	9,6
90	45	600	0 - 50	11,5
90	45	650	0 - 50	12,5

CW

80 914 ...

09000

09100

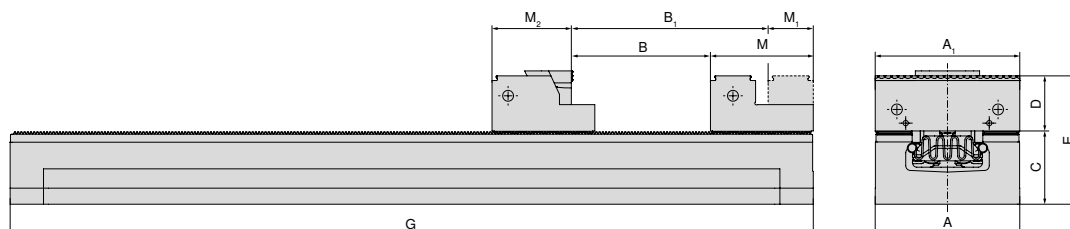
09200

09300

09400

Verso – Structural dimension table

Clamping rail



A mm	A ₁ mm	B mm	B ₁ mm	C mm	D mm	E mm	G mm	M mm	M ₁ mm	M ₂
90	40 / 65 / 90	145	181	45	35	80	260	64	28	53,5
90	40 / 65 / 90	285	321	45	35	80	400	64	28	53,5
90	40 / 65 / 90	385	421	45	35	80	500	64	28	53,5
90	40 / 65 / 90	485	521	45	35	80	600	64	28	53,5
90	40 / 65 / 90	535	571	45	35	80	650	64	28	53,5



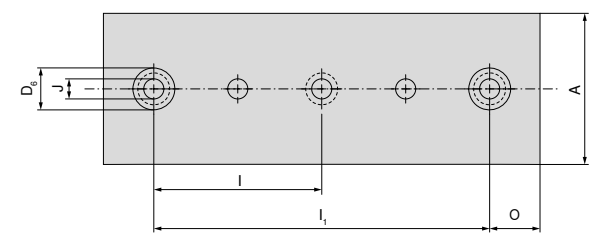
When using the 90 mm pendulum jaw grip and parallel clamping jaws, dimensions B, B₁ and M₂ will differ.

Vice guide

- Quick change reversible jaws
- Underside Dimensions
- Overview of clamping ranges
- System jaws overview
- MNG-/PNG zero point clamping system
- General top jaws
- Workpiece location
- General accessories
- Clamping lever
- Screws

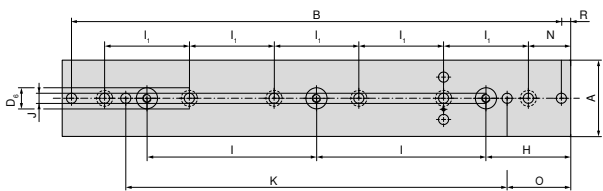
Verso underside dimensions

Base width 90 mm and length 260 mm



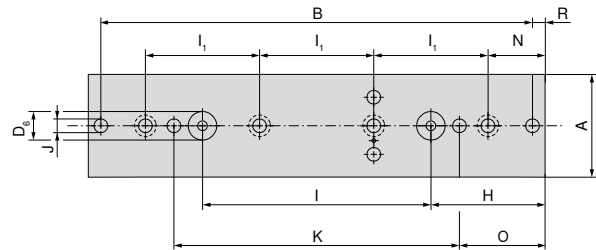
A	D ₆ H7	I ±0,015	I ₁ ±0,015	J F7	O ±0,015
mm	mm	mm	mm	mm	mm
90	25	100	200	12	30

Base width 90 mm and length 600 mm



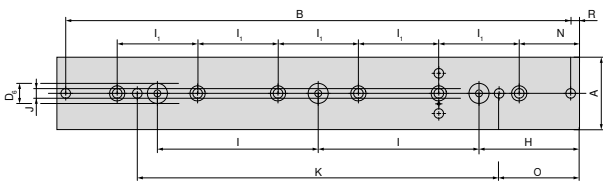
A	B	D ₆ H7	H ±0,015	I ±0,015	I ₁ ±0,015	J F7	K ±0,015	N	O ±0,015	R
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
90	578	25	100	200	100	12	450	50	75	11

Base width 90 mm and length 400 mm



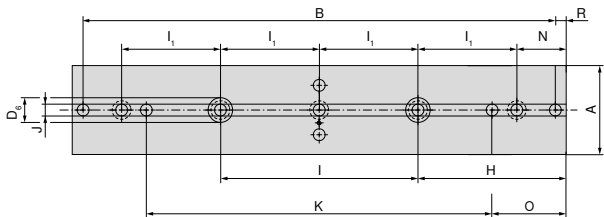
A	B	D ₆ H7	H ±0,015	I ±0,015	I ₁ ±0,015	J F7	K ±0,015	N	O ±0,015	R
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
90	378	25	100	200	100	12	250	50	75	11

Base width 90 mm and length 650 mm



A	B	D ₆ H7	H ±0,015	I ±0,015	I ₁ ±0,015	J F7	K ±0,015	N	O ±0,015	R
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
90	628	25	125	200	100	12	450	75	100	11

Base width 90 mm and length 500 mm

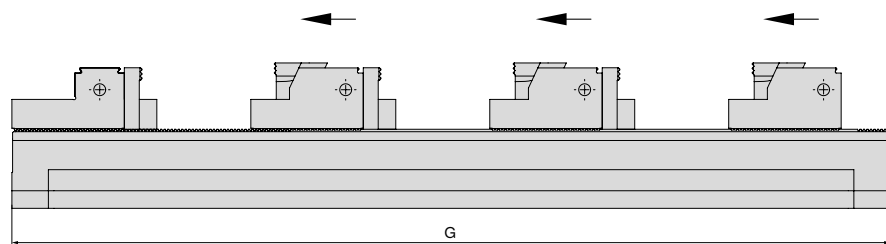


A	B	D ₆ H7	H ±0,015	I ±0,015	I ₁ ±0,015	J F7	K ±0,015	N	O ±0,015	R
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
90	478	25	150	200	100	12	350	50	75	11

Verso – Overview of clamping ranges

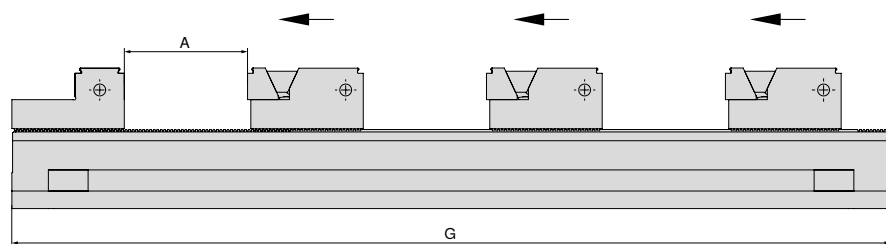
The clamping range shows the max. workpiece size depending on the number of clamping points for the individual clamping bar lengths.

Adjustable jaws with 40 mm pull-down jaw grip



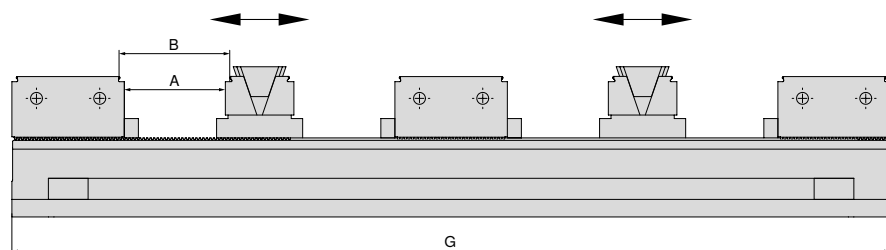
G mm	Number of workpieces							Article no. Vices
	1	2	3	4	5	6	7	
260	134	36	–	–	–	–	–	8091409000
400	274	106	50	22	–	–	–	8091409100
500	374	156	82	45	24	–	–	8091409200
600	474	206	116	72	44	26	–	8091409300
650	524	230	135	84	54	34	20	8091409400

Adjustable jaws with parallel clamping jaws



G mm	Number of workpieces									Article no. Vices
	1 A	2 A	3 A	4 A	5 A	6 A	7 A	8 A	9 A	
260	175	59	–	–	–	–	–	–	–	8091409000
400	315	129	67	27	10	–	–	–	–	8091409100
500	415	179	100	61	30	15	–	–	–	8091409200
600	515	229	133	86	57	32	19	10	–	8091409300
650	565	254	150	98	67	46	26	16	8	8091409400

With wedge grip elements

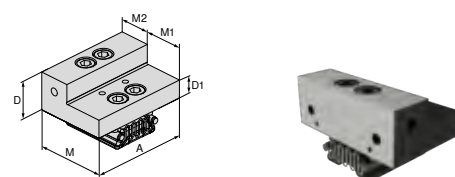


G mm	Number of workpieces								Article no. Vices
	2		4		6		8		
	A	B	A	B	A	B	A	B	
260	45	50	–	–	–	–	–	–	8091409000
400	115	120	31	36	–	–	–	–	8091409100
500	165	170	56	61	19	24	–	–	8091409200
600	215	220	81	86	36	41	14	19	8091409300
650	240	245	93	98	44	49	20	25	8091409400

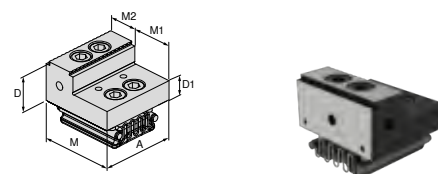
Stop jaw, fixed, grip 2,9 mm

[illegible]

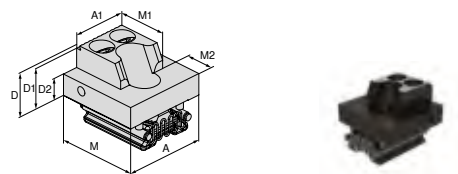
▲ Price per piece

[illegible]

▲ Price per piece

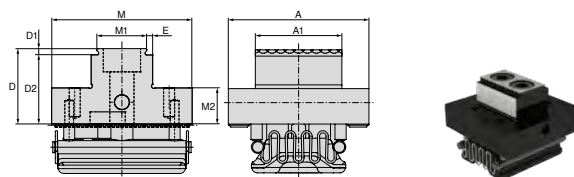
[illegible]

▲ Price per piece

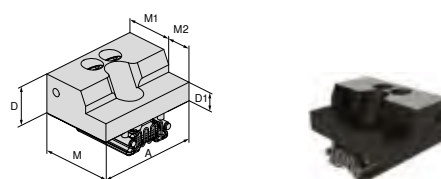
[illegible]

Indexable jaw, fixed VS, grip 3 mm

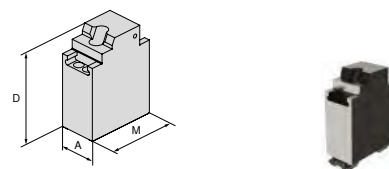
- ▲ Price per piece
- ▲ VS = Larger clamping range

[illegible]

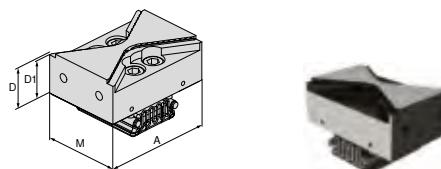
▲ Price per piece

[illegible]

▲ Price per piece

[illegible]

▲ Price per piece

[illegible]

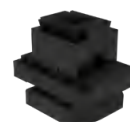
Wedge jaw

Technical drawing of a square nut (Fig. 10). Dimensions shown: A (width), A1 (width of the base), D (height), D1 (height of the base), and M (thread pitch).



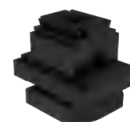
Wedge grip jaw

Technical drawing of a square base with a central hole and a grid of holes. Dimensions A, D, D1, A1, and M are indicated.



Wedge grip jaw, 3 mm

Technical drawing of a square block with dimensions A, A1, D, D1, and M. The drawing shows a 3D perspective view of a square block with a central circular hole. The dimensions are labeled as follows: A is the top width, A1 is the bottom width, D is the total height, D1 is the height of the upper section, and M is the width of the base.



Jaw, grip



										CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂												
65	65		35	7			10														
65	40		35	7			10														
90	90		35	7			10														

Base jaw

-

[illegible][illegible][illegible][illegible]

Pull-down jaw, grip – round

Parallel clamping jaw, grip – round

Parallel clamping jaw

Pendulum jaw, grip

[illegible]

Clamping Wedge

Parallel clamping jaw, smooth

Parallel clamping jaw, grip

Jaw, steel

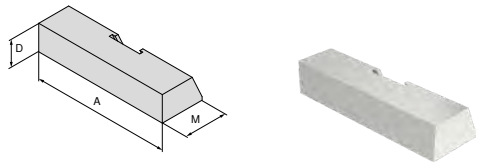
[illegible]

System jaws overview

Jaw, alu

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
90	90		18				30		

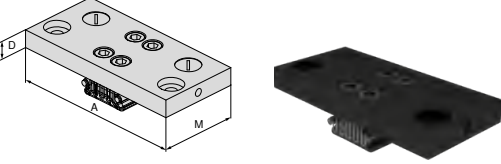


CW	8091433900	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
----	------------	-----	---------------	------------	-------	-------	-------	-------	----------	-------	-------	-----

Fixed adaptor jaw

▲ to accommodate 6-way reversible jaws
▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
90	160		17				74		

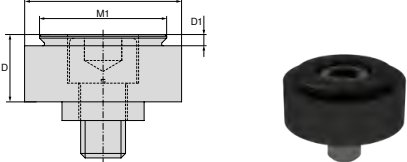


CW	8091434000	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
----	------------	-----	---------------	------------	-------	-------	-------	-------	----------	-------	-------	-----

Insert jaws, round, grip 3 mm

▲ Price per piece
▲ For adapter jaws **80 914 34000**

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
			18	3			42	34	

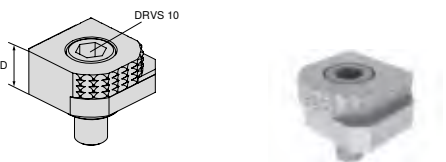


CW	8091434500	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
----	------------	-----	---------------	------------	-------	-------	-------	-------	----------	-------	-------	-----

6 function indexable jaw

▲ 1 = Smooth, carbide coated
▲ 2 = Grip with 3 mm step
▲ 3 = Grip with 8 mm step
▲ 4 = Grip with 18 mm step
▲ 5 = Rough grip with 8 mm step
▲ 6 = Round grip
▲ M_{max} = 60 Nm
▲ Including fixation screws

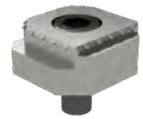
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
			18						



CW	80892246	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
----	----------	-----	---------------	------------	-------	-------	-------	-------	----------	-------	-------	-----

6x indexable jaw, carbide grip

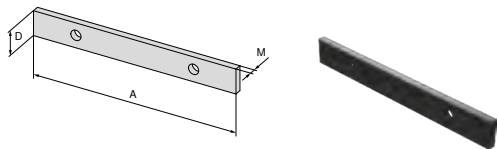
-

[illegible]

Workpiece support

▲ Price for 2 pieces

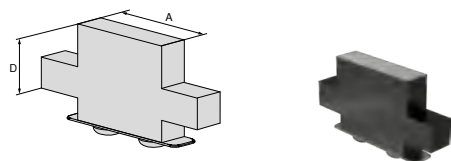
For vice width	A	A _i	D	D ₁	D ₂	E	M	M ₁	M ₂
90	90		11				3		

[illegible]

Workpiece supports, offset

▲ Price for 2 pieces

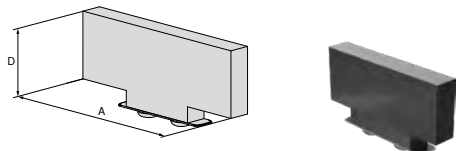
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
90	40		22						
90	40		25						
90	40		30						

[illegible]

Workpiece supports, offset

▲ Price for 2 pieces

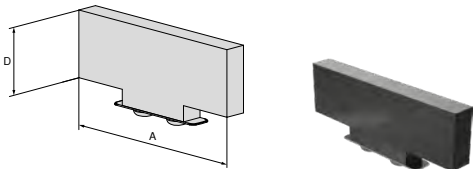
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
90	65		11						
90	65		17						
90	65		25						
90	65		30						

[illegible]

Workpiece supports, offset

▲ Price for 2 pieces

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
90	90		11						
90	90		17						
90	90		22						
90	90		25						
90	90		30						

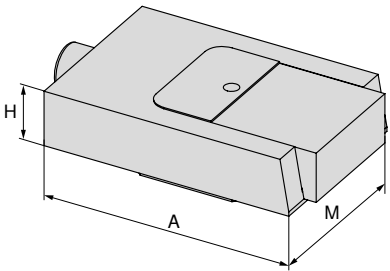
[illegible]

System accessories overview

Adjustable stop with basic body

- ▲ for vibration damping
- ▲ height adjustable 16 – 17 mm

Verso



H	A	M
mm	mm	mm
16	72	50

CW

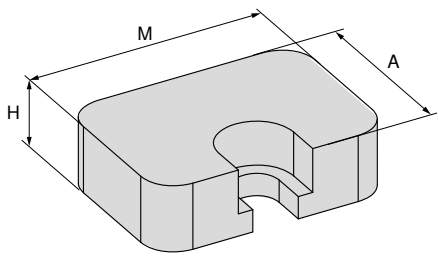
80 914 ...

50100

Support

- ▲ for vibration damping: Article no. 80 914 50100

Verso



H	A	M
mm	mm	mm
8	20	28
13	20	28

CW

80 914 ...

50200

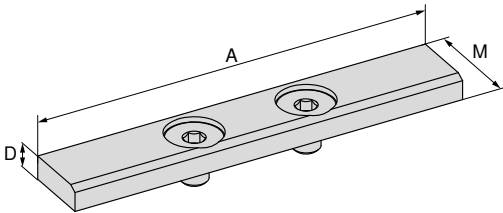
50300

System accessories overview

Support, hard for milling over

▲ Price per piece

Verso



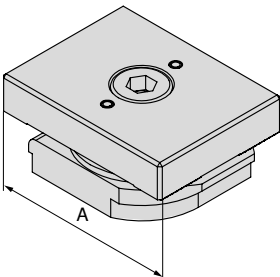
A	D	M
mm	mm	mm
40	5,4	15
90	5,4	15

CW
80 914 ...
51200
51100

Joint

▲ to connect 2 basic bodies

Verso



A
mm
90

CW
80 914 ...
50400

System accessories overview

Clamping Screw Set for T-slot for MNG

Scope of supply:
Clamping screw and T-Nuts

Verso



for slot width mm	G
20	M12
22	M12
24	M12

CW
80 914 ...
50500
50600
50700

Alignment Pin

Verso



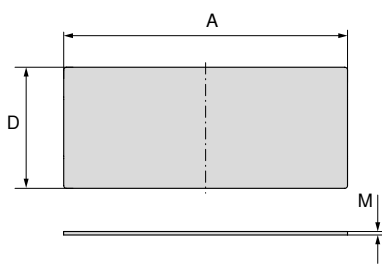
D ₁ mm	D ₂ mm
12	14
12	16
12	18

CW
80 914 ...
81400
81600
81800

System accessories overview

Cover

Verso



A	D	M
mm	mm	mm
50	84	0,5
50	86	0,5
200	86	0,5

CW

80 914 ...

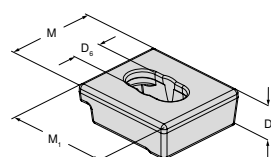
51000

50800

50900

Clamping claws

▲ Price for 2 pieces



D	D ₆	M	M ₁
mm	mm	mm	mm
20	16	50	57

CW

80 890 ...

315

System accessories overview

Torque key

▲ without socket

- ZSGmini
- MSG2
- Verso
- MNG



TQXNm	Square	AS
10 - 50	3/8"	80 884 ...
		402

Clamping screw and T-Nuts

- ▲ For mounting the clamping claw
- ▲ Price per 2 pieces

Scope of supply:
Incl. washers

- NCG
- H5G
- ESG4
- HDG2
- ZSG4
- DSG4
- Verso



for slot widthmm	G	CW
12	M10	80 890 ...
14	M12	308
16	M14	309
18	M16	310
		311

System accessories overview

Clamping screws for round clamps, T-Nut

▲ incl. nut and washer
▲ Price per 2 Pieces

- Verso
- MNG



for width mm	G	CW	
12	M10	80 899 ...	112
14	M12		114
16	M12		116
18	M12		118

Socket

▲ Suitable for 1/2" or 3/8" square drive

- ESG mini
- MSG 2
- Verso
- MNG



DRVS mm	AS	
8	80 877 ...	108

System accessories overview

Dowel screw

▲ Price for 2 pieces

- H5G
- ESG
4
- ZSG
4
- DSG
4
- MNG
- X5G
-Z



for width mm	G	J mm
125	M12x45	12

CW

80 895 ...

019

SBF 3

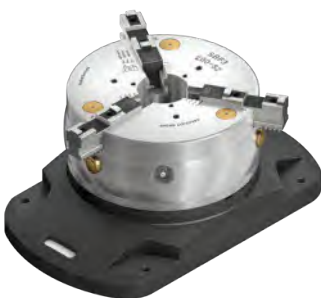


Hotly anticipated – now also for round components

Machining round components has become daily routine for many companies. We now have a solution in the portfolio in the form of the SBF 3 stationary three-jaw chuck – fully compatible with the in-house MNG and PNG zero point clamping systems for rapid, uncomplicated handling.

Your benefits:

- ▲ Suitable for 3/5-axis machining of round components
- ▲ Compatible with PNG and MNG zero point clamping systems
- ▲ Quick change jaw system with single release of jaws
- ▲ Spindle with hex connection



SBF 3 Ø 200 mm



SBF 3 Ø 315 mm

Technical information – cross-section diagram



- | | |
|--|---|
| <p>1 Wedge bar drive
Allows for excellent machining results</p> | <p>7 Base jaws with angled teeth (SFG)</p> |
| <p>2 Hardened and extremely stiff base body
Longer service life with maximum precision as a result – even at the highest clamping force</p> | <p>8 Locking mechanism
Guarantees secure engagement of the base jaw teeth with the wedge bar teeth</p> |
| <p>3 Large through hole
For machining all common bar material diameters (optional: enlargement of through hole)</p> | <p>9 Engagement pin
For pre-positioning the base jaw</p> |
| <p>4 Optimised lubrication system
For high degree of efficiency</p> | <p>10 Actuation via hex connection
Easier operation as a result</p> |
| <p>5 Mounting threads
For workpiece stops or cover plates</p> | <p>11 Pushbutton for jaw change
For extremely short setup times</p> |
| <p>6 Quick jaw change system
Single release of jaws, meaning extremely short setup times</p> | <p>12 Indicator pin
For visual stroke monitoring of the manual clamping chuck</p> |

CoreLine – SBF 3 three-jaw chuck (Ø 200 mm) with console – SBF 3

- ▲ Suitable for 3/5-axis machining of round components
- ▲ Compatible with PNG and MNG zero point clamping systems (zero point clamping bolts must be ordered separately)
- ▲ Quick change jaw system with single release of jaws
- ▲ Spindle with hex connection

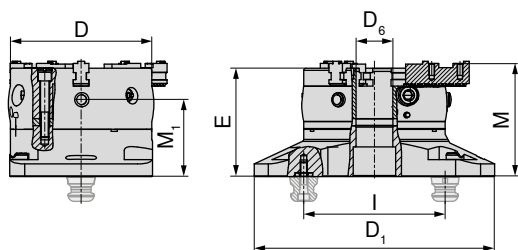
Scope of supply:

SBF 3 three-jaw chuck (Ø 200 mm) including console (PNG- and MNG-compatible)

1 set GBA base jaws

1 set SB-H stepped jaws

6 fixing screws and clamping key



D	D ₁	D ₆	E	I	M	M ₁	MXC	TQX	DRVS	Stroke / jaw	Tooth pitch	WT
mm	mm	mm	mm	mm	mm	mm	kN	Nm	mm	mm	mm	kg
200	340	52	153,3	200	160,1	108,8	100	120	12	7	4,8	49,5

CW

80 913 ...

20000

CoreLine – SBF 3 three-jaw chuck (Ø 315 mm) with console – SBF 3

- ▲ Suitable for 3/5-axis machining of round components
- ▲ Compatible with PNG and MNG zero point clamping systems (zero point clamping bolts must be ordered separately)
- ▲ Quick change jaw system with single release of jaws
- ▲ Spindle with hex connection

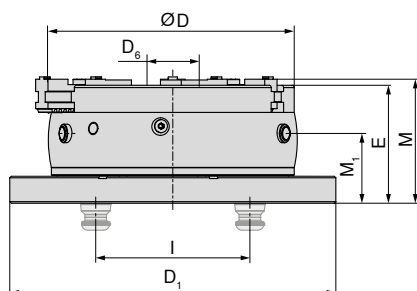
Scope of supply:

SBF 3 three-jaw chuck (Ø 315 mm) including console (PNG- and MNG-compatible)

1 set GBA base jaws

1 set SB-H stepped jaws

6 fixing screws and clamping key



D	D ₁	D ₆	E	I	M	M ₁	MXC	TQX	DRVS	Stroke / jaw	Tooth pitch	WT
mm	mm	mm	mm	mm	mm	mm	kN	Nm	mm	mm	mm	kg
315	423	92	153	200	160,86	90,5	180	220	16	9,9	7	95

CW

80 913 ...

31500



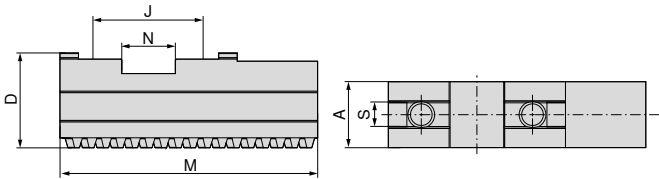
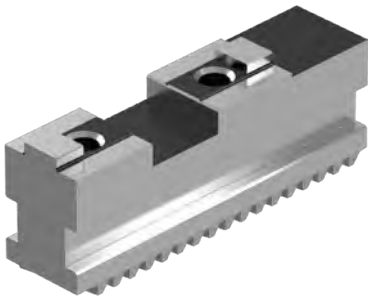
The chuck is designed exclusively for stationary use – do not use while rotating!

System jaws overview

Base jaws (GBA) – set

- ▲ Base jaws with angled teeth
- ▲ Price per set of 3 pieces

Scope of supply:
3 base jaws with angled teeth
Including cylindrical screws

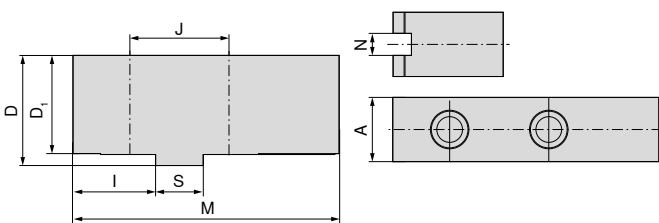


for	A mm	D mm	J mm	M mm	N mm	S mm	G	WT kg	CW	
SBF-3.200	22	32	40	90	20	10	M8x1	1,2	80 913 ...	50300
SBF-3.315	32	43	54	125	26	12	M12x1,5	3,1		60300

Soft top jaws (AB-W) – set

- ▲ Price per set of 3 pieces
- ▲ Material: 16MnCr5

Scope of supply:
3 soft top jaws



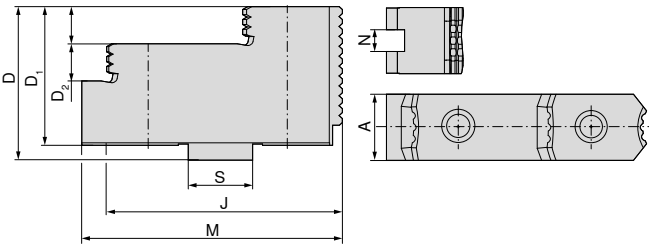
for	A mm	D mm	D ₁ mm	I mm	J mm	M mm	N mm	S mm	Hole for	WT kg	CW	
SBF-3.200	22	47	43	35	40	105	10	20	M8	2,0	80 913 ...	50400
SBF-3.315	35	60	54	45	54	145	12	26	M12	5,6		60400

System jaws overview

Hard stepped top jaws (AB-H) – set

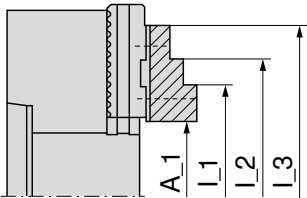
▲ Price per set of 3 pieces

Scope of supply:
3 hard stepped top jaws

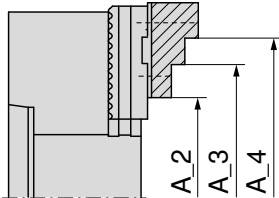


for	A mm	D mm	D ₁ mm	D ₂ mm	J mm	M mm	N mm	S mm	Hole for	WT kg	CW 80 913 ... 50200 60200	
SBF-3.200	22	42	38	10	40	71,7	10	20	M8	2,4		
SBF-3.315	36	62	56	15	54	105	12	26	M12	3,3		

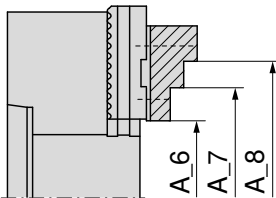
Dimension table – Hard stepped top jaws (AB-H)



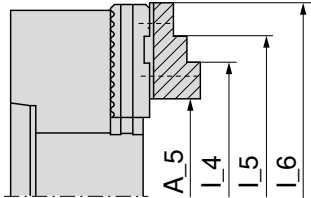
Basic jaw position 2



Basic jaw position 1



Basic jaw position 2



Basic jaw position 1

		Externall clamping range							
3-jaw chuck	System jaw	A_1	A_2	A_3	A_4	A_5	A_6	A_7	A_8
SBF-3.200	8091350200 SBF-3.AB-H.200.71.7.22.10	7–76	57–125	108–177	135–204	55–125	14–77	66–129	93–156
SBF-3.315	8091360200 SBF-3.AB-H.315.105.36.15	14–125	93–224	202–333	–	87–219	44–130	153–239	–

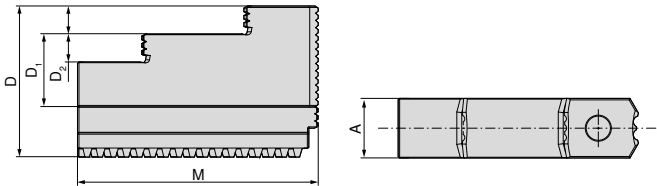
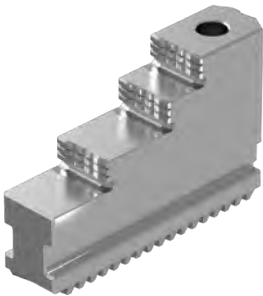
		Internal clamping range					
3-jaw chuck	System jaw	I_1	I_2	I_3	I_4	I_5	I_6
SBF-3.200	8091350200 SBF-3.AB-H.200.71.7.22.10	72–141	99–168	151–220	120–189	147–216	199–268
SBF-3.315	8091360200 SBF-3.AB-H.315.105.36.15	93–204	202–313	–	167–298	276–407	–

System jaws overview

Hard stepped top jaws (SB-H) – set

- ▲ Stepped block jaws with angled teeth
- ▲ Price per set of 3 pieces

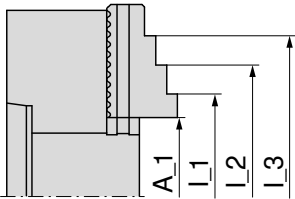
Scope of supply:
3 hard stepped block jaws



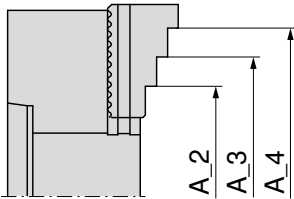
for	A mm	D mm	D ₁ mm	D ₂ mm	M mm	WT kg
SBF-3.200	22	60	35	10	94	1,9
SBF-3.315	32	81	46	15	129	5,5

CW
80 913 ...
50100
60100

Dimension table – Hard stepped top jaws (SB-H)



Hard stepped top jaws
steel 16MnCr5, case-
hardened



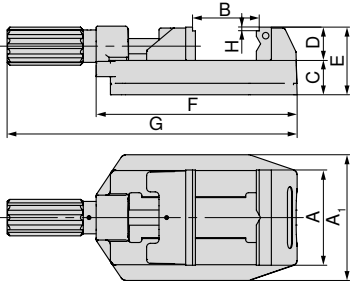
Hard stepped top jaws
steel 16MnCr5, case-
hardened

3-jaw chuck	System jaw	Externall clamping range				Internal clamping range		
		A_1	A_2	A_3	A_4	I_1	I_2	I_3
SBF-3.200	8091350100SBF-3.SB-H.200.94.22.10	6–74	59–128	111–180	138–207	70–138	97–165	149–217
SBF-3.315	8091360100SBF-3.SB-H.315.129.32.15	12–124	89–210	189–420	–	91–203	199–311	–

CoreLine – Manual machine vice

- ▲ handy, universal vice with large clamping range
- ▲ Stepped jaws with horizontal and vertical 120° prism
- ▲ Optional material stop can be used on both sides

HSG



A	A ₁	B	C	D	E	F	G	H	WT
mm	mm	mm	mm	mm	mm	mm	mm	mm	kg
80	112	0 - 81	36	35	71	194	286,5	4	4,5
100	132	0 - 100	36	35	71	211	304,5	4	5,6
125	156	0 - 131	40	40	84	274	386	4	11,2

CW

80 893 ...

080

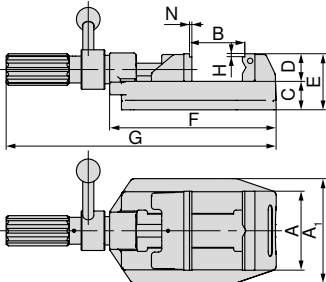
100

125

CoreLine – Manual machine vice with clamping aid

- ▲ Quick and accurate workpiece clamping using the clamping aid
- ▲ handy, universal vice with large clamping range
- ▲ Stepped jaws with horizontal and vertical 120° prism
- ▲ Optional material stop can be used on both sides
- ▲ N = Stroke with handle clamping

HSG



A	A ₁	B	C	D	E	F	G	H	N	WT
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kg
100	132	0 - 100	36	35	71	211	342	4	1,5	6,1
125	156	0 - 133	44	40	84	274	405	4	1,5	11,7

CW

80 893 ...

101

126

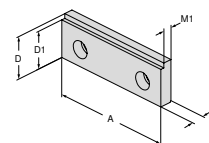
Vice guide

→ System jaws	→ Clamping lever
→ System accessories	→ Screws
→ General top jaws	
→ Workpiece location	
→ General accessories	

Top jaws overview

Stepped jaw, smooth

▲ Price per piece

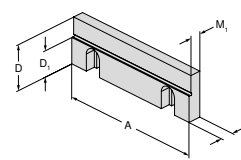


For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
	80		35	31			10,2	7,2	
	100		35	31			10,2	7,2	
	125		40	36			11,8	8,8	

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80893082											●
80893102											●
80893127											●

Stepped jaw, 17 mm

▲ Price per piece



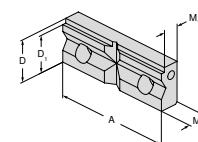
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
	125		40	23			11,5	9,5	

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80892244											●

Prismatic jaw

▲ Prism jaw with horizontal and vertical prism

▲ price per piece



For clamping diameter	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
9 - 31	80		35	31			15,8	12,8	
9 - 31	100		35	31			15,8	12,8	
11 - 41	125		40	36			17,8	14,8	

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80893083											●
80893103											●
80893128											●



→ Here you will find other matching top jaws.

System accessories overview

Workpiece stop

- ▲ Fixed to the top section, either on the left, the right, or at both ends. The length adjustment can be performed quickly and accurately using a clamping screw.

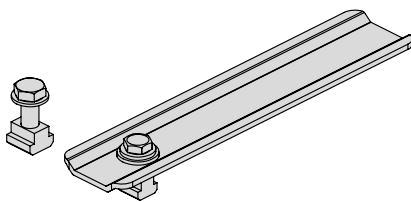
HSG

for width
mm
80/100/125

CW
80 893 ...
265

Guide rail

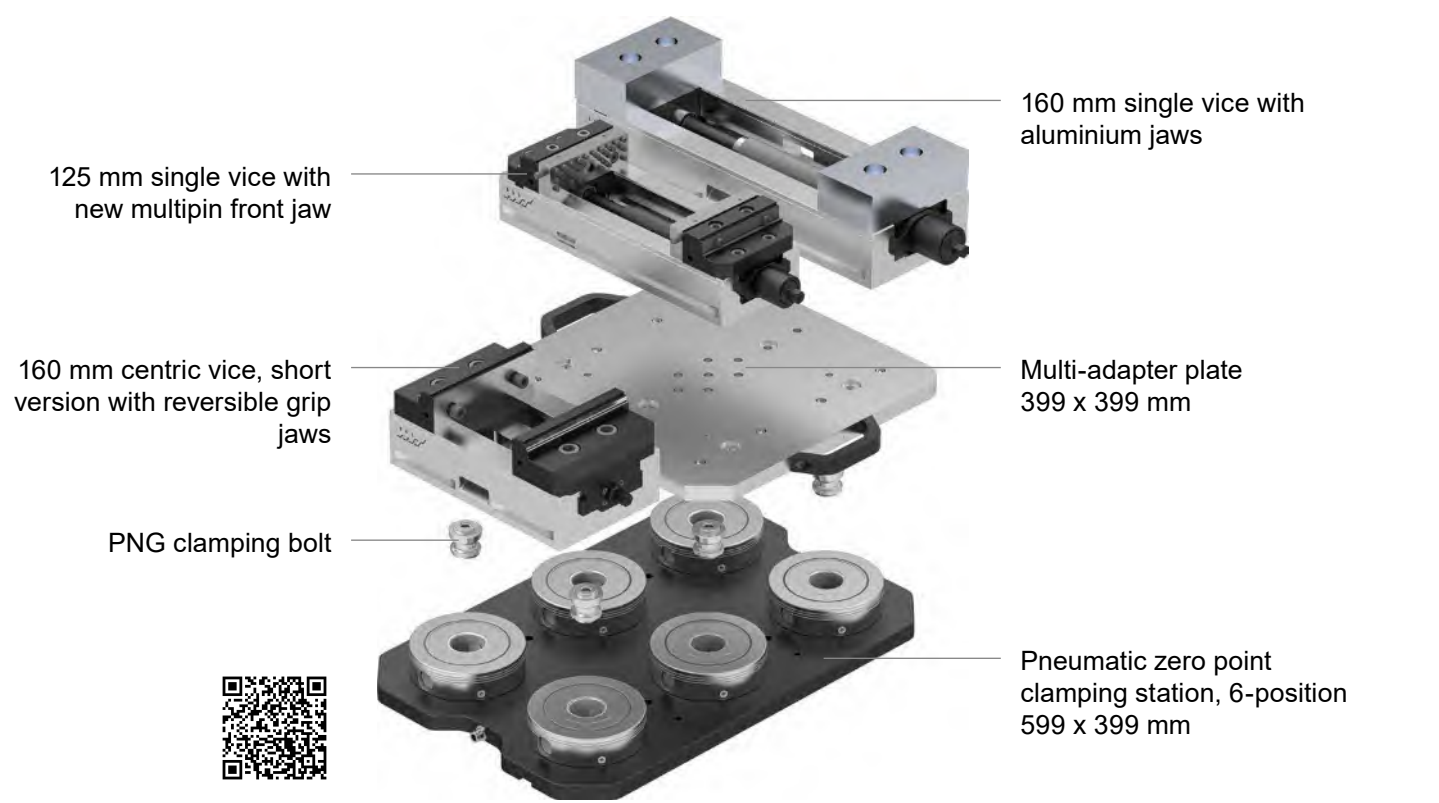
- ▲ Helps prevent accidents
- ▲ Prevents unwanted movement, lifting and dragging

HSG

for width
mm
80/100/125

CW
80 893 ...
260

Overview of MNG and PNG zero point clamping system



CoreLine – Base plate, round – MNG

- ▲ MNG – Mechanical Zero-point Clamping System
- ▲ hardened and ground
- ▲ Repeatability ≤ 0.01 mm
- ▲ Insertion force 20 kN
- ▲ Torque 30 Nm

MNG

A	B	C	D	E	F	WT	
mm	mm	± 0.005 mm	mm	mm	$H7$ mm	kg	
135	148	30	50	100	12	3,5	

CW

80 899 ...

125

Vice guide

→ System accessories	→ Clamping lever
→ MNG clamping options	→ Screws
→ General top jaws	
→ Workpiece location	
→ General accessories	

CoreLine – Base plate, rectangular – MNG

- ▲ MNG – Mechanical Zero-point Clamping System
- ▲ Insertion force 20 kN on the clamping bolt
- ▲ Stainless and vacuum-hardened
- ▲ Repeatability ≤ 0.01 mm
- ▲ Tightening torque 30 Nm

MNG

Size	WT
195x130 mm	5,2

CW

80 899 ...

65000

CoreLine – Base plate, rectangular 2-location – MNG

- ▲ MNG – Mechanical Zero-point Clamping System
- ▲ Insertion force 20 kN on the clamping bolt
- ▲ Stainless and vacuum-hardened
- ▲ Repeatability ≤ 0.01 mm
- ▲ Tightening torque 30 Nm

MNG

Size	WT
400x130 mm	11

CW

80 899 ...

65100

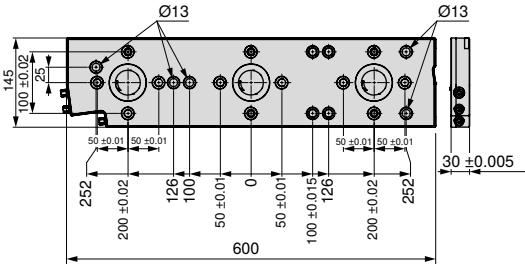
Vice guide

→ System accessories	→ Clamping lever
→ MNG clamping options	→ Screws
→ General top jaws	
→ Workpiece location	
→ General accessories	

CoreLine – Base plate, rectangular 3-location – MNG

- ▲ MNG – Mechanical Zero-point Clamping System
- ▲ Insertion force 20 kN on the clamping bolt
- ▲ Stainless and vacuum-hardened
- ▲ Repeatability ≤ 0.01 mm
- ▲ Tightening torque 30 Nm

MNG



Size	WT
600x145 mm	18 kg

CW

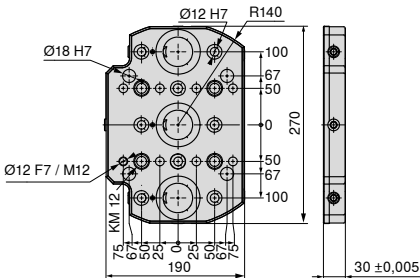
80 899 ...

65200

CoreLine – 3 location base plate – MNG

- ▲ MNG – Mechanical Zero-point Clamping System
- ▲ Clamping force 20 kN on each location bolt
- ▲ 4 x M12 mounting holes for T-slot nuts 50 mm spread
- ▲ 8 x dowel bushes Ø12 F7 / M12
- ▲ 4 x dowel holes Ø18 H7 for positioning

MNG



Size	WT
270x190 mm	9 kg

CW

80 899 ...

230

Vice guide

→ System accessories	→ Clamping lever
→ MNG clamping options	→ Screws
→ General top jaws	
→ Workpiece location	
→ General accessories	

CoreLine – Base plate 4-sided with indexing – MNG

- ▲ MNG – Mechanical zero point clamping system
- ▲ Stainless and vacuum-hardened
- ▲ Insertion force 20 kN on each clamping bolt
- ▲ 15 x M12 mounting holes for T-slot spacing 50, 63, 100, 125 mm
- ▲ 2 x locating holes Ø18 G7 for positioning
- ▲ 1 x locating hole Ø12 F7 for positioning

MNG

Size	WT kg
330x400 mm	28

80 899 ...
64200 ¹⁾

1) Not ex-stock

CoreLine – Base plate 6-sided with indexing – MNG

- ▲ MNG – Mechanical Zero-point Clamping System
- ▲ Stainless and vacuum-hardened
- ▲ Insertion force 20 kN on the clamping bolt
- ▲ 14 x mounting holes for M16, for T-slot spacing 63, 80, 100, 125 mm
- ▲ 2 x mounting holes for M12
- ▲ 2 x mating holes Ø18 G7 for positioning
- ▲ 1 x mating holes Ø12 F7 for positioning

MNG

Size	WT kg
400x400 mm	33

80 899 ...
64300 ¹⁾

1) Not ex-stock

Vice guide

→ System accessories	→ Clamping lever
→ MNG clamping options	→ Screws
→ General top jaws	
→ Workpiece location	
→ General accessories	

CoreLine – Base plate 6-sided with indexing – MNG

- ▲ MNG – Mechanical zero point clamping system
- ▲ Stainless and vacuum-hardened
- ▲ Insertion force 20 kN on each clamping bolt
- ▲ 24 x M12 mounting holes for T-slot spacing 63, 100, 125 mm
- ▲ 2 x locating holes Ø18 G7 for positioning
- ▲ 1 x locating hole Ø12 F7 for positioning

MNG

Size	WT kg
400x530 mm	45

1) Not ex-stock

CW

80 899 ...

64400 ¹⁾

CoreLine – Base plate 10-sided with indexing – MNG

- ▲ MNG – Mechanical Zero-point Clamping System
- ▲ Stainless and vacuum-hardened
- ▲ Insertion force 20 kN on the clamping bolt
- ▲ 27 x mounting holes M12 for T-slot spacing 50, 63, 100, 125 mm and star slots 45°
- ▲ 2 x mating holes Ø18 G7 for positioning
- ▲ 1 x mating holes Ø12 F7 for positioning

MNG

Size	WT kg
496,5x532 mm	54

1) Not ex-stock

CW

80 899 ...

64500 ¹⁾

Vice guide

→ System accessories	→ Clamping lever
→ MNG clamping options	→ Screws
→ General top jaws	
→ Workpiece location	
→ General accessories	

Centering Pin

▲ MNG – Mechanical Zero-point Clamping System



D ₁ h6 mm	D ₂ h6 mm
12	30
12	32
12	50

CW
80 899 ...
61700
61800
61900

Clamping Screw Set for T-slot

▲ MNG – Mechanical Zero-point Clamping System

Scope of supply:
Clamping screw and T-Nuts



for slot width mm	G
12	M8
12	M10
14	M8
14	M12
16	M8
16	M12
18	M8
18	M12

CW
80 899 ...
63800
63400
63900
63500 ¹⁾
64000
63600 ¹⁾
64100
63700 ¹⁾

1) With low head screws

Vice guide

→ System accessories	→ Clamping lever
→ MNG clamping options	→ Screws
→ General top jaws	
→ Workpiece location	
→ General accessories	

Alignment Pin

▲ MNG – Mechanical Zero-point Clamping System



D ₁ h6		D ₂ h6		CW	
mm		mm		80 899 ...	
18		14		607	
18		18		608	
18		20		609	
18		22		610	

Vice guide

→ System accessories	→ Clamping lever
→ MNG clamping options	→ Screws
→ General top jaws	
→ Workpiece location	
→ General accessories	

CoreLine – Console with zero point clamping module – MNG

- ▲ MNG – Mechanical Zero-point Clamping System
- ▲ universal application on all machine tables
- ▲ Clamping force 20 kN

Scope of supply:
Plate incl. MNG round clamping module

MNG



A	B	C	D	E	F	G	WT
mm	mm	mm	mm	mm	mm	mm	kg
260	147	70	30	100	135	200	8,9

CW

80 899 ...

425

CoreLine – Console – MNG

- ▲ MNG – Mechanical Zero-point Clamping System
- ▲ universal application on all machine tables
- ▲ Material: Aluminum, hard anodized



A	B	C	D	E	G	H	I	WT
mm	mm	mm	mm	±0,02 mm	M12	mm	mm	kg
260	147	70	50	100	M12	30	200	5,5

CW

80 899 ...

420

Vice guide

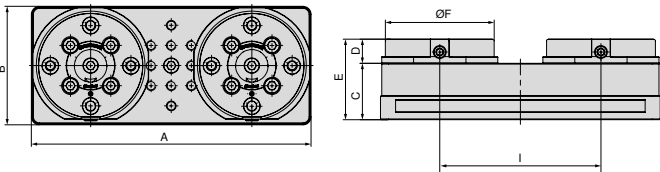
→ System accessories	→ Clamping lever
→ MNG clamping options	→ Screws
→ General top jaws	
→ Workpiece location	
→ General accessories	

CoreLine – Double console with zero point clamping module – MNG

- ▲ MNG – Mechanical Zero-point Clamping System
- ▲ universally applicable on all machine tables
- ▲ Material: Aluminium Hard Anodised

Scope of supply:
Console including MNG round clamping module

MNG



A	B	C	D	E	F	I	WT
mm	mm	mm	mm	mm	mm	mm	kg
347	147	70	30	100	135	200	16,5

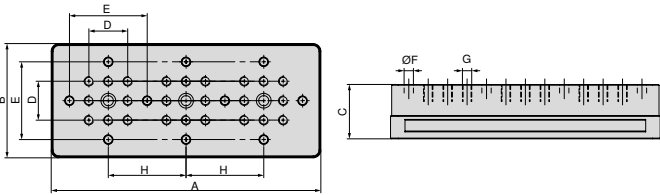
CW

80 899 ...

435

CoreLine – Double console – MNG

- ▲ MNG – Mechanical Zero-point Clamping System
- ▲ universally applicable on all machine tables
- ▲ Material: Aluminium Hard Anodised



A	B	C	D	E ±0,02	F F7	G	H	WT
mm	mm	mm	mm	mm	mm		mm	kg
347	147	70	50	100	12	M12	100	9,3

CW

80 899 ...

430

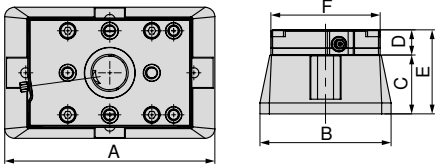
Vice guide

→ System accessories	→ Clamping lever
→ MNG clamping options	→ Screws
→ General top jaws	
→ Workpiece location	
→ General accessories	

CoreLine – Console with zero point clamping module – MNG

▲ MNG – Mechanical Zero-point Clamping System

MNG



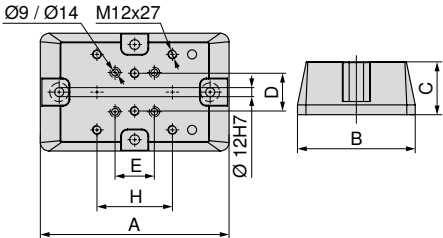
A	B	C	D	E	F
mm	mm	mm	mm	mm	mm
250	156	70	30	100	130

CW
80 878 ...
54000

CoreLine – Console

▲ MNG – Mechanical Zero-point Clamping System

ZSG
4



A	B	C	D	E	H	for
mm	mm	mm	mm	mm	mm	
250	156	70	50	52	100	ZSG 4 - 80 L = 130 mm + 190 mm / ZSG 4 - 125 L = 160 mm
320	197	100	50	50	100	ZSG 4 - 160 L = 280 mm
340	162	100	50	50	100	ZSG 4 - 125 L = 235 mm / 300 mm

CW
80 878 ...
54100
54400
54300

Vice guide

→ System accessories	→ Clamping lever
→ MNG clamping options	→ Screws
→ General top jaws	
→ Workpiece location	
→ General accessories	

Assembly set for console

▲ MNG – Mechanical Zero-point Clamping System



for	CW
ZSG-4.125/160.L235-L280	80 878 ...
ZSG-4.80.L130-L190	54500
	54200

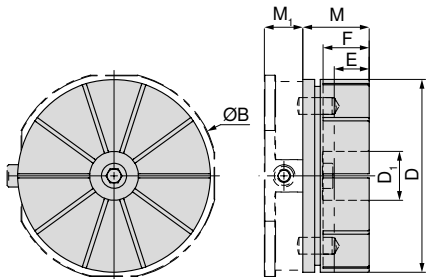
Vice guide

→ System accessories	→ Clamping lever
→ MNG clamping options	→ Screws
→ General top jaws	
→ Workpiece location	
→ General accessories	

CoreLine – Aluminum form chuck – MNG

- ▲ MNG – Mechanical Zero-point Clamping System
- ▲ for incorporation of forms for 2nd op machining

Scope of supply:
Collet with positioning pins, without locating bolts



B	D	D ₁	E	F	M	M ₁
mm	mm	mm	mm	mm	mm	mm
148	138	35	22	33	47,5	27,5

CW
80 899 ...
500

Available on request



Machineable Alu chuck to suit round MNG



Machineable Alu chuck to suit round MNG with clamped workpiece



Grid plate



Blank plate

The maximum cutting depth E is 22 mm

Vice guide

→ System accessories	→ Clamping lever
→ MNG clamping options	→ Screws
→ General top jaws	
→ Workpiece location	
→ General accessories	

Adjustable ring for MNG form collet

MNG



CW
80 899 ...
510

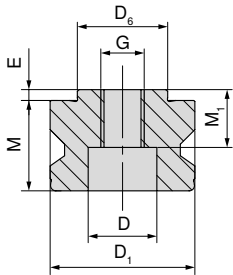
Vice guide

→ System accessories	→ Clamping lever
→ MNG clamping options	→ Screws
→ General top jaws	
→ Workpiece location	
→ General accessories	

Pull studs

▲ MNG – Mechanical Zero-point Clamping System

Scope of supply:
including fixation screws



D ₆ h6	D ₁ h6	M	M ₁	E	D	G
mm	mm	mm	mm	mm	mm	
25	40	27	17	3	19	M12

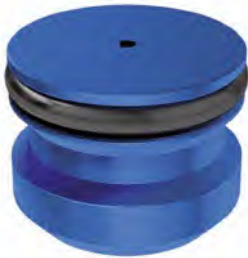
CW

80 899 ...

025

Bungs

▲ MNG – Mechanical Zero-point Clamping System



D ₁
mm
40

CW

80 899 ...

040

Sealing plug with O-ring

▲ MNG – Mechanical Zero-point Clamping System

MNG



G

M12

CW

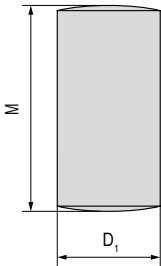
80 899 ...

126

Dowel Set

- ▲ MNG – Mechanical Zero-point Clamping System
- ▲ for ESG mini 4V tower and direct workpiece clamping
- ▲ Price per 2 Pieces

MNG



D ₁ m6	M
mm	mm
12	24

CW

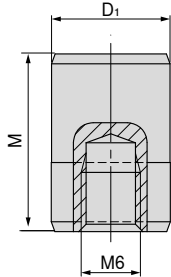
80 899 ...

120

Indexing bolt

▲ MNG – Mechanical Zero-point Clamping System

MNG





D ₁ mm	M mm
12	18

CW

80 899 ...

51500

Clamping Screw Set for T-slot

▲ MNG – Mechanical Zero-point Clamping System

Scope of supply:
Clamping screw and T-Nuts

MNG



for slot width mm	G
12	M8
12	M10
14	M8
14	M12
16	M8
16	M12
18	M8
18	M12

CW

80 899 ...

63800

63400

63900

63500 ¹⁾

64000

63600 ¹⁾

64100

63700 ¹⁾

1) With low head screws

Clamping set for 14 mm T-slot

- ▲ MNG – Mechanical Zero-point Clamping System
- ▲ T-nuts are modified for 63 mm slot pitch
- ▲ Price per 2 Pieces

MNG



for slot width mm	A mm
14	63

CW
80 899 ...
614

Alignment/centering set for T-slots

- ▲ A = groove spacing

Scope of supply:
1 Terminal block, 2 T-nuts, 2 screws, 2 washers for width 12 mm, without clamping strip!

MNG



A mm	for slot width mm
50	12
50	14
50	16
50	18
100	12
100	14
100	16
100	18

CW
80 899 ...
012 ¹⁾
014
016
018
81200
81400
81600
81800

1) For 12 mm width excluding clamping strip

Round claw

- ▲ MNG – Mechanical Zero-point Clamping System
- ▲ Two pieces contained in set
- ▲ Price per 2 pieces

MNG

CW

80 899 ...

300

MNG

Replacement clamping unit

- ▲ MNG – Mechanical Zero-point Clamping System
- ▲ Three-part set
- ▲ for MNG round

MNG

CW

80 899 ...

026

MNG

MNG clamping options

MNG – Base plate, rectangular

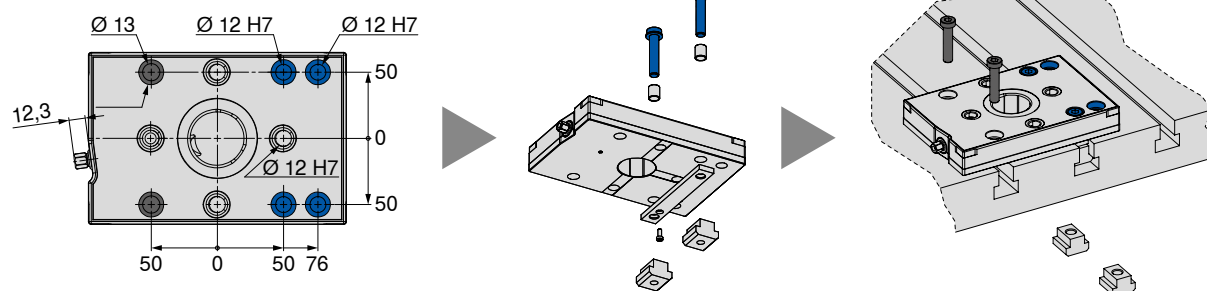
Mounting:

● 2 x M12 low head screws

● 1 x Alignment and centring set



→ Here you will find the suitable screws.



MNG – Base plate, rectangular 2-location

Mounting:

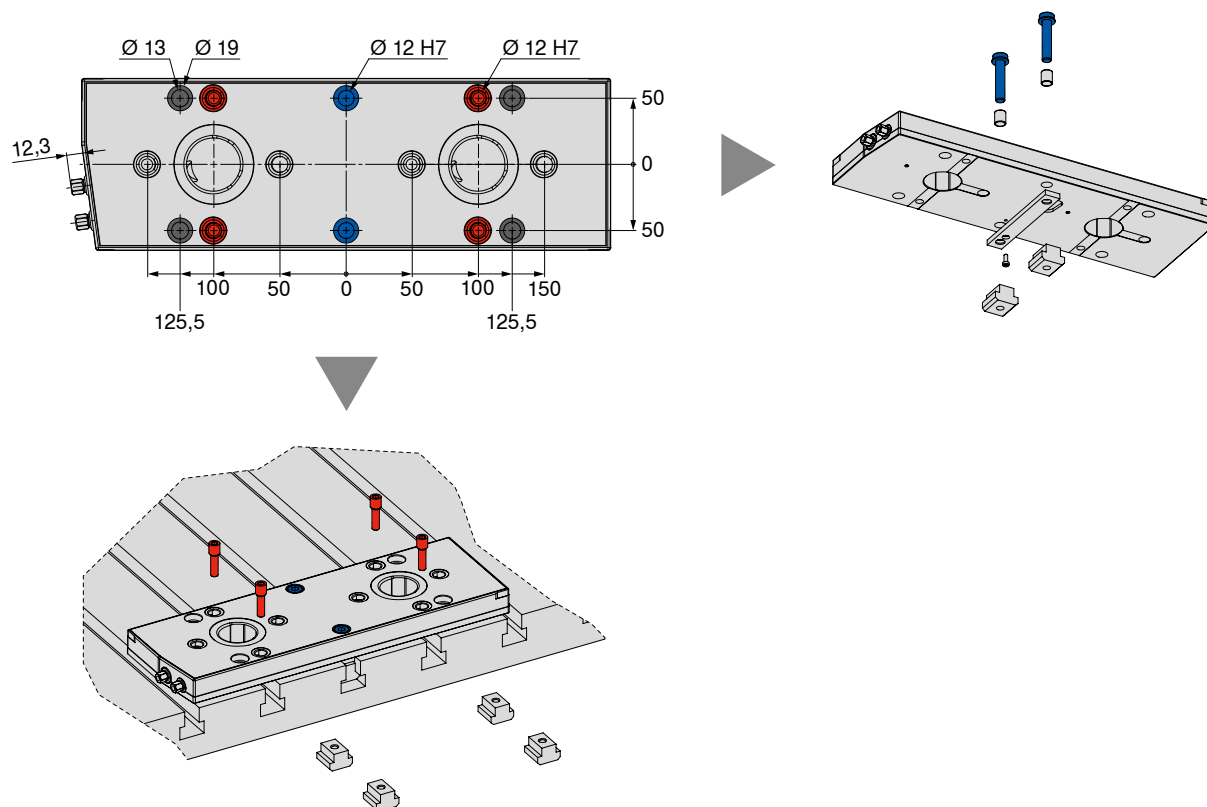
● 4 x M12 low head screws

● 1 x Alignment and centring set

● 4 x M8 MNG special screws



→ Here you will find the suitable screws.



MNG clamping options

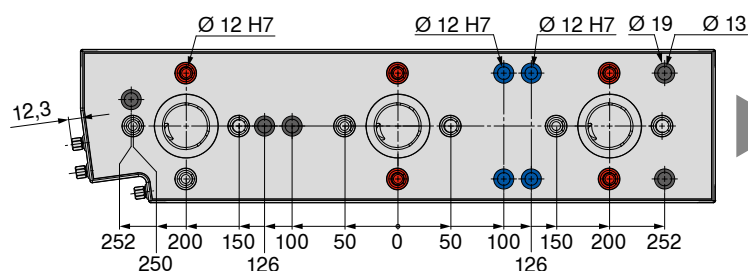
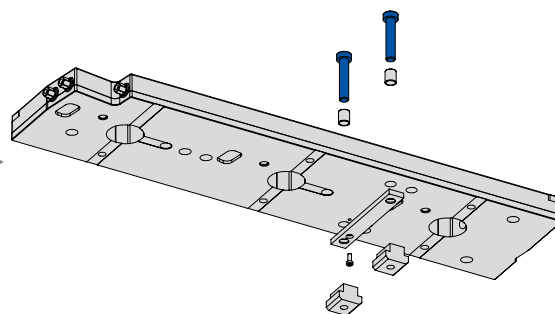
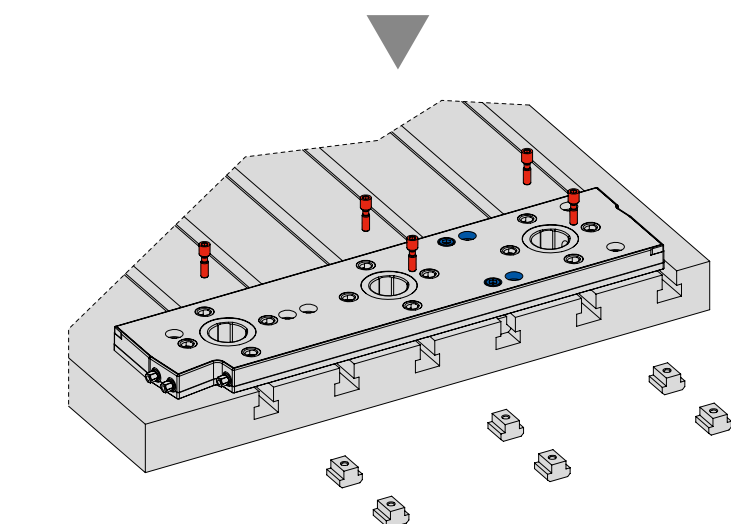
MNG – Base plate, rectangular 3-location

Mounting:

- 5 x M12 low head screws
- 1 x Alignment and centring set
- 5 x M8 MNG special screws



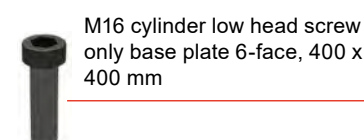
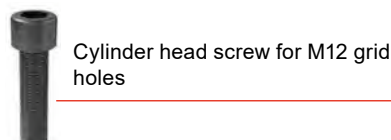
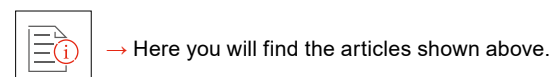
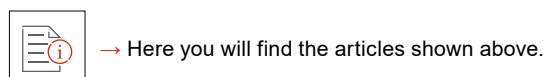
→ Here you will find the suitable screws.



MNG clamping options

T-slot table – spacing of 126 mm / 63 mm													
	12 mm			14 mm			16 mm			18 mm			
													
	Alignment and centring set spacing 100 mm 80 899 81200	Clamping set with M10 low head screws 80 899 63400	Clamping set with M8 MNG special screws 80 899 63800	Alignment and centring set spacing 100 mm 80 899 81400	Clamping set with M12 low head screws 80 899 63500	Clamping set with M8 MNG special screws 80 899 63900	Alignment and centring set spacing 100 mm 80 899 81600	Clamping set with M12 low head screws 80 899 63600	Clamping set with M8 MNG special screws 80 899 64000	Alignment and centring set spacing 100 mm 80 899 81800	Clamping set with M12 low head screws 80 899 63700	Clamping set with M8 MNG special screws 80 899 64100	
	MNG – Base plate, rectangular	1 x	2 x	—	1 x	2 x	—	1 x	2 x	—	1 x	2 x	—
	MNG – Base plate, rectangular 2-location	1 x	4 x	—	1 x	4 x	—	1 x	4 x	—	1 x	4 x	—
	MNG – Base plate, rectangular 3-location	1 x	4 x	2 x	1 x	4 x	2 x	1 x	4 x	2 x	1 x	4 x	2 x

T-slot table – spacing of 100 mm / 50 mm													
	12 mm			14 mm			16 mm			18 mm			
													
	Alignment and centring set spacing 100 mm 80 899 81200	Clamping set with M10 low head screws 80 899 63400	Clamping set with M8 MNG special screws 80 899 63800	Alignment and centring set spacing 100 mm 80 899 81400	Clamping set with M12 low head screws 80 899 63500	Clamping set with M8 MNG special screws 80 899 63900	Alignment and centring set spacing 100 mm 80 899 81600	Clamping set with M12 low head screws 80 899 63600	Clamping set with M8 MNG special screws 80 899 64000	Alignment and centring set spacing 100 mm 80 899 81800	Clamping set with M12 low head screws 80 899 63700	Clamping set with M8 MNG special screws 80 899 64100	
	MNG – Base plate, rectangular	1 x	2 x	—	1 x	2 x	—	1 x	2 x	—	1 x	2 x	—
	MNG – Base plate, rectangular 2-location	1 x	—	4 x	1 x	—	4 x	1 x	—	4 x	1 x	—	4 x
	MNG – Base plate, rectangular 3-location	1 x	1 x	5 x	1 x	1 x	5 x	1 x	1 x	5 x	1 x	1 x	5 x

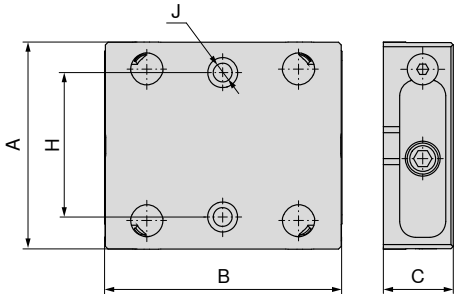


CoreLine – Base plate, rectangular – MNG mini

▲ Order mounting bolts separately

MNG
mini

52 x 52



A	B	C $\pm 0,005$	H $\pm 0,01$	J F7	WT
mm	mm	mm	mm	mm	kg
80	100	27	50	12	1,36

CW

80 915 ...

75200

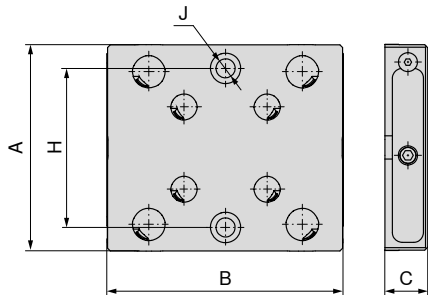
CoreLine – Combi-insert – MNG mini

▲ Order mounting bolts separately

MNG
mini

52 x 52

96 x 96



A	B	C $\pm 0,005$	H $\pm 0,01$	J F7	WT
mm	mm	mm	mm	mm	kg
130	148	27	100	12	3,43

CW

80 915 ...

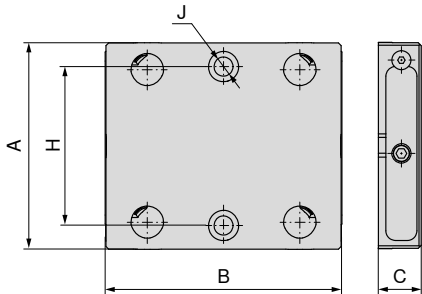
75900

CoreLine – Base plate, rectangular – MNG mini

▲ Order mounting bolts separately

MNG mini

96 x 96



A	B	C $\pm 0,005$	H $\pm 0,01$	J F7	WT
mm	mm	mm	mm	mm	kg
130	148	27	100	12	3,59

CW
80 915 ...
79600

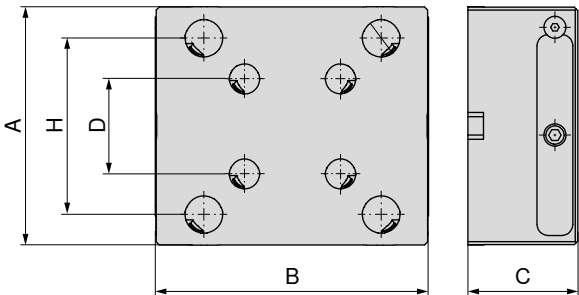
CoreLine – Combi-5-axis-increase – MNG mini

▲ Order mounting bolts separately

MNG mini

52 x 52

96 x 96



A	B	C	D	H
mm	mm	mm	mm	mm
130	148	60	52	96
130	148	100	52	96

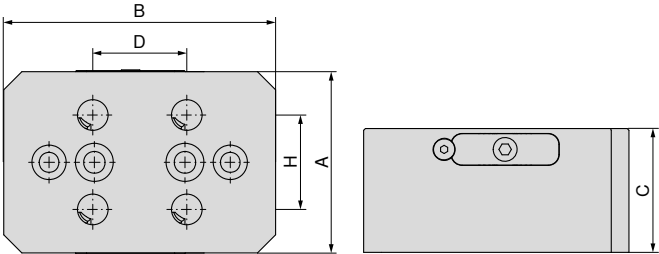
CW
80 915 ...
56000
51000

CoreLine – Console – MNG mini

- ▲ With integrated MNG mini zero point clamping system
- ▲ Order mounting bolts separately
- ▲ Material: hard-anodised aluminium

MNG mini

52 x 52



A	B	C	D	H
mm	mm	mm	mm	mm
100	150	70	52	52

CW

80 915 ...

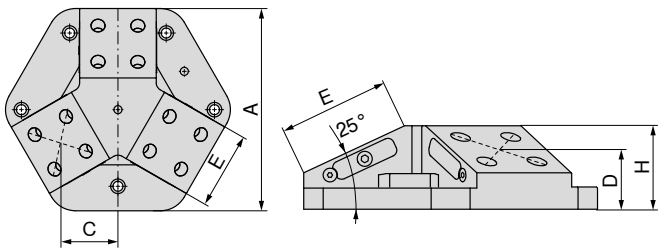
57000

CoreLine – Three-sided pyramid – MNG mini

- ▲ Incl. 3 x MNG mini zero point clamping systems
- ▲ Order mounting bolts separately
- ▲ Material: hard-anodised aluminium

MNG mini

52 x 52



A	C	D	E	H
mm	mm	mm	mm	mm
264	86,68	53,87	100	75

CW

80 915 ...

58000

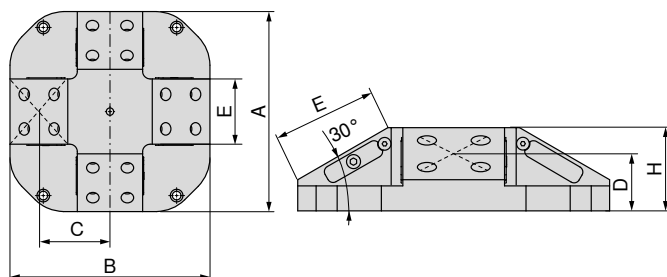


Suitable for: ESG 5 – 80 L-130 / ZSG 4 – 80 L-130 / ZSG mini – 70 L-80 / ZSG mini – 70 L-100

CoreLine – Four-sided pyramid – MNG mini

- ▲ Incl. 4 x MNG mini zero point clamping systems
- ▲ Order mounting bolts separately
- ▲ Material: hard-anodised aluminium

**MNG
mini** 52 x 52



A	B	C	D	E	H
mm	mm	mm	mm	mm	mm
300	300	106,7	55	100	80



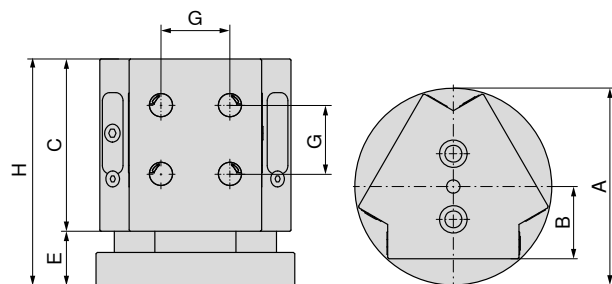
CW

80 915 ...
57500

CoreLine – Triangular tombstone – MNG mini

- ▲ Incl. 3 x MNG mini zero point clamping systems
- ▲ Order mounting bolts separately
- ▲ Material: hard-anodised aluminium

**MNG
mini** 52 x 52



A	B	C	E	G	H
mm	mm	mm	mm	mm	mm
148	55	130	41	52	171



CW

80 915 ...
51700



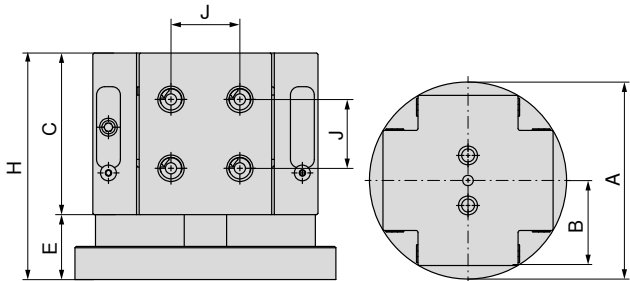
Suitable for: ESG 5 – 80 L-130 / ZSG 4 – 80 L-130 / ZSG mini – 70 L-80 / ZSG mini – 70 L-100

CoreLine – 4-sided clamping tower – MNG mini

- ▲ Incl. 4 x MNG mini zero point clamping systems
- ▲ Order mounting bolts separately
- ▲ Material: hard-anodised aluminium

MNG mini

52 x 52



A	B	C	E	G _{H7}	H	J _{±0.015}
mm	mm	mm	mm	mm	mm	mm
197	85	122	49	12	171	52

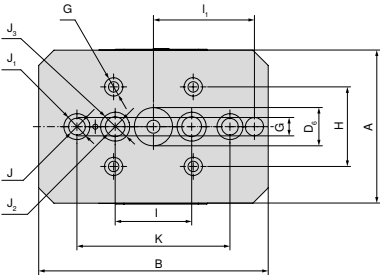
CW

80 915 ...

54000

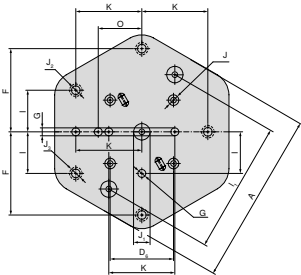
MNG mini underside dimensions

Console



A	B	D ₆	G	H	I	I ₁	J	J ₁	J ₂	J ₃	K
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
100	150	25	12	52	50	66	11	17	13	19	100

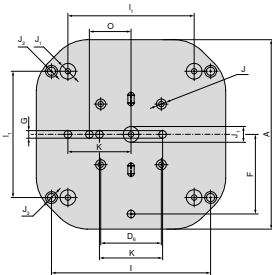
Three-sided pyramid



A	D ₆	F	G	I	I ₁	J	J ₁	J ₂	J ₃	K	O
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
264	96	126	12	63	200	16	25	13	19	100	66

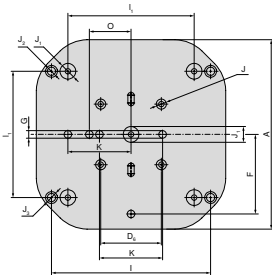
MNG mini underside dimensions

Four-sided pyramid



A	D ₆ ±0,015	F	G H ₇	I	I ₁ ±0,015	J H ₇	J ₁ H ₇	J ₂	J ₃	K ±0,015	O ±0,015
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
300	96	126	12	252	200	16	25	13	19	100	66

Triangular tombstone



A	D ₆	F H ₇	I ±0,015	J ₁ H ₇	J ₂	J ₃	K ±0,015	O ±0,015
mm	mm	mm	mm	mm	mm	mm	mm	mm
148	50	12	52	25	13	19	100	66

System accessories overview

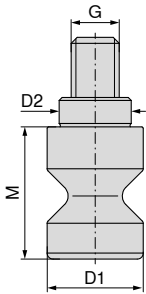
MNG mini mounting bolt set

Scope of supply:
Set contains four mounting bolts

MNG
mini

52 x 52

96 x 96



D ₁ h6 mm	D ₂ h6 mm	M mm	G mm	TQX Nm	Clamping force kN
16	12	22	M8	18	15
20	16	22	M10	18	15

CW

80 915 ...

51600

51100

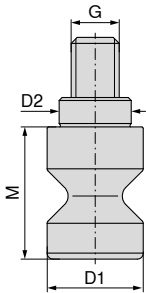
Mounting bolt set – LANG / HWR

Scope of supply:
Set contains four mounting bolts

MNG
mini

52 x 52

96 x 96



D ₁ h6 mm	D ₂ h6 mm	M mm	G mm	TQX Nm	Clamping force kN
15	12	22		18	15
19	16	22	M10	18	15

CW

80 915 ...

51500

51400

System accessories overview

Alignment/centering set for T-slots

▲ A = groove spacing

Scope of supply:
1 Terminal block, 2 T-nuts, 2 screws, 2 washers for width 12 mm, without clamping strip!



A	for slot width	CW
mm	mm	
35	12	80 915 ...
35	14	82200
35	16	82400
		82600
40	18	82800
100	12	81200
100	14	81400
100	16	81600
100	18	81800

Clamping Screw Set for T-slot for MNG mini

Scope of supply:
Clamping screw and T-Nuts



for slot width	G	CW
mm		
12	M10	80 915 ...
14	M12	61200
16	M12	61400
18	M12	61600
		61800

System accessories overview

Expansion aid

MNG
mini



D ₁ mm	M mm	
15	40	

CW

80 915 ...

51300

Protection plugs

▲ Protective cover to shield changeover interface

Scope of supply:
Set contains four sealing plugs

MNG
mini

52 x 52

96 x 96



for size	D mm	H mm	
52x52	16	18	
96x96	20	18	

CW

80 915 ...

52100

52200

System accessories overview

Cover disc

Scope of supply:
Set contains 20 cover discs



D	H
mm	mm
20	1,85

CW
80 915 ...
52000

Clamping Screw Set for T-slot for MNG mini

Scope of supply:
Clamping screw and T-Nuts



for slot width	G
mm	
14	M12
16	M12
18	M12

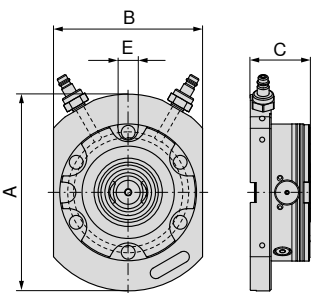
CW
80 915 ...
62400
62600
62800

CoreLine – 1-position clamping station – PNG

- ▲ PNG – Pneumatic zero point clamping system
- ▲ Insertion force 8 kN
- ▲ Insertion force with turbo 28 kN
- ▲ Unlocking pressure 6 bar
- ▲ Air connection G 1/8

Scope of supply:
Clamping station, fixing clamps, sealing nipple, pneumatic plug connections, dust covers, operating instructions; without clamping bolt, without indexing bolt

PNG





A	B	C	E _{H7}	WT
mm	mm	mm	mm	kg
198	150	60	20	7

CW

80 809 ...

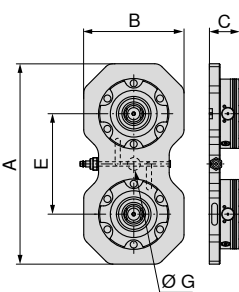
01100

CoreLine – 2-position clamping station – PNG

- ▲ PNG – Pneumatic zero point clamping system
- ▲ Insertion force 16 kN
- ▲ Unlocking pressure 6 bar
- ▲ Air connection G 1/8

Scope of supply:
Clamping station, fixing clamps, sealing nipple, pneumatic plug connections, dust covers, operating instructions; without clamping bolt, without indexing bolt

PNG





A	B	C	E	G _{H7}	WT
mm	mm	mm	mm	mm	kg
399	199	60	200	25	16,9

CW

80 809 ...

02100

CoreLine – 4-position clamping station – PNG

- ▲ PNG – Pneumatic zero point clamping system
- ▲ Insertion force 32 kN
- ▲ Unlocking pressure 6 bar
- ▲ Air connection G 1/8

Scope of supply:
Clamping station, fixing clamps, sealing nipple, pneumatic plug connections, dust covers, operating instructions; without clamping bolt, without indexing bolt

PNG

CW

80 809 ...

04100

A	B	C	E	G H7	H	WT
mm	mm	mm	mm	mm	mm	kg
399	399	60	200	25	11	35,7

CoreLine – 6-position clamping station – PNG

- ▲ PNG – Pneumatic zero point clamping system
- ▲ Insertion force 48 kN
- ▲ Unlocking pressure 6 bar
- ▲ Air connection G 1/8

Scope of supply:
Clamping station, fixing clamps, sealing nipple, pneumatic plug connections, dust covers, operating instructions; without clamping bolt, without indexing bolt

PNG

CW

80 809 ...

06100

A	B	C	E	G H7	H	I	WT
mm	mm	mm	mm	mm	mm	mm	kg
599	399	60	200	25	11	200	54,4

CoreLine – Zero point clamping module SM.138 – PNG

- ▲ PNG – Pneumatic zero point clamping system
- ▲ Insertion force 8 kN
- ▲ Insertion force with turbo 28 kN
- ▲ Unlocking pressure 6 bar
- ▲ Air connection G 1/8
- ▲ Repeatability 0.005

Scope of supply:
Clamping module, fixing screws, O-rings, cover caps, operating instructions; without clamping bolts

PNG



A	B	C	D	E	G	WT
mm	mm	mm	mm	mm		kg
138	110	55,7	39	121	G1/8"	4,4

CW

80 809 ...

10100

CoreLine – Zero point clamping module SM.V.138 – PNG

- ▲ PNG – Pneumatic zero point clamping system
- ▲ Insertion force 8 kN
- ▲ Insertion force with turbo 28 kN
- ▲ Unlocking pressure 6 bar
- ▲ Air connection G 1/8
- ▲ Repeatability 0.005

Scope of supply:
Clamping module, fixing screws, dowel screw, O-rings, cover caps, operating instructions; without clamping bolts, without indexing bolt

PNG



A	B	C	D	E	G	WT
mm	mm	mm	mm	mm		kg
138	110	55,7	39	121	G1/8"	4,4

CW

80 809 ...

11100

CoreLine – Zero point clamping system SM.T.138 – PNG

- ▲ PNG – Pneumatic zero point clamping system
- ▲ Insertion force 7 kN
- ▲ Insertion force with turbo 24 kN
- ▲ Unlocking pressure 6 bar
- ▲ Air connection G 1/8
- ▲ Repeatability 0.005

Scope of supply:
Clamping module, fixing screws, O-rings, cover caps, operating instructions; without clamping bolts

PNG



A	B	C	D	E	G	WT
mm	mm	mm	mm	mm		kg
138	110	59	11	121	G1/8"	3,5

CW

80 809 ...

12100

CoreLine – Aluminium form collet – PNG

- ▲ PNG – Pneumatic zero point clamping system
- ▲ Max. clamping force 50 kN
- ▲ Repeatability 0.005
- ▲ Clamping stroke 0.5 mm
- ▲ Aluminium

Scope of supply:
Aluminium form collet, adjustment ring, clamping bolt, indexing bolt, operating instructions

PNG



A	WT
mm	kg
149	1,5

CW

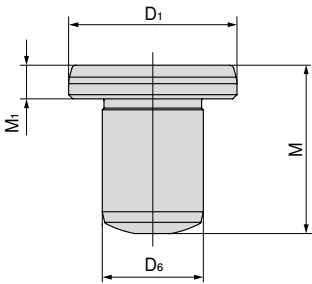
80 809 ...

07600

Indexing bolt

▲ PNG – Pneumatic zero point clamping system

PNG



D_1 h5	M	M_1	D_6 m6
mm	mm	mm	mm
20	15	4	12

CW

80 809 ...

073

Assembly – Clamping bolts

The workpieces or devices being assembled are positioned and fixed with three different clamping bolts:



Centring bolt
Precision-ground, used to precisely position the clamping device.



Positioning bolt
This bolt, which is also known as a diamond bolt, is only ground in an axial direction so that the system is not overloaded.



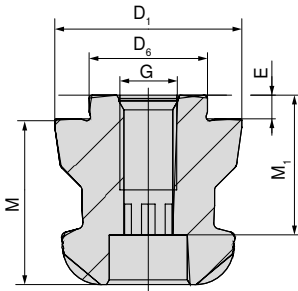
Locking bolt
Ensures that the pallets lie flat on the clamping system. Ground smaller to short taper.

Clamping bolt

- ▲ PNG – Pneumatic zero point clamping system
- ▲ Three bolt types – ZB (centring bolt), PB (positioning bolt), HB (clamping bolt)
- ▲ Precision location bolts ensuring accuracy and repeatability
- ▲ Clamping force 50 kN

Scope of supply:
Incl. M10 fixing screw

PNG



Type	D ₆ h6 mm	D ₁ h6 mm	M mm	M ₁ mm	E mm	G
ZB	25	40	35	27	5	M12
PB	25	40	35	27	5	M12
HB	25	40	35	27	5	M12

CW

80 809 ...

070

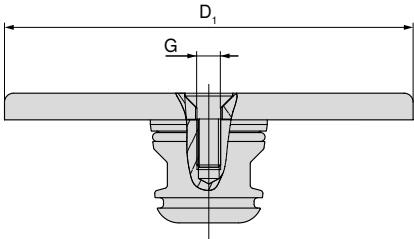
071

072

Protective cover

- ▲ PNG – Pneumatic zero point clamping system
- ▲ Protective cover for the interchangeable interface

PNG



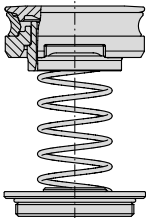


D ₁ mm	G	CW
138	M8	80 809 ... 074

Cone seal

- ▲ PNG – Pneumatic zero point clamping system
- ▲ Protective cover for the interchangeable interface

PNG



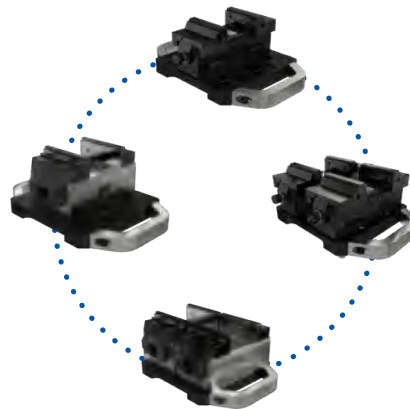


WT kg	CW
0,11	80 809 ... 07500

Overview of multi-adapter pallets



Multi-adapter pallet 159 x 159 mm



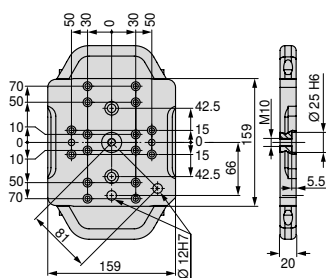
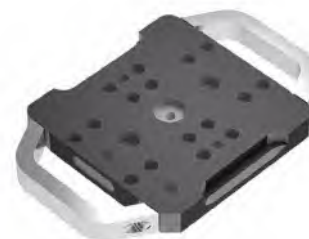
Application examples

CoreLine – Multi-adapter pallet

▲ Multi-adapter pallet for mounting PNG and MNG

Scope of supply:

Incl. clamping bolts and screws
without pull studs



Size	WT kg
159x159 mm	4

CW

80 809 ...

500

Mounting set – multi-adapter pallet

▲ price per set



for
ZSG-4.80

CW

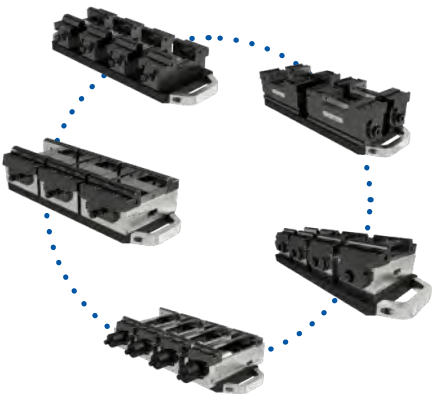
80 878 ...

503

Overview of multi-adapter pallets



Multi-adapter pallet 399 x 159 mm

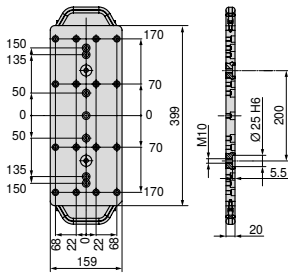


Application examples

CoreLine – Multi-adapter pallet

▲ Multi-adapter pallet for mounting PNG and MNG

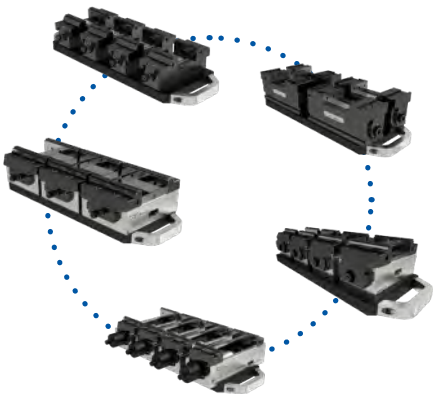
Scope of supply:
Incl. clamping bolts and screws
without pull studs



Size	WT kg
399x159 mm	10

CW
80 809 ...
501

Overview of multi-adapter pallets

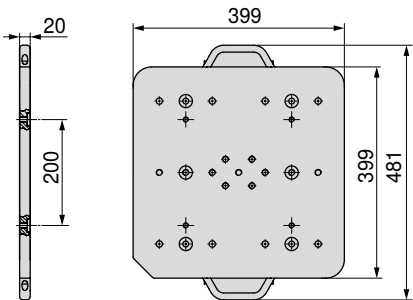


Application examples

CoreLine – Multi-adapter pallet

▲ Multi-adapter pallet for mounting PNG and MNG

Scope of supply:
Incl. clamping bolts and screws
without pull studs



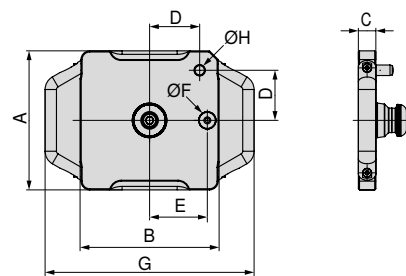
Size	WT
399x399 mm	25 kg

CW
80 809 ...
502

CoreLine – Steel clamping pallet

- ▲ Clamping pallet for mounting PNG
- ▲ Without hole pattern

Scope of supply:
Unmachined clamping pallet, PNG clamping bolt and positioning pin



Size	A	B	C	D	E	F _{H5}	G	H _{m6}	WT
	mm	mm	mm	mm	mm	mm	mm	mm	kg
159x159 mm	159	159	20	58	66	20	239	12	4,2

CW

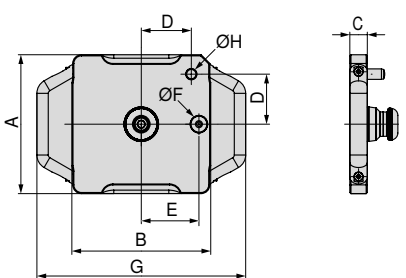
80 809 ...

080

CoreLine – Aluminium clamping pallet

- ▲ Clamping pallet for mounting PNG
- ▲ Without hole pattern

Scope of supply:
Unmachined clamping pallet, PNG clamping bolt and positioning pin



Size	A	B	C	D	E	F _{H5}	G	H _{m6}	WT
	mm	mm	mm	mm	mm	mm	mm	mm	kg
159x159 mm	159	159	25	58	66	20	239	12	2,2

CW

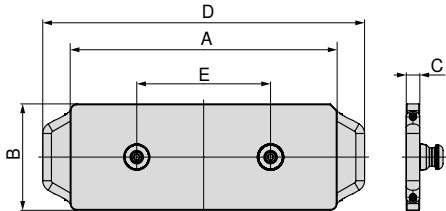
80 809 ...

081

CoreLine – Steel clamping pallet

- ▲ Clamping pallet for mounting PNG and MNG
- ▲ Without hole pattern

Scope of supply:
Unmachined clamping pallet, PNG clamping bolt and positioning pin



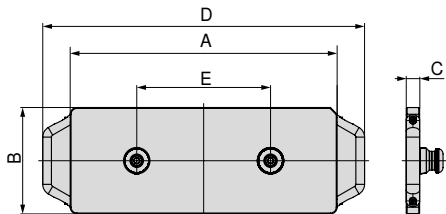
Size	A	B	C	D	E	WT
	mm	mm	mm	mm	mm	kg
399x159 mm	399	159	20	481	200	10,6

CW
80 809 ...
082

CoreLine – Aluminium clamping pallet

- ▲ Clamping pallet for mounting PNG and MNG
- ▲ Without hole pattern

Scope of supply:
Unmachined clamping pallet, PNG clamping bolt and positioning pin



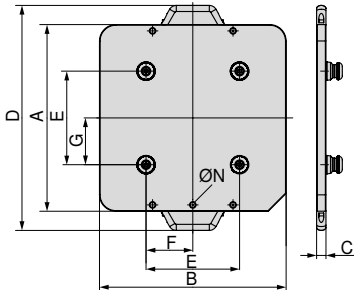
Size	A	B	C	D	E	WT
	mm	mm	mm	mm	mm	kg
399x159 mm	399	159	25	481	200	5,1

CW
80 809 ...
083

CoreLine – Steel clamping pallet

- ▲ Clamping pallet for mounting PNG and MNG
- ▲ Without hole pattern

Scope of supply:
Unmachined clamping pallet, PNG clamping bolt and positioning pin



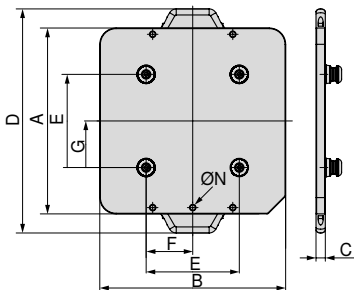
Size	A	B	C	D	E	F	G	N	WT
	mm	mm	mm	mm	mm	mm	mm		kg
399x399 mm	399	399	20	481	200	100	100	M10	28

CW
80 809 ...
084

CoreLine – Aluminium clamping pallet

- ▲ Clamping pallet for mounting PNG and MNG
- ▲ Without hole pattern

Scope of supply:
Unmachined clamping pallet, PNG clamping bolt and positioning pin



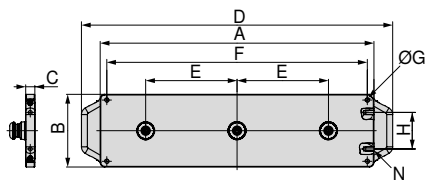
Size	A	B	C	D	E	F	G	N	WT
	mm	mm	mm	mm	mm	mm	mm		kg
399x399 mm	399	399	25	481	200	100	100	M10	12

CW
80 809 ...
085

CoreLine – Steel clamping pallet

- ▲ Clamping pallet for mounting PNG and MNG
- ▲ Without hole pattern

Scope of supply:
Unmachined clamping pallet, PNG clamping bolt and positioning pin



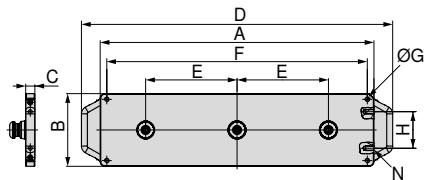
Size	A	B	C	D	E	F	G	H	N	WT
	mm	mm	mm	mm	mm	mm		mm		kg
599x159 mm	599	159	20	681	200	570	M10	80	M10	15,6

CW
80 809 ...
086

CoreLine – Aluminium clamping pallet

- ▲ Clamping pallet for mounting PNG and MNG
- ▲ Without hole pattern

Scope of supply:
Unmachined clamping pallet, PNG clamping bolt and positioning pin

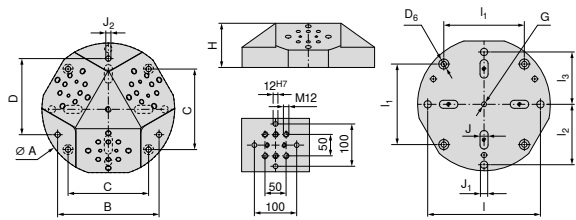


Size	A	B	C	D	E	F	G	H	N	WT
	mm	mm	mm	mm	mm	mm		mm		kg
599x159 mm	599	159	25	681	200	570	M10	80	M10	7,4

CW
80 809 ...
087

CoreLine – pyramid 3-fold 30°

- ▲ Order mounting bolts separately
- ▲ Material: Hard-anodized aluminum



A	B	C	D	D ₆ H7	G H7	H	I	I ₁ ±0,015	I ₂	I ₃	J H7	J ₁ H7	J ₂	WT
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kg
330	252	200	189	25	12	110	280	200	150	130	20	18	13	17,5

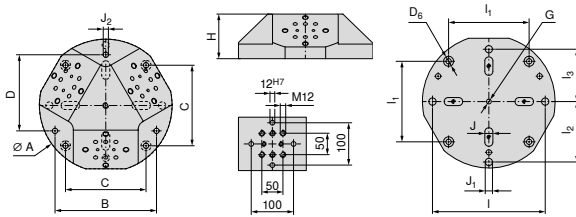
CW

80 911 ...

70500

CoreLine – pyramid 3-fold 40°

- ▲ Order mounting bolts separately
- ▲ Material: Hard-anodized aluminum



A	B	C	D	D ₆ H7	G H7	H	I	I ₁ ±0,015	I ₂	I ₃	J H7	J ₁ H7	J ₂	WT
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kg
330	252	200	189	25	12	110	300	200	150	45	20	18	13	16,1

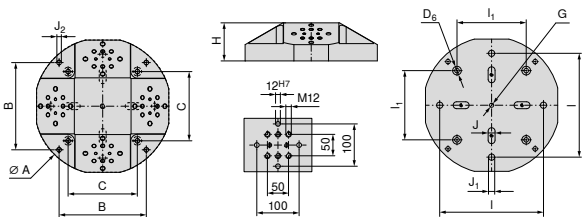
CW

80 911 ...

70600

CoreLine – pyramid 4-fold 30°

- ▲ Order mounting bolts separately
- ▲ Material: Hard-anodized aluminum



A	B	C	D ₆ H7	G H7	H	I	I ₁ ±0,015	J H7	J ₁ H7	J ₂	WT
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kg
395	252	200	25	12	110	300	200	20	18	13	26,5

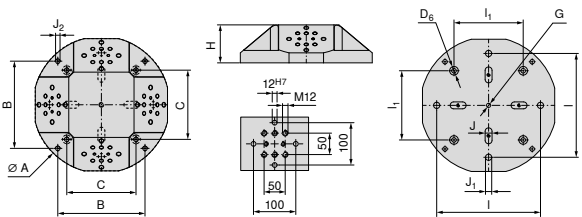
CW

80 911 ...

71000

CoreLine – pyramid 4-fold 40°

- ▲ Order mounting bolts separately
- ▲ Material: Hard-anodized aluminum



A	B	C	D ₆ H7	G H7	H	I	I ₁ ±0,015	J H7	J ₁ H7	J ₂	WT
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kg
395	252	200	25	12	110	250	200	20	18	13	24,8

CW

80 911 ...

71100

CoreLine – Cruciform tombstone

▲ For positioning on a 500 x 500 mm machine table with edge locator stops, both spacer plates **8091101000** and **8091101100** must be fitted on the side of the base plate.

NCG

A	B	C	E	H	I	WT
mm	mm	mm	mm	mm	mm	kg
400	326	390	100	559	125	225,5
400	326	390	100	559	125	225,0

CW

80 890 ...

51100 ¹⁾

51000 ¹⁾

1) Not ex-stock

CoreLine – Cruciform tombstone

▲ For positioning on a 500 x 500 mm machine table with edge locator stops, both spacer plates **8091101000** and **8091101100** must be fitted on the side of the base plate.

ESG
4

A	B	C	E	H	I	WT
mm	mm	mm	mm	mm	mm	kg
400	246	362	100	523	125	160,5
400	246	362	100	523	125	160,0

CW

80 901 ...

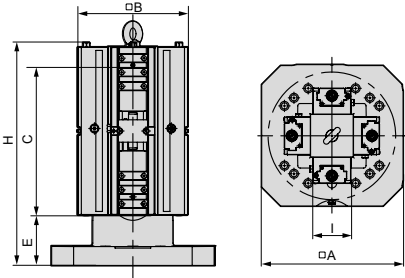
55100 ¹⁾

55000 ¹⁾

1) Not ex-stock

CoreLine – Cruciform tombstone

DSG
4



A	B	C	E	H	I	WT
mm	mm	mm	mm	mm	mm	kg
300	201	300	90	298	80	76

CW

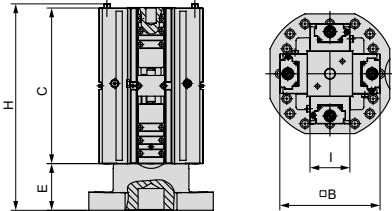
80 906 ...

55000 ¹⁾

1) Not ex-stock

CoreLine – Cruciform tombstone

DSG
4



A	B	C	E	H	I	WT
mm	mm	mm	mm	mm	mm	kg
300	90	201	100	523	80	68,2
300	90	201	100	523	80	68,0

CW

80 906 ...

55200 ¹⁾

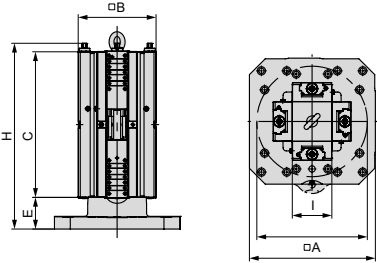
55100 ¹⁾

1) Not ex-stock

CoreLine – Cruciform tombstone

▲ For positioning on a 500 x 500 mm machine table with edge locator stops, both spacer plates **8091101000** and **8091101100** must be fitted on the side of the base plate.

DSG
4



A	B	C	E	H	I	WT
mm	mm	mm	mm	mm	mm	kg
400	246	460	100	587	125	190,5
400	246	390	100	517	125	170,0
400	246	390	100	517	125	170,5
400	246	460	100	587	125	190,0
400	246	530	100	657	125	210,0
400	246	530	100	657	125	210,5

CW

80 906 ...

55600 ¹⁾

55300 ¹⁾

55400 ¹⁾

55500 ¹⁾

55700 ¹⁾

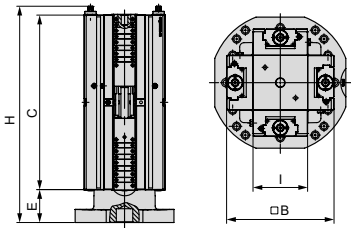
55800 ¹⁾

1)

Not ex-stock

CoreLine – Cruciform tombstone

DSG
4



B	C	E	H	I	WT
mm	mm	mm	mm	mm	kg
246	390	100	517	125	190

CW

80 906 ...

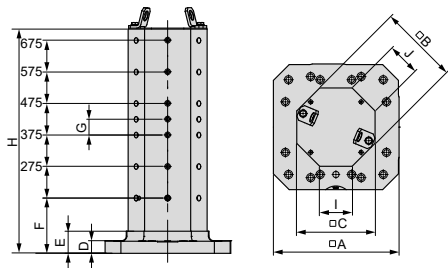
55900 ¹⁾

1)

Not ex-stock

CoreLine – Octagonal tombstone

▲ reduced grid pattern



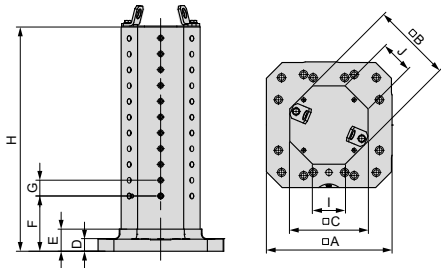
A	B ±0.02	C ±0.02	D	E	F	G	H	I	J	WT
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kg
400	280	250	40	70	175	50	710	104	104	150
500	280	250	40	70	175	50	710	104	104	175

CW
80 911 ...
646 ¹⁾
651 ¹⁾

1) Not ex-stock

CoreLine – Octagonal tombstone

▲ 8 faces, 50 mm grid pattern
▲ Coordinates of the grid holes numbered (horizontal: letter, vertical: number)



A	B ±0.02	C ±0.02	D	E	F	G	H	I	J	WT
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kg
500	355	340	40	70	175	50	1000	162	126	211

CW
80 911 ...
525 ¹⁾

1) Not ex-stock

CoreLine – Double sided tombstone

▲ 4 MNG square baseplates mounted on clamping faces

MNG

A	B ±0.02	C ±0.02	D	E	F ±0.005	G	G1	H	WT
mm	mm	mm	mm	mm	mm	mm	mm	mm	kg
400	160	380	40	70	30	200	300	710	240
500	160	380	40	70	30	200	300	710	265

CW

80 911 ...

575 ¹⁾

580 ¹⁾

1) Not ex-stock

CoreLine – Double sided tombstone

▲ 50 mm grid pattern
▲ Coordinates of the grid holes numbered (horizontal: letter, vertical: number)

A	B ±0.02	C ±0.02	D	E	F	G	H	WT
mm	mm	mm	mm	mm	mm	mm	mm	kg
400	160	380	40	70	150	50	710	190
500	160	380	40	70	150	50	710	215
500	220	480	40	70	150	50	1000	350

CW

80 911 ...

555 ¹⁾

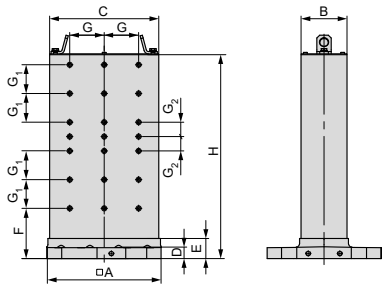
560 ¹⁾

505 ¹⁾

1) Not ex-stock

CoreLine – Double sided tombstone

▲ reduced grid pattern



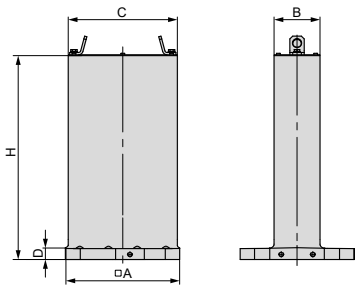
A	B ±0.02	C ±0.02	D	E	F	G	G ₁	G ₂	H	WT
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kg
400	160	380	40	70	175	120	100	50	710	192
500	160	380	40	70	175	120	100	50	710	217

CW
80 911 ...
565 ¹⁾
570 ¹⁾

1) Not ex-stock

CoreLine – Double sided tombstone

▲ rough clamping faces (unmachined)
▲ machined base



A	B ±0.02	C ±0.02	D	H	WT
mm	mm	mm	mm	mm	kg
400	170	390	40	710	221
500	170	390	40	710	244
500	220	490	40	1000	355

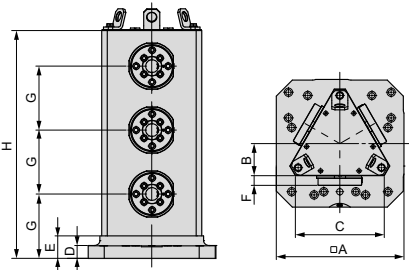
CW
80 911 ...
585 ¹⁾
590 ¹⁾
500 ¹⁾

1) Not ex-stock

CoreLine – Triangular tombstone

▲ 9 MNG round baseplates mounted on clamping faces

MNG



A	B ±0.02	C	D	E	F ±0.005	G	H	WT
mm	mm	mm	mm	mm	mm	mm	mm	kg
400	100	277	40	70	30	200	710	203
500	100	277	40	70	30	200	710	228

CW

80 911 ...

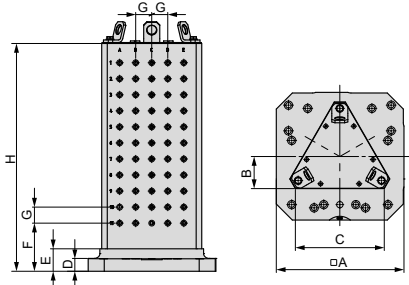
615 ¹⁾

620 ¹⁾

1) Not ex-stock

CoreLine – Triangular tombstone

- ▲ 50 mm grid pattern
- ▲ Coordinates of the grid holes numbered (horizontal: letter, vertical: number)



A	B ±0.02	C	D	E	F	G	H	WT
mm	mm	mm	mm	mm	mm	mm	mm	kg
400	100	277	40	70	150	50	710	170
500	100	277	40	70	150	50	710	195
500	100	277	40	70	150	50	1000	242

CW

80 911 ...

595 ¹⁾

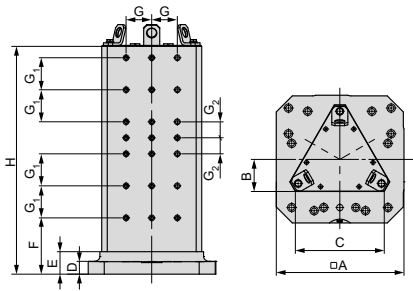
600 ¹⁾

535 ¹⁾

1) Not ex-stock

CoreLine – Triangular tombstone

▲ reduced grid pattern



A	B ±0.02	C	D	E	F	G	G ₁	G ₂	H	WT
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kg
400	100	277	40	70	175	80	100	50	710	172
500	100	277	40	70	175	80	100	50	710	197

CW

80 911 ...

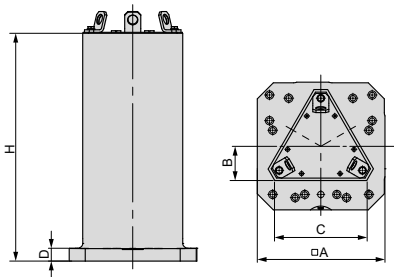
605 ¹⁾

610 ¹⁾

1) Not ex-stock

CoreLine – Triangular tombstone

▲ rough clamping faces (unmachined)
▲ machined base



A	B	C	D	H	WT
mm	mm	mm	mm	mm	kg
400	105	283	40	710	195
500	105	283	40	710	220
500	105	283	40	1000	278

CW

80 911 ...

625 ¹⁾

630 ¹⁾

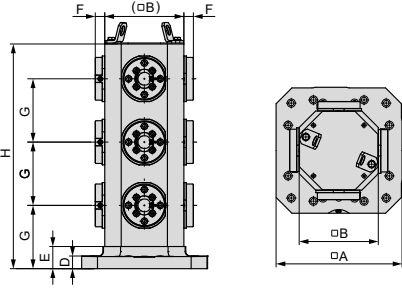
530 ¹⁾

1) Not ex-stock

CoreLine – Cruciform tombstone

▲ 12 MNG round baseplates mounted on clamping faces

MNG



A	B ±0.02	D	E	F ±0.005	G	H	WT
mm	mm	mm	mm	mm	mm	mm	kg
400	250	40	70	30	200	710	212
500	250	40	70	30	200	710	237

CW

80 911 ...

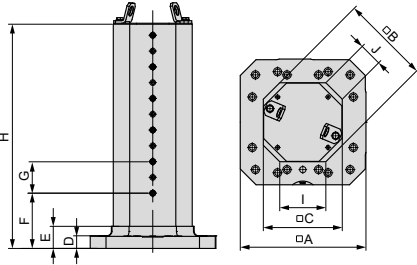
655 ¹⁾

660 ¹⁾

1) Not ex-stock

CoreLine – Cruciform tombstone

▲ 4 faces, reduced grid pattern



A	B ±0.02	C	D	E	F	G	H	I	J	WT
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kg
500	340	340	40	70	175	50	1000	162	126	295

CW

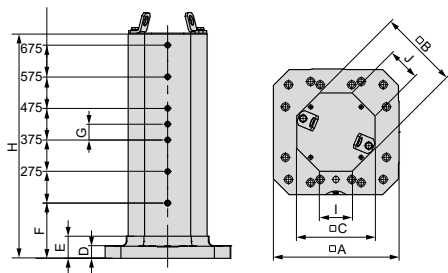
80 911 ...

510 ¹⁾

1) Not ex-stock

CoreLine – Cruciform tombstone

▲ reduced grid pattern



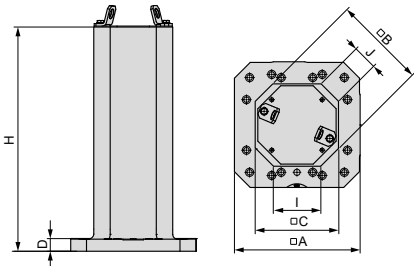
A	B ±0.02	C	D	E	F	G	H	I	J	WT
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kg
400	280	250	40	70	175	50	710	146	74	170
500	280	250	40	70	175	50	710	146	74	195

CW
80 911 ...
636 ¹⁾
641 ¹⁾

1) Not ex-stock

CoreLine – Cruciform tombstone

▲ rough clamping faces (unmachined)
▲ machined base



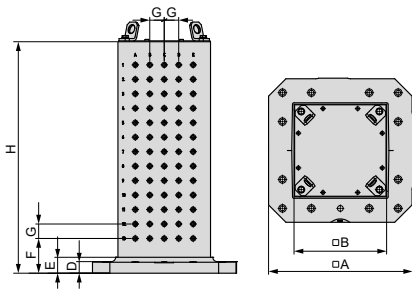
A	B	C	D	H	I	J	WT
mm	mm	mm	mm	mm	mm	mm	kg
400	290	260	40	710	150	76	195
500	290	260	40	710	150	76	220
500	355	350	40	1000	150	76	279

CW
80 911 ...
665 ¹⁾
670 ¹⁾
520 ¹⁾

1) Not ex-stock

CoreLine – Cube tombstone

- ▲ 50 mm grid pattern
- ▲ Coordinates of the grid holes numbered (horizontal: letter, vertical: number)



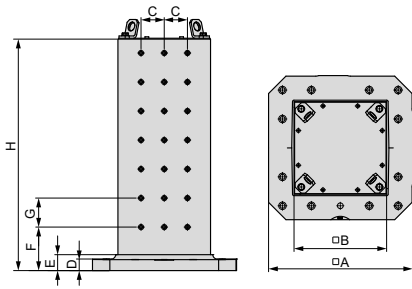
A	B ± 0.02	D	E	F	G	H	WT
mm	mm	mm	mm	mm	mm	mm	kg
400	250	40	55	120	50	600	155
500	320	40	55	120	50	800	276
500	320	40	55	120	50	1000	327

CW
80 911 ...
675 ¹⁾
680 ¹⁾
550 ¹⁾

1) Not ex-stock

CoreLine – Cube tombstone

- ▲ reduced grid pattern



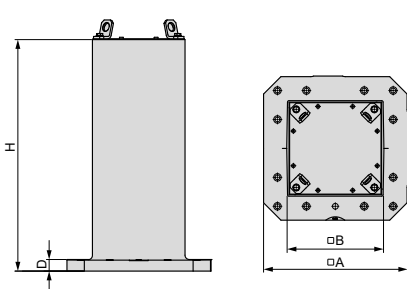
A	B ± 0.02	C	D	E	F	G	H	WT
mm	mm	mm	mm	mm	mm	mm	mm	kg
400	250	70	40	55	135	100	600	157
500	320	80	40	55	150	100	800	279
500	320	80	40	55	150	100	1000	331

CW
80 911 ...
685 ¹⁾
690 ¹⁾
540 ¹⁾

1) Not ex-stock

CoreLine – Cube tombstone

- ▲ rough clamping faces (unmachined)
- ▲ machined base



A	B	D	H	WT
mm	mm	mm	mm	kg
400	260	40	600	180
500	330	40	800	320
500	330	40	1000	385

CW

80 911 ...

695 ¹⁾

700 ¹⁾

545 ¹⁾

1) Not ex-stock

Distance plate

▲ base plate 500 x 500 mm



Size	WT kg
250X50X36 mm	3,4

CW

80 911 ...

01000 ¹⁾

1) Not ex-stock

Distance Plate narrow

▲ base plate 500 x 500 mm



Size	WT kg
100X50X36 mm	1,3

CW

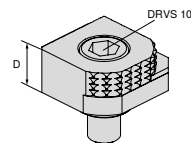
80 911 ...

01100 ¹⁾

1) Not ex-stock

6 function indexable jaw

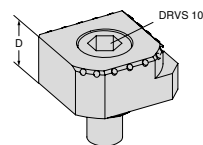
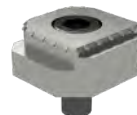
- ▲ 1 = Smooth, carbide coated
- ▲ 2 = Grip with 3 mm step
- ▲ 3 = Grip with 8 mm step
- ▲ 4 = Grip with 18 mm step
- ▲ 5 = Rough grip with 8 mm step
- ▲ 6 = Round grip
- ▲ $M_{max} = 60 \text{ Nm}$
- ▲ Including fixation screws



For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
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CW		●	●	●	●						
80892246		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
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		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
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		●	●	●	●						
		●	●	●	●						
		●	●	●	●						
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		●	●	●	●						
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		●	●	●	●						
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		●	●	●	●						
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		●	●	●	●						
		●	●	●	●						
		●	●	●	●						

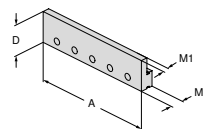
- ▲ 1 = Smooth
- ▲ 2 = Carbide grip
- ▲ 3 = Carbide grip with 3 mm step
- ▲ 4 = Carbide grip with 8 mm step
- ▲ 5 = Round carbide grip with 8 mm step
- ▲ 6 = Round carbide grip
- ▲ Incl. fixing screws



For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
----------------	---	----------------	---	----------------	----------------	---	---	----------------	----------------

[illegible]

- ▲ for stepped jaw with T-slot
- ▲ different clamping depths achievable through milling
- ▲ by milling the bar can be used as stop strip
- ▲ Material 1.7131 can be hardened if required
- ▲ Price per piece



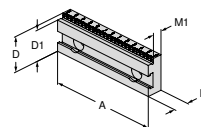
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
	100		32				13,5	7	
	125		32				13,5	7	
	160		32				13,5	7	

		NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
CW												
80892338	●						●					●
80892339		●					●	●		●		●
80892340	●				●		●	●				

General top jaws overview

Stepped jaw, grip with T-slot

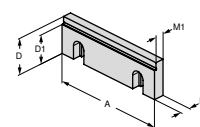
- ▲ T-slot for accommodating a positioning bar
- ▲ with 6.5 mm wide contact surface suitable for workpieces with rough edges
- ▲ laser etched graduation marks (2 mm) as a positioning aid
- ▲ Price per piece



For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
100			35	32			17,5	11,5		80892341	•					•					•
100			35	30			17,5	11,5		80892342	•					•					•
100			35	27			17,5	11,5		80892343	•					•					•
125			40	37			17,5	11,5		80892344	•	•		•		•	•		•		•
125			40	35			17,5	11,5		80892345	•	•		•		•	•		•		•
125			40	32			17,5	11,5		80892346	•	•		•		•	•		•		•
160			50	45			20	13,5		80892348	•			•		•	•		•		•
160			50	42			20	13,5		80892349	•			•		•	•				

Stepped jaw, smooth

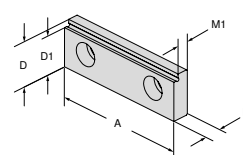
- ▲ Price per piece



For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
100			35	30			10	7,5		8089221400	•					•					•
125			40	32			11,5	9,5		8089221500	•	•		•		•	•		•		•
160			50	42			13,5	10,5		8089221600	•			•		•	•				

Stepped jaw, smooth

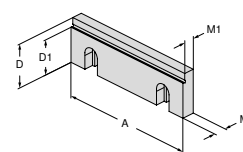
- ▲ Can be used as smooth or stepped jaw
- ▲ Jaw hardened and ground
- ▲ price per piece



For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
65			22	19			8	5,5		80895332	•										

Stepped jaw, coated 5 mm

- ▲ Price per piece



For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80			28	23			10	7,5		8087831400	•			•			•		•		

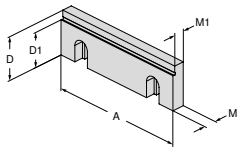
General top jaws overview

Stepped jaw, coated 5 mm

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
	100		35	30			10	7,5	
	125		40	35			11,5	9,5	
	160		50	45			13,5	10,5	

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8089236300	●					●					
80892250	●	●				●			●		●
8089236400	●					●		●			

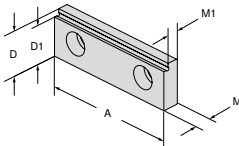


Stepped jaw, 5 mm

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
	80		28	23			10	7,5	

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80878830				●			●		●		

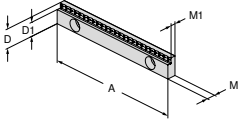


Stepped jaw, Grip

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
	125		18	13			8	5,5	
	125		18	15			8	5,5	

CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80898252		●		●					●		
80898250		●		●					●		

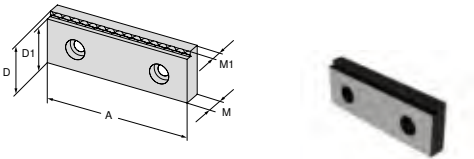


General top jaws overview

Stepped jaw, grip, 3 mm

▲ Price per piece

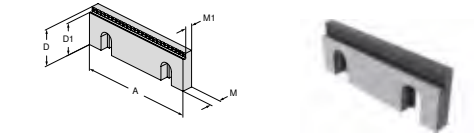
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
	80		28	25			10	7		8090630900				●			●		●		



Stepped jaw, grip 3, 5 and 8 mm

▲ Price per piece

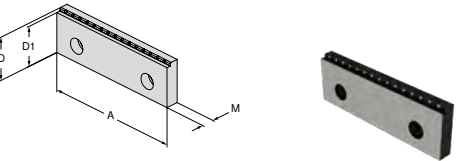
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
	100		35	27			10	7,5		8089229200	●					●					●
	100		35	30			10	7,5		8089229000	●					●					●
	100		35	32			10	7,5		8089229400	●					●					●
	125		40	32			11,5	9		8089229300	●	●		●		●	●		●		●
	125		40	35			11,5	9		8089229100	●			●		●	●		●		●
	125		40	37			11,5	9		8089229500	●	●		●		●	●		●		●
	160		50	42			13,5	11		8089229900	●			●		●	●				●
	160		50	45			13,5	11		8089229800	●			●		●	●				●
	160		50	47			13,5	11		8089229700	●			●		●	●				●



Stepped jaw, carbide grip 3 mm

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
	100		35	32			7,5			8089237600	●	●		●		●	●		●		
	125		40	37			11,5			8089236500	●	●		●		●	●		●		
	160		50	47			13,5			8089237400	●	●		●		●	●		●		

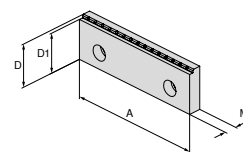


General top jaws overview

Stepped jaw, carbide grip 5 mm

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
	100		35	30			12		
	125		40	35			13,5		
	160		50	45			15,5		

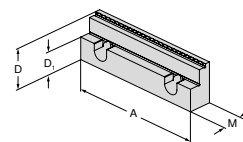


CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8089237700	●	●		●		●	●		●		
8089237500	●	●		●		●	●		●		
8089237300	●	●		●		●	●		●		

Stepped jaw, 18 mm with 3 mm Grip Step

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
	125		40	22			21,5		

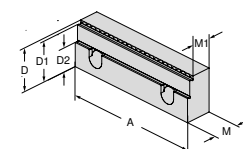


CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80892288	●	●		●		●	●		●		●

Stepped jaw, 18 mm with 3 mm grip step

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
	125		40	37	22		24	19	

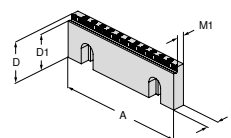


CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80907302	●	●		●		●	●		●		●

Stepped jaw, grip 5 mm for aluminium and plastic

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
	125		40	35			11,5	8	



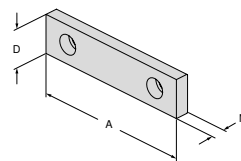
CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8089236100	●	●		●		●	●		●		

General top jaws overview

Ground top jaw

▲ Price per piece

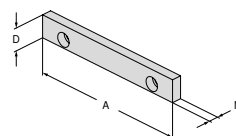
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
	40		22				7,7			80889401										•	
	40		35				10			80889405										•	
	65		22				7,7			80889651										•	
	65		35				10			80889655										•	
	90		22				7,7			80889901										•	
	90		35				10			80889905										•	



Ground top jaw

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
	125		18				7,6			80898251	•	•		•					•		

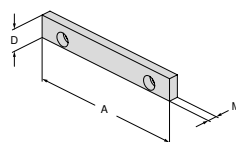


Top jaw, carbide coated

▲ with carbide coating

▲ Price per piece

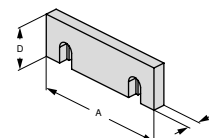
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
	125		18				7,6			80898254	•	•		•					•		



Smooth jaw

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
	100		35				10			8089220400	•					•					•
	125		40				11,5			8089220500	•			•		•	•		•		•
	160		50				13,5			8089220600	•			•		•	•				

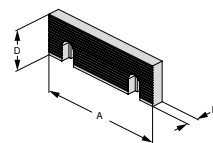


General top jaws overview

Jaw, profiled

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
	100		35				10		
	125		40				11,5		
	160		50				13,5		



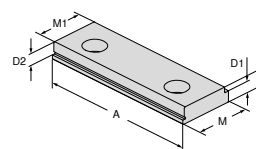
CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8089220700	●					●					●
8089220800	●			●		●	●		●		●
8089220900	●			●		●	●				

Grip jaw, indexable

▲ For vertical and horizontal application

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
	65		8	5,5	5		22	19	
	100		10,5	8	5		35	32	



CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80895340		●					●				
80895343	●					●					●

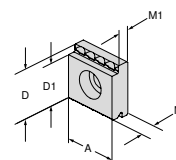
Grip jaw, indexable

▲ For vertical and horizontal application

▲ 3 point clamping

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
65	22		22	19			8	5,5	
100	35		35	32			10,5	8	

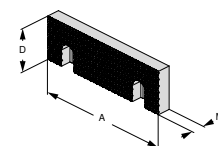


CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80895335		●					●				
80895345	●					●					

Jaw, cut

▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
	100		35				11		
	125		40				12,5		
	160		50				14,5		

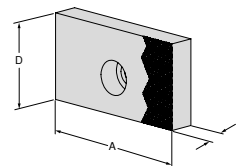


CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8089220100	●					●					●
8089220200	●			●		●	●		●		●
8089220300	●			●		●	●				

General top jaws overview

Jaw, cut

▲ Price per piece



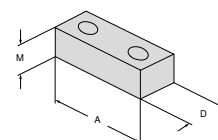
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
	40		35				11			80889408										•	
	40		22				8			80889404										•	
	65		35				11			80889658										•	
	65		22				8			80889654										•	
	90		35				11			80889908										•	
	90		22				8			80889904										•	

Soft jaw, steel

▲ Material: 16MnCr5

▲ Only for vertical application

▲ Price per piece



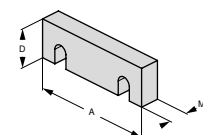
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
	40		22				20			80895244										•	
	65		22				20			80895245		•		•			•			•	
	90		22				20			80895246										•	

Soft jaw, steel

▲ Material: 14NiCr14

▲ for the preparation of formed jaws

▲ Price per piece



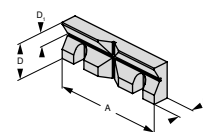
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
	100		35				16			8089224700	•										•
	125		40				20			8089224800	•	•		•		•	•		•		•
	160		50				20			8089224900	•			•		•	•				

General top jaws overview

Prismatic jaw

- ▲ with horizontal and vertical prism
- ▲ prism horizontally and vertically ground for parallelism
- ▲ Price per piece

For clamping diameter	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
11 - 41	100		35	13			15,5		
14 - 48	125		40	16			17,5		
16 - 60	160		50	20			19,5		

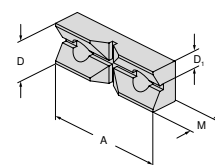


CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
8089226100	●					●					●
8089226200	●	●				●			●		●
8089226300	●			●		●	●				

Prismatic jaw

- ▲ with horizontal and vertical prism
- ▲ price per piece

For clamping diameter	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
11 - 22	65		22	11			15		

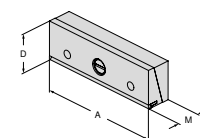


CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80895337	●						●				

Precision pull down jaw

- ▲ Pull down jaw is only for use on the movable jaw
- ▲ Price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
	100		35				25		
	125		40				25		
	160		50				27,5		

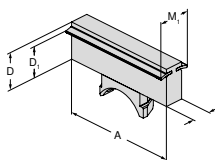


CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80892370	●										●
80892371	●	●		●		●	●		●		●
80892372	●			●		●	●				

Adapter jaws with pull down

- ▲ for the types NCG, NCG2, and HDG2
- ▲ with reciprocal pull down feather/spring jaws
- ▲ price per piece

For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂
	100		35	28			28	45	
	125		40	32,5			20	35	
	160		50	42			20	35	



CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80892258	●										
80892259	●					●					
80892260	●					●					

General top jaws overview

Multipin front jaw

▲ Price per piece

NCG	H5G	H5G -Z	ESG 4	HDG 2	ZSG 4	DSG 4
-----	-----	-----------	----------	----------	----------	----------



CW

80 890 ...

30200

Pull down jaw with spring plate

▲ for finish machining
▲ Price per piece

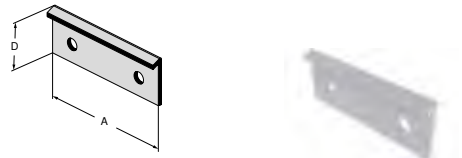
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
	80		24							80901309				•			•		•		
	125		35							80901310				•			•		•		
	160		45							80901311				•			•				



Pull down jaw with spring plate

▲ for finish machining
▲ Price per piece

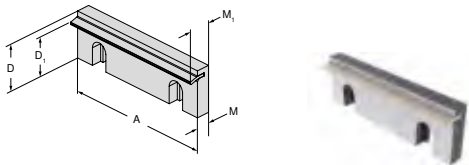
For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
	65		23							80898923											
	100		36							80898924	•					•					•
	125		41							80898925	•					•					•
	160		51							80898926	•					•					



General top jaws overview

Spring leaf pull down jaw

▲ Price per piece



For vice width	A	A ₁	D	D ₁	D ₂	E	M	M ₁	M ₂	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
	100		35	28			10	18,5		8089222800	●					●					●
	125		40	32,5			11,5	19		8089222900	●			●		●	●			●	●
	160		50	42			13,5	21		8089223000	●			●		●	●				

Magnet workpiece supports, set



- ▲ With clearance on the underside
- ▲ Flexible and rational clamping
- ▲ Height accuracy +/- 0.01 mm
- ▲ Quick and easy to install thanks to magnetic adhesion

Workpiece supports overview

Magnet workpiece supports, set

- ▲ Stainless spring steel
- ▲ Pressed magnets
- ▲ Delivered in set: 5 pairs of 2 pieces
- ▲ Price per set



A	D	M	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80	5 / 10 / 15 / 20 / 22	2,5	80 878 79800			●	●			●		●		
125	8 / 12 / 15 / 20 / 22	2,5	80 878 79700	●		●	●		●	●		●		
125	8 / 12 / 20 / 25 / 27	2,5	80 878 79900	●		●	●		●	●		●		

Magnet workpiece supports, set

- ▲ Stainless spring steel
- ▲ Pressed magnets
- ▲ Delivered in set: 5 pairs of 2 pieces
- ▲ Price per set



			CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
A	D	M												
100	12 / 20 / 25 / 30 / 32	2,5	80 892 79700	●		●			●	●				
125	12 / 25 / 30 / 35 / 37	2,5	80 892 79800	●		●			●	●		●		
160	15 / 30 / 40 / 45 / 47	2,5	80 892 79900	●		●	●		●	●				

Magnet workpiece supports, set

- ▲ Stainless spring steel
- ▲ Pressed magnets
- ▲ Delivered in set: 5 pairs of 2 pieces
- ▲ Price per set



A	D	M		CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
125	9 / 22 / 27 / 32 / 34	2,5		80 901 79900	●		●			●	●		●		

Workpiece supports overview

Magnet workpiece supports

▲ Price per pair



			CW											
A	D	M		NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG
80	5	2,5	80 892 79600			•	•					•		
80	10	2,5	80 892 79500	•		•	•		•	•		•		
80	15	2,5	80 892 79400			•	•					•		
80	20	2,5	80 892 79300			•	•		•			•		
80	22	2,5	80 892 79200			•	•			•		•		
100	12	2,5	80 892 79100	•		•			•	•				
100	20	2,5	80 892 79000	•		•			•	•				
100	25	2,5	80 892 78900	•		•			•	•				
100	27	2,5	80 892 78800	•		•			•	•				
100	29	2,5	80 892 78700	•		•			•	•				
100	30	2,5	80 892 78600	•		•			•	•				
100	31	2,5	80 892 78500	•		•			•	•				
100	32	2,5	80 892 78400	•		•			•	•				
125	8	2,5	80 892 78300	•		•			•	•		•		
125	9	2,5	80 892 78200	•		•			•	•		•		
125	10	2,5	80 892 78100	•		•			•	•		•		
125	12	2,5	80 892 78000	•		•			•	•		•		
125	15	2,5	80 892 77900	•		•			•	•		•		
125	20	2,5	80 892 77800	•		•			•	•		•		
125	22	2,5	80 892 77700	•		•			•	•		•		
125	23	2,5	80 892 77600	•		•			•	•		•		
125	25	2,5	80 892 77500	•		•			•	•		•		
125	27	2,5	80 892 77400	•		•			•	•		•		
125	30	2,5	80 892 77300	•		•			•	•		•		
125	31	2,5	80 892 77200	•		•			•	•		•		
125	32	2,5	80 892 77100	•		•			•	•		•		
125	33	2,5	80 892 77000	•		•			•	•		•		
125	34	2,5	80 892 76900	•		•			•	•		•		
125	35	2,5	80 892 76800	•		•			•	•		•		
125	36	2,5	80 892 76700	•		•			•	•		•		
125	37	2,5	80 892 76600	•		•			•	•		•		
160	15	2,5	80 892 76500	•		•			•	•				
160	22	2,5	80 892 76400	•		•			•	•				
160	30	2,5	80 892 76300	•		•			•	•				
160	37	2,5	80 892 76200	•		•			•	•				
160	40	2,5	80 892 76100	•		•			•	•				
160	41	2,5	80 892 76000	•		•			•	•				
160	42	2,5	80 892 75900	•		•			•	•				
160	43	2,5	80 892 75800	•		•			•	•				
160	44	2,5	80 892 75700	•		•			•	•				
160	45	2,5	80 892 75600	•		•			•	•				
160	46	2,5	80 892 75500	•		•			•	•				
160	47	2,5	80 892 75400	•		•			•	•				

Workpiece supports overview

Workpiece support, magnetic

Scope of supply:
Including stop pin 50 mm/100 mm



115x15



60x15

		CW
for width mm	Size	80 892 ...
80/100/125/160	60x15	23800
80/100/125/160	115x15	23900

Accessories General Overview

Alignment and centering kit for T-slots

▲ Price per piece

H5G
-Z

ESG
4

DSG
4



I mm	for slot width mm
100	14
100	16
100	18

CW
80 897 ...
114
116
118

Clamping Screw Set for T-slot for MNG

▲ Price for 2 pieces

ESG
4

ZSG
4

DSG
4



for width mm	G
12	M10
14	M12
16	M12
18	M12

CW
80 899 ...
312 ¹⁾
314
316
318

1) Version with washers

Accessories General Overview

Workpiece stop

- NCG
- H5G
- ESG
4
- HDG
2
- ZSG
4
- DSG
4



CW

80 892 ...

400

Workpiece stop

- ESG
4
- ZSG
4
- DSG
4



CW

80 895 ...

010

Accessories General Overview

Workpiece stop

- ESG
4
- ZSG
4



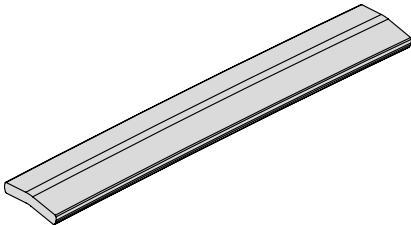
CW

80 884 ...

400

Replacement spring plates

- ▲ price per piece
- ▲ for pull down and intermediate jaws



for width
mm

125

CW

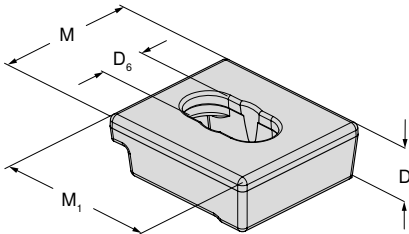
80 892 ...

431

Accessories General Overview

Clamping claws

▲ Price for 2 pieces



D	D ₆	M	M ₁
mm	mm	mm	mm
20	16	50	57

CW
80 890 ...
315

▲ without socket



Torque in Nm	Square drive	DRVS	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG	MNG	MNG mini
	1/2"		80 891 600				●			●						

▲ without socket



Torque in Nm	Square drive	DRVS	AS	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG	MNG	MNG mini
10 - 100	1/2"		80 884 502			●			●	●	●	●				
20 - 200	1/2"		80 884 504		●	●			●	●	●	●				

▲ without socket



Torque in Nm	Square drive	DRVS	AS	NCG	H5G / -S / -Z	X5G -Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG	MNG	MNG mini
5 - 50	3/8"		80 884 402								●		●		●	

▲ Torque key incl. socket, screwdriver A/F10 and 1/2" extension

[illegible]

Clamping levers overview

Socket

▲ Suitable for 1/2" or 3/8" square drive



Torque in Nm	Square drive	DRVS	AS	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG	MNG	MNG mini
	3/8"	5	80 877 105													
	3/8"	6	80 877 10600													●
	3/8"	8	80 877 108										●		●	
	1/2"	8	80 877 208													
	1/2"	10	80 877 210													
	1/2"	14	80 877 214			●										

Socket

▲ Suitable for 1/2" or 3/8" square drive



Torque in Nm	Square drive	DRVS	AS	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG	MNG	MNG mini
	3/8"	7	80 875 107													
	3/8"	11	80 875 11100								●					
	3/8"	12	80 875 112				●			●		●				
	1/2"	12	80 875 212				●			●		●				
	1/2"	14	80 875 214				●			●		●				

Clamping screw for top jaws



For vice width	G	J ₁₇	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG	MNG	MNG mini
	M8x12		80 892 296	●	●				●	●						
	M6x8		80 895 013								●		●			

For vice width	G	J ₁₇	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG	MNG	MNG mini
	M8x10		80 889 950	●	●					●	●					

[illegible]

For vice width	G	J ₁₇	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG	MNG	MNG mini
M12x45				80 899 124												

Screws Overview

Dowel screws

▲ Price for 2 pieces



For vice width	G	J ₁₇	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG	MNG	MNG mini
100	M12x38	12	80 890 313	●			●									
125 / 160	M16x55	16	80 890 314	●												

Dowel screw

▲ Price for 2 pieces



For vice width	G	J ₁₇	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG	MNG	MNG mini
125	M12x45	12	80 895 019	●	●	●	●			●		●			●	

Clamping screw and T-Nuts

▲ For mounting the clamping claw
▲ Price per 2 pieces



For slot width	G	J ₁₇	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG	MNG	MNG mini
12	M10		80 890 308	●	●		●					●	●			
14	M12		80 890 309	●	●		●		●	●		●	●			
16	M14		80 890 310	●	●		●		●	●		●	●			
18	M16		80 890 311	●	●		●		●	●		●	●			

Clamping screws for round clamps, T-Nut

▲ incl. nut and washer
▲ Price per 2 Pieces



For slot width	G	J ₁₇	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG	MNG	MNG mini
12	M10		80 899 112										●		●	
14	M12		80 899 114										●		●	
16	M12		80 899 116										●		●	
18	M12		80 899 118										●		●	

Screws Overview

Tenon incl. screw

▲ Price per 2 pieces



For slot width	G	J ₁₇	CW	NCG	H5G / -S / -Z	X5G-Z / -S	ESG 4	ESG 5	HDG 2	ZSG 4	ZSG mini	DSG 4	Verso	HSG	MNG	MNG mini
				•	•	•	•		•			•				
12	M6		80 898 412	•	•	•	•		•			•				
14	M6		80 898 414	•	•	•	•		•			•				
16	M6		80 898 416	•	•	•	•		•			•				
18	M6		80 898 418	•	•	•	•		•			•				



Material examples



Extended Material Examples for the Cutting Data Tables

	Material sub-group	Index	Composition / Structure / Heat treatment		Tensile strength N/mm ² / HB / HRC
P	Unalloyed steel	P.1.1	< 0,15 % C	Annealed	420 N/mm ² / 125 HB
		P.1.2	< 0,45 % C	Annealed	640 N/mm ² / 190 HB
		P.1.3		Tempered	840 N/mm ² / 250 HB
		P.1.4	< 0,75 % C	Annealed	910 N/mm ² / 270 HB
		P.1.5		Tempered	1010 N/mm ² / 300 HB
	Low-alloy steel	P.2.1		Annealed	610 N/mm ² / 180 HB
		P.2.2		Tempered	930 N/mm ² / 275 HB
		P.2.3		Tempered	1010 N/mm ² / 300 HB
		P.2.4		Tempered	1200 N/mm ² / 375 HB
	High-alloy steel and high-alloy tool steel	P.3.1		Annealed	680 N/mm ² / 200 HB
		P.3.2		Hardened and tempered	1100 N/mm ² / 300 HB
		P.3.3		Hardened and tempered	1300 N/mm ² / 400 HB
	Stainless steel	P.4.1	Ferritic / martensitic	Annealed	680 N/mm ² / 200 HB
		P.4.2	Martensitic	Tempered	1010 N/mm ² / 300 HB
M	Stainless steel	M.1.1	Austenitic / austenitic-ferritic	Quenched	610 N/mm ² / 180 HB
		M.2.1	Austenitic	Tempered	300 HB
		M.3.1	Austenitic / ferritic (Duplex)		780 N/mm ² / 230 HB
K	Grey cast iron	K.1.1	Pearlitic / ferritic		350 N/mm ² / 180 HB
		K.1.2	Pearlitic (martensitic)		500 N/mm ² / 260 HB
	Spherulitic graphite cast iron	K.2.1	Ferritic		540 N/mm ² / 160 HB
		K.2.2	Pearlitic		845 N/mm ² / 250 HB
	Malleable iron	K.3.1	Ferritic		440 N/mm ² / 130 HB
		K.3.2	Pearlitic		780 N/mm ² / 230 HB
N	Aluminium wrought alloy	N.1.1	Non-hardenable		60 HB
		N.1.2	Hardenable	Age-hardened	340 N/mm ² / 100 HB
	Cast aluminium alloy	N.2.1	≤ 12 % Si, non-hardenable		250 N/mm ² / 75 HB
		N.2.2	≤ 12 % Si, hardenable	Age-hardened	300 N/mm ² / 90 HB
		N.2.3	> 12 % Si, non-hardenable		440 N/mm ² / 130 HB
	Copper and copper alloys (bronze/brass)	N.3.1	Free-machining alloys, PB > 1 %		375 N/mm ² / 110 HB
		N.3.2	CuZn, CuSnZn		300 N/mm ² / 90 HB
		N.3.3	CuSn, lead-free copper and electrolytic copper		340 N/mm ² / 100 HB
	Magnesium alloys	N.4.1	Magnesium and magnesium alloys		70 HB
S	Heat-resistant alloys	S.1.1	Fe - basis	Annealed	680 N/mm ² / 200 HB
		S.1.2		Age-hardened	950 N/mm ² / 280 HB
		S.2.1	Ni or Co basis	Annealed	840 N/mm ² / 250 HB
		S.2.2		Age-hardened	1180 N/mm ² / 350 HB
		S.2.3		Cast	1080 N/mm ² / 320 HB
	Titanium alloys	S.3.1	Pure titanium		400 N/mm ²
		S.3.2	Alpha + beta alloys	Age-hardened	1050 N/mm ² / 320 HB
		S.3.3	Beta alloys		1400 N/mm ² / 410 HB
H	Hardened steel	H.1.1		Hardened and tempered	46–55 HRC
		H.1.2		Hardened and tempered	56–60 HRC
		H.1.3		Hardened and tempered	61–65 HRC
		H.1.4		Hardened and tempered	66–70 HRC
	Chilled iron	H.2.1		Cast	400 HB
	Hardened cast iron	H.3.1		Hardened and tempered	55 HRC
O	Non-metal materials	O.1.1	Plastics, duroplastic		≤ 150 N/mm ²
		O.1.2	Plastics, thermoplastic		≤ 100 N/mm ²
		O.2.1	Aramid fibre-reinforced		≤ 1000 N/mm ²
		O.2.2	Glass/carbon-fibre reinforced		≤ 1000 N/mm ²
		O.3.1	Graphite		

* Tensile strength

On the following 16 pages you will find an extension of the material examples to our usual indexes with additional international standards.

Overview of standards:

DIN

Deutsche Industrie Norm (German Standard)

AFNOR

Association Francaise de Normalisation (French Standard)

UNI

Unificazione Italiana (Italian Standard)

ČSN

Czechoslovakian Standard

BS

British Standards

SIS

Standardiseringen i Sverige (Swedish Standard)

UNE

Spanish Standard

JIS

Japanese Industrial Standard

GOST / FOCT

Soviet Standard

UNS

Unified Numbering System

USA

Under **USA** several American standards are summarized

	Index	Material number	DIN	AFNOR	UNI	ČSN	BS	SIS	UNE	JIS	GOST	UNS	USA
P	P.1.1	1.5423	16 Mo 5		16 Mo 5		1503-245-420					G 45200	4520
		1.0037	St 37-2	E 24-2		11 343				STKM 12 C			
		1.0044	St 44-2	E 28-2	Fe 430 B FN	11 443	4360-43 B	1412		SM 41 B			A 570 Gr. 40
		1.0116	St 37-3	E 24-3; E 24-4	Fe 360 D FF	11 378	4360-40 C	1312; 1313			St 3 kp; ps; sp		A 573 Gr. 58
		1.0144	St 44-3	E 28-3; E 28-4	Fe 430 D FF	11 448	4360-43 C	1412; 1414		SM 41 C	St 4 kp; ps; sp		A 573 Gr. 70
		1.0301	C 10	AF 34 C 10; XC 10	C 10	12 010	045 M 10			S 10 C	10	G 10100	1010
		1.0401	C 15	AF3 7 C 12; XC 18	C 15; C 16	12 020	080 M 15	1350	F-111			G 10170	1015
		1.0402	C 22	AF 42 C 20	C 20; C 21	12 024	050 A 20	1450	F-112		20	G 10200	1020
		1.0406	C 25	AF 50 C 30	C 25	12 030	070 M 26						1025
		1.0570	St 52-3	E 36-3; E 36-4	Fe 510 B; C; D	11 523	4360-50 B	2132		SM 50 YA	17 GS		
		1.1121	Ck 10	XC 10	C 10	12 010	045 M 10	1265	F-1510	S 10 C; S 9 CK	08; 10	G 10100	1010
		1.1133	20 Mn 5	20 M 5	G 22 Mn 3	42 2714	120 M 19			SMnC 420		G 10220	1022; 1518
		1.1141	Ck 15	XC 15; XC 18	C 15; C 16	12 020	080 M 15	1370	F-1511	S 15 C; S 15 CK	15	G 10170	1015
		1.1151	Ck 22	XC 25; XC 18	C 20		050 A 20			S 20 C; S 20 CK	20		1023
		1.1158	Ck 25	XC 25	C 25	12 030	070 M 26			S 25 C	25	G 10250	1025
	P.1.2	1.0050	St 50-2	A 50-2	Fe 490	11 500	4360-50 B	2172		SS 50	BSt 5 ps; sp		A 570 Gr. 50
		1.0060	St 60-2	A 60-2	Fe 590; Fe 60-2	11 600	4360-SSE; SSC			SM 58	St 6 ps; sp		
		1.0406	C 25	AF 50 C 30	C 25	12 030	070 M 26						1025
		1.0420	GS-38										
		1.0446	GS-45										
		1.0481	17 Mn 4			11 748							
		1.0501	C 35	AF 55 C 35	C 35	12 040	060 A 35	1550	F-113		35	G 10350	1035
		1.0503	C 45	AF 65 C 45	C 45	12 050	080 M 46	1650	F-114		45	G 10430	1045
		1.0511	C 40	AF 60 C 40	C 40	12 041							1040
		1.0528	C 30			12 031							
		1.0540	C 50			12 051							
		1.0552	GS-52										
		1.0558	GS-60										
		1.0619	GS-C 25										
		1.0711	9 S 20		CF 9 S 22		220 M 07	220 M 07		SUM 21	SUM 21	G 12120	1212
		1.0715	9 SMn 28	S 250	CF 9 SMn 28	11 109	230 M 07	1912	F-211 / F-2111	SUM 22		G 12130	1213
		1.0718	9 SMnPb 28	S 250 Pb	CF 9 SMnPb 28			1914	F-212 / F-2112	SUM 22 L		G 12134	12 L 13
		1.0721	10 S 20	10 F 1	CF 10 S 20	10 110	210 M 15		F-2121				1108
		1.0722	10 SPb 20	10 PbF 2	CF 10 SPb 20				F-2122				11 L 08
		1.0723	15 S 20				210 A 15	1922		SUM 32			
		1.0736	9 SMn 36	S 300	CF 9 SMn 36		240 M 07		F-2113			G 12150	1215
		1.0737	9 SMnPb 36	S 300 Pb	CF 9 SMnPb 36			1926	F-2114			G 12144	12 L 14
		1.1118	GS-24 Mn 6			42 2714							
		1.1120	GS-20 Mn 5										
		1.1131	GS-16 Mn 5										
		1.1138	GS-21 Mn 5										
		1.1142	GS-Ck 16										
		1.1151	Ck 22	XC 25; XC 18	C 20		050 A 20			S 20 C; S 20 CK	20		1023
		1.1155	GS-Ck 25										
		1.1158	Ck 25	XC 25	C 25	12 030	070 M 26			S 25 C	25	G 10250	1025
		1.1178	Ck 30										
		1.1181	Ck 35	XC 38 H1;XC 32	C 35	12 040	080 M 36	1572		S 35 C	35	G 10340	1035
		1.1186	Ck 40	XC 42 H1	C 40	12 041	080 M 40			S 40 C	40		1040
		1.1191	Ck 45	XC 42	C 45	12 050	080 M 46	1672		S 45 C	45	G 10420	1045
		1.1206	Ck 50	XC 48 H1		12 051	080 M 50				50		1050
		1.1730	C 45 W	Y3 42		19 083							

	Index	Material number	DIN	AFNOR	UNI	ČSN	BS	SIS	UNE	JIS	GOST	UNS	USA
P	P.1.3	1.0501	C 35	AF 55 C 35	C 35	12 040	060 A 35	1550	F-113		35	G 10350	1035
		1.0503	C 45	AF 65 C 45	C 45	12 050	080 M 46	1650	F-114		45	G 10430	1045
		1.0511	C 40	AF 60 C 40	C 40	12 041							1040
		1.0528	C 30			12 031							
		1.0540	C 50			12 051							
		1.0726	35 S 20	35 MF 4		11 140	212 M 36	1957	F-210.G			G 11400	1140
		1.0727	45 S 20	45 MF 4			212 M 44	1973				G 11460	1146
		1.0728	60 S 20	60 MF 4									
		1.1178	Ck 30										
		1.1181	Ck 35	XC 38 H1:XC 32	C 35	12 040	080 M 36	1572		S 35 C	35	G 10340	1035
		1.1186	Ck 40	XC 42 H1	C 40	12 041	080 M 40			S 40 C	40		1040
		1.1191	Ck 45	XC 42	C 45	12 050	080 M 46	1672		S 45 C	45	G 10420	1045
		1.1206	Ck 50	XC 48 H1		12 051	080 M 50				50		1050
	P.1.4	1.0535	C 55	AF 70 C55	C 55	12 060	070 M 55	1655			55		1055
		1.0601	C 60	CC 55	C 60	12 061	080 A 62				60	G 10600	1060
		1.0757	46 SPb 20										
		1.1203	Ck 55	XC 55	C50	12 060	070 M 55			S 55 C	55		1055
		1.1221	Ck 60	XC 60	C60	12 061	080 A 62	1665; 1678		S 58 C	60; 60G	G 10640	1060
		1.1248	Ck 75	XC 75	C 75	12 081	060 A 78	1774; 1778			75	G 10780	1078; 1080
		1.1274	Ck 101	XC 100			060 A 96	1870		SUP 4		G 10950	1095
		1.1520	C 70 W1										
		1.1525	C 80 W1	Y1 90; Y1 80	C 80 KU						U8A	T 72301	W 108
		1.1545+G502	C 105 W1	Y1 105	C 100 KU			1880			U10A	T 72301	W 110
		1.1620	C 70 W2			19 132							
		1.1625	C 80 W2		C 80 KU	19 152	BW 1 B			SKC 3; SK 5; SK 6	U8; 80	T 72301	W 1
		1.1645	C 105 W2	Y2 105	C 100 KU	19 191				SK 3	U10	T 72301	
		1.1663	C 125 W	Y2 120	C 120 KU					SK 2	U13	T 72301	W 112
		1.1673	C 135 W	Y2 140	C 140 KU					SK 1			
		1.1740	C 60 W	Y3 55		19 103				SK 7			
		1.1750	C 75 W				BW 1A				75		W 1
		1.1820	C 55 W										
		1.1830	C 85 W	Y3 90						SK 5			
	P.1.5	1.0535	C 55	AF 70 C55	C 55	12 060	070 M 55	1655			55		1055
		1.0601	C 60	CC 55	C 60	12 061	080 A 62				60	G 10600	1060
		1.1203	Ck 55	XC 55	C50	12 060	070 M 55			S 55 C	55		1055
		1.1221	Ck 60	XC 60	C60	12 061	080 A 62	1665; 1678		S 58 C	60; 60G	G 10640	1060
		1.1231	Ck 67	XC 68	C 70	12 071	060 A 67	1770			70	G 10700	1070
		1.1274	Ck 101	XC 100			060 A 96	1870		SUP 4		G 10950	1095
		1.1520	C 70 W1										
	P.2.1	1.2162	21 MnCr 5	20 NC 5		19 487				SCR 420 H			
		1.2210	115 CrV 3	100 C 3	107 CrV 3 KU	19 421						T 61202	L 2
		1.2323	GS-48 CrMoV 6 7			19 512							
		1.2341	X 6 CrMo 4										
		1.2369	81 CrMov 42 16										
		1.2516	120 WV 4	110 WC 20	110 W 4 KU	19 711	BF 1						
		1.2542	45 WCrV 7		45 WCrV 8 KU	19 732	BS 1	2710				T 41901	S 1
		1.2550	60 WCrV 7	55 WC 20	55 WCrV 8 KU	19 735							
		1.2711	54 NiCrMoV 6	55 NCDV 6		19 662							
		1.2735	15 NiCr 14	10 NC 12		16 240				SNC 22		T 51606	
		1.2762	75 CrMoNiW 6 7										
		1.2842	90 MnCrV 8	90 MV 8	90 MnVCr 8 KU	19 314	BO 2					T 31502	O 2

	Index	Material number	DIN	AFNOR	UNI	ČSN	BS	SIS	UNE	JIS	GOST	UNS	USA
P	P.2.1	1.5015	GS-8 Mn 7										
		1.5122	37 MnSi 4			13 240							
		1.5415	15 Mo 3	15 D 3	16 Mo 3	15 020	1501-240	2912					A 204 Gr. A
		1.5419	GS-22 Mo 4										
		1.5621	GS-10 Ni 6										
		1.5622	14 Ni 6	16 N 6	14 Ni 6								A 350-LF 5
		1.5633	GS-24 Ni 8										
		1.5638	GS-10 Ni 14										
		1.5732	14 NiCr 10	14 NC 11	16 NiCr 11				F-1540	SNC 415 (H)			3415
		1.5752	14 NiCr 14	12 NC 15		16 240	655 M 13		F-1540	SNC 815 (H)		G 33106	3310; 9314
		1.5919	15 CrNi 6	16 NC 6	16 CrNi 4	16 220	S 107						
		1.5920	18 CrNi 8	20 NC 6		13 231							
		1.6221	GS-13 MnNi 6 4										
		1.6523	21 NiCrMo 2	20 NCD 2	20 NiCrMo 2		805 M 20	2506	F-1522	SNCM 220 (H)		G 86170	8620
		1.6587	17 CrNiMo 6	18 NCD 6	18 NiCrMo 7		820 A 16						
		1.6750	GS-20 NiCrMo 3 7										
		1.7003	38 Cr 2	38 C 2	38 Cr 2								
		1.7006	46 Cr 2	42 C 2	45 Cr 2								5045
		1.7012	13 Cr 2										
		1.7015	15 Cr 3	12 C 3		14 120	523 M 15			SCr 415 (H)	15Ch	G 50150	5015
		1.7020	32 Cr 2										
		1.7030	28 Cr 4				530 A 30				30Ch		5130
		1.7033	34 Cr 4	32 C 4	34 Cr 4 (KB)		530 A 32			SCr 430 (H)	35Ch	G 51320	5132
		1.7131	16 MnCr 5	16 MC 5	16 MnCr 5	14 220	527 M 17	2511	F-1516 / F-1517	SCR 415	18ChG	G 51170	5115
		1.7139	16 MnCrS 5						F-150D				
		1.7147	20 MnCr 5	20 MC 5	20 MnCr 5	14 221				SMnC 420 (H)	18ChG	G 51200	5120
		1.7149	20 MnCrS 5						F-1551				
		1.7218	25 CrMo 4	25 CD 4 S	25 CrMo 4 (KB)	15 130	1717 CDS 110	2225		SCM 420; SCM 430	30ChM	G 41300	4130
		1.7219	GS-26 CrMo 4										
		1.7220	34 CrMo 4	35 CD 4	35 CrMo 4	15 131	708 A 37	2234		SCM 432; SCCrM 3	AS38ChGM	G 41350	4135; 4137
		1.7262	15 CrMo 5	12 CD 4	12 CrMo 4					SCM 415 (H)			
		1.7264	20 CrMo 5	18 CD 4						SCM 421			
		1.7271	23 CrMoB 3 3										
		1.7311	20 CrMo 2						F-1523				
		1.7321	20 MoCr 4	20 CD 4									
		1.7335	13 CrMo 4 4	15 CD 3.5	14 CrMo 4 5	15 121	1501-620 Gr. 27	2216			12ChM; 15ChM		A 182-F11; F12
		1.7337	16 CrMo 4 4	15 CD 4.5	14 CrMo 4 5		1501-620 Gr. 27	2216			15ChM		A 387 Gr. 12 Cl. 2
		1.7357	GS-17 CrMo 5 5										
		1.7363	GS-12 CrMo 19 5										
		1.7377	GS-17 CrMo 9 10										
		1.7379	GS-18 CrMo 9 10										
		1.7380	10 CrMo 9 10	10 CD 9.10	12 CrMo 9 10		1501-622 Gr. 31; 45 1503-660-440	2218				J 21890	A 182-F22
		1.7715	14 MoV 6 3										
		1.7725	GS-30 CrMoV 6 4										
		1.8504	34 CrAl 6			14 340							
		1.8506	34 CrAlS 5									K 23745	
		1.8521	15 CrMoV 5 9										
		1.0904	55 Si 7	55 S 7	55 Si 8		250 A 53	2085; 2090			55S2		9255
	P.2.2	1.2067	100 Cr 6	Y 100 C 6			BL 3					T 61203	L 3
		1.2101	62 SiMnCr 4										
		1.2103	58 SiCr 8			19 452							

	Index	Material number	DIN	AFNOR	UNI	ČSN	BS	SIS	UNE	JIS	GOST	UNS	USA
P	P.2.2	1.2108	90 CrSi 5P										
		1.2162	21 MnCr 5	20 NC 5		19 487				SCR 420 H			
		1.2210	115 CrV 3	100 C 3	107 CrV 3 KU	19 421						T 61202	L 2
		1.2311	40 CrMnMo 7			19 520							
		1.2312	40 CrMnMoS 8 6	40 CMD 8 + S									
		1.2323	GS-48 CrMoV 6 7			19 512							
		1.2330	35 CrMo 4	34 CD 4	35 CrMo 4		708 A 37	2234			35 HM	T 51620	4135
		1.2332	47 CrMo 4	42 CD 4	40 CrMo 4		708 M 40	2244					4142
		1.2419	105 WC 6	105 WC 13	107 WC 5 KU					SKS 31	ChWG		
		1.2510	100 MnCrW 4	90 MWCV 5	95 MnWC 5 KU	19 314	BO 1	2140	F-5220	SKS 3		T 31501	O 1
		1.2542	45 WC 7		45 WC 8 KU	19 732	BS 1	2710				T 41901	S 1
		1.2550	60 WC 7	55 WC 20	55 WC 8 KU	19 735							
		1.2711	54 NiCrMoV 6	55 NCDV 6		19 662							
		1.2713	55 NiCrMoV 6	55 NCDV 7		19 662			F-520.S	SKT 4	5ChNM	T 61206	L 6
		1.2721	50 NiCr 13										
		1.2738	40 CrMnNiMo 8						F-5303				
		1.2826	60 MnSiCr 4										
		1.2833	100 V 1	Y1 105 V	102 V 2 KU	19 356	BW 2			SKS 43		T 72302	W 210
		1.2842	90 MnCrV 8	90 MV 8	90 MnVC 8 KU	19 314	BO 2					T 31502	O 2
		1.3505	100 Cr 6	100 C 6	100 Cr 6	14 100	534 A 99	2258	F-131 / F-1310	SUJ 2	SchCh 15	G 52986	52100
		1.3520	100 CrMn 6			14 209							
		1.3561	44 Cr 2										
		1.3563	43 CrMo 4										
		1.5120	38 MnSi 4										
		1.5121	46 MnSi 4										
		1.5122	37 MnSi 5			13 240							
		1.5131	50 MnSi 4										
		1.5141	53 MnSi 4										
		1.5223	42 MnV 7			13 242							
		1.5710	36 NiCr 6	35 NC 6		16 240	640 A 35			SNC 236			3135
		1.5736	36 NiCr 10	30 NC 11	35 NiCr 9					SNC 631 (H)			3435
		1.5755	31 NiCr 14	18 NC 13		14 440	653 M 31			SNC 836			
		1.6511	36 CrNiMo 4	40 NCD 3	38 NiCrMo 4 (KB)	16 341	816 M 40				40 ChN2MA	G 98400	9840
		1.6513	28 NiCrMo 4										
		1.6546	40 NiCrMo 2 2	40 NCD 2	40 NiCrMo 2 (KB)		311-Type 7			SNCM 240	38ChGNM	G 87400	8740
		1.6565	40 NiCrMo 6				311-Type 6			SNCM 439	40Ch2N2MA		4340
		1.6570	GS-30 NiCrMo 8 5										
		1.6580	30 CrNiMo 8	30 CND 8	30 NiCrMo 8		823 M 30		F-1272	SNCM 431			
		1.6582	34 CrNiMo 6	35 NCD 6	35 NiCrMo 6 (KW)	16 342	817 M 40	2541	F-128 / F-1270	SNCM 447	38Ch2N2MA		4340
		1.6746	32 NiCrMo 14 5	35 NCD 14			830 M 31						
		1.6781	GS-18 NiCrMo 12 6										
		1.7003	38 Cr 2	38 C 2	38 Cr 2								
		1.7006	46 Cr 2	42 C 2	45 Cr 2								5045
		1.7030	28 Cr 4				530 A 30				30Ch		5130
		1.7033	34 Cr 4	32 C 4	34 Cr 4 (KB)		530 A 32			SCr 430 (H)	35Ch	G 51320	5132
		1.7034	37 Cr 4	38 C 4	38 Cr 4	14 140	530 A 36			SCr 435 H	40Ch		5135
		1.7035	41 Cr 4	42 C 4	41 Cr 4		530 M 40			SCr 440 (H)	40Ch	G 51400	5140
		1.7045	42 Cr 4	42 C 4 TS	41 Cr 4		530 A 40	2245		SCr 440	40Ch		5140
		1.7103	67 SiCr 5										
		1.7131	16 MnCr 5	16 MC 5	16 MnCr 5	14 220	527 M 17	2511	F-1516 / F-1517	SCR 415	18ChG	G 51170	5115
		1.7139	16 MnCrS 5						F-150D				

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P	P.2.2	1.7147	20 MnCr 5	20 MC 5	20 MnCr 5	14 221				SMnC 420 (H)	18ChG	G 51200	5120	
		1.7149	20 MnCrS 5						F-1551					
		1.7176	55 Cr 3	55 C 3	55 Cr 3		527 A 60	2253	F-1431	SUP 9 (A)	50ChGA	G 51550	5155	
		1.7218	25 CrMo 4	25 CD 4 S	25 CrMo 4 (KB)	15 130	1717 CDS 110	2225		SCM 420; SCM 430	30ChM	G 41300	4130	
		1.7220	34 CrMo 4	35 CD 4	35 CrMo 4	15 131	708 A 37	2234		SCM 432; SCCrM 3	AS38ChGM	G 41350	4135; 4137	
		1.7223	41 CrMo 4	42 CD 4 TS	41 CrMo 4		708 M 40	2244		SCM 440	40 ChFA	G 41420	4142; 4140	
		1.7225	42 CrMo 4	42 CD 4	42 CrMo 4	15 142	708 M 40	2244		SCM 440 (H)		G 41400	4142; 4140	
		1.7228	50 CrMo 4	50 CR MO4			708 A 47			SCM 445 (H)	50ChFA	G 41470	4150	
		1.7323	20 MoCrS 4	20 CD 4 S										
		1.7325	25 MoCr 4	25 CD 4										
		1.7326	25 MoCrS 4	25 CD 4 S										
		1.7361	32 CrMo 12	30 CD 12	32 CrMo 12	15 230	722 M 24	2240	F-124A					
		1.7707	30 CrMoV 9			15 330								
		1.7709	21 CrMoV 5 7											
		1.7725	GS-30 CrMoV 6 4											
		1.7735	14 CrMoV 6 9	15 CDV 6										
		1.8159	50 CrV 4	50 CV 4	51 CrV 4	15 260	735 A 50	2230	F-143 / F-1430	SUP 10	50ChGFA	G 61500	6150	
		1.8161	58 CrV 4			15 261								
		1.8507	34 CrAlMo 5	30 CAD 6.12	34 CrAlMo 7		905 M 31		F-1741				K 23545	A 355 Cl. D
		1.8509	41 CrAlMo 7	40 CAD 6.12	41 CrAlMo 7	15 340	905 M 39	2940	F-1740	SACM 645	38ChMJuA	K 24065	A 355 Cl. A	
		1.8515	31 CrMo 12	30 CD 12	31 CrMo 12		722 M 24	2240	F-1712					
		1.8519	31 CrMoV 9						F-1721					
		1.8523	39 CrMoV 13 9		36 CrMoV 13 9		897 M 39							
		1.8550	34 CrAlNi 7										K 52440	
		1.0904	55 Si 7	55 S 7	55 Si 8		250 A 53	2085; 2090				55S2		9255
		1.1157	40 Mn 4	35 M 5			150 M 36					40G	G 10390	1039
		1.1165	30 Mn 5	35 M 5		13 141	120 M 36			SMn 433 H; SCMn 2		30GSL		1330
		1.1167	36 Mn 5	40 M 5		42 2715	150 M 36	2120		SMn 438 (H); SCMn 3		35G2; 35GL	G 13350	1335
		1.1170	28 Mn 6	20 M 5	C 28 Mn	13 141	150 M 28			SCMn 1		30G		1330
		P.2.3	1.2744	57 NiCrMoV 7 7										
	1.7131		16 MnCr 5	16 MC 5	16 MnCr 5	14 220	527 M 17		F-1516 / F-1517	SCR 415	18ChG	G 51170	5115	
	1.7755		GS-35 CrMoV 10 4											
	P.2.4	1.2714	56 NiCrMoV 7			19 663								
		1.3505	100 Cr 6	100 C 6	100 Cr 6	14 100	534 A 99	2258	F-131 / F-1310	SUJ 2	SchCh 15	G 52986	52100	
		1.7225	42 CrMo 4	42 CD 4	42 CrMo 4	15 142	708 M 40	2244		SCM 440 (H)		G 41400	4142; 4140	
	P.3.1	1.2080	X 210 Cr 12	Z 200 C 12	X 210 Cr 13 KU	19 436	BD 3				SKD 1	Ch12	T 30403	D 3
		1.2201	G-X 165 CrV 12			19 572								
		1.2343	X 38 CrMoV 5 1	Z 38 CDV 5	X 37 CrMoV 5 1 KU	19 552	BH 11		F-5317	SKD 6	4Ch5MFS	T 28811	H 11	
		1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	X 100 CrMoV 5 1 KU	19 571	BA 2	2260	F-5227	SKD 12		T 30102	A 2	
		1.2365	X 32 CrMoV 3 3	32 DCV 28	30 CrMoV 12 27 KU	19 541	BH 10			SKD 7	3Ch3M3F	T 20810	H 10	
1.2367		X 38 CrMoV 5 3												
1.2379		X 155 CrVMo 12 1	Z 160 CDV 12	X 155 CrVMo 12 1 KU	19 573	BD 2		F-5211	SKD 11		T 30402	D 2		
1.2436		X 210 CrW 12	Z 200 CW 12	X 215 CrW 12 1 KU	19 437		2312	F-5213	SKD 2					
1.2567		X 30 WCrV 5 3	Z 32 WCV 5	X 30 WCrV 5 3 KU	19 720				SKD 4					
1.2581		X 30 WCrV 9 3	Z 30 WCV 9	X 30 WCrV 9 3 KU	19 721	BH 21			SKD 5	3Ch2W8F	T 20821	H 21		
1.2601		X 165 CrMoV 12		X 165 CrMoW 12 KU	19 572		2310							
1.2606		G-X 37 CrMoW 5 1												
1.2764		X 19 NiCrMo 4												
1.2767		X 45 NiCrMo 4	Y 35 NCD 16	42 NiCrMo 15 7	19 655									
1.2880		G-X 165 CrCoMo 12												
1.2885		X 32 CrMoCoV 3 3 3	30 DCKV 28											

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P	P.4.1	1.4104	X 14 CrMoS 17	Z 10 CF 17	X 10 CrS 17	17 140		2383	F-3403	SUS 430 F		S 43020	430 F	
		1.4105	X 4 CrMoS 18						F-3114					
		1.4106	X 2 CrMoSiS 18 2 1											
		1.4107	G-X 8 CrNi 12			42 2904								
		1.4109	X 65 CrMo 14											
		1.4112	X 90 CrMoV 18										S 44003	
		1.4113	X 6 CrMo 17	Z 8 CD 17.01	X 8 CrMo 17		434 S 17	2325	F-3116	SUS 434			S 43400	434
		1.4116	X 45 CrMoV 15						F-3422					
		1.4122	G-X 35 CrMo 17			17 137								
		1.4125	X 105 CrMo 17	Z 100 CD 17	X 105 CrMo 17					SUS 440 C			S 44004	440 C
		1.4136	G-X 70 CrMo 29 2											
		1.4405	G-X 5 CrNiMo 16 5											
		1.4407	G-X 5 CrNiMo 13 4											
		1.4510	X 6 CrTi 17	Z 8 CT 17	X 6 CrTi 17					SUS 430 LX	08Ch17T		S 43036	XM 8; 430 Ti
		1.4511	X 8 CrNb 17	Z 8 CNb 17	X 6 CrNb 17				F-3122	SUS 430 LX				
		1.4512	X 5 CrTi 12	Z 6 CT 12	X 6 CrTi 12		409 S 19		F-3121	SUH 409			S 40900	409
		1.4528	X 105 CrCoMo 18 2											
		1.4540	G-X 4 CrNiCuNb 16 4											
		1.4724	X 10 CrAl 13	Z 10 C 13	X 10 CrAl 12	17 125	403 S 17		F-3152		10Ch13SJ _U			
		1.4742	X 10 CrAl 18	Z 10 CAS 18	X 8 Cr 17		430 S 15		F-3153	SUS 430; SUH21				430
		1.4761	G-X 120 CrSi 23											
		1.4762	X 10 CrAl 24	Z 10 CAS 24	X 16 Cr 26	17 153			F-3154				S 44600	446
		1.4931	G-X 22 CrMoV 12 1											
		1.4962	X 12 CrNiWTi 16 3											
		1.6982	G-X 3 CrNi 13 4											
		P.4.2	1.2316	X 36 CrMo 17	Z 38 CD 17	X 38 CrMo 16 1 KU								
	1.4000		X 6 Cr 13	Z 6 C 13	X 6 Cr 13	17 020	403 S 17	2301		SUS 403	08Ch13		S 40300	403
	1.4021		X 20 Cr 13	Z 20 C 13	X 20 Cr 13	17 022	420 S 37	2303	F-3402	SUS 420 J 1	20Ch13		S 42000	420
	1.4024		X 15 Cr 13	Z 13 C 13		17 021	420 S 29			SUS 410 J 1				
	1.4028		X 30 Cr 13	Z 30 C 13	X 30 Cr 13	17 023	420 S 45	2304		SUS 420 J 2	30Ch13			
	1.4031		X 38 Cr 13	Z 40 C 14	X 40 Cr 14	17 024		2304	F-3404	SUS 420 J 2	40Ch13			
	1.4034		X 46 Cr 13	Z 40 C 14	X 40 Cr 14	17 029	420 S 45		F-3405		40Ch13			
	1.4057		X 20 CrNi 17 2	Z 15 CN 16.02	X 16 CrNi 16	17 145	431 S 29	2321	F-3427	SUS 431	20Ch17N2		S 43100	431
	1.4059		G-X 22 CrNi 17											
	1.4086		G-X 120 Cr 29											
	1.4108		X 100 CrMo 13											
	1.4112		X 90 CrMoV 18										S 44003	
	1.4116		X 45 CrMoV 15						F-3422					
	1.4120		G-X 20 CrMo 13											
	1.4122		G-X 35 CrMo 17			17 137								
1.4138	G-X 120 CrMo 29 2													
1.4313	X 5 CrNi 13 4		Z 5 CN 13.4	X 6 CrNi 13 04		425 C 11	2385		SCS 5				CA 6-NM	
1.4340	G-X 40 CrNi 27 4													
1.4464	G-X 40 CrNiMo 27 5													
1.4542	X 7 CrNiCu 16 4 4		Z7 CNU 17 04 04 (17-4PH)						SCS 24; SUS 630			S 17400	630	
1.4545	X 5 CrNiCu 15-5		E-Z5 CNU 15 05 (15-5PH)											
1.4710	G-X 30 CrSi 6													
1.4718	X 45 CrSi 9 3		Z 45 CS 9	X 45 CrSi 8	17 115	401 S 45		F-3220	SUH 1	40Ch9S2		S 65007	HNV 3	
1.4729	G-X 40 CrSi 13													
1.4740	G-X 40 CrSi 17													
1.4743	G-X 160 CrSi 18													

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P	P.4.2	1.4745	G-X 40 CrSi 23										
		1.4747	X 80 CrNiSi 20	Z 80 CSN 20.02	X 80 CrSiNi 20		443 S 65			SUH 4		S 65006	HNV 6
		1.4776	G-X 40 CrSi 29										
		1.4823	G-X 40 CrNiSi 27 4										
		1.4923	X 22 CrMoV 12 1			17 134	762						
		1.4928	G-X 12 CrNiMoCoVN 12										
		1.4935	X 20 CrMoWV 12 1									S 42200	
M	M.1.1	1.3941	G-X 4 CrNi 18 13										
		1.3944	G-X 5 CrNi 18 11										
		1.3952	G-X 4 CrNiMoN 18 14										
		1.3953	G-X 2 CrNiMo 18 15										
		1.3955	G-X 12 CrNi 18 11										
		1.3959	G-X 10 CrNiNb 16 13										
		1.4301	X 5 CrNi 18 10	Z 6 CN 18-09	X 5 CrNi 18 10	17 240	304 S 15	2332; 2333	F-3504	SUS 304	08Ch18N10	S 30400	304; 304 H
		1.4303	X 5 CrNi 18 12	Z 8 CN 18.12	X 8 CrNi 19 10		305 S 19			SUS 305	06Ch18N11	S 30500	308; 305
		1.4305	X 10 CrNiS 18 9	Z 8 CNF 18-03	X 10 CrNi 18 09	17 243	303 S 21	2346		SUS 303		S 30300	303
		1.4306	X 2 CrNi 19 11	Z 3 CN 18-10	X 2 CrNi 18 11	17 249	304 S 12	2352; 2333	F-3503	SCS 19	03Ch18N11	S 30403	304 L
		1.4308	G-X 6 CrNi 18 9	Z 6 CN 18.10 M		42 2930	304 C 15	2333	F-8411	SCS 13	07Ch18N9L		CF-8
		1.4311	X 2 CrNiN 18 10	Z 2 CN 18 .10	X 2 CrNiN 18 11	17 249	304 S 62	2371		SUS 304 LN		S 30453	304 LN
		1.4312	G-X 10 CrNi 18 8			42 2931							
		1.4401	X 5 CrNiMo 18 10	Z 6 CND 17 12 02	X 5 CrNiMo 17 12	17 346	316 S 16	2347	F-3543	SUS 316		S 31600	316
		1.4404	X 2 CrNiMo 17 13 2	Z 3 CND 17 12 02	X 2 CrNiMo 17 12	17 349	316 S 11	2348	F-3533	SUS 316 L		S 31603	316 L
		1.4406	X 2 CrNiMoN 17 12 2	Z 2 CND 17.12 Az	X 2 CrNiMoN 17 12		316 S 61			SUS 316 LN		S 31653	316 LN
		1.4408	G-X 6 CrNiMo 18 10			42 2940			F-8414				
		1.4413	G-X 4 CrNiMo 13-4										
		1.4429	X 2 CrNiMoN 17 13 3	Z 3 CND 17 11 03 Az	X 2 CrNiMoN 17 13		316 S 62	2375		SUS 316 LN		S 31653	316 LN
		1.4435	X 2 CrNiMo 18 14 3	Z 2 CND 17.13	X 2 CrNiMo 17 13		316 S 12	2353		SCS 16; SUS 316 L	03Ch17N 14M2	S 31603	316 L
		1.4436	X 5 CrNiMo 17 13 3	Z 6 CND 17.12	X 5 CrNiMo 17 13		316 S 16	2343		SUS 316		S 31600	316
		1.4437	G-X 6 CrNiMo 18 12			42 2940							
		1.4438	X 2 CrNiMo 18 16 4	Z 2 CND 19.15	X 2 CrNiMo 18 15		317 S 12	2367		SUS 317 L		S 31703	317 L
		1.4439	G-X 3 CrNiMo 17 13 5						F-3544				
		1.4446	G-X 2 CrNiMo 17 13 4										
		1.4448	G-X 6 CrNiMo 17 13										
		1.4449	X 3 CrNiMo 18 12 3										
		1.4507	X 2 CrNiMoCuN 25 6 3	Z 3 CNDU 25 07 Az (Uranus 52 N)								S 32750	F61
		1.4541	X 6 CrNiTi 18 10	Z 6 CNT 18.10	X 6 CrNiTi 18 11	17 248	321 S 12	2337		SUS 321	12Ch18N 10T	S 32100	321
		1.4546	X 5 CrNiNb 18 10		X 6 CrNiNb 18 11		347 S 18					S 34800	348
		1.4550	X 6 CrNiNb 18 10	Z10 CNNb 18-10	X 6 CrNiNb 18 11	17 245	347 S 17	2338	F-3552 / F-3524	SUS 347	08Ch18N 12B	S 34700	347
		1.4552	G-X 5 CrNiNb 18 9			42 2933			F-8413				
		1.4571	X 6 CrNiMoTi 17 12 2	Z 6 CNT 17.12	X 6 CrNiMoTi 17 12	17 348	320 S 31	2350	F-3535		10Ch17N13M2T	S 31635	316 Ti
		1.4573	X 10 CrNiMoTi 18 12		X 6 CrNiMoTi 17 13		320 S 33				10Ch17N13M3T	S 31635	316 Ti
		1.4580	X 6 CrNiMoNb 17 12 2	Z 6 CNDNb 17.12	X 6 CrNiMoNb 17 12		318 S 17		F-3536		08Ch16N13M2B	S 31640	316 Cb
		1.4581	G-X 5 CrNiMoNb 18 10	Z 4 CNDNb 18.12 M	GX 6 CrMoNb 20 11	42 2941	318 C 17			SCS 22			
		1.4583	X 10 CrNiMoNb 18 12		X 6 CrNiMoNb 17 13								318
		1.4821	X 15 CrNiSi 25-4	Z20 CNS 25 04									
		1.4825	G-X 25 CrNiSi 18 9			42 2932							
		1.4826	G-X 40 CrNiSi 22 9			42 2934							
		1.4828	X 15 CrNiSi 20 12	Z 15 CNS 20.12		17 251	309 S 24		F-3312	SUH 309	20Ch20N 14S2	S 30900	309
		1.4832	G-X 25 CrNiSi 20 14										
		1.4876	X 10 NiCrAlTi 32 20	Z10 NCAT 32-21 (Incoloy 800)		17 358	NA 15 (H)		F-3314	NCF 800			B 163
		1.4878	X 12 CrNiTi 18 9	Z 6 CNT 18.12 (B)	X 6 CrNiTi 18 11	17 246	321 S 20	2337		SUS 321	12Ch18N 10T		321

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M	M.1.1	1.4968	G-X 7 CrNiNb 16 13										
		1.4988	G-X 8 CrNiMoVNb 16 1										
		1.6901	G-X 8 CrNi 18 10										
		1.6902	G-X 6 CrNi 18 10										
		1.6905	G-X 5 CrNiNb 18 10										
	M.2.1	1.3964	G-X 4 CrNiMnMoN 19 1										
		1.4310	X 12 CrNi 17 7	Z 12 CN 17.07	X 12 CrNi 17 07		301 S 21			SUS 301		S 30100	301
		1.4465	G-X 2 CrNiMoN 25 25										
		1.4536	G-X 2 NiCrMoCuN 25 2										
		1.4539	X 1 NiCrMoCu 25 20 5	Z2 NCDU 25 20 (Uranus B6)								N 08904	904L
		1.4547	X 1 CrNiMoCuN 20 18 17	Z1 CNDU 20 18 06 Az (254 SMO)									F44
		1.4568	X 7 CrNiAl 17 7										17-7 PH
		1.4837	G-X 40 CrNiSi 25 12			42 2936							
		1.4840	G-X 15 CrNi 25 20										
		1.4841	X 15 CrNiSi 25 20	Z 15 CNS 25.20	X 16 CrNiSi 25 20	17 255			F-3310	SUH 310	20Ch25N 20S2	S 31000	314; 310
		1.4845	X 12 CrNi 25 21	Z 12 CN 25.20	X 6 CrNi 26 20	17 255	310 S24	2361		SUH 310;		S 31008	310 S
		1.4848	G-X 40 CrNiSi 25 20		GX 40 CrNi 26 20	42 2952							
		1.4849	G-X 40 NiCrSiNb 38 1										
		1.4852	G-X 40 NiCrNb 35 25										
		1.4855	G-X 30 CrNiSiNb 24 2										
		1.4857	G-X 40 NiCrSi 35 25										
		1.4864	X 12 NiCrSi 36 16	Z 12 NCS 37.18		17 253	NA 17		F-3313	SUH 330		N 08330	330
		1.4865	G-X 40 NiCrSi 38 18		GX 50 NiCr 39 19		330 C 40			SCH 15; SCH 16			
		1.4871	X 53 CrMnNiN 21 9	Z 52 CMN 21.09	X 53 CrMnNiN 21 9		349 S 54		F-3217	SUH 35; SUH 36	55Ch20G9AN4	S 63008	EV 8
		1.4873	X 45 CrNiW 18 9	Z 35 CNWS 20.09	X 45 CrNiW 18 9		331 S 40			SUH 31			
	M.3.1	1.4339	G-X 32 CrNi 28 10										
		1.4347	G-X 8 CrNi 26 7										
		1.4410	X 2 CrNiMoN 25 7 4	Z2 CND 25 07 04 Az					F-3552				F53
		1.4460	X 8 CrNiMo 27 5	Z5 CND 25 05 AZ				2324		SUS 329 J 1		S 32900	329 LN
		1.4462	X 2 CrNiMoN 22 5 3	Z2 CND 22 05 03 AZ (Uranus 45 N)		17 381			F-3308			S 31803	329 A (F51)
		1.4463	G-X 6 CrNiMo 24 8 2										
		1.4501	X 2 CrNiMoCuWN 25 7 4	Z2 CNDUW 25 07 04 Az (Zeron 100)								S 32760	F55
		1.4815	G-X 8 CrNi 19 10										
		1.4822	G-X 40 CrNi 24 5										
K	K.1.1	0.6010	GG-10	Ft 10 D	G 10	42 2410		01 10-00		FC 10	Sc 10		A48-20 B
		0.6015	GG-15	Ft 15 D	G 15	42 2415	Grade 150	01 15-00	FG-15	FC 15	Sc 15		A48-25 B
		0.6020	GG-20	Ft 20 D	G 20	42 2420	Grade 220	01 20-00	FG-20	FC 20	Sc 20		A48-30 B
		0.6025	GG-25	Ft 25 D	G 25	42 2425	Grade 260	01 25-00	FG-25	FC 25	Sc 25		A48-40 B
	K.1.2	0.6030	GG-30	Ft 30 D	G 30	42 2430	Grade 300	01 30-00	FG-30	FC 30	Sc 30		A48-45 B
		0.6035	GG-35	Ft 35 D	G 35	42 2435	Grade 350	01 35-00	FG-35	FC 35	Sc 35		A48-50 B
		0.6040	GG-40	Ft 40 D		42 2440	Grade 400	01 40-00			Sc 40		A48-60 B
		0.6652	GGL-NiMn 13 7	L- NM 13 7			L-NiMn 13 7						
		0.6655	GGL-NiCuCr 15 6 2	L-NUC 15 6 2			L-NiCuCr 15 6 2						A 436 Type 1
		0.6656	GGL-NiCuCr 15 6 3	L-NUC 15 6 3			L-NiCuCr 15 6 3						A 436 Type 1b
		0.6660	GGL-NiCr 20 2	L-NC 20 2			L-NiCr 20 2	05 23-00					A 436 Type 2
		0.6661	GGL-NiCr 20 3	L-NC 20 3			L-NiCr 20 3						A 436 Type 2b
		0.6667	GGL-NiSiCr 20 5 3	L-NSC 20 5 3			L-NiSiCr 20 5 3						
		0.6676	GGL-NiCr 30 3	L-NC 30 3			L-NiCr 30 3						A 436 Type 3
		0.6680	GGL-NiSiCr 30 5 5	L-NSC 30 5 5			L-NiSiCr 30 5 5						A 436 Type 4
	K.2.1	0.7033	GGG-35.3			42 2303							
		0.7040	GGG-40	FGS 400-12	GS 400-12	42 2304	SNG 420/12	0717-02	FGE 38-17	FCD 40	VC 42-12		60 40 18

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K	K.2.1	0.7043	GGG-40.3	FGS 370-17	GSO 42/17	42 2314	SNG 370/17	0717-15			VC 42-12			
		0.7050	GGG-50	FGS 500-7	GS 500/7	42 2305	SNG 500/7	0727-02	FGE 50-7	FCD 50	VC 50-2		65-45-12	
		0.7060	GGG-60	FGS 600-3	GS 600/3	42 2306	SNG 600/3	0732-03		FCD 60	VC 60-2		80-55-06	
	K.2.2	0.7070	GGG-70	FGS 700-2	GS 700-2	42 2307	SNG 700/2	0737-01	FGS 70-2	FCD 70	VC 70-2			100-70-03
		0.7080	GGG-80	FGS 800-2	GS 800-2	42 2308	SNG 800/2				VC 80-2			120-90-02
		0.7652	GGG-NiMn 13 7	S-NM 13 7			S-NiMn 13 7							
		0.7660	GGG-NiCr 20 2	S-NC 20 2			S-NiCr 20 2							A 439 Type D-2
		0.7661	GGG-NiCr 20 3	S-NC 20 3			S-NiCr 20 3							A 439 Type D-2B
		0.7665	GGG-NiSiCr 20 5 2	S-NSC 20 5 2			S-NiSiCr 20 5 2							
		0.7670	GGG-Ni 22	S-N 22			S-Ni 22							A 439 Type D-2C
		0.7673	GGG-NiMn 23 4	S-NM 23 4			S-NiMn 23 4							A 439 Type D-2M
		0.7676	GGG-NiCr 30 3	S-NC 30 3			S-NiCr 30 3							A 439 Type D-3
		0.7677	GGG-NiCr 30 1	S-NC 30 1			S-NiCr 30 1							A 439 Type D-3A
		0.7680	GGG-NiSiCr 30 5 5	S-NSC 30 5 5			S-NiSiCr 30 5 5							A 439 Type D-4
		0.7683	GGG-Ni 35	S-N 35			S-Ni 35							A 439 Type D-5
		0.7685	GGG-NiCr 35 3	S-NC 35 3			S-NiCr 35 3							A 439 Type D-5B
		0.8065	GTW-65											
		K.3.1	0.8035	GTW-35-04			42 2536				GTW 35			
	0.8040		GTW-40-05			42 2540								
	0.8045		GTW-45-07											
	0.8055		GTW-55											
	0.8135		GTS-35-10	MN 35-10		42 2533	B 340/12			GTS 35				
	0.8145		GTS-45-06			42 2545	P 440/7			GTS 45				
	0.8155		GTS-55-04	MP 50-5		42 2555	P 510/4			GTS 55				
0.8165	GTS-65-02		MP 60-3			P 570/3			GTS 65					
K.3.2	0.8170	GTS-70-02	IP 70-2			P 690/2		GTS 70						
N	N.1.1	3.3307	Al99.85Mg0.5											
		3.3308	Al99.9Mg0.5											
		3.3315	AlMg1	5005 (AlMg1)						L-3350				
		3.3316	AlMg1.5											
		3.3317	Al99.85Mg1											
		3.3318	Al99.9Mg1											
		3.3326	AlMg1.8											
		3.3523	AlMg2.5											
		3.3525	AlMg2Mn0.3											
		3.3527	AlMg2Mn0.8											
		3.3535	AlMg3	5754										
		3.3537	AlMg2.7Mn											
		3.3555	AlMg5	5056 A										
		3.3561	G-AlMg5											
		3.3591	G-AlMg10											
		3.0205	Al99	1200 (A4)	9001/1	42 4009				L-3001				
		3.0255	Al99.5	1050 A	9001/2	42 4004				L-3051				
		3.0275	Al99.7	1070 A		42 4003				L-3071				
		3.0285	Al99.8	1080 A (A8)		42 4002				L-3081				
		3.0305	Al99.9											
		3.0505	AlMn0.5Mg0.5											
		3.0506	AlMn0.6											
		3.0515	AlMn1			42 4432				L-3810				
		3.0517	AlMnCu											
		3.0525	AlMn1Mg0.5	3005										

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N	N.1.1	3.0526	AlMn1Mg1										
		3.0615	AlMgSiPb										
		3.0915	AlFeSi										
	N.1.2	3.2307	Al99.85MgSi										
		3.2315	AlMgSi1	6082	9006/4	42 4400							6082
		3.3206	AlMgSi0,5	6060 (AGS)		42 4401			L-3441				6063
		3.3208	Al99.9MgSi										
		3.3210	AlMgSi0.7	6005 A									
		3.3211	AlMg1SiCu	6061									
		3.3345	AlMg4.5										
		3.3545	AlMg4Mn	5086 (AG4MC)	9005/5				L-3322				5083
		3.3547	AlMg4,5Mn0,7	5083 (AlMg5Mn0,7)			N8		L-3321	A 5083			A95083
		3.3549	AlMg5Mn										
		3.4335	AlZn4,5Mg1	7020 (AZ5G)	9007/1	42 4441			L-3741				7020
		3.4337	Al99.8ZnMg										
		3.4345	AlZnMgCu0.5										
		3.4365	AlZnMgCu1.5	7075 (AZ5GU)		42 4222			L-3710				7075
		2.1086	G-CuSn10Zn										
		3.1255	AlCuSiMn	2014	9002/3								2014
		3.1305	AlCu2.5Mg0.5										
		3.1325	AlCuMg1	2017 A (AU4G)					L-3120				2017 A
		3.1355	AlCuMg2	2024 (AU4G1)	9002/4	42 4203			L-3140				2024
		3.1645	AlCuMgPb	2030 (AU4PB)		42 4254			L-3121				
		3.1655	AlCuBiPb	2011 (AU5PbBi)	9002/5				L-3192				2011
		MFK											
	N.2.1	3.2581	G-AlSi12			42 4330							
		3.2583	G-AlSi12(Cu)			42 4330							
		3.3261	G-AlMg5Si			42 4515							
		3.3292	GD-AlMg9			42 4519							
		3.3541	G-AlMg3										
		3.3543	G-AlMg3(Cu)										
	N.2.2	3.2134	G-AlSi5Cu1Mg										
		3.2151	G-AlSi6Cu4			42 4357							
		3.2161	G-AlSi8Cu3										
		3.2341	G-AlSi5Mg										
		3.2371	G-AlSi7Mg			42 4334							
		3.2373	G-AlSi9Mg			42 4331							
		3.2381	G-AlSi10Mg			42 4331							
		3.2383	G-AlSi10Mg(Cu)			42 4331							
		3.3241	G-AlMg3Si										
		3.1371	G-AlCu4TiMg										
		3.1841	G-AlCu4Ti										
	N.3.1	2.0040	OF-Cu			42 3000							
		2.0060	E-Cu57			42 3001							
		2.0065	E-Cu58			42 3001							
		2.0070	SE-Cu										
		2.0076	SW-Cu										
		2.0090	SF-Cu			42 3003							
		2.0220	CuZn5			42 3200							
		2.0230	CuZn10			42 3201							
		2.0240	CuZn15			42 3202							

	Index	Material number	DIN	AFNOR	UNI	ČSN	BS	SIS	UNE	JIS	GOST	UNS	USA
N	N.3.1	2.0250	CuZn20			42 3203							
		2.0261	CuZn28										
		2.0265	CuZn30			42 3210							
		2.0280	CuZn33			42 3212							
		2.0321	CuZn37		C2700	42 3213							
		2.0335	CuZn36										
		2.0360	CuZn40			42 3220							
		2.0460	CuZn20Al2										
		2.0470	CuZn28Sn1										
		2.0510	CuZn37Al1			42 3231							
		2.0530	CuZn38Sn1			42 3237							
		2.0730	CuNi12Zn24										
		2.0740	CuNi18Zn20										
		2.0830	CuNi25										
		2.0842	CuNi44Mn1										
		2.0853	CuNi1.5Si										
		2.0855	CuNi2Si			42 3054							
		2.0857	CuNi3Si										
		2.0872	CuNi10Fe1Mn										
		2.0875	CuNi9Sn2										
		2.0882	CuNi30Mn1Fe										
		2.0883	CuNi30Fe2Mn2										
		2.0918	CuAl5As										
		2.0920	CuAl8										
		2.0932	CuAl8Fe3										
		2.0936	CuAl10Fe3Mn2										
		2.0960	CuAl9Mn2										
		2.0966	CuAl10Ni5Fe4										
		2.0971	CuAl9Ni3Fe2										
		2.1016	CuSn4										
		2.1020	CuSn6										
		2.1030	CuSn8										
		2.1080	CuSn6Zn6										
		2.1191	CuAg0.1P										
		2.1203	CuAg0.1										
		2.1245	CuBe1.7										
		2.1247	CuBe2										
		2.1293	CuCrZr			42 3039							
		2.1310	CuFe2P										
		2.1522	CuSi2Mn										
		2.1525	CuSi3Mn										
		Ampco 16	CuAl10Fe3										
		Ampco 18	CuAl10.5Fe3.5										
		Ampco 8	CuAl6.5Fe2.5Sn										
			Ampco 8-16										
	N.3.2	2.0331	CuZn36Pb1.5			42 3214							
		2.0332	CuZn37Pb0.5										
		2.0372	CuZn39Pb0.5			42 3221							
		2.0540	CuZn35Ni2										
		2.0550	CuZn40Al2										
		2.0561	CuZn40Al1			42 3231							

	Index	Material number	DIN	AFNOR	UNI	ČSN	BS	SIS	UNE	JIS	GOST	UNS	USA
S	S.2.1	2.4856	NiCr22Mo9Nb	Inconel 625									
		2.4858	NiCr21Mo				NA 16			NCF 825		N 08825	
		2.4951	NiCr20Ti	Nimonic 75			HR 5						
		2.4964	CoCr20W15Ni										
		2.4989	CoCr20NiW										
	S.2.2	2.4375	NiCu30Al	Monel K 500									
		2.4631	NiCr20TiAl	Nimonic 80 A			HR 401; 601			NCF 80 A		N 07080	
		2.4634	NiCo20Cr15MoAlTi	Nimonic 105									
		2.4640	NiCr15Fe	Inconel 600									
		2.4654	NiCr20Co13Mo4Ti4Al	Waspaloy									
		2.4662	NiCr13Mo6Ti3	Nimonic 901									
		2.4668	NiCr19Fe18Nb5Mg	Inconel 718									
		2.4816	NiCr15Fe	Inconel 600			NA 14			NCF 600		N 06600	
		2.4952	NiCr20TiAl	Nimonic 80 A									
		2.4973	NiCr19Co11MoTi										
		2.4983	NiCr18Co18MoAlTi	Udimet 500									
	S.2.3	2.4670	G-NiCr13Al6MoNb	Nimocast 713									
		2.4674	NiCo15Cr10MoAlTi	Nimocast PK 24									
		2.4979	CoCr28MoNi										
	S.3.1	3.7024	Ti99,5										
		3.7025	Ti99,8										
		3.7034	Ti99,7										
		3.7055	Ti99,4										
		3.7064	Ti99,2										
		3.7124	TiCu2										
	S.3.2	3.7114	TiAl5Sn2										
		3.7144	TiAl6Sn2Zr4Mo2										
		3.7154	TiAl6Zr5										
		3.7165	TiAl6V4	T-A 6 V			TA 10 – TA 13					R 56400	
		3.7174	TiAl6V6Sn2										
		3.7184	TiAl4Mo4Sn2				TA 45 – TA 51						
H	H.1.1	1.2311	40 CrMnMo 7			19 520							
		1.2312	40 CrMnMoS 8 6	40 CMD 8 + S									
		1.2316	X 36 CrMo 17	Z 38 CD 17	X 38 CrMo 16 1 KU								
		1.2365	X 32 CrMoV 3 3	32 DCV 28	30 CrMoV 12 27 KU	19 541	BH 10			SKD 7	3Ch3M3F	T 20810	H 10
		1.2567	X 30 WCrV 5 3	Z 32 WCV 5	X 30 WCrV 5 3 KU	19 720				SKD 4			
		1.2581	X 30 WCrV 9 3	Z 30 WCV 9	X 30 WCrV 9 3 KU	19 721	BH 21			SKD 5	3Ch2W8F	T 20821	H 21
		1.2738	40 CrMnNiMo 8						F-5303				
		1.2885	X 32 CrMoCoV 3 3 3	30 DCKV 28									
		1.4028	X 30 Cr 13	Z 30 C 13	X 30 Cr 13	17 023	420 S 45	2304		SUS 420 J 2	30Ch13		
		1.4031	X 38 Cr 13	Z 40 C 14	X 40 Cr 14	17 024		2304	F-3404	SUS 420 J 2	40Ch13		
		1.4034	X 46 Cr 13	Z 40 C 14	X 40 Cr 14	17 029	420 S 45		F-3405		40Ch13		
		1.4112	X 90 CrMoV 18									S 44003	
		1.5122	37 MnSi 4			13 240							
		1.6358	X 2 NiCoMoTi 18 9 5										
		1.6582	34 CrNiMo 6	35 NCD 6	35 NiCrMo 6 (KW)	16 342	817 M 40	2541	F-128 / F-1270	SNCM 447	38Ch2N2MA		4340
		1.7003	38 Cr 2	38 C 2	38 Cr 2								
		1.7006	46 Cr 2	42 C 2	45 Cr 2								5045
		1.7030	28 Cr 4				530 A 30				30Ch		5130
		1.7176	55 Cr 3	55 C 3	55 Cr 3		527 A 60	2253	F-1431	SUP 9 (A)	50ChGA	G 51550	5155
		1.0961	60 SiCr 7	60 SC 7	60 SiCr 8					SUP 7			9262

	Index	Material number	DIN	AFNOR	UNI	ČSN	BS	SIS	UNE	JIS	GOST	UNS	USA
H	H.1.1	1.1248	Ck 75	XC 75	C 75	12 081	060 A 78	1774; 1778			75	G 10780	1078; 1080
		1.1273	90 Mn 4										
	H.1.2	1.2083	X 42 Cr 13	Z 40 C 14	X 41 Cr 13 KU	19 435			F-5263	SUS 420 J 2			
		1.2323	GS-48 CrMoV 6 7										
		1.2343	X 38 CrMoV 5 1	Z 38 CDV 5	X 37 CrMoV 5 1 KU	19 552	BH 11		F-5317	SKD 6	4Ch5MFS	T 28811	H 11
		1.2367	X 38 CrMoV 5 3										
		1.2510	100 MnCrW 4	90 MWCV 5	95 MnWCr 5 KU	19 314	BO 1	2140	F-5220	SKS 3		T 31501	O 1
		1.2542	45 WCrV 7		45 WCrV 8 KU	19 732	BS 1	2710				T 41901	S 1
		1.2550	60 WCrV 7	55 WC 20	55 WCrV 8 KU	19 735							
		1.2606	G-X 37 CrMoW 5 1										
		1.2711	54 NiCrMoV 6	55 NCDV 6		19 662							
		1.2713	55 NiCrMoV 6	55 NCDV 7		19 662			F-520.S	SKT 4	5ChNM	T 61206	L 6
		1.2764	X 19 NiCrMo 4										
		1.2767	X 45 NiCrMo 4	Y 35 NCD 16	42 NiCrMo 15 7	19 655							
		1.4109	X 65 CrMo 14										
		1.4112	X 90 CrMoV 18									S 44003	
		1.1157	40 Mn 4	35 M 5			150 M 36				40G	G 10390	1039
		1.1231	Ck 67	XC 68	C 70	12 071	060 A 67	1770			70	G 10700	1070
		1.1274	Ck 101	XC 100			060 A 96	1870		SUP 4		G 10950	1095
	H.1.3	1.2080	X 210 Cr 12	Z 200 C 12	X 210 Cr 13 KU	19 436	BD 3			SKD 1	Ch12	T 30403	D 3
		1.2101	62 SiMnCr 4										
		1.2162	21 MnCr 5	20 NC 5		19 487				SCR 420 H			
		1.2201	G-X 165 CrV 12										
		1.2210	115 CrV 3	100 C 3	107 CrV 3 KU	19 421						T 61202	L 2
		1.2341	X 6 CrMo 4										
		1.2379	X 155 CrVMo 12 1	Z 160 CDV 12	X 155 CrVMo 12 1 KU	19 573	BD 2		F-5211	SKD 11		T 30402	D 2
		1.2419	105 WCr 6	105 WC 13	107 WCr 5 KU					SKS 31	ChWG		
		1.2601	X 165 CrMoV 12		X 165 CrMoW 12 KU	19 572		2310					
		1.2721	50 NiCr 13										
		1.2735	15 NiCr 14	10 NC 12		16 240				SNC 22		T 51606	
		1.2833	100 V 1	Y1 105 V	102 V 2 KU	19 356	BW 2			SKS 43		T 72302	W 210
		1.2842	90 MnCrV 8	90 MV 8	90 MnVCr 8 KU	19 314	BO 2					T 31502	O 2
		1.3505	100 Cr 6	100 C 6	100 Cr 6	14 100	534 A 99	2258	F-131 / F-1310	SUJ 2	SchCh 15	G 52986	52100
		1.4112	X 90 CrMoV 18									S 44003	
		1.4125	X 105 CrMo 17	Z 100 CD 17	X 105 CrMo 17					SUS 440 C		S 44004	440 C
		1.8161	58 CrV 4			15 261							
		1.1520	C 70 W1										
	H.1.4	1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	X 100 CrMoV 5 1 KU	19 571	BA 2	2260	F-5227	SKD 12		T 30102	A 2
		1.2436	X 210 CrW 12	Z 200 CW 12	X 215 CrW 12 1 KU	19 437		2312	F-5213	SKD 2			
		1.2880	G-X 165 CrCoMo 12										
		1.3202	S 12-1-4-5			19 858						T 12015	T15
		1.3207	S 10-4-3-10	Z 130 WKCDV 10-10-04	HS 10-4-3-10	19 861	BT 42		F-5553	SKH 57			
		1.3243	S 6-5-2-5	Z 85 WDKCV 06-05-05	HS 6-5-2-5	19 852		2723	F-5613	SKH 55	R6M5K5		
		1.3246	S 7-4-2-5	Z 110 WKCDV 07-05-04	HS 7-4-2-5	19 851						T 11341	M 41
		1.3247	S 2-10-1-8	Z 110 DKCWV 09-08-04	HS 2-9-1-8		BM 42			SKH 51		T 11342	M 42
		1.3249	S 2-9-2-8				BM 34					T 11333	M 33; M 34
		1.3257	S 18-1-2-15										
		1.3333	S 3-3-2		HS 3-3-2	19 820							
		1.3343	S 6-5-2	Z 85 WDCV 06-05-04-0	HS 6-5-2	19 830	BM 2	2722	F-5603	SKH 9; SKH 51	R6AM5	T 11302	M 2
		1.3344	S 6-5-3	Z 120 WDCV 06-05-04	HS 6-5-3		BM 4			SKH 52; SKH 53		T 11323	M 3 Cl. 2
		1.3346	S 2-9-1	Z 85 DCWV 08-04-02-0	HS 1-8-1		BM 1				H41	T 11301	H 41; M 1

[illegible]

ISO designation system

ISO attribute	Feature Description
A	
ADJRG	Adjustment range
ADJRGR	Adjustment range radial
ALP	Clearance angle axial
AN	Clearance angle major
APMX	Depth of cut maximum
B	
B	Shank width
BD	Body diameter
BD_1	Body diameter, 1st cutting step
BD_2	Body diameter, 2nd cutting step
BD_3	Body diameter, 3rd cutting step
BD_4	Body diameter, 4th cutting step
BDRED	Body diameter, reduced
BDX	Body diameter maximum
BHTA	Body half taper angle
BLQ	Balance quality code
BN	Face land width
BS	Trailing edge length
BTED	Body taper end diameter
C	
CDX	Cutting depth maximum
CF	Central flat
CHW	Corner chamfer width
CHWTL	Flank chamfer width left hand
CLDIS_1	Centre line distance 1
CLDIS_2	Centre line distance 2
CLDIS_3	Centre line distance 3
CND	Coolant entry diameter
CNT	Coolant entry, thread size
CODX	Parting off diameter, max.
CRE	Spot radius
CRKS	Pull stud thread size
CW	Cutting width
CXD	Coolant exit diameter
D	
D1	Fixing hole diameter
DAXN	Axial groove outside diameter minimum
DAXX	Axial groove outside diameter maximum
DC	Cutting diameter
DC_1	Cutting diameter, 1st cutting step
DC_2	Cutting diameter, 2nd cutting step
DCD	Cutting diameter drilling part
DCINTF	Interference cutting diameter
DCN	Cutting diameter minimum
DCONMS	Mounting spigot diameter
DCONWS	Connection diameter workpiece side
DCONWS_1	Connection diameter workpiece side – 1
DCONWS_2	Connection diameter workpiece side – 2
DCSKX	Countersunk diameter, max
DCX	Cutting diameter maximum
DF	Flange diameter
DFC	Functional diameter
DHUB	Hub diameter
DLN	Diameter lock nut
DMIN	Minimum bore diameter
DN	Neck Diameter
DRVS	Drive size

ISO attribute	Feature Description
G	
GAN	Insert rake angle
GB	Face land angle
H	
H	Shank height
HDD	Head diameter
HDW	Head width
HF	Functional height
HLN	Lock nut height
HSUP	Support height
I	
IC	Inscribed circle diameter
IDNR	Identifying order number
IH	Insert hand
INSL	Insert length
K	
KAPR	Tool cutting edge angle
KCH	Corner chamfer angle
L	
L	Cutting edge length
L_1	Cutting edge length 1
L_2	Cutting edge length 2
L_3	Cutting edge length 3
LB	Body length
LB_1	Body length 1
LB_2	Body length 2
LCF	Length chip flute
LCOL	Collet length
LDRED	Reduced body diameter length
LE	Cutting edge effective length
LF	Functional length
LF_1	Functional length 1
LF_2	Functional length 2
LF_3	Functional length 3
LFSF	Distance to face
LH	Head length
LPCON	Connection protruding length
LPR	Protruding length
LS	Shank length
LSC	Clamping length machine side
LSCN	Clamping length minimum machine side
LSCX	Clamping length maximum machine side
LTA	Length tool assembly
LU	Usable length
M	
MXC	Clamping force maximum
N	
NOF	Flute count
NT	Tooth count
O	
OAH	Overall height
OAL	Overall length
OAW	Overall width

Continued on next page

ISO designation system

ISO attribute	Feature Description
P	
PDPT	Profile depth insert
PDX	Profile distance ex
PDY	Profile distance ey
PHD	Premachined hole diameter
PL	Point length
PLGL	Plug length
PNA	Profile included angle
PRFA	Profile angle
PRFRAD	Profile radius
PRFRAD1	Profile radius 1
PRFRAD2	Profile radius 2
PRFRAD3	Profile radius 3
PSIR	Tool lead angle
R	
RA	Relief angle
RADH	Radial height
RADW	Radial width
RADWOF	Radial offset width
RAL	Relief angle lh
RAR	Relief angle rh
RCSK	Radius countersunk
RE	Corner radius
RE_1	Corner radius 1
RE_2	Corner radius 2
RE_3	Corner radius 3
REL	Corner radius left hand
RETL	Flank radius left hand
RETR	Flank radius right hand
RHCDL	Radial height chamfer distance lower
RHCDU	Radial height chamfer distance upper
RPMX	Rotational speed maximum
S	
S	Insert thickness
S1	Insert thickness total
SD	Step distance
SDL	Step diameter length
SDL_1	Step diameter length 1
SDL_2	Step diameter length 2
SZID	Nominal size
T	
TD	Thread diameter
TDIN	Thread diameter, inch measure
THID	Thread designation inside
THL	Thread cutting part length
THOD	Thread designation outside
THSZMS	Connection thread nominal size
THSZWS	Connection thread nominal size workpiece side
TP	Thread pitch
TPI	Threads per inch
TQX	Torque maximum

ISO attribute	Feature Description
W	
W1	Insert width
WF	Functional width
WF2	Functional width 2
WT	Weight of item
Z	
ZEFF	Face effective cutting edge count
ZEFP	Peripheral effective cutting edge count
ZNF	Face mounted insert count
ZNP	Peripheral mounted insert count



We reserve the right to make technical changes and product improvements.

