


















Turning · Drehen

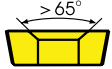

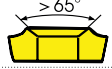

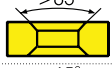

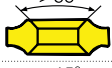
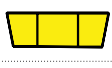
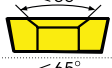
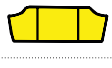

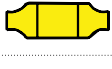


Turning Inserts Code Key · WSP ISO Kennzeichnung

A










General Turning
Allgemeine Drehbearbeitung

Turning Inserts Code Key
WSP ISO Kennzeichnung

Insert Shape / Schneidplattenform		
 A	 B	 C
 D	 E	 H
 K	 L	 M
 O	 P	 R
 S	 T	 T
 V	 W	Others Z
Insert Shape / Schneidplattenform		

Metric / Metrisch							
Code	Hole / Bohrung	Insert Section / Spanleitstufe	Insert Section / Plattenform	Code	Hole / Bohrung	Insert Section / Spanleitstufe	Insert Section / Plattenform
B	✓	---		N	---	---	
H	✓	Single side / einseitig		R	---	Single side / einseitig	
C	✓	---		F	---	Double side / doppelseitig	
J	✓	Double side / doppelseitig		A	✓	---	
W	✓	---		M	✓	Single side / einseitig	
T	✓	Single side / einseitig		G	✓	Double side / doppelseitig	
Q	✓	---		X	---	---	Special
U	✓	Double side / doppelseitig				---	
Insert Type / Plattentyp							



Clearance angle of main cutting edge Freiwinkel der Hauptschneide			
Code	angle / Winkel	Code	angle / Winkel
A	 3°	B	 5°
C	 7°	D	 15°
E	 20°	F	 25°
G	 30°	N	 0°
P	 11°	O	Others

Tolerances / Toleranzklasse										
Code	Tolerance	Incirle Tolerance ØI.C	Tolerance S	(Reference) M class precision (according to shape and size) (mm) (Bezug) M-Toleranz (entsprechend Form und Größe)						
				Incirle	regular triangle	square	80° rhomboid	55° rhomboid	35° rhomboid	round runde
A	±0.005	±0.025	±0.025	6.35	±0.08	±0.08	±0.08	±0.11	±0.16	---
F	±0.005	±0.013	±0.025	9.525	±0.08	±0.08	±0.08	±0.11	±0.16	---
C	±0.013	±0.025	±0.025	12.7	±0.13	±0.13	±0.13	±0.15	---	---
H	±0.013	±0.013	±0.025	15.875	±0.15	±0.15	±0.15	±0.18	---	---
E	±0.025	±0.025	±0.025	19.05	±0.15	±0.15	±0.15	±0.18	---	---
G	±0.025	±0.025	±0.13	25.4	---	±0.18	---	---	---	---
J	±0.005	±0.05±0.13	±0.025	ØI.C (mm) Incirle tolerance Eingeschriebener Kreis Toleranz						
K	±0.013	±0.05±0.13	±0.025	Incirle	regular triangle	square	80° rhomboid	55° rhomboid	35° rhomboid	round runde
L	±0.025	±0.05±0.13	±0.025	6.35	±0.05	±0.05	±0.05	±0.05	±0.05	---
M	±0.08±0.18	±0.05±0.13	±0.13	9.525	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05
N	±0.08±0.18	±0.05±0.13	±0.025	12.7	±0.08	±0.08	±0.08	±0.08	---	±0.08
				15.875	±0.10	±0.10	±0.10	±0.10	---	±0.10
				19.05	±0.10	±0.10	±0.10	±0.10	---	±0.10
U	±0.13±0.38	±0.08±0.25	±0.13	25.4	---	±0.13	---	---	---	±0.13

Turning · Drehen

Turning Inserts Code Key · WSP ISO Kennzeichnung

A

General Turning
Allgemeine Drehbearbeitung

Turning Inserts Code Key
WSP ISO Kennzeichnung

Ø of IC (mm)	Cutting edge length / Schneidenlänge (mm)							
	Insert Shape / Plattenform							
	C	D	R	S	T	V	W	K
3.97					06			
5.0			05					
5.56					09			
6.0			06					
6.35	06	07			11	11		
8.0			08					
9.525	09	11	09	09	16	16	06	16
10.0			10					
12.0			12					
12.7	12	15	12	12	22	22	08	
15.875	16		15	15	27			
16.0		19	16					
19.05	19		19	19	33			
20.0			20					
25.0	25	25	25					
25.4			25	25				
31.75			31					
32			32					

Insert Thickness / Dicke (mm)	
Thickness / Dicke	
Code	Insert Thickness (mm)
00	0.79
T0	0.99
01	1.59
T1	1.98
02	2.38
T2	2.58
03	3.18
T3	3.97
04	4.76
T4	4.96
05	5.56
T5	5.95
06	6.35
T6	6.75
07	7.94
09	9.52
T9	9.72
11	11.11
12	12.70

22 04 08 - DM (ISO)

4 3 2 (inch)

Incircle Innenkreis	
Code	Diameter (mm)
2	6.35
3	9.525
4	12.7
5	15.875
6	19.05
8	25.4

Thickness Dicke	
Code	Thickness (mm)
2	3.18
3	4.76
4	6.35
5	7.94
6	9.52

Nose radius Eckenradius	
Code	Nose radius (mm)
0	0.2
1	0.4
2	0.8
3	1.2
4	1.6
5	2.0
6	2.4

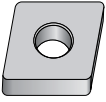
Nose radius Eckenradius	
Code	Radius (mm)
00	No Radius
02	0.2
04	0.4
08	0.8
12	1.2
16	1.6
20	2.0
24	2.4
32	3.2
X	Others
MO	Round Inserts Andere Runde Platten

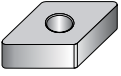
Code Chipbreakers Spanleitstufen		
DF	DM	DR / HDR

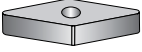
Turning · Drehen


Turning Insert Comparison List · WSP Vergleichstabelle


Metric and Imperial system comparison list of general turning insert/
Vergleichstabelle für allgemeine Drehwedgeschneidplatten (Metrisch / Imperial System)

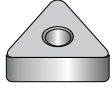
C Type Negative angle/WSP Negativer Winkel	(ISO)	(Inch)	Chipbreaker/ Spanleitstufe
Plattenform Insert shape 	090304	321	-DF -WG -SF -EF -NF -PM -DM -EM -TC -NM -LR -DR -ER -HDR -HPR
	090308	322	
	120404	431	
	120408	432	
	120412	433	
	120416	434	
	160608	542	
	160612	543	
	160616	544	
	190608	642	
	190612	643	
	190616	644	
	190624	646	
	250724	856	
	250732	858	
	250924	866	
250932	868		


D Type Negative angle/WSP Negativer Winkel	(ISO)	(Inch)	Chipbreaker/ Spanleitstufe
Plattenform Insert shape 	110404	331	-DF -WG -SF -NF -FM -PM -DM -EM -NM -LR -DR -ER -HDR
	110408	332	
	110412	333	
	150404	431	
	150408	432	
	150412	433	
	150604	441	
	150608	442	
	150612	443	
	150616	444	
	190608	542	
	190612	543	

V Type Negative angle/WSP Negativer Winkel	(ISO)	(Inch)	Chipbreaker/ Spanleitstufe
Insert shape Plattenform 	160404	331	-DF -EF -SF -NF -PM -DM -EM -NM
	160408	332	
	160412	333	

R Type Negative angle/WSP Negativer Winkel	(ISO)	(Inch)	Chipbreaker/ Spanleitstufe
Insert shape Plattenform 	0903MO	32	
	1204MO	43	

W Type Negative angle/WSP Negativer Winkel	(ISO)	(Inch)	Chipbreaker/ Spanleitstufe
Plattenform Insert shape 	06T304	3(2.5)1	-DF -WG -SF -EF -NF -PM -DM -EM -TC -NM -DR
	06T308	3(2.5)2	
	06T312	3(2.5)3	
	060404	331	
	060408	332	
	060412	333	
	080404	431	
	080408	432	
	080412	433	

T Type Negative angle/WSP Negativer Winkel	(ISO)	(Inch)	Chipbreaker/ Spanleitstufe
Plattenform Insert shape 	113304	221	-DF -WG -SF -EF -FM -PM -DM -EM -TC -LR -DR -ER -HDR
	110308	222	
	160404	331	
	160408	332	
	160412	333	
	220404	431	
	220408	432	
	220412	433	
	220416	434	
	270608	542	
	270612	543	
	270616	544	


S Type Negative angle/WSP Negativer Winkel	(ISO)	(Inch)	Chipbreaker/ Spanleitstufe
Plattenform Insert shape 	090304	321	-DF -SF -EF -PM -DM -EM -TC -NM -LR -DR -ER -HDR -HPR
	090308	322	
	090312	323	
	120404	431	
	120408	432	
	120412	433	
	120416	434	
	150608	542	
	150612	543	
	150616	544	
	190412	633	
	190424	636	
	190612	643	
	190616	644	
	250724	856	
	250732	858	
	250924	866	
	250932	868	

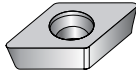
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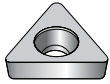
General Turning
Allgemeine Drehbearbeitung


Turning Insert Comparison List
WSP Vergleichstabelle

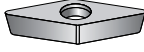
Metric and Imperial system comparison list of general turning insert/
Vergleichstabelle für allgemeine Drehwendeschneidplatten (Metrisch / Imperial System)

C Type Positive angle/WSP Positiver Winkel	(ISO)	(Inch)	Chipbreaker Spanleitstufe
Plattenform Insert shape 	060202	2(1.5)0	-USF
	060204	2(1.5)1	-SF
	060208	2(1.5)2	-HF
	09T302	3(2.5)0	-EF
	09T304	3(2.5)1	-HM
	09T308	3(2.5)2	-EM
	120404	431	-HR
	120408	432	-LH
	120412	433	-LC

D Type Positive angle/ WSP Positiver Winkel	(ISO)	(Inch)	Chipbreaker Spanleitstufe
Plattenform Insert shape 	070202	2(1.5)0	-USF
	070204	2(1.5)1	-SF
	070208	2(1.5)2	-HF
	11T302	3(2.5)0	-EF
	11T304	3(2.5)1	-HM
	11T308	3(2.5)2	-EM
	11T312	3(2.5)3	-HR
			-LH
			-LC

T Type Positive angle/WSP Positiver Winkel	(ISO)	(Inch)	Chipbreaker Spanleitstufe
Plattenform Insert shape 	06T102	1.2(1.2)0	-USF
	06T104	1.2(1.2)1	
	06T108	1.2(1.2)2	
	090202	1.8(1.5)0	
	090204	1.8(1.5)1	
	090208	1.8(1.5)2	
	110202	2(1.5)0	
	110204	2(1.5)1	
	110208	2(1.5)2	
	110302	220	
	110304	221	
	110308	222	
	16T302	30	
	16T304	31	
	16T308	32	
	16T312	33	
	160400	330	
	220408	432	
	220412	433	
	220416	434	
	270408	532	
	270412	533	
	330612	643	
	330616	644	

S Type Positive angle/WSP Positiver Winkel	(ISO)	(Inch)	Chipbreaker Spanleitstufe
Plattenform Insert shape 	060204	2(1.5)1	-USF
	09T302	3(2.5)0	
	09T304	3(2.5)1	
	09T308	3(2.5)2	
	120404	431	
	120408	432	
	120412	433	
	150404	531	
	150408	532	
	150412	533	
	190408	632	
	190412	633	
	190416	634	

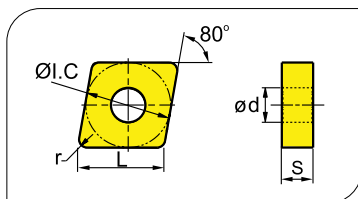
V Type Positive angle/WSP Positiver Winkel	(ISO)	(Inch)	Chipbreaker Spanleitstufe
Plattenform Insert shape 	110202	2(1.5)0	-USF
	110204	2(1.5)1	
	110208	2(1.5)2	
	110302	220	
	110304	221	
	110308	222	
	160402	330	
	160404	331	
	160408	332	
	160412	333	

Turning · Drehen

Cemented carbide and cermet inserts · Hartmetall und Cermet WSP

CN** Negative Insert · Negative WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Stainless Steel / Rostfreier Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Cast iron / Gusseisen	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Non-ferrous material / Ne Metalle	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Heat-resistant steel / Warmfester Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall													Cermet unbeschichtet	Cermet beschichtet / Cermet	Uncoated Carbide / unbeschichtetes Hartmetall						
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251	YBM253			YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101
DF Finishing Schlichten	CNMG090304-DF	9.7	9.525	3.18	3.81	0.4	○	●	○	●				○														
	CNMG090308-DF	9.7	9.525	3.18	3.81	0.8	○	●	○	●																		
	CNMG120404-DF	12.9	12.7	4.76	5.16	0.4	○	●	●	●				○		○												
	CNMG120408-DF	12.9	12.7	4.76	5.16	0.8	○	●	●	●	○																	
	CNMG120412-DF	12.9	12.7	4.76	5.16	1.2	○	●	●	●																		
WG Wiper	CNMG120404-WG	12.9	12.7	4.76	5.16	0.4	●																					
	CNMG120408-WG	12.9	12.7	4.76	5.16	0.8	●	●	○	●					○			●		●								
	CNMG120412-WG	12.9	12.7	4.76	5.16	1.2	●	●	○																			
	CNMG160608-WG	16.1	15.875	6.35	6.35	0.8		○																				
	CNMG160612-WG	16.1	15.875	6.35	6.35	1.2		○																				
SF Finishing Schlichten	CNMG090304-SF	9.7	9.525	3.18	3.81	0.4																			●			
	CNMG090308-SF	9.7	9.525	3.18	3.81	0.8																			●			
	CNMG120404-SF	12.9	12.7	4.76	5.16	0.4																			●			
	CNMG120408-SF	12.9	12.7	4.76	5.16	0.8																			●			
	CNMG120412-SF	12.9	12.7	4.76	5.16	1.2																						
EF Finishing Schlichten	CNMG090304-EF	9.7	9.525	3.18	3.81	0.4									●	○												
	CNMG090308-EF	9.7	9.525	3.18	3.81	0.8								○	●	○												
	CNMG120404-EF	12.9	12.7	4.76	5.16	0.4		○	○	○	○	●	○	●	●													
	CNMG120408-EF	12.9	12.7	4.76	5.16	0.8		○		●	●	●	○	●	○													
	CNMG120412-EF	12.9	12.7	4.76	5.16	1.2								○	○		○											

Tool holder / Klemmhalter



Page / Seite: A173 A180 A181 A192 A193 A238

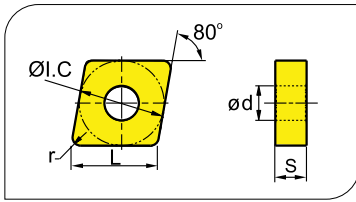
● Ex Stock / ab Lager ○ On demand / auf Anfrage YBC152F, YBC252F, YBM153F, YBM253F available / verfügbar.

Turning · Drehen

Cemented carbide and cermet inserts · Hartmetall und Cermet WSP

CN** Negative Insert · Negative WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●	●	●	●	●
Stainless Steel / Rostfreier Stahl	●	●	●	●	●
Cast iron / Gusseisen	●	●	●	●	●
Non-ferrous material / Ne Metalle	●	●	●	●	●
Heat-resistant steel / Warmfester Stahl	●	●	●	●	●

A

General Turning / Allgemeine Drehbearbeitung

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall								
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101	YD201
DM Medium Cut / Mittl. Bearb.	CNMG090304-DM	9.7	9.525	3.18	3.81	0.4	○	●	●	●																			
	CNMG090308-DM	9.7	9.525	3.18	3.81	0.8		●	●	●																			
	CNMG090312-DM	9.7	9.525	3.18	3.81	1.2				○																			
	CNMG120404-DM	12.9	12.7	4.76	5.16	0.4	○	●	●	●	●					○		○											
	CNMG120408-DM	12.9	12.7	4.76	5.16	0.8	●	●	●	●	●					●		●											
	CNMG120412-DM	12.9	12.7	4.76	5.16	1.2	●	●	●	●	●					○	○	●											
	CNMG120416-DM	12.9	12.7	4.76	5.16	1.6		●	○	●								○											
	CNMG160608-DM	16.1	15.875	6.35	6.35	0.8	○	●	○	●	●							○											
	CNMG160612-DM	16.1	15.875	6.35	6.35	1.2	○	●	●	●	○							○											
	CNMG160616-DM	16.1	15.875	6.35	6.35	1.6	○	●	●	●	●																		
	CNMG190608-DM	19.3	19.05	6.35	7.94	0.8		●	●	●								○											
	CNMG190612-DM	19.3	19.05	6.35	7.94	1.2		●	●	●	●							○											
CNMG190616-DM	19.3	19.05	6.35	7.94	1.6		●	●	●	●																			
EM Medium Cut / Mittl. Bearb.	CNMG120404-EM	12.9	12.7	4.76	5.16	0.4								●	●	●	○	●											
	CNMG120408-EM	12.9	12.7	4.76	5.16	0.8								●	●	○	●	○	●										
	CNMG120412-EM	12.9	12.7	4.76	5.16	1.2								○	●	●	○	●											
	CNMG160608-EM	16.1	15.875	6.35	6.35	0.8									●	●	●	●											
	CNMG160612-EM	16.1	15.875	6.35	6.35	1.2									○	●	●	○	●										
CNMG160616-EM	16.1	15.875	6.35	6.35	1.6										○														

Tool holder / Klemmhalter



Page / Seite: A173 A180 A181 A192 A193 A238

● Ex Stock / ab Lager ○ On demand / auf Anfrage YBC152F, YBC252F, YBM153F, YBM253F available / verfügbar.

Turning · Drehen

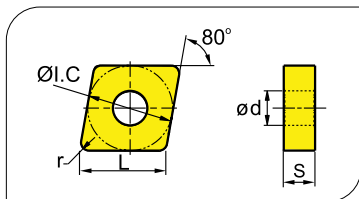
Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

A

General Turning
Allgemeine Drehbearbeitung

CN** Negative Insert- Negative WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



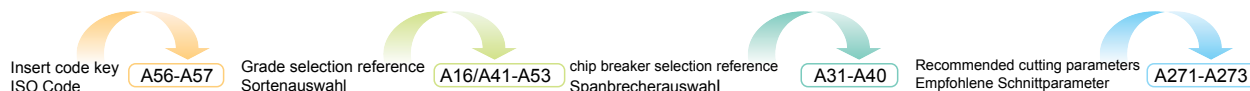
Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Stainless Steel / Rostfreier Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Cast iron / Gusseisen	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Non-ferrous material / Ne Metalle	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Heat-resistant steel / Warmfester Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall											Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall								
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153			YBM251	YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101
HDR Roughing / Schruppen	CNMM120408-HDR	12.9	12.7	4.76	5.16	0.8	○	●	●	●	●							○										
	CNMM120412-HDR	12.9	12.7	4.76	5.16	1.2	○	●	●	●								○										
	CNMM120416-HDR	12.9	12.7	4.76	5.16	1.6		○	●	●	○																	
	CNMM160612-HDR	16.1	15.875	6.35	6.35	1.2	○	●	●	●	○																	
	CNMM160616-HDR	16.1	15.875	6.35	6.35	1.6	○	○	●	●	○																	
	CNMM160624-HDR	16.1	15.875	6.35	6.35	2.4		○		●																		
	CNMM190608-HDR	19.3	19.05	6.35	7.94	0.8			○	●																		
	CNMM190612-HDR	19.3	19.05	6.35	7.94	1.2				○	●	○																
	CNMM190616-HDR	19.3	19.05	6.35	7.94	1.6	○	●	●	●	●											○						
	CNMM190624-HDR	19.3	19.05	6.35	7.94	2.4	○	●	●	●																		
	CNMM250924-HDR	25.79	25.4	9.525	9.12	2.4		●		●																		
HPR Roughing / Schruppen	CNMM190616-HPR	19.3	19.05	6.35	7.94	1.6				●																		
	CNMM250924-HPR	25.79	25.4	9.525	9.12	2.4				●																		
Basic 	CNMM120404	12.9	12.7	4.76	5.16	0.4	○	○																				
	CNMM120408	12.9	12.7	4.76	5.16	0.8		○																				
	CNMM120412	12.9	12.7	4.76	5.16	1.2			○																			
	CNMM190608	19.3	19.05	6.35	7.94	0.8			○																			
	CNMM190612	19.3	19.05	6.35	7.94	1.2				●	○																	
	CNMM190616	19.3	19.05	6.35	7.94	1.6				○																		
	CNMM190624	19.3	19.05	6.35	7.94	2.4																						

Tool holder / Klemmhalter



Page / Seite: A173 A180 A181 A192 A193 A238



Turning · Drehen

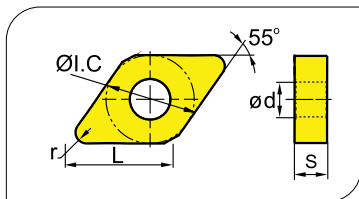
Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

A

General Turning
Allgemeine Drehbearbeitung

DN** Negative Insert-Negative WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



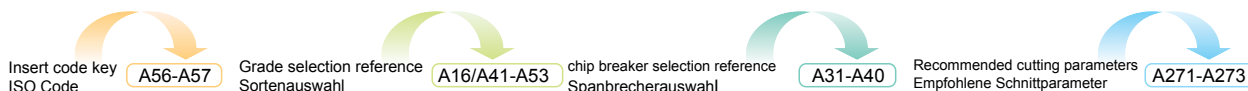
Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●	●	●	●	●
Stainless Steel / Rostfreier Stahl	●	●	●	●	●
Cast iron / Gusseisen	●	●	●	●	●
Non-ferrous material / Ne Metalle	●	●	●	●	●
Heat-resistant steel / Warmfester Stahl	●	●	●	●	●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall													Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall						
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251	YBM253			YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101
DF Finishing / Schlichten	DNMG110404-DF	11.6	9.525	4.76	3.81	0.4	○	●	○	●																		
	DNMG110408-DF	11.6	9.525	4.76	3.81	0.8	○	●	○	●																		
	DNMG110412-DF	11.6	9.525	4.76	3.81	1.2		●	○	○																		
	DNMG150404-DF	15.5	12.7	4.76	5.16	0.4	○	●	○	○																		
	DNMG150408-DF	15.5	12.7	4.76	5.16	0.8	○	●	○	●																		
	DNMG150412-DF	15.5	12.7	4.76	5.16	1.2		○	○	○																		
	DNMG150604-DF	15.5	12.7	6.35	5.16	0.4	○	●	●	●																		
	DNMG150608-DF	15.5	12.7	6.35	5.16	0.8	○	●	●	●																		
DNMG150612-DF	15.5	12.7	6.35	5.16	1.2		●	○	○																			
WG Wiper	DNMX110404-WG	11.6	9.525	4.76	3.81	0.4	●	○																				
	DNMX110408-WG	11.6	9.525	4.76	3.81	0.8	○	●	○	●																		
	DNMX150408-WG	15.5	12.7	4.76	5.16	0.8	○	○																				
	DNMX150412-WG	15.5	12.7	4.76	5.16	1.2		○																				
	DNMX150608-WG	15.5	12.7	6.35	5.16	0.8	○	●	○	●																		
DNMX150612-WG	15.5	12.7	6.35	5.16	1.2		○	●																				
SF Finishing / Schlichten	DNMG110404-SF	11.6	9.525	4.76	3.81	0.4																			●			
	DNMG150404-SF	15.5	12.7	4.76	5.16	0.4																			●			
	DNMG150408-SF	15.5	12.7	4.76	5.16	0.8																			●			
	DNMG150604-SF	15.5	12.7	6.35	5.16	0.4																			●			
	DNMG150608-SF	15.5	12.7	6.35	5.16	0.8																			●			

Tool holder / Klemmhalter



Page/Seite A174 A182 A183 A194 A195 A240 A241



Turning · Drehen

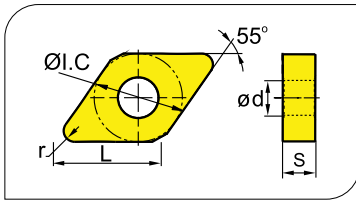
Cemented carbide and cermet inserts · Hartmetall und Cermet WSP

DN** Negative Insert Negative WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

A

General Turning
Allgemeine Drehbearbeitung



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●	●	●	●	●
Stainless Steel / Rostfreier Stahl	●	●	●	●	●
Cast iron / Gusseisen	●	●	●	●	●
Non-ferrite material / Ne Metalle	●	●	●	●	●
Heat-resistant steel / Warmfester Stahl	●	●	●	●	●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall							
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101
EM Medium Cut / Mittl. Bearb.	DNMG110404-EM	11.6	9.525	4.76	3.81	0.4									○	●	●											
	DNMG110408-EM	11.6	9.525	4.76	3.81	0.8									○	●	●	○										
	DNMG110412-EM	11.6	9.525	4.76	3.81	1.2									○													
	DNMG150404-EM	15.5	12.7	4.76	5.16	0.4										●	●											
	DNMG150408-EM	15.5	12.7	4.76	5.16	0.8										●	●											
	DNMG150412-EM	15.5	12.7	4.76	5.16	1.2										○	○											
	DNMG150604-EM	15.5	12.7	6.35	5.16	0.4									○	●	●	○	●									
	DNMG150608-EM	15.5	12.7	6.35	5.16	0.8									○	●	○	●	○	●								
	DNMG150612-EM	15.5	12.7	6.35	5.16	1.2										●	●	○	●									
NM Medium Cut / Mittl. Bearb.	DNMG150608-NM	15.5	12.7	6.35	5.16	1.2										●												
	DNMG150612-NM	15.5	12.7	6.35	5.16	1.2									○	●										○		
DR Roughing / Schruppen	DNMG150608-DR	15.5	12.7	6.35	5.16	0.8	○	●	●	●	○								○	●	●							
	DNMG150612-DR	15.5	12.7	6.35	5.16	1.2	○	●	●	●	○									●	●							
	DNMG150616-DR	15.5	12.7	6.35	5.16	1.6		●	○	●	○									●	○							
ER Roughing / Schruppen	DNMG150608-ER	15.5	12.7	6.35	5.16	0.8									○		●											
	DNMG150612-ER	15.5	12.7	6.35	5.16	1.2									○		●											

Tool holder / Klemmhalter



Page/Seite A174

A182

A183

A194

A195

A240

A241

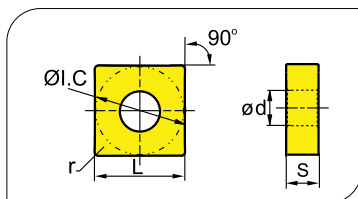
● Ex Stock / ab Lager ○ On demand / auf Anfrage YBC152F, YBC252F, YBM153F, YBM253F available / verfügbar.

Turning · Drehen



Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

SN** Negative Insert · Negative WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	Steel / Stahl	Stainless Steel / Rostfreier Stahl	Cast iron / Gusseisen	Non-ferrous material / Ne Metalle	Heat-resistant steel / Warmfester Stahl
P	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
M	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
K	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
N	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
S	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall							
		L	I.C.	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101
SF  Finishing / Schlichten	SNMG090304-SF	9.525	9.525	3.18	3.81	0.4																						
	SNMG090308-SF	9.525	9.525	3.18	3.81	0.8																						
	SNMG120404-SF	12.7	12.7	4.76	5.16	0.4																						
	SNMG120408-SF	12.7	12.7	4.76	5.16	0.8																						
	SNMG120412-SF	12.7	12.7	4.76	5.16	1.2																						
	SNMG150608-SF	15.875	15.875	6.35	6.35	0.8																						
PM  Medium Cut / Mittl. Bearb.	SNMG090304-PM	9.525	9.525	3.18	3.81	0.4		●	○																			
	SNMG090308-PM	9.525	9.525	3.18	3.81	0.8		●	○	○									○	●	●							
	SNMG090312-PM	9.525	9.525	3.18	3.81	1.2			○	○																		
	SNMG120404-PM	12.7	12.7	4.76	5.16	0.4	○	●	●	○											●	●						
	SNMG120408-PM	12.7	12.7	4.76	5.16	0.8	○	●	●	●	●									●	●	●						
	SNMG120412-PM	12.7	12.7	4.76	5.16	1.2	○	●	●	●	●									○	●	●						
	SNMG120416-PM	12.7	12.7	4.76	5.16	1.6		○	○	○	○									●	○	●						
	SNMG150608-PM	15.875	15.875	6.35	6.35	0.8				○																		
	SNMG150612-PM	15.875	15.875	6.35	6.35	1.2				●	●	○								○	●	●						
	SNMG190612-PM	19.05	19.05	6.35	7.94	1.2	○	●	●	●	●									○	●	●						
SNMG190616-PM	19.05	19.05	6.35	7.94	1.6				○																			

Tool holder / Klemmhalter

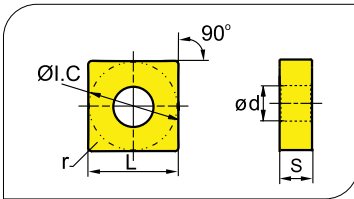
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Page/Seite A175	A184	A185	A186	A187	A196	A197
MSKNR/L Kr:75° 	MSDNN Kr:45° 	PSKNR/L Kr:75° 				
Page/Seite A198	A199	A243				

● Ex Stock / ab Lager ○ On demand / auf Anfrage YBC152F, YBC252F, YBM153F, YBM253F available / verfügbar.




Turning · Drehen

SN** Negative Insert-Negative WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen
● Normal Machining Condition / Normale Bearbeitungsbedingungen
● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S	Steel Stahl	Stainless Steel Rostfreier Stahl	Cast iron Gusseisen	Non-ferrite material Ne Metalle	Heat-resistant steel Warmfester Stahl
P	●	●	●	●	●	●	●	●	●	●
M	●	●	●	●	●	●	●	●	●	●
K	●	●	●	●	●	●	●	●	●	●
N	●	●	●	●	●	●	●	●	●	●
S	●	●	●	●	●	●	●	●	●	●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall													Cermet unbeschichtet	Cermet Coated beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall							
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251	YBM253			YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101	YD201
 Medium Cut / Mittl. Bearb.	SNMG120408-NM	12.7	12.7	4.76	5.16	0.8						●	●																
	SNMG120412-NM	12.7	12.7	4.76	5.16	1.2						○																○	
 Roughing / Schruppen	SNMG120408-DR	12.7	12.7	4.76	5.16	0.8	○	●	●	●	●										●	●							
	SNMG120412-DR	12.7	12.7	4.76	5.16	1.2	○	●	●	●	●										●	●							
	SNMG120416-DR	12.7	12.7	4.76	5.16	1.6	○	○	●	●	○										●	●							
	SNMG150608-DR	15.875	15.875	6.35	6.35	0.8					○																		
	SNMG150612-DR	15.875	15.875	6.35	6.35	1.2	○	●	●	●	○											●	●						
	SNMG150616-DR	15.875	15.875	6.35	6.35	1.6		○	●	●												○	○						
	SNMG150624-DR	15.875	15.875	6.35	6.35	2.4					○																		
	SNMG190612-DR	19.05	19.05	6.35	7.94	1.2	○	●	●	●	●											●							
	SNMG190616-DR	19.05	19.05	6.35	7.94	1.6	○	●	●	●	●											○	●						
	SNMG190624-DR	19.05	19.05	6.35	7.94	2.4	○	○	●	○	●																		
SNMG250924-DR	25.4	25.4	9.525	9.12	2.4					●	○																		
 Roughing / Schruppen	SNMG120408-ER	12.7	12.7	4.76	5.16	0.8										○	○	○											
	SNMG120412-ER	12.7	12.7	4.76	5.16	1.2										○	○	○											
	SNMG150608-ER	15.875	15.875	6.35	6.35	0.8										○	○	○											
	SNMG150612-ER	15.875	15.875	6.35	6.35	1.2										○	○	○											
	SNMG190612-ER	19.05	19.05	6.35	7.94	1.2										○	○	●											
	SNMG190616-ER	19.05	19.05	6.35	7.94	1.6										○	○	○											

Tool holder / Klemmhalter



Page/Seite A175 A184 A185 A186 A187 A196 A197



Page/Seite A198 A199 A243

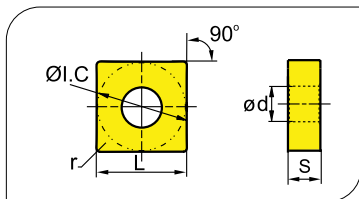
● Ex Stock / ab Lager ○ On demand / auf Anfrage

Turning · Drehen



Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

SN** Negative Insert-Negative WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen
● Normal Machining Condition / Normale Bearbeitungsbedingungen
● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

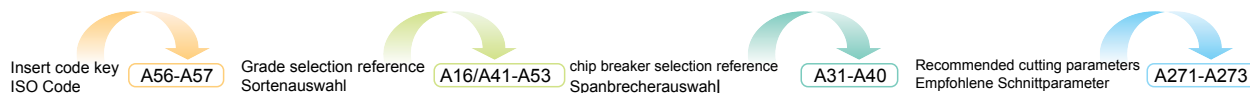


Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Stainless Steel / Rostfreier Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Cast iron / Gusseisen	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Non-ferrous material / Ne Metalle	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Heat-resistant steel / Warmfester Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall								
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101	YD201
 Roughing / Schruppen	SNMM120408-LR	12.7	12.7	4.76	5.16	0.8	○	●																					
	SNMM120412-LR	12.7	12.7	4.76	5.16	1.2	○	●																					
	SNMM120416-LR	12.7	12.7	4.76	5.16	1.6	○	○																					
	SNMM150612-LR	15.875	15.875	6.35	6.35	1.2	○	●																					
	SNMM150616-LR	15.875	15.875	6.35	6.35	1.6	○	○																					
	SNMM190612-LR	19.05	19.05	6.35	7.94	1.2	○	●											○										
	SNMM190616-LR	19.05	19.05	6.35	7.94	1.6	○	●																					
	SNMM190624-LR	19.05	19.05	6.35	7.94	2.4	○	●																					
SNMM250924-LR	25.4	25.4	9.525	9.12	2.4	●	●																						
 Roughing / Schruppen	SNMM120408-DR	12.7	12.7	4.76	5.16	0.8		○	○																				
	SNMM120412-DR	12.7	12.7	4.76	5.16	1.2		○	○																				
	SNMM120416-DR	12.7	12.7	4.76	5.16	1.6																							
	SNMM150608-DR	15.875	15.875	6.35	6.35	0.8		○	●																				
	SNMM150612-DR	15.875	15.875	6.35	6.35	1.2		○	●																				
	SNMM150616-DR	15.875	15.875	6.35	6.35	1.6		○	○																				
	SNMM190608-DR	19.05	19.05	6.35	7.94	0.8				○																			
	SNMM190612-DR	19.05	19.05	6.35	7.94	1.2	●	●	●	●																			
	SNMM190616-DR	19.05	19.05	6.35	7.94	1.6	●	●	●	●																			
	SNMM190624-DR	19.05	19.05	6.35	7.94	2.4	○	●	●	●	○																		
	SNMM250716-DR	25.4	25.4	7.94	9.12	1.6				●																			
	SNMM250724-DR	25.4	25.4	7.94	9.12	2.4		○	●	●	●																		
SNMM250924-DR	25.4	25.4	9.525	9.12	2.4		○	●	●																				

Tool holder / Klemmhalter

 DSBNR/L Kr:75° Page/Seite A175	 PSBNR/L Kr:75° A184	 PSDNN Kr:45° A185	 PSKNR/L Kr:75° A186	 PSSNR/L Kr:45° A187	 MSBNR/L Kr:75° A196	 MSRNR/L Kr:75° A197
 MSKNR/L Kr:75° Page/Seite A198	 MSDNN Kr:45° A199	 PSKNR/L Kr:75° A243				



A

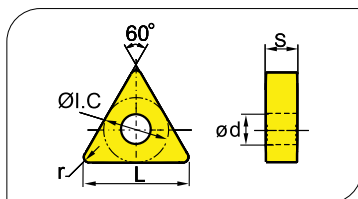
General Turning / Allgemeine Drehbearbeitung

Turning · Drehen

Cemented carbide and cermet inserts · Hartmetall und Cermet WSP

TN** Negative Insert-Negative WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	Steel / Stahl	Stainless Steel / Rostfreier Stahl	Cast iron / Gusseisen	Non-ferrous material / Ne Metalle	Heat-resistant steel / Warmfester Stahl
P	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
M	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
K	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
N	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
S	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / Beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall								
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101	YD201
HDR Heavy Turning / Schwer zerspannung	TNMM160408-HDR	16.5	9.525	4.76	3.81	0.8																							
	TNMM160412-HDR	16.5	9.525	4.76	3.81	1.2																							
	TNMM220408-HDR	22	12.7	4.76	5.16	0.8																							
	TNMM220412-HDR	22	12.7	4.76	5.16	1.2																							
	TNMM220416-HDR	22	12.7	4.76	5.16	1.6																							
	TNMM270612-HDR	27.5	15.875	6.35	6.35	1.2																							
	TNMM270616-HDR	27.5	15.875	6.35	6.35	1.6																							
	TNMM270624-HDR	27.5	15.875	6.35	6.35	2.4																							
Basic 	TNMG110308	11	6.35	3.18	2.26	0.8	○																						
	TNMG160404	16.5	9.525	4.76	3.81	0.4		●	○																				
	TNMG160408	16.5	9.525	4.76	3.81	0.8		●	●	○																			
	TNMG160412	16.5	9.525	4.76	3.81	1.2		●	●	●																			
	TNMG220404	22	12.7	4.76	5.16	0.4			○	○																			
	TNMG220408	22	12.7	4.76	5.16	0.8			●	○																			
	TNMG220412	22	12.7	4.76	5.16	1.2			○	○	○																		
	TNMG220416	22	12.7	4.76	5.16	1.6			○	○																			
	TNMG270612	27.5	15.875	6.35	6.35	1.2			○	○	●																		
	TNMG270616	27.5	15.875	6.35	6.35	1.6			○	○	●																		
	TNMG330916	33	19.05	9.525	7.94	1.6			○	○	○																		
	TNMG330924	33	19.05	9.525	7.94	2.4			○	○	○																		

Tool holder / Klemmhalter

DTGNR/L Kr:91° 	PTFNR/L Kr:90° 	PTTNR/L Kr:60° 	PTGNR/L Kr:90° 	MTGNR/L Kr:90° 	MTJNR/L Kr:93° 	MTFNR/L Kr:90°
Page/Seite A176	A188	A189	A190	A200	A201	A203
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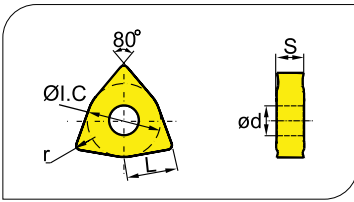
● Ex Stock / ab Lager ○ On demand / auf Anfrage YBC152F, YBC252F, YBM153F, YBM253F available / verfügbar.

Turning · Drehen

Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

WN** Negative Insert · Negative WSP



● Ideal Machining Condition / Gute Bearbeitungsbedingungen
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Stainless Steel / Rostfreier Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Cast iron / Gusseisen	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Non-ferrous material / Ne Metalle	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
Heat-resistant steel / Warmfester Stahl	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●

A

General Turning / Allgemeine Drehbearbeitung

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall													Cermet unbeschichtet	Cermet Coated / Beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall							
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251	YBM253			YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101	YD201
 Finishing / Schlichten	WNUMG06T304-DF	6.5	9.525	3.97	3.81	0.4																							
	WNUMG06T308-DF	6.5	9.525	3.97	3.81	0.8																							
	WNUMG06T312-DF	6.5	9.525	3.97	3.81	1.2																							
	WNUMG060404-DF	6.5	9.525	4.76	3.81	0.4	○	●	●	●																			
	WNUMG060408-DF	6.5	9.525	4.76	3.81	0.8	○	●	●	●																			
	WNUMG060412-DF	6.5	9.525	4.76	3.81	1.2	○	●	○	○																			
	WNUMG080404-DF	8.7	12.7	4.76	5.16	0.4	○	●	●	●																			
	WNUMG080408-DF	8.7	12.7	4.76t	5.16	0.8	○	●	●	○																			
	WNUMG080412-DF	8.7	12.7	4.76	5.16	1.2	○	●	●	●																			
 Wiper	WNUMG060404-WG	6.5	9.525	4.76	3.81	0.4																							
	WNUMG060408-WG	6.5	9.525	4.76	3.81	0.8																							
	WNUMG060412-WG	6.5	9.525	4.76	3.81	1.2																							
	WNUMG080404-WG	8.7	12.7	4.76	5.16	0.4																							
	WNUMG080408-WG	8.7	12.7	4.76	5.16	0.8	●	●	●	●		○			○														
	WNUMG080412-WG	8.7	12.7	4.76	5.16	1.2	●	●	●	●																			

Tool holder / Klemmhalter



Page/Seite A179 A191 A206 A245

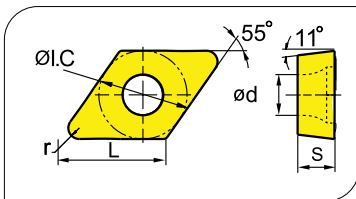
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Turning · Drehen

Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

DP** Positive Insert/ Positive WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●	●	●	●	●
Stainless Steel / Rostfreier Stahl		●	●	●	●
Cast iron / Gusseisen			●	●	●
Non-ferrous material / Ne Metalle				●	●
Heat-resistant steel / Warmfester Stahl					●

insert shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtete Hartmetall													Cermet unbeschichtet	Cermet Coated / Beschicht. Cermet	carbide / Hartmetall							
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251	YBM253			YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101	YD201
	DPGT0702005R-USF	7.8	6.35	2.38	2.8	0.05																							
	DPGT070201R-USF	7.8	6.35	2.38	2.8	0.1																							
	DPGT11T301R-USF	11.6	9.525	3.97	4.4	0.1																							
	DPGT0702005L-USF	7.8	6.35	2.38	2.8	0.05																							
	DPGT070201L-USF	7.8	6.35	2.38	2.8	0.1																							
	DPGT11T301L-USF	11.6	9.525	3.97	4.4	0.1																							
	DPGT070202-SF	7.8	6.35	2.38	2.8	0.2																	●	●					
	DPGT070204-SF	7.8	6.35	2.38	2.8	0.4																	●	●					
	DPGT070208-SF	7.8	6.35	2.38	2.8	0.8																	○	●					
	DPGT11T304-SF	11.6	9.525	3.97	4.4	0.4																	●	●					
	DPGT11T308-SF	11.6	9.525	3.97	4.4	0.8																	○	○					
	DPMW11T304	11.6	9.525	3.97	4.4	0.4																							
	DPMW11T308	11.6	9.525	3.97	4.4	0.8																							

Tool holder / Klemmhalter



Page/Seite A265

A266

Insert code key / ISO Code

A56-A57

Grade selection reference / Sortenauswahl

A16/A41-A53

chip breaker selection reference / Spanbrecherauswahl

A31-A40

Recommended cutting parameters / Empfohlene Schnittparameter

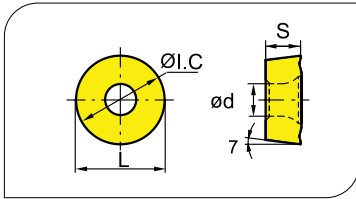
A271-A273

Turning · Drehen

Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

RC** Positive Insert/ Positive WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

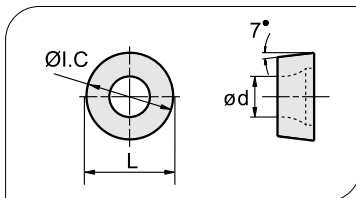


Workpiece Material / Werkstoffe	P Steel Stahl	M Stainless Steel Rostfreier Stahl	K Cast iron Gusseisen	N Non-ferrite material Ne Metalle	S Heat-resistant steel Warmfester Stahl
P	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
M	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
K	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
N	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
S	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●

Insert Shape / Schneidplattenform	Type Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated beschicht. Cermet	Uncoated Carbide unbeschicht. Hartmetall								
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101	YD201
	Basic RCGT1204MO	12	12	4.76	4.4	\		●																					
	RCGT190600	19.05	19.05	6.35	6.55	\			○																				
	RCMT0803MO	8.0	8.0	3.18	3.36	\			●												●								
	RCMT10T3MO	10	10	3.97	3.6	\			●	○				○								○							
	RCMT1204MO	12	12	4.76	4.4	\	○	●	●	●				○							●	●							
	RCMT1606MO	16	16	6.35	5.5	\	○	●	●	●	●										○	●							
	RCMT2006MO	20	20	6.35	6.5	\	○	●	●	●																			
	RCMT2507MO	25	25	7.94	7.7	\	○	●	●	○																			

RC** positive insert

● Ideal Machining Condition / Gute Bearbeitungsbedingungen
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P Steel Stahl	M Stainless Steel Rostfreier Stahl	K Cast iron Gusseisen	N Non-ferrite material Ne Metalle	S Heat-resistant steel Warmfester Stahl
P	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
M	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
K	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
N	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
S	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●

Insert Shape / Schneidplattenform	Type Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated beschicht. Cermet	Uncoated Carbide unbeschicht. Hartmetall										
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101	YD201		
	LH RCGX0803MO-LH	8.0	8.0	3.18	3.36	\																								●	

Tool holder / Klemmhalter



Page/Seite A224

A225

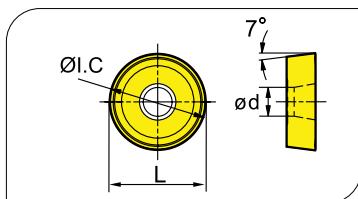
● Ex Stock / ab Lager ○ On demand / auf Anfrage YBC152F, YBC252F, YBM153F, YBM253F available / verfügbar.

Turning · Drehen


Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

RC** Positive Insert/ Positive WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen
⊗ Normal Machining Condition / Normale Bearbeitungsbedingungen
⊗ Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Stainless Steel / Rostfreier Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Cast iron / Gusseisen	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Non-ferrous material / Ne Metalle	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Heat-resistant steel / Warmfester Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall													Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall						
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251	YBM253			YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101
	RCMX0803MO	8.0	8.0	3.18	3.36	\		●	○	○																		
	RCMX1003MO	10	10	3.18	3.6	\	○	●	○	●																		
	RCMX1204MO	12	12	4.76	4.4	\	○	○	●	○	○																	
	RCMX1606MO	16	16	6.35	5.5	\	○	○	●	●	●																○	○
	RCMX2006MO	20	20	6.35	6.5	\	○	●	●	●	●																○	○
	RCMX2507MO	25	25	7.94	7.2	\	○	●	○	●	●							○										
	RCMX2507MO-1	25	25	7.94	7.2	\	○	●																				
	RCMX3209MO	32	32	9.52	9.5	\	○	○	●	●	○																	
	RCMX3209MO-PV	32	32	9.52	9.5	\	○	○	●	●																		

A

General Turning / Allgemeine Drehbearbeitung

Insert code key / ISO Code: **A56-A57**

Grade selection reference / Sortenauswahl: **A16/A41-A53**

chip breaker selection reference / Spanbrecherauswahl: **A31-A40**

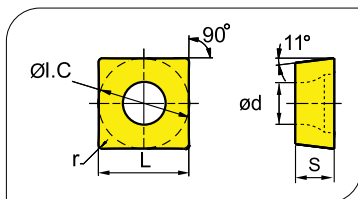
Recommended cutting parameters / Empfohlene Schnittparameter: **A271-A273**

Turning · Drehen

Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

SP** Positive Insert/ Positive WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Stainless Steel / Rostfreier Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Cast iron / Gusseisen	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Non-ferrite material / Ne Metalle	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Heat-resistant steel / Warmfester Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall								
		L	I.C.	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101	YD201
Flat Glatt 	SPMW09T304	9.525	9.525	3.97	4.4	0.4		○																					
	SPMW09T308	9.525	9.525	3.97	4.4	0.8		○																					
	SPMW120408	12.7	12.7	4.76	5.56	0.8																							

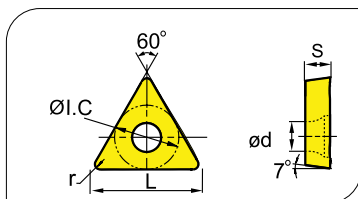
● Ex Stock / ab Lager ○ On demand / auf Anfrage YBC152F, YBC252F, YBM153F, YBM253F available / verfügbar.

Turning · Drehen

Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

TC** Positive Insert/ Positive WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen
● Normal Machining Condition / Normale Bearbeitungsbedingungen
● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●				
Stainless Steel / Rostfreier Stahl		●●●●●			
Cast iron / Gusseisen			●●●●●		
Non-ferrous material / Ne Metalle				●●●●●	
Heat-resistant steel / Warmfester Stahl					●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall								
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101	YD201
	TCMT06T104-HF	6.4	3.97	1.98	2.2	0.4																							
	TCMT06T108-HF	6.4	3.97	1.98	2.2	0.8																							
	TCMT090202-HF	9.6	5.56	2.38	2.5	0.2	○	○	●	●														●					
	TCMT090204-HF	9.6	5.56	2.38	2.5	0.4	○	○	○	●					○									○					
	TCMT090208-HF	9.6	5.56	2.38	2.5	0.8	○		●	○														○					
	TCMT110202-HF	11	6.35	2.38	2.8	0.2				●	○			●										○					
	TCMT110204-HF	11	6.35	2.38	2.8	0.4	○	●	●	●	○													○		○			
	TCMT110208-HF	11	6.35	2.38	2.8	0.8	○	●	○	●	○			○									●	○					
	TCMT16T302-HF	16.5	9.525	3.97	4.4	0.2				○																			
	TCMT16T304-HF	16.5	9.525	3.97	4.4	0.4	○	●	●						○		○							○					
	TCMT16T308-HF	16.5	9.525	3.97	4.4	0.8	○	●	●															○					

Tool holder / Klemmhalter



Page/Seite A220 A220 A221 A222 A252

Insert code key / ISO Code

A56-A57

Grade selection reference / Sortenauswahl

A16/A41-A53

chip breaker selection reference / Spanbrecherauswahl

A31-A40

Recommended cutting parameters / Empfohlene Schnittparameter

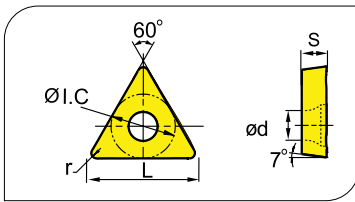
A271-A273

Turning · Drehen



Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

TC** Positive Insert/ Positive WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	Steel / Stahl	Stainless Steel / Rostfreier Stahl	Cast iron / Gusseisen	Non-ferrite material / Ne Metalle	Heat-resistant steel / Warmfester Stahl
P	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
M	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
K	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
N	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●
S	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●	●●●●●●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall									
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101	YD201	
 Aluminium Machining / Aluminium bearbeitung	TCGX090202-LC	9.6	5.56	2.38	2.5	0.2																							●	
	TCGX090204-LC	9.6	5.56	2.38	2.5	0.4																							●	
	TCGX110202-LC	11	6.35	2.38	2.8	0.2																							●	
	TCGX110204-LC	11	6.35	2.38	2.8	0.4																							●	
	TCGX110208-LC	11	6.35	2.38	2.8	0.8																							●	
	TCGX16T304-LC	16.5	9.525	3.97	4.4	0.4																							●	
	TCGX16T308-LC	16.5	9.525	3.97	4.4	0.8																							●	
 Aluminium Machining / Aluminium bearbeitung	TCGX090202-LH	9.6	5.56	2.38	2.5	0.2									○													●		
	TCGX090204-LH	9.6	5.56	2.38	2.5	0.4									○														●	
	TCGX110202-LH	11	6.35	2.38	2.8	0.2									●														●	
	TCGX110204-LH	11	6.35	2.38	2.8	0.4									●														●	
	TCGX110208-LH	11	6.35	2.38	2.8	0.8									○														○	
	TCGX16T302-LH	16.5	9.525	3.97	4.4	0.2									○														●	
	TCGX16T304-LH	16.5	9.525	3.97	4.4	0.4									○														●	
	TCGX16T308-LH	16.5	9.525	3.97	4.4	0.8									○														●	

Tool holder / Klemmhalter



Page/Seite A220 A220 A221 A222 A252

● Ex Stock / ab Lager ○ On demand / auf Anfrage YBC152F, YBC252F, YBM153F, YBM253F available / verfügbar.

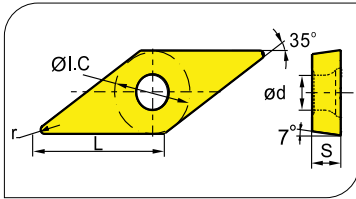
General Turning / Allgemeine Drehbearbeitung

Turning · Drehen

Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

VC** Positive Insert/ Positive WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●	●	●	●	●
Stainless Steel / Rostfreier Stahl	●	●	●	●	●
Cast iron / Gusseisen	●	●	●	●	●
Non-ferrous material / Nichte Metalle	●	●	●	●	●
Heat-resistant steel / Warmfester Stahl	●	●	●	●	●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / Beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall								
		L	I.C	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101	YD201
USF Finishing Schlichten	VCGT080201R-USF	8	4.76	2.38	2.3	0.1																							
	VCGT080202R-USF	8	4.76	2.38	2.3	0.2																							
	VCGT110301R-USF	11	6.35	3.18	2.8	0.1																							
	VCGT110302R-USF	11	6.35	3.18	2.8	0.2																							
USF Finishing Schlichten	VCGT080201L-USF	8	4.76	2.38	2.3	0.1																							
	VCGT080202L-USF	8	4.76	2.38	2.3	0.2																							
	VCGT110301L-USF	11	6.35	3.18	2.8	0.1																							
	VCGT110302L-USF	11	6.35	3.18	2.8	0.2																							
SF Finishing Schlichten	VCGT110302-SF	11	6.35	3.18	2.8	0.2																							
	VCGT110304-SF	11	6.35	3.18	2.8	0.4																							
	VCGT160404-SF	16.5	9.525	4.8	4.4	0.4																							
HF Finishing Schlichten	VCGT110304-HF	11	6.35	3.18	2.8	0.4																							
	VCGT130304	13.8	7.94	3.3	3.4	0.4																							
NF Finishing Schlichten	VCGT160408-NF	16.5	9.525	4.76	4.4	0.8																							

Tool holder / Klemmhalter



Page/Seite A253 A254 A216 A217

● Ex Stock / ab Lager ○ On demand / auf Anfrage YBC152F, YBC252F, YBM153F, YBM253F available / verfügbar.

Turning · Drehen

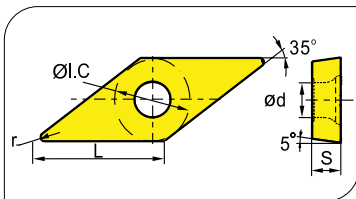
Cemented carbide and cermet Inserts · Hartmetall und Cermet WSP

A

General Turning
Allgemeine Drehbearbeitung

VB** Positive Insert/ Positive WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Stainless Steel / Rostfreier Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Cast iron / Gusseisen	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Non-ferrous material / Ne Metalle	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Heat-resistant steel / Warmfester Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall							
		L	I.C.	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD152C	YNG151	YNG151C	YD101
EM Medium Cut / Mittl. Bearb.	VBMT110304-EM	11	6.35	3.18	2.8	0.4								○	●	●												
	VBMT110308-EM	11	6.35	3.18	2.8	0.8								○	●	●												
	VBMT160404-EM	16.5	9.525	4.76	4.4	0.4									●	●												
	VBMT160408-EM	16.5	9.525	4.76	4.4	0.8									●	●												
HM Medium Cut / Mittl. Bearb.	VBMT160404-HM	16.5	9.525	4.76	4.4	0.4	○	●	●	●	●			●	○	○					●						○	
	VBMT160408-HM	16.5	9.525	4.76	4.4	0.8	○	●	●	●	●			●	○	○					●	●					○	
	VBMT160412-HM	16.5	9.525	4.76	4.4	1.2		●	●	○	○											○						○
HR Roughing / Schruppen	VBMT160404-HR	16.5	9.525	4.76	4.4	0.4		●	○	●																		
	VBMT160408-HR	16.5	9.525	4.76	4.4	0.8	○	●	●	●	○				○	○												
	VBMT160412-HR	16.5	9.525	4.76	4.4	1.2		●	○	●											○							
	VBGT160408-HR	16.5	9.525	4.76	4.4	0.8					○																	
Flat Glatt	VBMT160404	16.5	9.525	4.76	4.4	0.4	○																				○	
	VBMT160408	16.5	9.525	4.76	4.4	0.8																						○

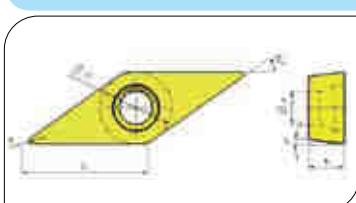
Tool holder / Klemmhalter



Page/Seite A213 A214 A215 A255 A256

VC** Positive Insert/ Positive WSP

● Ideal Machining Condition / Gute Bearbeitungsbedingungen
 ● Normal Machining Condition / Normale Bearbeitungsbedingungen
 ● Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen



Workpiece Material / Werkstoffe	P	M	K	N	S
Steel / Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Stainless Steel / Rostfreier Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Cast iron / Gusseisen	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Non-ferrous material / Ne Metalle	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●
Heat-resistant steel / Warmfester Stahl	●●●●●	●●●●●	●●●●●	●●●●●	●●●●●

Insert Shape / Schneidplattenform	Type / Typ	Dimension (mm) / Abmessung					Coated Carbide / Beschichtetes Hartmetall												Cermet unbeschichtet	Cermet Coated / beschicht. Cermet	Uncoated Carbide / unbeschicht. Hartmetall							
		L	I.C.	S	d	r	YBC151	YBC152	YBC251	YBC252	YBC351	YBG102	YBG105	YBG202	YBG205	YBM151	YBM153	YBM251			YBM253	YBD052	YBD102	YBD152	YBD252	YNG151	YNG151C	YD101
EF	VCMT160404-EF	16	9.525	4.76	4.4	0.4																						
EM Finishing / Schlichten	VCMT160404-EM	16	9.525	4.76	4.4	0.4									●	○	○											
	VCMT160408-EM	16	9.525	4.76	4.4	0.8									●	○												

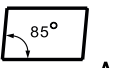
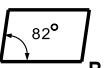
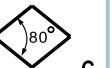


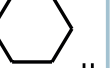
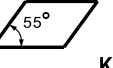

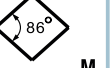
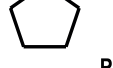



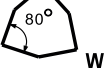


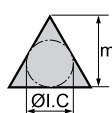

Turning · Drehen

PCBN & PCD Inserts Code Key · PCBN & PCD ISO Kennzeichnung WSP










A


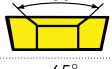
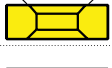
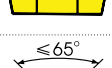
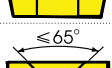

General Turning
Allgemeine Drehbearbeitung

Insert shape Schneidplattenform		
 85° A	 82° B	 80° C
 55° D	 75° E	 H
 55° K	 L	 86° M
 P	 S	 T
 35° V	 80° W	Others Andere Z

Tolerance Toleranzklasse							
							
Code	Tolerance Toleranzklasse	Tolerance Toleranzklasse Øl.C	Thickness S Dicke	Code	Tolerance Toleranzklasse	Tolerance Toleranzklasse Øl.C	Thickness S Dicke
A	±0.005	±0.025	±0.025	J	±0.005	±0.05-±0.13	±0.025
F	±0.005	±0.013	±0.025	K	±0.013	±0.05-±0.13	±0.025
C	±0.013	±0.025	±0.025	L	±0.025	±0.05-±0.13	±0.025
H	±0.013	±0.013	±0.025	M	±0.08-±0.18	±0.05-±0.13	±0.13
E	±0.025	±0.025	±0.025	N	±0.08-±0.18	±0.05-±0.13	±0.025
G	±0.025	±0.025	±0.13	U	±0.13-±0.38	±0.08-±0.25	±0.13

C N G A

Clearance angle of main cutting edge Freiwinkel der Hauptschneide			
Code	Angle Winkel	Code	Angle Winkel
A	 3°	B	 5°
C	 7°	D	 15°
E	 20°	F	 25°
G	 30°	N	 0°
P	 11°	O	Others Andere

Insert type Plattentyp		
Code	Hole Loch	Insert Section Ausführung
N	---	
B	✓	 > 65°
C	✓	 > 65°
A	✓	
W	✓	 ≤ 65°
Q	✓	 ≤ 65°
X	---	Special Spezial

Turning · Drehen

PCBN & PCD Inserts Code Key · PCBN & PCD ISO Kennzeichnung WSP

A

General Turning
Allgemeine Drehbearbeitung

Cutting edge length Schneidenlänge (mm)		Insert Shape Plattenform					
Diameter of incircle Eingeschriebener Kreis (mm)	C	D	S	T	V	W	
3.97				06			
5.0				09			
5.56							
6.0							
6.35	06	07		11	11		
8.0							
9.525	09	11	09	16	16	06	
10.0							
12.0							
12.7	12	15	12	22	22	08	
15.875	16		15	27			
16.0		19					
19.05	19		19	33			
20.0							
25.0	25	25					
25.4			25				
31.75							
32							

Insert thickness Dicke (mm)			
thickness Dicke		thickness Dicke	
Code	Insert Thickness Dicke	Code	Insert Thickness Dicke
02	2.38	06	6.35
T2	2.58	T6	6.75
03	3.18	07	7.94
T3	3.97	09	9.52
04	4.76	T9	9.72
T4	4.96	11	11.11
05	5.56	12	12.70
T5	5.95		

Nose radius Eckenradius (mm)	
Code	Radius (mm)
00	-
02	0.2
04	0.4
08	0.8
12	1.2
16	1.6
20	2.0
24	2.4
32	3.2
X	Others Andere
Mo	Round Insert Runde Platten

12 04 08 T 020 20 -2 W

Profile of cutting edges Schneidkantenausführung		
Code	Cutting Edge Schneidkante	Shape Form Plattenform
F	Sharp edges Scharfe Kante	
E	Honing Verrundung	
T	Chamfering Fase	
S	Chamfering Fase + Honing Verrundung	

width of chamfer Breite der Fase			
010	0.10	040	0.40
015	0.15	045	0.45
020	0.20	050	0.50
025	0.25	100	1.00
030	0.30	200	2.00
035	0.35		

angle of chamfer Winkel der Fase	
05	5°
10	10°
15	15°
20	20°
25	25°
30	30°

Number of cutting edges Anzahl der Schneidkanten		
Code	Number of edges Anzahl der Schneidkanten	
1	1	
2	2	
3	3	
4	4	

Wiper edge Wiperfase
W

**Standard edge preparation
Standard Faserausführung**













	CBN				Solid CBN Voil CBN			PCD PKD
	YCB111	YCB121	YCB131	YCB211	YZB121	YZB221	YZB231	YCD421
Radius = 0.4	S01020	S01020	S01020	S01020	S01020	T02020	T02025	F
Radius ≥ 0.8	S02020	S02020	S02020	S02020	S01020	T02020	T02025	F

* other edge preparation on demand
andere Faserausführung auf Anfrage






PCBN

A

General Turning
Allgemeine Drehbearbeitung

	Insert Shape Schneidplattenform	Type Typ	Grade Sorte				
			YCB111	YCB121	YCB131	YCB211	
Negative Inserts WSP		CNGA120404-2	○	○	○	○	
		CNGA120408-2	○	○	○	○	
		CNGA120412-2	○	○	○	○	
		CNGA120408-2W	○	○			
		CNGA120412-2W	○	○			
	A129		DNGA150604-2	○	○		○
			DNGA150608-2	○	○	○	○
			DNGA150612-2	○	○	○	○
	A130		SNGA120408-2	○	○	○	○
			SNGA120412-2	○	○	○	○
	A131		TNGA160404-3	○	○		
			TNGA160408-3	○	○	○	○
	A132		TNGA160412-3	○	○	○	○
			VNGA160404-2	○	○		
	A133		VNGA160408-2	○	○		
			WNGA080404-3	○	○	○	
	A133		WNGA080408-3	○	○	○	○
			WNGA080412-3	○	○	○	○
	Positive Inserts WSP		CCGW060204-1	○	○		
CCGW060208-1			○	○			
CCGW09T304-2			○	○	○	○	
CCGW09T308-2			○	○	○	○	
CCGW120404-2			○	○	○	○	
CCGW120408-2			○	○	○	○	
A134			DCGW070202-1	○	○		
			DCGW070204-1	○	○		
			DCGW070208-1	○	○		
			DCGW11T304-2	○	○	○	○
			DCGW11T308-2	○	○	○	○
A135			TCGW110204-1	○	○	○	
			TCGW110208-1	○	○	○	
			TCGW16T304-3	○	○	○	○
			TCGW16T308-3	○	○	○	○
A136			VBGW160404-2	○	○		○
			VBGW160408-2	○	○		○
A137			VCGW160404-2	○	○		○
			VCGW160408-2	○	○		○

PCBN

	Insert Shape Schneidplattenform	Type Typ	Grade Sorte		
			YZB121	YZB221	YZB231
			S01020 *	T02020 *	T02025 *
Negative Inserts WSP	 A138	CNGN090308	○	○	○
		CNGN090312	○	○	○
		CNGN120404	○	○	○
		CNGN120408	○	●	○
		CNGN120412	○	●	○
		CNGN120416	○	●	○
		CNGN12T608	○	○	○
		CNGN120712	○	○	○
	 A138	DNGN110404	○	○	○
		DNGN110408	○	○	○
	 A139	SNGN090308	○	○	○
		SNGN090312	○	○	○
		SNGN090316	○	○	○
		SNGN120404	○	○	○
		SNGN120408	○	●	○
		SNGN120412	○	●	○
		SNGN120416	○	●	○
		SNGN12T612	○	○	○
		SNGN150716	○	○	○
	SNGN150720	○	○	○	
	 A139	WNGN060304	○	○	○
		WNGN080408	○	○	○
		WNGN080412	○	○	○
	 A140	RNGN090300	○	○	○
		RNGN020300	○	○	○
		RNGN120400	○	●	○
		RNGN120700	○	○	○
		RNGN150700	○	○	○







* Standard edge preparation
Standard Fasenausführung

* other edge preparation on demand
andere Fasenausführung auf Anfrage

PCD/PKD

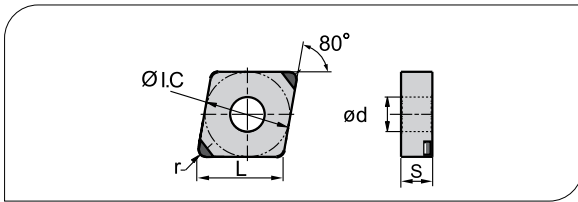
A

General Turning
Allgemeine Drehbearbeitung

Insert Shape <i>Schneidplattenform</i>	Type <i>Typ</i>	Grade <i>Sorte</i>
		YCD421
 A141	CCMT060202	○
	CCMT060204	○
	CCMT09T304	○
	CCMT09T308	○
	CCMT120404	○
	CCMT120408	○
 A142	CCMW060202	○
	CCMW060204	○
	CCMW09T304	○
	CCMW09T308	○
	CCMW120404	○
	CCMW120408	○
 A143	DCMT070202	○
	DCMT070204	○
	DCMT11T302	○
	DCMT11T304	○
	DCMT11T308	○
 A144	DCMW070202	○
	DCMW070204	○
	DCMW070208	○
	DCMW11T302	○
	DCMW11T304	○
	DCMW11T308	○
 A145	TCMT110204	○
	TCMT16T304	○
	TCMT16T308	○
 A146	TCMW110208	○
	TCMW16T304	○
	TCMW16T308	○
 A147	VBMT160404	○
	VBMT160408	○
 A147	VBMW160404	○
	VBMW160408	○
 A148	VCMT160404	○
	VCMT160408	○
 A148	VCMW160404	○
	VCMW160408	○

CN**

- Continuous cutting
Vollschnitt
- ⊗ Continuous and interrupted cutting
Voll und leicht schnitt unterbrochener Schnitt
- ⊗ Interrupted cutting
Stark unterbrochener Schnitt



Workpiece Material Werkstoffe	H Hardened material Gehärtete Werkstoff	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>					
	K Cast iron Gusseisen						<input checked="" type="checkbox"/>		
	N Non-ferrite material Ne Metalle								

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					CBN			
		L	I.C	S	d	r	YCB111	YCB121	YCB131	YCB211
	CNGA120404-2	12.9	12.7	4.76	5.16	0.4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
	CNGA120408-2	12.9	12.7	4.76	5.16	0.8	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
	CNGA120412-2	12.9	12.7	4.76	5.16	1.2	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
	CNGA120408-2W	12.9	12.7	4.76	5.16	0.8	<input type="checkbox"/>	<input type="checkbox"/>		
	CNGA120412-2W	12.9	12.7	4.76	5.16	1.2	<input type="checkbox"/>	<input type="checkbox"/>		

Tool Holder · Klemmhalter



Page · Seite A173

A181

A238

Further insert size, edge preparation, special inserts and grade on demand possible.
Weitere Größen, Fasenausführungen, Sonderplatten und Sondersorten auf Anfrage möglich.

● Ex Stock / ab Lager ○ On demand / auf Anfrage

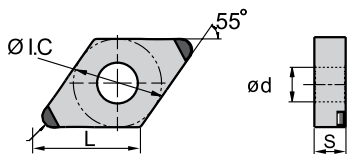
A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

PCBN & PCG Inserts · PCBN & PCG WSP

DN**



● Continuous cutting
Vollschnitt

● Continuous and interrupted cutting
Voll und leicht schnitt unterbrochner Schnitt

☼ Interrupted cutting
Stark unterbrochner Schnitt

Workpiece Material Werkstoffe	H Hardened material Gehärtete Werkstoff	○	☼	☼					
	K Cast iron Gusseisen								●
	N Non-ferrous material Ne Metalle								

Insert Shape Schneid- plattenform	Type Typ	Dimension (mm) Abmessung					CBN			
		L	I.C	S	d	r	YCB111	YCB121	YCB131	YCB211
	DNGA150604-2	15.5	12.7	6.35	5.16	0.4	○	○	○	○
	DNGA150608-2	15.5	12.7	6.35	5.16	0.8	○	○	○	○
	DNGA150612-2	15.5	12.7	6.35	5.16	1.2	○	○	○	○

Tool Holder · Klemmhalter

DDJNR/L
Kr:93°



PDJNR/L
Kr:93°



PDNNR/L
Kr:63°



PDSNR/L
Kr:62°30'



PDUNR/L
Kr:93°



Page · Seite A174

A182

A183

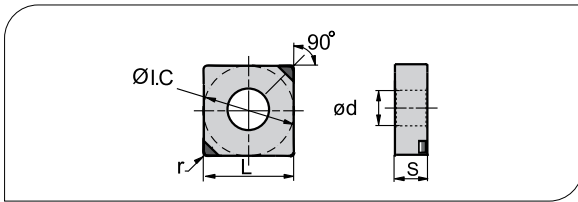
A240

A241

Further insert size, edge preparation, special inserts and grade on demand possible.
Weitere Größen, Fasenausführungen, Sonderplatten und Sondersorten auf Anfrage möglich.

● Ex Stock / ab Lager ○ On demand / auf Anfrage

SN**



- Continuous cutting
Vollschnitt
- Continuous and interrupted cutting
Voll und leicht schnitt unterbrochner Schnitt
- Interrupted cutting
Stark unterbrochner Schnitt

Workpiece Material Werkstoffe	H Hardened material Gehärtete Werkstoff								
	K Cast iron Gusseisen								
	N Non-ferrite material Ne Metalle								

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					CBN			
		L	I.C	S	d	r	YCB111	YCB121	YCB131	YCB211
	SNGA120408-2	12.7	12.7	4.76	5.16	0.8				
	SNGA120412-2	12.7	12.7	4.76	5.16	1.2				

Tool Holder · Klemmhalter



Page · Seite A175 A184 A185 A186 A187 A243

Further insert size, edge preparation, special inserts and grade on demand possible.
Weitere Größen, Fasenausführungen, Sonderplatten und Sondersorten auf Anfrage möglich.

● Ex Stock / ab Lager ○ On demand / auf Anfrage

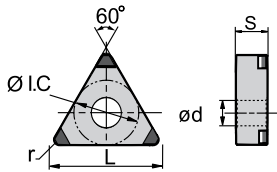
A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

PCBN & PCG Inserts · PCBN & PCG WSP

TN**



● Continuous cutting
Vollschnitt

☼ Continuous and interrupted cutting
Voll und leicht schnitt unterbrochner Schnitt

☼ Intermittent cutting
Stark unterbrochner Schnitt

Workpiece Material Werkstoffe	H Hardened material Gehärtete Werkstoff	○	☼	☼					
	K Cast iron Gusseisen								●
	N Non-ferrous material Nichte Metalle								

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					CBN					
		L	I.C	S	d	r	YCB111	YCB121	YCB131	YCB211		
	TNGA160404-3	16.5	9.525	4.76	3.81	0.4	○	○				
	TNGA160408-3	16.5	9.525	4.76	3.81	0.8	○	○	○	○		
	TNGA160412-3	16.5	9.525	4.76	3.81	1.2	○	○	○	○		

Tool Holder · Klemmhalter



Page · Seite A176

A188

A189

A190

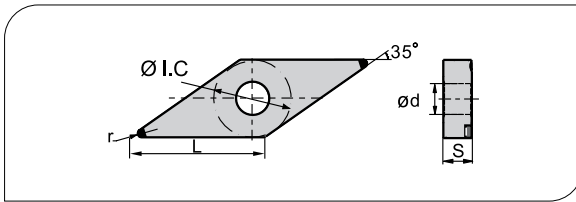
A244

Further insert size, edge preparation, special inserts and grade on demand possible.
Weitere Größen, Fasenausführungen, Sonderplatten und Sondersorten auf Anfrage möglich.

● Ex Stock / ab Lager ○ On demand / auf Anfrage

VN**

- Continuous cutting
Vollschnitt
- Continuous and interrupted cutting
Voll und leicht schnitt unterbrochner Schnitt
- Interrupted cutting
Stark unterbrochner Schnitt



Workpiece Material Werkstoffe	H	Hardened material Gehärtete Werkstoff	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>					
	K	Cast iron Gusseisen							<input checked="" type="checkbox"/>	
	N	Non-ferrous material Ne Metalle								

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					CBN				
		L	I.C	S	d	r	YCB111	YCB121	YCB131	YCB211	
	VNGA160404-2	16.6	9.525	4.76	3.81	0.4	<input type="checkbox"/>	<input type="checkbox"/>			
	VNGA160408-2	16.6	9.525	4.76	3.81	0.8	<input type="checkbox"/>	<input type="checkbox"/>			

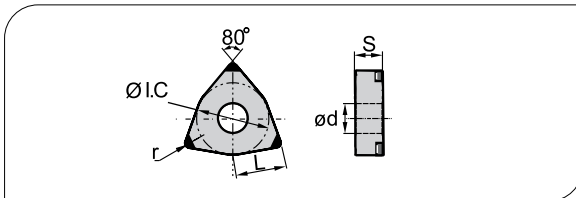
Tool Holder · Klemmhalter



Page · Seite A177 A178 A204 A205

WN**

- Continuous cutting
Vollschnitt
- Continuous and interrupted cutting
Voll und leicht schnitt unterbrochner Schnitt
- Interrupted cutting
Stark unterbrochner Schnitt



Workpiece Material Werkstoffe	H	Hardened material Gehärtete Werkstoff	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>					
	K	Cast iron Gusseisen							<input checked="" type="checkbox"/>	
	N	Non-ferrous material Ne Metalle								

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					CBN				
		L	I.C	S	d	r	YCB111	YCB121	YCB131	YCB211	
	WNGA080408-3	8.69	12.7	4.76	5.16	0.8		<input type="checkbox"/>			
	WNGA160404-3	8.69	12.7	4.76	5.16	0.4		<input type="checkbox"/>			
	WNGA160408-3	8.69	12.7	4.76	5.16	0.8					

Tool Holder · Klemmhalter



Page · Seite A179 A191 A245

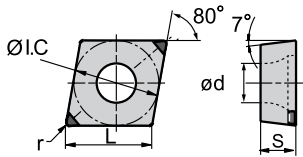
Further insert size, edge preparation, special inserts and grade on demand possible.
Weitere Größen, Fasenausführungen, Sonderplatten und Sondersorten auf Anfrage möglich.

● Ex Stock / ab Lager ○ On demand / auf Anfrage

Turning · Drehen

PCBN & PCG Inserts · PCBN & PCG WSP

CC**



- Continuous cutting
Vollschnitt
- ✶ Continuous and interrupted cutting
Voll und leicht schnitt unterbrochener Schnitt
- ✶ Interrupted cutting
Stark unterbrochener Schnitt

Workpiece Material Werkstoffe	H Hardened material Gehärtete Werkstoff	●	●	●					
	K Cast iron Gusseisen						●		
	N Non-ferrite material Ne Metalle								

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					CBN			
		L	I.C	S	d	r	YCB111	YCB121	YCB131	YCB211
	CCGW060204-1	6.4	6.35	2.38	2.8	0.4	○	○		
	CCGW060208-1	6.4	6.35	2.38	2.8	0.8	○	○		
	CCGW09T304-2	9.7	9.525	3.97	4.4	0.4	○	○	○	○
	CCGW09T308-2	9.7	9.525	3.97	4.4	0.8	○	○	○	○
	CCGW120404-2	12.9	12.7	4.76	5.5	0.4	○	○	○	○
	CCGW120408-2	12.9	12.7	4.76	5.5	0.8	○	○	○	○

Tool Holder · Klemmhalter



SCACR/L
Kr:90°



SCLCR/L
Kr:95°



SCLCR/L
Kr:95°



SCFCR
Kr:90°



SCLCR
Kr:95°

Page · Seite A208

A209

A246

A261

A262

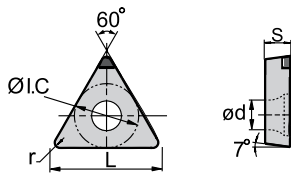
Further insert size, edge preparation, special inserts and grade on demand possible.
Weitere Größen, Fasenausführungen, Sonderplatten und Sondersorten auf Anfrage möglich.

- Ex Stock / ab Lager
- On demand / auf Anfrage

Turning · Drehen

PCBN & PCG Inserts · PCBN & PCG WSP

TC**



● Continuous cutting
Vollschnitt

● Continuous and interrupted cutting
Voll und leicht schnitt unterbrochner Schnitt

☼ Interrupted cutting
Stark unterbrochner Schnitt

Workpiece Material Werkstoffe	H Hardened material Gehärtete Werkstoff	○	☼	☼					
	K Cast iron Gusseisen								●
	N Non-ferrite material Ne Metalle								

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					CBN			
		L	I.C	S	d	r	YCB111	YCB121	YCB131	YCB211
	TCGW110204-1	9.6	5.56	2.38	2.5	0.4	○	○	○	
	TCGW110208-1	9.6	5.56	2.38	2.5	0.8	○	○	○	
	TCGW16T304-3	16.5	9.525	3.97	4.4	0.4	○	○	○	○
	TCGW16T308-3	16.5	9.525	3.97	4.4	0.8	○	○	○	○

Tool Holder · Klemmhalter

STACR/L
Kr:90°



STFCR/L
Kr:91°



STGCR/L
Kr:91°



STTCR/L
Kr:60°



STFCR/L
Kr:90°



Page · Seite A220

A220

A221

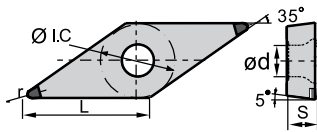
A222

A252

Further insert size, edge preparation, special inserts and grade on demand possible.
Weitere Größen, Fasenausführungen, Sonderplatten und Sondersorten auf Anfrage möglich.

● Ex Stock / ab Lager ○ On demand / auf Anfrage

VB**



- Continuous cutting
Vollschnitt
- Continuous and interrupted cutting
Voll und leicht schnitt unterbrochner Schnitt
- Interrupted cutting
Stark unterbrochner Schnitt

Workpiece Material Werkstoffe	H Hardened material Gehärtete Werkstoff	●	●	●					
	K Cast iron Gusseisen							●	
	N Non-ferrite material Ne Metalle								

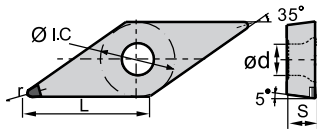
Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					CBN			
		L	I.C	S	d	r	YCB111	YCB121	YCB131	YCB211
	VBGW160404-2	16.6	9.525	4.76	4.4	0.4	○	○		○
	VBGW160408-2	16.6	9.525	4.76	4.4	0.8	○	○		○

Tool Holder · Klemmhalter



Page · Seite A213 A214 A215 A255 A256

VC**



- Continuous cutting
Vollschnitt
- Continuous and interrupted cutting
Voll und leicht schnitt unterbrochner Schnitt
- Interrupted cutting
Stark unterbrochner Schnitt

Workpiece Material Werkstoffe	H Hardened material Gehärtete Werkstoff	●	●	●					
	K Cast iron Gusseisen							●	
	N Non-ferrite material Ne Metalle								

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					CBN			
		L	I.C	S	d	r	YCB111	YCB121	YCB131	YCB211
	VCGW160404-2	16.6	9.525	4.76	4.4	0.4	○	○		○
	VCGW160408-2	16.6	9.525	4.76	4.4	0.8	○	○		○

Tool Holder · Klemmhalter



Page · Seite A216 A217 A253 A254

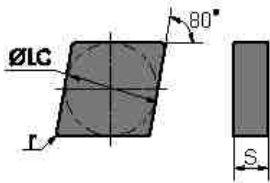
Further insert size, edge preparation, special inserts and grade on demand possible.
Weitere Größen, Fasenausführungen, Sonderplatten und Sondersorten auf Anfrage möglich.

● Ex Stock / ab Lager ○ On demand / auf Anfrage

Turning · Drehen

PCBN & PCG Inserts · PCBN & PCG WSP

CN**

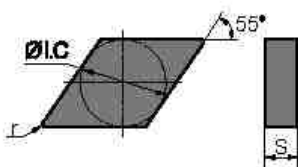


- Continuous cutting
Vollschnitt
- ⊗ Continuous and interrupted cutting
Voll und leicht schnitt unterbrochner Schnitt
- ⊗ Interrupted cutting
Stark unterbrochner Schnitt

Workpiece Material Werkstoffe	H	Hardened material Gehärtete Werkstoff	⊗					
	K	Cast iron Gusseisen		⊗	⊗			
	N	Non-ferrite material Ne Metalle						

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					CBN		
		L	I.C	S	d	r	YZB121	YZB221	YZB231
	CNGN090308	9,7	9,525	3,18	-	0,8	○	○	○
	CNGN090312	9,7	9,525	3,18	-	1,2	○	○	○
	CNGN120404	12,9	12,7	4,76	-	0,4	○	○	○
	CNGN120408	12,9	12,7	4,76	-	0,8	○	●	○
	CNGN120412	12,9	12,7	4,76	-	1,2	○	●	○
	CNGN120416	12,9	12,7	4,76	-	1,6	○	●	○
	CNGN12T608	12,9	12,7	6,75	-	0,8	○	○	○
	CNGN120701	12,9	12,7	7,94	-	0,8	○	○	○

DN**



- Continuous cutting
Vollschnitt
- ⊗ Continuous and interrupted cutting
Voll und leicht schnitt unterbrochner Schnitt
- ⊗ Interrupted cutting
Stark unterbrochner Schnitt

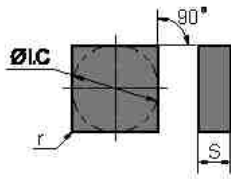
Workpiece Material Werkstoffe	H	Hardened material Gehärtete Werkstoff	⊗					
	K	Cast iron Gusseisen		⊗	⊗			
	N	Non-ferrite material Ne Metalle						

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					CBN		
		L	I.C	S	d	r	YZB121	YZB221	YZB231
	DNGN110404	15,5	9,525	4,76	-	0,4	○	○	○
	DNGN110408	15,5	9,525	4,76	-	0,8	○	○	○

Further insert size, edge preparation, special inserts and grade on demand possible.
Weitere Größen, Fasenausführungen, Sonderplatten und Sondersorten auf Anfrage möglich.

● Ex Stock / ab Lager ○ On demand / auf Anfrage

SN**

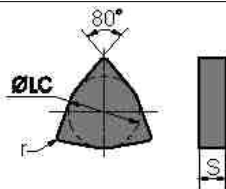


- Continuous cutting
Vollschnitt
- ✳ Continuous and interrupted cutting
Voll und leicht schnitt unterbrochner Schnitt
- ✳ Interrupted cutting
Stark unterbrochner Schnitt

Workpiece Material Werkstoffe	H	Hardened material Gehärtete Werkstoff	✳						
	K	Cast iron Gusseisen	✳	✳					
	N	Non-ferrite material Ne Metalle							

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					CBN		
		L	I.C	S	d	r	YZB121	YZB221	YZB231
	SNGN090308	9,525	9,525	3,18	-	0,8	○	○	○
	SNGN090312	9,525	9,525	3,18	-	1,2	○	○	○
	SNGN090316	9,525	9,525	3,18	-	1,6	○	○	○
	SNGN120404	12,7	12,7	4,76	-	0,4	○	○	○
	SNGN120408	12,7	12,7	4,76	-	0,8	○	●	○
	SNGN120412	12,7	12,7	4,76	-	1,2	○	●	○
	SNGN120416	12,7	12,7	4,76	-	1,6	○	●	○
	SNGN12T612	12,7	12,7	6,75	-	1,2	○	○	○
	SNGN150716	15,875	15,875	7,94	-	1,6	○	○	○
	SNGN150720	15,875	15,875	7,94	-	2,0	○	○	○

WN**



- Continuous cutting
Vollschnitt
- ✳ Continuous and interrupted cutting
Voll und leicht schnitt unterbrochner Schnitt
- ✳ Interrupted cutting
Stark unterbrochner Schnitt

Workpiece Material Werkstoffe	H	Hardened material Gehärtete Werkstoff	✳					
	K	Cast iron Gusseisen	✳	✳				
	N	Non-ferrite material Ne Metalle						

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					CBN		
		L	I.C	S	d	r	YZB121	YZB221	YZB231
	WNGN060304	6,5	9,525	3,18	-	0,4	○	○	○
	WNGN080408	8,69	12,7	4,76	-	0,8	○	○	○
	WNGN080412	8,69	12,7	4,76	-	1,2	○	○	○

Further insert size, edge preparation, special inserts and grade on demand possible.
Weitere Größen, Fasenausführungen, Sonderplatten und Sondersorten auf Anfrage möglich.

● Ex Stock / ab Lager ○ On demand / auf Anfrage

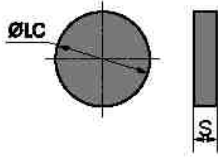
A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

PCBN & PCD Inserts · PGBN & PGD WSP

RN**



- Continuous cutting
Vollschnitt
- Continuous and interrupted cutting
Voll und leicht schnitt unterbrochener Schnitt
- Interrupted cutting
Stark unterbrochener Schnitt

Workpiece Material Werkstoffe	H	Hardened material Gehärtete Werkstoff						
	K	Cast iron Gusseisen						
	N	Non-ferrite material Ne Metalle						

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					CBN		
		L	I.C	S	d	r	YZB121	YZB221	YZB231
	RNGN090300	9.525	9.525	3.18	-	-	○	○	○
	RNGN120300	12.7	12.7	3.18	-	-	○	○	○
	RNGN120400	12.7	12.7	4.76	-	-	○	●	○
	RNGN120700	12.7	12.7	7.94	-	-	○	○	○
	RNGN150700	15.875	15.875	7.94	-	-	○	○	○

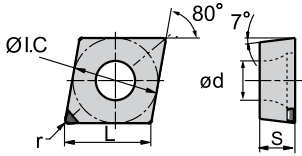
Further insert size, edge preparation, special inserts and grade on demand possible.
Weitere Größen, Fasenausführungen, Sonderplatten und Sondersorten auf Anfrage möglich.

● Ex Stock / ab Lager ○ On demand / auf Anfrage

Turning · Drehen

PCBN & PCD Inserts · PCBN & PCD WSP

CC**



● Continuous cutting
Vollschnitt

⊕ Continuous and interrupted cutting
Voll und leicht schnitt unterbrochener Schnitt

⊗ Interrupted cutting
Stark unterbrochener Schnitt

Workpiece Material Werkstoffe	H	Hardened material Gehärtete Werkstoff					
	K	Cast iron Gusseisen					
	N	Non-ferrite material Ne Metalle	●				

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					PCD			
		L	I.C	S	d	r	YCD421			
	CCMW060202	6.4	6.35	2.38	2.8	0.2	○			
	CCMW060204	6.4	6.35	2.38	2.8	0.4	○			
	CCMW09T304	9.7	9.525	3.97	4.4	0.4	○			
	CCMW09T308	9.7	9.525	3.97	4.4	0.8	○			
	CCMW120404	12.9	12.7	4.76	5.56	0.4	○			
	CCMW120408	12.9	12.7	4.76	5.56	0.8	○			

Tool Holder · Klemmhalter

SCACR/L
Kr:90°



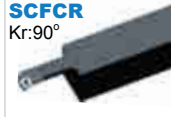
SCLCR/L
Kr:95°



SCLCR/L
Kr:95°



SCFCR
Kr:90°



SCLCR
Kr:95°



Page · Seite A208

A209

A246

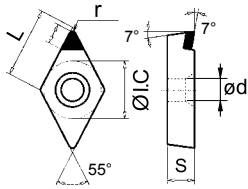
A261

A262

Further insert size, edge preparation, special inserts and grade on demand possible.
Weitere Größen, Fasenausführungen, Sonderplatten und Sondersorten auf Anfrage möglich.

● Ex Stock / ab Lager ○ On demand / auf Anfrage

DC**



- Continuous cutting
Vollschnitt
- ⊗ Continuous and interrupted cutting
Voll und leicht schnitt unterbrochener Schnitt
- ⊗ Interrupted cutting
Stark unterbrochener Schnitt

Workpiece Material Werkstoffe	H	Hardened material Gehärtete Werkstoff						
	K	Cast iron Gusseisen						
	N	Non-ferrite material Ne Metalle	●					

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					PCD				
		L	I.C	S	d	r	YCD421				
	DCMT070202	7.8	6.35	2.38	2.8	0.2	○				
	DCMT070204	7.8	6.35	2.38	2.8	0.4	○				
	DCMT11T302	11.6	9.525	3.97	4.4	0.2	○				
	DCMT11T304	11.6	9.525	3.97	4.4	0.4	○				
	DCMT11T308	11.6	9.525	3.97	4.4	0.8	○				

Tool Holder · Klemmhalter



SDACR/L
Kr:90°



SDJCR/L
Kr:93°



SDNCN
Kr:62°30'



SDQCR/L
Kr:107°30'



SDUCR/L
Kr:93°



SDZCR/L
Kr:85°

Page · Seite A210

A211

A212

A248

A249

A250

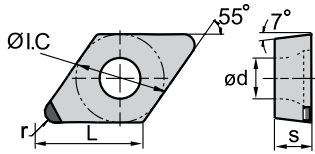
Further insert size, edge preparation, special inserts and grade on demand possible.
Weitere Größen, Fasenausführungen, Sonderplatten und Sondersorten auf Anfrage möglich.

● Ex Stock / ab Lager ○ On demand / auf Anfrage

Turning · Drehen

PCBN & PCG Inserts · PCBN & PCG WSP

DC**



● Continuous cutting
Vollschnitt

● Continuous and interrupted cutting
Voll und leicht schnitt unterbrochener Schnitt

● Interrupted cutting
Stark unterbrochener Schnitt

Workpiece Material Werkstoffe	H	Hardened material Gehärtete Werkstoff						
	K	Cast iron Gusseisen						
	N	Non-ferrite material Ne Metalle	●					

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					PCD		
		L	I.C	S	d	r	YCD421		
	DCMW070202	7.8	6.35	2.38	2.8	0.2	○		
	DCMW070204	7.8	6.35	2.38	2.8	0.4	○		
	DCMW070208	7.8	6.35	2.38	2.8	0.8	○		
	DCMW11T302	11.6	9.525	3.97	4.4	0.2	○		
	DCMW11T304	11.6	9.525	3.97	4.4	0.4	○		
	DCMW11T308	11.6	9.525	3.97	4.4	0.8	○		

Tool Holder · Klemmhalter



Page · Seite A210



A211



A212



A248



A249



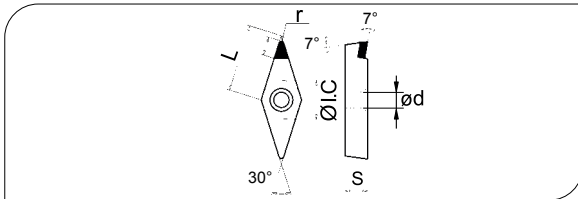
A250

Further insert size, edge preparation, special inserts and grade on demand possible.
Weitere Größen, Fasenausführungen, Sonderplatten und Sondersorten auf Anfrage möglich.

● Ex Stock / ab Lager ○ On demand / auf Anfrage

VB**

- Continuous cutting
Vollschnitt
- Continuous and interrupted cutting
Voll und leicht schnitt unterbrochner Schnitt
- Interrupted cutting
Stark unterbrochner Schnitt



Workpiece Material Werkstoffe	H	Hardened material Gehärtete Werkstoff																		
	K	Cast iron Gusseisen																		
	N	Non-ferrite material Ne Metalle	●																	

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					PCD															
		L	I.C	S	d	r	YCD421															
	VBMT160404	16.6	9.525	4.76	4.4	0.4	○															
	VBMT160408	16.6	9.525	4.76	4.4	0.8	○															

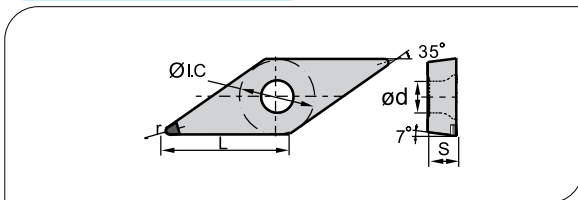
Tool Holder · Klemmhalter



Page · Seite A213 A214 A215 A255 A256

VB**

- Continuous cutting
Vollschnitt
- Continuous and interrupted cutting
Voll und leicht schnitt unterbrochner Schnitt
- Interrupted cutting
Stark unterbrochner Schnitt



Workpiece Material Werkstoffe	H	Hardened material Gehärtete Werkstoff																		
	K	Cast iron Gusseisen																		
	N	Non-ferrite material Ne Metalle	●																	

Insert shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					PCD															
		L	I.C	S	d	r	YCD421															
	VBMW160404	16.6	9.525	4.76	4.4	0.4	○															
	VBMW160408	16.6	9.525	4.76	4.4	0.8	○															

Tool Holder · Klemmhalter



Page · Seite A213 A214 A215 A255 A256

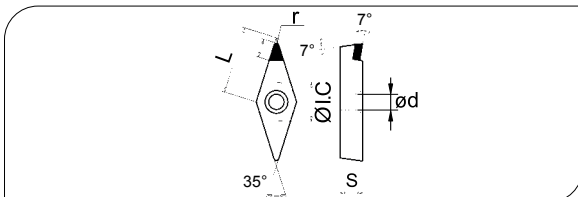
Further insert size, edge preparation, special inserts and grade on demand possible.
Weitere Größen, Fasenausführungen, Sonderplatten und Sondersorten auf Anfrage möglich.

● Ex Stock / ab Lager ○ On demand / auf Anfrage

Turning · Drehen

PCBN & PCG Inserts · PCBN & PCG WSP

VC**



- Continuous cutting
Vollschnitt
- Continuous and interrupted cutting
Voll und leicht schnitt unterbrochner Schnitt
- Interrupted cutting
Stark unterbrochner Schnitt

Workpiece Material Werkstoffe	H	Hardened material Gehärtete Werkstoff						
	K	Cast iron Gusseisen						
	N	Non-ferrite material Ne Metalle	●					

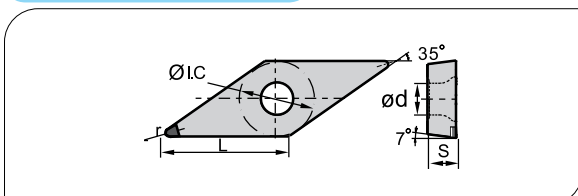
Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					PCD		
		L	I.C	S	d	r	YCD421		
	VCMT160404	16.6	9.525	4.76	4.4	0.4	○		
	VCMT160408	16.6	9.525	4.76	4.4	0.8	○		

Tool Holder · Klemmhalter



Page · Seite A213 A214 A215 A255 A256

VC**



- Continuous cutting
Vollschnitt
- Continuous and interrupted cutting
Voll und leicht schnitt unterbrochner Schnitt
- Interrupted cutting
Stark unterbrochner Schnitt

Workpiece Material Werkstoffe	H	Hardened material Gehärtete Werkstoff						
	K	Cast iron Gusseisen						
	N	Non-ferrite material Ne Metalle	●					

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					PCD		
		L	I.C	S	d	r	YCD421		
	VCMW160404	16.6	9.525	4.76	4.4	0.4	○		
	VCMW160408	16.6	9.525	4.76	4.4	0.8	○		

Tool Holder · Klemmhalter



Page · Seite A213 A214 A215 A255 A256

Further insert size, edge preparation, special inserts and grade on demand possible.
Weitere Größen, Fasenausführungen, Sonderplatten und Sondersorten auf Anfrage möglich.

● Ex Stock / ab Lager ○ On demand / auf Anfrage

Troubleshooting - PCBN Cutting Materials Problembehandlung - PCBN Schneidstoffe

For investigation please send us used inserts. If breakage is problem please use inserts only 80-90% of expected tool life because broken inserts almost have no information.

Für eine genaue Untersuchung schicken Sie uns bitte die gebrauchten WSP zu. Sollte Bruch das Problem sein, setzen Sie die Platte nur 80-90% der eigentlichen Standzeit ein, denn eine gebrochene Platte enthält keine Informationen mehr.

Wear phenomenon	Solution	
	Geometry	Cutting condition
Flank wear	Sharp cutting edge to reduce cutting force - smaller negative lend - change to positive inserts	Reduce cutting speed - increase feed rate to minimise contact time
Notch wear	Bigger nose radius	Use method of altering feed rate
Crater wear/ Breakage due to crater wear	Crater wear · Breakage due to crater wear	Reduce cutting speed - increase feed rate to minimise contact time and increase distance between cutting edge and crater
Chipping due to rough condition or vibration	Bigger negative lend; angle and · or honing	Increase feed rate to reduce number of hits
Flaking	Sharp cutting edge to reduce cutting force - smaller negative lend - change to positive inserts	Increase feed rate to reduce cutting time
Thermal crack	Sharp cutting edge to reduce cutting force - smaller negative lend - change to positive inserts	Reduce cutting speed, feed rate and depth of cut. Use dry machining.
Chipping	Bigger negative lend	Increase cutting speed to reduce cutting force

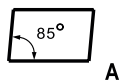
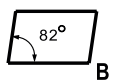
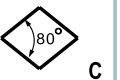


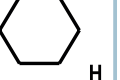
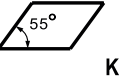


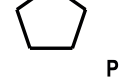
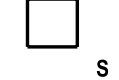



Verschleißbild	Gegenmaßnahmen	
	Geometrie	Schnittbedingungen
Freiflächenverschleiß	Schärfere Schneidkante für weniger Schnittkraft - kleinere Negativfase - positive Platten verwenden	Schnittgeschwindigkeit reduzieren - Vorschub erhöhen um Eingriffszeit zu reduzieren
Kerbverschleiß	Größerer Radius	“Methode des variierenden Vorschubs” verwenden
Kolkverschleiß/ Kolkbruch		- Schnittgeschwindigkeit reduzieren - Vorschub erhöhen um Kontaktzeit zu verringern und den Abstand zwischen Schneidkante und Kolk tasche zu vergrößern.
Ausbrüche durch Schlagwirkung oder Vibrationen	Größere Negativfase Winkel und · oder gehonte Fase	- Vorschub erhöhen, um die Anzahl der Schläge zu reduzieren
Schalenförmige Ausplatzungen	Schärfere Schneidkante für weniger Schnittkraft - kleinere Negativfase - positive Platten verwenden	- Vorschub erhöhen, um Eingriffszeit zu reduzieren
Thermische Risse · Bruch	Schärfere Schneidkante für weniger Schnittkraft - kleinere Negativfase - positive Platten verwenden	Schnittgeschwindigkeit, Vorschub und Schnitttiefe reduzieren. Trockenbearbeitung
Ausbrüche	Größere Negativfase	Schnittgeschwindigkeit erhöhen um Schnittkraft zu reduzieren

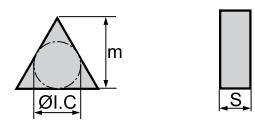
Turning · Drehen

Ceramic Inserts Code Key · ISO Kennzeichnung für Keramikschnidplatten

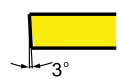
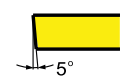

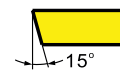
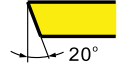

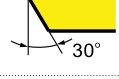
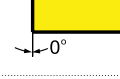
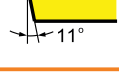
A

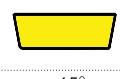
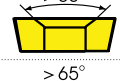

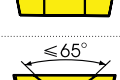
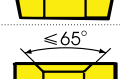

General Turning
Allgemeine Drehbearbeitung

Insert Shape Schnidplattenform		
 A	 B	 C
 D	 E	 H
 K	 L	 M
 P	 S	 T
 V	 W	Others Andere Z

Tolerance Toleranzklasse							
							
Code	Tolerance Toleranzklasse	Tolerance Toleranzklasse ØI.C	Thickness S Dicke	Code	Tolerance Toleranzklasse	Tolerance Toleranzklasse ØI.C	Thickness S Dicke
A	±0.005	±0.025	±0.025	J	±0.005	±0.05-±0.13	±0.025
F	±0.005	±0.013	±0.025	K	±0.013	±0.05-±0.13	±0.025
C	±0.013	±0.025	±0.025	L	±0.025	±0.05-±0.13	±0.025
H	±0.013	±0.013	±0.025	M	±0.08-±0.18	±0.05-±0.13	±0.13
E	±0.025	±0.025	±0.025	N	±0.08-±0.18	±0.05-±0.13	±0.025
G	±0.025	±0.025	±0.13	U	±0.13-±0.38	±0.08-±0.25	±0.13

T N G A

Clearance angle of main cutting edge Freiwinkel der Hauptschneide			
code	Angle Winkel	code	Angle Winkel
A	 3°	B	 5°
C	 7°	D	 15°
E	 20°	F	 25°
G	 30°	N	 0°
P	 11°	O	Others Andere

Insert type Plattentyp		
Code	hole Loch	Insert Section Ausführung
N	No	
B	Yes	 > 65°
C	Yes	 > 65°
A	Yes	
W	Yes	 ≤ 65°
Q	Yes	 ≤ 65°
X	---	Special Spezial

Turning · Drehen

Ceramic Inserts Code Key · ISO Kennzeichnung für Keramikscheidplatten

A

General Turning
Allgemeine Drehbearbeitung

Diameter of incircle Eingeschriebener Kreis (mm)	Cutting edge length Schneidenlänge (mm) insert shape Plattenform					
	C	D	S	T	V	W
3.97				06		
5.0						
5.56				09		
6.0						
6.35	06	07		11	11	
8.0						
9.525	09	11	09	16	16	06
10.0						
12.0						
12.7	12	15	12	22	22	08
15.875	16		15	27		
16.0		19				
19.05	19		19	33		
20.0						
25.0	25	25				
25.4			25			
31.75						
32						

Insert thickness Dicke (mm)			
thickness Dicke			
code	Insert thickness Dicke	code	Insert thickness Dicke
02	2.38	06	6.35
T2	2.58	T6	6.75
03	3.18	07	7.94
T3	3.97	09	9.52
04	4.76	T9	9.72
T4	4.96	11	11.11
05	5.56	12	12.70
T5	5.95		

Nose radius Eckenradius	
code	Radius (mm)
00	no Radius
02	0.2
04	0.4
08	0.8
12	1.2
16	1.6
20	2.0
24	2.4
32	3.2
X	Others Andere
Insert diameter WSP Durchmesser Mo (metric)	Runde insert Runde Platten

12 04 08 T 020 20

Profile of cutting edges Scheidekantenausführung		
code	Cutting Edge Schneidkante	Shape Form Plattenform
E	Honing Verrundung	
T	Chamfering Fase	
S	Chamfering Fase + Honing Verrundung	
F	Sharp edges Scharfe Kante	

width of chamfer Breite der Fase			
010	0.10	040	0.40
015	0.15	045	0.45
020	0.20	050	0.50
025	0.25	100	1.00
030	0.30	200	2.00
035	0.35		

angle of chamfer Winkel der Fase	
05	5°
10	10°
15	15°
20	20°
25	25°
30	30°

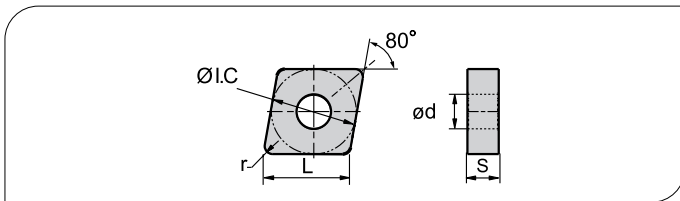
Turning · Drehen

Ceramic Inserts · Keramik WSP

A

General Turning
Allgemeine Drehbearbeitung

- Ideal Machining Condition
Gute Bearbeitungsbedingungen
- ⊗ Normal Machining Condition
Normale Bearbeitungsbedingungen
- ⊗ Unfavorable Machining Condition
Ungünstige Bearbeitungsbedingungen



Workpiece Material Werkstoffe	P Steel Stahl	●		
	K Cast iron Gusseisen	●	● ⊗	⊗

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					Grade Sorte		
		L	I.C	S	d	r	CA1000	CN1000	CN2000
	CNGA120404T02020	12.9	12.7	4.76	5.16	0.4		●	
	CNGA120408T02020	12.9	12.7	4.76	5.16	0.8	○	●	
	CNGA120412T02020	12.9	12.7	4.76	5.16	1.2		●	
	CNGA120412T03020	12.9	12.7	4.76	5.16	1.2		○	
	CNGA160608T02020	16.1	15.875	6.35	6.35	0.8		○	
	CNGA160612T02020	16.1	15.875	6.35	6.35	1.2		●	
	CNGA160616T02020	16.1	15.875	6.35	6.35	1.6		●	

Tool Holder · Klemmhalter



Page · Seite A173

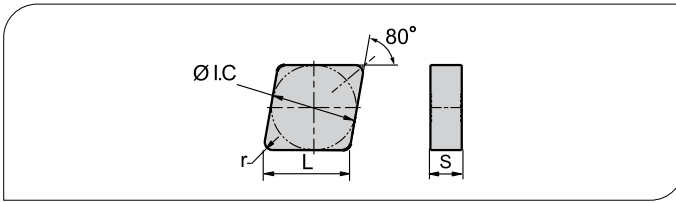
A180

A181

A238

● Ex Stock / ab Lager ○ On demand / auf Anfrage

- Ideal Machining Condition
Gute Bearbeitungsbedingungen
- ⊗ Normal Machining Condition
Normale Bearbeitungsbedingungen
- ⊗ Unfavorable Machining Condition
Ungünstige Bearbeitungsbedingungen



Workpiece Material Werkstoffe	P Steel Stahl	●		
	K Cast iron Gusseisen	●	● ⊗	⊗

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					Grade Sorte		
		L	I.C	S	d	r	CA1000	CN1000	CN2000
	CNGN120404T02020	12.9	12.7	4.76	-	0.4	○	○	○
	CNGN120408T02020	12.9	12.7	4.76	-	0.8	●	●	●
	CNGN120412T02020	12.9	12.7	4.76	-	1.2	●	○	●
	CNGN120708T02020	12.9	12.7	7.94	-	0.8	○	○	●
	CNGN120712T02020	12.9	12.7	7.94	-	1.2	●	●	○
	CNGN120716T02020	12.9	12.7	7.94	-	1.6	○	●	○
	CNGN160408T02020	16.1	15.875	4.76	-	0.8	○		
	CNGN160412T02020	16.1	15.875	4.76	-	1.2	○	○	○
	CNGN160416T02020	16.1	15.875	4.76	-	1.6	○	○	○
	CNGN160612T02020	16.1	15.875	6.35	-	1.2	○	○	
	CNGN160616T02020	16.1	15.875	6.35	-	1.6	○	○	○

Tool Holder · Klemmhalter






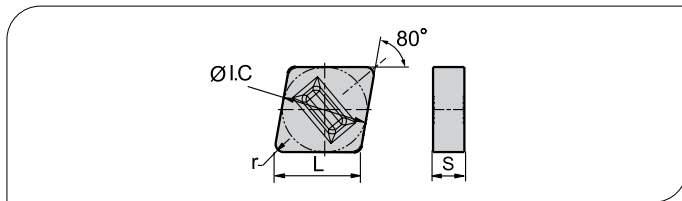
Turning · Drehen





Ceramic Inserts · Keramik WSP




A

General Turning
Allgemeine Drehbearbeitung

-  Ideal Machining Condition
Gute Bearbeitungsbedingungen
-  Normal Machining Condition
Normale Bearbeitungsbedingungen
-  Unfavorable Machining Condition
Ungünstige Bearbeitungsbedingungen






Workpiece Material Werkstoffe	Machining Condition		
	CA1000	CN1000	CN2000
P Steel Stahl			
K Cast iron Gusseisen			

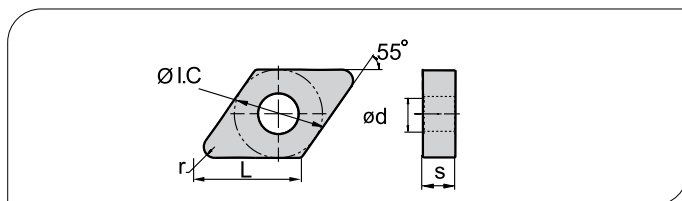
Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					Grade Sorte		
		L	I.C	S	d	r	CA1000	CN1000	CN2000
	CNGX120712T02020	12.9	12.7	7.94	-	1.2			
	CNGX120716T02020	12.9	12.7	7.94	-	1.6			





Tool Holder · Klemmhalter








Page · Seite A231

-  Ideal Machining Condition
Gute Bearbeitungsbedingungen
-  Normal Machining Condition
Normale Bearbeitungsbedingungen
-  Unfavorable Machining Condition
Ungünstige Bearbeitungsbedingungen



Workpiece Material Werkstoffe	Machining Condition		
	CA1000	CN1000	CN2000
P Steel Stahl			
K Cast iron Gusseisen			

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					Grade Sorte		
		L	I.C	S	d	r	CA1000	CN1000	CN2000
	DNGA150604T02020	15.5	12.7	6.35	5.16	0.4			
	DNGA150608T02020	15.5	12.7	6.35	5.16	0.8			
	DNGA150612T02020	15.5	12.7	6.35	5.16	1.2			
	DNGA150616T02020	15.5	12.7	6.35	5.16	1.6			

Tool Holder · Klemmhalter



Page · Seite A174

A182

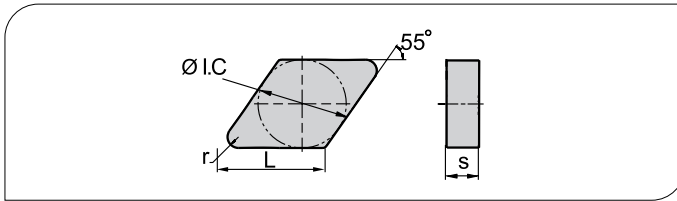
A183

A240

A241

-  Ex Stock / ab Lager
-  On demand / auf Anfrage

- Ideal Machining Condition
Gute Bearbeitungsbedingungen
- ⊗ Normal Machining Condition
Normale Bearbeitungsbedingungen
- ⊗ Unfavorable Machining Condition
Ungünstige Bearbeitungsbedingungen



Workpiece Material Werkstoffe	P Steel Stahl	●		
	K Cast iron Gusseisen	●	● ⊗	⊗

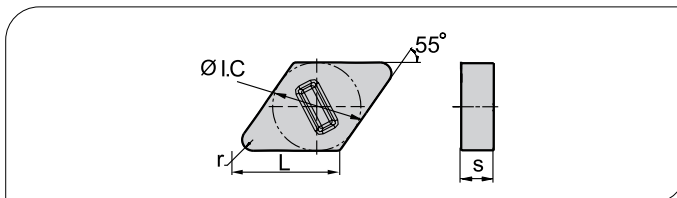
Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					Grade Sorte		
		L	I.C	S	d	r	CA1000	CN1000	CN2000
	DNGN150408T02020	15.5	12.7	4.76	-	0.8	○		
	DNGN150412T02020	15.5	12.7	4.76	-	1.2	○		
	DNGN150704T02020	15.5	12.7	7.94	-	0.4	○	○	○
	DNGN150708T02020	15.5	12.7	7.94	-	0.8	●	○	○
	DNGN150712T02020	15.5	12.7	7.94	-	1.2	○	○	○
	DNGN150716T02020	15.5	12.7	7.94	-	1.6	○		

Tool Holder · Klemmhalter



Page · Seite A228

- Ideal Machining Condition
Gute Bearbeitungsbedingungen
- ⊗ Normal Machining Condition
Normale Bearbeitungsbedingungen
- ⊗ Unfavorable Machining Condition
Ungünstige Bearbeitungsbedingungen



Workpiece Material Werkstoffe	P Steel Stahl	●		
	K Cast iron Gusseisen	●	● ⊗	⊗

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					Grade Sorte		
		L	I.C	S	d	r	CA1000	CN1000	CN2000
	DNGX150712T02020	15.5	12.7	7.94	-	1.2		○	
	DNGX150716T02020	15.5	12.7	7.94	-	1.6		●	

Tool Holder · Klemmhalter



Page · Seite A231

● Ex Stock / ab Lager ○ On demand / auf Anfrage

A



General Turning
Allgemeine Drehbearbeitung

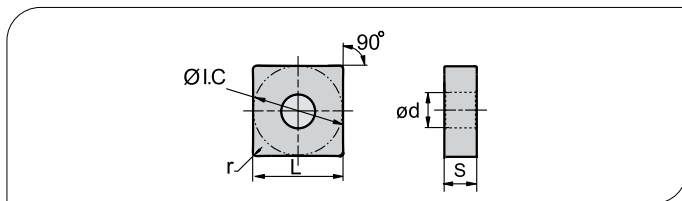
Turning · Drehen





Ceramic Inserts · Keramik WSP








A

General Turning
Allgemeine Drehbearbeitung

-  Ideal Machining Condition
Gute Bearbeitungsbedingungen
-  Normal Machining Condition
Normale Bearbeitungsbedingungen
-  Unfavorable Machining Condition
Ungünstige Bearbeitungsbedingungen






Workpiece Material Werkstoffe	P Steel Stahl			
	K Cast iron Gusseisen			

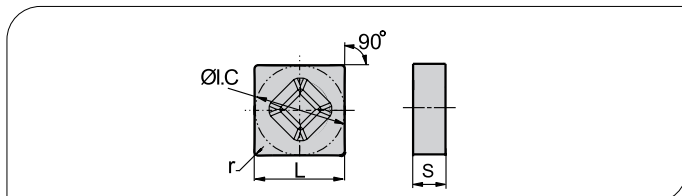
Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					Grade Sorte		
		L	I.C	S	d	r	CA1000	CN1000	CN2000
	SNGA120404T02020	12.7	12.7	4.76	5.16	0.4			
	SNGA120408T02020	12.7	12.7	4.76	5.16	0.8			
	SNGA120412T02020	12.7	12.7	4.76	5.16	1.2			
	SNGA120412T03020	12.7	12.7	4.76	5.16	1.2			
	SNGA120416T02020	12.7	12.7	4.76	5.16	1.6			
	SNGA120416T03020	12.7	12.7	4.76	5.16	1.6			





Tool Holder · Klemmhalter







Page · Seite A175 A184 A185 A186 A187 A243

-  Ideal Machining Condition
Gute Bearbeitungsbedingungen
-  Normal Machining Condition
Normale Bearbeitungsbedingungen
-  Unfavorable Machining Condition
Ungünstige Bearbeitungsbedingungen



Workpiece Material Werkstoffe	P Steel Stahl			
	K Cast iron Gusseisen			

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					Grade Sorte		
		L	I.C	S	d	r	CA1000	CN1000	CN2000
	SNGX120708T02020	12.7	12.7	7.94	-	0.8			
	SNGX120712T02020	12.7	12.7	7.94	-	1.2			
	SNGX120716T02020	12.7	12.7	7.94	-	1.6			

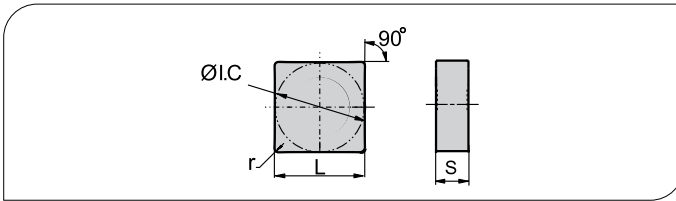
Tool Holder · Klemmhalter



Page · Seite A232

-  Ex Stock / ab Lager
-  On demand / auf Anfrage

- Ideal Machining Condition
Gute Bearbeitungsbedingungen
- ⊗ Normal Machining Condition
Normale Bearbeitungsbedingungen
- ⊗ Unfavorable Machining Condition
Ungünstige Bearbeitungsbedingungen



Workpiece Material Werkstoffe	P	Steel Stahl	●		
	K	Cast iron Gusseisen	●	● ⊗	⊗

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					Grade Sorte		
		L	I.C	S	d	r	CA1000	CN1000	CN2000
	SNGN090308T01020	9.525	9.525	3.18	-	0.8	○		
	SNGN090312T01020	9.525	9.525	3.18	-	1.2	○		
	SNGN120404T02020	12.7	12.7	4.76	-	0.4	○		
	SNGN120408T02020	12.7	12.7	4.76	-	0.8	●	●	○
	SNGN120412T02020	12.7	12.7	4.76	-	1.2	●	●	●
	SNGN120412T03020	12.7	12.7	4.76	-	1.2		○	
	SNGN120416T02020	12.7	12.7	4.76	-	1.6	○	○	○
	SNGN120704T02020	12.7	12.7	7.94	-	0.4	●		
	SNGN120708T02020	12.7	12.7	7.94	-	0.8	○	○	●
	SNGN120712T02020	12.7	12.7	7.94	-	1.2	●	●	○
	SNGN120716T02020	12.7	12.7	7.94	-	1.6	●		●
	SNGN150708T02020	15.875	15.875	7.94	-	0.8	○		
	SNGN150712T02020	15.875	15.875	7.94	-	1.2	●	○	○
	SNGN150716T02020	15.875	15.875	7.94	-	1.6	●	○	○
	SNGN190708T03020	19.05	19.05	7.94	-	0.8	○		
	SNGN190712T03020	19.05	19.05	7.94	-	1.2	○		
	SNGN190716T03020	19.05	19.05	7.94	-	1.6	○		
	SNGN190724T03020	19.05	19.05	7.94	-	2.4	○		
	SNGN191024T04020	19.05	19.05	10.05	-	2.4	○		
	SNGN251024T10015	25.4	25.4	10.05	-	2.4	○		

Tool Holder · Klemmhalter



Page · Seite A229




● Ex Stock / ab Lager ○ On demand / auf Anfrage

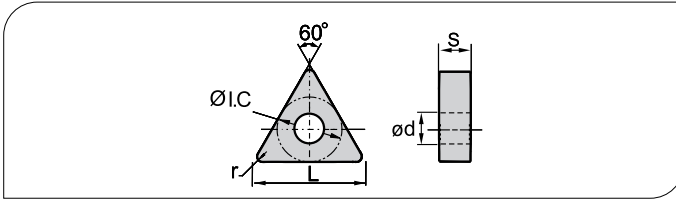
Turning · Drehen





Ceramic Inserts · Keramik WSP


A

General Turning
Allgemeine Drehbearbeitung

-  Ideal Machining Condition
Gute Bearbeitungsbedingungen
-  Normal Machining Condition
Normale Bearbeitungsbedingungen
-  Unfavorable Machining Condition
Ungünstige Bearbeitungsbedingungen



Workpiece Material Werkstoffe	P Steel Stahl			
	K Cast iron Gusseisen			

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					Grade Sorte		
		L	I.C	S	d	r	CA1000	CN1000	CN2000
	TNGA160404T01020	16.50	9.525	4.76	3.86	0.4		●	
	TNGA160408T02020	16.50	9.525	4.76	3.86	0.8		●	
	TNGA160412T02020	16.50	9.525	4.76	3.86	1.2		●	
	TNGA220408T02020	22.00	12.7	4.76	5.16	0.8		○	
	TNGA220412T02020	22.00	12.7	4.76	5.16	1.2		○	
	TNGA220416T02020	22.00	12.7	4.76	5.16	1.6		○	
	TNGA220416T03020	22.00	12.7	4.76	5.16	1.6		○	

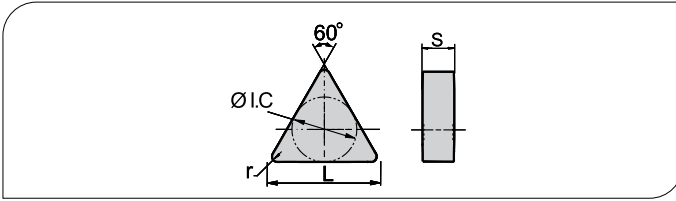
Tool Holder · Klemmhalter



Page · Seite A176 A188 A189 A190 A244

● Ex Stock / ab Lager ○ On demand / auf Anfrage

- Ideal Machining Condition
Gute Bearbeitungsbedingungen
- ⊗ Normal Machining Condition
Normale Bearbeitungsbedingungen
- ⊗ Unfavorable Machining Condition
Ungünstige Bearbeitungsbedingungen



Workpiece Material Werkstoffe	P	Steel Stahl	●		
	K	Cast iron Gusseisen	●	● ⊗	⊗

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					Grade Sorte		
		L	I.C	S	d	r	CA1000	CN1000	CN2000
	TNGN160404T02020	16.50	9.525	4.76	-	0.4	●	○	○
	TNGN160408T02020	16.50	9.525	4.76	-	0.8	●	○	○
	TNGN160412T02020	16.50	9.525	4.76	-	1.2	●	○	●
	TNGN160708T02020	16.50	9.525	7.94	-	0.8	●	●	●
	TNGN160712T02020	16.50	9.525	7.94	-	1.2	○	○	○
	TNGN160716T02020	16.50	9.525	7.94	-	1.6	○		
	TNGN220408T02020	22.00	12.7	4.76	-	0.8	○	○	○
	TNGN220412T02020	22.00	12.7	4.76	-	1.2	○	○	○
	TNGN220416T02020	22.00	12.7	4.76	-	1.6	○	○	○
	TNGN220712T02020	22.00	12.7	7.94	-	1.2	○		
	TNGN220716T02020	22.00	12.7	7.94	-	1.6	○		

Tool Holder · Klemmhalter

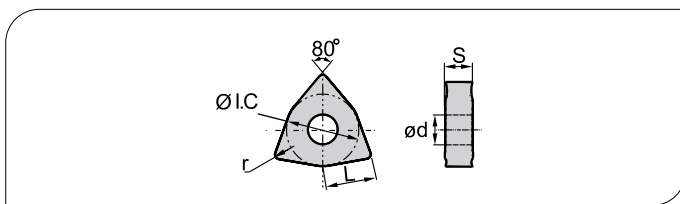


Turning · Drehen

Ceramic Inserts · Keramik WSP

General Turning
Allgemeine Drehbearbeitung

- Ideal Machining Condition
Gute Bearbeitungsbedingungen
- ⊙ Normal Machining Condition
Normale Bearbeitungsbedingungen
- ⊙ Unfavorable Machining Condition
Ungünstige Bearbeitungsbedingungen



Workpiece Material Werkstoffe	P Steel Stahl	●		
	K Cast iron Gusseisen	●	● ⊙	⊙

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					Grade Sorte		
		L	I.C	S	d	r	CA1000	CN1000	CN2000
	WNGA080408T02020	8.69	12.7	4.76	5.16	0.8		●	
	WNGA080412T02020	8.69	12.7	4.76	5.16	1.2		●	
	WNGA080416T02020	8.69	12.7	4.76	5.16	1.6		●	

Tool Holder · Klemmhalter

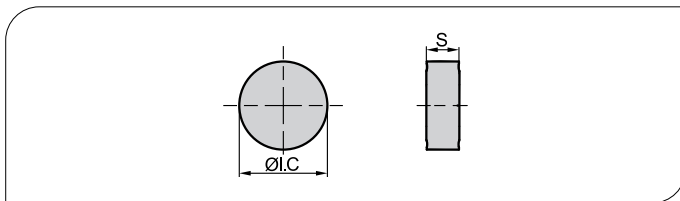


Page · Seite A179

A191

A245

- Ideal Machining Condition
Gute Bearbeitungsbedingungen
- ⊙ Normal Machining Condition
Normale Bearbeitungsbedingungen
- ⊙ Unfavorable Machining Condition
Ungünstige Bearbeitungsbedingungen



Workpiece Material Werkstoffe	P Steel Stahl	●		
	K Cast iron Gusseisen	●	● ⊙	⊙

Insert Shape Schneid plattenform	Type Typ	Dimension (mm) Abmessung					Grade Sorte		
		L	I.C	S	d	r	CA1000	CN1000	CN2000
	RNGN090400T02020	---	9.53	4.76	---	---	○		
	RNGN120400T02020	---	12.7	4.76	---	---	○	○	●
	RNGN120700T02020	---	12.7	7.94	---	---	●	○	●
	RNGN150700T02020	---	15.875	7.94	---	---	●	○	
	RNGN190700T03020	---	19.05	7.94	---	---	○	○	●
	RNGN251000T05020	---	25.40	10.05	---	---	○	○	

Tool Holder Klemmhalter



Page · Seite A230

- Ex Stock / ab Lager
- On demand / auf Anfrage



D Clamping

D Halter

Turning · Drehen

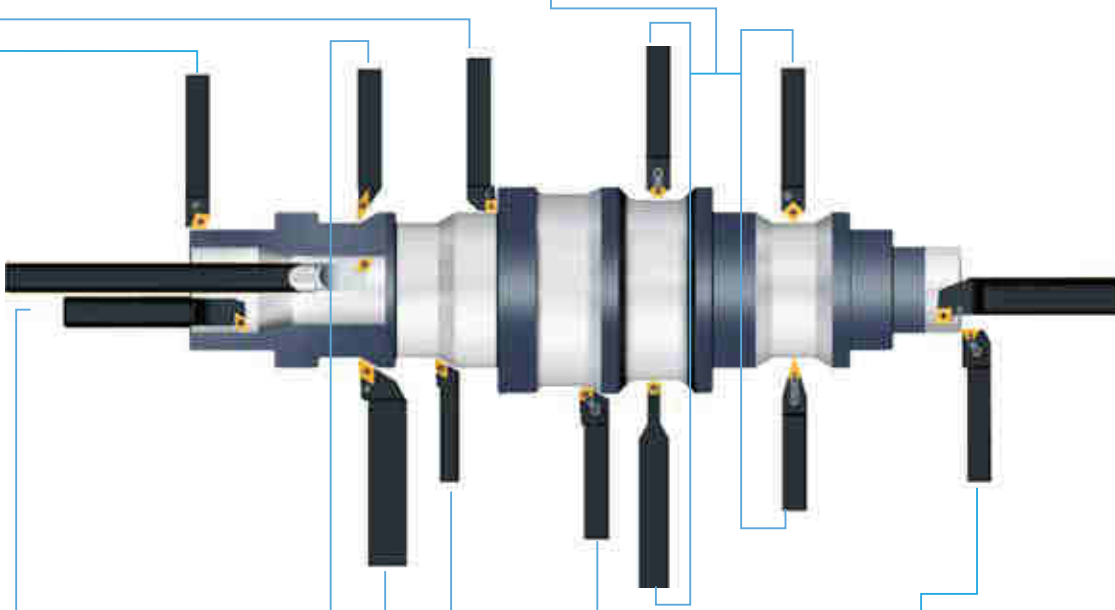
Application of turning tools · Anwendung von Drehwerkzeugen

● External and internal turning · Außen- und Innenbearbeitung

External Turning · Außenbearbeitung	Type · Typ					
	PCBNR/ L**	PSBNR/ L**	PSSN *	PTGNR/ L**	PTTNR/ L**	MCBNR/ L**
	MSBNR/ L**	MSRNR/ L**	MTGNR/ L**	MTJNR/ L**	SCACR/ L**	SSBCR/ L**
	SSSCR/ L**	STACR/ L**	STGCR/ L**	STTCR/ L**	SWACR/ L**	DTJNR/ L**
	DSBNR/ L**					

External facing & turning · Außen- & Planbearbeitung	Type · Typ	
	PCLNR/ L**	PWLNr/ L**
	MCLNR/ L**	MWLNr/ L**
	SCLCR/ L**	DCLNR/ L**
	DWLNr/ L**	

Profiling · Profilbearbeitung	Type · Typ			
	PDNNR/ L**	PSDNN**	MDPNN**	MSDNN**
	MVVNN**	MRDNN**	SDNCN**	SVVBN**
	SVVCN**	SSDCN**	SRDCN**	CKNNR/ L**
	DVVNN**			



Profiling · Profilbearbeit.	Type · Typ		
	PDJNR/ L**	MDJNR/ L**	MVJNR/ L**
	SDACR/ L**	SDJCR/ L**	SVABR/ L**
	SVJBR/ L**	SVJCR/ L**	CKJNR/ L**
	DDJNR/ L**	DVJCR/ L**	

Profiling · Profilbearbeit.	Type · Typ
	MRGNR/ L**
	SRGCR/ L**

Facing · Planbearbeitung	Type · Typ
	PSKNR/ L**
	PTFNR/ L**
	SSKCR/ L**

Toolholders for internal turning (Steel toolholder) · Klemmhalter Innenbearbeitung (Stahl) (Stahl) (Stahl)						
	S*-PSKNR/ L*	S*-PCLNR/ L*	S*-PDSNR/ L*	S*-PDUNR/ L*	S*-SDQCR/ L*	S*-SDZCR/ L*
	S*-PTFNR/ L*	S*-PWLNR/ L*		S*-SDUCR/ L*	S*-SDQPR/ L*	
	S*-SCFCR*	S*-SCLCR/ L*		S*-SDUNR/ L*	S*-SVQBR/ L*	
	S*-SSKCR/ L*	S*-SCLPR/ L*		S*-SDUPR/ L*	S*-SVQCR/ L*	
	S*-STFCR/ L*			S*-SVUBR/ L*		
	S*-STUPR/ L*			S*-SVUCR/ L*		

Toolholders for internal turning (Cemented carbide) · Klemmhalter Innenbearbeitung (Hartmetall)				
	C*-STUPR/ L*	C*-SCLPR/ L*	C*-SDUPR/ L*	C*-SDQPR/ L*
		C*-SVUCR/ L*	C*-SVQCR/ L*	

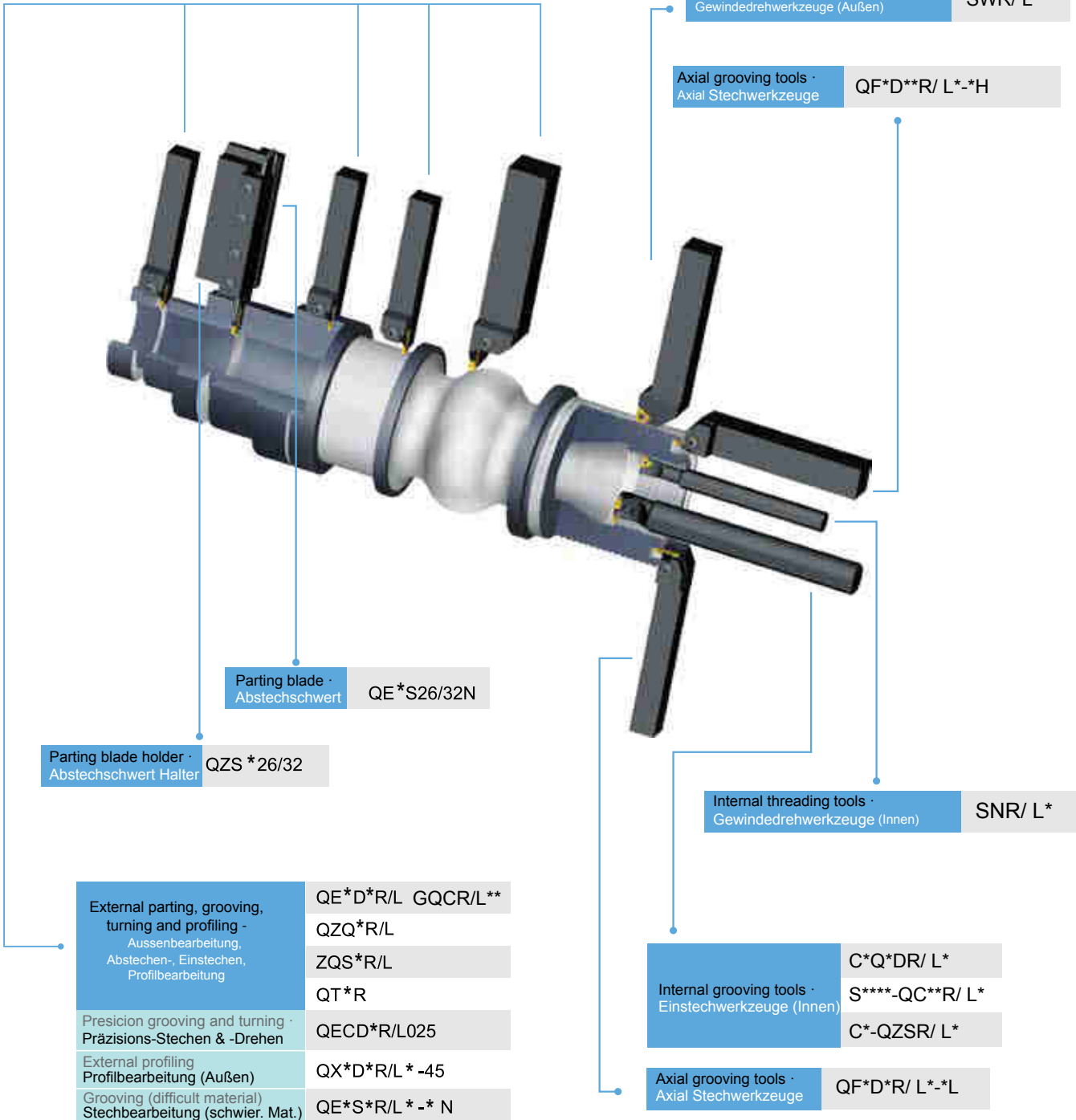
A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

Application of turning tools · Anwendung von Drehwerkzeugen

Parting, Grooving and Threading Tools · Abstech-, Einstech-, und Gewindewerkzeuge



A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

External Turning Tools · Drehwerkzeuge zur Außenbearbeitung

Turning tools overview · Drehwerkzeuge Übersicht **A166-A169**

Turning tools code key · ISO Kennzeichnung **A170-A171**

**Detailed table of external turning tools
Drehwerkzeuge zur Außenbearbeitung** **A172-A226**

Turning toolholders by D type clamping · Drehwerkzeuge / D Klemmung A173-A179

Turning toolholders by P type clamping · Drehwerkzeuge / P Klemmung A180-A191

Turning toolholders by M type clamping · Drehwerkzeuge / M Klemmung A192-A207

Turning toolholders by S type clamping · Drehwerkzeuge / S Klemmung A208-A225

Turning toolholders by C type clamping · Drehwerkzeuge / C Klemmung A226

**Detailed table of external turning tools (Ceramic)
Drehwerkzeuge zur Außenbearbeitung für Keramik WSP** **A227-A232**

Turning · Drehen

External turning tools Overview · Drehwerkzeuge zur Außenbearbeitung Übersicht

Clamping system Klemmsystem	Tool Type Werkzeug Typ	Approach angle Einstellwinkel	Turning Application · Anwendung					Workpiece · Werkstück		Page · Seite
			External turning Außenbearbeit.	Facing Planbearbeit.	Ext. turning & facing · Außen- & Planbearbeit.	Profiling Profilbearbeit.	Profiling Profilbearbeit.	Profiling Profilbearbeit.	Stable Stabil	
D	 DCLNR/L 95			✓				✓		A173
	 DDJNR/L 93					✓		✓		A174
	 DSBNR/L 75	✓						✓		A175
	 DTGNR/L 91	✓						✓		A176
	 DVVNN 72.5						✓	✓		A177
	 DVJNR/L 93					✓		✓		A178
	 DWLNR/L 95			✓				✓		A179
P	 PCBNR/L 75	✓						✓		A180
	 PCLNR/L 95			✓				✓		A181
	 PDJNR/L 93					✓		✓	✓	A182
	 PDNNR/L 63						✓	✓		A183
	 PSBNR/L 75	✓						✓		A184
	 PSDNN 45						✓	✓		A185
	 PSKNR/L 75			✓				✓		A186
	 PSSNR/L 45	✓						✓		A187

✓ Recommended · Empfehlung

External turning tools Overview · Drehwerkzeuge zur Außenbearbeitung Übersicht

Clamping system Klemmsystem	Tool Type Werkzeug Typ	Approach angle Einstellwinkel	Turning Application · Anwendung						Workpiece · Werkstück		Page · Seite
			External turning Außenbearbeit.	Facing Planbearbeit.	Ext., turning & facing · Außen- & Planbearbeit.	Profiling Profilbearbeit.	Profiling Profilbearbeit.	Profiling Profilbearbeit.	Stable Stabil	Unstable Instabil	
P	 PTFNR/ L	90		✓					✓	✓	A188
	 PTTNR/ L	60	✓						✓		A189
	 PTGNR/ L	90	✓						✓	✓	A190
	 PWLNR/ L	95			✓				✓		A191
M	 MCBNR/ L	75	✓						✓		A192
	 MCLNR/ L	95			✓				✓		A193
	 MDJNR/ L	93					✓		✓	✓	A194
	 MDPNN	62.5						✓	✓		A195
	 MSBNR/ L	75	✓						✓		A196
	 MSRNR/ L	75	✓						✓		A197
	 MSKNR/ L	75		✓					✓		A198
	 MSDNN	45						✓	✓		A199
	 MTGNR/ L	90	✓						✓	✓	A200
	 MTJNR/ L	93	✓						✓		A201
	 MTJNR/ L-Z	93			✓			✓	✓		A202

✓ Recommended · Empfehlung

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

External turning tools Overview · Drehwerkzeuge zur Außenbearbeitung Übersicht

A

General Turning
Allgemeine Drehbearbeitung

Clamping system Klemmsystem	Tool Type Werkzeug Typ	Approach angle Einstellwinkel	Turning Application · Anwendung						Workpiece · Werkstück		Page · Seite
			External turning Außenbearbeit.	Facing Planbearbeit.	Ext., turning & facing · Außen- & Planbearbeit.	Profiling Profilbearbeit.	Profiling Profilbearbeit.	Profiling Profilbearbeit.	Stable Stabil	Unstable Instabil	
M	 MTFNR/ L	90									A203
	 MVVNN	72.5		✓				✓	✓		A204
	 MVJNR/ L	93					✓		✓	✓	A205
	 MWLNR/ L	95			✓				✓		A206
	 MRGNR/ L	-				✓			✓		A207
	 MRDNN	-						✓	✓		A207
S	 SCACR/ L	90	✓						✓	✓	A208
	 SCLCR/ L	95			✓				✓	✓	A209
	 SDACR/ L	90					✓		✓	✓	A210
	 SDJCR/ L	93					✓		✓	✓	A211
	 SDNCN	62.5						✓	✓	✓	A212
	 SVJBR/ L	93					✓		✓	✓	A213
	 SVABR/ L	90					✓		✓	✓	A214
	 SVVBN	72.5						✓	✓	✓	A215
	 SVVCN	72.5						✓	✓	✓	A216

✓ Recommended · Empfehlung

Clamping system Klemmsystem	Tool Type Werkzeug Typ	Approach angle Einstellwinkel	Turning Application · Anwendung						Workpiece · Werkstück		Page · Seite
			External turning Außenbearbeit.	Facing Planbearbeit.	Ext. turning & facing ·Außen- & Planbearbeit.	Profiling Profilbearbeit.	Profiling Profilbearbeit.	Profiling Profilbearbeit.	Stable Stabil	Unstable Instabil	
S	 SVJCR/ L 93						✓		✓	✓	A217
	 SSBCR/ L 75	✓							✓		A218
	 SSDCN 45							✓	✓		A218
	 SSKCR/ L 75			✓					✓		A219
	 SSSCR/ L 45	✓							✓		A219
	 STACR/ L 90	✓							✓	✓	A220
	 STFCR/ L 91			✓					✓		A220
	 STGCR/ L 91	✓							✓	✓	A221
	 STTCR/ L 60	✓							✓		A222
	 SWACR/ L 90	✓							✓	✓	A223
	 SRDCN -								✓	✓	A224
	 SRGCR/ L -					✓			✓		A225
C	 CKJNR/ L 93						✓		✓		A226
	 CKNNR/ L 63							✓	✓		A226




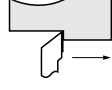



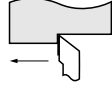



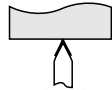




✓ Recommended · Empfehlung

Turning · Drehen

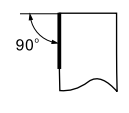
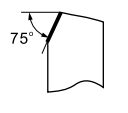
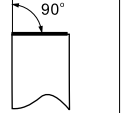
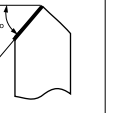
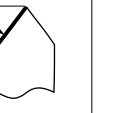
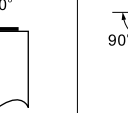
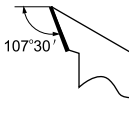
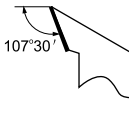
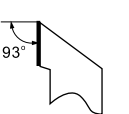
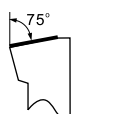
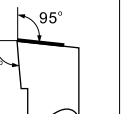
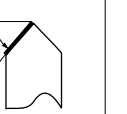
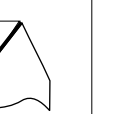
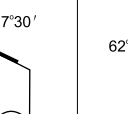
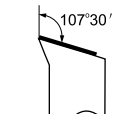
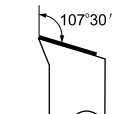
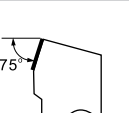
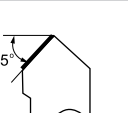
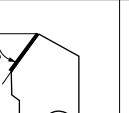
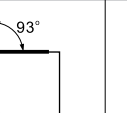
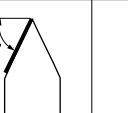
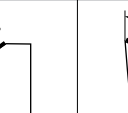

External turning tools Code Key · Drehwerkzeuge zur Außenbearbeitung ISO Kennzeichnung

A

General Turning
Allgemeine Drehbearbeitung

Clamping system <i>Klemmsystem</i>	Insert shape <i>Plattenform</i>		Clearance angle of major cutting edge <i>Freiwinkel der Hauptschneide</i>	Holder execution <i>Halterauführung</i>
P lever lock clamping <i>Kniehebel-Spannsystem</i>	 C	 D	 B	 L
M Screw clamping <i>Schrauben-Spannsystem</i>	 R	 S	 C	 R
S Wedge lock clamping <i>Pratzenkeilklemmung</i>	 T	 V	 D	 N
C Overhead clamping <i>Pratzenklemmung</i>	 W		 E	
D Double clamping <i>Doppelklemmung</i>			 N	
			 P	

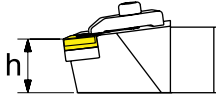
P C L N L

Holder style and lead angle <i>Halteform und Anstellwinkel</i>							
A	B	C	D	E	F	G	H
							
							
							

Turning · Drehen

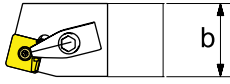
External turning tools Code Key · Drehwerkzeuge zur Außenbearbeitung ISO Kennzeichnung

**Height
Schafthöhe**



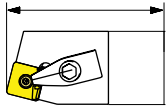
Code	Height Höhe
12	12
16	16
20	20
25	25
32	32
40	40
50	50

**Schank width
Schaftbreite**








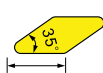

Code	Width Breite
12	12
16	16
20	20
25	25
32	32
40	40
50	50

**Tool length
Halterlänge**



Code	Length Länge
H	100
K	125
M	150
P	170
Q	180
R	200
S	250
T	300

25 25 M 12

Cutting edge length Schneidkantenlänge							
insert shape Plattenform	C	D	R	S	T	V	W
							
Diameter of incircle Durchmesser (mm)	Cutting edge length / Schneidkantenlänge						
5.556	---	---	---	---	09	---	---
6.350	06	07	---	---	11	---	---
9.525	09	11	09	09	16	16	06
12.700	12	15	12	12	22	22	08
15.875	16	19	15	15	27	---	---
19.050	19	---	19	19	33	---	---
25.400	25	---	25	25	44	---	---
32.000	---	---	32	---	---	---	---

A

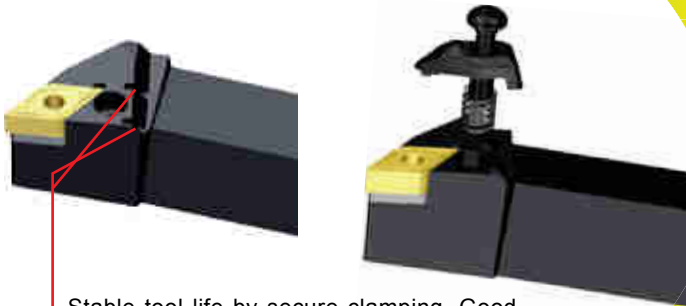
General Turning
Allgemeine Drehbearbeitung



Series double clamping toolholder Serie doppel Klemmhalter

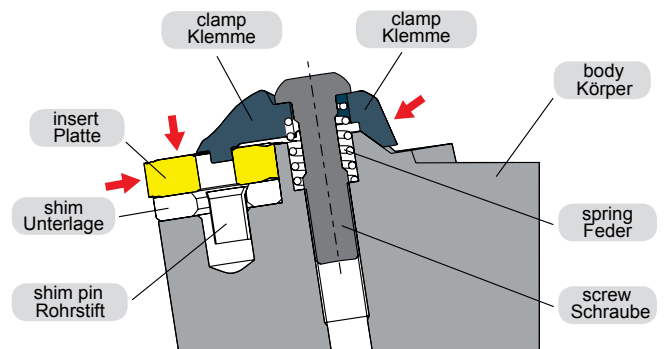
D-Type clamp toolholder
Double clamping system in one operation. The special designed clamping finger enable a stable holding of the inserts, with high accuracy and clamping force for better tool life and higher machining accuracy.

Best indexing accuracy, high clamping force.
Hohe Wiederholgenauigkeit, exzellente Klemmkraft.



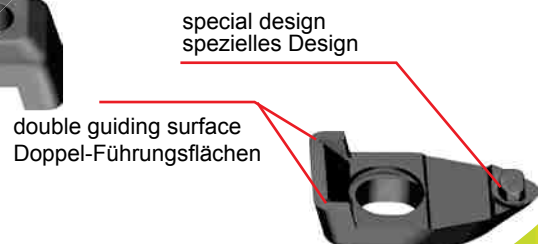
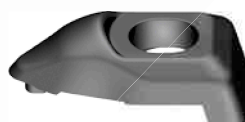
Stable tool life by secure clamping. Good anti-corrosive and wear-resistance.
Stabile Standzeiten durch sichere Klemmung. Gute Verschleißfestigkeit.

D-Typ Drehhalter
Doppelklemmsystem mit einer Handbewegung. Der speziell designte Spannfinger ermöglicht eine stabile Spannung der Wendeschneidplatten und sorgt für hohe Positioniergenauigkeit und Spannkraft für höhere Standzeiten und Bearbeitungsgenauigkeiten.



Special clamp nose design for more stability and high clamping accuracy.

Spezielles Spannfingerdesign für mehr Stabilität und Genauigkeit.

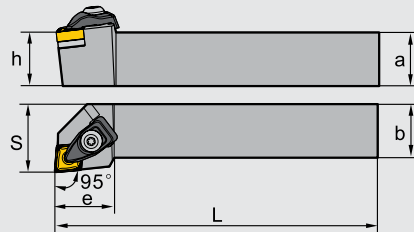


CN** Toolholder · Halter

D-Clamping · D-Halter

DCLNR/ L

Kr:95°



Type Typ		Stock Lager		Dimension (mm) Abmessung					Screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Shim pin Rohrstift	Spring Feder	
		R	L	a	b	L	h	s	e						
DCLNR/ L	1616H09	●	○	16	16	100	16	20	24	CM5x22C	C09BM	WH30L	C1RA	SM5 x8.65XA1	SPR6
	2020K09	●	●	20	20	125	20	25	24						
	2525M09	●	●	25	25	150	25	32	24						
	2020K12	●	●	20	20	125	20	25	28	CM6x25C	C12BM	WH40L	C2RA	SM6 x10XA1	SPR4
	2525M12	●	●	25	25	150	25	32	28						
	3225P12	●	●	32	25	170	32	32	28						

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspannung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF A60	PM A61	DR Double side doppel seitig A63	HDR A65	Flat Flach A66	Flat Flach A129
	SF A60	DM A62	DR Single side einseitig A63	HPR A65	TC A63	
	EF A60	EM A62	ER Double side doppel seitig A64			
	NF A61	NM A63	ER Single side einseitig A64			
			LR Single side einseitig A64			
Type · Typ	DCLNR/L**H/K/M09	CN**0903**	CN**0903**			
	DCLNR/L**K/M/P12	CN**1204**	CN**1204**	CN**1204**	CN**1204**	CN**1204**

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

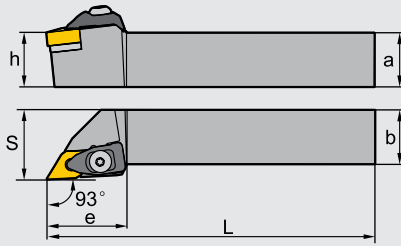
External turning tools · Drehwerkzeuge zur Außenbearbeitung

DN** Toolholder · Halter

D-Clamping · D-Halter

DDJNR/ L

Kr:93°



Type Typ		Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Shim pin Rohrstift	Spring Feder
		R	L	a	b	L	h	s	e						
DDJNR/L	1616H11	○	○	16	16	100	16	20	30	CM5x22C	D11BM	WH30L	C1RA	SM5 × 8.65XA1	SPR6
	2020K11	●	●	20	20	125	20	25	30						
	2525M11	●	●	25	25	150	25	32	30						
	3225P11	○	○	32	25	170	32	32	30						
	2020K15	●	●	20	20	125	20	25	35	CM6x25C	D15BM	WH40L	C2RA	SM6 × 10XA1	SPR4
	2525M15	●	●	25	25	150	25	32	35						
	3232P15	●	●	32	32	170	32	40	35						

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspannung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF A67	PM A69	DR Double side doppelt seitig A70	HDR A72	Flat Flach A71	Flat Flach A130
	SF A67	DM A69	DR Single side einseitig A72			
	EF A68	EM A70	ER Double side doppelt seitig A70			
	NF A68	NM A70	ER Single side einseitig A72			
			LR Single side einseitig A72			
Type · Typ	DDJNR/L**H/K/M/P11	DN**1104**	DN**1104**		DN**1104**	
	DDJNR/L**K/M/P15	DN**1506**	DN**1506**	DN**1506**	DN**1506**	DN**1506**

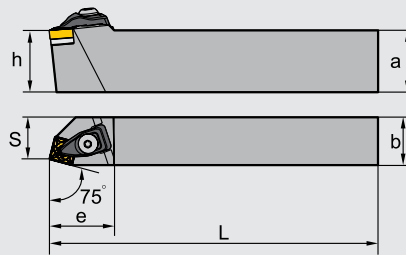
● ex stock · ab Lager ○ on demand · Anfrage







SN** Toolholder · Halter

D-Clamping · D-Halter


















DSBNR/ L

Kr:75°



Type Typ		Stock Lager		Dimension (mm) Abmessung					Screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Shim pin Rohrstift	Spring Feder	
		R	L	a	b	L	h	s	e						
DSBNR/L	1616H09	●	○	16	16	100	16	13	26	CM5x22C	S09BM	WH30L	C1RA	SM5 × 8.65XA1	SPR6
	2020K12	●	●	20	20	125	20	17	34						
	2525M12	●	●	25	25	150	25	22	34	CM6x25C	S12BM	WH40L	C2RA	SM6 × 10XA1	SPR4
	3225P12	●	●	32	25	170	32	22	34						
	3232P15	●	●	32	32	170	32	27	41	CM6x25C	S15BM	WH40L	C3RA	SM6 × 10XA2	SPR4

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspanung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF  A73	PM  A74	DR Double side doppel seitig  A76	HDR  A78	 A80	 A131
	EF  A73	DM  A75	DR Single side einseitig  A77	HPR  A78	TC  A75	
	SF  A74	EM  A75	ER Double side doppel seitig  A76			
		NM  A76	ER Single side einseitig  A78			
			LR Single side einseitig  A77			
Type · Typ	DSBNR/L**H09	SN**0903**	SN**0903**		SN**0903**	
	DSBNR/L**K/M/P12	SN**1204**	SN**1204**	SN**1204**	SN**1204**	SN**1204**
	DSBNR/L**P15	SN**1506**	SN**1506**	SN**1506**	SN**1506**	SN**1506**

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

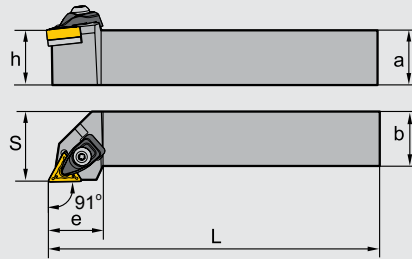
External turning tools · Drehwerkzeuge zur Außenbearbeitung

TN** Toolholder · Halter

D-Clamping · D-Halter

DTGNR/ L

Kr:91°



Type Typ		Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Shim pin Rohrstift	Spring Feder
		R	L	a	b	L	h	s	e						
DTGNR/L	1616H16	●	●	16	16	100	16	20	25						
	2020K16	●	●	20	20	125	20	25	25	CM5x22C	T16BM	WH30L	C1RA	SM5 x 8.65XA1	SPR6
	2525M16	●	●	25	25	150	25	32	25						

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerverspanung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF A82	PM A83	DR Double side doppel seitig A84	HDR A86	Flat Flach A87	Flat Flach A132
	SF A82	DM A83	DR Single side einseitig A85		TC A84	
	EF A82	EM A84	ER Double side doppel seitig A85			
			LR Single side einseitig A85			
Type · Typ	DTGNR/L**H/K/M16	TN**1604**	TN**1604**	TN**1604**	TN**1604**	TN**1604**

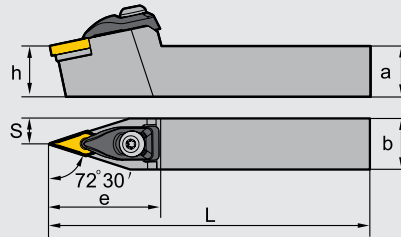
● ex stock · ab Lager ○ on demand · Anfrage

VN** Toolholder · Halter

D-Clamping · D-Halter



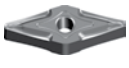



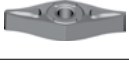
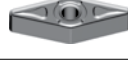
DVVNN

Kr:72°30'



Type Typ		Stock Lager	Dimension (mm) Abmessung					Screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Shim pin Rohrstift	Spring Feder	
			N	a	b	L	h							s
DVVNN	2020K16	●	20	20	125	20	10	44	CM5×22C	V16BM	WH30L	C6RA	SM5 × 8.65XA1	SPR6
	2525M16	●	25	25	150	25	12.5	44						

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schichten		Semi-Finishing Mittlere Bearbeitung		PCBN · PCD PCBN · PKD	
	insert shape Schneidplattenform	DF	 A88	PM	 A89	Flat Flach
EF		 A88	DM	 A89		
SF		 A88	EM	 A89		
NF		 A88	NM	 A89		
Type · Typ	DVVNN**K/M16	VN**1604**		VN**1604**		VN**1604**

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

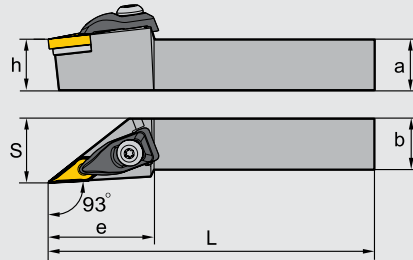
External turning tools · Drehwerkzeuge zur Außenbearbeitung







VN** Toolholder · Halter

D-Clamping · D-Halter










DVJNR/L

Kr:93°



Type Typ		Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Shim pin Rohrstift	Spring Feder
		R	L	a	b	L	h	s	e						
DVJNR/L	2020K16	●	○	20	20	125	20	25	41	CM5×22C	V16BM	WH30L	C6RA	SM5 × 8.65XA1	SPR6
	2525M16	●	●	25	25	150	25	32	41						

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schichten	Semi-Finishing Mittlere Bearbeitung	PCBN · PCD PCBN · PKD	
insert shape Schneidplattenform	DF  A88	PM  A89	Flat Flach  A133	
	EF  A88	DM  A89		
	SF  A88	EM  A89		
	NF  A88	NM  A89		
Type · Typ	DVVN**K/M16	VN**1604**	VN**1604**	VN**1604**

● ex stock · ab Lager ○ on demand · Anfrage

Turning · Drehen

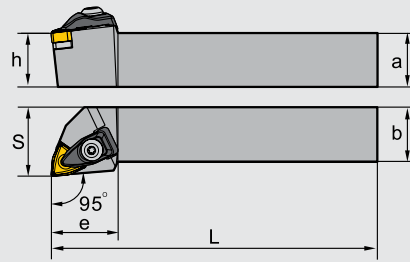
External turning tools · Drehwerkzeuge zur Außenbearbeitung







WN** Toolholder · Halter

D-Clamping · D-Halter











DWLNR/ L

Kr:95°



Type Typ		Stock Lager		Dimension (mm) Abmessung					Screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Shim pin Rohrstift	Spring Feder	
		R	L	a	b	L	h	s	e						
DWLNR/L	1616H06	●	●	16	16	100	16	20	24	CM5×22C	W06BM	WH30L	C1RA	SM5 × 8.65XA1	SPR6
	2020K06	●	●	20	20	125	20	25	24						
	2525M06	●	●	25	25	150	25	32	24						
	2020K08	●	●	20	20	125	20	25	31	CM6×25C	W08BM	WH40L	C2RA	SM6 × 10XA1	SPR4
	2525M08	●	●	25	25	150	25	32	31						
	3225P08	●	●	32	25	170	32	32	31						

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Cast iron machining Grauguss Bearbeit.	
insert shape Schneidplattenform	DF  A90	PM  A92	DR Double side doppel seitig  A93	TC Flat Flach  A93	
	SF  A91	DM  A92			
	EF  A91	EM  A92			
	NF  A91	NM  A92			
Type · Typ	DWLNR/L**H/K/M06	WN**0604**	WN**0604**	WN**0604**	WN**0604**
	DWLNR/L**K/M/P08	WN**0804**	WN**0804**	WN**0804**	WN**0804**

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

External turning tools · Drehwerkzeuge zur Außenbearbeitung

CN** Toolholder · Halter

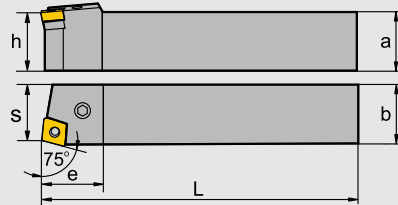
P-Clamping · P-Halter

PCBNR/ L

Kr:75°



R Type
Rechtsausführung



Type Typ		Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Wrench Schlüssel	Lever Kniehebel	Shim pin Rohrstift
		R	L	a	b	L	h	s	e					
PCBNR/ L	2020K12	●	●	20	20	125	20	17	27	LEM8×21	C12AP	WH30L	L4	SP4
	2525M12	●	●	25	25	150	25	22	27					
	3232P12	●	●	32	32	170	32	27	27					
	2525M16	●	●	25	25	150	25	22	33	LEM8×25	C16AP	WH30L	L5	SP5
	3232P16	●	●	32	32	170	32	27	33					
	3232P19	●	●	32	32	170	32	27	38	LEM10×27	C19AP	WH40L	L6	SP6
	4040S19	●	●	40	40	250	40	35	38					
	4040S2507	●	●	40	40	250	40	35	50	LEM12×36A	C25AP-07	WH50L	L8	SP8
4040S2509	●	●	40	40	250	40	35	50	C25AP					

Applicable inserts
Wendeschneidplatten

Application Anwendung	Finishing Schichten	Semi-Finishing Mittlere Bearbeitung	Rough machining Schruppen	Heavy Duty Schwerzerspanung	Cast iron Grauguss-Bearbeit.
WSP Inserts	DF A60	PM A61	DR A63 Double side doppelseitig	HDR A65	Flat A66
	SF A60	DM A62	DR A63 Single side einseitig	HPR A65	TC A63
	EF A60	EM A62	ER A64 Double side doppelseitig		
	NF A61	NM A63	ER A64 Single side einseitig		
			LR A64 Single side einseitig		
PCBNR/L**K / M / P12	CN**1204**	CN**1204**	CN**1204**	CN**1204**	CN**1204**
PCBNR/L**M / P16	CN**1606**	CN**1606**	CN**1606**	CN**1606**	CN**1606**
PCBNR/L**P / S19		CN**1906**	CN**1906**	CN**1906**	CN**1906**
PCBNR/L**S2507			CN**2507**		
PCBNR/L**S2509			CN**2509**	CN**2509**	

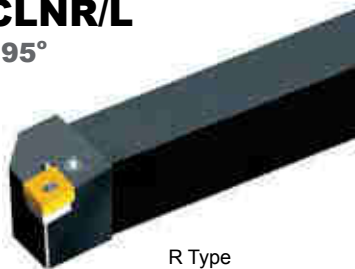
● ex stock · ab Lager ○ on demand · Anfrage

CN** Toolholder · Halter

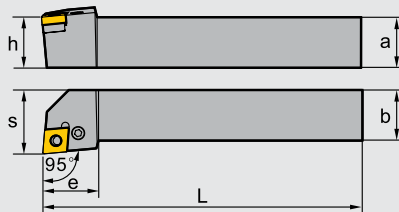
P-Clamping · P-Halter






PCLNR/L

Kr:95°





















R Type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Wrench Schlüssel	Lever Kniehebel	Shim pin Rohrstift
	R	L	a	b	L	h	s	e					
PCLNR/ L	1616H09	● ●	16	16	100	16	20	20	LEM6×13.4A	C09AP	WH25L	L3	SP10
	2020K09	● ●	20	20	125	20	25	22					
	2525M09	○ ●	25	25	150	25	32	22					
	2020K12	● ●	20	20	125	20	25	28	LEM8×21	C12AP	WH30L	L4	SP4
	2525M12	● ●	25	25	150	25	32	28					
	3232P12	● ●	32	32	170	32	40	28	LEM8×25	C16AP	WH30L	L5	SP5
	2525M16	● ●	25	25	150	25	32	33					
	3232P16	● ●	32	32	170	32	40	33	LEM10×27	C19AP	WH40L	L6	SP6
	3232P19	● ●	32	32	170	32	40	38					
	4040S19	● ●	40	40	250	40	50	38	LEM12×36A	C25AP-07 C25AP	WH50L	L8	SP8
4040S2507	● ●	40	40	250	40	50	49						
4040S2509	● ●	40	40	250	40	50	49						

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspannung	Cast iron Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF  A60	PM  A61	DR Double side doppel seitig  A63	HDR  A65	Flat Flach  A66	Flat Flach  A129
	SF  A60	DM  A62	DR Single side einseitig  A63	HPR  A65	TC  A63	
	EF  A60	EM  A62	ER Double side doppel seitig  A64			
	NF  A61	NM  A63	ER Single side einseitig  A64			
			LR Single side einseitig  A64			
PCLNR/L**H / K / M09	CN**0903**	CN**0903**				
PCLNR/L**K / M / P12	CN**1204**	CN**1204**	CN**1204**	CN**1204**	CN**1204**	CN**1204**
PCLNR/L**M / P16	CN**1606**	CN**1606**	CN**1606**	CN**1606**	CN**1606**	
PCLNR/L**P / S19		CN**1906**	CN**1906**	CN**1906**	CN**1906**	
PCLNR/L**S2507			CN**2507**			
PCLNR/L**S2509			CN**2509**	CN**2509**		

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

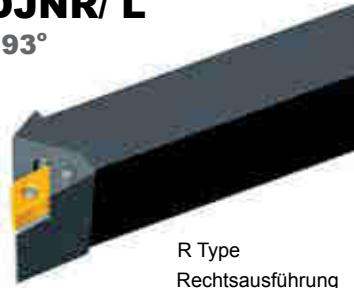
External turning tools · Drehwerkzeuge zur Außenbearbeitung

DN** Toolholder · Halter

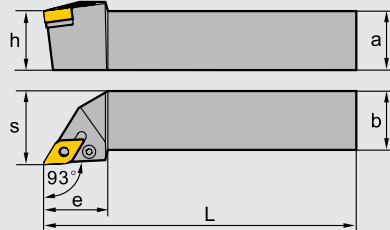
P-Clamping · P-Halter

PDJNR/ L

Kr:93°



R Type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Wrench Schlüssel	Lever Kniehebel	Shim pin Rohrstift	
	R	L	a	b	L	h	s	e						
PDJNR/ L	1616H11	●	●	16	16	100	16	20	25	LEM6×13.4A	D11AP	WH25L	L3	SP3
	2020K11	●	●	20	20	125	20	25	25					
	2525M11	●	●	25	25	150	25	32	30					
	2020K15	●	●	20	20	125	20	25	35					
	2525M15	●	●	25	25	150	25	32	35	LEM8×21	D15AP	WH30L	L4B	SP4
	3232P15	●	●	32	32	170	32	40	35					
	2020K15-3	●	●	20	20	125	20	25	35	LEM8×21	D15AP	WH30L	L4	SP4
	2525M15-3	●	●	25	25	150	25	32	35					
*3232P15-3	●	●	32	32	170	32	40	35						

* For DNMG1504 / Für DNMG1504

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspanung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF A67	PM A69	DR Double side doppel seitig A70	HDR A72	Flat Flach A71	Flat Flach A130
	SF A67	DM A69	DR Single side einseitig A72			
	EF A68	EM A70	ER Double side doppel seitig A70			
	NF A68	NM A70	ER Single side einseitig A72			
			LR Single side einseitig A72			
Type · Typ	PDJNR/L**H / K / M11	DN**1104**	DN**1104**		DN**1104**	
	PDJNR/L**K / M / P15	DN**1506**	DN**1506**	DN**1506**	DN**1506**	DN**1506**
	PDJNR/L**K / M / P15-3	DN**1504**	DN**1504**		DN**1504**	DN**1504**

● ex stock · ab Lager ○ on demand · Anfrage

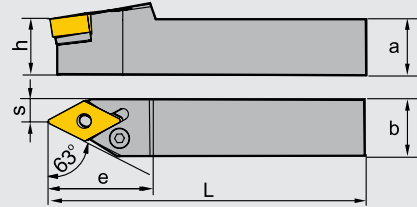
DN** Toolholder · Halter






P-Clamping · P-Halter

PDNNR/ L Kr:63°



















L Type
Linksausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Wrench Schlüssel	Lever Kniehebel	Shim pin Rohrstift	
	R	L	a	b	L	h	s	e						
PDNNR/ L	2020K15	●	●	20	20	125	20	8	37	LEM8×21	D15AP	WH30L	L4B	SP4
	2525M15	●	●	25	25	150	25	12.5	37					
	3232P15	●	●	32	32	170	32	16	37					
	2020K15-3	●	●	20	20	125	20	8	37	LEM8×21	D15AP	WH30L	L4	SP4
	2525M15-3	●	●	25	25	150	25	12.5	37					
	*3232P15-3	●	●	32	32	170	32	16	37					

* For DNMG1504 / Für DNMG1504

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspannung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF  A67	PM  A69	DR Double side doppelseitig  A70	HDR  A72	Flat Flach  A71	Flat Flach  A130
	SF  A67	DM  A69	DR Single side einseitig  A72			
	EF  A68	EM  A70	ER Double side doppelseitig  A70			
	NF  A68	NM  A70	ER Single side einseitig  A72			
			LR Single side einseitig  A72			
Type · Typ	PDNNR/L**K / M/ P15	DN**1506**	DN**1506**	DN**1506**	DN**1506**	DN**1506**
	PDNNR/L**K / M/ P15-3	DN**1504**	DN**1504**		DN**1504**	DN**1504**

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

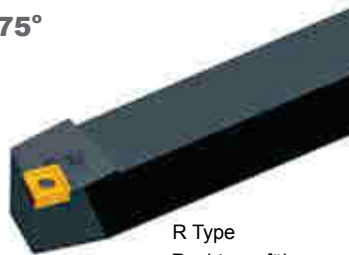
External turning tools · Drehwerkzeuge zur Außenbearbeitung

SN** Toolholder · Halter

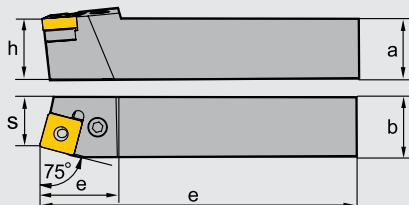
P-Clamping · P-Halter

PSBNR/ L

Kr:75°




















R Type
Rechtsausführung



Type Typ	Stock Lager	Dimension (mm) Abmessung							Screw Schraube	Shim Unterlage	Wrench Schlüssel	Lever Kniehebel	Shim pin Rohrstift	
		R	L	a	b	L	h	s						e
PSBNR/ L	1616H09	●	●	16	16	100	16	13	21	LEM6×13.4A	S09AP	WH25L	L3	SP10
	2020K09	●	●	20	20	125	20	17	23					
	2020K12	●	●	20	20	125	20	17	28					
	2525M12	●	●	25	25	125	25	22	28	LEM8×21	S12AP	WH30L	L4	SP4
	3225P12	●	○	32	25	170	32	22	28					
	3232P12	●	●	32	32	170	32	27	28					
	2525M15	●	○	25	25	150	25	22	35	LEM8×25	S15AP	WH30L	L5	SP5
	3232P15	●	●	32	32	170	32	27	35					
	3232P19	●	●	32	32	170	32	27	40					
	4040S19	●	●	40	40	250	40	35	40	LEM10×27	S19AP	WH40L	L6	SP6
	4040S2507	○	○	40	40	250	40	35	48					
4040S2509	○	○	40	40	250	40	35	48						
									LEM12×36A	S25AP S25AP-09	WH50L	L8	SP8	

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspannung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD	
insert shape Schneidplattenform	DF  A73	PM  A74	DR  A76 Double side doppel seitig	HDR  A78	Flat Flach  A80	Flat Flach  A131	
	EF  A73	DM  A75	DR  A77 Single side einseitig	HPR  A78	TC  A75		
	SF  A74	EM  A75	ER  A76 Double side doppel seitig				
		NM  A76	ER  A78 Single side einseitig				
			LR  A77 Single side einseitig				
	PSBNR/L**H / K09	SN**0903**	SN**0903**			SN**0903**	
	PSBNR/L**K / M / P12	SN**1204**	SN**1204**	SN**1204**	SN**1204**	SN**1204**	SN**1204**
PSBNR/L**M / P15	SN**1506**	SN**1506**	SN**1506**	SN**1506**	SN**1506**		
PSBNR/L**P / S19		SN**1906**	SN**1906**	SN**1906**	SN**1906**		
PSBNR/L**S2507			SN**2507**	SN**2507**			
PSBNR/L**S2509			SN**2509**	SN**2509**			

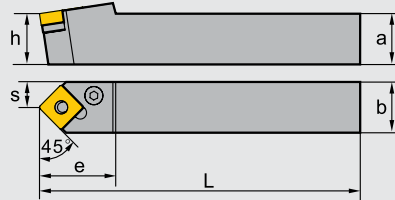
● ex stock · ab Lager ○ on demand · Anfrage

SN** Toolholder · Halter

P-Clamping · P-Halter


















PSDNN

Kr:45°



Type Typ	Stock Lager	Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Wrench Schlüssel	Lever Kniehebel	Shim pin Rohrstift	
		a	b	L	h	s	e						
PSDNN	1212F09	○	12	12	80	12	6	21	LEM5×12B	—	WH20L	L3B	—
	1616H09	●	16	16	100	16	8	23	LEM6×13.4A	S09AP	WH25L	L3	SP10
	2020K12	●	20	20	125	20	10	30	LEM8×21	S12AP	WH30L	L4	SP4
	2525M12	●	20	20	150	20	12.5	30					
	3232P12	●	32	32	170	32	16	40	LEM8×25	S15AP	WH30L	L5	SP5
	2525M15	●	25	25	150	25	12.5	40					
	3232P15	●	32	32	170	32	16	40	LEM10×27	S19AP	WH40L	L6	SP6
	3232P19	●	32	32	170	32	16	40					
4040S19	●	40	40	250	40	20	40						

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspannung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF  A73	PM  A74	DR Double side doppel seitig  A76	HDR  A78	Flat Flach  A80	Flat Flach  A131
	EF  A73	DM  A75	DR Single side einseitig  A77	HPR  A78	TC  A75	
	SF  A74	EM  A75	ER Double side doppel seitig  A76			
		NM  A76	ER Single side einseitig  A78			
			LR Single side einseitig  A77			
Type · Typ	PSDNN**F / H09	SN**0903**	SN**0903**		SN**0903**	
	PSDNN**K / M / P12	SN**1204**	SN**1204**	SN**1204**	SN**1204**	SN**1204**
	PSDNN**M / P15	SN**1506**	SN**1506**	SN**1506**	SN**1506**	
	PSDNN**P / S19		SN**1906**	SN**1906**	SN**1906**	

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

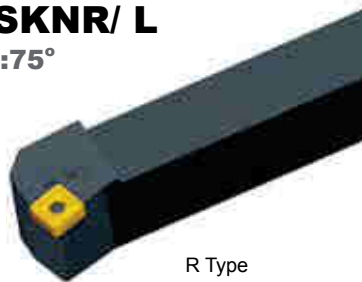
External turning tools · Drehwerkzeuge zur Außenbearbeitung

SN** Toolholder · Halter

P-Clamping · P-Halter

PSKNR/ L

Kr:75°



R Type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Wrench Schlüssel	Lever Kniehebel	Shim pin Rohrstift	
	R	L	a	b	L	h	s	e						
PSKNR/ L	1616H09	○	●	16	16	100	16	20	17	LEM6×13.4A	S09AP	WH25L	L3	SP10
	2020K09	●	●	20	20	125	20	25	20	LEM8×21	S12AP	WH30L	L4	SP4
	2020K12	●	●	20	20	125	20	25	26					
	2525M12	●	●	25	25	150	25	32	26					
	3232P12	●	●	32	32	170	32	40	26	LEM8×25	S15AP	WH30L	L5	SP5
	2525M15	●	○	25	25	150	25	32	32					
	3232P15	●	●	32	32	170	32	40	32	LEM10×27	S19AP	WH40L	L6	SP6
	3232P19	●	●	32	32	170	32	40	36					
4040S19	○	○	40	40	250	40	50	40						

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspannung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF A73	PM A74	DR A76 Double side doppel seitig	HDR A78	Flat Flach A80	Flat Flach A131
	EF A73	DM A75	DR A77 Single side einseitig	HPR A78	TC A75	
	SF A74	EM A75	ER A76 Double side doppel seitig			
		NM A76	ER A78 Single side einseitig			
			LR A77 Single side einseitig			
Type · Typ	PSKNR/ L**H / K09	SN**0903**	SN**0903**		SN**0903**	
	PSKNR/ L**K / M / P12	SN**1204**	SN**1204**	SN**1204**	SN**1204**	SN**1204**
	PSKNR/ L**M / P15	SN**1506**	SN**1506**	SN**1506**	SN**1506**	SN**1506**
	PSKNR/ L**P / S19		SN**1906**	SN**1906**	SN**1906**	SN**1906**

● ex stock · ab Lager ○ on demand · Anfrage

Turning · Drehen

External turning tools · Drehwerkzeuge zur Außenbearbeitung

SN** Toolholder · Halter

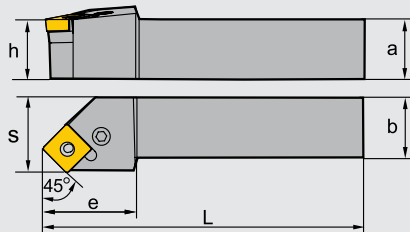
P-Clamping · P-Halter

PSSNR/ L

Kr:45°




















R Type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Wrench Schlüssel	Lever Kniehebel	Shim pin Rohrstift	
	R	L	a	b	L	h	s	e						
PSSNR/ L	1616H09	●	●	16	16	100	16	20	25	LEM6×13.4A	S09AP	WH25L	L3	SP10
	2020K12	●	●	20	20	125	20	25	30					
	2525M12	●	●	25	25	150	25	32	30	LEM8×21	S12AP	WH30L	L4	SP4
	3232P12	●	●	32	32	170	32	40	40					
	2525M15	●	●	25	25	150	25	32	30	LEM8×25	S15AP	WH30L	L5	SP5
	3232P15	●	●	32	32	170	32	40	40					
	3232P19	●	●	32	32	170	32	40	40	LEM10×27	S19AP	WH40L	L6	SP6
	4040S19	●	●	40	40	250	40	50	50					
	4040S2507	●	●	40	40	250	40	50	50	LEM12×36A	S25AP			
4040S2509	●	●	40	40	250	40	50	50		S25AP-09	WH50L	L8	SP8	

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspanung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF  A73	PM  A74	DR  A76 Double side doppel seitig	HDR  A78	Flat Flach  A80	Flat Flach  A131
	EF  A73	DM  A75	DR  A77 Single side einseitig	HPR  A78	TC  A75	
	SF  A74	EM  A75	ER  A76 Double side doppel seitig			
		NM  A76	ER  A78 Single side einseitig			
			LR  A77 Single side einseitig			
Type · Typ	PSSNR/ L**H09	SN**0903**	SN**0903**	SN**0903**	SN**0903**	
	PSSNR/ L**K / M / P12	SN**1204**	SN**1204**	SN**1204**	SN**1204**	SN**1204**
	PSSNR/ L**M / P15	SN**1506**	SN**1506**	SN**1506**	SN**1506**	
	PSSNR/ L**P / S19		SN**1906**	SN**1906**	SN**1906**	
	PSSNR/ L**S2507			SN**2507**	SN**2507**	
	PSSNR/ L**S2509			SN**2509**	SN**2509**	

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

External turning tools · Drehwerkzeuge zur Außenbearbeitung

TN** Toolholder · Halter

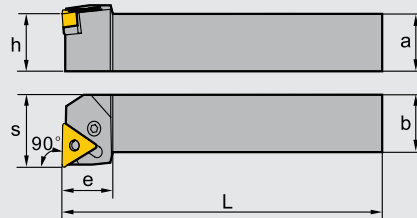
P-Clamping · P-Halter

PTFNR/ L

Kr:90°

















R Type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Wrench Schlüssel	Lever Kniehebel	Shim pin Rohrstift	
	R	L	a	b	L	h	s	e						
PTFNR/ L	1616H16	●	●	16	16	100	16	20	20	LEM6×13.4A	T16AP	WH25L	L3	SP3
	2020K16	●	●	20	20	125	20	25	20					
	2525M16	●	●	25	25	150	25	32	20					
	2525M22	●	●	25	25	150	25	32	25	LEM8×21	T22AP	WH30L	L4	SP4
	3232P22	●	●	32	32	170	32	40	25					
	3232P27	●	○	32	32	170	32	40	34	LEM8×25	T27AP	WH30L	L5	SP5
4040S27	○	○	40	40	250	40	50	34						

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspannung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF  A82	PM  A83	DR Double side doppel seitig  A84	HDR  A86	Flat Flach  A87	Flat Flach  A132
	SF  A82	DM  A83	DR Single side einseitig  A85		TC  A84	
	EF  A82	EM  A84	ER Double side doppel seitig  A85			
			LR Single side einseitig  A85			
Typ	PTFNR/ L**H / K / M16	TN**1604**	TN**1604**	TN**1604**	TN**1604**	TN**1604**
	PTFNR/ L**M / P22	TN**2204**	TN**2204**	TN**2204**	TN**2204**	TN**2204**
Typ	PTFNR/ L**P / S27			TN**2706**	TN**2706**	TN**2706**

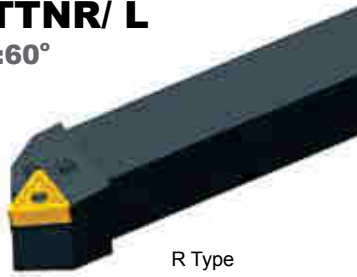
● ex stock · ab Lager ○ on demand · Anfrage

TN** Toolholder · Halter

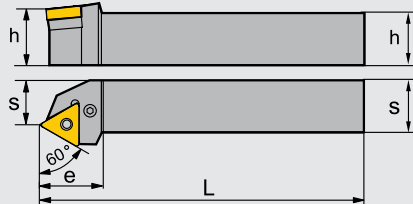
P-Clamping · P-Halter

PTTNR/ L

Kr:60°

















R Type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Wrench Schlüssel	Lever Kniehebel	Shim pin Rohrstift	
	R	L	a	b	L	h	s	e						
PTTNR/ L	1616H16	●	●	16	16	100	16	13	25	LEM6×13.4A	T16AP	WH25L	L3	SP3
	2020K16	●	●	20	20	125	20	17	25					
	2525M22	●	●	25	25	150	20	22	32	LEM8×21	T22AP	WH30L	L4	SP4

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspannung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF  A82	PM  A83	DR Double side doppel seitig  A84	HDR  A86	 A87	 A132
	SF  A82	DM  A83	DR Single side einseitig  A85		TC  A84	
	EF  A82	EM  A84	ER Double side doppel seitig  A85			
			LR Single side einseitig  A85			
Type · Typ	PTTNR / L**H / K16	TN**1604**	TN**1604**	TN**1604**	TN**1604**	TN**1604**
	PTTNR / L**M22	TN**2204**	TN**2204**	TN**2204**	TN**2204**	TN**2204**

A

General Turning
Allgemeine Drehbearbeitung

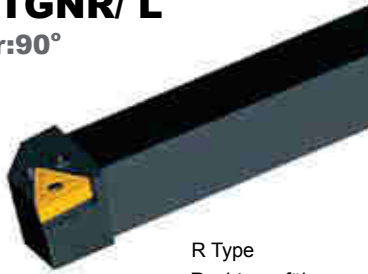
Turning · Drehen

External turning tools · Drehwerkzeuge zur Außenbearbeitung

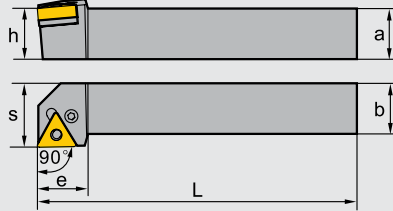
TN** Toolholder · Halter

P-Clamping · P-Halter

PTGNR/ L Kr:90°

















R Type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Wrench Schlüssel	Lever Kniehebel	Shim pin Rohrstift	
	R	L	a	b	L	h	s	e						
PTGNR/ L	1010E11	○	○	10	10	70	10	14	16	LEM5×9B	—	WH20L	L2	—
	1212F11	○	○	12	12	80	12	16	14					
	1616H11	●	●	16	16	100	16	20	18					
	2020K11	●	●	20	20	125	20	25	19					
	2525M11	○	●	25	25	150	25	32	20					
	1616H16	●	●	16	16	100	16	20	20					
	2020K16	●	●	20	20	125	20	25	20	LEM6×13.4A	T16AP	WH25L	L3	SP3
	2525M16	●	●	25	25	150	25	32	20					
	3232P16	●	●	32	32	170	32	40	20					
	2525M22	●	●	25	25	150	25	32	28					
	3232P22	●	●	32	32	170	32	40	28	LEM8×21	T22AP	WH30L	L4	SP4
	3232P27	●	●	32	32	170	32	40	33					
4040S27	○	●	40	40	250	40	50	33	LEM8×25	T27AP	WH30L	L5	SP5	

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspanung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF  A82	PM  A83	DR Double side doppel seitig  A84	HDR  A86	 A87	 A132
	SF  A82	DM  A83	DR Single side einseitig  A85		TC  A84	
	EF  A82	EM  A84	ER Double side doppel seitig  A85			
			LR Single side einseitig  A85			
Type Typ	PTGNR/L**E / F / H / K / M11	TN**1103**	TN**1103**		TN**1103**	
	PTGNR/L**H / K / M16	TN**1604**	TN**1604**	TN**1604**	TN**1604**	TN**1604**
	PTGNR /L**M / P22	TN**2204**	TN**2204**	TN**2204**	TN**2204**	TN**2204**
	PTGNR/L**P / S27		TN**2706**	TN**2706**	TN**2706**	

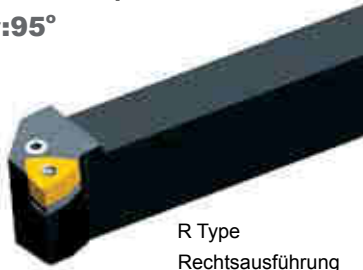
● ex stock · ab Lager ○ on demand · Anfrage

WN** Toolholder · Halter

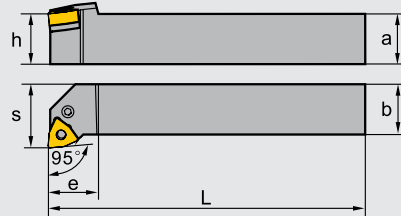
P-Clamping · P-Halter

PWLNLR/ L

Kr:95°














R Type
Rechtsausführung



Type Typ	Stock Lager	Dimension (mm) Abmessung							Screw Schraube	Shim Unterlage	Wrench Schlüssel	Lever Kniehebel	Shim pin Rohrstift	
		R	L	a	b	L	h	s						e
PWLNLR/ L	1616H06	●	●	16	16	100	16	20	20	LEM6×13.4A	W06AP	WH25L	L3	SP3
	2020K06	●	●	20	20	125	20	25	20					
	2525M06	●	●	25	25	150	25	32	20					
	2020K08	●	●	20	20	125	20	25	26	LEM8×21	W08AP	WH30L	L4	SP4
	2525M08	●	●	25	25	150	25	32	26					

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Cast iron machining Grauguss-Bearbeit.	
insert shape Schneidplattenform	DF  A90	PM  A92	DR Double side doppelseitig  A93	Flat Flach  A93	
	SF  A91	DM  A92		TC  A93	
	EF  A91	EM  A92			
	NF  A91	NM  A92			
Type · Typ	PWLNLR/ L**H / K / M06	WN**0604**	WN**0604**	WN**0604**	WN**0604**
	PWLNLR/ L**K / M08	WN**0804**	WN**0804**	WN**0804**	WN**0804**

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

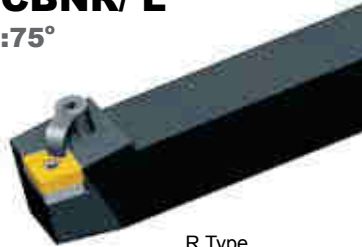
External turning tools · Drehwerkzeuge zur Außenbearbeitung

CN** Toolholder · Halter

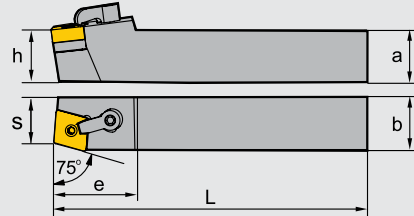
M-Clamping · M-Halter

MCBNR/ L

Kr:75°




















R Type
Rechtsausführung



Type Typ	Stock Lager	Dimension (mm) Abmessung								Clamping screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Clamping stud Passestift
		R	L	a	b	L	h	s	e					
MCBNR/ L	2020K12	●	○	20	20	125	20	17	32	DM6×25				
	2525M12	●	●	25	25	150	20	22	32	DM6×30	C12BM	WH30L	C1RD	TM6×17
	3225P12	●	●	32	25	170	32	22	32	DM6×30				
	2525M16	○	○	25	25	150	25	22	40	DM6×30	C16BM	WH30L	C2RD	TM8×21
	3232P16	●	●	32	32	170	32	27	40	DM6×30				
	3232P19	○	○	32	32	170	32	27	45	DM8×30X	C19BM	WH40L	C5RD	TM10×21
	4040R19	○	○	40	40	200	40	35	45	DM8×30X	C19BM	WH40L	C5RD	TM10×21

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspannung	Cast iron machining Grauguss-Bearbeit.
insert shape Schneidplattenform	DF  A60	PM  A61	DR Double side doppel seitig  A63	HDR  A65	Flat Flach  A66
	SF  A60	DM  A62	DR Single side einseitig  A63	HPR  A65	TC  A63
	EF  A60	EM  A62	ER Double side doppel seitig  A64		
	NF  A61	NM  A63	ER Single side einseitig  A64		
			LR Single side einseitig  A64		
Type · Typ	MCBNR/ L**K / M / P12	CN**1204**	CN**1204**	CN**1204**	CN**1204**
	MCBNR/ L**M / P16	CN**1606**	CN**1606**	CN**1606**	CN**1606**
	MCBNR/ L**P / R19		CN**1906**	CN**1906**	CN**1906**

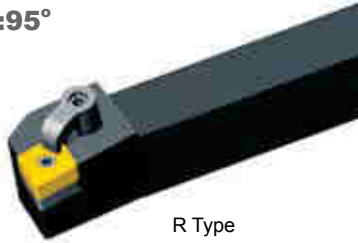
● ex stock · ab Lager ○ on demand · Anfrage

CN** Toolholder · Halter

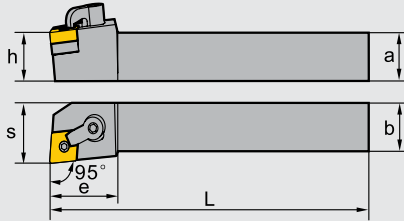
M-Clamping · M-Halter

MCLNR/ L

Kr:95°





















R Type
Rechtsausführung



Type Typ	Stock Lager	Dimension (mm) Abmessung								Clamping screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Clamping stud Passstift
		R	L	a	b	L	h	s	e					
MCLNR/ L	2020K12	●	●	20	20	125	20	25	32	DM6×25				
	2525M12	●	●	25	25	150	25	32	32	DM6×30	C12BM	WH30L	C1RD	TM6×17
	3225P12	●	●	32	25	170	32	32	32					
	2525M16	●	●	25	25	150	25	32	38	DM6×30	C16BM	WH30L	C2RD	TM8×21
	3232P16	●	●	32	32	170	32	40	38					
	3232P19	●	●	32	32	170	32	40	45	DM8×30X	C19BM	WH40L	C5RD	TM10×21
	4040R19	●	○	40	40	200	40	50	45					

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspannung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF  A60	PM  A61	DR Double side doppel seitig  A63	HDR  A65	Flat Flach  A66	Flat Flach  A129
	SF  A60	DM  A62	DR Single side einseitig  A63	HPR  A65	TC  A63	
	EF  A60	EM  A62	ER Double side doppel seitig  A64			
	NF  A61	NM  A63	ER Single side einseitig  A64			
			LR Single side einseitig  A64			
Type · Typ	MCLNR/ L**K / M / P12	CN**1204**	CN**1204**	CN**1204**	CN**1204**	CN**1204**
	MCLNR/ L**M / P16	CN**1606**	CN**1606**	CN**1606**	CN**1606**	CN**1606**
	MCLNR/ L**P / R19		CN**1906**	CN**1906**	CN**1906**	CN**1906**

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

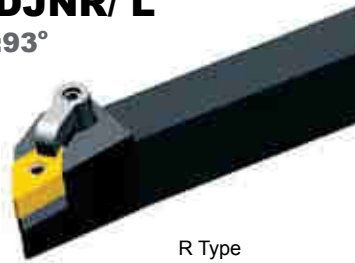
External turning tools · Drehwerkzeuge zur Außenbearbeitung

DN** Toolholder · Halter

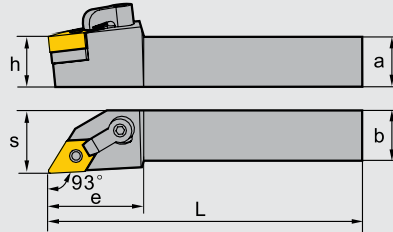
M-Clamping · M-Halter

MDJNR/ L

Kr:93°



















R Type
Rechtsausführung



Type Typ		Stock Lager		Dimension (mm) Abmessung						Clamping screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Clamping stud Passestift
		R	L	a	b	L	h	s	e					
MDJNR/ L	2020K11	●	●	20	20	125	20	25	32	DM6×25	D11BM	WH20L WH30L	C1RD	TM5×13
	2525M11	●	●	25	25	150	25	32	32	DM6×30				
	3225P11	●	○	32	25	170	32	32	32	DM6×30				
	2020K15	●	●	20	20	125	20	25	38	DM6×25	D15BM	WH30L	C2RD	TM6×19
	2525M15	●	●	25	25	150	25	32	38	DM6×30				
	3225P15	●	●	32	25	170	32	32	38	DM6×30				

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspannung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF  A67	PM  A69	DR Double side doppel seitig  A70	HDR  A72	Flat Flach  A71	Flat Flach  A130
	SF  A67	DM  A69	DR Single side einseitig  A72			
	EF  A68	EM  A70	ER Double side doppel seitig  A70			
	NF  A68	NM  A70	ER Single side einseitig  A72			
			LR Single side einseitig  A72			
Type · Typ	MDJNR / L**K / M / P11	DN**1104**	DN**1104**		DN**1104**	
	MDJNR / L**K / M / P15	DN**1506**	DN**1506**	DN**1506**	DN**1506**	DN**1506**

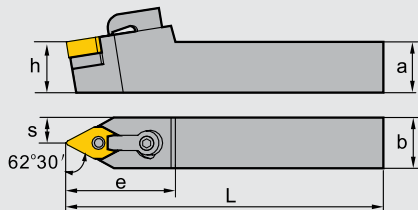
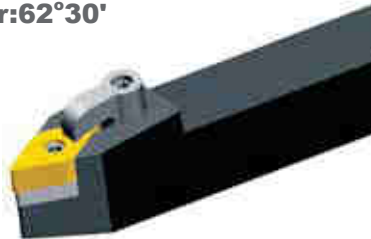
● ex stock · ab Lager ○ on demand · Anfrage

DN** Toolholder · Halter

M-Clamping · M-Halter

















MDPNN

Kr:62°30'



Type Typ	Stock Lager	Dimension (mm) Abmessung							Clamping screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Clamping stud Passtift
		a	b	L	h	s	e						
MDPNN	2020K11	●	20	20	125	20	10	35	DM6×25	D11BM	WH20L WH30L	C1RD	TM5×13
	2525M11	●	25	25	150	25	12.5	35	DM6×30				
	3225P11	●	32	25	170	32	12.5	35	DM6×30				
	2020K15	●	20	20	125	20	10	40	DM6×25	D15BM	WH30L	C2RD	TM6×19
	2525M15	●	25	25	150	25	12.5	40	DM6×30				
	3225P15	●	32	25	170	32	12.5	40	DM6×30				

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspannung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF  A67	PM  A69	DR Double side doppel seitig  A70	HDR  A72	Flat Flach  A71	Flat Flach  A130
	SF  A67	DM  A69	DR Single side einseitig  A72			
	EF  A68	EM  A70	ER Double side doppel seitig  A70			
	NF  A68	NM  A70	ER Single side einseitig  A72			
			LR Single side einseitig  A72			
Type · Typ	MDPNN**K / M / P11	DN**1104**	DN**1104**		DN**1104**	
	MDPNN**K / M / P15	DN**1506**	DN**1506**	DN**1506**	DN**1506**	DN**1506**

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

External turning tools · Drehwerkzeuge zur Außenbearbeitung

SN** Toolholder · Halter

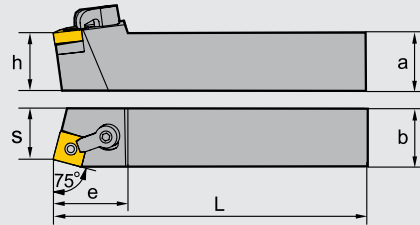
M-Clamping · M-Halter

MSBNR/ L

Kr:75°




















R Type
Rechtsausführung



Type Typ	Stock Lager	Dimension (mm) Abmessung								Clamping screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Clamping stud Passstift
		R	L	a	b	L	h	s	e					
MSBNR/ L	2020K12	●	●	20	20	125	20	17	32	DM6×25	S12BM	WH30L	C1RD	TM6×17
	2525M12	●	○	25	25	150	25	22	32	DM6×30				
	3225P12	●	○	32	25	170	32	22	32	DM6×30				
	2525M15	●	○	25	25	150	25	22	38	DM6×30	S15BM	WH30L	C2RD	TM8×21
	3232P15	●	○	32	32	170	32	29	38					
	4032R15	○	○	40	32	200	40	27	38	DM8×30X	S19BM	WH40L	C5RD	TM10×21
	3232P19	○	○	32	32	170	32	27	45					
	4040R19	○	●	40	40	200	40	35	45					
	4040R25	●	○	40	40	200	40	35	50	DM10×35X	S25BM	WH40L WH40L WH50L	C6RD	TM12×29
4040S2509	○	○	40	40	250	40	35	50						

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspannung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF  A73	PM  A74	DR Double side doppel seitig  A76	HDR  A78	Flat Flach  A80	Flat Flach  A131
	EF  A73	DM  A75	DR Single side einseitig  A77	HPR  A78	TC  A75	
	SF  A74	EM  A75	ER Double side doppel seitig  A76			
		NM  A76	ER Single side einseitig  A78			
			LR Single side einseitig  A77			
Type Typ	MSBNR / L**K / M / P12	SN**1204**	SN**1204**	SN**1204**	SN**1204**	SN**1204**
	MSBNR / L**M / P / R15	SN**1506**	SN**1506**	SN**1506**	SN**1506**	SN**1506**
	MSBNR / L**P / R19		SN**1906**	SN**1906**	SN**1906**	SN**1906**
	MSBNR / L**R / S2509			SN**2509**	SN**2509**	

● ex stock · ab Lager ○ on demand · Anfrage

Turning · Drehen

External turning tools · Drehwerkzeuge zur Außenbearbeitung

SN** Toolholder · Halter

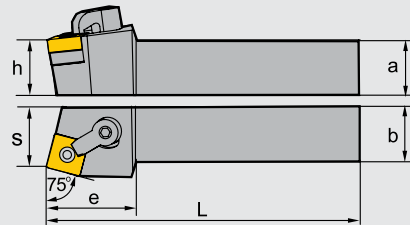
M-Clamping · M-Halter

MSRNR/ L

Kr:75°




















R Type
Rechtsausführung



Type Typ	Stock Lager	Dimension (mm) Abmessung							Clamping screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Clamping stud Passstift	
		R	L	a	b	L	h	s						e
MSRNR/ L	2020K12	●	●	20	20	125	20	22	36	DM6×25	S12BM	WH30L	C1RD	TM6×17
	2525M12	●	●	25	25	150	25	27	36	DM6×30				
	3225P12	●	○	32	25	170	32	27	36	DM6×30				
	2525M15	●	○	25	25	150	25	27	40	DM6×30	S15BM	WH30L	C2RD	TM8×21
	3232P15	●	○	32	32	170	32	35	40					
	4032R15	○	○	40	32	200	40	35	40					
	3232P19	○	○	32	32	170	32	35	45	DM8×30X	S19BM	WH40L	C5RD	TM10×21
	4040R19	○		40	40	200	40	43	45					
	4040R2509	○	○	40	40	200	40	43	50	DM10×35X	S25BM	WH40L WH50L	C6RD	TM12×29
4040S2509	○	○	40	40	250	40	43	50						

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspannung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF  A73	PM  A74	DR Double side doppel seitig  A76	HDR  A78	Flat Flach  A80	Flat Flach  A131
	EF  A73	DM  A75	DR Single side einseitig  A77	HPR  A78	TC  A75	
	SF  A74	EM  A75	ER Double side doppel seitig  A76			
		NM  A76	ER Single side einseitig  A78			
			LR Single side einseitig  A77			
MSRNR / L**K / M / P12	SN**1204**	SN**1204**	SN**1204**	SN**1204**	SN**1204**	SN**1204**
MSRNR / L**M / P / R15	SN**1506**	SN**1506**	SN**1506**	SN**1506**	SN**1506**	SN**1506**
MSRNR / L**P / R19		SN**1906**	SN**1906**	SN**1906**	SN**1906**	
MSRNR / L**R / S2509			SN**2509**	SN**2509**		

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

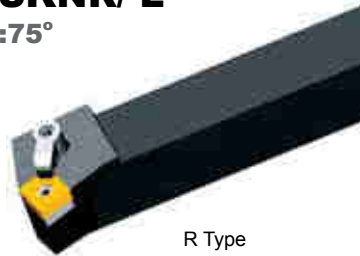
External turning tools · Drehwerkzeuge zur Außenbearbeitung

SN** Toolholder · Halter

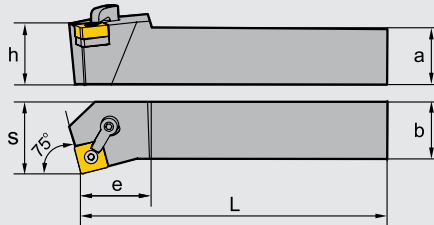
M-Clamping · M-Halter

MSKNR/ L

Kr:75°




















R Type
Rechtsausführung



Type Typ	Stock Lager	Dimension (mm) Abmessung							Clamping screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Clamping stud Passstift	
		R	L	a	b	L	h	s						e
MSKNR/ L	2020K12	●	●	20	20	125	20	25	32	DM6×25	S12BM	WH30L	C1RD	TM6×17
	2525M12	●	●	25	25	150	25	32	32	DM6×30				
	3225P12	●	○	32	25	170	32	32	32	DM6×30	S15BM	WH30L	C2RD	TM8×21
	2525M15	●	○	25	25	150	25	32	28					
	3232P15	●	○	32	32	170	32	40	38	DM8×30X	S19BM	WH40L	C5RD	TM10×21
	4032R15	○	○	40	32	200	40	40	38					
	3232P19	●	○	32	32	170	32	40	45	DM10×35X	S25BM	WH40L WH50L	C6RD	TM12×29
	4040R19	○	○	40	40	200	40	50	45					
4040S2509	○	●	40	40	250	40	50	50						

Applicable insert
Wendeschneidplatten

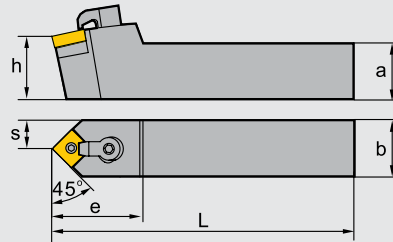
Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspannung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF  A73	PM  A74	DR Double side doppel seitig  A76	HDR  A78	Flat Flach  A80	Flat Flach  A131
	EF  A73	DM  A75	DR Single side einseitig  A77	HPR  A78	TC  A75	
	SF  A74	EM  A75	ER Double side doppel seitig  A76			
		NM  A76	ER Single side einseitig  A78			
			LR Single side einseitig  A77			
Type · Typ	MSKNR / L**K / M / P12	SN**1204**	SN**1204**	SN**1204**	SN**1204**	SN**1204**
	MSKNR / L**M / P / R15	SN**1506**	SN**1506**	SN**1506**	SN**1506**	SN**1506**
	MSKNR / L**P / R19		SN**1906**	SN**1906**	SN**1906**	SN**1906**
	MSKNR / L**S2509		SN**2509**	SN**2509**		

● ex stock · ab Lager ○ on demand · Anfrage

SN** Toolholder · Halter


















M-Clamping · M-Halter

MSDNN Kr:45°



Type Typ	Stock Lager	Dimension (mm) Abmessung							Clamping screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Clamping stud Passstift
		a	b	L	h	s	e						
MSDNN	●	20	20	125	20	10	35	DM6×25	S12BM	WH30L	C1RD	TM6×17	
	●	25	25	150	25	12.5	35						
	●	32	25	170	32	12.5	35	DM6×30	S15BM	WH30L	C2RD	TM8×21	
	●	25	25	150	25	12.5	42						
	○	32	32	170	32	16	42	DM6×30	S15BM	WH30L	C2RD	TM8×21	
	○	40	32	200	40	16	42						

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspannung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF  A73	PM  A74	DR Double side doppel seitig  A76	HDR  A78	Flat Flach  A80	Flat Flach  A131
	EF  A73	DM  A75	DR Single side einseitig  A77	HPR  A78	TC  A75	
	SF  A74	EM  A75	ER Double side doppel seitig  A76			
		NM  A76	ER Single side einseitig  A78			
			LR Single side einseitig  A77			
Type · Typ	MSDNN**K · M · P12	SN**1204**	SN**1204**	SN**1204**	SN**1204**	SN**1204**
	MSDNN**M · P · R15	SN**1506**	SN**1506**	SN**1506**	SN**1506**	SN**1506**

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

External turning tools · Drehwerkzeuge zur Außenbearbeitung

TN** Toolholder · Halter

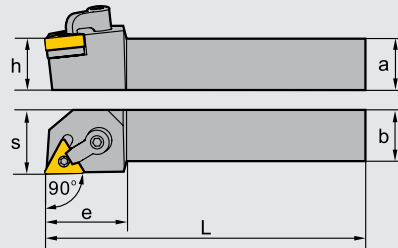
M-Clamping · M-Halter

MTGNR/ L

Kr:90°

















R Type
Rechtsausführung



Type Typ	Stock Lager	Dimension (mm) Abmessung							Clamping screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Clamping stud Passstift	
		R	L	a	b	L	h	s						e
MTGNR/ L	2020K16	●	○	20	20	125	20	25	33	DM6×25	T16BM	WH20L WH30L	C1RD	TM5×13
	2525M16	●	●	25	25	150	25	32	33	DM6×30				
	3225P16	●	○	32	25	170	32	32	33	DM6×30				
	2525M22	●	○	25	25	150	25	32	35	DM6×30	T22BM	WH30L	C2RD	TM6×17
	3225P22	○	○	32	25	170	32	32	35	DM6×30	T22BM	WH30L	C2RD	TM6×17

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspannung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF  A82	PM  A83	DR Double side doppel seitig  A84	HDR  A86	Flat Flach  A87	Flat Flach  A132
	SF  A82	DM  A83	DR Single side einseitig  A85		TC  A84	
	EF  A82	EM  A84	ER Double side doppel seitig  A85			
			LR Single side einseitig  A85			
Type · Typ	MTGNR / L** K / M / P16	TN**1604**	TN**1604**	TN**1604**	TN**1604**	TN**1604**
	MTGNR / L** M / P22	TN**2204**	TN**2204**	TN**2204**	TN**2204**	TN**2204**

● ex stock · ab Lager ○ on demand · Anfrage

TN** Toolholder · Halter

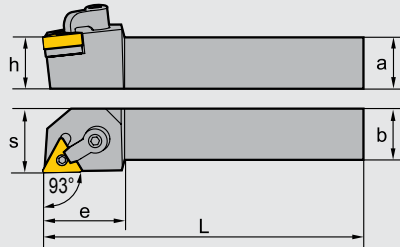
M-Clamping · M-Halter

MTJNR/ L

Kr:93°

















R Type
Rechtsausführung



Type Typ	Stock Lager	Dimension (mm) Abmessung							Clamping screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Clamping stud Passestift	
		R	L	a	b	L	h	s						e
MTJNR/ L	2020K16	●	○	20	20	125	20	25	32	DM6×25	T16BM	WH20L WH30L	C1RD	TM5×13
	2525M16	●	●	25	25	150	25	32	32	DM6×30				
	3225P16	●	●	32	25	170	32	32	32	DM6×30	T22BM	WH30L	C2RD	TM6×17
	2525M22	●	●	25	25	150	25	32	36	DM6×30	T22BM	WH30L	C2RD	TM6×17
	3225P22	○	●	32	25	170	32	32	36	DM6×30	T22BM	WH30L	C2RD	TM6×17

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspannung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF  A82	PM  A83	DR Double side doppel seitig  A84	HDR  A86	Flat Flach  A87	Flat Flach  A132
	SF  A82	DM  A83	DR Single side einseitig  A85		TC  A84	
	EF  A82	EM  A84	ER Double side doppel seitig  A85			
			LR Double side doppel seitig  A85			
Type · Typ	MTJNR / L** K / M / P16	TN**1604**	TN**1604**	TN**1604**	TN**1604**	TN**1604**
	MTJNR / L**M / P22	TN**2204**	TN**2204**	TN**2204**	TN**2204**	TN**2204**

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

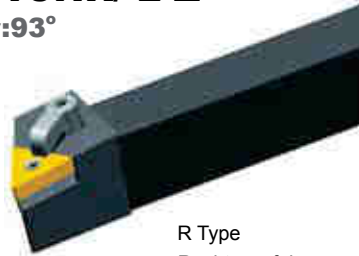
External turning tools · Drehwerkzeuge zur Außenbearbeitung

TN** Toolholder · Halter

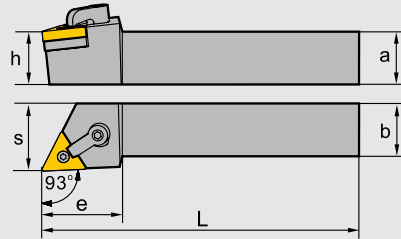
M-Clamping · M-Halter

MTJNR/ L-Z

Kr:93°

















R Type
Rechtsausführung



Type Typ		Stock Lager		Dimension (mm) Abmessung					Clamping screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Clamping stud Passestift	
		R	L	a	b	L	h	s						e
MTJNR/ L	2020K16-Z	●	●	20	20	125	20	25	32	DM6×25	T16BM	WH20L WH30L	C1RD	TM5×13
	2525M16-Z	●	●	25	25	150	25	32	32	DM6×30				
	3225P16-Z	●	●	32	25	170	32	32	32	DM6×30	T22BM	WH30L	C2RD	TM6×17
	2525M22-Z	●	●	25	25	150	25	32	36	DM6×30	T22BM	WH30L	C2RD	TM6×17
	3225P22-Z	○	○	32	25	170	32	32	36	DM6×30	T22BM	WH30L	C2RD	TM6×17

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspannung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	DF  A82	PM  A83	DR Double side doppel seitig  A84	HDF  A86	Flat Flach  A87	Flat Flach  A132
	SF  A82	DM  A83	DR Single side einseitig  A85		TC  A84	
	EF  A82	EM  A84	ER Double side doppel seitig  A85			
			LR Single side einseitig  A85			
Type · Typ	MTJNR / L** K / M / P16	TN**1604**	TN**1604**	TN**1604**	TN**1604**	TN**1604**
	MTJNR / L** M / P22	TN**2204**	TN**2204**	TN**2204**	TN**2204**	TN**2204**

● ex stock · ab Lager ○ on demand · Anfrage

Turning · Drehen

External turning tools · Drehwerkzeuge zur Außenbearbeitung

TN** Toolholder · Halter

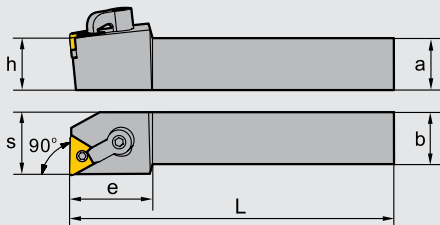
M-Clamping · M-Halter

MTFNR/ L

Kr:90°

















R Type
Rechtsausführung



Type Typ	Stock Lager	Dimension (mm) Abmessung							Clamping screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Clamping stud Passtift	
		R	L	a	b	L	h	s						e
MTFNR/ L	2020K16	●	○	20	20	125	20	25	32	DM6×25	T16BM	WH20L WH30L	C1RD	TM5×13
	2525M16	●	○	25	25	150	25	32	32	DM6×30				
	3225P16	●	○	32	25	170	32	32	32	DM6×30	T22BM	WH30L	C2RD	TM6×17
	2525M22	●	○	25	25	150	25	32	36	DM6×30	T22BM	WH30L	C2RD	TM6×17
	3225P22	●	○	32	25	170	32	32	36	DM6×30	T22BM	WH30L	C2RD	TM6×17

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Heavy Duty Schwerzerspannung	Cast iron machining Grauguss-Bearbeit.	PCBN · PCD PCBN · PKD	
insert shape Schneidplattenform	DF  A82	PM  A83	DR Double side doppel seitig  A84	HDR  A86	Flat Flach  A87	Flat Flach  A132	
	SF  A82	DM  A83	DR Single side einseitig  A85		TC  A84		
	EF  A82	EM  A84	ER Double side doppel seitig  A85				
			LR Double side doppel seitig  A85				
Type · Typ	MTFNR / L** K / M / P16	TN**1604**	TN**1604**	TN**1604**	TN**1604**	TN**1604**	TN**1604**
	MTFNR / L** M / P22	TN**2204**	TN**2204**	TN**2204**	TN**2204**	TN**2204**	TN**2204**

A

General Turning
Allgemeine Drehbearbeitung

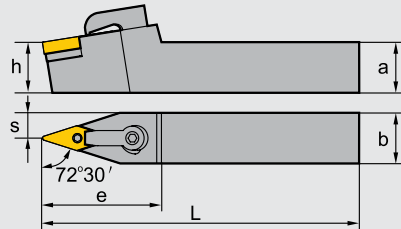
Turning · Drehen

External turning tools · Drehwerkzeuge zur Außenbearbeitung

VN** Toolholder · Halter




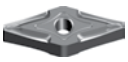





M-Clamping · M-Halter

MVVNN Kr:72°30'



Type Typ	Stock Lager	Dimension (mm) Abmessung							Clamping screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Clamping stud Passstift
		a	b	L	h	s	e						
MVVNN	2020K16	●	20	20	125	20	10	45	DM6×25	V16BM	WH20L WH30L	C3RD	TM5×13
	2525M16	●	25	25	150	25	12.5	45	DM6×30				
	3225P16	○	32	25	170	32	12.5	45		DM6×30			
	3232P16	●	32	32	170	32	16	45	DM6×30				

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere-Bearbeitung	PCBN · PCD PCBN · PKD	
insert shape Schneidplattenform	DF  A88	PM  A89	Flat Flach  A133	
	EF  A88	DM  A89		
	SF  A88	EM  A89		
	NF  A88	NM  A89		
Type · Typ	MVVNN** K / M / P16	VN**1604**	VN**1604**	VN**1604**

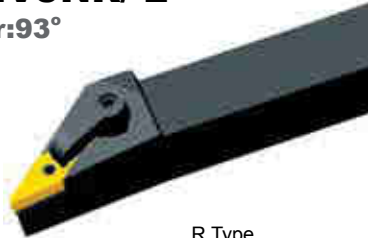
● ex stock · ab Lager ○ on demand · Anfrage

VN** Toolholder · Halter

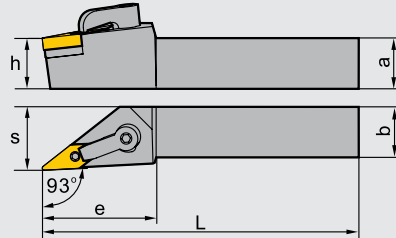
M-Clamping · M-Halter

MVJNR/ L

Kr:93°



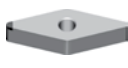
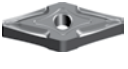







R Type
Rechtsausführung



Type Typ	Stock Lager	Dimension (mm) Abmessung							Clamping screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Clamping stud Passestift	
		R	L	a	b	L	h	s						e
MVJNR/ L	2020K16	●	●	20	20	125	20	25	45	DM6×25	V16BM	WH20L WH30L	C3RD	TM5×13
	2525M16	●	●	25	25	150	25	32	45					
	3225P16	●	●	32	25	170	32	32	45	DM6×30				
	3232P16	●	●	32	32	170	32	40	45					

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	PCBN · PCD PCBN · PKD	
insert shape Schneidplattenform	DF  A88	PM  A89	Flat Flach  A133	
	EF  A88	DM  A89		
	SF  A88	EM  A89		
	NF  A88	NM  A89		
Type · Typ	MVJNR / L** K / M / P16	VN**1604**	VN**1604**	VN**1604**

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

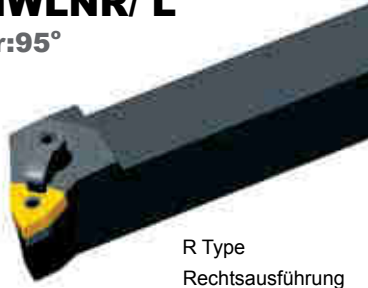
External turning tools · Drehwerkzeuge zur Außenbearbeitung

WN** Toolholder · Halter

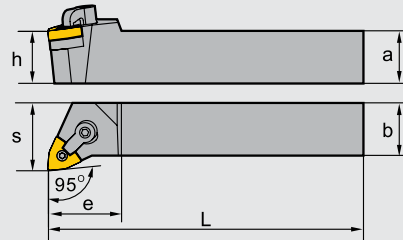
M-Clamping · M-Halter

MWLNLR/ L

Kr:95°














R Type
Rechtsausführung



Type Typ		Stock Lager		Dimension (mm) Abmessung						Clamping screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Clamping stud Passestift
		R	L	a	b	L	h	s	e					
MWLNLR/ L	2020K06	●	●	20	20	125	20	25	30	DM6×25	W06BM	WH20L WH30L	C1RD	TM5×13
	2525M06	●	●	25	25	150	25	32	30	DM6×30				
	2020K08	●	●	20	20	125	20	25	30	DM6×25				
	2525M08	●	●	25	25	150	25	32	35	DM6×30	W08BM	WH30L	C1RD	TM6×17
	3525P08	○	○	32	25	170	32	32	35					
	3232P08	●	●	32	32	170	32	40	35					

Applicable insert
Wendeschneidplatten

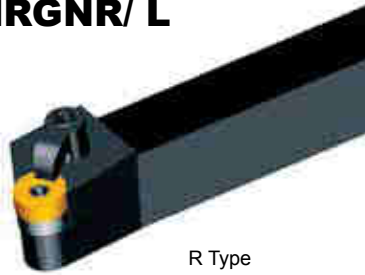
Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Cast iron machining Grauguss-Bearbeit.	
insert shape Schneidplattenform	DF  A90	PM  A92	DR Double side doppel seitig  A93	Flat Flach  A93	
	SF  A91	DM  A92		TC  A93	
	EF  A91	EM  A92			
	NF  A91	NM  A92			
Type · Typ	MWLNLR / L**K / M06	WN**0604**	WN**0604**	WN**0604**	WN**0604**
	MWLNLR / L**K / M / P08	WN**0804**	WN**0804**	WN**0804**	WN**0804**

● ex stock · ab Lager ○ on demand · Anfrage

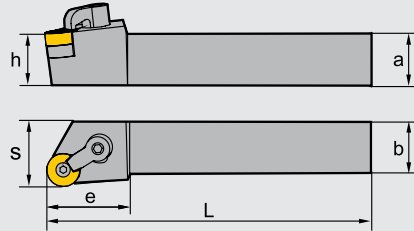
RN** Toolholder · Halter

M-Clamping · M-Halter

MRGNR/ L



R Type
Rechtsausführung

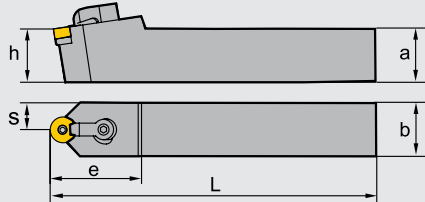


Type Typ	Stock Lager	Dimension (mm) Abmessung							Application inserts Wendeschneid- platten	Clamping Screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Clamping stud Passtift	
		R	L	a	b	L	h	s							e
MRGNR/ L	2020K12	○	○	20	20	125	20	25	32	RN**1204** A94	DM6×25	R12BM	WH30L	C1RD	TM6×17
	2525M12	○	●	25	25	150	25	32	32		DM6×30				
	3225P12	○	○	32	25	170	32	32	32						
	3232P12	○	○	32	32	170	32	40	32						

RN** Toolholder · Halter

M-Clamping · M-Halter

MRDNN



Type Typ	Stock Lager	Dimension (mm) Abmessung							Application inserts Wendeschneid- platten	Clamping screw Schraube	Shim Unterlage	Wrench Schlüssel	Clamp Pratze	Clamping stud Passtift
		a	b	L	h	s	e							
MRDNN	2020K12	○	20	20	125	20	10	35	RN**1204** A94	DM6×25	R12BM	WH30L	C1RD	TM6×17
	2525M 12	○	25	25	150	25	12.5	35		DM6×30				
	3225P12	○	32	25	170	32	12.5	35						
	3232P12	○	32	32	170	32	16	35						

Turning · Drehen

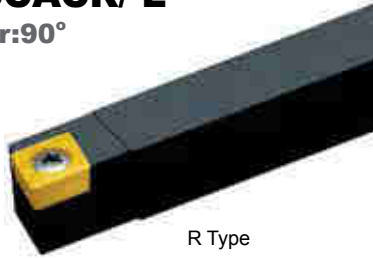
External turning tools · Drehwerkzeuge zur Außenbearbeitung

CC** Toolholder · Halter

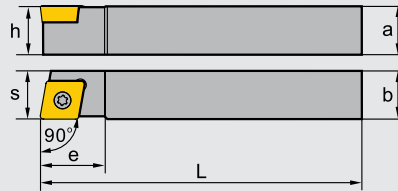
S-Clamping · S-Halter

SCACR/ L

Kr:90°













R Type
Rechtsausführung



Type Typ	Stock Lager	Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel			
		R	L	a	b	L	h	s					e
SCACR/ L	1010E06	●	●	10	10	70	10	10.5	10	I60M2.5×6.5	WT07IP		
	1212F09	●	●	12	12	80	12	12.7	16	I60M3.5×8	WT15IP		

Applicable insert
Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schlichten	Semi-finishing Mittlere Bearbeit.	Roughing Schruppen	Al machining Alu-Bearbeitung	Cast iron machining Grauguss-Bearbeit.	PCBN/PCD inserts/WSP
insert shape Schneidplattenform	SF  A98	HF  A98	HM  A99	HR  A100	LH  A100	 A100	 A134
		EF  A99	EM  A99		LC  A100		
Type · Typ	SCACR/ L**E06	CC**0602**	CC**0602**	CC**0602**	CC**0602**	CCGX 0602**	CC** 0602**
	SCACR/ L**F09	CC**09T3**	CC**09T3**	CC**09T3**	CC**09T3**	CCGX 09T3**	CC** 09T3**

● ex stock · ab Lager ○ on demand · Anfrage

CC** Toolholder · Halter

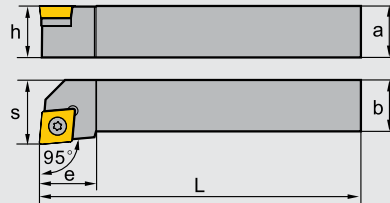
S-Clamping · S-Halter

SCLCR/ L

Kr:95°













R Type
Rechtsausführung



Type Typ		Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel
		R	L	a	b	L	h	s	e				
SCLCR/ L	0808D06	●	●	08	08	60	08	10	10	I60M2.5×6.5	—	—	WT07IP
	1010E06	●	●	10	10	70	10	12	10				
	1212F09	●	●	12	12	80	12	16	16				
	1616H09	●	●	16	16	100	16	20	16	I60M3.5×8	—	—	WT15IP
	1616H12	●	○	16	16	100	16	20	18				
	2020K09	●	●	20	20	125	20	25	25	I60M4×11X	C12BS	SM6×10XA	WT15IP WH40L
	2020K12	●	●	20	20	125	20	25	25				
	2525M12	●	●	25	25	150	25	32	26				
	3225P12	●	●	32	25	170	32	32	26				
	3232P12	●	○	32	32	170	32	40	28				

Applicable insert
Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schlichten	Semi-finishing Mittlere Bearbeit.	Roughing Schruppen	Al machining Alu-Bearbeitung	Cast iron mach. Grauguss- Bearbeitung	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	SF  A98	HF  A98	HM  A99	HR  A100	LH  A100	Flat Flach  A100	Flat Flach  A134
		EF  A99	EM  A99		LC  A100		
Type · Typ	SCLCR/ L**D / E06	CC** 0602**	CC** 0602**	CC** 0602**	CC** 0602**	CCGX 0602**	CC** 0602**
	SCLCR / L*F / H09	CC** 09T3**	CC** 09T3**	CC** 09T3**	CC** 09T3**	CCGX 09T3**	CC** 09T3**
	SCLCR / L**K / M / P12		CC** 1204**	CC** 1204**	CC** 1204**	CCGX 1204**	CC** 1204**

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

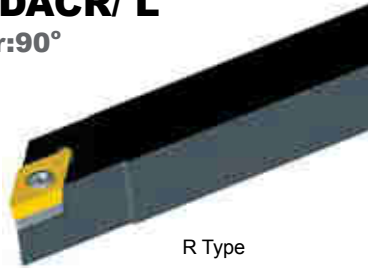
External turning tools · Drehwerkzeuge zur Außenbearbeitung

DC** Toolholder · Halter

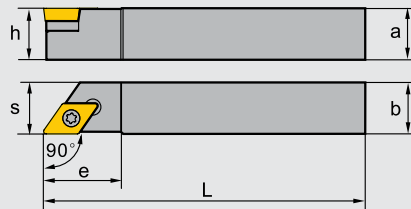
S-Clamping · S-Halter

SDACR/ L

Kr:90°













R Type
Rechtsausführung



Type Typ		Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel
		R	L	a	b	L	h	s	e				
SDACR/ L	1010E07	●	●	10	10	70	10	10.5	15	I60M2.5×6.5	—	—	WT07IP
	1212F11	●	●	12	12	80	12	12.5	15	I60M3.5×8	—	—	WT15IP
	1616H11	●	●	16	16	100	16	16.7	24	I60M3.5×12	D11BS	SM5×8.65XA	WT15IP WH35L

Applicable insert
Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schlichten	Semi-finishing Mittlere Bearbeit.	Roughing Schruppen	Al machining Alu-Bearbeitung	Cast iron mach. Grauguss- Bearbeitung	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	SF  A102	HF  A102	HM  A103	HR  A104	LH  A104	Flat Flach  A104	Flat Flach  A135
		EF  A103	EM  A103		LC  A104		
Type · Typ	SDACR / L**E07	DC** 0702**	DC** 0702**	DC** 0702**		DCGX 0702**	DC**0702**
	SDACR / L**F / H11	DC** 11T3**	DC** 11T3**	DC** 11T3**	DC** 11T3**	DCGX 11T3**	DC** 11T3**

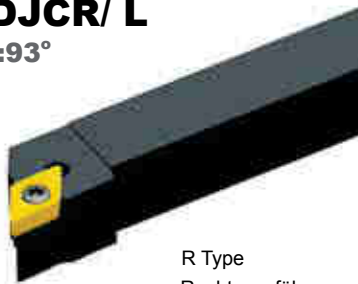
● ex stock · ab Lager ○ on demand · Anfrage

DC** Toolholder · Halter

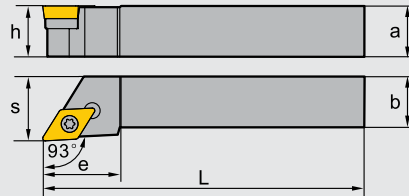
S-Clamping · S-Halter

SDJCR/ L

Kr:93°









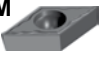



R Type
Rechtsausführung



Type Typ		Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel
		R	L	a	b	L	h	s	e				
SDJCR/ L	1010E07	●	●	10	10	70	10	12	15	I60M2.5×6.5	—	—	WT07IP
	1212F07	●	●	12	12	80	12	16	15				
	1616H07	●	●	16	16	100	16	20	18				
	1616H11	●	●	16	16	100	16	20	24	I60M3.5×12	D11BS	SM5×8.65XA	WT15IP WH35L
	2020K11	●	●	20	20	125	20	25	24				
	2525M11	●	●	25	25	150	25	32	29				
	3225P11	●	●	32	25	170	32	32	29				

Applicable insert
Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schlichten	Semi-finishing Mittlere Bearbeit.	Roughing Schruppen	Al machining Alu-Bearbeitung	Cast iron mach. Grauguss- Bearbeitung	PCBN · PCD PCBN · PKD	
insert shape Schneidplattenform	SF  A102	HF  A102	HM  A103	HR  A104	LH  A104	Flat Flach  A104	Flat Flach  A135	
		EF  A103	EM  A103		LC  A104			
Type · Typ	SDJCR / L**E / F / H07	DC**0702**	DC** 0702**	DC**0702**		DCGX 0702**	DC** 0702**	DC** 0702**
	SDJCR / L**H / K / M / P11	DC** 11T3**	DC** 11T3**	DC**11T3**	DC**11T3**	DCGX 11T3**	DC** 11T3**	DC** 11T3**

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

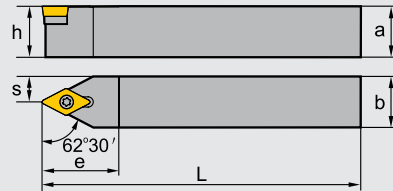
External turning tools · Drehwerkzeuge zur Außenbearbeitung

DC** Toolholder · Halter

S-Clamping · S-Halter









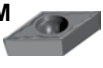

SDNCN

Kr:62°30'



Type Typ	Stock Lager	Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel	
		a	b	L	h	s	e					
SDNCN	1010E07	●	10	10	70	10	5	20	I60M2.5×6.5	—	—	WT07IP
	1212F07	●	12	12	80	12	6	20				
	1212H11	●	12	12	100	12	6	30				
	1616H11	●	16	16	100	16	8	30	I60M3.5×12	D11BS	SM5×8.65XA	WT15IP WH35L
	2020K11	●	20	20	125	20	10	30				
	2525M11	●	25	25	150	25	12.5	30				

Applicable insert
Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schlichten	Semi-finishing Mittlere Bearbeit.	Roughing Schruppen	Al machining Alu-Bearbeitung	Cast iron mach. Grauguss- Bearbeitung	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	SF  A102	HF  A102	HM  A103	HR  A104	LH  A104	Flat Flach  A104	Flat Flach  A135
		EF  A103	EM  A103		LC  A104		
Type · Typ	SDNCN**E / F07	DC**0702**	DC**0702**	DC**0702**	DCGX 0702**	DC**0702**	DC**0702**
	SDNCN**H / K / M11	DC**11T3**	DC**11T3**	DC**11T3**	DCGX 11T3**	DC**11T3**	DC**11T3**

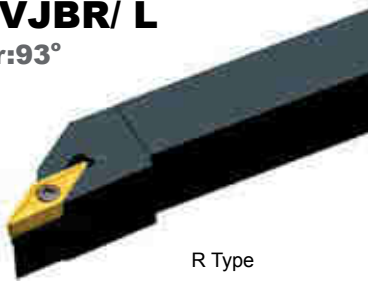
● ex stock · ab Lager ○ on demand · Anfrage

VB** Toolholder · Halter

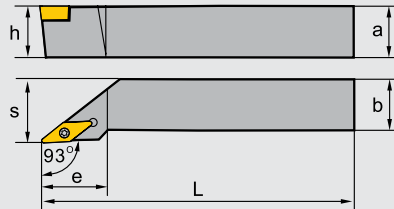
S-Clamping · S-Halter

SVJBR/ L

Kr:93°








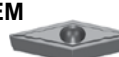



R Type
Rechtsausführung



Type Typ		Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel
		R	L	a	b	L	h	s	e				
SVJBR/ L	1212F11	●	●	12	12	80	12	16	27	I60M2.5×6.5	—	—	WT07IP
	1616H11	●	●	16	16	100	16	20	27				
	2020K11	●	●	20	20	125	20	25	27				
	2525M11	●	●	25	25	150	25	32	27				
	1616H16	●	●	16	16	100	16	20	36	I60M3.5×12	V16BS	SM5×8.65XA	WT15IP WH35L
	2020K16	●	●	20	20	125	20	25	41				
	2525M16	●	●	25	25	150	25	32	41				
	3225P16	●	●	32	25	170	32	32	41				

Applicable insert
Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schlichten	Semi-finishing Mittlere Bearbeit.	Roughing Schruppen	Cast iron mach. Grauguss-Bearb.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	SF  A120	EF  A120	HM  A121	HR  A121	Flat Flach  A121	Flat Flach  A137
		HF  A120	EM  A121			
		NF  A120				
Type · Typ	SVJBR/L**F/H/K/M11	VB**1102**	VB**1102**	VB**1102**		
	SVJBR/L**H/K/M/P16		VB**1604**	VB**1604**	VB**1604**	VB**1604**

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

External turning tools · Drehwerkzeuge zur Außenbearbeitung

VB** Toolholder · Halter

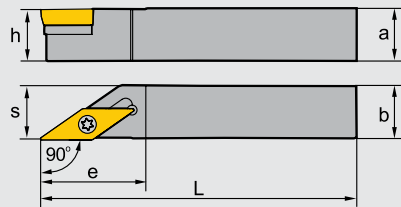
S-Clamping · S-Halter

SVABR/ L

Kr:90°


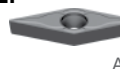



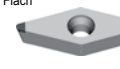

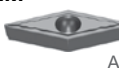



R Type
Rechtsausführung



Type Typ		Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel
		R	L	a	b	L	h	s	e				
SVABR/ L	1010F11			10	10	80	10	-	-	I60M2.5×6.5	—	—	WT071P
	1616H16	●	●	16	16	100	16	16.5	28	I60M3.5×12	V16BS	SM5×8.65XA	WT151P WH35L
	2020K16	●	○	20	20	125	20	20.5	28				
	2525M16	●	●	25	25	150	25	25.5	28				

Applicable insert
Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schlichten	Semi-finishing Mittlere Bearbeit.	Roughing Schruppen	Cast iron mach. Grauguss-Bearb.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	SF  A120	EF  A120	HM  A121	HR  A121	Flat Flach  A121	Flat Flach  A137
		HF  A120	EM  A121			
		NF  A120				
Type · Typ	SVABR / L**F11	VB**1102**	VB**1102**	VB**1102**		
	SVABR / L**H / K / M16		VB**1604**	VB**1604**	VB**1604**	VB**1604**

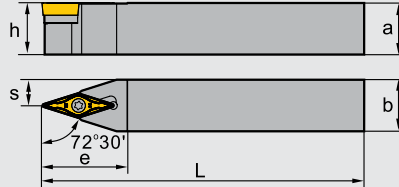
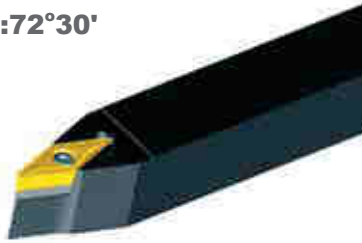
● ex stock · ab Lager ○ on demand · Anfrage

VB** Toolholder · Halter

S-Clamping · S-Halter






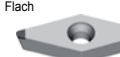



SVVBN

Kr:72°30'



Type Typ		Stock Lager	Dimension (mm) Abmessung					Screw Schraube	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel	
			a	b	L	h	s					e
SVVBN	1212F11	●	12	12	80	12	6	27	I60M2.5×6.5	—	—	WT07IP
	1616H11	●	16	16	100	16	8	27				
	2020K11	●	20	20	125	20	10	30				
	1616H16	●	16	16	100	16	8	33	I60M3.5×12	V16BS	SM5×8.65XA	WT15IP WH35L
	2020K16	●	20	20	125	20	10	33				
	2525M16	●	25	25	150	25	12.5	38				

Applicable insert
Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schlichten	Semi-finishing Mittlere Bearbeit.	Roughing Schruppen	Cast iron mach. Grauguss-Bearb.	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	SF  A120	EF  A120	HM  A121	HR  A121	 Flat Flach A121	 Flat Flach A137
		HF  A120	EM  A121			
		NF  A120				
Type · Typ	SVVBN**F / H / K11	VB**1102**	VB**1102**	VB**1102**		
	SVVBN**H / K / M16		VB**1604**	VB**1604**	VB**1604**	VB**1604**

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

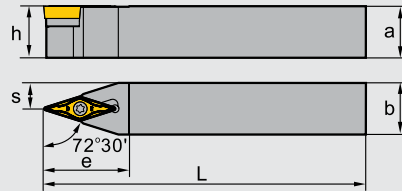
External turning tools · Drehwerkzeuge zur Außenbearbeitung

VC** Toolholder · Halter

S-Clamping · S-Halter







SVVCN

Kr:72°30'



Type Typ		Stock Lager	Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel
			a	b	L	h	s	e				
SVVCN	1212F11	●	12	12	80	12	6	27	I60M2.5×6.5	—	—	WT071P
	1212M11	●	12	12	150	12	6	27				
	1616H11	●	16	16	100	16	8	27				
	2020K11	●	20	20	125	20	10	30				
	2525M11	●	25	25	150	25	12.5	38				
	1616H16	●	16	16	100	16	8	33				
	2020K16	●	20	20	125	20	10	33	I60M3.5×12	V16BSC	SM5×8.65XA	WT151P WH35L
	2525M16	●	25	25	150	25	12.5	38				

Applicable insert
Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schlichten	Al machining Alu-Bearbeitung	PCBN · PCD PCBN · PKD
insert shape Schneidplattenform	SF  A118	HF  A118	LH  A119	Flat Flach  A137
		NF  A118	LC  A119	
Type · Typ	SVVCN**F / H / K / M11	VC**1103**	VC**1103**	VCGX1103**
	SVVCN**H / K / M16		VC**1604**	VCGX1604**
				VC**1604**

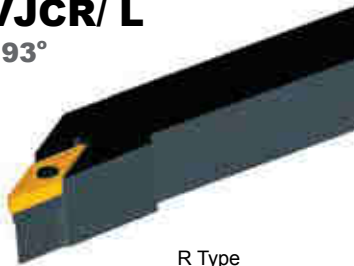
● ex stock · ab Lager ○ on demand · Anfrage

VC** Toolholder · Halter

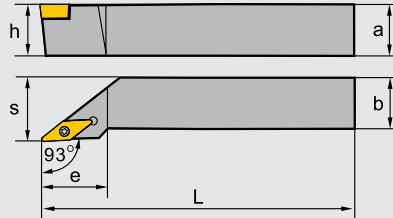
S-Clamping · S-Halter

SVJCR/ L

Kr:93°









R Type
Rechtsausführung



Type Typ		Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel
		R	L	a	b	L	h	s	e				
SVJCR/ L	1010E11			10	10	70	10	12	22	I60M2.5×6.5	—	—	WT071P
	1212F11	●	●	12	12	80	12	16	27				
	1616H11	●	●	16	16	100	16	20	27				
	2020K11	●	●	20	20	125	20	25	27				
	2525M11	●	●	25	25	150	25	32	27				
	1616H16	●	●	16	16	100	16	20	36	I60M3.5×12	V16BSC	SM5×8.65XA	WT151P WH35L
	2020K16	●	●	20	20	125	20	25	41				
	2020M16	●	●	20	20	150	20	25	41				
	2525M16	●	●	25	25	150	20	32	41				
3225P16			32	25	170	32	32	41					

Applicable insert
Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schichten	Al machining Alu-Bearbeitung	PCBN · PCD PCBN · PKD	
insert shape Schneidplattenform	SF  A118	HF  A118	LH  A119	Flat Flach  A137	
		NF  A118	LC  A119		
Type · Typ	SVJCR/ L**E/ F/ H/ K/ M11	VC**1103**	VC**1103**	VCGX1103**	
	SVJCR/ L**H/ K/ M/ P16		VC**1604**	VCGX1604**	VC**1604**

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

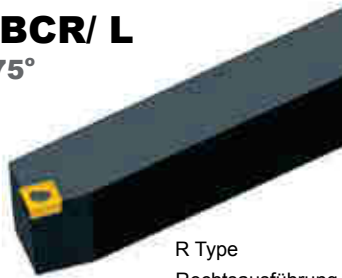
External turning tools · Drehwerkzeuge zur Außenbearbeitung

SC** Toolholder · Halter

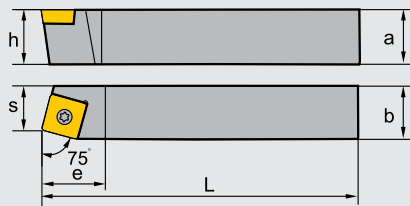
S-Clamping · S-Halter

SSBCR/ L

Kr:75°



R Type
Rechtsausführung



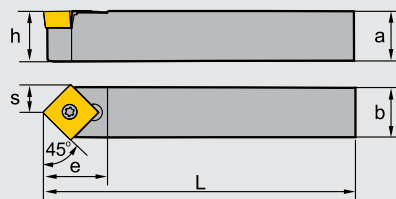
Type Typ	Stock Lager	Dimension (mm) Abmessung							Screw Schraube	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel	
		R	L	a	b	L	h	s					e
SSBCR/ L	1212F09	●	●	12	12	80	12	11	16	I60M3.5×8	—	—	WT151P
	1616H09	●	●	16	16	100	16	13	16	I60M3.5×8	S09BS	SM5×8.65XA	WT151P WH35L
	2020K12	●	●	20	20	125	20	17	25	I60M4×11X	S12BS	SM6×10XA	WT151P WH40L

SC** Toolholder · Halter

S-Clamping · S-Halter









SSDCN

Kr:45°



Type Typ	Stock Lager	Dimension (mm) Abmessung							Screw Schraube	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel
		a	b	L	h	s	e					
SSDCN	1212F09	●	12	12	80	12	6	15.5	I60M3.5×8	—	—	WT151P
	1616H09	●	16	16	100	16	8	15.5	I60M3.5×12	S09BS	SM5×8.65XA	WT151P WH35L

Applicable insert
Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schlichten	Semi-finishing Mittlere Bearbeit.	Al machining Alu-Bearbeitung	Cast iron machining Grauguss-Bearbeit.
insert shape Schneidplattenform	HF  A108	HM  A108	HR  A109	LH  A109	Flat Flach  A109
	EF  A108	EM  A108		LC  A109	
Type · Typ	SSBCR / L**F / H09	SSDCN**F / H09	SSBCR / L**K12	SSDCN**F / H09	
	SC**09T3**	SC**09T3**	SC**1204**	SC**09T3**	SC**09T3**

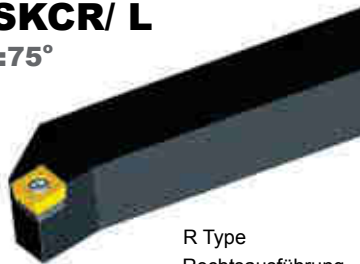
● ex stock · ab Lager ○ on demand · Anfrage

SC** Toolholder · Halter

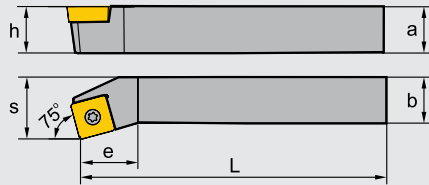
S-Clamping · S-Halter

SSKCR/ L

Kr:75°



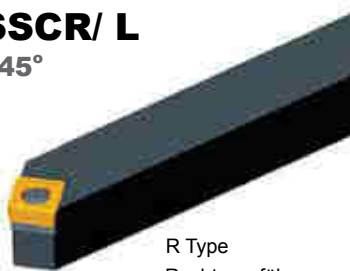
R Type
Rechtsausführung



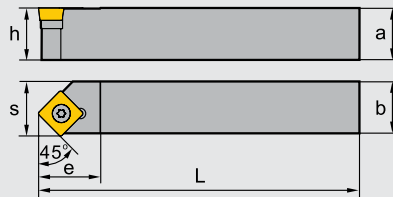
Type Typ		Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel
		R	L	a	b	L	h	s	e				
SSKCR/ L	1616H09	●	●	16	16	100	16	20	13				
										I60M3.5×12	S09BS	SM5×8.65XA	WT15IP WH35L

SSSCR/ L

Kr:45°



R Type
Rechtsausführung



Type Typ		Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel
		R	L	a	b	L	h	s	e				
SSSCR/ L	1616H09	●	●	16	16	100	16	17	16		—	—	
	2020K12	●	●	20	20	125	20	21	24	I60M4×11X	S12BS	SM6×10XA	WT15IP WH40L

Applicable insert Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schlichten	Semi-finishing Mittlere Bearbeit.	Al machining Alu-Bearbeitung	Cast iron machining Grauguss-Bearbeit.
insert shape Schneidplattenform	HF A108	HM A108	HR A109	LH A109	Flat Flach A109
	EF A108	EM A108		LC A109	
Type · Typ	SSKCR / L**H09	SC**09T3**	SC**09T3**	SC**09T3**	SCG09T3**
	SSSCR / L**H09	SC**09T3**	SC**09T3**	SC**09T3**	SCG09T3**
	SSSCR / L**K12		SC**1204**	SC**1204**	SCG1204**

Turning · Drehen

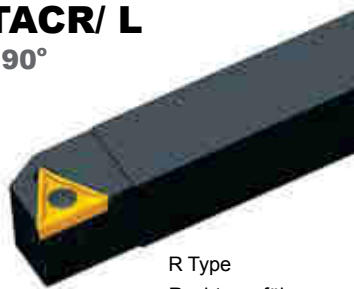
External turning tools · Drehwerkzeuge zur Außenbearbeitung

TC** Toolholder · Halter

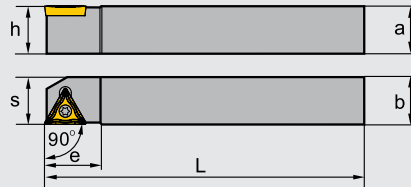
S-Clamping · S-Halter

STACR/ L

Kr:90°



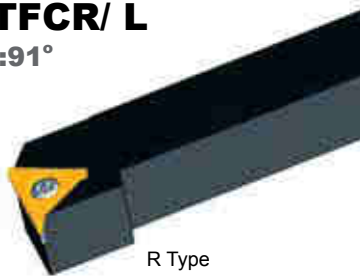
R Type
Rechtsausführung



Type Typ	Stock Lager	Dimension (mm) Abmessung								Screw Schraube	Wrench Schlüssel		
		R	L	a	b	L	h	s	e				
STACR/ L	1212F11	●	●	12	12	80	12	12.5	14	I60M2.5×6.5	WT07IP		

STFCR/ L

Kr:91°













R Type
Rechtsausführung



Type Typ	Stock Lager	Dimension (mm) Abmessung								Screw Schraube	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel
		R	L	a	b	L	h	s	e				
STFCR/ L	1212F11	●	○	12	12	80	12	16	14	I60M2.5×6.5	—	—	WT07IP
	1616H11	●	○	16	16	100	16	20	14				
	1616H16	●	○	16	16	100	16	20	19	I60M3.5×12	T16BS	SM5×8.65XA	WT15IP WH35L
	2020K16	●	●	20	20	125	20	25	19				

Applicable insert
Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schlichten	Semi-finishing Mittlere Bearbeit.	Roughing Schruppen	Al machining Alu-Bearbeitung	Cast iron machining	PCBN/PCD inserts/WSP
insert shape Schneidplattenform	SF  A112	HF  A113	HM  A115	HR  A115	LH  A116	Flat Flach  A115	Flat Flach  A136
		EF  A114	EM  A114		LC  A116		
Type · Typ	STACR/ L**F11	TC**1102**	TC**1102**	TC**1102**	TC**1102**	TCGX1102**	TC**1102**
	STFCR/ L**F/ H11	TC**1102**	TC**1102**	TC**1102**	TC**1102**	TCGX1102**	TC**1102**
	STFCR/ L**H/ K16		TC**16T3**	TC**16T3**	TC**16T3**	TCGX16T3**	TC**16T3**

● ex stock · ab Lager ○ on demand · Anfrage

TC** Toolholder · Halter

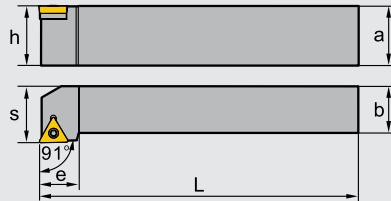
S-Clamping · S-Halter

STGCR/ L

Kr:91°













R Type
Rechtsausführung



Type Typ		Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel
		R	L	a	b	L	h	s	e				
STGCR/ L	0808D09	●	●	08	08	60	8	10	11	I60M2.2×5.5	—	—	WT06IP
	1010E09	●	●	10	10	70	10	12	11				
	1212F11	●	●	12	12	80	12	16	14				
	1616H11	●	●	16	16	100	16	20	16	I60M2.5×6.5	—	—	WT07IP
	2020K16	●	●	20	20	125	20	25	21				
	2525M16	●	●	25	25	150	25	25	21	I60M3.5×12	T16BS	SM5×8.65XA	WT15IP WH35L

Applicable insert
Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schlichten	Semi-finishing Mittlere Bearbeit.	Roughing Schruppen	Al machining Alu-Bearbeitung	Cast iron machining	PCBN/PCD inserts/WSP	
insert shape Schneidplattenform	SF  A112	HF  A113	HM  A115	HR  A115	LH  A116	Flat Flach  A115	Flat Flach  A136	
		EF  A114	EM  A114		LC  A116			
Type · Typ	STGCR / L**D / E09	TC**0902**	TC**0902**	TC**0902**	TC**0902**	TCGX0902**	TC**0902**	TC**0902**
	STGCR / L**F / H11	TC**1102**	TC**1102**	TC**1102**	TC**1102**	TCGX1102**	TC**1102**	TC**1102**
	STGCR / L**K / M16		TC**16T3**	TC**16T3**	TC**16T3**	TCGX16T3**	TC**16T3**	TC**16T3**

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

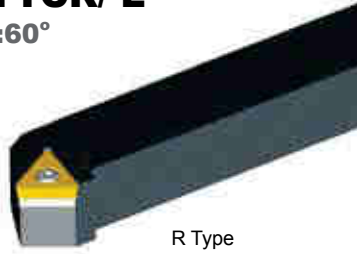
External turning tools · Drehwerkzeuge zur Außenbearbeitung

TC** Toolholder · Halter

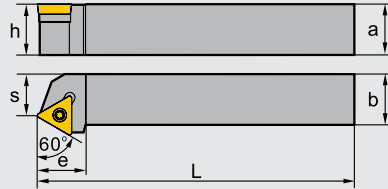
S-Clamping · S-Halter

STTCR/ L

Kr:60°













R Type
Rechtsausführung



Type Typ		Stock Lager		Dimension (mm) Abmessung						Screw Schraube	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel
		R	L	a	b	L	h	s	e				
STTCR/ L	1616H11	●	○	16	16	100	16	13	14	I60M2.5×6.5	—	—	WT07IP
	1616H16	●	●	16	16	100	16	13	19	I60M3.5×12	T16BS	SM5×8.65XA	WT15IP
	2020K16	●	●	20	20	125	20	17	19				WH35L

Applicable insert
Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schlichten	Semi-finishing Mittlere Bearbeit.	Roughing Schruppen	Al machining Alu-Bearbeitung	Cast iron machining	PCBN/PCD inserts/WSP	
insert shape Schneidplattenform	SF  A112	HF  A113	HM  A115	HR  A115	LH  A116	Flat Flach  A115	Flat Flach  A136	
		EF  A114	EM  A114		LC  A116			
Type · Typ	STTCR / L**H11	TC**1102**	TC**1102**	TC**1102**	TC**1102**	TCGX1102**	TC**1102**	TC**1102**
	STTCR / L**H / K16		TC**16T3**	TC**16T3**	TC**16T3**	TCGX16T3**	TC**16T3**	TC**16T3**

● ex stock · ab Lager ○ on demand · Anfrage

WC** Toolholder · Halter

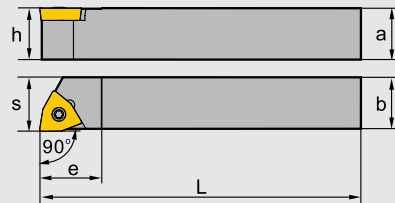
S-Clamping · S-Halter



SWACR/ L

Kr:90°



R Type
Rechtsausführung



Type Typ	Stock Lager	Dimension (mm) Abmessung								Screw Schraube	Wrench Schlüssel		
		R	L	a	b	L	h	s	e				
SWACR/ L	1010E04	●	●	10	10	70	10	10.5	10	I60M2.5×6.5	WT07IP		
	1212F04	●	●	12	12	80	12	12.0	14				
	1616H06	●	●	16	16	100	16	16.5	20	I60M3×7	WT10IP		
	2020K08	●	●	20	20	125	20	20.5	24	I60M3.5×12	WT15IP		

Applicable insert
Wendeschneidplatten

Application
Anwendung

Finishing
Schlichten

insert shape
Schneidplattenform

53



A112

Type · Typ		
SWACR / L**E / F04		WC*X0402**
SWACR / L**H06		WC*X06T3**
SWACR / L**K08		WC*X0804**

A

General Turning
Allgemeine Drehbearbeitung

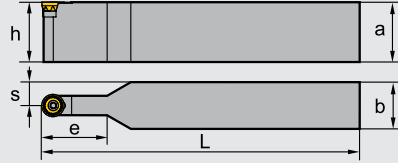
Turning · Drehen

External turning tools · Drehwerkzeuge zur Außenbearbeitung

RC** Toolholder · Halter



S-Clamping · S-Halter

SRDCN



Type Typ	Stock Lager	Dimension (mm) Abmessung							Screw Schraube	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel
		a	b	L	h	s	e					
SRDCN	1616H08	○	16	16	100	16	8	16	I60M3×7	—	—	WT10IP
	2020K08	●	20	20	125	20	10	16	I60M3.5×10	—	—	WT15IP
	2020K10	●	20	20	125	20	10	25				
	2525M10	●	25	25	150	25	12.5	25				
	2020K12	●	20	20	125	20	10	35	I60M3.5×12	R12BS	SM5×8.65XA	WT15IP WH35L
	2525M12	●	25	25	150	25	12.5	35				
	3225P12	●	32	25	170	32	12.5	35				
	3225P16	●	32	25	170	32	12.5	35	I60M4×15X	R16BS	SM6×10XA	WT15IP WH40L
	3232P16	●	32	32	170	32	16	40				
	4040S16	●	40	40	250	40	20	50				
4040S20	●	40	40	250	40	20	50	I43M6×16	—	—	WT25IT	

Applicable insert
Wendeschneidplatten

Application Anwendung	Semi-Finishing Mittlere Bearbeitung	Al machining Alu-Bearbeitung
insert shape Schneidplattenform	 A106	LH  A106
SRDCN**H08	RCMT0803MO	RCGX0803MO-LH
SRDCN**H / K / M10	RCMT10T3 MO	
SRDCN**K / M / P12	RCMT1204 MO	
SRDCN**P / S16	RCMT1606 MO	
SRDCN**P / S20	RCMT2006 MO	

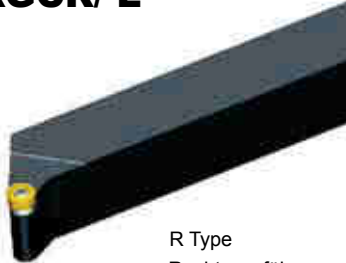
Holder not suitable for RCMX inserts
Halter nicht für RCMX Platten geeignet

● ex stock · ab Lager ○ on demand · Anfrage

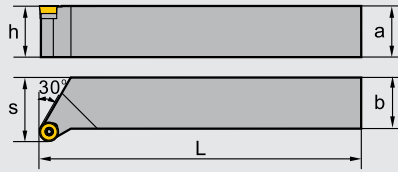
RC** Toolholder · Halter





S-Clamping · S-Halter

SRGCR/ L





R Type
Rechtsausführung



Type Typ		Stock Lager		Dimension (mm) Abmessung					Screw Schraube	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel
		R	L	a	b	L	h	s				
SRGCR/ L	1616H08			16	16	100	16	20	I60M3×7	—	—	WT10IP
	1616H10			16	16	100	16	20	I60M3.5×10	—	—	WT15IP
	2020K10	●	●	20	20	125	20	25				
	2525M10	●	○	25	25	100	25	32	I60M3.5×12	R12BS	SM5×8.65XA	WT15IP WH35L
	2020K12	●	●	20	20	125	20	27				
2525M12	●	○	25	25	150	25	32					

Applicable insert
Wendeschneidplatten

Application Anwendung	Semi-Finishing Mittlere Bearbeitung	Al machining Alu-Bearbeitung
insert shape Schneidplattenform	 A106	LH  A106
Type Typ	SRGCR / L**H08	RCGX0803MO-LH
	SRGCR / L**H / K / M10	RCMT10T3 MO
	SRGCR / L**K / M12	RCMT1204 MO

Holder not suitable for RCMX inserts
Halter nicht für RCMX Platten geeignet

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

External turning tools · Drehwerkzeuge zur Außenbearbeitung

KNUX** Toolholder · Halter

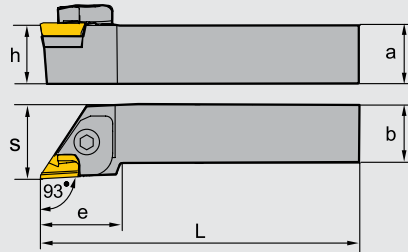
C-Clamping · C-Halter

CKJNR/ L

Kr:93°



R Type
Rechtsausführung



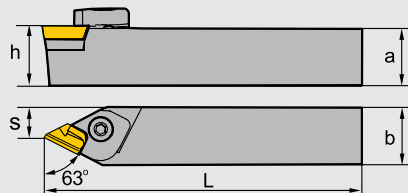
Type Typ		Stock Lager	Dimension (mm) Abmessung					Application inserts Wendeschneid- platten	Clamp Pratze	Clamp PratzeScrew Schraube	Spring Feder	Clamping stud Passstift	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel	
			a	b	L	h	s									e
CKJNR	2525M16	●	25	25	150	25	32	KNUX1604**R A95	C6R1T	CM6×25A	SPR1 SPR2	P0515	K16CC	SM3×10B	WH20L WH40L	
	3232P16	●	32	32	170	32	40									32
	4040R16	●	40	40	200	40	50									32
CKJNL	2525M16	●	25	25	150	25	32	KNUX1604**L A95	C6L1T	CM6×25A	SPR1 SPR2	P0515	K16CCL	SM3×10B	WH20L WH40L	
	3232P16	●	32	32	170	32	40									32
	4040R16	●	40	40	200	40	50									32

CKNNR/ L

Kr:63°



R Type
Rechtsausführung



Type Typ		Stock Lager	Dimension (mm) Abmessung					Application inserts Wendeschneid- platten	Clamp Pratze	Clamp PratzeScrew Schraube	Spring Feder	Clamping stud Passstift	Shim Unterlage	Shim Screw, Unterlage Schraube	Wrench Schlüssel
			a	b	L	h	s								
CKNNR	2525M16	●	25	25	150	25	14.3	KNUX1604**R A95	C6R1T	CM6×25A	SPR1 SPR2	P0515	K16CC	SM3×10B	WH20L WH40L
	3232P16	○	32	32	170	32	16.8								
CKNNL	2525M16	●	25	25	150	25	14.3	KNUX1604**L A95	C6L1T	CM6×25A	SPR1 SPR2	P0515	K16CCL	SM3×10B	WH20L WH40L
	3232P16	○	32	32	170	32	16.8								

● ex stock · ab Lager ○ on demand · Anfrage

CN** Toolholder · Halter

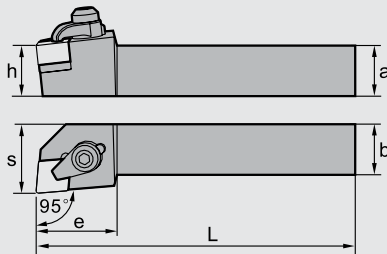
C-Clamping · C-Halter

CCLNR/ L

Kr:95°



R Type
Rechtsausführung



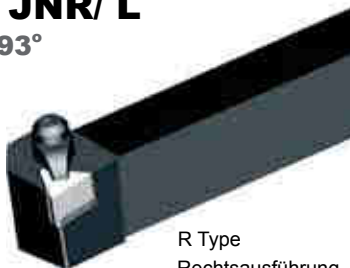
Type Typ	Stock Lager	Dimension (mm) Abmessung							Application inserts Wendeschneid- platten	Clamp Pratze	Clamp screw Schraube	Wrench Schlüssel	Shim Unterlage	Shim screw Schraube	Spring Feder	
		R	L	a	b	L	h	s								e
CCLNR/ L	2020K12	○	○	20	20	125	20	27	32	CNGN1207** (1204**) A153	C1RC	CM6×30B	WH20L WH40L	C12CC-07 (C12CC-04)	SM3×10B	SPR1
	2525M12	○	●	25	20	100	25	27	36							
	2525M16	○	○	25	25	150	25	32	36	CNGN1606** (1604**) A153	C2RC	CM8×30B	WH30L WH50L	C16CC-06 (16CC-04)	SM4×12B	SPR3
	3225P16	○	○	32	25	170	32	32	36							

TN** Toolholder · Halter

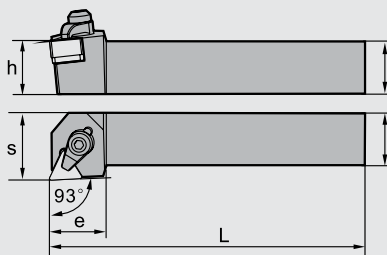
C-Clamping · C-Halter

CTJNR/ L

Kr:93°



R Type
Rechtsausführung



Type Typ	Stock Lager	Dimension (mm) Abmessung							Application inserts Wendeschneid- platten	Clamp Pratze	Clamp screw Schraube	Wrench Schlüssel	Shim Unterlage	Shim screw Schraube	Spring Feder	
		R	L	a	b	L	h	s								e
CTJNR/ L	2020K16	○	○	20	20	125	20	25	30	TNGN1607** (1604**) A159	C1RC	CM6×30B	WH20L WH40L	T16CC-07 (T16CC-04)	SM3×10B	SPR1
	2525M16	○	○	25	25	150	25	32	30							

Turning · Drehen

External turning tools · Drehwerkzeuge zur Außenbearbeitung

TN** Toolholder · Halter

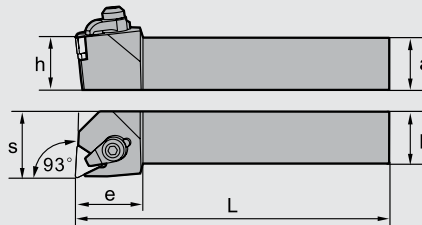
C-Clamping · C-Halter








CTUNR/ L

Kr:93°



R Type
Rechtsausführung



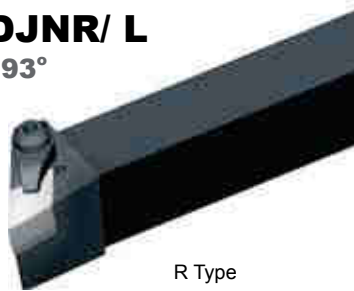
Type Typ	Stock Lager	Dimension (mm) Abmessung							Application inserts Wendeschneid- platten	Clamp Pratze	Clamp screw Schraube	Wrench Schlüssel	Shim Unterlage	Shim screw Schraube	Spring Feder	
		R	L	a	b	L	h	s								e
CTUNR/ L	2020K12			20	20	125	20	25	27	 TNGN1607** (1604**) A159	 C1RC	 CM6×30B	 WH20L WH40L	 T16CC-07 (T16CC-04)	 SM3×10B	 SPR1
	2525M16	○	○	25	25	150	25	32	27							

DN** Toolholder · Halter

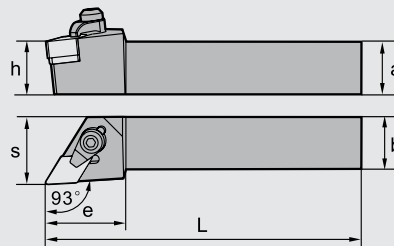
C-Clamping · C-Halter








CDJNR/ L

Kr:93°



R Type
Rechtsausführung



Type Typ	Stock Lager	Dimension (mm) Abmessung							Application inserts Wendeschneid- platten	Clamp Pratze	Clamp screw Schraube	Wrench Schlüssel	Shim Unterlage	Shim screw Schraube	Spring Feder	
		R	L	a	b	L	h	s								e
CDJNR/ L	2525M15	●	●	25	25	150	25	32	32	 DNGN1507** (1504**) A155	 C1RC	 CM6×30B	 WH20L WH40L	 D15CC-07 (D15CC-04)	 SM3×10B	 SPR1
	3225P15	○	○	32	25	170	32	32	32							

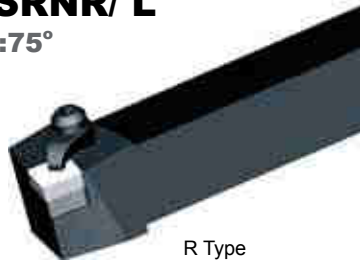
● ex stock · ab Lager ○ on demand · Anfrage

SN** Toolholder · Halter

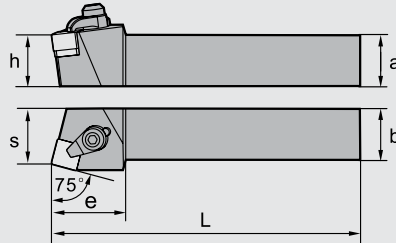
C-Clamping · C-Halter

CSNR/ L

Kr:75°



R Type
Rechtausführung



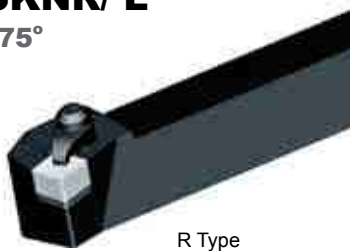
Type Typ	Stock Lager	Dimension (mm) Abmessung								Application inserts Wendeschneid- platten	Clamp Pratze	Clamp screw Schraube	Wrench Schlüssel	Shim Unterlage	Shim screw Schraube	Spring Feder
		R	L	a	b	L	h	s	e							
CSNR/ L	2020K12	o	o	20	20	125	20	22	32	SNGN1207** (1204**) A157	C1RC	CM6×30B	WH20L WH40L	S12CC-07 (S12CC-04)	SM3×10B	SPR1
	2525M12	o	o	25	20	100	25	27	32							
	3225P12	o	o	32	25	170	32	27	32	SNGN1507** A157	C2RC	CM8×30B	Wø30L WH50L	S15CC-07	SM4×12B	SPR3
	3225P15	o	o	32	25	170	32	32	40							
4040R15	o	o	40	40	200	40	43	40								

SN** Toolholder · Halter

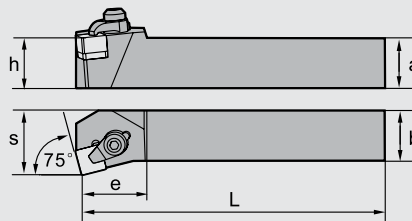
C-Clamping · C-Halter

CSKNR/ L

Kr:75°



R Type
Rechtausführung



Type Typ	Stock Lager	Dimension (mm) Abmessung								Application inserts Wendeschneid- platten	Clamp Pratze	Clamp screw Schraube	Wrench Schlüssel	Shim Unterlage	Shim screw Schraube	Spring Feder
		R	L	a	b	L	h	s	e							
CSKNR/ L	2020K12	o	o	20	20	125	20	25	25	SNGN1207** (1204**) A157	C1RC	CM6×30B	WH20L WH40L	S12CC-07 (S12CC-04)	SM3×10B	SPR1
	2525M12	o	o	25	25	170	25	32	25							
	3225P12	o	o	32	25	170	32	32	25	SNGN1507** A157	C2RC	CM8×30B	WH30L WH50L	S15CC-07	SM4×12B	SPR3
	3225P15	o	o	32	25	170	32	32	30							

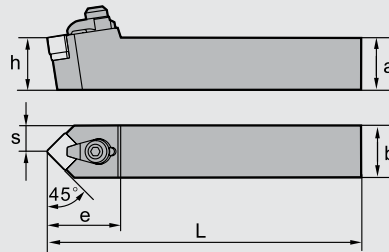
Turning · Drehen

External turning tools · Drehwerkzeuge zur Außenbearbeitung

SN** Toolholder · Halter

C-Clamping · C-Halter

CSDNN Kr:45°

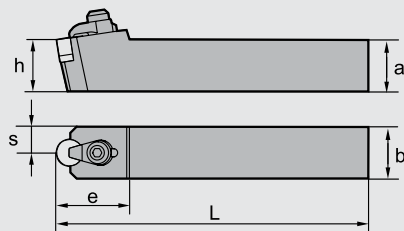


Type Typ		Stock Lager	Dimension (mm) Abmessung						Application inserts Wendeschneid- platten	Clamp Pratze	Clamp screw Schraube	Wrench Schlüssel	Shim Unterlage	Shim screw Schraube	Spring Feder
			a	b	L	h	s	e							
CSDNN	2020K12	○	20	20	125	20	10	35	SNGN1207** (1204**) A157	C1RC	CM6×30B	WH20L WH40L	S12CC-07 (S12CC-04)	SM3×10B	SPR1
	2525M12	●	25	25	150	25	12.5	30							
	3225P12	○	32	25	170	32	12.5	35							

RN** Toolholder · Halter

C-Clamping · C-Halter

CRDNN



Type Typ		Stock Lager	Dimension (mm) Abmessung						Application inserts Wendeschneid- platten	Clamp Pratze	Clamp screw Schraube	Wrench Schlüssel	Shim Unterlage	Shim screw Schraube	Spring Feder
			a	b	L	h	s	e							
CRDNN	2020K12	○	20	20	125	20	10	32	RNGN1207** (1204**) A160	C1RC	CM6×30B	WH20L WH40L	R12CC-07 (R12CC-04)	SM3×10B	SPR1
	2525M12	○	25	25	150	25	12.5	32							
	3225P12	○	32	25	170	32	12.5	32							
	3232P15	○	32	32	170	32	17.5	40	RNGN1507** A160	C2RC	CM8×30B	WH20L WH50L	R15CC-07	SM3×10B	SPR3
	4040R15	○	40	40	200	40	20	40							

● ex stock · ab Lager ○ on demand · Anfrage

CN** Toolholder · Halter

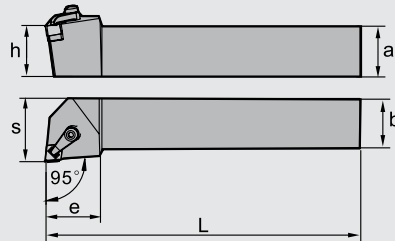
J-Clamping · J-Halter

JCLNR/ L

Kr:95°



R Type
Rechtsausführung



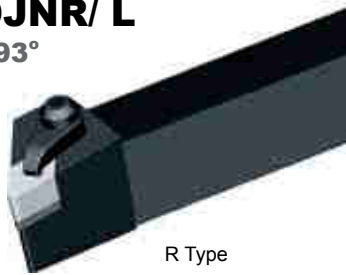
Type Typ	Stock Lager	Dimension (mm) Abmessung							Application inserts Wendeschneid- platten	Clamp Pratze	Clamp screw Schraube	Wrench Schlüssel	Shim Unterlage	Shim screw Schraube	Spring Feder	
		R	L	a	b	L	h	s								e
JCLNR/ L	2020K12	○	○	20	20	125	20	29	32	CNGX1207** A154	C1RJ	CM6×30B	WH20L WH40L	C12CC-07	SM3×10B	SPR1
	2525M12	○	○	25	25	150	25	32	32							

DN** Toolholder · Halter

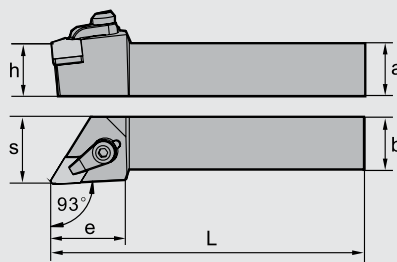
J-Clamping · J-Halter

JDJNR/ L

Kr:93°



R Type
Rechtsausführung



Type Typ	Stock Lager	Dimension (mm) Abmessung							Application inserts Wendeschneid- platten	Clamp Pratze	Clamp screw Schraube	Wrench Schlüssel	Shim Unterlage	Shim screw Schraube	Spring Feder	
		R	L	a	b	L	h	s								e
JDJNR/ L	2525M15	●	○	25	25	150	25	32	38	DNGX1507** A155	C1RJ	CM6×30B	WH20L WH40L	D15CC-07	SM3×10B	SPR1
	3225P15	○	○	32	25	170	32	32	38							

A

General Turning
Allgemeine Drehbearbeitung

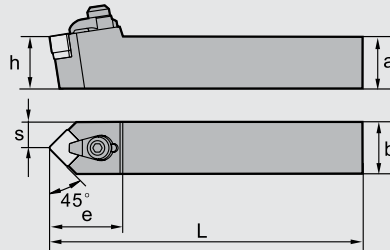
Turning · Drehen








External turning tools · Drehwerkzeuge zur Außenbearbeitung

SN** Toolholder · Halter

J-Clamping · J-Halter

JSDNN Kr:45°



Type Typ	Stock Lager	Dimension (mm) Abmessung						Application inserts Wendeschneid- platten	Clamp Pratze	Clamp screw Schraube	Wrench Schlüssel	Shim Unterlage	Shim screw Schraube	Spring Feder	
		a	b	L	h	s	e								
JSDNN	2020K12	○	20	20	125	20	10	40	SNGX1207** A156	C1RJ	CM6×30B	WH20L WH40L	S12CC-07	SM3×10B	SPR1
	2525M12	○	25	25	150	25	12.5	40							
	3225P12	○	32	25	170	32	12.5	40							

● ex stock · ab Lager ○ on demand · Anfrage



Turning · Drehen

Internal Turning Tools · Drehwerkzeuge zur Innenbearbeitung

Turning tool overview · Drehwerkzeuge Übersicht A235

Turning tool code key · ISO Kennzeichnung A236-A237

**Detailed table of Internal turning tool
Drehwerkzeuge zur Innenbearbeitung A238-A263**

Turning toolholders by P type clamping · Drehwerkzeuge / P Klemmung A238-A245

Turning toolholders by S type clamping · Drehwerkzeuge / S Klemmung A246-A262

Antivibration Tool Holder · Antivibration-Klemmhalter A264-A270



Turning · Drehen

Internal turning tools Overview · Drehwerkzeugen zur Innenbearbeitung Übersicht

Clamping system Klemmsystem	Feature Merkmale	62°30'	75°	85°	90°	91°	93°	93°	95°	107°30'
P	<ul style="list-style-type: none"> min. Ø to be machined = 20mm min. Bearbeitungs Ø = 20mm neg. inserts with good stability and Economy Neg. WSP mit guter Stabilität & Wirtschaftlichkeit 	PDSN A240	PSKN A243		PTFN A244			PDUN A241	PCLN A238	
									PWLN A245	
S	<ul style="list-style-type: none"> min. Ø to be machined = 8,5mm (Screw Clamping) min. Bearbeitungs Ø = 8,5mm (Schraubenklemm.) Inserts with 5°/7°/11° Pos.-WSP mit 5°/7°/11° 		SSKC A251	SDZC A250	SCFC A261	STFC A252	STUP A260	SDUC A249		SDQC A248
								SDUP A259	SCLC A246	SDQP A258
								SVUC A254	SCLC A246	SVQB A255
								SVUB A256	SCLP A257	SVQC A253
Antivibration Antivibration	<ul style="list-style-type: none"> Antivibrations toolholder (Cemented Carbide) min. Ø to be machined = 8,5mm Inserts with 5°/7°/11° Antivibrations-Klemmhalter (Hartmetall) min. Bearbeitungs Ø = 8,5mm WSP mit 5°/7°/11° 						STUP A267	SDUP A266	SCLP A264	SDQP A265
									SVUC A270	

A

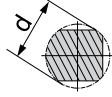
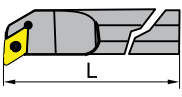


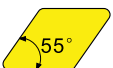



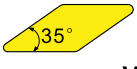

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

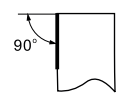
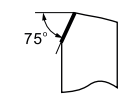
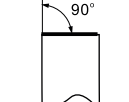
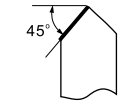
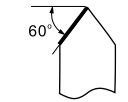
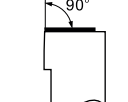
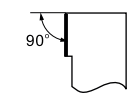
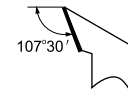
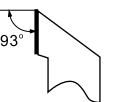
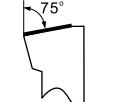
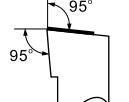
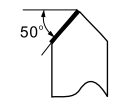
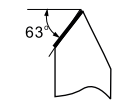
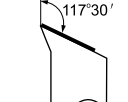
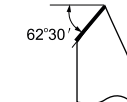
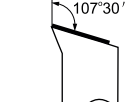
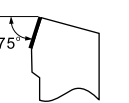
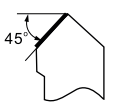
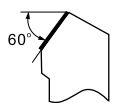
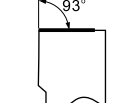
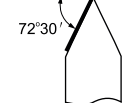
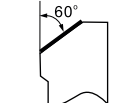
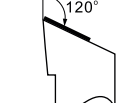
Internal turning tools Code Key · Drehwerkzeugen zur Innenbearbeitung ISO Kennzeichnung

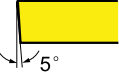

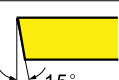

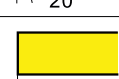
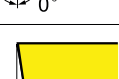
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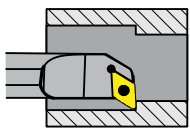
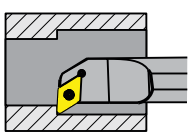
General Turning
Allgemeine Drehbearbeitung

Type of Shank Schaftausführung		Shank diameter Schaftdurchmesser	Tool length Halterlänge	Clamping System Klemmsystem	Insert shape Plattenform	
code	Type Typ					
A	Steel shank+Oil hole Stahlschaft mit Kühlbohrung	code diameter Durchmesser	code length Länge	M Screw clamping Schraub-Spannsystem		
C	Carbide shank Hartmetallschaft	16 16	H 100	S Wedge lock clamping Pratzenkeilklemmung		
E	Carbide shank+Oil hole Hartmetallschaft mit Kühlbohrung	20 20	K 125	C Overhead clamping Pratzenkeilklemmung		
S	Steel shank Stahlschaft	25 25	M 150			
X	Special insert application Besondere Anwendung	32 32	N 160			
		40 40	Q 180			
		50 50	R 200			
			S 250			
			T 300			
			U 350			
			V 400			

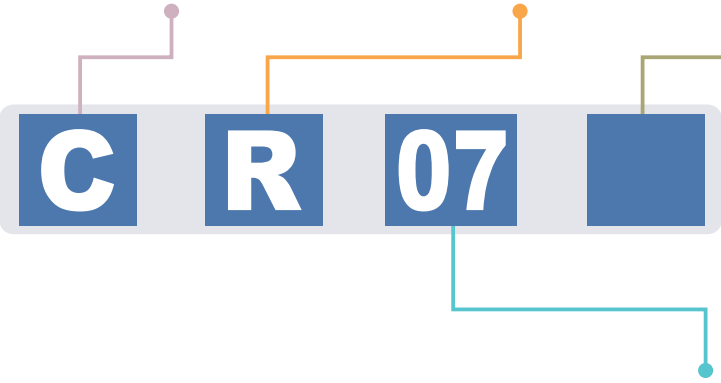
S 16 R - S D U








Holder style and lead angle Halterform und Anstellwinkel							
A	B	C	D	E	F	G	H
							
J	K	L	M	N	O	P	Q
							
R	S	T	U	V	W	X	
							

Clearance angle of major cutting edge <i>Freiwinkel von Hauptschneide</i>	
	B
	C
	D
	E
	N
	P

Holder execution <i>Halteausführung</i>	
	L
	R

Manufacture option <i>Herstellungsoptionen</i>	
D	Increase offset f size+1.0mm <i>Aufmaß von F +1mm erhöhen</i>
E	Increase offset f size+2.0mm <i>Aufmaß von F +2mm erhöhen</i>
R	Round shank <i>Rundschaft</i>
W	Wedge clamping <i>Keil-Klemmung</i>
X	Back boring <i>Rückwärts drehen</i>



Cutting edge length <i>Schneidkantenlänge</i>							
insert shape <i>insert shape</i>	C	D	R	S	T	V	W
							
Diameter of incircle (mm) <i>Durchmesser von Innenkreis</i>	Cutting edge length <i>Schneidkantenlänge</i>						
5.556	---	---	---	---	09	---	---
6.350	06	07	---	---	11	---	---
9.525	09	11	09	09	16	16	06
12.700	12	15	12	12	22	22	08
15.875	16	19	15	15	27	---	---
19.050	19	---	19	19	33	---	---
25.400	25	---	25	25	44	---	---

Turning · Drehen

Internal turning tools · Drehwerkzeuge zur Innenbearbeitung

CN** Toolholder · Halter

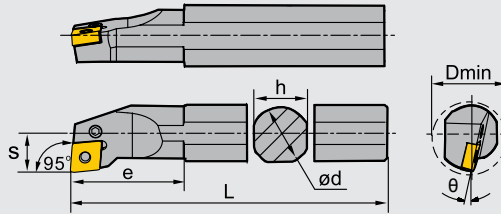
P-Clamping / P-Halter

PCLNR/L

Kr:95°



R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel	Lever Kniehebel	Shim Unterlage	Shim pin Rohrstift
	R	L	Dmin	ød	h	L	s	θ	e					
S16M-PCLNR/L09	●	●	20	16	15	150	11	-12°	28	LEM5×9B	WH20L	L3C	—	—
S16R-PCLNR/L09	●	●	20	16	15	200	11	-12°	28					
S20Q-PCLNR/L09	●	●	25	20	18	180	13	-11°	31					
S20S-PCLNR/L09	●	●	25	20	18	250	13	-11°	31					
S25Q-PCLNR/L09	○	○	32	25	23	180	17	-10°	35					
S25T-PCLNR/L09	●	●	32	25	23	300	17	-10°	35	LEM6×13.4A	WH25L	L4A	—	—
S25Q-PCLNR/L12	○	○	32	25	23	180	17	-12°	40					
S25T-PCLNR/L12	●	●	32	25	23	300	17	-12°	40					
S32R-PCLNR/L12	●	●	44	32	30	200	22	-10°	50	LEM8×21	WH30L	L4	C12APB	SP4
S32U-PCLNR/L12	●	●	44	32	30	350	22	-10°	50					
S40S-PCLNR/L12	○	○	54	40	37	250	27	-10°	55					
S40V-PCLNR/L12	●	●	54	40	37	400	27	-10°	55					
S50S-PCLNR/L12	○	●	63	50	47	250	35	-10°	56					
S50W-PCLNR/L12	●	●	63	50	47	450	35	-10°	56	LEM10×27	WH40L	L6	C19AP	SP6
S50S-PCLNR/L19	○	○	63	50	47	250	35	-10°	63					
S50W-PCLNR/L19	●	●	63	50	47	450	35	-10°	63					
◆ A25R-PCLNR/L12	●	●	32	25	24	200	17	-12°	40	LEM6×13.4A	WH25L	L4A	—	—
◆ A32S-PCLNR/L12	●	●	44	32	31	250	22	-10°	50	LEM8×21	WH30L	L4	C12APB	SP4
















● ex stock · ab Lager ○ on demand · auf Anfrage ◆ Toolholder with holes for coolant · Klemmhalter mit Kühlmittelbohrung

Turning · Drehen

Internal turning tools · Drehwerkzeuge zur Innenbearbeitung

A

General Turning
Allgemeine Drehbearbeitung

Applicable insert Wendeschneidplatten		Finishing Schlichten		Semi-Finishing Mittlere Bearbeitung		Roughing Schruppen		Cast iron machining Grauguss Bearbeitung				
Application Anwendung												
insert shape Schneidplattenform	DF		A60	PM		A61	DR Double side doppelseitig		A63	Flat Flach		A66
	SF		A60	DM		A62	DR Single side einseitig		A63	TC		A63
	EF		A60	EM		A62	ER Double side doppelseitig		A64			
	NF		A61	NM		A63	ER Single side einseitig		A64			
							LR Single side einseitig		A64			
Type Typ	**PCLNR/L09	CN**0903**		CN**0903**						CN**0903**		
	PCLNR/L12	CN1204**		CN**1204**		CN**1204**		CN**1204**		CN**1204**		
	PCLNR/L19					CN1906**		CN**1906**		CN**1906**		

◆ Toolholder with holes for Coolant · Klemmhalter mit Kühlmittelbohrung

● ex stock · ab Lager ○ on demand · auf Anfrage

Turning · Drehen

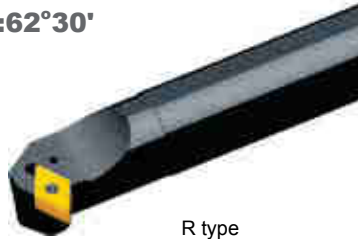
Internal turning tools · Drehwerkzeuge zur Innenbearbeitung

DN** Toolholder Halter

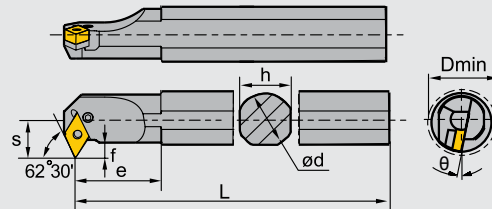
P-Clamping / P-Halter

PDSNR/L

Kr:62°30'

















R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung								Screw Schraube	Wrench Schlüssel	Lever Kniehebel	Shim Unterlage	Shim pin Rohrstift
	R	L	Dmin	ød	h	L	S	θ	e	f					
S32R-PDSNR/L15	●	●	40	32	30	200	22	-11°	45	8,5	LEM8×21	WH30L	L4B	D15AP	SP4
S32U-PDSNR/L15	●	●	40	32	30	350	22	-11°	45	8,5	LEM8×21	WH30L	L4	D15AP	SP4
S32R-PDSNR/L15-3	●	●	40	32	30	200	22	-11°	45	8,5	LEM8×21	WH30L	L4	D15AP	SP4
S32U-PDSNR/L15-3	●	●	40	32	30	350	22	-11°	45	8,5	LEM8×21	WH30L	L4B	D15AP	SP4
S40S-PDSNR/L15	●	●	50	40	37	250	27	-11°	43	9,4	LEM8×21	WH30L	L4B	D15AP	SP4
S40V-PDSNR/L15	●	●	50	40	37	400	27	-11°	43	9,4	LEM8×21	WH30L	L4	D15AP	SP4
S40S-PDSNR/L15-3	●	●	50	40	37	250	27	-11°	43	9,4	LEM8×21	WH30L	L4	D15AP	SP4
S40V-PDSNR/L15-3	●	●	50	40	37	400	27	-11°	43	9,4	LEM8×21	WH30L	L4B	D15AP	SP4
◆ A32S- PDSNR/L15	●	●	40	32	31	250	22	-11°	45	8,5	LEM8×21	WH30L	L4B	D15AP	SP4
*◆ A32S- PDSNR/L15-3	●	●	40	32	31	250	22	-11°	45	8,5	LEM8×21	WH30L	L4	D15AP	SP4

* For DNMG1504 / Für DNMG1504

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Cast iron machining Grauguss Bearbeitung
insert shape Schneidplattenform	DF  A67	PM  A69	DR  A70 Double side doppelseitig	Flat Flach  A71
	SF  A67	DM  A69	DR  A72 Single side einseitig	
	EF  A68	EM  A70	ER  A70 Double side doppelseitig	
	NF  A68	NM  A70	ER  A72 Single side einseitig	
			LR  A72 Single side einseitig	
Type Typ	**PDSNR/L-15-3	DN**1504**	DN**1504**	DN**1504**
	PDSNR/L-15	DN1506**	DN**1506**	DN**1506**

● ex stock · ab Lager ○ on demand · auf Anfrage ◆ Toolholder with holes for coolant · Klemhalter mit Kühlmittelbohrung

DN** Toolholder · Halter

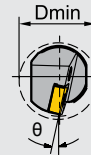
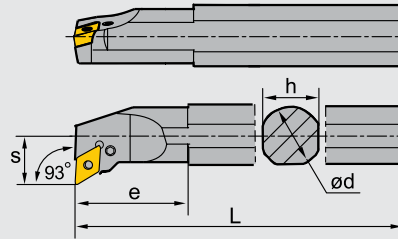
P-Clamping / P-Halter

PDUNR/L

Kr:93°



R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel	Lever Kniehebel	Shim Unterlage	Shim pin Rohrstift
	R	L	Dmin	ød	h	L	S	θ	e					
S20Q-PDUNR/L11	●	○	25	20	18	180	13	-16°	30	LEM5×12B	WH20L	L3D	—	—
S20S-PDUNR/L11	●	●	25	20	18	250	13	-16°	30					
S25Q-PDUNR/L11	○	○	32	25	23	180	17	-13°	35					
S25T-PDUNR/L11	●	●	32	25	23	300	17	-13°	35	LEM6×17	WH25L	L3	D11AP	SP3
S32R-PDUNR/L11	●	●	40	32	30	200	22	-16°	40					
S32U-PDUNR/L11	●	●	40	32	30	350	22	-16°	40					
S32R-PDUNR/L15	●	●	40	32	30	200	22	-16°	50	LEM8×21	WH30L	L4B	D15AP	SP4
S32U-PDUNR/L15	●	●	40	32	30	350	22	-16°	50					
S32R-PDUNR/L15-3	●	●	40	32	30	200	22	-16°	50					
S32U-PDUNR/L15-3	●	●	40	32	30	350	22	-16°	50	LEM8×21	WH30L	L4	D15AP	SP4
S40S-PDUNR/L15	●	●	50	40	37	250	27	-11°	50					
S40V-PDUNR/L15	●	●	50	40	37	400	27	-11°	50					
S40S-PDUNR/L15-3	●	●	50	40	37	250	27	-11°	50	LEM8×21	WH30L	L4	D15AP	SP4
S40V-PDUNR/L15-3	●	●	50	40	37	400	27	-11°	50					
◆ A32S- PDUNR/L15	●	●	40	32	31	250	22	-16°	50					
*◆ A32S- PDUNR/L15-3	●	●	40	32	31	250	22	-16°	50	LEM8×21	WH30L	L4	D15AP	SP4

* For DNMG1504 / Für DNMG1504

◆ Toolholder with holes for Coolant · Klemmhalter mit Kühlmittelbohrung

● ex stock · ab Lager















○ on demand · auf Anfrage

Turning · Drehen

Internal turning tools · Drehwerkzeuge zur Innenbearbeitung

A

General Turning
Allgemeine Drehbearbeitung

Applicable insert Wendeschneidplatten		Finishing Schlichten		Semi-Finishing Mittlere Bearbeitung		Roughing Schruppen		Cast iron machining Grauguss Bearbeitung	
Application Anwendung									
insert shape Schneidplattenform	DF	 A67	PM	 A69	DR Double side doppelseitig	 A70	Flat Flach	 A71	
	SF	 A67	DM	 A69	DR Single side einseitig	 A72			
	EF	 A68	EM	 A70	ER Double side doppelseitig	 A70			
	NF	 A68	NM	 A70	ER Single side einseitig	 A72			
					LR Single side einseitig	 A72			
Type Typ	**PDUNR/L11	DN**1104**		DN**1104**					
	PDUNR/L15-3	DN1504**		DN**1504**				DN**1504**	
	PDUNR/L15	DN1506**		DN**1506**		DN**1506**		DN**1506**	

● ex stock · ab Lager ○ on demand · auf Anfrage ◆ Toolholder with holes for coolant · Klemmhalter mit Kühlmittelbohrung

SN** Toolholder · Halter

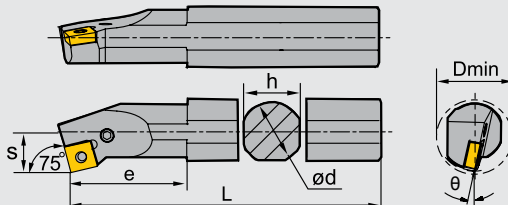
P-Clamping / P-Halter

PSKNR/L

Kr:75°



R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel	Lever Kniehebel	Shim Unterlage	Shim pin Rohrstift
	R	L	Dmin	ød	h	L	S	θ	e					
S25Q-PSKNR/L12	○	○	32	25	23	180	17	-12°	42	LEM6×13.4A	WH25L	L4A	—	—
S25T-PSKNR/L12	●	○	32	25	23	300	17	-12°	42					
S32R-PSKNR/L12	●	●	44	32	30	200	22	-10°	45	LEM8×21	WH30L	L4	S12APB	SP4
S32U-PSKNR/L12	●	●	44	32	30	350	22	-10°	45					
S40S-PSKNR/L12	●	●	54	40	37	250	27	-10°	50					
S40V-PSKNR/L12	●	○	54	40	37	400	27	-10°	50					
◆ A25R-PSKNR/L12	●	●	32	25	24	200	17	-12°	42	LEM6×13.4A	WH25L	L4A	—	—
◆ A32S-PSKNR/L12	●	●	44	32	31	250	22	-12°	50	LEM8×21	WH30L	L4	S12APB	SP4

Applicable insert Wendeschneidplatten		Application Anwendung			
insert shape Schneidplattenform		Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Cast iron machining Grauguss Bearbeit.
Type Typ	**-PSKNR/L12	DF A73	PM A74	DR Double side doppelseitig A76	Flat Flach A80
		EF A73	DM A75	DR Single side einseitig A77	TC A75
		SF A74	EM A75	ER Double side doppelseitig A76	
			NM A76	ER Single side einseitig A78	
				LR Single side einseitig A77	
		SN**1204**	SN**1204**	SN**1204**	SN**1204**

◆ Toolholder with holes for Coolant · Klemmhalter mit Kühlmittelbohrung ● ex stock · ab Lager ○ on demand · auf Anfrage

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

Internal turning tools · Drehwerkzeuge zur Innenbearbeitung

TN** Toolholder · Halter

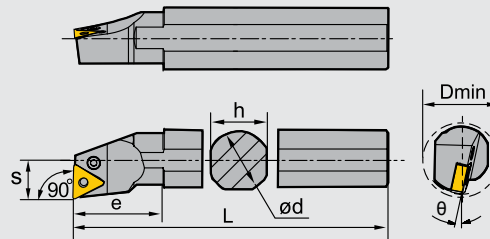
P-Clamping / P-Halter

PTFNR/L

Kr:90°















R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel	Lever Kniehebel	Shim Unterlage	Shim pin Rohrstift
	R	L	Dmin	ød	h	L	S	θ	e					
S16M-PTFNR/L11	●	●	20	16	15	150	11	-14°	28	LEM5×9B	WH20L	L2	—	—
S16R-PTFNR/L11	●	●	20	16	15	200	11	-14°	28					
S20Q-PTFNR/L11	○	○	25	20	18	180	13	-12°	31					
S20S-PTFNR/L11	●	●	25	20	18	250	13	-12°	31					
S25Q-PTFNR/L11	○	○	32	25	23	180	17	-10°	35					
S25T-PTFNR/L11	○	○	32	25	23	300	17	-10°	35	LEM5×12B	WH20L	L3B	—	—
S25Q-PTFNR/L16	○	○	32	25	23	180	17	-12°	42					
S25T-PTFNR/L16	●	●	32	25	23	300	17	-12°	42					
S32R-PTFNR/L16	○	○	44	32	30	200	22	-10°	50	LEM6×17	WH25L	L3	T16APB	SP3
S32U-PTFNR/L16	●	●	44	32	30	350	22	-10°	50					
S40S-PTFNR/L16	○	○	54	40	37	250	27	-10°	55					
S40V-PTFNR/L16	●	●	54	40	37	400	27	-10°	55					
◆ A25R-PTFNR/L16	●	○	32	25	24	200	17	-12°	40					
◆ A32S-PTFNR/L16	●	●	44	32	31	250	22	-10°	50					

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Cast iron machining Grauguss Bearbeitung
insert shape Schneidplattenform	DF  A82	PM  A83	DR  A84 Double side doppelseitig	Flat Flach  A87
	SF  A82	DM  A83	DR  A85 Single side einseitig	TC  A84
	EF  A82	EM  A84	ER  A85 Double side doppelseitig	
			LR  A85 Single side einseitig	
Type Typ	**PTFNR/L11	TN**1103**	TN**1103**	TN**1103**
	PTFNR/L16	TN1604**	TN**1604**	TN**1604**

● ex stock · ab Lager ○ on demand · auf Anfrage ◆ Toolholder with holes for coolant · Klemhalter mit Kühlmittelbohrung

WN** Toolholder · Halter

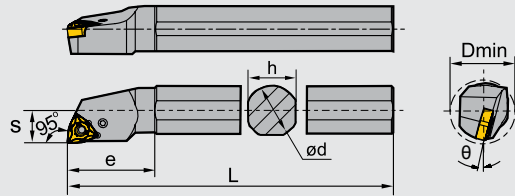
P-Clamping /P-Halter

PWLNR/L

Kr:95°














R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel	Lever Kniehebel	Shim Unterlage	Shim pin Rohrstift
	R	L	Dmin	ød	h	L	S	θ	e					
S16M-PWLNR/L06	●	●	20	16	15	150	11	-13°	25	LEM5X12B	WH20L	L3B	—	—
S16R-PWLNR/L06	○	○	20	16	15	200	11	-13°	25					
S20Q-PWLNR/L06	●	●	25	20	18	180	13	-13°	35	LEM5X12B	WH20L	L3B	—	—
S20S-PWLNR/L06	○	○	25	20	18	250	13	-13°	35					
S25Q-PWLNR/L06	○	○	32	25	23	180	17	-13°	35					
S25T-PWLNR/L06	○	○	32	25	23	300	17	-13°	35					
S20Q-PWLNR/L08	●	●	25	20	18	180	13	-13°	32	LEM6X13.4A	WH25L	L4A	—	—
S20S-PWLNR/L08	○	○	25	20	18	250	13	-13°	32					
S25Q-PWLNR/L08	●	○	32	25	23	180	17	-13°	45					
S25T-PWLNR/L08	●	○	32	25	23	300	17	-13°	45					
S32R-PWLNR/L08	●	●	40	32	30	200	22	-15°	50	LEM8X21	WH30L	L4	W08AP	SP4
S32U-PWLNR/L08	●	●	40	32	30	350	22	-15°	50					

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Cast iron machining Grauguss Bearbeitung	
insert shape Schneidplattenform	DF  A90	PM  A92	DR Double side doppelseitig  A93	Flat Flach  A93	
	SF  A91	DM  A92		TC  A93	
	EF  A91	EM  A92			
	NF  A91	NM  A92			
Type Typ	**PWLNR/L06	WN**0604**	WN**0604**	WN**0604**	WN**0604**
	PWLNR/L08	WN0804**	WN**0804**	WN**0804**	WN**0804**

◆ Toolholder with holes for Coolant · Klemmhalter mit Kühlmittelbohrung ● ex stock · ab Lager ○ on demand · auf Anfrage

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

Internal turning tools · Drehwerkzeuge zur Innenbearbeitung

CC** Toolholder · Halter

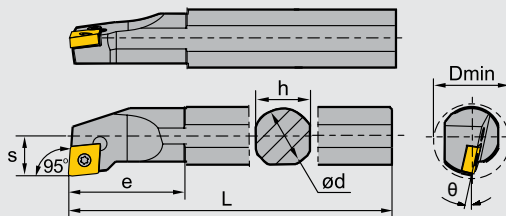
S-Clamping / S-Halter

SCLCR/L

Kr:95°



R type
Rechtsausführung



A

General Turning
Allgemeine Drehbearbeitung

Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel	Shim Unterlage	Shim Unterlage Schraube
	R	L	Dmin	ød	h	L	S	θ	e				
S08K-SCLCR/L06	●	●	10	8	7	125	5	-15°	14	I60M2.5×5.5	WT07IP	—	—
S10K-SCLCR/L06	●	●	10	10	7	125	5	-15°	14				
S10M-SCLCR/L06	●	●	12	10	9	150	6	-13°	14				
S12M-SCLCR/L06	●	●	16	12	11	150	9	-10°	25				
S12M-SCLCR/L09	●	●	16	12	11	150	9	-10°	25	I60M3.5×8	WT15IP	—	—
S16M-SCLCR/L09	●	○	20	16	15	150	11	-12°	32.5				
S16R-SCLCR/L09	●	●	20	16	15	200	11	-12°	32.5				
S20Q-SCLCR/L09	●	●	25	20	18	180	13	-8°	38				
S20S-SCLCR/L09	●	●	25	20	18	250	13	-8°	38	I60M3.5×10	WT15IP	—	—
S25Q-SCLCR/L09	●	○	32	25	23	180	17	-6°	45				
S25T-SCLCR/L09	●	●	32	25	23	300	17	-6°	45				
S25Q-SCLCR/L12	●	○	32	25	23	180	17	-6°	45				
S25T-SCLCR/L12	●	●	32	25	23	300	17	-6°	45	I60M4×11X	WT15IP	—	—
S32R-SCLCR/L12	●	●	40	32	30	200	22	-10°	50	I60M4×11X	WH40L WT15IP	C12BS	SM6×10XA
S32U-SCLCR/L12	●	●	40	32	30	350	22	-10°	50				
S40S-SCLCR/L12	○	○	50	40	37	250	27	-8°	60				
S40V-SCLCR/L12	●	●	50	40	37	400	27	-8°	60				
♦ A08F-SCLCR/L06	●	●	10	8	7.5	80	5	-15°	14	I60M2.5×5.5	WT07IP	—	—
♦ A10H-SCLCR/L06	●	●	12	10	9.5	100	6	-13°	14				
♦ A12K-SCLCR/L06	●	●	16	12	11.5	125	9	-10°	25				
♦ A12K-SCLCR/L09	●	●	16	12	11.5	125	9	-10°	25				
♦ A16M-SCLCR/L09	●	●	20	16	15.5	150	11	-12°	32.5	I60M3.5×8	WT15IP	—	—
♦ A20Q-SCLCR/L09	●	●	25	20	19	180	13	-8°	38				
♦ A25R-SCLCR/L09	●	●	32	25	24	200	17	-6°	45				
♦ A25R-SCLCR/L12	●	●	32	25	24	200	17	-6°	45				
♦ A32S-SCLCR/L12	●	●	40	32	31	250	22	-10°	50	I60M4×11X	WH40L, WT15IP	C12BS	SM6×10XA










● ex stock · ab Lager ○ on demand · auf Anfrage ♦ Toolholder with holes for coolant · Klemhalter mit Kühlmittelbohrung

Turning · Drehen

Internal turning tools · Drehwerkzeuge zur Innenbearbeitung

A

General Turning
Allgemeine Drehbearbeitung

Applicable insert Wendeschneidplatten		Extra Finishing Feinbearbeitung	Finishing Schlichten	Semi-finishing Mittlere Bearbeit.	Roughing Schruppen	Al machining Alu Bearbeitung	Cast iron machining Grauguss Bearbeit.
Application Anwendung		SF  A98	HF  A98	HM  A99	HR  A100	LH  A100	Flat Flach  A100
	insert shape Schneidplattenform		EF  A99	EM  A99		LC  A100	
Type Typ	** -SCLCR/L06	CC**0602**	CC**0602**	CC**0602**	CC**0602**	CCG0602**	CC**0602**
	** -SCLCR/L09	CC**09T3**	CC**09T3**	CC**09T3**	CC**09T3**	CCG09T3**	CC**09T3**
	** -SCLCR/L12	CC**1204**	CC**1204**	CC**1204**	CC**1204**	CCGX1204**	CC**1204**

◆ Toolholder with holes for Coolant · Klemmhalter mit Kühlmittelbohrung

● ex stock · ab Lager ○ on demand · auf Anfrage

Turning · Drehen

Internal turning tools · Drehwerkzeuge zur Innenbearbeitung

DC** Toolholder · Halter

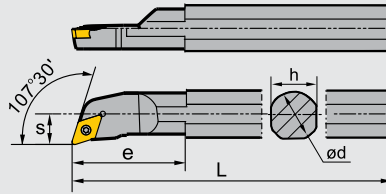
S-Clamping / S-Halter

SDQCR/L










Kr:107°30'



R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel		
	R	L	Dmin	ød	h	L	S	θ	e				
S10M-SDQCR/L07	●	●	13	10	9	150	7	-8°	20	I60M2.5×5.5	WT07IP		
S12M-SDQCR/L07	●	●	16	12	11	150	9	-8°	22				
S16M-SDQCR/L07	○	●	20	16	15	150	11	-6°	27				
S16Q-SDQCR/L07	●	●	20	16	15	150	11	-6°	27				
S16R-SDQCR/L07	●	●	20	16	15	200	11	-6°	27	I60M3.5×8	WT15IP		
S20Q-SDQCR/L11	●	○	25	20	18	180	13	-6°	32				
S20S-SDQCR/L11	●	●	25	20	18	250	13	-6°	32				
S25Q-SDQCR/L11	●	○	32	25	23	180	17	-6°	32	I60M3.5×10			
S25T-SDQCR/L11	●	●	32	25	23	300	17	-6°	32				
♦ A10H-SDQCR/L07	●	●	13	10	9.5	100	7	-8°	20	I60M2.5×5.5	WT07IP		
♦ A12K-SDQCR/L07	●	●	16	12	11.5	125	9	-8°	22	I60M2.5×6.5			
♦ A16M-SDQCR/L11	●	●	20	16	15.5	150	11	-6°	27	I60M3.5×8	WT15IP		
♦ A20Q-SDQCR/L11	●	●	25	20	19	180	13	-6°	32				
♦ A25R-SDQCR/L11	●	●	32	25	24	200	17	-6°	32				

Applicable insert Wendeschneidplatten		Extra Finishing Feinbearbeitung	Finishing Schlichten	Semi-finishing Mittlere Bearbeit.	Roughing Schruppen	Al machining Alu Bearbeitung	Cast iron machining Grauguss Bearbeit.
Application Anwendung	insert shape Schneidplattenform	SF  A102	HF  A102	HM  A103	HR  A104	LH  A104	Flat Flach  A104
			EF  A103	EM  A103		LC  A104	
Type Typ	**SDQCR/L07	DC**0702**	DC**0702**	DC**0702**		DCGX0702**	DC**0702**
	SDQCR/L11	DC11T3**	DC**11T3**	DC**11T3**	DC**11T3**	DCGX11T3**	DC**11T3**

● ex stock · ab Lager ○ on demand · auf Anfrage ♦ Toolholder with holes for coolant · Klemmhalter mit Kühlmittelbohrung

DC** Toolholder · Halter

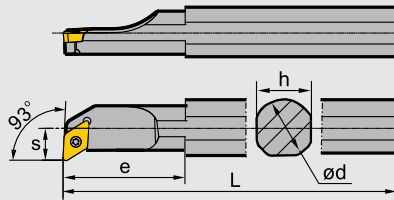
S-Clamping / S-Halter

SDUCR/L










Kr:93°



R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel		
	R	L	Dmin	ød	h	L	S	θ	e				
S10M-SDUCR/L07	●	●	13	10	9	150	7	-8°	0	I60M2.5×5.5	WT07IP		
S12M-SDUCR/L07	●	●	16	12	11	150	9	-8°	22				
S16M-SDUCR/L07	●	●	20	16	15	150	11	-6°	27	I60M2.5×6.5	WT07IP		
S16R-SDUCR/L07	●	●	20	16	15	200	11	-6°	27				
S20Q-SDUCR/L11	●	●	25	20	18	180	13	-6°	40	I60M3.5×8	WT15IP		
S20S-SDUCR/L11	●	●	25	20	18	250	13	-6°	40				
S25Q-SDUCR/L11	●	○	32	25	23	180	17	-6°	46	I60M3.5×10	WT15IP		
S25T-SDUCR/L11	●	●	32	25	23	300	17	-6°	46				
♦ A10H-SDUCR/L07	●	●	13	10	9.5	100	7	-8°	0	I60M2.5×5.5	WT07IP		
♦ A12K-SDUCR/L07	●	●	16	12	11.5	125	9	-8°	22				
♦ A16M-SDUCR/L07	●	●	20	16	15.5	150	11	-6°	27	I60M2.5×6.5	WT07IP		
♦ A20Q-SDUCR/L11	●	●	25	20	19	180	13	-6°	40				
♦ A25R-SDUCR/L11	●	●	32	25	24	200	17	-6°	46	I60M3.5×10	WT15IP		

Applicable insert Wendeschneidplatten		Extra Finishing Feinbearbeitung	Finishing Schlichten	Semi-finishing Mittlere Bearbeit.	Roughing Schruppen	Al machining Alu Bearbeitung	Cast iron machining Grauguss Bearbeit.
Application Anwendung	insert shape Schneidplattenform	SF  A102	HF  A102	HM  A103	HR  A104	LH  A104	Flat Flach  A104
			EF  A103	EM  A103		LC  A104	
Type Typ	**SDUCR/L07	DC**0702**	DC**0702**	DC**0702**		DCGX0702**	DC**0702**
	SDUCR/L11	DC11T3**	DC**11T3**	DC**11T3**	DC**11T3**	DCGX11T3**	DC**11T3**

♦ Toolholder with holes for Coolant · Klemmhalter mit Kühlmittelbohrung

● ex stock · ab Lager ○ on demand · auf Anfrage

Turning · Drehen

Internal turning tools · Drehwerkzeuge zur Innenbearbeitung

DC** Toolholder · Halter

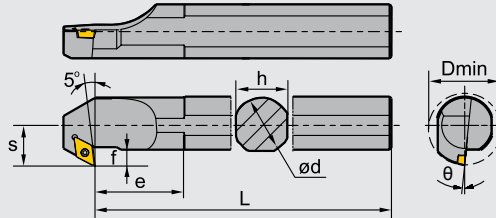
S-Clamping / S-Halter

SDZCR/L

Kr:85°












R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung								Screw Schraube	Wrench Schlüssel	Shim Unterlage	Shim/ Screw Schraube Unterlage
	R	L	Dmin	ød	h	L	S	θ	e	f				
S25Q-SDZCR/L11	●	●	32	25	23	180	17	-6°	30	6.9	I60M3.5×10	WT15IP		
S25T-SDZCR/L11	●	●	32	25	23	300	17	-6°	30	6.9				
S32R-SDZCR/L11	○	●	40	32	30	200	22	-6°	39	8.4	I60M3.5×12	WT15IP WH35L	D11BS	SM5×8.65XA
S32U-SDZCR/L11	●	●	40	32	30	350	22	-6°	39	8.4				
S40S-SDZCR/L11	●	●	50	40	37	250	27	-4°	47	9.4				
S40V-SDZCR/L11	●	●	50	40	37	400	27	-4°	47	9.4				
♦ A25R-SDZCR/L11	●	●	32	25	24	200	17	-6°	30	4.5	I60M3.5×10	WT15IP		
♦ A32S-SDZCR/L11	●	●	40	32	31	250	22	-6°	39	6.0	I60M3.5×12	WT15IP WH35L	D11BS	SM5×8.65XA

Applicable insert
Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schlichten	Semi-finishing Mittlere Bearbeit.	Roughing Schruppen	Al machining Alu Bearbeitung	Cast iron machining Grauguss Bearbeit.
insert shape Schneidplattenform	SF  A102	HF  A102	HM  A103	HR  A104	LH  A104	Flat Flach  A104
		EF  A103	EM  A103		LC  A104	
SDZCR/L11	DC11T3**	DC**11T3**	DC**11T3**	DC**11T3**	DCGX11T3**	DC**11T3**
Type Typ						

● ex stock · ab Lager ○ on demand · auf Anfrage ♦ Toolholder with holes for coolant · Klemmhalter mit Kühlmittelbohrung

SC** Toolholder · Halter

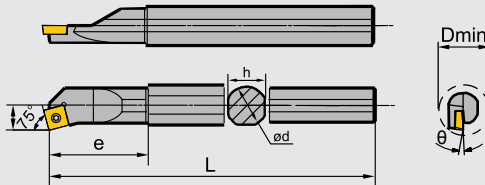
S-Clamping / S-Halter

SSKCR/L

Kr:75°



R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel	Shim Unterlage	Shim/ Screw Schraube Unterlage
	R	L	Dmin	ød	h	L	S	θ	e				
S12M-SSKCR/L09	●	●	16	12	11	150	9	-10	26	I60M3.5×8	WT15IP		
S16M-SSKCR/L09	●	●	20	16	15	150	11	-11	32.5				
S16R-SSKCR/L09	●	●	20	16	15	200	11	-11	32.5				
S20Q-SSKCR/L09	●	●	25	20	18	180	13	-6	34.5				
S20S-SSKCR/L09	●		25	20	18	250	13	-6	34.5				
S25Q-SSKCR/L12	●	●	32	25	23	180	17	-8	36.3	I60M4×11X	WT15IP	S12BS	SM6×10XA
S25T-SSKCR/L12	●	●	32	25	23	300	17	-8	36.3				
S32R-SSKCR/L12	●	●	40	32	30	200	22	-10	43.5				
S32U-SSKCR/L12	●		40	32	30	350	22	-10	43.5	I60M3.5×8	WT15IP		
◆ A12K-SSKCR/L09	●		16	12	11	125	9	-10	26				
◆ A16M-SSKCR/L09	●		20	16	15	150	11	-11	32.5				
◆ A20Q-SSKCR/L09	●		25	20	19	180	13	-6	34.5				
◆ A25R-SSKCR/L12	●	●	32	25	24	200	17	-8	41.3				
◆ A32S-SSKCR/L12	●		40	32	31	250	22	-10	42.8	I60M4×11X	WT15IP WH40L	S12BS	SM6×10XA

Applicable insert Wendeschneidplatten		Finishing Schlichten		Semi-finishing Mittlere Bearbeit.		Roughing Schruppen		Al machining Alu Bearbeitung		Cast iron machining Grauguss Bearbeit.	
Application Anwendung		HF		HM		HR		LH		Flat Flach	
insert shape Schneidplattenform		EF		EM				LC			
Type Typ	**SSKCR/L09	SC**09T3**		SC**09T3**		SC**09T3**		SCGX09T3**		SC**09T3**	
	SSKCR/L12			SC1204**		SC**1204**		SCGX1204**		SC**1204**	

◆ Toolholder with holes for Coolant · Klemmhalter mit Kühlmittelbohrung

● ex stock · ab Lager ○ on demand · auf Anfrage

Turning · Drehen

Internal turning tools · Drehwerkzeuge zur Innenbearbeitung

TC** Toolholder · Halter

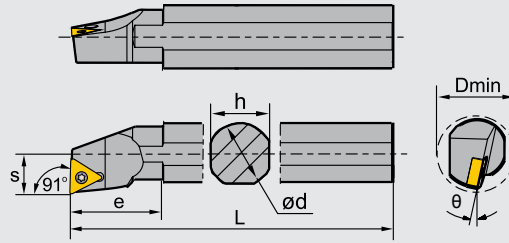
S-Clamping / S-Halter

STFCR/L

Kr:91°/*Kr:90°












R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel	Shim Unterlage	Shim/ Screw Schraube Unterlage
	R	L	Dmin	ød	h	L	S	θ	e				
S12M-STFCR/L11	●	●	16	12	11	150	9	-10°	30	I60M2.5×6.5	WT07IP		
S16M-STFCR/L11	○	○	20	16	15	150	11	-6°	35				
S16R-STFCR/L11	●	●	20	16	15	200	11	-6°	35				
S20Q-STFCR/L11	○	○	25	20	18	180	13	-3°	36				
S20S-STFCR/L11	●	●	25	20	18	250	13	-3°	36	I60M3.5×10	WT15IP		
S25Q-STFCR/L16	○	○	32	25	23	180	17	-6°	49				
S25T-STFCR/L16	●	●	32	25	23	300	17	-6°	49	I60M3.5×12	WT15IP WH35L	T16BS	SM5×8.65XA
S32R-STFCR/L16	○	○	40	32	30	200	22	-10°	50				
S32U-STFCR/L16	●	●	40	32	30	350	22	-10°	50				
S40S-STFCR/L16	○	○	50	40	37	250	27	-8°	60	I60M2.5×6.5	WT07IP		
S40V-STFCR/L16	●	●	50	40	37	400	27	-8°	60				
♦ A12K-STFCR/L11	●	●	16	12	11.5	125	9	-10°	26	I60M2.5×6.5	WT07IP		
♦ A16M-STFCR/L11	●	○	20	16	15.5	150	11	-6°	30				
♦ A20Q-STFCR/L11	●	●	25	20	19	180	13	-3°	36				
♦ A25R-STFCR/L16	●	●	32	25	24	200	17	-6°	45				
♦ A32S-STFCR/L16	●	○	40	32	31	250	22	-10°	49	I60M3.5×10	WT15IP		
										I60M3.5×12	WT15IP	T16BS	SM5×8.65XA

Applicable insert
Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schlichten	Semi-finishing Mittlere Bearbeit.	Roughing Schruppen	Al machining Alu Bearbeitung	Cast iron machining Grauguss Bearbeit.
insert shape Schneidplattenform	SF  A112	HF  A113	HM  A115	HR  A115	LH  A116	Flat Flach  A115
		EF  A114	EM  A114		LC  A116	
STFCR/L11	TC1102**	TC**1102**	TC**1102**	TC**1102**	TCGX1102**	TC**1102**
STFCR/L16	TC16T3**	TC**16T3**	TC**16T3**	TC**16T3**	TCGX16T3**	TC**16T3**

● ex stock · ab Lager ○ on demand · auf Anfrage ♦ Toolholder with holes for coolant · Klemmhalter mit Kühlmittelbohrung

VC** Toolholder · Halter

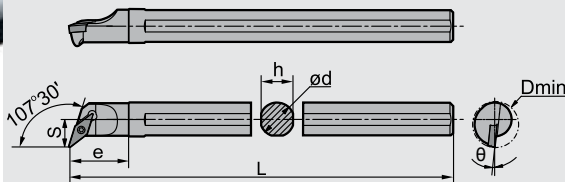
S-Clamping / S-Halter



SVQCR/L

Kr:107°30'






R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel		
	R	L	Dmin	ød	h	L	S	θ	e				
S16Q-SVQCR/L11	●	●	22	16	15	180	13	-6°	28	I60M2.5×6.5	WT07IP		
S20R-SVQCR/L11	●	○	26	20	18	200	15	-4°	32				

Applicable insert
Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schlichten	Al machining Alu Bearbeitung
insert shape Schneidplattenform	SF  A118	HF  A118	LH  A119
SVQCR/L11	VC1103**	VC**1103**	VCGX1103**
Type Typ			

◆ Toolholder with holes for Coolant · Klemmhalter mit Kühlmittelbohrung

● ex stock · ab Lager ○ on demand · auf Anfrage

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

Internal turning tools · Drehwerkzeuge zur Innenbearbeitung

VC** Toolholder · Halter

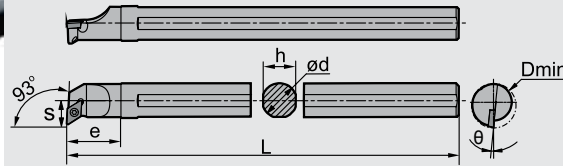
S-Clamping / S-Halter



SVUCR/L

Kr:93°






R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel		
	R	L	Dmin	ød	h	L	S	θ	e				
S16Q-SVUCR/L11	●	●	24	16	15	180	15	-6°	25	I60M2.5×6.5	WT07IP		
S20R-SVUCR/L11	●	●	28	20	18	200	17	-4°	30				

Applicable insert
Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schlichten	Al machining Alu Bearbeitung
insert shape Schneidplattenform	SF  A118	HF  A118	LH  A119
** -SVUCR/L11	VC**1103**	VC**1103**	VCGX1103**
Type Typ			

● ex stock · ab Lager ○ on demand · auf Anfrage ◆ Toolholder with holes for coolant · Klemhalter mit Kühlmittelbohrung

VB** Toolholder · Halter

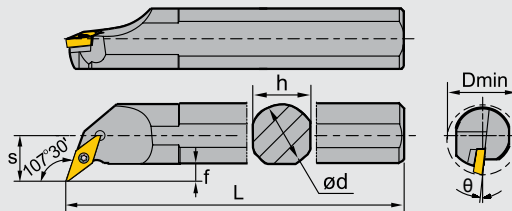
S-Clamping / S-Halter


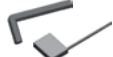


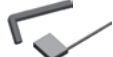
SVQBR/L

Kr:107°30'








R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung								Screw Schraube	Wrench Schlüssel	Shim Unterlage	Shim/ Screw Schraube Unterlage
	R	L	Dmin	ød	h	L	S	θ	e	f				
S32R-SVQBR/L16			40	32	30	200	22	-8°	56	8.4	I60M3.5×12		V16BS	SM5×8.65XA
S32U-SVQBR/L16	●	●	40	32	30	350	22	-8°	56	8.4				
S40S-SVQBR/L16			50	40	37	250	27	-8°	64	9.4				
S40V-SVQBR/L16	●	●	50	40	37	400	27	-8°	64	9.4				
◆ A32S-SVQBR/L16	○	○	40	32	31	250	22	-8°	56	8.4				

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Cast iron machining Grauguss Bearbeitung
insert shape Schneidplattenform	EF  A120	HM  A121	HR  A121	Flat Flach  A121
	HF  A120			
SVQBR/L16	VB1604**	VB**1604**	VB**1604**	VB**1604**
Type Typ				

◆ Toolholder with holes for Coolant · Klemhalter mit Kühlmittelbohrung

● ex stock · ab Lager ○ on demand · auf Anfrage

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

Internal turning tools · Drehwerkzeuge zur Innenbearbeitung

VB** Toolholder · Halter

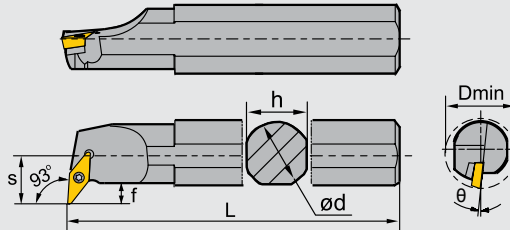
S-Clamping / S-Halter






SVUBR/L

Kr:93°










R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung								Screw Schraube	Wrench Schlüssel	Shim Unterlage	Shim/ Screw Schraube Unterlage
	R	L	Dmin	ød	h	L	S	θ	e	f				
S32R-SVUBR/L16	●	●	40	32	30	200	22	-8°	49	8.4	160M3.5×12		V16BS	SM5×8.65XA
S32U-SVUBR/L16	●	●	40	32	30	350	22	-8°	49	8.4				
S40S-SVUBR/L16	●	●	50	40	37	250	27	-8°	56.5	9.4				
S40V-SVUBR/L16	●	●	50	40	37	400	27	-8°	56.5	9.4				
◆ A32S-SVUBR/L16	●	●	40	32	31	250	22	-8°	49	8.4				

Applicable insert
Wendeschneidplatten

Application Anwendung	Finishing Schlichten	Semi-Finishing Mittlere Bearbeitung	Roughing Schruppen	Cast iron machining Grauguss Bearbeitung
insert shape Schneidplattenform	EF  A120	HM  A121	HR  A121	Flat Flach  A121
	HF  A120	EM  A121		
	NF  A120			
SVUBR/L16	VB1604**	VB**1604**	VB**1604**	VB**1604**
Type Typ				

● ex stock · ab Lager ○ on demand · auf Anfrage ◆ Toolholder with holes for coolant · Klemhalter mit Kühlmittelbohrung

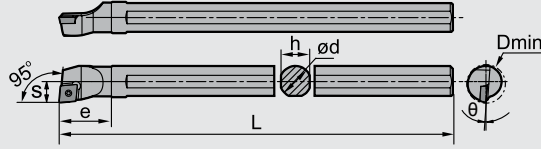
CP** Toolholder · Halter

S-Clamping / S-Halter

SCLPR/L Kr:95°



R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel		
	R	L	Dmin	ød	h	L	S	θ	e				
S10K-SCLPR/L06	●	●	12	10	9	125	6	-7°	17	I60M2.5×5.5	WT07IP		
S12M-SCLPR/L06	●	●	16	12	11	150	8	-4°	20				
S16Q-SCLPR/L09	●	●	20	16	15	180	10	-4°	29	I60M3.5×8	WT15IP		
S20R-SCLPR/L09	○	○	25	20	18	200	13	-4°	35				

Applicable insert
Wendeschneidplatten

Application
Anwendung

Extra Finishing
Feinbearbeitung

insert shape
Schneidplattenform

SF



A101

Type Typ		
SCLPR/L06		CP0602**
SCLPR/L09		CP09T3**

◆ Toolholder with holes for Coolant · Klemmhalter mit Kühlmittelbohrung

● ex stock · ab Lager ○ on demand · auf Anfrage

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

Internal turning tools · Drehwerkzeuge zur Innenbearbeitung

DP** Toolholder · Halter

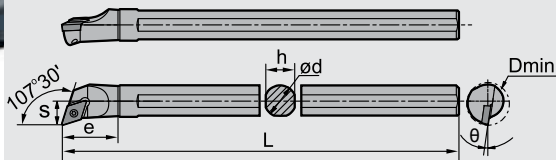
S-Clamping / S-Halter

SDQPR/L

Kr:107°30'



R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel		
	R	L	Dmin	ød	h	L	S	θ	e				
S10K-SDQPR/L07	●	●	13	10	9	125	7	-8°	20	I60M2.5×5.5	WT07IP		
S12M-SDQPR/L07	●	●	16	12	11	150	9	-8°	22				
S16Q-SDQPR/L07	●	●	20	16	15	180	11	-6°	27	I60M2.5×6.5			
S16Q-SDQPR/L11	●	●	20	16	15	180	11	-6°	32	I60M3.5×8	WT15IP		
S20R-SDQPR/L11	●	●	25	20	18	200	13	-6°	33				

Applicable insert
Wendeschneidplatten

Application
Anwendung

Extra Finishing
Feinbearbeitung

insert shape
Schneidplattenform

SF



A105

Type Typ	**SDQPR/L07	DP**0702**
	SDQPR/L11	DP11T3**

● ex stock · ab Lager ○ on demand · auf Anfrage ◆ Toolholder with holes for coolant · Klemmhalter mit Kühlmittelbohrung

DP** Toolholder · Halter

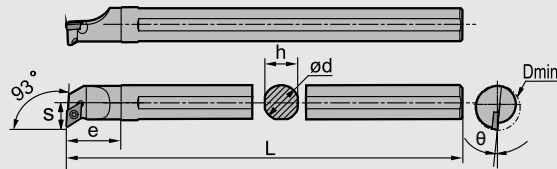
S-Clamping / S-Halter



SDUPR/L


Kr:93°



R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel		
	R	L	Dmin	ød	h	L	S	θ	e				
S10K-SDUPR/L07	●	●	15	10	9	125	9	-8°	18	I60M2.5×5.5	WT071P		
S12M-SDUPR/L07	●	●	16	12	11	150	9	-8°	19				
S16Q-SDUPR/L07	●	●	20	16	15	180	11	-6°	25			I60M2.5×6.5	

Applicable insert Wendeschneidplatten	
Application Anwendung	Extra Finishing Feinbearbeitung
insert shape Schneidplattenform	SF 
	A105
Type Typ	**SDUPR/L07 DP**0702**

◆ Toolholder with holes for Coolant · Klemmhalter mit Kühlmittelbohrung

● ex stock · ab Lager ○ on demand · auf Anfrage

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

Internal turning tools · Drehwerkzeuge zur Innenbearbeitung

TP** Toolholder · Halter

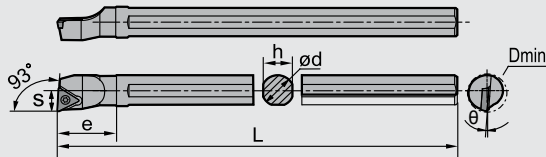
S-Clamping / S-Halter



STUPR/L

Kr:93°



R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel		
	R	L	Dmin	ød	h	L	S	θ	e				
S10K-STUPR/L09	●	●	12	10	9	125	6	-6°	20	I60M2.2×5.5	WT07IP		
S12M-STUPR/L09	●	●	16	12	11	150	8	-4°	22				
S12M-STUPR/L11	●	●	16	12	11	150	8	-4°	25	I60M2.5×6.5	WT07IP		
S16Q-STUPR/L11	●	●	20	16	15	180	10	-3°	27				

Applicable insert
Wendeschneidplatten

Application
Anwendung

Extra Finishing
Feinbearbeitung

insert shape
Schneidplattenform

SF



A117

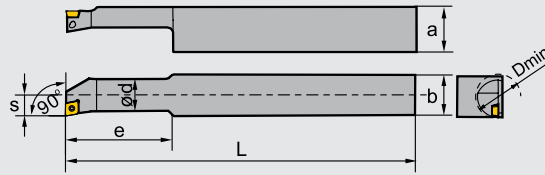
Type Typ	**STUPR/L09	TP**0902**
	STUPR/L11	TP1103**



● ex stock · ab Lager ○ on demand · auf Anfrage ♦ Toolholder with holes for coolant · Klemmhalter mit Kühlmittelbohrung










CC** Toolholder · Halter

S-Clamping / S-Halter

SCFCR Kr:90°



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel		
	R	L	Dmin	ød	L	s	a	b	e				
S10M-SCFCR/L06S25	●	●	13	10	150	7	27	25	30	I60M2.5×5.5	WT07IP		
S12P-SCFCR/L06S25	●		16	12	170	9	27	25	35	I60M2.5×6.5			
S16Q-SCFCR/L09S25	●	●	20	16	180	11	27	25	40	I60M3.5×8	WT15IP		
S20R-SCFCR/L09S25	●		25	20	200	13	27	25	45				
S25R-SCFCR/L12S25	●		32	25	200	17	27	25	50	I60M5×13	WT20IP		

Applicable insert Wendeschneidplatten		Extra Finishing Feinbearbeitung	Finishing Schlichten	Semi-finishing Mittlere Bearbeit.	Roughing Schruppen	Al machining Alu Bearbeitung	Cast iron ma. Grauguss Bear.					
Application Anwendung	SF	 A98	HF	 A98	HM	 A99	HR	 A100	LH	 A100	Flat Flach	 A100
	insert shape Schneidplattenform		EF	 A99	EM	 A99			LC	 A100		
Type Typ	**SCFCR06	CC**0602**	CC**0602**	CC**0602**	CC**0602**	CCG0602**	CC**0602**					
	SCFCR09	CC09T3**	CC**09T3**	CC**09T3**	CC**09T3**	CCG09T3**	CC**09T3**					
	SCFCR12	CC1204**	CC**1204**	CC**1204**	CC**1204**	CCG1204**	CC**1204**					

◆ Toolholder with holes for Coolant · Klemmhalter mit Kühlmittelbohrung

● ex stock · ab Lager ○ on demand · auf Anfrage

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

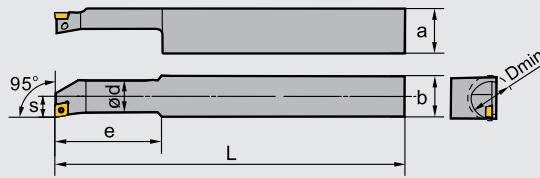
Internal turning tools · Drehwerkzeuge zur Innenbearbeitung

CC** Toolholder · Halter

S-Clamping / S-Halter










SCLCR

Kr:95°



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel		
	R	L	Dmin	ød	L	s	a	b	e				
S10M-SCLCR06S20	○		13	10	150	7	22	20	30	I60M2.5×5.5	WT07IP		
S12P-SCLCR06S20	●		16	12	170	9	22	20	35				
S16Q-SCLCR09S20	●		20	16	180	11	22	20	40	I60M3.5×8	WT15IP		
S20R-SCLCR09S20	●		25	20	200	13	22	20	60				

Applicable insert
Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schlichten	Semi-finishing Mittlere Bearbeit.	Roughing Schruppen	Al machining Alu Bearbeitung	Cast iron Grauguss Bear.	
insert shape Schneidplattenform	SF  A98	HF  A98	HM  A99	HR  A100	LH  A100	Flat Flach  A100	
		EF  A99	EM  A99		LC  A100		
Type Typ	**SCLCR06S20	CC**0602**	CC**0602**	CC**0602**	CC**0602**	CCGX0602**	CC**0602**
	SCLCR09S20	CC09T3**	CC**09T3**	CC**09T3**	CC**09T3**	CCGX09T3**	CC**09T3**

● ex stock · ab Lager ○ on demand · auf Anfrage ♦ Toolholder with holes for coolant · Klemhalter mit Kühlmittelbohrung



Anti Vibration Boring Bar

Anti Vibration Bohrstange

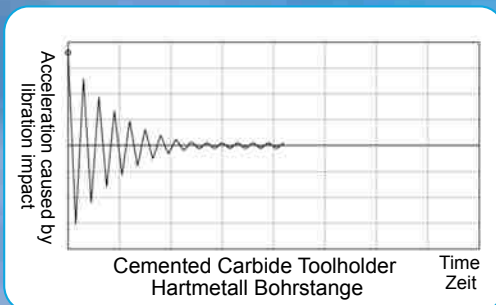
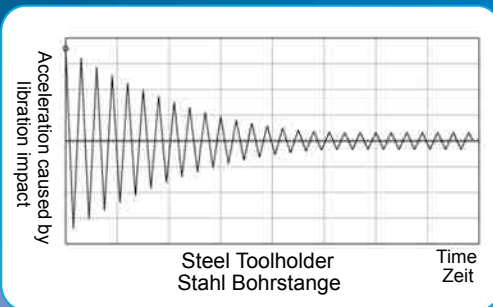
Technical features · Technische Merkmale

By increasing the rigidity of the tool materials the vibration will be reduced. The carbide toolholder performs much better than steel toolholder. The cutting data can be increased and the shank overhang extended. Therefore you achieve better surface and higher workpiece precision.

Durch den Einsatz von Hartmetall als Werkzeugmaterial wird die Stabilität des Werkzeuges verbessert, und Vibrationen werden reduziert.

Die Hartmetall-Bohrstange erlaubt durch die Stabilität höhere Schnittleistungen und eine größere Auskragung. Darüberhinaus wird eine höhere Werkstückpräzision und eine exzellente Oberflächenqualität erzielt.

Vibration amplitude · Schwingungsausschlag



Under same machining conditions:

Bei gleichen Bearbeitungsbedingungen:

The maximum overhang of carbide toolholder is ca. $L \leq 6D$

Die maximale Auskragung beim Einsatz von Hartmetall-Bohrstangen beträgt ca. $L \leq 6D$

The maximum overhang of steel toolholder is suggested to be ca. $L \leq 3D$

Die maximale Auskragung beim Einsatz von Stahl-Bohrstangen beträgt ca. $L \leq 3D$

Turning · Drehen

Internal turning tools · Drehwerkzeuge zur Innenbearbeitung

CP** / CC** Toolholder · Halter

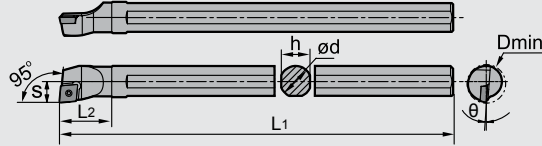
S-Clamping / S-Halter

SCLPR/L SCLCR/L

Kr:95°



R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel	Shim Unterlage	Shim/ Screw Schraube Unterlage
	R	L	ØD	ød	s	L1	L2	h	θ				
C10M-SCLPR/L06	●	●	12	10	6	150	17	9	7°	I60M2.5×5.5	WT07IP		
C12Q-SCLPR/L06	●	●	16	12	8	180	20	11	4°				
C16R-SCLPR/L09	●	●	20	16	10	200	29	15	4°				
C20S-SCLPR/L09	●	●	25	20	13	250	35	18	4°	I60M3.5×8	WT15IP		
◆ E16R-SCLPR/L09	○	○	19	16	10	200	-	15.5	-2°				
◆ E20S-SCLPR/L09	○	○	24	20	13	250	-	19.5	-2°	I60M3.5×10	WT15IP		
◆ E08K-SCLCR/L06-9	●	○	9	8	5	125	-	7.5	-12°				
◆ E08K-SCLCR/L06-10	●	○	10	8	6	125	-	7.5	-12°	I60M2.5×5.5	WT07IP		
◆ E10M-SCLCR/L06	●	○	12	10	7	150	-	9.5	-10°				
◆ E12Q-SCLCR/L06	●	○	15	12	9	180	-	11.5	-10°				
◆ E12Q-SCLCR/L09	●	●	15	12	9	180	-	11.5	-9°	I60M3.5×8	WT15IP		
◆ E16R-SCLCR/L06	●	○	18	16	10	200	-	15.5	-8°	I60M2.5×5.5	WT07IP		
◆ E16R-SCLCR/L09	●	●	18	16	10	200	-	15.5	-10°	I60M3.5×10	WT15IP		
◆ E20S-SCLCR/L09	●	●	24	20	13	250	-	19.5	-8°				
◆ E25T-SCLCR/L09	●	●	31	25	17	300	-	24	-6°				

more diameter on demand

Weitere Durchmesser auf Anfrage

Applicable insert
Wendeschneidplatten

Application
Anwendung

Extra Finishing
Feinbearbeitung

insert shape
Schneidplattenform

SF



A101

Type Typ	Application Anwendung	Extra Finishing Feinbearbeitung
C*-SCLPR/L06		CP**0602**
C*--SCLPR/L09		CP**09T3**
E*-SCLCR/L06		CC**0602**
E*--SCLCR/L09		CC**09T3**

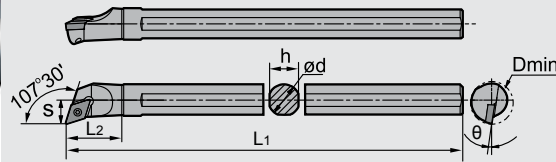
● ex stock · ab Lager ○ on demand · auf Anfrage ◆ Toolholder with holes for coolant · Klemmhalter mit Kühlmittelbohrung



DP** / DC** Toolholder · Halter S-Clamping / S-Halter

SDQPR/L
SDQCR/L
Kr:107°30'




R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel		
	R	L	ØD	ød	s	L1	L2	h	θ				
C10M-SDQPR/L07	●	●	13	10	7	150	20	9	8°	I60M2.5×5.5	WT07IP		
C12Q-SDQPR/L07	●	●	16	12	9	180	22	11	8°				
C16R-SDQPR/L07	●	○	20	16	11	200	27	15	6°			I60M2.5×6.5	
C16R-SDQPR/L11	●	●	20	16	11	200	32	15	6°	I60M3.5×8	WT15IP		
C20S-SDQPR/L11	●	○	25	20	13	250	33	18	6°				
◆ E08K-SDQCR/L07	●	○	11	8	6.5	140	-	7.5	-12°	I60M2.5×5.5	WT07IP		
◆ E10M-SDQCR/L07	●	○	12	10	7	150	-	9.5	-10°				
◆ E12Q-SDQCR/L07	●	○	15	12	9	180	-	11.5	-10°				
◆ E16R-SDQCR/L07	●	○	18	16	10	200	-	15.5	-6°				
◆ E16R-SDQCR/L11	●	○	18	16	10	200	-	15.5	-8°			I60M3.5×10	WT15IP
◆ E20S-SDQCR/L07	●	○	24	20	13	250	-	19.5	-4°	I60M2.5×5.5	WT07IP		
◆ E20S-SDQCR/L11	●	○	24	20	13	250	-	19.5	-8°	I60M3.5×10	WT15IP		
◆ E25T-SDQCR/L11	●	○	31	25	17	300	-	24	-6°				

more diameter on demand
Weitere Durchmesser auf Anfrage

Applicable insert Wendeschneidplatten	
Application Anwendung	Extra Finishing Feinbearbeitung
insert shape Schneidplattenform	SF  A105
C*-SDQPR/L07	DP**0702**
C*-SDQPR/L11	DP**11T3**
E*-SDQCR/L07	DC**0702**
E*-SDQCR/L11	DC**11T3**

◆ Toolholder with holes for Coolant · Klemmhalter mit Kühlmittelbohrung ● ex stock · ab Lager ○ on demand · auf Anfrage

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

Internal turning tools · Drehwerkzeuge zur Innenbearbeitung

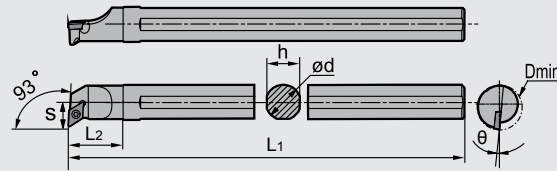
DP** / DC** Toolholder · Halter



S-Clamping / S-Halter

SDUPR/L
SDUCR/L
Kr:93°



R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel		
	R	L	ØD	ød	s	L1	L2	h	θ				
C10M-SDUPR/L07	●	●	15	10	9	150	18	9	8°	I60M2.5×5.5	WT07IP		
C12Q-SDUPR/L07	●	●	16	12	9	180	19	11	8°	I60M2.5×6.5			
C16R-SDUPR/L07	○	○	20	16	11	200	25	15	6°				
◆ E10M-SDUCR/L 07	●	○	12	10	7	150	-	9.5	-10°	I60M2.5×5.5	WT07IP		
◆ E12Q-SDUCR/L 07	●	●	15	12	9	180	-	11.5	-10°				
◆ E16R-SDUCR/L 07	●	○	18	16	10	200	-	15.5	-6°	I60M3.5×10	WT15IP		
◆ E16R-SDUCR/L 11	●	○	18	16	10	200	-	15.5	-8°				
◆ E20S-SDUCR/L 07	○	○	24	20	13	250	-	19.5	-4°	I60M2.5×5.5	WT07IP		
◆ E20S-SDUCR/L 11	○	○	24	20	13	250	-	19.5	-8°	I60M3.5×10	WT15IP		
◆ E25T-SDUCR/L 11	○	○	31	25	17	300	-	24	-6°				

more diameter on demand
Weitere Durchmesser auf Anfrage

Applicable insert
Wendeschneidplatten

Application
Anwendung

Extra Finishing
Feinbearbeitung

insert shape
Schneidplattenform

SF



A105

Type Typ	C*-SDUPR/L07	DP**0702**
	E*-SDUCR/L07	DC**0702**
	E*-SDUCR/L11	DC**11T3**

● ex stock · ab Lager ○ on demand · auf Anfrage ◆ Toolholder with holes for coolant · Klemhalter mit Kühlmittelbohrung

TP** Toolholder · Halter

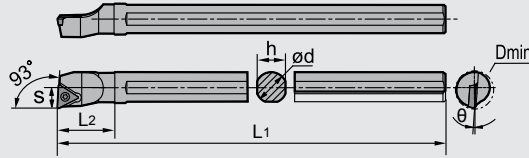
S-Clamping / S-Halter



STUPR/L

Kr:93°



R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel		
	R	L	ØD	ød	s	L ₁	L ₂	h	θ				
C10M-STUPR/L09	○	●	12	10	6	150	20	9	6°	I60M2.2×5.5	WT07IP		
C12Q-STUPR/L09	●	○	16	12	8	180	22	11	4°				
C12Q-STUPR/L11	●	○	16	12	8	180	25	11	4°	I60M2.5×6.5	WT07IP		
C16R-STUPR/L11	○	○	20	16	10	200	27	15	3°				

Applicable insert
Wendeschneidplatten

Application
Anwendung

Extra Finishing
Feinbearbeitung

insert shape
Schneidplattenform

SF



A117

Type Typ		
C*-STUPR/L09	TP**0902**	
C*-STUPR/L11	TP**1103**	

◆ Toolholder with holes for Coolant · Klemmhalter mit Kühlmittelbohrung

● ex stock · ab Lager ○ on demand · auf Anfrage

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

Internal turning tools · Drehwerkzeuge zur Innenbearbeitung

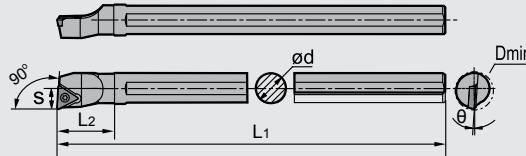
TC** Toolholder · Halter

S-Clamping / S-Halter

STFCR/L
STFPR/L
Kr:90°



R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel		
	R	L	ØD	ød	s	L ₁	L ₂	h	θ				
◆ E08K-STFCR/L 09	○	○	11	8	6	125	-	7.5	-12	I60M2.2×5.5	WT07IP		
◆ E10M-STFCR/L 09	○	○	12	10	7	150	-	9.5	-10				
◆ E12Q-STFCR/L 11	○	○	15	12	9	180	-	11.5	-10	I60M2.5×5.5	WT07IP		
◆ E16R-STFCR/L 11	○	○	18	16	10	200	-	15.5	-8				
◆ E20S-STFCR/L 11	○	○	24	20	13	250	-	19.5	-8	I60M3.5×10	WT15IP		
◆ E20S-STFCR/L 16	○	○	24	20	13	250	-	19.5	-8				
◆ E25T-STFCR/L 16	○	○	31	25	17	300	-	24	-6				
◆ E10M-STFPR/L 11	○	○	12	10	6	150	-	9.5	-5	I60M3.0×7.0	WT08IP		
◆ E12Q-STFPR/L 11	○	○	15	12	8	180	-	11.5	-4				
◆ E16R-STFPR/L 11	○	○	19	16	10	200	-	15.5	-2				
◆ E20S-STFPR/L 11	○	○	24	20	13	250	-	19	-2				

more diameter on demand
Weitere Durchmesser auf Anfrage

Applicable insert
Wendeschneidplatten

Application
Anwendung

Extra Finishing
Feinbearbeitung

insert shape
Schneidplattenform

SF



A117

Type Typ	E*-STFCR/L09	TC**0902**
	E*-STFCR/L11	TC**1103**
	E*-STFCR/L16	TC**16T3**
	E*-STFPR/L11	TP**1103**

● ex stock · ab Lager ○ on demand · auf Anfrage ◆ Toolholder with holes for coolant · Klemmhalter mit Kühlmittelbohrung

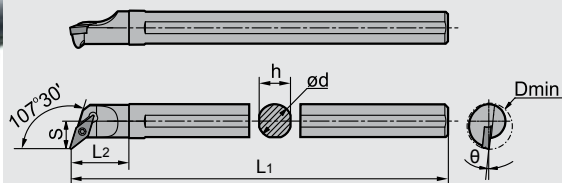
VC** Toolholder · Halter



S-Clamping / S-Halter

SVQCR/L Kr:107°30'






R type
Rechtsausführung



Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel		
	R	L	ØD	ød	s	L1	L2	h	θ				
C16R-SVQCR/L11	●	●	22	16	13	200	28	15	-6°	I60M2.5×6.5	WT07IP		
C20S-SVQCR/L11	●	●	26	20	15	250	32	18	-4°				

Applicable insert
Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schlichten	Al machining Alu Bearbeitung	
insert shape Schneidplattenform	SF  A118	HF  A118	LH  A119	
Type Typ	C*-SVQCR/L11	VC**1103**	VC**1103**	VCGX1103**
	C*-SVUCR/L11	VC**1103**	VC**1103**	VCGX1103**

◆ Toolholder with holes for Coolant · Klemmhalter mit Kühlmittelbohrung

● ex stock · ab Lager ○ on demand · auf Anfrage

A

General Turning
Allgemeine Drehbearbeitung

Turning · Drehen

Internal turning tools · Drehwerkzeugen zur Innenbearbeitung

VC** Toolholder · Halter

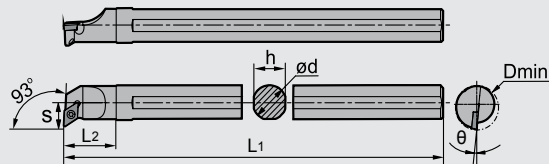
S-Clamping / S-Halter

SVUCR/L

Kr:93°



R type
Rechtsausführung






Type Typ	Stock Lager		Dimension (mm) Abmessung							Screw Schraube	Wrench Schlüssel		
	R	L	ØD	ød	s	L1	L2	h	θ				
C16R-SVUCR/L11	●	●	24	16	15	200	25	15	6°	I60M2.5×6.5	WT07IP		
C20S-SVUCR/L11	●	●	28	20	17	250	30	18	4°				
◆ E16R-SVUCR/L 11	○	○	22	16	13	200	-	15	-6.5°	I60M2.5×6.5	WT07IP		
◆ E20S-SVUCR/L 11	○	○	27	20	13	250	-	18	-6.5°				
◆ E25T-SVUCR/L 16	○	○	35	25	20.5	300	-	23	-6.5°	I60M3.5×10	WT15IP		

more diameter on demand

Weitere Durchmesser auf Anfrage

Applicable insert
Wendeschneidplatten

Application Anwendung	Extra Finishing Feinbearbeitung	Finishing Schlichten	Al machining Alu Bearbeitung
insert shape Schneidplattenform	SF  A118	HF  A118	LH  A119
C*-SVUCR/L11	VC**1103**	VC**1103**	VCGX1103**
E*-SVUCR/L11	VC**1103**	VC**1103**	VCGX1103**

● ex Stock Lager · ab Lager ○ on demand · auf Anfrage

◆ Toolholder with wholes for Coolant · Klemhalter mit Kühlmittelbohrung

■ Recommended cutting data · Empfohlene Schnittdaten

ISO	Workpiece Materials Werkstückstoff		Hardness · Härte HB	CVD Coating Beschichtung					PVD Coating Beschicht.			Cermet Cermet	Coated cermet Coated cermet	Ceramic Keramik					
				YBC151	YBC251	YBC152	YBC252	YBC351	YBG102	YBG202		YNG151	YNG151C		CA1000	CN2000			
				Feed rate Vorschub (mm/rev)															
				0.1-0.6	0.1-0.8	0.1-0.6	0.1-0.8	0.2-1.0	0.2-0.4	0.1-0.6		0.05-0.2	0.05-0.2			0.1-1.5	0.1-1.5		
		Cutting speed Schnittgeschwindigkeit (m/min)																	
P	Carbon steel Kohlenstoffstahl	C=0.15%	125	430-200	430-190	500-270	480-240	380-165	460-220	380-180		550-350	580-350			800-300			
		C=0.35%	150	380-180	410-180	460-250	460-230	300-150	440-210	300-170		500-300	520-300			600-200			
		C=0.60%	200	330-150	350-150	400-220	400-200	260-130	380-180	260-150		460-260	480-260			400-150			
	Alloy steel legierter Stahl	low alloy, annealed geglüht	180	350-170	350-150	400-180	400-200	200-100	380-180	200-120		410-240	430-240			150-180	400-150		
		low alloy, tempered vergütet	275	230-100	210-100	280-150	260-140	140-70	240-120	140-90		300-180	320-180			350-120	300-100		
		low alloy, tempered vergütet	300	210-100	190-70	260-150	240-120	125-60	220-100	125-80		250-170	270-170			300-100	250-80		
	High alloy steel Hochlegierter	high alloy, annealed geglüht	200	320-150	260-120	360-190	310-170	175-80	290-150	175-100		350-200	370-200			400-150	350-120		
		high alloy, tempered vergütet	325	140-90	100-50	190-130	150-100	85-40	130-80	85-60		170-110	190-110			300-100	280-80		
	Cast steel Stahlguß	Non-Alloy unlegiert	180	240-120	200-100	280-160	250-140	135-75	230-125	135-95		260-170	280-170			600-220			
		Low alloy niedrig legiert	200	230-70	170-60	280-110	220-110	120-80	200-90	120-100		260-170	280-170			400-150			
		High alloy hoch legiert	225	160-70	140-50	210-110	190-100	95-55	170-80	95-55		260-100	280-100			350-120			
	ISO	Workpiece Materials Werkstückstoff		Hardness · Härte HB	CVD Coating Beschichtung					PVD Coating Beschicht.			Cermet Cermet	Coated cermet Coated cermet					
YBM151					YBM153	YBM251	YBM253		YBG202	YBG205		YNG151	YNG151C						
Feed rate Vorschub (mm/rev)																			
0.2-0.6					0.2-0.6	0.2-0.6	0.2-0.6		0.1-0.3	0.1-0.3		0.05-0.2	0.05-0.2						
		Cutting speed Schnittgeschwindigkeit (m/min)																	
M	Stainless steel Rostfreier Stahl	Ferrous Ferrous	200	250-180	280-180	230-140	250-140		240-170	250-170		330-220	350-210						
		Austenite Austenite	260	220-150	250-150	180-110	200-110		180-110	200-100		250-150	270-140						
		Martensite Martensite	330	110-60	130-60	90-50	110-50		120-80	130-80		270-170	290-160						

Turning · Drehen

Application information · Anwendungsinformation

Recommended table of cutting parameters for general turning Empfohlene Schnittparameter für allgemeine Drehbearbeitung

ISO	Workpiece Materials Werkstückstoff		Hardness · Härte HB	CVD Coating Beschichtung				Cermet Cermet	Coated cermet Coated cermet	Ceramic Keramik						
				YBD052	YBD102	YBD152	YBD152C			YNG151	YNG151C	CA1000	CN1000	CN2000		
				Feed rate Vorschub (mm/rev)												
				0.1-0.4	0.1-0.4	0.1-0.5	0.1-0.5		0.1-0.4	0.1-0.4	0.1-1.5	0.1-1.5	0.1-1.5			
				Cutting speed Schnittgeschwindigkeit (m/min)												
K	Malleable cast iron Temperguss	Ferrous Ferrous	130	350-230	330-220	320-105	320-105		280-160	300-180	1200-200	800-600	800-600			
		Pearlite Pearlite	230	250-105	230-100	230-100	230-100		220-120	240-150	1000-200	700-500	700-500			
	Low cast iron Grauguss	180	520-200	480-200	480-190	480-190		400-250	420-270	1200-200	800-600	700-500				
	High cast iron Grauguss	260	230-120	220-115	210-100	210-100		360-240	380-260	1000-200	750-500	800-600				
	Nodular cast iron Nodular cast iron	Ferrous Ferrous	160	310-150	300-150	290-140	290-140		330-190	350-210	800-200	600-450	600-450			
		Pearlite Pearlite	250	230-110	220-105	210-100	210-100		310-200	330-220	700-200	500-350	500-350			
ISO	Workpiece Materials Werkstückstoff		Hardness · Härte HB	PVD Coating Beschichtung		Cemented carbide Hartmetall										
				YBG102	YBG105		YD101									
				Feed rate Vorschub (mm/rev)												
				0.05-0.15		0.05-0.35										
Cutting speed Schnittgeschwindigkeit (m/min)																
N	Al alloy Al Legierung	No heat treatment keine Wärmebeh.	60			1750-800										
		Heat treatment Wärmebeh.	100			510-250										
	Cast aluminum alloy Alu. leg.	No heat treatment keine Wärmebeh.	75			460-175										
		Heat treatment Wärmebeh.	90			300-110										
	Copper alloy Kupfer leg.	Cu-alloy short chip Cu-Leg. kurzspanend	110			610-205										
		Messing, Bronze Rotguss	90			310-195										
unalloy electrolytic Copper unlegiert Elektrolyt Kupfer		100			225-115											
S	Ni-base alloy Ni-base alloy	40	90-30	100-30	70-20											
I	Other materials Andere Materialien	Hard steel Harte Stahl	45 HRC													
		Super hard steel Super harte Stahl	50-60 HRC													
		Chilled cast iron gekühlt Gusseisen	500													

A

General Turning
Allgemeine Drehbearbeitung

■ Correctional cutting parameters table of internal turning Schnittparameter Übersicht zur Innendrehbearbeitung

Internal turning tools by P type clamping · Drehwerkzeuge (Innen) P Typ Klemmung

Workpiece material Werkstück Material	Hardness HB Härte	Machining category Anwendung	L/D≤3		L/D=3-4 (Diameter of shank ≥ Φ16mm) (Schaftdurchmesser ≥ Φ16mm)	
			Feed rate Vorschub (mm/rev)	Cutting depth Schnitttiefe (mm)	Feed rate Vorschub (mm/rev)	Cutting depth Schnitttiefe (mm)
P Carbon steel, Alloy steel Kohlenstoff Stahl, Stahlleg. 45#, 42CrMo	HB180—280	Semi-finishing Mittlere Bear.	0.1- 0.25 -0.4	<5.0	0.1- 0.2 -0.3	<4.0
M Stainless steel Rostfreier Stahl 1Cr18Ni9Ti 0Cr18Ni9	≤HB220	Semi-finishing Mittlere Bear.	0.1- 0.2 -0.3	<4.0	0.1- 0.15 -0.25	<3.0
K Cast iron HT250 Gusseisen	HB170—230	Semi-finishing Mittlere Bear.	0.1- 0.25 -0.4	<5.0	0.1- 0.2 -0.3	<4.0

Internal turning tools by S type clamping · Drehwerkzeuge (Innen) S Typ Klemmung

Workpiece material Werkstück Material	Hardness HB Härte	Machining category Anwendung	L/D≤3		L/D=4		L/D=5		L/D=6	
			Feed rate Vorschub (mm/rev)	Cutting depth Schnitttiefe (mm)	Feed rate Vorschub (mm/rev)	Cutting depth Schnitttiefe (mm)	Feed rate Vorschub (mm/rev)	Cutting depth Schnitttiefe (mm)	Feed rate Vorschub (mm/rev)	Cutting depth Schnitttiefe (mm)
P Carbon steel, Alloy steel Kohlenst. Stahl, leg. Stahl 45#, 42CrMo	HB180-280	For finishing Schlichten	0.05- 0.1 -0.15	<0.2	0.05- 0.1 -0.15	<0.2	-	-	-	-
		For semi-finishing Mittlere Bear.	0.15- 0.25 -0.35	<3.0	0.1- 0.15 -0.2	<1.5	-	-	-	-
M Stainless steel Rostfreier Stahl 1Cr18Ni9Ti 0Cr18Ni9	≤HB220	For finishing Schlichten	0.05- 0.1 -0.15	<0.2	0.05- 0.1 -0.15	<0.2	-	-	-	-
		For semi-finishing Mittlere Bear.	0.15- 0.2 -0.25	<2.0	0.1- 0.15 -0.2	<1.0	-	-	-	-
N Al Alloy Al Leg.	---	For finishing Schlichten	0.05- 0.1 -0.15	<0.2	0.05- 0.1 -0.15	<0.2	0.05- 0.1 -0.15	-0.15	0.05- 0.1 -0.15	<0.1
		For semi-finishing Mittlere Bear.	0.05- 0.1 -0.15	<2.0	0.05- 0.1 -0.15	<1.5	0.05- 0.1 -0.15	-1.0	0.05- 0.1 -0.15	<1.0

Antivibration internal turning tools · Antivibrations Drehwerkzeuge (Innen)

Workpiece material Werkstück Material	Machining conditions Anwendung	Chipbreaker Spanbrecher	Grade Sorte	Feed rate Vorschub (mm/rev)	Cutting depth Schnitttiefe (mm)
P Steel HB180—280 Stahl	Finishing Schlichten	SF	YNG151 YNG151C	0.05- 0.2 -0.35	0.05- 0.1-0.3 -0.5
M Stainless steel ≤HB220 Rostfreier Stahl				0.05- 0.2 -0.35	0.05- 0.1-0.3 -0.5
K Cast iron HB170—230 Gusseisen				0.05- 0.2 -0.35	0.05- 0.1-0.3 -0.5

The characters in blue color are recommended cutting parameters.
Die blaue Ziffern sind empfohlene Schnittdaten.

Turning · Drehen

Application information · Anwendungsinformation

A

General Turning
Allgemeine Drehbearbeitung

No.	Tool wear type	Situation	Reason	Countermeasures
1+2	Flank wear	Poor surface quality and inconsistent measurement. Increase in cutting force.	Grade is too soft Cutting speed is too high. Flank angle is too small. Feed rate is too low	Select grade with higher wear resistance Reduce cutting speed Increase flank angle. Increase feed rate
3	Crater wear	Bad surface and chip control	Grade is too soft. Cutting speed is too high. Feed rate is too high.	Select grade with higher wear resistance Reduce cutting speed Reduce feed rate
4	Chipping	Tool life not stable Sudden breakage of cutting edge	Grade is too hard. Feed rate is too high. Cutting edge strength not strong enough The rigidity of holder is insufficient (vibration)	Select grade with higher toughness Reduce feed rate Change honing of cutting edge Use holder with bigger shank size
5	Fracturing	Cutting force increasing Surface roughness and measure becomes bad	Grade is too hard. Feed rate is too high. Cutting edge strength not strong enough The rigidity of holder is insufficient	Select grade with higher toughness Reduce feed rate Change honing of cutting edge Use holder with bigger shank size
6	Plastic deformation	Inconsistent measure meet. Damage to the cutting edge	Grade is too soft. Cutting speed is too high. Depth of cut and feed rate too high Cutting temperature is high	Grade with high wear resistance. Reduce cutting speed Decrease depth of cut and feed rate. Grade with high thermal conductivity.
7	Welding	Poor surface quality and inconsistent measurement. Increase in cutting force.	Cutting speed is low. Cutting edge not sharp enough Grade not suitable	Increase cutting speed Increase rake angle. Select grade with lower affinity
8	Thermal Cracks	Break due to thermal variation effect often caused when cutting is interrupted.	Expansion or shrinkage due to cutting heat Grade is too hard.	Use dry cutting Select grade with higher toughness
9	Notch wear	Burr increase of Cutting force information	Unstable cutting condition (uncut surface, chilled parts, machining hardened layer) Friction caused by jagged shape chips. Feed rate and cutting speed too high	Grade with high wear resistance. Increase rake angle to improve sharpness Decrease cutting speed
10	Flaking	Mostly happens during machining of high hard materials or vibration	Cutting edge welding and adhesion. Bad chip removing	Increase rake angle to improve sharpness Use chip breaker with wider chip pocket

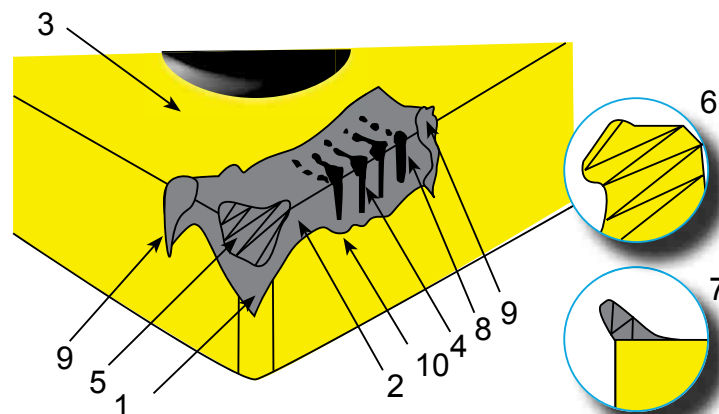


Bild	Art des Verschleißes	Auswirkungen	Grund	Gegenmaßnahmen
1+2	Freiflächenverschleiß	Schlechte Oberflächengüte und Maßhaltigkeit Anstieg der Schnittkraft	Sorte nicht verschleißfest genug Schnittgeschwindigkeit zu hoch Freiwinkel zu klein Vorschub zu gering	Sorte mit höherer Verschleißfestigkeit Schnittgeschwindigkeit reduzieren Freiwinkel vergrößern Vorschub reduzieren
3	Kolkverschleiß	Schlechte Oberflächengüte und Spankontrolle	Sorte nicht verschleißfest genug Schnittgeschwindigkeit zu hoch Vorschub zu hoch	Sorte mit höherer Verschleißfestigkeit Schnittgeschwindigkeit reduzieren Vorschub reduzieren
4	Ausbröckelung	Standzeit nicht stabil Plötzlicher Bruch der Schneidkante	Sorte ist zu hart Vorschub zu hoch Schneidkantenstabilität nicht ausreichend Stabilität des Werkzeughalter oder Spannung nicht ausreichend	Sorte mit höherer Zähigkeit Vorschub reduzieren Schneidkantenverrundung ändern Stabileren Halter verwenden
5	Bruch	Anstieg der Schnittkraft Schlechte Oberflächengüte und Maßhaltigkeit	Sorte ist zu hart Vorschub zu hoch Schneidkantenstabilität nicht ausreichend Stabilität des Werkzeughalter oder Spannung nicht ausreichend	Sorte mit höherer Zähigkeit Vorschub reduzieren Schneidkantenverrundung ändern Stabileren Halter verwenden
6	Plastische Deformation	Schlechte Maßhaltigkeit Beschädigung der Schneidkante	Sorte nicht verschleißfest genug. Schnittgeschwindigkeit zu hoch Schnitttiefe und/oder Vorschub zu hoch Temperatur an der Schneide zu hoch	Sorte mit höherer Verschleißfestigkeit Schnittgeschwindigkeit reduzieren Schnitttiefe und Vorschub reduzieren Sorte mit höherer Wärmebeständigkeit
7	Aufbauschneide	Anstieg der Schnittkraft Schlechte Oberflächengüte	Schnittgeschwindigkeit zu niedrig Schneidkante nicht scharf genug Sorte nicht geeignet	Schnittgeschwindigkeit erhöhen Spanwinkel erhöhen Sorte mit geringer Affinität
8	Thermischer Verschleiß	Bruch durch thermische Wechselwirkung Off bei unterbrochenem Schnitt (Fräsen)	Durch die Bearbeitungs- Temperaturschwankungen Sorte ist zu hart	Trockenbearbeitung Sorte mit höherer Zähigkeit
9	Kerbverschleiß	Gratbildung Anstieg der Schnittkraft	Beschädigung durch Späne (ausgefranzte Spankante) Vorschub und Schnittgeschwindigkeit zu hoch	Sorte mit höherer Verschleißfestigkeit Spanwinkel vergrößern um eine schärfere Schneide zu bekommen Schnittgeschwindigkeit verringern
10	Abplatzung (Beschichtung)	Off bei der Bearbeitung härterer Werkstoffe oder wenn Vibrationen auftauchen	Verklebungen an der Schneidkante sowie Ausbrüche. Schlechte Spanabfuhr	Spanwinkel vergrößern um eine schärfere Schneide zu bekommen Spanbrecher mit größerer Spankammer