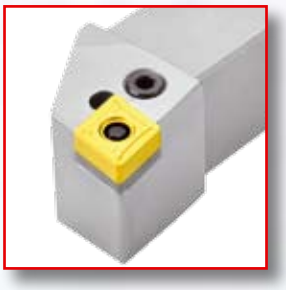
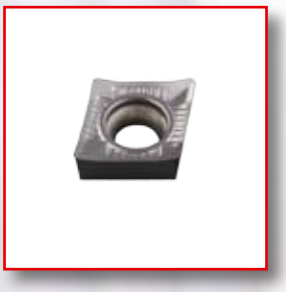
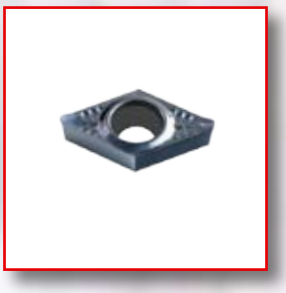
GERMANY JD TOOLS

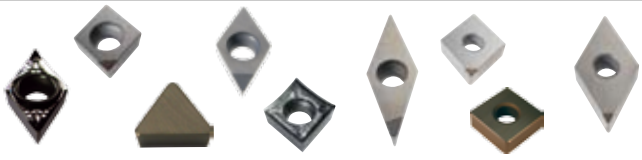






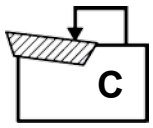
# Drehen
# *Turning*
# 1

**... Qualität schafft Vertrauen**

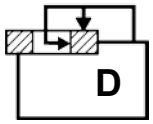
| | Seite *Page* |
|---|---|
| ISO - Bezeichnungssystem für Klemmhalter *Designation System for Toolholders* S C L C R 25 25 M 12 | 1.02 |
| Drehwerkzeuge für Außenbearbeitung *External Turning Tools* | 1.04 |
| ISO - Bezeichnungssystem für Bohrstangen *Designation System for Boring Bars* A 32 S P C L N L 12 | 1.20 |
| Drehwerkzeuge für Innenbearbeitung *Internal Turning Tools* | 1.22 |
| ISO - Bezeichnungssystem für Wende-schneidplatten zum Drehen - *Designation System for Indexable Inserts for Turning* T N M G 16 04 04 E R | 1.30 |
| Wendeschneidplatten zum Drehen *Indexable Inserts for Turning* | 1.32 |
| Wendeschneidplatten zum Drehen CBN, PKD, Keramik *Indexable Inserts for Turning CBN, PKD, Ceramics*  | 1.51 |
| Schneidstoffsorten-Übersicht zum Drehen *Description of Carbide Grades for Turning* | 1.60 |
| Schneidstoffsorten-Schlüssel zum Drehen *Code Explanation of Carbide Grades for Turning* | 1.61 |
| Spanleitstufen zum Drehen *Chipbreakers for Turning* | 1.62 |
| Schnittdaten-Empfehlungen zum Drehen *Cutting Data Recommendations for Turning* | 1.64 |

# ISO - Bezeichnungssystem für Klemmhalter / *ISO Designation System for Toolholders*

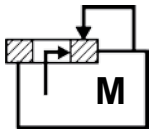
## Klemmsystem *Clamping Method*



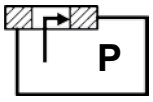

Von oben geklemmt
*Top clamping*



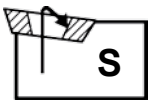

Von oben und über Bohrung geklemmt
*Top and hole clamping*




Von oben und über Bohrung geklemmt
*Top and hole clamping*




Über Bohrung geklemmt
*Hole clamping*




Durch Bohrung aufgeschraubt
*With screw through hole*

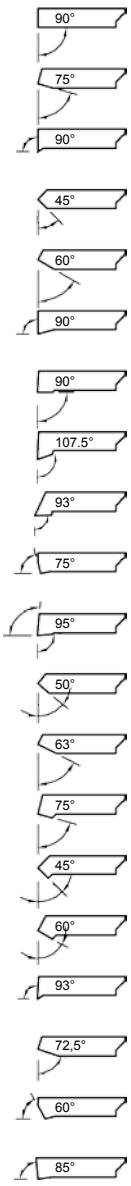
## Plattenform *Shape*

| | |
|---|---|
| 80° | C |
| 55° | D |
| 75° | E |
| 86° | M |
| 35° | V |

| | |
|---|---|
| 85° | A |
| 82° | B |
| 55° | K |

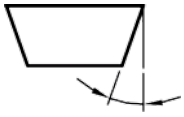
| | |
|---|---|
| H | |
| L | |
| O | |
| P | |
| R | |
| S | |
| T | |
| W | |

## Halterform *Style*



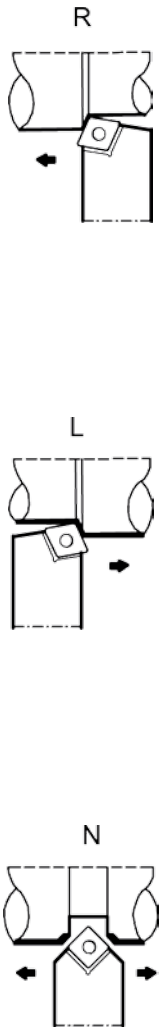

| | |
|---|---|
| A | |
| B | |
| C | |
| D | |
| E | |
| F | |
| G | |
| H | |
| J | |
| K | |
| L | |
| M | |
| N | |
| R | |
| S | |
| T | |
| U | |
| V | |
| W | |
| Y | |

## Freiwinkel *Clearance Angle*



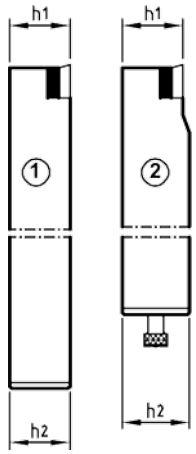
| | |
|---|---|
| 3° | A |
| 5° | B |
| 7° | C |
| 15° | D |
| 20° | E |
| 25° | F |
| 30° | G |
| 0° | N |
| 11° | P |
| Sonstige *Others* | O |

## Halterausführung *Holder Execution*




| S | C | L | C | R |
|---|---|---|---|---|
| Klemmsystem *Clamping Method* | Plattenform *Shape* | Halterform *Style* | Freiwinkel *Clearance Angle* | Halterausführung *Holder Execution* |

## ISO - Bezeichnungssystem für Klemmhalter / *ISO Designation System for Toolholders*

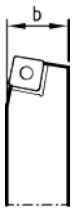



Höhe der Schneidenecke "h1" in mm

*Height of cutting edge "h1" in mm*

**25**

Schafthöhe
*Height of Shank*

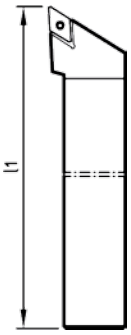



Schaftbreite "b" in mm

*Width "b" in mm*

**25**

Schaftbreite
*Width of Shank*

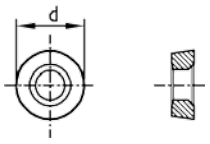



| L1 (mm) | | L1 (mm) | |
|---|---|---|---|
| 32 | **A** | 150 | **M** |
| 40 | **B** | 160 | **N** |
| 50 | **C** | 170 | **P** |
| 60 | **D** | 180 | **Q** |
| 70 | **E** | 200 | **R** |
| 80 | **F** | 250 | **S** |
| 90 | **G** | 300 | **T** |
| 100 | **H** | 350 | **U** |
| 110 | **J** | 400 | **V**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

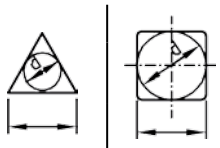
Sonderlänge *Special Length* X

**M**

Halterlänge
*Length of Holder*




| d (mm) |
|---|
| 06 |
| 08 |
| 10 |
| 12 |
| 16 |
| 20 |
| 25 |
| 32 |



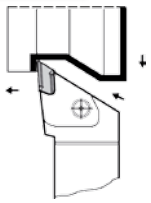
| (mm) | d (inch) | d (mm) | (mm) |
|---|---|---|---|
| **06** | 5/32 | 3.96 | **03** |
| **09** | 7/32 | 5.55 | **05** |
| **11** | 1/4 | 6.35 | **06** |
| **16** | 3/8 | 9.52 | **09** |
| **22** | 1/2 | 12.7 | **12** |
| **27** | 5/8 | 15.8 | **15** |
| **33** | 3/4 | 19.0 | **19** |
| **44** | 1 |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

**12**

Schneidenlänge
*Length of Cutting Edge*

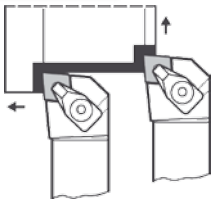
# Übersicht - Außendrehen
## *Overview - External Turning*

**CKJNR/L** 93°



Seite / *page:* 1.06

**DCLNR/L** 95°



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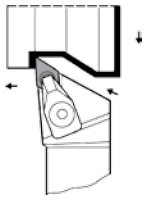
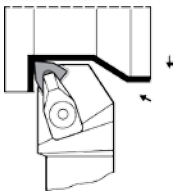
**DDJNR/L** 93°



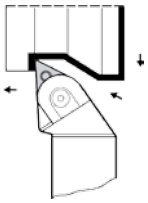
Seite / *page:* 1.07

**DWLNR/L** 95°



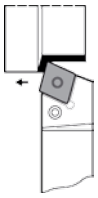
Seite / *page:* 1.07

**MTJNR/L** 93°



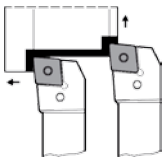
Seite / *page:* 1.08

**PCBNR/L** 75°



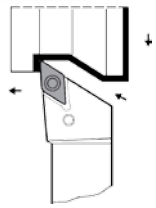
Seite / *page:* 1.08

**PCLNR/L** 95°



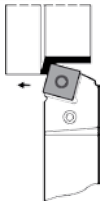
Seite / *page:* 1.09

**PDJNR/L** 93°



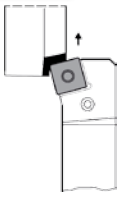
Seite / *page:* 1.10

**PSBNR/L** 75°



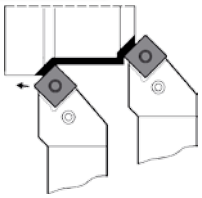
Seite / *page:* 1.10

**PSKNR/L** 75°



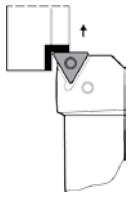
Seite / *page:* 1.11

**PSSNR/L** 45°



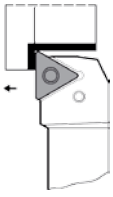
Seite / *page:* 1.11

**PTFNR/L** 90°



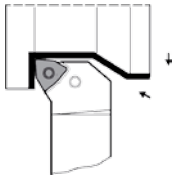
Seite / *page:* 1.12

**PTGNR/L** 95°



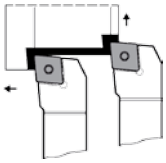
Seite / *page:* 1.12

**PWLNR/L** 95°



Seite / *page:* 1.13

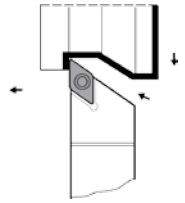
**SCLCR/L** 95°



Seite / *page:* 1.13

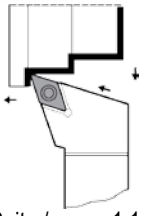
## Übersicht - Außendrehen
## *Overview - External Turning*

**SDACR/L** 90°



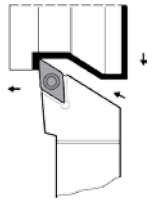
Seite / *page:* 1.14

**SDHCR/L** 107,5°



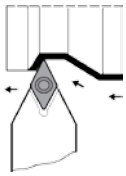
Seite / *page:* 1.14

**SDJCR/L** 93°



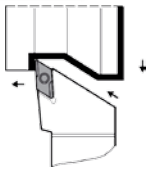
Seite / *page:* 1.15

**SDNCN** 62,5°



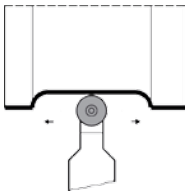
Seite / *page:* 1.15

**SKJCR/L** 93°



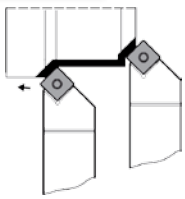
Seite / *page:* 1.16

**SRDCN** 45°



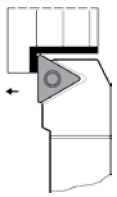
Seite / *page:* 1.16

**SSSCR/L** 45°



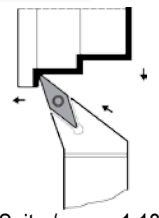
Seite / *page:* 1.17

**STGCR/L** 90°



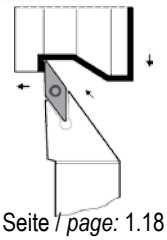
Seite / *page:* 1.17

**SVHCR/L** 107,5°



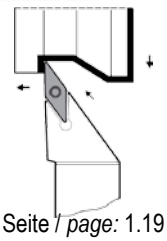
Seite / *page:* 1.18

**SVJBR/L** 93°



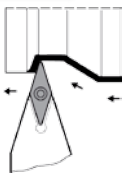
Seite / *page:* 1.18

**SVJCR/L** 93°



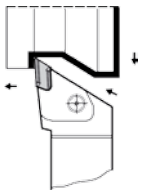
Seite / *page:* 1.19

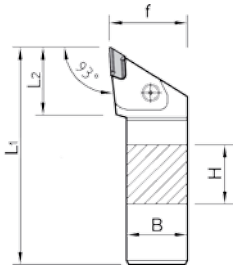
**SVVCN** 72,5°



Seite / *page:* 1.19

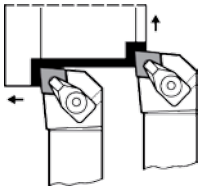
# CKJNR/L 93°

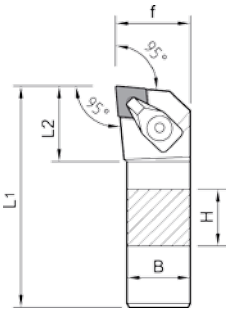





| Bezeichnung *Part Number* | Lager *Stock* | | Maße [mm] *Dimensions* | | | | | Seite / Page: 1.38 | Ersatzteile *Spare Parts* | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | R | L | H | B | $L_1$ | $L_2$ | f | | | | | | | | |  |
| **CKJNR 2020 K16** | ○ | | 20 | 20 | 125 | 32 | 25 | KNUX 1604••R | 48.11.705 | 48.11.105 | 48.12.606 (SW4) | 48.11.503 | 48.11.500 + 48.11.504 | 48.11.208 | 48.11.301 | 48.12.605 (SW2) |
| **2525 M16** | ○ | | 25 | 25 | 150 | 32 | 32 | | | | | | | | | |
| **3232 P16** | ○ | | 32 | 32 | 170 | 32 | 40 | | | | | | | 48.11.209 | | |
| **CKJNL 2020 K16** | | ○ | 20 | 20 | 125 | 32 | 25 | KNUX 1604••L | 48.11.706 | | | | | | | |
| **2525 M16** | | ○ | 25 | 25 | 150 | 32 | 32 | | | | | | | | | |
| **3232 P16** | | ○ | 32 | 32 | 170 | 32 | 40 | | | | | | | | | |

# DCLNR/L 95°



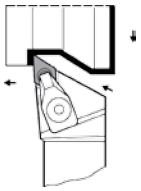


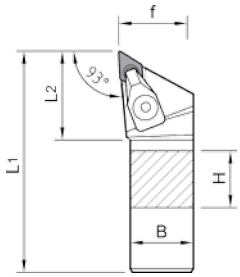

| Bezeichnung *Part Number* | Lager *Stock* | | Maße [mm] *Dimensions* | | | | | Seite / Page: 1.34 | Ersatzteile *Spare Parts* | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | R | L | H | B | $L_1$ | $L_2$ | f | | | | | | | | |  |
| **DCLNR/L 2020 K12** | ● | ○ | 20 | 20 | 125 | 30 | 25 | CN •• 1204 •• | 48.34.701 | 48.34.101 | 48.12.606 (SW4) | 48.33.501 | 48.33.502 | 48.33.201 | 48.34.102 | 48.12.604 (SW2,5) |
| **2525 M12** | ● | ○ | 25 | 25 | 150 | 30 | 32 | | | | | | | | | |
| **3232 P12** | ○ | ○ | 32 | 32 | 170 | 30 | 40 | | | | | | | | | |



● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

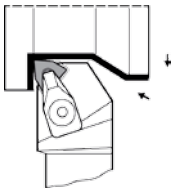
# DDJNR/L 93°

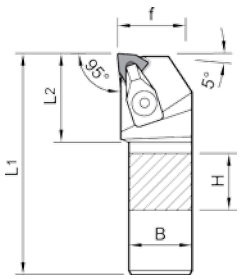





| Bezeichnung *Part Number* | Lager *Stock* | | Maße [mm] *Dimensions* | | | | | Seite / Page: 1.37 | Ersatzteile *Spare Parts* | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | R | L | H | B | $L_1$ | $L_2$ | f | | | | | | | | | |
| **DDJNR/L 2020 K15** | ● | ○ | 20 | 20 | 125 | 38 | 25 | DN •• 1506 •• | 48.34.701 | 48.34.101 | 48.12.606 ( SW4 ) | 48.33.501 | 48.33.502 | 48.33.202 | 48.34.102 | 48.12.604 ( SW2,5 ) |
| **2525 M15** | ● | ○ | 25 | 25 | 150 | 38 | 32 | | | | | | | | | |
| **3232 P15** | ○ | ○ | 32 | 32 | 170 | 38 | 40 | | | | | | | | | |

# DWLNR/L 95°

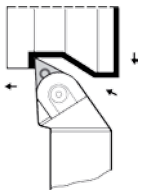


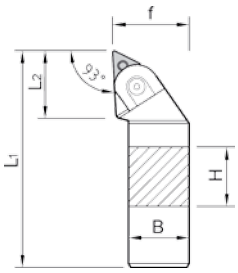



| Bezeichnung *Part Number* | Lager *Stock* | | Maße [mm] *Dimensions* | | | | | Seite / Page: 1.48 | Ersatzteile *Spare Parts* | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | R | L | H | B | $L_1$ | $L_2$ | f | | | | | | | | | |
| **DWLNR/L 2020 K08** | ● | ○ | 20 | 20 | 125 | 35 | 25 | WN •• 0804 •• | 48.34.701 | 48.34.101 | 48.12.606 ( SW4 ) | 48.33.501 | 48.33.502 | 48.34.201 | 56.44.102 | 56.33.614 ( T20 ) |
| **2525 M08** | ● | ○ | 25 | 25 | 150 | 35 | 32 | | | | | | | | | |

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

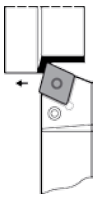
# MTJNR/L 93°

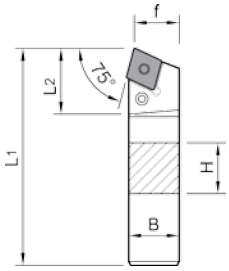





| Bezeichnung *Part Number* | Lager *Stock* R | L | Maße [mm] *Dimensions* H | B | $L_1$ | $L_2$ | f | Seite / Page: 1.43 | Ersatzteile *Spare Parts* | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **MTJNR/L 2020 K16** | | | 20 | 20 | 125 | 33 | 25 | TN •• 1604 •• | 48.10.702 | 48.10.505 | 48.10.201 | 48.10.104 | 48.10.501 | 48.10.902 | 48.10.503 | 48.12.604 ( SW2,5 ) |
| **2525 M16** | | | 25 | 25 | 150 | 33 | 32 | | | | | | | | | |
| **3232 P16** | | | 32 | 32 | 170 | 33 | 40 | | | | | | | | | |
| **2525 M22** | | | 25 | 25 | 150 | 35 | 32 | TN •• 2204 •• | 48.10.703 | 48.10.506 | 48.10.202 | | 48.10.502 | 48.10.903 | 48.10.504 | 48.12.603 ( SW3 ) |
| **3232 P22** | | | 32 | 32 | 170 | 35 | 40 | | | | | | | | | |

# PCBNR/L 75°



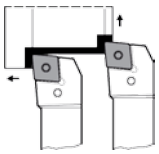


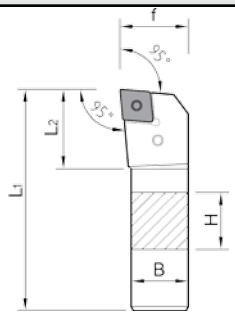

| Bezeichnung *Part Number* | Lager *Stock* R | L | Maße [mm] *Dimensions* H | B | $L_1$ | $L_2$ | f | Seite / Page: 1.34 | Ersatzteile *Spare Parts* | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **PCBNR/L 2020 K12** | ○ | ○ | 20 | 20 | 125 | 27 | 17 | CN •• 1204 •• | 48.12.414 | 48.12.113 | 48.33.201 | 48.12.901 | 48.12.603 ( SW3 ) |
| **2525 M12** | ○ | ○ | 25 | 25 | 150 | 27 | 22 | | | | | | |
| **3232 P12** | | | 32 | 32 | 170 | 27 | 22 | | | | | | |
| **2525 M16** | ○ | | 25 | 25 | 150 | 33 | 22 | CN •• 1606 •• | 48.12.415 | 48.12.114 | 48.12.202 | 48.12.902 | |
| **3232 P16** | | | 32 | 32 | 170 | 33 | 27 | | | | | | |
| **3232 P19** | ● | ● | 32 | 32 | 170 | 38 | 27 | CN •• 1906 •• | 48.12.416 | 48.12.115 | 48.12.203 | 48.12.903 | 48.12.606 ( SW4 ) |
| **4040 S19** | | | 40 | 40 | 250 | 38 | 35 | | | | | | |



● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# PCLNR/L 95°

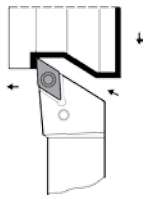


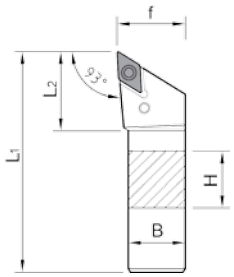



| Bezeichnung *Part Number* | Lager *Stock* | | Maße [mm] *Dimensions* | | | | | Seite / Page: 1.34 | Ersatzteile *Spare Parts* | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | R | L | H | B | $L_1$ | $L_2$ | f | | | | | | |
| **PCLNR/L 1616 H09** | ○ | ○ | 16 | 16 | 100 | 20 | 20 | CN •• 0903 •• | 48.12.417 | 48.12.116 | 48.12.201 | 48.12.904 | 48.12.604 ( SW2,5 ) |
| **2020 K09** | ○ | ○ | 20 | 20 | 125 | 22 | 25 | | | | | | |
| **2525 M09** | ○ | ○ | 25 | 25 | 150 | 22 | 32 | | | | | | |
| **1616 H12** | ● | ● | 16 | 16 | 100 | 28 | 20 | CN •• 1204 •• | 48.12.414 | 48.12.113 | 48.33.201 | 48.12.901 | 48.12.603 ( SW3 ) |
| **2020 K12** | ● | ● | 20 | 20 | 125 | 28 | 25 | | | | | | |
| **2525 M12** | ● | ● | 25 | 25 | 150 | 28 | 32 | | | | | | |
| **3232 P12** | ○ | ○ | 32 | 32 | 170 | 28 | 32 | | | | | | |
| **2525 M16** | ○ | ○ | 25 | 25 | 150 | 33 | 32 | CN •• 1606 •• | 48.12.415 | 48.12.114 | 48.12.202 | 48.12.902 | |
| **3232 P16** | ○ | ○ | 32 | 32 | 170 | 33 | 40 | | | | | | |
| **3232 P19** | ● | ● | 32 | 32 | 170 | 38 | 40 | CN •• 1906 •• | 48.12.416 | 48.12.115 | 48.12.203 | 48.12.903 | 48.12.606 ( SW4 ) |
| **4040 S19** | ○ | ○ | 40 | 40 | 250 | 38 | 50 | | | | | | |

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

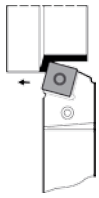
# PDJNR/L 93°

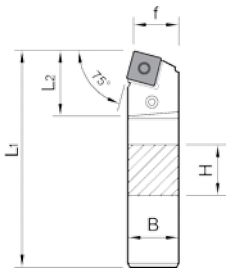





| Bezeichnung *Part Number* | Lager *Stock* R | L | Maße [mm] *Dimensions* H | B | $L_1$ | $L_2$ | f | Seite / Page: 1.37 | Ersatzteile *Spare Parts* | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **PDJNR/L 1616 H11** | ● | ○ | 16 | 16 | 100 | 25 | 20 | DN •• 1104 •• | 48.12.417 | 48.12.116 | 48.12.204 | 48.12.905 | 48.12.604 ( SW2,5 ) |
| **2020 K11** | ● | ● | 20 | 20 | 125 | 25 | 25 | | | | | | |
| **2525 M11** | ○ | ○ | 25 | 25 | 150 | 30 | 32 | | | | | | |
| **2020 K15** | ● | ● | 20 | 20 | 125 | 35 | 25 | DN •• 1506 •• | 48.12.418 | 48.12.113 | 48.33.202 | 48.12.901 | 48.12.603 ( SW3 ) |
| **2525 M15** | ● | ● | 25 | 25 | 150 | 35 | 32 | | | | | | |
| **3232 P15** | ○ | ○ | 32 | 32 | 170 | 35 | 40 | | | | | | |

# PSBNR/L 75°



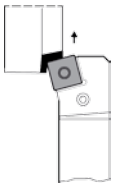


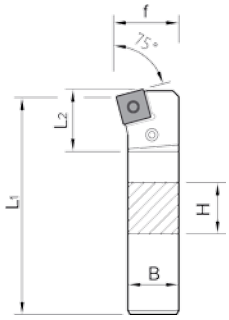

| Bezeichnung *Part Number* | Lager *Stock* R | L | Maße [mm] *Dimensions* H | B | $L_1$ | $L_2$ | f | Seite / Page: 1.41 | Ersatzteile *Spare Parts* | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **PSBNR/L 2020 K12** | | ● | 20 | 20 | 125 | 28 | 17 | SN •• 1204 •• | 48.12.414 | 48.12.116 | 48.12.205 | 48.12.901 | 48.12.603 ( SW3 ) |
| **2525 M12** | ○ | | 25 | 25 | 150 | 28 | 22 | | | | | | |
| **3232 P12** | | | 32 | 32 | 170 | 28 | 27 | | | | | | |
| **2525 M15** | | | 25 | 25 | 150 | 35 | 22 | SN •• 1506 •• | 48.12.415 | 48.12.114 | 48.12.206 | 48.12.902 | |
| **3232 P15** | | | 32 | 32 | 170 | 37 | 27 | | | | | | |
| **3232 P19** | | | 32 | 32 | 170 | 40 | 27 | SN •• 1906 •• | 48.12.416 | 48.12.115 | 48.12.234 | 48.12.903 | 48.12.606 ( SW4 ) |
| **4040 S19** | | | 40 | 40 | 250 | 40 | 35 | | | | | | |



● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

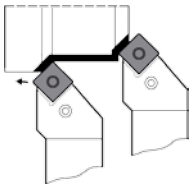
# PSKNR/L 75°

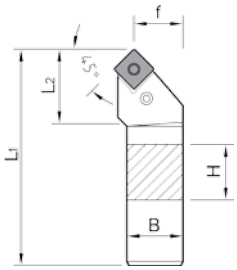





| Bezeichnung *Part Number* | Lager *Stock* R | L | Maße [mm] *Dimensions* H | B | $L_1$ | $L_2$ | f | Seite / Page: 1.41 | Ersatzteile *Spare Parts* | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **PSKNR/L 2020 K12** | | | 20 | 20 | 125 | 26 | 25 | SN •• 1204 •• | 48.12.414 | 48.12.113 | 48.12.205 | 48.12.901 | 48.12.603 ( SW3 ) |
| **2525 M12** | | | 25 | 25 | 150 | 26 | 32 | | | | | | |
| **2525 M15** | | | 25 | 25 | 150 | 32 | 32 | SN •• 1506 •• | 48.12.415 | 48.12.114 | 48.12.206 | 48.12.902 | |
| **3232 P15** | | | 32 | 32 | 170 | 32 | 40 | | | | | | |
| **3232 P19** | | | 32 | 32 | 170 | 40 | 40 | SN •• 1906 •• | 48.12.416 | 48.12.115 | 48.12.234 | 48.12.903 | 48.12.606 ( SW4 ) |
| **4040 S19** | | | 40 | 40 | 250 | 50 | 50 | | | | | | |

# PSSNR/L 45°

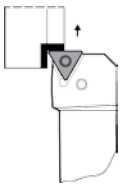


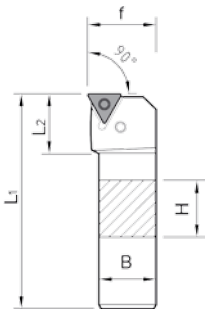



| Bezeichnung *Part Number* | Lager *Stock* R | L | Maße [mm] *Dimensions* H | B | $L_1$ | $L_2$ | f | Seite / Page: 1.41 | Ersatzteile *Spare Parts* | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **PSSNR/L 2020 K12** | ● | ○ | 20 | 20 | 125 | 30 | 25 | SN •• 1204 •• | 48.12.414 | 48.12.113 | 48.12.205 | 48.12.901 | 48.12.603 ( SW3 ) |
| **2525 M12** | ● | ○ | 25 | 25 | 150 | 30 | 32 | | | | | | |
| **2525 M15** | | | 25 | 25 | 150 | 30 | 32 | SN •• 1506 •• | 48.12.415 | 48.12.114 | 48.12.206 | 48.12.902 | |
| **3232 P15** | | | 32 | 32 | 170 | 40 | 40 | | | | | | |
| **3232 P19** | ○ | ○ | 32 | 32 | 170 | 40 | 40 | SN •• 1906 •• | 48.12.416 | 48.12.115 | 48.12.234 | 48.12.903 | 48.12.606 ( SW4 ) |
| **4040 S19** | | ○ | 40 | 40 | 250 | 40 | 50 | | | | | | |

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

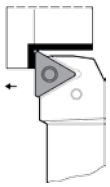
# PTFNR/L 90°

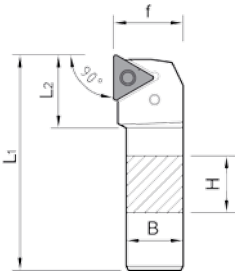





| Bezeichnung *Part Number* | Lager *Stock* R | Lager *Stock* L | Maße [mm] *Dimensions* H | B | $L_1$ | $L_2$ | f | Seite / Page: 1.43 | Ersatzteile *Spare Parts* | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **PTFNR/L 1616 H16** | ○ | ○ | 16 | 16 | 100 | 20 | 20 | TN•• 1604•• | 48.12.417 | 48.12.116 | 48.12.229 | 48.12.905 | 48.12.604 ( SW2,5 ) |
| **2020 K16** | ○ | ○ | 20 | 20 | 125 | 20 | 25 | | | | | | |
| **2525 M16** | ○ | ○ | 25 | 25 | 150 | 20 | 32 | | | | | | |
| **2525 M22** | ○ | ○ | 25 | 25 | 150 | 25 | 32 | TN•• 2204•• | 48.12.414 | 48.12.113 | 48.12.230 | 48.12.901 | 48.12.603 ( SW3 ) |
| **3232 P22** | | | 32 | 32 | 170 | 25 | 40 | | | | | | |
| **3232 P27** | | | 32 | 32 | 170 | 33 | 40 | TN•• 2706•• | 48.12.415 | 48.12.114 | 48.12.231 | 48.12.902 | |
| **4040 S27** | | | 40 | 40 | 250 | 33 | 50 | | | | | | |

# PTGNR/L 90°



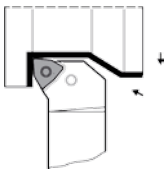


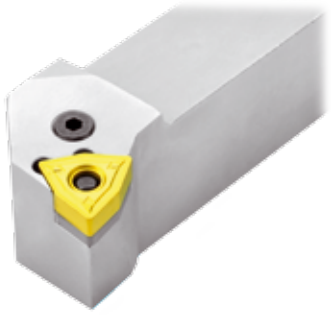

| Bezeichnung *Part Number* | Lager *Stock* R | Lager *Stock* L | Maße [mm] *Dimensions* H | B | $L_1$ | $L_2$ | f | Seite / Page: 1.43 | Ersatzteile *Spare Parts* | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **PTGNR/L 1616 H16** | | | 16 | 16 | 100 | 20 | 20 | TN•• 1604•• | 48.12.417 | 48.12.116 | 48.12.229 | 48.12.905 | 48.12.604 ( SW2,5 ) |
| **2020 K16** | ○ | ○ | 20 | 20 | 125 | 20 | 25 | | | | | | |
| **2525 M16** | ○ | ○ | 25 | 25 | 150 | 20 | 32 | | | | | | |
| **3232 P16** | | | 32 | 32 | 170 | 20 | 40 | | | | | | |
| **2525 M22** | ○ | ○ | 25 | 25 | 150 | 28 | 32 | TN•• 2204•• | 48.12.414 | 48.12.113 | 48.12.230 | 48.12.901 | 48.12.603 ( SW3 ) |
| **3232 P22** | | | 32 | 32 | 170 | 28 | 40 | | | | | | |
| **3232 P27** | | | 32 | 32 | 170 | 33 | 40 | TN•• 2706•• | 48.12.415 | 48.12.114 | 48.12.231 | 48.12.902 | |
| **4040 S27** | | | 40 | 40 | 250 | 33 | 50 | | | | | | |

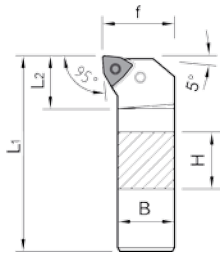


● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# PWLNR/L 95°

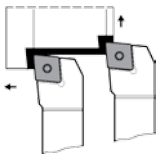


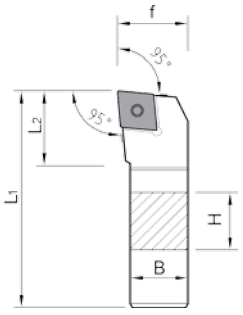





| Bezeichnung *Part Number* | Lager *Stock* | | Maße [mm] *Dimensions* | | | | | | Ersatzteile *Spare Parts* | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | R | L | H | B | $L_1$ | $L_2$ | f | Seite / Page: 1.48 | | | | | |
| **PWLNR/L 1616 H06** | ○ | ○ | 16 | 16 | 100 | 20 | 20 | WN •• 0604 •• | 48.12.417 | 48.12.116 | 48.12.232 | 48.12.905 | 48.12.604 ( SW2,5 ) |
| **2020 K06** | ○ | ○ | 20 | 20 | 125 | 20 | 25 | | | | | | |
| **2525 M06** | ○ | ○ | 25 | 25 | 150 | 20 | 32 | | | | | | |
| **2020 K08** | ● | ● | 20 | 20 | 125 | 26 | 25 | WN •• 0804 •• | 48.12.414 | 48.12.113 | 48.12.233 | 48.12.901 | 48.12.603 ( SW3 ) |
| **2525 M08** | ● | ● | 25 | 25 | 150 | 26 | 32 | | | | | | |
| **3232 P08** | | ○ | 32 | 32 | 170 | 26 | 40 | | | | | | |

# SCLCR/L 95°

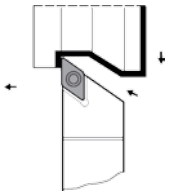


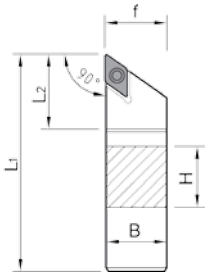



| Bezeichnung *Part Number* | Lager *Stock* | | Maße [mm] *Dimensions* | | | | | | Ersatzteile *Spare Parts* | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | R | L | H | B | $L_1$ | $L_2$ | f | Seite / Page: 1.32 | | | | |
| **SCLCR/L 0808 D06** | ● | ○ | 8 | 8 | 60 | 8 | 10 | CC •• 0602 •• | 48.13.101 | - | - | 56.33.612 ( T08 ) |
| **1010 E06** | ● | ○ | 10 | 10 | 70 | 10 | 12 | | | | | |
| **1212 F09** | ● | ● | 12 | 12 | 80 | 16 | 16 | CC •• 09T3 •• | 48.13.102 | - | - | 56.33.613 ( T15 ) |
| **1616 H09** | ● | ● | 16 | 16 | 100 | 16 | 20 | | | 48.13.201 | 48.13.301 | |
| **2020 K09** | ● | ● | 20 | 20 | 125 | 25 | 25 | | | | | |
| **1616 H12** | ○ | | 16 | 16 | 100 | 25 | 20 | CC •• 1204 •• | 48.13.103 | 48.13.202 | 48.13.302 | |
| **2020 K12** | ● | ● | 20 | 20 | 125 | 25 | 25 | | | | | |
| **2525 M12** | ● | ● | 25 | 25 | 150 | 25 | 32 | | | | | |
| **3232 P12** | ○ | ○ | 32 | 25 | 170 | 25 | 40 | | | | | |

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

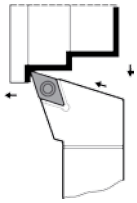
# SDACR/L 90°

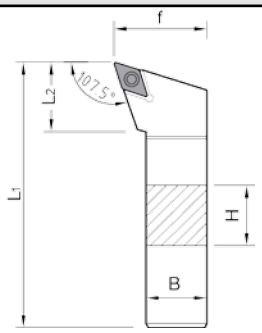





| Bezeichnung *Part Number* | Lager *Stock* R | L | Maße [mm] *Dimensions* H | B | $L_1$ | $L_2$ | f | Seite / Page: 1.36 | Ersatzteile *Spare Parts* | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **SDACR/L 0808 K07** | | | 8 | 8 | 125 | 14 | 8.5 | DC•• 0702 •• | 48.13.101 | - | - | 56.33.612 (T08) |
| **1010 M07** | | | 10 | 10 | 150 | 14 | 10.5 | | | | | |
| **1212 M07** | | | 12 | 12 | 150 | 14 | 12.5 | | | | | |
| **1212 M11** | | | 12 | 12 | 150 | 21 | 12.5 | DC•• 11T3 •• | 48.24.109 | - | - | 56.33.613 (T15) |
| **1414 M11** | | | 14 | 14 | 150 | 21 | 14.5 | | | | | |
| **2525 M11** | | | 25 | 25 | 150 | 21 | 25.5 | | 48.13.102 | 48.13.203 | 48.13.301 | |

# SDHCR/L 107,5°



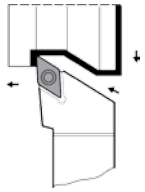


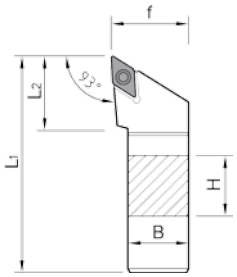

| Bezeichnung *Part Number* | Lager *Stock* R | L | Maße [mm] *Dimensions* H | B | $L_1$ | $L_2$ | f | Seite / Page: 1.36 | Ersatzteile *Spare Parts* | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **SDHCR/L 1010 E07** | ○ | | 10 | 10 | 70 | 15 | 12 | DC•• 0702 •• | 48.13.101 | - | - | 56.33.612 (T08) |
| **1212 F07** | ○ | ○ | 12 | 12 | 80 | 15 | 16 | | | | | |
| **1616 H11** | ● | ○ | 16 | 16 | 100 | 24 | 20 | DC•• 11T3 •• | 48.13.102 | 48.13.203 | 48.13.301 | 56.33.613 (T15) |
| **2020 K11** | ● | ● | 20 | 20 | 125 | 24 | 25 | | | | | |
| **2525 M11** | ● | ● | 25 | 25 | 150 | 29 | 32 | | | | | |



● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

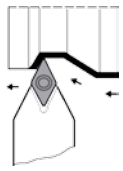
# SDJCR/L 93°

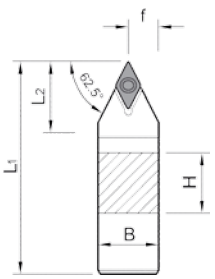





| Bezeichnung *Part Number* | | Lager *Stock* | | Maße [mm] *Dimensions* | | | | | Seite / Page: 1.36 | Ersatzteile *Spare Parts* | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | R | L | H | B | $L_1$ | $L_2$ | f | | | | | |
| **SDJCR/L** | **1010 E07** | ○ | | 10 | 10 | 70 | 15 | 12 | DC•• 0702 •• | 48.13.101 | - | - | 56.33.612 ( T08 ) |
| | **1212 F07** | ● | ○ | 12 | 12 | 80 | 15 | 16 | | | | | |
| | **1616 H11** | ● | ● | 16 | 16 | 100 | 24 | 20 | DC•• 11T3 •• | 48.13.102 | 48.13.203 | 48.13.301 | 56.33.613 ( T15 ) |
| | **2020 K11** | ● | ● | 20 | 20 | 125 | 24 | 25 | | | | | |
| | **2525 M11** | ● | ● | 25 | 25 | 150 | 29 | 32 | | | | | |

# SDNCN 62,5°

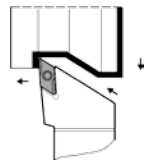


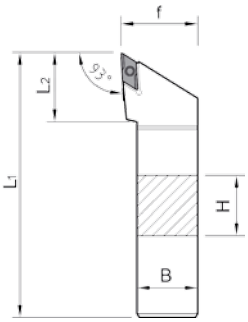



| Bezeichnung *Part Number* | | Lager *Stock* | Maße [mm] *Dimensions* | | | | | Seite / Page: 1.36 | Ersatzteile *Spare Parts* | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | H | B | $L_1$ | $L_2$ | f | | | | | |
| **SDNCN** | **1010 E07** | ○ | 10 | 10 | 70 | 20 | 5 | DC•• 0702 •• | 48.13.101 | - | - | 56.33.612 ( T08 ) |
| | **1212 F07** | ○ | 12 | 12 | 80 | 20 | 6 | | | | | |
| | **1212 M07** | | 12 | 12 | 150 | 20 | 6 | | | | | |
| | **1212 M11** | | 12 | 12 | 150 | 30 | 6 | DC•• 11T3 •• | 48.24.109 | - | - | 56.33.613 ( T15 ) |
| | **1616 H11** | ● | 16 | 16 | 100 | 30 | 8 | | 48.13.102 | 48.13.203 | 48.13.301 | |
| | **2020 K11** | ● | 20 | 20 | 125 | 30 | 10 | | | | | |
| | **2525 M11** | ○ | 25 | 25 | 150 | 30 | 12.5 | | | | | |

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

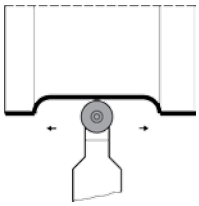
# SKJCR/L 93°

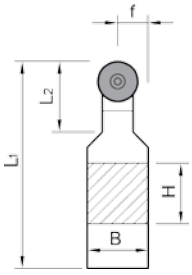





| Bezeichnung *Part Number* | Lager *Stock* R | L | Maße [mm] *Dimensions* H | B | $L_1$ | $L_2$ | f | Seite / Page: 1.38 | Ersatzteile *Spare Parts* | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **SKJCR/L 1212 F11** | ○ | | 12 | 12 | 80 | 15 | 16 | KC • X 1103 •• R/L | 48.13.104 | - | - | 56.33.612 (T08) |
| **1616 H11** | ○ | ○ | 16 | 16 | 100 | 24 | 20 | | | | | |
| **2020 K11** | ○ | ○ | 20 | 20 | 125 | 24 | 25 | | | | | |
| **2525 M11** | ○ | | 20 | 25 | 150 | 29 | 32 | | | | | |

# SRDCN 45°



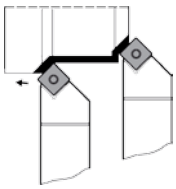


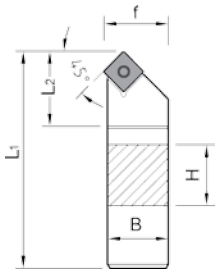

| Bezeichnung *Part Number* | Lager *Stock* | Maße [mm] *Dimensions* H | B | $L_1$ | $L_2$ | f | Seite / Page: 1.39 | Ersatzteile *Spare Parts* | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| **SRDCN 1212 F06** | | 12 | 12 | 80 | 12 | 6 | RC •T 0602 •• | 48.13.101 | - | - | 56.33.612 (T08) |
| **1616 H06** | | 16 | 16 | 100 | 12 | 8 | | | | | |
| **2020 K06** | ○ | 20 | 20 | 125 | 12 | 10 | | | | | |
| **2525 M06** | ○ | 25 | 25 | 150 | 12 | 12.5 | | | | | |
| **1616 H08** | | 16 | 16 | 100 | 16 | 8 | RC •T 0803 •• | 48.13.105 | - | - | |
| **2020 K08** | ○ | 20 | 20 | 125 | 16 | 10 | | | | | |
| **2525 M08** | ○ | 25 | 25 | 150 | 16 | 12.5 | | | | | |
| **1616 H10** | | 16 | 16 | 100 | 20 | 8 | RC •T 1003 •• | 48.13.102 | 48.13.204 | 48.13.301 | 56.33.613 (T15) |
| **2020 K10** | | 20 | 20 | 125 | 20 | 10 | | | | | |
| **2525 M10** | ○ | 25 | 25 | 150 | 20 | 12.5 | | | | | |



● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

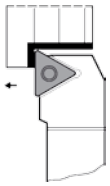
# SSSCR/L 45°

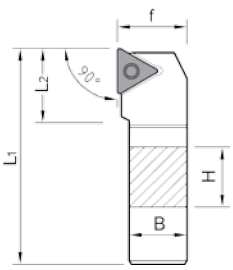





| Bezeichnung *Part Number* | Lager *Stock* R | Lager *Stock* L | Maße [mm] *Dimensions* H | B | $L_1$ | $L_2$ | f | Seite / Page: 1.40 | Ersatzteile *Spare Parts* | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **SSSCR/L 1212 F09** | ● | | 12 | 12 | 80 | 18 | 13 | SC•• 09T3 •• | 48.13.102 | - | - | 56.33.612 (T08) |
| **1616 H09** | ● | ○ | 16 | 16 | 100 | 20 | 17 | | | | | |
| **2020 K09** | ● | ○ | 20 | 20 | 125 | 20 | 21 | | | | | |
| **1616 H12** | | | 16 | 16 | 100 | 25 | 17 | SC•• 1204 •• | 48.13.103 | 48.13.206 | 48.13.302 | 56.33.613 (T15) |
| **2020 K12** | ● | ○ | 20 | 20 | 125 | 25 | 21 | | | | | |
| **2525 M12** | ● | ○ | 25 | 25 | 150 | 25 | 26 | | | | | |
| **3225 P12** | | | 32 | 25 | 170 | 25 | 26 | | | | | |

# STGCR/L 90°

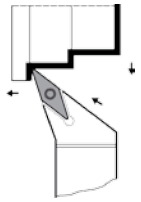


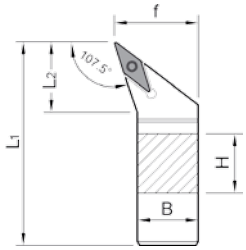



| Bezeichnung *Part Number* | Lager *Stock* R | Lager *Stock* L | Maße [mm] *Dimensions* H | B | $L_1$ | $L_2$ | f | Seite / Page: 1.41 | Ersatzteile *Spare Parts* | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **STGCR/L 0808 D09** | ○ | | 8 | 8 | 60 | 8 | 10 | TC•• 0902 •• | L60M2.2x5 | - | - | 75.20.621 (T06) |
| **1010 E09** | ○ | | 10 | 10 | 70 | 10 | 12 | | | | | |
| **1212 F11** | | | 12 | 12 | 80 | 15 | 16 | TC•• 1102 •• | 48.13.101 | - | - | 56.33.612 (T08) |
| **1616 H11** | | ○ | 16 | 16 | 100 | 15 | 20 | | | | | |
| **1616 H16** | | | 16 | 16 | 100 | 22 | 20 | TC•• 16T3 •• | 48.13.102 | 48.13.207 | 48.13.301 | 56.33.613 (T15) |
| **2020 K16** | | ○ | 20 | 20 | 125 | 22 | 25 | | | | | |
| **2525 M16** | | ○ | 25 | 25 | 150 | 22 | 32 | | | | | |

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

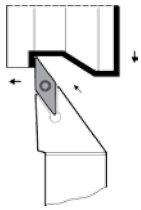
# SVHCR/L 107,5°

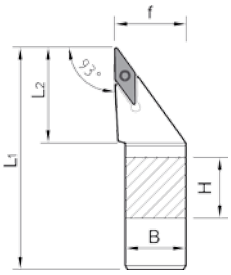





| Bezeichnung *Part Number* | Lager *Stock* R | Lager *Stock* L | Maße [mm] *Dimensions* H | B | $L_1$ | $L_2$ | f | Seite / Page: 1.46 | Ersatzteile *Spare Parts* | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **SVHCR/L 1212 F11** | | | 12 | 12 | 80 | 11.5 | 16 | VC•• 1103•• | 48.13.101 | - | - | 56.33.612 (T08) |
| **1616 H11** | | | 16 | 16 | 100 | 11.5 | 20 | | | | | |
| **2020 K11** | | | 20 | 20 | 125 | 14.5 | 25 | | | | | |
| **2525 M11** | | | 25 | 25 | 150 | 20.0 | 32 | | | | | |
| **1616 H16** | | | 16 | 16 | 100 | 13.5 | 20 | VC•• 1604•• | 48.13.102 | 48.13.208 | 48.13.301 | 56.33.613 (T15) |
| **2020 K16** | ● | | 20 | 20 | 125 | 13.5 | 25 | | | | | |
| **2525 M16** | ● | | 25 | 25 | 150 | 20.0 | 32 | | | | | |

# SVJBR/L 93°



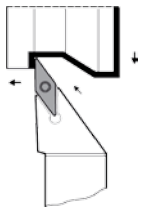


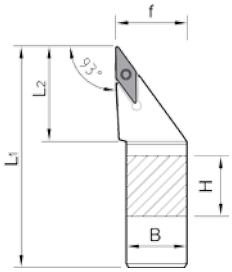

| Bezeichnung *Part Number* | Lager *Stock* R | Lager *Stock* L | Maße [mm] *Dimensions* H | B | $L_1$ | $L_2$ | f | Seite / Page: 1.45 | Ersatzteile *Spare Parts* | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **SVJBR/L 1212 F11** | ○ | | 12 | 12 | 80 | 11.5 | 16 | VB•• 1103•• | 48.13.101 | - | - | 56.33.612 (T08) |
| **1616 M11** | ○ | ○ | 16 | 16 | 100 | 11.5 | 20 | | | | | |
| **2020 K11** | | | 20 | 20 | 125 | 14.5 | 25 | | | | | |
| **2525 M11** | | | 25 | 25 | 150 | 20.0 | 32 | | | | | |
| **1616 H16** | | | 16 | 16 | 100 | 29.5 | 20 | VB•• 1604•• | 48.13.102 | 48.13.208 | 48.13.301 | 56.33.613 (T15) |
| **2020 K16** | ● | ● | 20 | 20 | 125 | 29.5 | 25 | | | | | |
| **2525 M16** | ● | ○ | 25 | 25 | 150 | 32.5 | 32 | | | | | |



● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

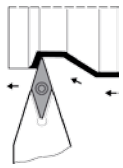
# SVJCR/L 93°

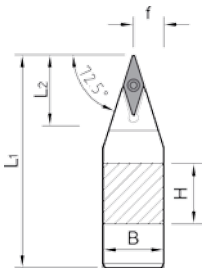





| Bezeichnung *Part Number* | | Lager *Stock* R | Lager *Stock* L | Maße [mm] *Dimensions* H | B | $L_1$ | $L_2$ | f | Seite / Page: 1.46 | Ersatzteile *Spare Parts* | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **SVJCR/L** | **1010 E11** | ○ | | 10 | 10 | 70 | 14.5 | 12 | VC•• 1103•• | 48.13.101 | - | - | 56.33.612 (T08) |
| | **1212 F11** | ● | ○ | 12 | 12 | 80 | 16.5 | 16 | | | | | |
| | **1616 H11** | ● | ● | 16 | 16 | 100 | 21.5 | 20 | | | | | |
| | **2020 K11** | ● | ● | 20 | 20 | 125 | 23.0 | 25 | | | | | |
| | **2525 M11** | ● | ○ | 25 | 25 | 150 | 25.5 | 32 | | | | | |
| | **1616 H16** | ● | ○ | 16 | 16 | 100 | 29.5 | 20 | VC•• 1604•• | 48.13.102 | 48.13.208 | 48.13.301 | 56.33.613 (T15) |
| | **2020 K16** | ● | ● | 20 | 20 | 125 | 29.5 | 25 | | | | | |
| | **2525 M16** | ● | ● | 25 | 25 | 150 | 32.5 | 32 | | | | | |
| | **3225 P16** | ○ | ○ | 32 | 25 | 170 | 35.0 | 32 | | | | | |

# SVVCN 72,5°

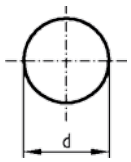
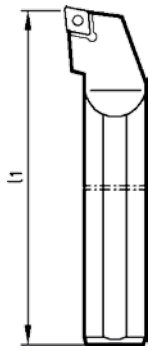
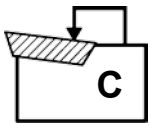
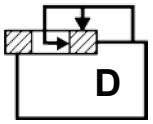
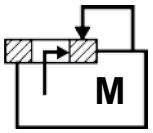
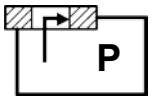
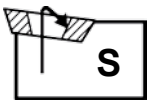





| Bezeichnung *Part Number* | | Lager *Stock* | Maße [mm] *Dimensions* H | B | $L_1$ | $L_2$ | f | Seite / Page: 1.46 | Ersatzteile *Spare Parts* | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **SVVCN** | **1010 E11** | ○ | 10 | 10 | 70 | 18 | 5 | VC•• 1103•• | 48.13.101 | - | - | 56.33.612 (T08) |
| | **1212 F11** | ○ | 12 | 12 | 80 | 27 | 6 | | | | | |
| | **1616 H11** | | 16 | 16 | 100 | 27 | 8 | | | | | |
| | **2020 K11** | ○ | 20 | 20 | 125 | 27 | 10 | | | | | |
| | **2525 M11** | | 25 | 25 | 150 | 41 | 12 | | | | | |
| | **1616 H16** | ○ | 16 | 16 | 100 | 36 | 8 | VC•• 1604•• | 48.13.102 | 48.13.208 | 48.13.301 | 56.33.613 (T15) |
| | **2020 K16** | ○ | 20 | 20 | 125 | 41 | 10 | | | | | |
| | **2525 M16** | ○ | 25 | 25 | 150 | 41 | 12 | | | | | |

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

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

| | | | |
|---|---|---|---|
| **A**<br>Stahlschaft mit Kühlbohrung<br>*Steel shank with coolant hole*<br><br>**B**<br>Stahlschaft mit Dämpfung<br>*Steel shank with vibration clamping*<br><br>**C**<br>Hartmetallschaft mit Stahlkopf<br>*Hardmetal shank with steel head*<br><br>**E**<br>Hartmetallschaft mit Stahlkopf und Kühlbohrung<br>*Hardmetal shank with steel head and coolant hole*<br><br>**S**<br>Stahlschaft<br>*Steel shank* |  |  |  <br>Von oben geklemmt<br>*Top clamping*<br><br>  <br>Von oben und über Bohrung geklemmt<br>*Top and hole clamping*<br><br>  <br>Von oben und über Bohrung geklemmt<br>*Top and hole clamping*<br><br>  <br>Über Bohrung geklemmt<br>*Hole clamping*<br><br>  <br>Durch Bohrung aufgeschraubt<br>*With screw through hole* |

| $D_1$ (mm) |
|---|
| **08** |
| **10** |
| **12** |
| **16** |
| **20** |
| **25** |
| **32** |
| **40** |
| **50** |
| **60** |

| $L_1$ (mm) | | $L_1$ (mm) | |
|---|---|---|---|
| 32 | **A** | 150 | **M** |
| 40 | **B** | 160 | **N** |
| 50 | **C** | 170 | **P** |
| 60 | **D** | 180 | **Q** |
| 70 | **E** | 200 | **R** |
| 80 | **F** | 250 | **S** |
| 90 | **G** | 300 | **T** |
| 100 | **H** | 350 | **U** |
| 110 | **J** | 400 | **V** |
| 125 | **K** | 450 | **W** |
| 140 | **L** | 500 | **Y** |
| Sonderlänge<br>*Special length* | | | **X** |

| | | | |
|---|---|---|---|
| **A** | **32** | **S** | **P** |
| Schaftausführung<br>*Type of Shank* | Schaft- Ø<br>*Shank- Ø* | Halterlänge<br>*Length* | Klemmsystem<br>*Clamping Method* |

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

| | |
|---|---|
| 80° | C |
| 55° | D |
| 75° | E |
| 86° | M |
| 35° | V |
| 85° | A |
| 82° | B |
| 55° | K |
| | H |
| | L |
| | O |
| | P |
| | R |
| | S |
| | T |
| | W |

| | |
|---|---|
| 90° | F |
| 75° | K |
| 95° | L |
| 107.5° | Q |
| 45° | S |
| 93° | U |
| 60° | W |
| 85° | Y |
| Sonderform *Special Style* | X |

| | |
|---|---|
| 3° | A |
| 5° | B |
| 7° | C |
| 15° | D |
| 20° | E |
| 25° | F |
| 30° | G |
| 0° | N |
| 11° | P |
| Sonstige *Others* | O |

L

R

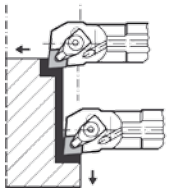
| d (mm) |
|---|
| 06 |
| 08 |
| 10 |
| 12 |
| 16 |
| 20 |
| 25 |
| 32 |

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

| C | L | N | L | 12 |
|---|---|---|---|---|
| Plattenform *Shape* | Halterform *Style* | Freiwinkel *Clearance Angle* | Halterausführung *Holder Execution* | Schneidenlänge *Length of Cutting Edge* |

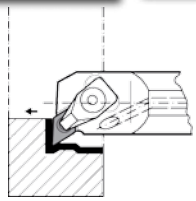
## Übersicht - Innendrehen
## *Overview - Internal Turning*

**DCLNR/L** 95°



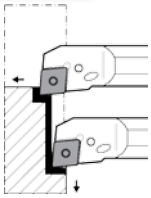
Seite / *page:* 1.23

**DDUNR/L** 93°



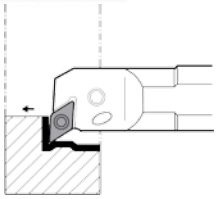
Seite / *page:* 1.23

**PCLNR/L** 95°



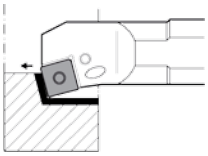
Seite / *page:* 1.24

**PDUNR/L** 93°



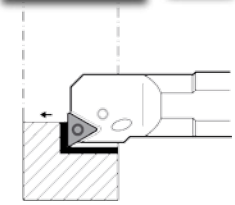
Seite / *page:* 1.24

**PSKNR/L** 75°



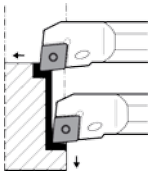
Seite / *page:* 1.25

**PTFNR/L** 90°



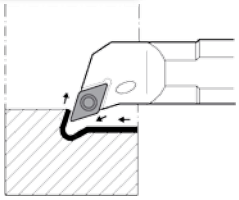
Seite / *page:* 1.25

**SCLCR/L** 95°



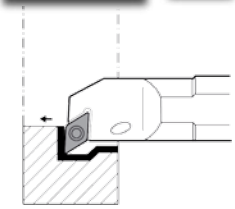
Seite / *page:* 1.26

**SDQCR/L** 107,5°



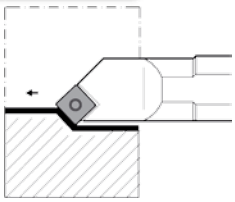
Seite / *page:* 1.27

**SDUCR/L** 93°



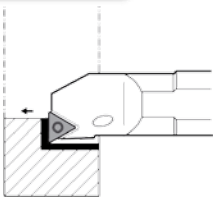
Seite / *page:* 1.27

**SSSCR/L** 45°



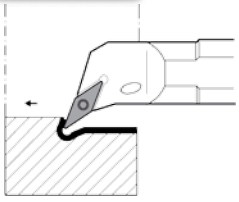
Seite / *page:* 1.28

**STFCR/L** 91°



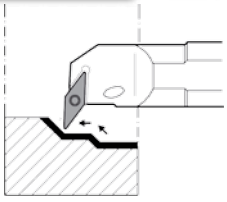
Seite / *page:* 1.28

**SVQCR/L** 107,5°



Seite / *page:* 1.29

**SVUCR/L** 93°

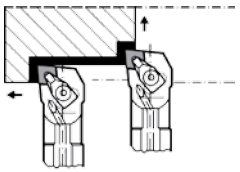


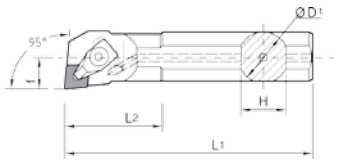
Seite / *page:* 1.29



● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# DCLNR/L 95°

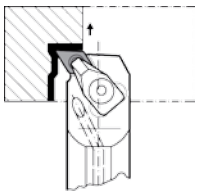


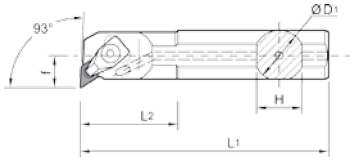



| Bezeichnung *Part Number* | Lager *Stock* | | Maße [mm] *Dimensions* | | | | | | | Ersatzteile *Spare Parts* | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | R | L | $D_{min}$ | $D_1$ | H | $L_1$ | $L_2$ | f | Seite / Page: 1.34 | | | | | | | | |
| **A25R DCLNR/L 12** | ● | ● | 32 | 25 | 23 | 200 | 50 | 17 | CN •• 1204 •• | 48.34.701 | 48.34.101 | 48.12.606 ( SW4 ) | 48.33.501 | 48.33.502 | 48.33.201 | 48.34.102 | 48.12.604 ( SW2,5 ) |
| **A32S DCLNR/L 12** | ○ | ○ | 40 | 32 | 30 | 250 | 60 | 22 | | | | | | | | | |
| **A40T DCLNR/L 12** | | | 50 | 40 | 37 | 300 | 60 | 27 | | | | | | | | | |
| **A50U DCLNR/L 12** | | | 63 | 50 | 47 | 350 | 65 | 35 | | | | | | | | | |

**A** : Stahlschaft mit Innenkühlung / *Steel Shank with inner coolant*

# DDUNR/L 93°



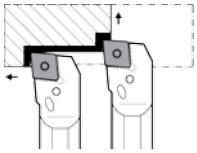


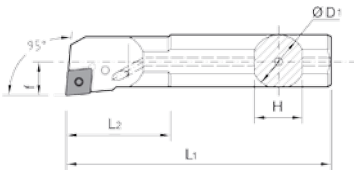

| Bezeichnung *Part Number* | Lager *Stock* | | Maße [mm] *Dimensions* | | | | | | | Ersatzteile *Spare Parts* | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | R | L | $D_{min}$ | $D_1$ | H | $L_1$ | $L_2$ | f | Seite / Page: 1.37 | | | | | | | | |
| **A32S DDUNR/L 15** | ○ | | 40 | 32 | 30 | 250 | 55 | 22 | DN •• 1506 •• | 48.34.701 | 48.34.101 | 48.12.606 ( SW4 ) | 48.33.501 | 48.33.502 | 48.33.202 | 48.34.102 | 48.12.604 ( SW2,5 ) |
| **A40T DDUNR/L 15** | | | 50 | 40 | 37 | 300 | 55 | 27 | | | | | | | | | |

**A** : Stahlschaft mit Innenkühlung / *Steel Shank with inner coolant*

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# PCLNR/L 95°

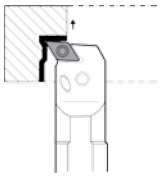


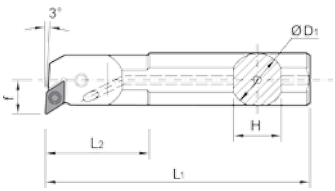



| Bezeichnung *Part Number* | Lager *Stock* R | L | Maße [mm] *Dimensions* Dmin | $D_1$ | H | $L_1$ | $L_2$ | f | Seite / Page: 1.34 | Ersatzteile *Spare Parts* | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **S16R PCLNR/L 09** | ○ | ○ | 21 | 16 | 15 | 150 | - | 11 | CN•• 0903 •• | 48.23.101 | 48.23.401 | - | - | 48.12.605 ( SW2 ) |
| **S20S PCLNR/L 09** | | | 25 | 20 | 19 | 180 | - | 13 | | | | | | |
| **S25T PCLNR/L 09** | | | 32 | 25 | 24 | 300 | - | 17 | | | | | | |
| **A25R PCLNR/L 12** | ● | ● | 32 | 25 | 24 | 200 | 40 | 17 | CN•• 1204 •• | 48.23.103 | 48.23.402 | - | - | 48.12.604 ( SW2,5 ) |
| **A32S PCLNR/L 12** | ● | ● | 44 | 32 | 31 | 250 | 50 | 22 | | 48.12.113 | 48.12.414 | 48.23.201 | 48.12.901 | 48.12.603 ( SW3 ) |
| **A40T PCLNR/L 12** | ● | ○ | 54 | 40 | 38.5 | 300 | 55 | 27 | | | | | | |
| **A50U PCLNR/L 12** | ○ | ○ | 63 | 50 | 48.5 | 350 | 56 | 35 | | | | | | |

**A** : Stahlschaft mit Innenkühlung / *Steel Shank with inner coolant*
**S** : Stahlschaft / *Steel Shank*

# PDUNR/L 93°





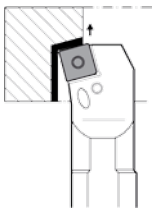

| Bezeichnung *Part Number* | Lager *Stock* R | L | Maße [mm] *Dimensions* Dmin | $D_1$ | H | $L_1$ | $L_2$ | f | Seite / Page: 1.37 | Ersatzteile *Spare Parts* | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **A20Q PDUNR/L 11** | ● | ○ | 25 | 20 | 19 | 180 | - | 16 | DN•• 1104 •• | 48.23.102 | 48.23.403 | - | - | 48.12.605 ( SW2 ) |
| **A25R PDUNR/L 11** | ○ | ○ | 31.5 | 25 | 24 | 200 | - | 18.5 | | | | | | |
| **A32S PDUNR/L 11** | ○ | ○ | 40 | 32 | 31 | 250 | - | 22 | | 48.12.116 | 48.12.417 | 48.12.204 | 48.12.905 | |
| **A32S PDUNR/L 15** | ● | ○ | 40 | 32 | 31 | 250 | 50 | 22 | DN•• 1506 •• | 48.12.113 | 48.12.418 | 48.33.202 | 48.12.901 | 48.12.603 ( SW3 ) |
| **A40T PDUNR/L 15** | ● | ○ | 50 | 40 | 38.5 | 300 | 50 | 27 | | | | | | |

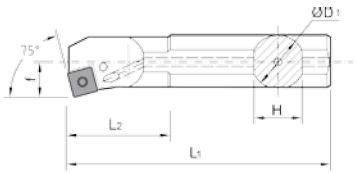
**A** : Stahlschaft mit Innenkühlung / *Steel Shank with inner coolant*
**S** : Stahlschaft / *Steel Shank*



● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# PSKNR/L 75°

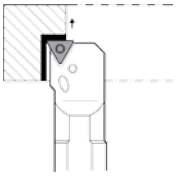


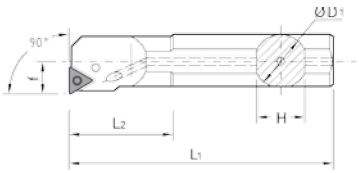



| Bezeichnung *Part Number* | Lager *Stock* | | Maße [mm] *Dimensions* | | | | | | Seite / Page: 1.41 | Ersatzteile *Spare Parts* | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | R | L | $D_{min}$ | $D_1$ | H | $L_1$ | $L_2$ | f | | | | | | |
| **A25R PSKNR/L 12** | ○ | ○ | 32 | 25 | 24 | 200 | 42 | 17 | SN •• 1204 •• | 48.23.103 | 48.23.402 | - | - | 48.12.604 ( SW2,5 ) |
| **A32S PSKNR/L 12** | ○ | ○ | 44 | 32 | 31 | 250 | 50 | 22 | | 48.12.113 | 48.12.414 | 48.23.203 | 48.12.901 | 48.12.603 ( SW3 ) |
| **A40T PSKNR/L 12** | | | 54 | 40 | 38.5 | 300 | 55 | 27 | | | | | | |

**A** : Stahlschaft mit Innenkühlung / *Steel Shank with inner coolant*

# PTFNR/L 90°



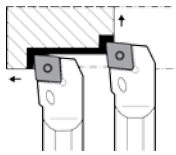



| Bezeichnung *Part Number* | Lager *Stock* | | Maße [mm] *Dimensions* | | | | | | Seite / Page: 1.43 | Ersatzteile *Spare Parts* | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | R | L | $D_{min}$ | $D_1$ | H | $L_1$ | $L_2$ | f | | | | | | |
| **S16R PTFNR/L 11** | ○ | ○ | 21 | 16 | 15 | 150 | - | 11 | TN •• 1103 •• | 48.23.102 | 48.23.406 | - | - | 48.12.605 ( SW2 ) |
| **S20S PTFNR/L 11** | ○ | ○ | 25 | 20 | 19 | 180 | - | 13 | | | | | | |
| **A25R PTFNR/L 16** | ○ | ○ | 32 | 25 | 24 | 200 | 40 | 17 | TN •• 1604 •• | 48.23.102 | 48.23.404 | - | - | 48.12.605 ( SW2 ) |
| **A32S PTFNR/L 16** | ○ | ○ | 44 | 32 | 31 | 250 | 50 | 22 | | 48.12.116 | 48.12.417 | 48.23.202 | 48.12.905 | 48.12.604 ( SW2,5 ) |
| **A40T PTFNR/L 16** | ○ | ○ | 54 | 40 | 38.5 | 300 | 55 | 27 | | | | | | |

**A** : Stahlschaft mit Innenkühlung / *Steel Shank with inner coolant*

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# SCLCR/L 95°



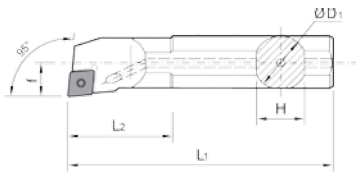



Fig. 1

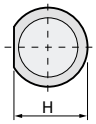
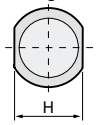



Fig. 2



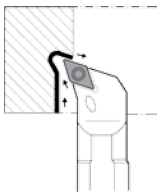

| Bezeichnung *Part Number* | | | Lager *Stock* R | Lager *Stock* L | Maße [mm] *Dimensions* Dmin | $D_1$ | H | $L_1$ | $L_2$ | f | Fig. | Seite / Page: 1.32 | Ersatzteile *Spare Parts* | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **A10H** | **SCLCR/L** | **0305** | ● | ○ | 5 | 10 | 9 | 100 | 25 | 2.5 | | | | | | |
| **A10H** | **SCLCR/L** | **0306** | ○ | | 6 | 10 | 9 | 100 | 25 | 3.0 | **2** | CCE T 0301 •• | 48.24.142 | - | - | |
| **A10J** | **SCLCR/L** | **0407** | ○ | ○ | 7 | 10 | 9 | 110 | 30 | 3.5 | | CCET 0401 •• | 48.24.143 | - | - | |
| **A10J** | **SCLCR/L** | **0408** | ○ | | 8 | 10 | 9 | 110 | 30 | 4.0 | | | | | | 75.20.621 (T06) |
| **E04G** | **SCLCR/L** | **0305** | ● | ● | 5 | 4 | 3.8 | 90 | - | 2.5 | | | | | | |
| **E05H** | **SCLCR/L** | **0306** | ● | ● | 6 | 5 | 4.4 | 100 | - | 3.0 | | CCET 0301 •• | 48.24.142 | - | - | |
| **E06J** | **SCLCR/L** | **0307** | ● | ● | 7 | 6 | 5.7 | 110 | - | 3.5 | **1** | | | | | |
| **E06J** | **SCLCR/L** | **0407** | ● | | 7 | 6 | 5.7 | 110 | - | 3.5 | | CCET 0401 •• | 48.24.143 | - | - | |
| **E07K** | **SCLCR/L** | **0408** | ● | | 8 | 7 | 6.4 | 120 | - | 4.0 | | | | | | |
| **S08H** | **SCLCR/L** | **06** | ● | ○ | 11 | 8 | 7 | 100 | 17 | 5 | | | | | | |
| **S10K** | **SCLCR/L** | **06** | ● | ○ | 14 | 10 | 9 | 125 | - | 6 | **2** | CC •• 0602 •• | 48.24.107 | - | - | 56.33.612 (T08) |
| **S12Q** | **SCLCR/L** | **06** | ● | ○ | 17 | 12 | 11 | 180 | 24 | 9 | | | | | | |
| **S16R** | **SCLCR/L** | **09** | ○ | ○ | 21 | 16 | 15 | 200 | 31.5 | 11 | | | | | | |
| **S20S** | **SCLCR/L** | **09** | ○ | ○ | 25 | 20 | 18 | 250 | 38 | 13 | **2** | CC •• 09T3 •• | 48.24.108 | - | - | 56.33.613 (T15) |
| **S25T** | **SCLCR/L** | **09** | ○ | ○ | 32 | 25 | 23 | 300 | 45 | 17 | | | | | | |
| **A0608H** | **SCLCR/L** | **06** | ● | ● | 8 | 8 | 7 | 100 | 25 | 4.5 | | | | | | |
| **A0810J** | **SCLCR/L** | **06** | ● | ● | 10.5 | 10 | 9 | 110 | 32 | 6 | | CC •• 0602 •• | 48.24.107 | - | - | 56.33.612 (T08) |
| **A1012K** | **SCLCR/L** | **06** | ● | ● | 12.5 | 12 | 11 | 125 | 38 | 7 | | | | | | |
| **A1216M** | **SCLCR/L** | **06** | ● | ● | 15.5 | 16 | 15 | 150 | 50 | 9 | | | | | | |
| **A08F** | **SCLCR/L** | **06** | ● | ● | 11 | 8 | 7.5 | 80 | 17 | 5 | | | | | | |
| **A10H** | **SCLCR/L** | **06** | ● | ● | 14 | 10 | 9.5 | 100 | 20 | 6 | | CC •• 0602 •• | 48.24.107 | - | - | 56.33.612 (T08) |
| **A12K** | **SCLCR/L** | **06** | ● | ● | 17 | 12 | 11 | 125 | 22 | 9 | | | | | | |
| **A16M** | **SCLCR/L** | **09** | ● | ● | 21 | 16 | 15 | 150 | 30 | 11 | | | | | | |
| **A20Q** | **SCLCR/L** | **09** | ● | ● | 25 | 20 | 19 | 180 | 38 | 13 | **2** | CC •• 09T3 •• | 48.24.108 | - | - | 56.33.613 (T15) |
| **A25R** | **SCLCR/L** | **09** | ● | ● | 32 | 25 | 24 | 200 | 40 | 17 | | | | | | |
| **A32S** | **SCLCR/L** | **12** | ● | ○ | 40 | 32 | 31 | 250 | 50 | 22 | | CC •• 1204 •• | 48.13.103 | 48.13.202 | 48.13.302 | |
| **A40T** | **SCLCR/L** | **12** | ○ | ○ | 50 | 40 | 38.5 | 300 | 60 | 27 | | | | | | |
| **E08K** | **SCLCR/L** | **06** | ● | ● | 11 | 8 | 7.5 | 125 | - | 5 | | | | | | |
| **E10M** | **SCLCR/L** | **06** | ● | ● | 14 | 10 | 9.5 | 150 | - | 6 | | CC •• 0602 •• | 48.24.107 | - | - | 56.33.612 (T08) |
| **E12Q** | **SCLCR/L** | **06** | ● | ● | 17 | 12 | 11 | 180 | - | 9 | | | | | | |
| **E16R** | **SCLCR/L** | **09** | ● | ● | 21 | 16 | 15 | 200 | 32.5 | 11 | **1** | | | | | |
| **E20S** | **SCLCR/L** | **09** | ● | ● | 25 | 20 | 19 | 250 | 38 | 13 | | CC •• 09T3 •• | 48.24.108 | - | - | 56.33.613 (T15) |
| **E25T** | **SCLCR/L** | **09** | | | 32 | 25 | 23 | 300 | 45 | 17 | | | | | | |

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



● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# SDQCR/L 107,5°



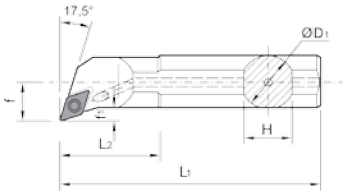



Fig. 1

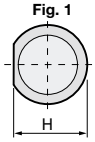
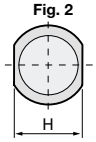


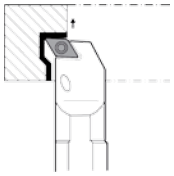

Fig. 2




| Bezeichnung *Part Number* | | | Lager *Stock* | | Maße [mm] *Dimensions* | | | | | | Fig. | Seite / Page: 1.36 | Ersatzteile *Spare Parts* | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | R | L | $D_{min}$ | $D_1$ | H | $L_1$ | $L_2$ | f | | | | | | |
| **A10H** | **SDQCR/L** | **07** | ● | ● | 14 | 10 | 9.5 | 100 | 18 | 7 | | | | | | |
| **A12K** | **SDQCR/L** | **07** | ● | ● | 17 | 12 | 11 | 125 | 22 | 9 | | DC•• 0702•• | 48.13.101 | - | - | 56.33.612 (T08) |
| **A16M** | **SDQCR/L** | **07** | ● | ● | 21 | 16 | 15 | 150 | 30 | 11 | | | | | | |
| **A20Q** | **SDQCR/L** | **07** | | | 25 | 20 | 19 | 180 | 32 | 13 | **2** | | | | | |
| **A16M** | **SDQCR/L** | **11** | ● | ○ | 21 | 16 | 15 | 150 | 30 | 11 | | | | | | |
| **A20Q** | **SDQCR/L** | **11** | ● | ● | 25 | 20 | 19 | 180 | 32 | 13 | | DC•• 11T3•• | 48.24.109 | - | - | 56.33.613 (T15) |
| **A25R** | **SDQCR/L** | **11** | ● | ● | 32 | 25 | 24 | 200 | 44 | 17 | | | | | | |
| **E10M** | **SDQCR/L** | **07** | ● | ● | 14 | 10 | 9.5 | 150 | - | 7 | | | | | | |
| **E12Q** | **SDQCR/L** | **07** | ● | ● | 17 | 12 | 11 | 180 | - | 9 | | DC•• 0702•• | 48.13.101 | - | - | 56.33.612 (T08) |
| **E16R** | **SDQCR/L** | **07** | ● | ● | 21 | 16 | 15 | 200 | - | 11 | | | | | | |
| **E20S** | **SDQCR/L** | **07** | ● | | 25 | 20 | 19 | 250 | - | 13 | **1** | | | | | |
| **E25T** | **SDQCR/L** | **11** | ● | | 32 | 25 | 24 | 300 | - | 17 | | DC•• 11T3•• | 48.24.109 | - | - | 56.33.613 (T15) |

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

# SDUCR/L 93°



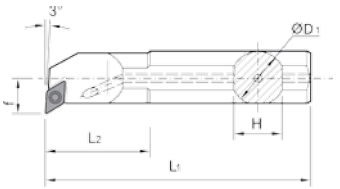



Fig. 1

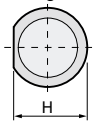
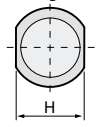



Fig. 2

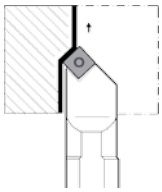


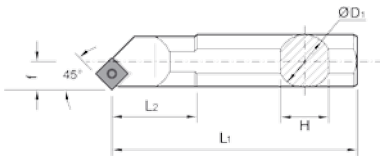

| Bezeichnung *Part Number* | | | Lager *Stock* | | Maße [mm] *Dimensions* | | | | | | Fig. | Seite / Page: 1.36 | Ersatzteile *Spare Parts* | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | R | L | $D_{min}$ | $D_1$ | H | $L_1$ | $L_2$ | f | | | | | | |
| **A0810H** | **SDUCR/L** | **07** | ● | ● | 12.5 | 10 | 9 | 100 | 22 | 7 | | | | | | |
| **A1012K** | **SDUCR/L** | **07** | ● | ● | 15.5 | 12 | 11 | 125 | 28 | 9 | | | | | | |
| **A1216M** | **SDUCR/L** | **07** | ● | ● | 19.5 | 16 | 15 | 150 | 36 | 11 | | DC•• 0702•• | 48.13.101 | - | - | 56.33.612 (T08) |
| **A10H** | **SDUCR/L** | **07** | ● | ● | 14 | 10 | 9.5 | 100 | 18 | 7 | | | | | | |
| **A12K** | **SDUCR/L** | **07** | ● | ● | 17 | 12 | 11 | 125 | 22 | 9 | | | | | | |
| **A16M** | **SDUCR/L** | **07** | ● | ● | 21 | 16 | 15 | 150 | 32 | 11 | **2** | | | | | |
| **A16M** | **SDUCR/L** | **11** | ○ | ○ | 20 | 16 | 15 | 15 | - | 11 | | | | | | |
| **A20Q** | **SDUCR/L** | **11** | ● | ● | 25 | 20 | 19 | 180 | 32 | 13 | | DC•• 11T3•• | 83.20.138 | - | - | 56.33.613 (T15) |
| **A25R** | **SDUCR/L** | **11** | ● | ● | 32 | 25 | 24 | 200 | 46 | 17 | | | | | | |
| **A32S** | **SDUCR/L** | **11** | ● | ○ | 40 | 32 | 31 | 250 | 50 | 22 | | | 48.13.102 | 48.13.203 | 48.13.301 | |
| **A40T** | **SDUCR/L** | **11** | ○ | ○ | 50 | 40 | 37 | 300 | 60 | 27 | | | | | | |
| **E10M** | **SDUCR/L** | **07** | ● | ● | 14 | 10 | 9.5 | 150 | - | 7 | | | | | | |
| **E12Q** | **SDUCR/L** | **07** | ● | ● | 17 | 12 | 11 | 180 | - | 9 | | DC•• 0702•• | 48.13.101 | - | - | 56.33.612 (T08) |
| **E16R** | **SDUCR/L** | **07** | ● | ● | 21 | 16 | 15 | 200 | - | 11 | | | | | | |
| **E20S** | **SDUCR/L** | **11** | ● | ● | 25 | 20 | 19 | 250 | - | 13 | **1** | | | | | |
| **E25T** | **SDUCR/L** | **11** | ● | | 32 | 25 | 24 | 300 | - | 17 | | DC•• 11T3•• | 48.24.109 | - | - | 56.33.613 (T15) |
| **E32T** | **SDUCR/L** | **11** | ○ | ○ | 40 | 32 | 31 | 300 | 50 | 22 | | | 48.13.102 | 48.13.203 | 48.13.301 | |

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

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# SSSCR/L 45°

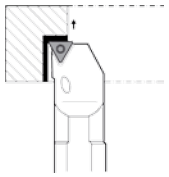





| Bezeichnung *Part Number* | Lager *Stock* R | L | Maße [mm] *Dimensions* Dmin | $D_1$ | H | $L_1$ | $L_2$ | f | Seite / Page: 1.40 | Ersatzteile *Spare Parts* | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **A16M SSSCR/L 09** | ○ | ○ | 21 | 16 | 15 | 150 | 29 | 11 | SC•• 09T3 •• | 48.24.108 | - | - | 56.33.613 (T15) |
| **A20Q SSSCR/L 09** | ● | ○ | 25 | 20 | 19 | 180 | 32 | 13 | | | | | |
| **A25R SSSCR/L 09** | ○ | ○ | 32 | 25 | 24 | 200 | 36 | 17 | | | | | |
| **A32S SSSCR/L 12** | | | 40 | 32 | 31 | 250 | 50 | 22 | SC•• 1204 •• | 48.13.103 | 48.13.206 | 48.13.302 | |
| **A40T SSSCR/L 12** | | | 49 | 40 | 39 | 300 | 60 | 27 | | | | | |

**A** : Stahlschaft mit Innenkühlung / *Steel Shank with inner coolant*

# STFCR/L 90°



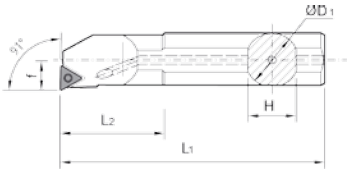



Fig. 1

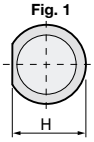
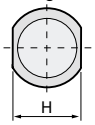



Fig. 2




| Bezeichnung *Part Number* | Lager *Stock* R | L | Maße [mm] *Dimensions* Dmin | $D_1$ | H | $L_1$ | $L_2$ | f | Fig. | Seite / Page: 1.42 | Ersatzteile *Spare Parts* | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| **A10H STFCR/L 09** | ○ | ○ | 14 | 10 | 9.50 | 100 | 23 | 7 | 2 | TC•• 0902 •• | 48.13.106 | - | - | 56.33.611 (T07) |
| **A12K STFCR/L 11** | ○ | ○ | 17 | 12 | 11 | 125 | 30 | 9 | | TC•• 1102 •• | 48.13.101 | - | - | 56.33.612 (T08) |
| **A16M STFCR/L 11** | ○ | ○ | 21 | 16 | 15 | 150 | 35 | 11 | | | | | | |
| **A20Q STFCR/L 11** | ○ | ○ | 25 | 20 | 19 | 180 | 36 | 13 | | | | | | |
| **A25R STFCR/L 16** | ○ | ○ | 32 | 25 | 24 | 200 | 49 | 17 | | TC•• 16T3 •• | 48.13.102 | 48.13.207 | 48.13.301 | 56.33.613 (T15) |
| **A32S STFCR/L 16** | | | 40 | 32 | 31 | 250 | 50 | 22 | | | | | | |

**A** : Stahlschaft mit Innenkühlung / *Steel Shank with inner coolant*



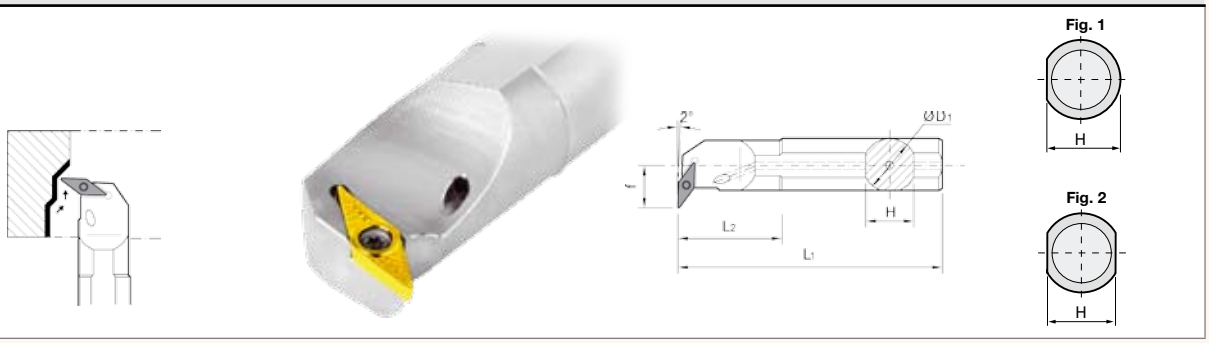
● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# SVQCR/L 107,5°

| Bezeichnung *Part Number* | | | | Lager *Stock* | | Maße [mm] *Dimensions* | | | | | | Seite / Page: 1.46 | Ersatzteile *Spare Parts* | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | R | L | Dmin | $D_1$ | H | $L_1$ | $L_2$ | f | | | | | |
| **A16M** | **SVQCR/L** | **11** | | ● | | 21 | 16 | 15 | 150 | 29 | 11 | VC•• 1103•• | 48.13.101 | - | - | 56.33.612 (T08) |
| **A20Q** | **SVQCR/L** | **11** | | ○ | | 25 | 20 | 18 | 180 | 32 | 13 | | | | | |
| **A25R** | **SVQCR/L** | **11** | | ○ | | 32 | 25 | 23 | 200 | 36 | 17 | | | | | |
| **A32S** | **SVQCR/L** | **16** | | | | 40 | 32 | 30 | 250 | 50 | 22 | VC•• 1604•• | 48.13.102 | 48.13.208 | 48.13.301 | 56.33.613 (T15) |

**A** : Stahlschaft mit Innenkühlung / *Steel Shank with inner coolant*

# SVUCR/L 93°




| Bezeichnung *Part Number* | | | | Lager *Stock* | | Maße [mm] *Dimensions* | | | | | | Fig. | Seite / Page: 1.46 | Ersatzteile *Spare Parts* | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | R | L | Dmin | $D_1$ | H | $L_1$ | $L_2$ | f | | | | | | |
| **A16M** | **SVUCR/L** | **11** | | ● | ○ | 21 | 16 | 15 | 150 | 29 | 11 | **2** | VC•• 1103•• | 48.13.101 | - | - | 56.33.612 (T08) |
| **A20Q** | **SVUCR/L** | **11** | | ● | ○ | 25 | 20 | 18 | 180 | 32 | 13 | | | | | | |
| **A25R** | **SVUCR/L** | **11** | | ○ | ○ | 32 | 25 | 23 | 200 | 36 | 17 | | | | | | |
| **A32S** | **SVUCR/L** | **16** | | ● | ○ | 40 | 32 | 30 | 250 | 50 | 22 | | VC•• 1604•• | 48.13.102 | 48.13.208 | 48.13.301 | 56.33.613 (T15) |
| **E16R** | **SVUCR/L** | **11** | | ○ | | 21 | 16 | 15 | 200 | 16 | 11 | **1** | VC•• 1103•• | 48.13.101 | - | - | 56.33.612 (T08) |
| **E20S** | **SVUCR/L** | **11** | | | | 25 | 20 | 18 | 250 | 20 | 13 | | | | | | |
| **E25T** | **SVUCR/L** | **11** | | ○ | | 32 | 25 | 23 | 300 | 25 | 17 | | | | | | |

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

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

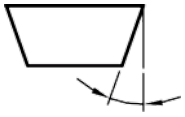
## ISO - Bezeichnungssystem für Wendeschneidplatten
## *ISO Designation System for Indexable Inserts*

| T | N | M | G |
|---|---|---|---|
| Plattenform *Shape* | Freiwinkel *Clearance Angle* | Toleranzen *Tolerances* | Plattentyp *Type of Inserts* |

### T – Plattenform / Shape

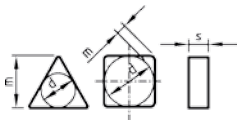
| | |
|---|---|
| 80° | C |
| 55° | D |
| 75° | E |
| 86° | M |
| 35° | V |
| 85° | A |
| 82° | B |
| 55° | K |
| | H |
| | L |
| | O |
| | P |
| | R |
| | S |
| | T |
| | W |

### N – Freiwinkel / Clearance Angle



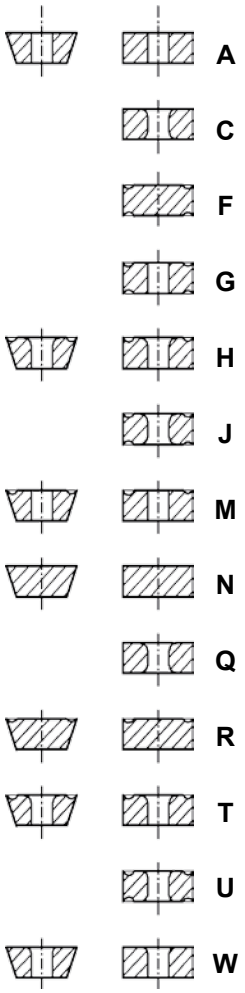
| | |
|---|---|
| 3° | A |
| 5° | B |
| 7° | C |
| 15° | D |
| 20° | E |
| 25° | F |
| 30° | G |
| 0° | N |
| 11° | P |
| Sonstige *Others* | O |

### M – Toleranzen / Tolerances



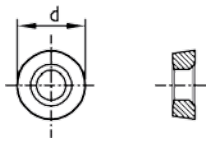
| Grenzabmaße (mm) *Range of tolerance* d +/- | m +/- | s +/- | Klasse *Class* |
|---|---|---|---|
| 0.025 | 0.005 | 0.025 | A |
| 0.025 | 0.013 | 0.025 | C |
| 0.025 | 0.025 | 0.025 | E |
| 0.013 | 0.005 | 0.025 | F |
| 0.025 | 0.025 | 0.05-0.13 | G |
| 0.013 | 0.013 | 0.025 | H |
| 0.05-0.15 | 0.005 | 0.025 | J |
| 0.05-0.15 | 0.013 | 0.025 | K |
| 0.05-0.15 | 0.025 | 0.025 | L |
| 0.05-0.15 | 0.08-0.2 | 0.05-0.13 | M |
| 0.05-0.15 | 0.08-0.2 | 0.025 | N |
| 0.08-0.25 | 0.13-0.38 | 0.13 | U |

### G – Plattentyp / Type of Inserts

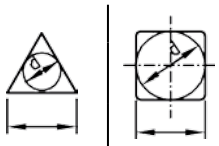


| | |
|---|---|
| | A |
| | C |
| | F |
| | G |
| | H |
| | J |
| | M |
| | N |
| | Q |
| | R |
| | T |
| | U |
| | W |
| Sonderausführung *Special Shape* | X |

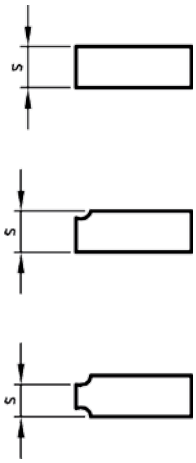
## ISO - Bezeichnungssystem für Wendeschneidplatten
## *ISO Designation System for Indexable Inserts*



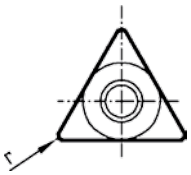

| d (mm) |
|---|
| 06 |
| 08 |
| 10 |
| 12 |
| 16 |
| 20 |
| 25 |
| 32 |



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




| s (mm) | Kennzahl *Index* |
|---|---|
| 1.59 | **01** |
| 1.98 | **T1** |
| 2.38 | **02** |
| 3.18 | **03** |
| 3.97 | **T3** |
| 4.76 | **04** |
| 5.56 | **05** |
| 6.35 | **06** |
| 7.94 | **07** |
| 9.52 | **09** |
| 11.11 | **11** |
| 12.70 | **12** |




| r (mm) | Kennzahl *Index* |
|---|---|
| 0.2 | **02** |
| 0.4 | **04** |
| 0.8 | **08** |
| 1.2 | **12** |
| 1.6 | **16** |
| 2.4 | **24** |
| 0 | **00** |

00: Runde Platte (Zoll)
*Round Insert (inch)*

MO: Runde Platte (metr.)
*Round Insert (metr.)*

**F**

Scharf
*Sharp*

**E**

Gerundet
*Rounded*

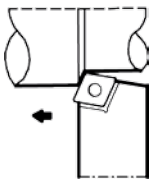
**T**

Gefast
*Chamfered*

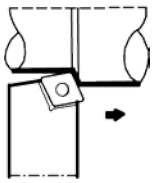
**S**

Gefast und gerundet
*Chamfered and rounded*

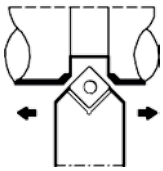
R



L



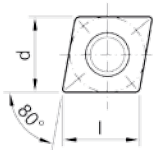
N

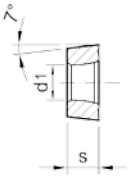


| 16 | 04 | 04 | E | R |
|---|---|---|---|---|
| Schneidenlänge *Length of Cutting Edge* | Plattendicke *Thickness of Insert* | Eckenradius *Corner Radius* | Schneidkante *Cutting Edge* | Schneidrichtung *Cutting Direction* |

# CC□□

80°




| Werkstück / *Workpiece* | | | Machinentyp *Machining types* |
|---|---|---|---|
| | Stahl / *Steel* | A (P) | ● Gute Bearbeitungsbedingungen / *Continuous cutting* |
| | Rostfreier Stahl / *Stainless steel* | R (M) | ⇕ Normale Bearbeitungsbedingungen / *General cutting* |
| | Guss / *Cast iron* | F (K) | ✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting* |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | |
| | Gehärteter Stahl / *Hardened steel* | H | |

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **CCET-L** | **03 01 02 L** | | | | ● | | | | | | | | | | | | ○ | 3.30 | 3.50 | 1.39 | 1.90 | 0,01~0,05 | 0,10~0,30 | | |
| | **04 01 02 L** | | | | ● | | | | | | | | | | | | ○ | 4.10 | 4.30 | 1.79 | 2.30 | 0,01~0,10 | 0,10~0,50 | | SCLC R/L / 1.26 |

| Werkstück / *Workpiece* | | | Machinentyp *Machining types* |
|---|---|---|---|
| | Stahl / *Steel* | A (P) | ● Gute Bearbeitungsbedingungen / *Continuous cutting* |
| | Rostfreier Stahl / *Stainless steel* | R (M) | ⇕ Normale Bearbeitungsbedingungen / *General cutting* |
| | Guss / *Cast iron* | F (K) | ✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting* |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | |
| | Gehärteter Stahl / *Hardened steel* | H | |

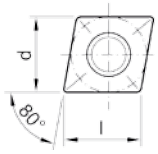
| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **CCGT-ALX** | **06 02 02 - ALX** | | ● | | ● | | | | | | | | | ● | | | ● | 6.20 | 6.35 | 2.38 | 2.80 | 0,01~0,30 | 0,05~3,00 | | |
| | **06 02 04 - ALX** | | ● | | ● | | | | | | | | | ● | | | ● | 6.00 | 6.35 | 2.38 | 2.80 | 0,02~0,40 | 0,10~3,00 | | |
| | **09 T3 02 - ALX** | | ● | | ● | | | | | | | | | ● | | | ● | 9.40 | 9.52 | 3.97 | 4.40 | 0,01~0,30 | 0,05~3,00 | | |
| | **09 T3 04 - ALX** | | ● | | ● | | | | | | | | | ● | | | ● | 9.20 | 9.52 | 3.97 | 4.40 | 0,02~0,40 | 0,10~4,00 | SCLC R/L / 1.13 | SCLC R/L / 1.26 |
| | **09 T3 08 - ALX** | | ● | | ○ | | | | | | | | | | | | ● | 8.80 | 9.52 | 3.97 | 4.40 | 0,03~0,50 | 0,10~5,00 | | |
| | **12 04 02 - ALX** | | ○ | | ○ | | | | | | | | | | | | ● | 12.60 | 12.70 | 4.76 | 5.50 | 0,01~0,30 | 0,50~5,00 | | |
| | **12 04 04 - ALX** | | ● | | ● | | | | | | | | | ● | | | ● | 12.40 | 12.70 | 4.76 | 5.50 | 0,02~0,40 | 0,10~5,00 | | |
| | **12 04 08 - ALX** | | ● | | ○ | | | | | | | | | | | | ● | 12.00 | 12.70 | 4.76 | 5.50 | 0,03~0,50 | 0,10~5,00 | | |

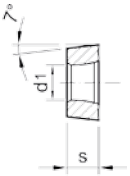


● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# CC□□

80°




| Werkstück / *Workpiece* | | | Machinentyp *Machining types* |
|---|---|---|---|
| | Stahl / *Steel* | A (P) | ● Gute Bearbeitungsbedingungen / *Continuous cutting* |
| | Rostfreier Stahl / *Stainless steel* | R (M) | ⧗ Normale Bearbeitungsbedingungen / *General cutting* |
| | Guss / *Cast iron* | F (K) | ✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting* |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | |
| | Gehärteter Stahl / *Hardened steel* | H | |

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **CCMT-F19** | **06 02 02 -F19** | | | | | | ● | | | | | | ● | | | | | 6.20 | 6.35 | 2.38 | 2.80 | 0,03~0,11 | 0,06~1,70 | SCLC R/L / 1.13 | SCLC R/L / 1.26 |
| | **06 02 04 -F19** | | | | | | ● | | | | | | ● | | | | | 6.00 | 6.35 | 2.38 | 2.80 | 0,05~0,17 | 0,10~1,70 | | |
| | **09 T3 02 -F19** | | | | | | ● | | | | | | ● | | | | | 9.40 | 9.52 | 3.97 | 4.40 | 0,04~0,15 | 0,08~2,00 | | |
| | **09 T3 04 -F19** | | | | | | ● | | | | | | ● | | | | | 9.20 | 9.52 | 3.97 | 4.40 | 0,06~0,23 | 0,11~2,00 | | |
| | **09 T3 08 -F19** | | | | | | ● | | | | | | ● | | | | | 8.80 | 9.52 | 3.97 | 4.40 | 0,08~0,30 | 0,15~2,00 | | |
| | **12 04 04 -F19** | | | | | | ● | | | | | | ● | | | | | 12.40 | 12.70 | 4.76 | 5.50 | 0,07~0,27 | 0,14~2,00 | | |
| **CCMT-M12** | **06 02 02 -M12** | | | | | ○ | | | | | | | | | | | | 6.20 | 6.35 | 2.38 | 2.80 | 0,03~0,12 | 0,10~1,50 | SCLC R/L / 1.13 | SCLC R/L / 1.26 |
| | **06 02 04 -M12** | | | | | ● | | | | | | | | | | | | 6.00 | 6.35 | 2.38 | 2.80 | 0,06~0,17 | 0,20~2,40 | | |
| | **06 02 08 -M12** | | | | | ○ | | | | | | | | | | | | 5.60 | 6.35 | 2.38 | 2.80 | 0,08~0,23 | 0,40~2,40 | | |
| | **09 T3 02 -M12** | | | | | ○ | | | | | | | | | | | | 9.40 | 9.52 | 3.97 | 4.40 | 0,07~0,22 | 0,10~2,00 | | |
| | **09 T3 04 -M12** | | | | | ● | | | | | | | | | | | | 9.20 | 9.52 | 3.97 | 4.40 | 0,08~0,23 | 0,30~3,00 | | |
| | **09 T3 08 -M12** | | | | | ○ | | | | | | | | | | | | 8.80 | 9.52 | 3.97 | 4.40 | 0,10~0,30 | 0,50~3,00 | | |
| **CCMT-M17** | **06 02 02 -M17** | | | | | | | ● | | | | | | | | | | 6.20 | 6.35 | 2.38 | 2.80 | 0,04~0,20 | 0,10~1,50 | SCLC R/L / 1.13 | SCLC R/L / 1.26 |
| | **06 02 04 -M17** | | | | | | | ● | | | | | | | | | | 6.00 | 6.35 | 2.38 | 2.80 | 0,05~0,30 | 0,08~1,80 | | |
| | **06 02 08 -M17** | | | | | | | ○ | | | | | | | | | | 5.60 | 6.35 | 2.38 | 2.80 | 0,05~0,45 | 0,08~1,80 | | |
| | **09 T3 04 -M17** | | | | | | | ● | | | | | | | | | | 9.20 | 9.52 | 3.97 | 4.40 | 0,05~0,30 | 0,15~2,70 | | |
| | **09 T3 08 -M17** | | | | | | | ● | | | | | | | | | | 8.80 | 9.52 | 3.97 | 4.40 | 0,05~0,45 | 0,15~2,70 | | |
| | **12 04 04 -M17** | | | | | | | ● | | | | | | | | | | 12.40 | 12.70 | 4.76 | 5.50 | 0,05~0,30 | 0,15~2,70 | | |
| | **12 04 08 -M17** | | | | | | | ● | | | | | | | | | | 12.00 | 12.70 | 4.76 | 5.50 | 0,05~0,45 | 0,15~2,70 | | |
| **CCMT-M18** | **06 02 04 -M18** | | | ○ | | | | | | | | | | | | ● | | 6.00 | 6.35 | 2.38 | 2.80 | 0,06~0,25 | 0,10~2,00 | SCLC R/L / 1.13 | SCLC R/L / 1.26 |
| | **09 T3 04 -M18** | | | | | | | | | | | | | | | ● | | 9.40 | 9.52 | 3.97 | 4.40 | 0,06~0,25 | 0,20~3,00 | | |
| | **09 T3 08 -M18** | | | ○ | | | | | | | | | | | | ● | | 8.80 | 9.52 | 3.97 | 4.40 | 0,07~0,35 | 0,20~3,00 | | |
| | **12 04 04 -M18** | | | ○ | | | | | | | | | | | | ● | | 12.40 | 12.70 | 4.76 | 5.50 | 0,06~0,25 | 0,20~3,00 | | |
| | **12 04 08 -M18** | | | ○ | | | | | | | | | | | | ● | | 12.00 | 12.70 | 4.76 | 5.50 | 0,07~0,35 | 0,20~3,00 | | |
| | **12 04 12 -M18** | | | | | | | | | | | | | | | ● | | 11.60 | 12.70 | 4.76 | 5.50 | 0,08~0,45 | 0,20~3,00 | | |
| **CCMT-MD** | **06 02 04 -MD** | | | | | | | | | | ● | ○ | | | ○ | | | 6.00 | 6.35 | 2.38 | 2.80 | 0,06~0,17 | 0,20~2,30 | SCLC R/L / 1.13 | SCLC R/L / 1.26 |
| | **06 02 08 -MD** | | | | | | | | | | ● | ○ | | | ○ | | | 5.60 | 6.35 | 2.38 | 2.80 | 0,08~0,23 | 0,40~2,30 | | |
| | **09 T3 04 -MD** | | | | | | | | | | ● | ○ | | | ○ | | | 9.20 | 9.52 | 3.97 | 4.40 | 0,06~0,17 | 0,20~2,50 | | |
| | **09 T3 08 -MD** | | | | | | | | | | ○ | ○ | | | ○ | | | 8.80 | 9.52 | 3.97 | 4.40 | 0,08~0,23 | 0,30~2,50 | | |
| | **12 04 04 -MD** | | | | | | | | | | ● | ○ | | | ○ | | | 12.40 | 12.70 | 4.76 | 5.50 | 0,06~0,17 | 0,30~3,50 | | |
| | **12 04 08 -MD** | | | | | | | | | | ● | ○ | | | ○ | | | 12.00 | 12.70 | 4.76 | 5.50 | 0,08~0,23 | 0,50~3,50 | | |

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

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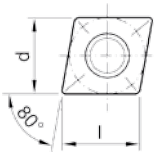


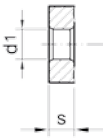


| Werkstück / *Workpiece* | | | Machinentyp / *Machining types* |
|---|---|---|---|
| | Stahl / *Steel* | A (P) | ● Gute Bearbeitungsbedingungen / *Continuous cutting* |
| | Rostfreier Stahl / *Stainless steel* | R (M) | ⧗ Normale Bearbeitungsbedingungen / *General cutting* |
| | Guss / *Cast iron* | F (K) | ✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting* |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | |
| | Gehärteter Stahl / *Hardened steel* | H | |

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **CNGG-A20** | **12 04 04 - A20** | | | | ○ | ● | | | | | | | | | | | ● | 12.40 | 12.70 | 4.76 | 5.16 | 0,05~0,28 | 0,23~4,80 | DCLN R/L / 1.06<br>PCBN R/L / 1.08<br>PCLN R/L / 1.09 | DCLN R/L / 1.23<br>PCLN R/L / 1.24 |
| | **12 04 08 - A20** | | | | ○ | ● | | | | | | | | | | | ● | 12.00 | 12.70 | 4.76 | 5.16 | 0,10~0,40 | 0,80~3,50 | | |

| Werkstück / *Workpiece* | | | Machinentyp / *Machining types* |
|---|---|---|---|
| | Stahl / *Steel* | A (P) | ● Gute Bearbeitungsbedingungen / *Continuous cutting* |
| | Rostfreier Stahl / *Stainless steel* | R (M) | ⧗ Normale Bearbeitungsbedingungen / *General cutting* |
| | Guss / *Cast iron* | F (K) | ✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting* |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | |
| | Gehärteter Stahl / *Hardened steel* | H | |

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **CNMG-C12** | **12 04 08 - C12** | | | | | | | ● | ○ | | | | | | | | | 12.00 | 12.70 | 4.76 | 5.16 | 0,08~0,40 | 0,80~4,00 | DCLN R/L / 1.06<br>PCBN R/L / 1.08<br>PCLN R/L / 1.09 | DCLN R/L / 1.23<br>PCLN R/L / 1.24 |
| **CNMG-M12** | **12 04 04 - M12** | | | | | ○ | | | | | | | | | | | | 12.40 | 12.70 | 4.76 | 5.16 | 0,05~0,30 | 0,90~5,00 | DCLN R/L / 1.06<br>PCBN R/L / 1.08<br>PCLN R/L / 1.09 | DCLN R/L / 1.23<br>PCLN R/L / 1.24 |
| | **12 04 08 - M12** | | | | | ○ | | | | | | | | | | | | 12.00 | 12.70 | 4.76 | 5.16 | 0,10~0,50 | 1,00~5,00 | | |
| **CNMG-M14** | **12 04 04 - M14** | | | | | | | ● | | | | | | | | | | 12.40 | 12.70 | 4.76 | 5.16 | 0,08~0,20 | 0,15~2,70 | DCLN R/L / 1.06<br>PCBN R/L / 1.08<br>PCLN R/L / 1.09 | DCLN R/L / 1.23<br>PCLN R/L / 1.24 |
| | **12 04 08 - M14** | | | | | | | ● | | | | | | | | | | 12.00 | 12.70 | 4.76 | 5.16 | 0,15~0,38 | 0,30~4,50 | | |
| **CNMG-M15** | **12 04 04 - M15** | | | ○ | | | | | | | | | | | | ● | | 12.40 | 12.70 | 4.76 | 5.16 | 0,07~0,35 | 0,20~3,00 | DCLN R/L / 1.06<br>PCBN R/L / 1.08<br>PCLN R/L / 1.09 | DCLN R/L / 1.23<br>PCLN R/L / 1.24 |
| | **12 04 08 - M15** | | | ○ | | | | | | | | | | | | ● | | 12.00 | 12.70 | 4.76 | 5.16 | 0,18~0,45 | 0,30~5,00 | | |
| | **12 04 12 - M15** | | | | | | | | | | | | | | | ● | | 11.60 | 12.70 | 4.76 | 5.16 | 0,23~0,60 | 0,50~5,00 | | |



● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

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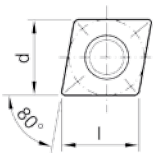
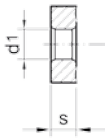



| Werkstück / *Workpiece* | | |
|---|---|---|
| Stahl / *Steel* | A (P) | |
| Rostfreier Stahl / *Stainless steel* | R (M) | |
| Guss / *Cast iron* | F (K) | |
| Nichtmet. Werkstoffe / *Non-fer. metall.* | N | |
| Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | |
| Gehärteter Stahl / *Hardened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

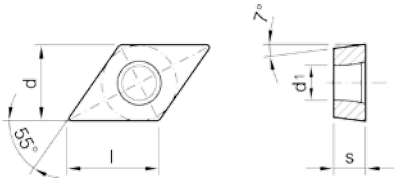
**Machinentyp** ***Machining types***

- ● Gute Bearbeitungsbedingungen / *Continuous cutting*
- ⧗ Normale Bearbeitungsbedingungen / *General cutting*
- ✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **CNMG-MD** | **12 04 04 - MD** | | | | | | | | | | ● | ● | | | ● | | | 12.40 | 12.70 | 4.76 | 5.16 | 0,05~0,35 | 0,80~4,50 | DCLN R/L / 1.06<br>PCBN R/L / 1.08<br>PCLN R/L / 1.09 | DCLN R/L / 1.23<br>PCLN R/L / 1.24 |
| | **12 04 08 - MD** | | | | | | | | | | ● | ● | | | ● | | | 12.00 | 12.70 | 4.76 | 5.16 | 0,08~0,45 | 1,00~4,50 | | |
| | **12 04 12 - MD** | | | | | | | | | | ● | ○ | | | ○ | | | 11.60 | 12.70 | 4.76 | 5.16 | 0,10~0,50 | 1,20~4,50 | | |
| **CNMG-S12** | **12 04 04 - S12** | | | | | ○ | | | | | | | | | | | | 12.40 | 12.70 | 4.76 | 5.16 | 0,05~0,20 | 1,00~4,50 | DCLN R/L / 1.06<br>PCBN R/L / 1.08<br>PCLN R/L / 1.09 | DCLN R/L / 1.23<br>PCLN R/L / 1.24 |
| | **12 04 08 - S12** | | | | | ● | | | | | | | | | | | | 12.00 | 12.70 | 4.76 | 5.16 | 0,10~0,40 | 1,00~4,50 | | |

● JD-Lager / *JD-Stock*  ○ begrenzte Lagerhaltung / *limited stock*

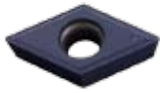
# DC□□




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

**Machinentyp** / ***Machining types***

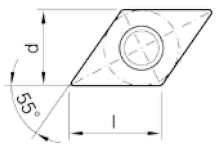
- ● Gute Bearbeitungsbedingungen / *Continuous cutting*
- ⇕ Normale Bearbeitungsbedingungen / *General cutting*
- ✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **DCGT-ALX** | **07 02 02 - ALX** | | ● | | ○ | | | | | | | | | | | | ● | 7.50 | 6.35 | 2.38 | 2.80 | 0,01~0,30 | 0,05~3,00 | | |
| | **07 02 04 - ALX** | | ● | | ● | | | | | | | | | ● | | | ● | 7.30 | 6.35 | 2.38 | 2.80 | 0,02~0,40 | 0,10~4,00 | SDAC R/L / 1.14 | |
| | **07 02 08 - ALX** | | | | ○ | | | | | | | | | | | | | 6.80 | 6.35 | 2.38 | 2.80 | 0,02~0,40 | 0,10~4,00 | SDHC R/L / 1.14 | SDQC R/L / 1.27 |
| | **11 T3 02 - ALX** | | ● | | ● | | | | | | | | | ● | | | ● | 11.40 | 9.52 | 3.97 | 4.40 | 0,02~0,30 | 0,05~4,00 | SDJC R/L / 1.15 | SDUC R/L / 1.27 |
| | **11 T3 04 - ALX** | | ● | | ● | | | | | | | | | ● | | | ● | 11.20 | 9.52 | 3.97 | 4.40 | 0,03~0,50 | 0,10~5,00 | SDNCN / 1.15 | |
| | **11 T3 08 - ALX** | | ● | | ● | | | | | | | | | ● | | | ● | 10.80 | 9.52 | 3.97 | 4.40 | 0,03~0,50 | 0,10~5,00 | | |
| **DCMT-F19** | **07 02 02 - F19** | | | | | | ● | | | | | | ● | | | | | 7.50 | 6.35 | 2.38 | 2.80 | 0,03~0,11 | 0,06~1,50 | | |
| | **07 02 04 - F19** | | | | | | ● | | | | | | ● | | | | | 7.30 | 6.35 | 2.38 | 2.80 | 0,05~0,17 | 0,08~1,50 | SDAC R/L / 1.14 | |
| | **11 T3 02 - F19** | | | | | | ● | | | | | | ● | | | | | 11.40 | 9.52 | 3.97 | 4.40 | 0,04~0,15 | 0,08~2,00 | SDHC R/L / 1.14 | SDQC R/L / 1.27 |
| | **11 T3 04 - F19** | | | | | | ● | | | | | | ● | | | | | 11.20 | 9.52 | 3.97 | 4.40 | 0,06~0,23 | 0,11~2,00 | SDJC R/L / 1.15 | SDUC R/L / 1.27 |
| | **11 T3 08 - F19** | | | | | | ● | | | | | | ● | | | | | 10.80 | 9.52 | 3.97 | 4.40 | 0,08~0,30 | 0,15~2,00 | SDNCN / 1.15 | |
| **DCMT-M12** | **11 T3 04 - M12** | | | | | ● | | | | | | | | | | | | 11.20 | 9.52 | 3.97 | 4.40 | 0,08~0,23 | 0,30~3,00 | | |
| | **11 T3 08 - M12** | | | | | ● | | | | | | | | | | | | 10.80 | 9.52 | 3.97 | 4.40 | 0,10~0,30 | 0,50~3,00 | SDAC R/L / 1.14 | |
| | | | | | | | | | | | | | | | | | | | | | | | | SDHC R/L / 1.14 | SDQC R/L / 1.27 |
| | | | | | | | | | | | | | | | | | | | | | | | | SDJC R/L / 1.15 | SDUC R/L / 1.27 |
| | | | | | | | | | | | | | | | | | | | | | | | | SDNCN / 1.15 | |
| **DCMT-M17** | **07 02 02 - M17** | | | | | | | ● | | | | | | | | | | 7.50 | 6.35 | 2.38 | 2.80 | 0,05~0,15 | 0,08~1,80 | | |
| | **07 02 04 - M17** | | | | | | | ● | | | | | | | | | | 7.30 | 6.35 | 2.38 | 2.80 | 0,05~0,30 | 0,08~1,80 | SDAC R/L / 1.14 | |
| | **07 02 08 - M17** | | | | | | | ● | | | | | | | | | | 6.80 | 6.35 | 2.38 | 2.80 | 0,05~0,45 | 0,08~1,80 | SDHC R/L / 1.14 | SDQC R/L / 1.27 |
| | **11 T3 02 - M17** | | | | | | | ● | | | | | | | | | | 11.40 | 9.52 | 3.97 | 4.40 | 0,05~0,15 | 0,15~2,70 | SDJC R/L / 1.15 | SDUC R/L / 1.27 |
| | **11 T3 04 - M17** | | | | | | | ● | | | | | | | | | | 11.20 | 9.52 | 3.97 | 4.40 | 0,05~0,30 | 0,15~2,70 | SDNCN / 1.15 | |
| | **11 T3 08 - M17** | | | | | | | ● | | | | | | | | | | 10.80 | 9.52 | 3.97 | 4.40 | 0,05~0,45 | 0,15~2,70 | | |
| **DCMT-M18** | **07 02 04 - M18** | | | ○ | | | | | | | | | | | | ● | | 7.30 | 6.35 | 2.38 | 2.80 | 0,06~0,25 | 0,10~2,00 | | |
|  | **11 T3 04 - M18** | | | ○ | | | | | | | | | | | | ● | | 11.20 | 9.52 | 3.97 | 4.40 | 0,06~0,25 | 0,20~3,00 | SDAC R/L / 1.14 | |
| | **11 T3 08 - M18** | | | ○ | | | | | | | | | | | | ● | | 10.80 | 9.52 | 3.97 | 4.40 | 0,07~0,35 | 0,20~3,00 | SDHC R/L / 1.14 | SDQC R/L / 1.27 |
| | | | | | | | | | | | | | | | | | | | | | | | | SDJC R/L / 1.15 | SDUC R/L / 1.27 |
| | | | | | | | | | | | | | | | | | | | | | | | | SDNCN / 1.15 | |
| **DCMT-MD** | **07 02 04 - MD** | | | | | | | | | | ● | ○ | | | ○ | | | 7.30 | 6.35 | 2.38 | 2.80 | 0,06~0,17 | 0,20~2,40 | | |
| | **11 T3 04 - MD** | | | | | | | | | | ● | ○ | | | ○ | | | 11.20 | 9.52 | 3.97 | 4.40 | 0,06~0,17 | 0,30~3,00 | SDAC R/L / 1.14 | |
| | **11 T3 08 - MD** | | | | | | | | | | ● | ○ | | | ○ | | | 10.80 | 9.52 | 3.97 | 4.40 | 0,08~0,23 | 0,50~3,00 | SDHC R/L / 1.14 | SDQC R/L / 1.27 |
| | | | | | | | | | | | | | | | | | | | | | | | | SDJC R/L / 1.15 | SDUC R/L / 1.27 |
| | | | | | | | | | | | | | | | | | | | | | | | | SDNCN / 1.15 | |



● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

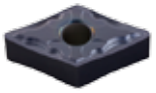
# DN□□




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

**Machinentyp** / ***Machining types***

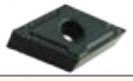
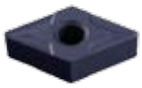
● Gute Bearbeitungsbedingungen / *Continuous cutting*
⇕ Normale Bearbeitungsbedingungen / *General cutting*
✣ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **DNGG-A20** | **15 06 04 - A20** | | | | | ● | | | | | | | | | | | ● | 15.50 | 12.70 | 6.35 | 5.16 | 0,05~0,25 | 0,80~3,50 | DDJN R/L / 1.07<br>PDJN R/L / 1.10 | DDUN R/L/ 1.23<br>PDUN R/L/ 1.24 |
|  | **15 06 08 - A20** | | | | | ● | | | | | | | | | | | ● | 15.50 | 12.70 | 6.35 | 5.16 | 0,05~0,40 | 0,80~3,50 | | |

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

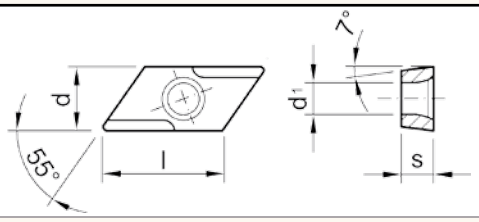
**Machinentyp** / ***Machining types***

● Gute Bearbeitungsbedingungen / *Continuous cutting*
⇕ Normale Bearbeitungsbedingungen / *General cutting*
✣ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **DNMG-C12** | **15 06 08 - C12** | | | | | | | | ○ | | | | | | | | | 14.70 | 12.70 | 6.35 | 5.16 | 0,08~0,40 | 0,80~4,00 | DDJN R/L / 1.07<br>PDJN R/L / 1.10 | DDUN R/L/ 1.23<br>PDUN R/L/ 1.24 |
|  | | | | | | | | | | | | | | | | | | | | | | | | | |
| **DNMG-M14** | **15 06 08 - M14** | | | | | | | ● | | | | | | | | | | 14.70 | 12.70 | 6.35 | 5.16 | 0,15~0,38 | 0,30~4,50 | DDJN R/L / 1.07<br>PDJN R/L / 1.10 | DDUN R/L/ 1.23<br>PDUN R/L/ 1.24 |
| | | | | | | | | | | | | | | | | | | | | | | | | | |
| **DNMG-M15** | **11 04 04 - M15** | | | ○ | | | | | | | | | | | | ● | | 11.20 | 9.52 | 4.76 | 3.81 | 0,07~0,35 | 0,20~3,00 | DDJN R/L / 1.07<br>PDJN R/L / 1.10 | DDUN R/L/ 1.23<br>PDUN R/L/ 1.24 |
|  | **11 04 08 - M15** | | | ○ | | | | | | | | | | | | ● | | 10.80 | 9.52 | 4.76 | 3.81 | 0,15~0,45 | 0,30~5,00 | | |
| | **15 06 04 - M15** | | | ○ | | | | | | | | | | | | ● | | 15.10 | 12.70 | 6.35 | 5.16 | 0,07~0,35 | 0,20~3,00 | | |
| | **15 06 08 - M15** | | | ○ | | | | | | | | | | | | ● | | 14.70 | 12.70 | 6.35 | 5.16 | 0,15~0,45 | 0,50~5,00 | | |
| | **15 06 12 - M15** | | | ○ | | | | | | | | | | | | ● | | 14.40 | 12.70 | 6.35 | 5.16 | 0,23~0,60 | 0,50~7,00 | | |
| **DNMG-MD** | **15 06 04 - MD** | | | | | | | | | | ● | ● | | | ● | | | 15.10 | 12.70 | 6.35 | 5.16 | 0,05~0,35 | 0,80~5,00 | DDJN R/L / 1.07<br>PDJN R/L / 1.10 | DDUN R/L/ 1.23<br>PDUN R/L/ 1.24 |
| | **15 06 08 - MD** | | | | | | | | | | ● | ● | | | ● | | | 14.70 | 12.70 | 6.35 | 5.16 | 0,08~0,45 | 1,00~5,00 | | |
| | **15 06 12 - MD** | | | | | | | | | | ● | | | | ○ | | | 14.40 | 12.70 | 6.35 | 5.16 | 0,10~0,50 | 1,20~5,00 | | |
| **DNMG-S12** | **15 06 04 - S12** | | | | | ● | | | | | | | | | | | | 15.10 | 12.70 | 6.35 | 5.16 | 0,05~0,35 | 0,80~4,00 | DDJN R/L / 1.07<br>PDJN R/L / 1.10 | DDUN R/L/ 1.23<br>PDUN R/L/ 1.24 |
| | **15 06 08 - S12** | | | | | ● | | | | | | | | | | | | 14.70 | 12.70 | 6.35 | 5.16 | 0,10~0,40 | 1,00~4,50 | | |
| **DNMX-11** | **15 06 04 - L11** | | | | | | | | | ● | | | | | | | | 15.10 | 12.70 | 6.35 | 5.16 | 0,15~0,30 | 1,00~5,00 | DDJN R/L / 1.07<br>PDJN R/L / 1.10 | DDUN R/L/ 1.23<br>PDUN R/L/ 1.24 |
| | **15 06 04 - R11** | | | | | | | | | ● | | | | | | | | 15.10 | 12.70 | 6.35 | 5.16 | 0,15~0,30 | 1,00~5,00 | | |
| | **15 06 08 - L11** | | | | | | | | | ● | | | | | | | | 14.70 | 12.70 | 6.35 | 5.16 | 0,15~0,55 | 1,00~6,00 | | |
| | **15 06 08 - R11** | | | | | | | | | ● | | | | | | | | 14.70 | 12.70 | 6.35 | 5.16 | 0,15~0,55 | 1,00~6,00 | | |

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

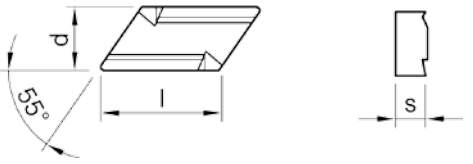
# KC □□




| Werkstück / *Workpiece* | | | Machinentyp *Machining types* |
|---|---|---|---|
| | Stahl / *Steel* | A (P) | ● Gute Bearbeitungsbedingungen / *Continuous cutting* |
| | Rostfreier Stahl / *Stainless steel* | R (M) | ⇕ Normale Bearbeitungsbedingungen / *General cutting* |
| | Guss / *Cast iron* | F (K) | ✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting* |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | |
| | Gehärteter Stahl / *Hardened steel* | H | |

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **KCGX-FL/FLX** | **11 03 02 - FL** | | | | | | | ○ | | | | | | | | | | 11.60 | 6.35 | 3.18 | 2.80 | 0,07~0,40 | 0,30~3,00 | | |
| | **11 03 02 - FLX** | ○ | | | | | | | | | | | | | | | | 11.60 | 6.35 | 3.18 | 2.80 | 0,07~0,40 | 0,50~3,00 | | |
| | **11 03 04 - FL** | | | | | | | ● | | | | | | | | | ○ | 11.60 | 6.35 | 6.35 | 2.80 | 0,10~0,50 | 0,50~3,00 | SKJC R/L / 1.16 | |
| | **11 03 04 - FLX** | ○ | | | | | | | | | | | | | | | | 11.60 | 6.35 | 3.18 | 2.80 | 0,10~0,50 | 0,50~3,00 | | |
| | **11 03 08 - FL** | | | | | | | | | | | | | | | | ○ | 11.60 | 6.35 | 3.18 | 2.80 | 0,13~0,50 | 0,50~3,00 | | |
| | **11 03 08 - FLX** | ○ | | | | | | | | | | | | | | | | 11.60 | 6.35 | 3.18 | 2.80 | 0,13~0,50 | 0,50~3,50 | | |
| **KCGX-FR/FRX** | **11 03 02 - FR** | | | | | | | ● | | | | | | | | | ○ | 11.60 | 6.35 | 3.18 | 2.80 | 0,07~0,40 | 0,30~3,00 | | |
| | **11 03 02 - FRX** | ○ | | | | | | | | | | | | | | | | 11.60 | 6.35 | 3.18 | 2.80 | 0,07~0,40 | 0,50~3,00 | | |
| | **11 03 04 - FR** | | | | | | | ● | | | | | | | | | ○ | 11.60 | 6.35 | 6.35 | 2.80 | 0,10~0,50 | 0,50~3,00 | SKJC R/L / 1.16 | |
| | **11 03 04 - FRX** | ○ | | | | | | | | | | | | | | | | 11.60 | 6.35 | 3.18 | 2.80 | 0,10~0,50 | 0,50~3,00 | | |
| | **11 03 08 - FR** | | | | | | | | | | | | | | | | ○ | 11.60 | 6.35 | 3.18 | 2.80 | 0,13~0,50 | 0,50~3,00 | | |
| | **11 03 08 - FRX** | ○ | | | | | | | | | | | | | | | | 11.60 | 6.35 | 3.18 | 2.80 | 0,13~0,50 | 0,50~3,00 | | |

# KN □□



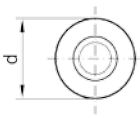

| Werkstück / *Workpiece* | | | Machinentyp *Machining types* |
|---|---|---|---|
| | Stahl / *Steel* | A (P) | ● Gute Bearbeitungsbedingungen / *Continuous cutting* |
| | Rostfreier Stahl / *Stainless steel* | R (M) | ⇕ Normale Bearbeitungsbedingungen / *General cutting* |
| | Guss / *Cast iron* | F (K) | ✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting* |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | |
| | Gehärteter Stahl / *Hardened steel* | H | |

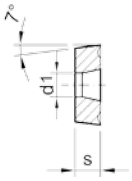
| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **KNUX-11** | **16 04 05 - L11** | | | | | | | | | | ● | | | | | | | 19.20 | 9.52 | 4.76 | - | 0,20~0,35 | 1,00~6,00 | | |
| | **16 04 05 - R11-M15** | | | ○ | | | | | | | | | | | | ● | | 19.20 | 9.52 | 4.76 | - | 0,20~0,35 | 1,00~6,00 | | |
| | **16 04 05 - R11** | | | | | | | ○ | | | ● | | | | | | | 19.20 | 9.52 | 4.76 | - | 0,20~0,35 | 1,00~6,00 | CKJN R/L / 1.06 | |
| | **16 04 10 - L11** | | | | | | | ○ | | | | | | | | | | 18.80 | 9.52 | 4.76 | - | 0,30~0,60 | 1,50~6,00 | | |
| | **16 04 10 - R11** | | | | | | | ○ | | | | | | | | | | 18.80 | 9.52 | 4.76 | - | 0,30~0,60 | 1,50~6,00 | | |
| **KNUX-12** | **16 04 05 - R12** | | | | | | | ○ | | | | | | | | | | 19.20 | 9.52 | 4.76 | - | 0,25~0,35 | 1,50~6,00 | | |
| | **16 04 10 - L12** | | | | | | | ○ | | | | | | | | | | 18.80 | 9.52 | 4.76 | - | 0,40~0,70 | 1,50~6,00 | | |
| | **16 04 10 - R12** | | | | | | | ○ | | | | | | | | | | 18.80 | 9.52 | 4.76 | - | 0,40~0,70 | 1,50~6,00 | CKJN R/L / 1.06 | |



● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# RC □□




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

**Machinentyp** ***Machining types***

- ● Gute Bearbeitungsbedingungen / *Continuous cutting*
- ⇕ Normale Bearbeitungsbedingungen / *General cutting*
- ✠ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **RCGT-AL/ALX** | **08 03 M0 - AL** | | ● | | ○ | | | | | | | | | | | | | | 8.00 | 3.18 | 3.35 | 0,05~0,25 | 0,50~2,50 | | |
| | **10 03 M0 - ALX** | | ● | | ○ | | | | | | | | | | | | ● | | 10.00 | 3.18 | 4.00 | 0,10~0,30 | 1,00~3,00 | SRDCN / 1.16 | |
| | **12 04 M0 - ALX** | | | | ○ | | | | | | | | | | | | ● | | 12.00 | 4.76 | 4.40 | 0,10~0,35 | 1,00~3,50 | | |

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

**Machinentyp** ***Machining types***

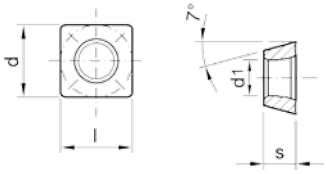
- ● Gute Bearbeitungsbedingungen / *Continuous cutting*
- ⇕ Normale Bearbeitungsbedingungen / *General cutting*
- ✠ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **RCMT-M18** | **06 02 M0 - M18** | | | ○ | | | | | | | | | | | | ● | | | 6.00 | 2.38 | - | 0,05~0,20 | 0,50~2,00 | | |
| | **08 03 M0 - M18** | | | ○ | | | | | | | | | | | | ● | | | 8.00 | 3.18 | - | 0,05~0,25 | 0,50~2,50 | SRDCN / 1.16 | |
| | **10 T3 M0 - M18** | | | ○ | | | | | | | | | | | | ● | | | 10.00 | 3.97 | - | 0,15~0,40 | 1,00~3,50 | | |
| | **12 04 M0 - M18** | | | ○ | | | | | | | | | | | | ○ | | | 12.00 | 4.76 | - | 0,20~0,50 | 2,00~4,50 | | |

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# SC □□

90°




| Werkstück / *Workpiece* | | | Machinentyp *Machining types* |
|---|---|---|---|
| | Stahl / *Steel* | A (P) | ● Gute Bearbeitungsbedingungen / *Continuous cutting* |
| | Rostfreier Stahl / *Stainless steel* | R (M) | ⇕ Normale Bearbeitungsbedingungen / *General cutting* |
| | Guss / *Cast iron* | F (K) | ✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting* |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | |
| | Gehärteter Stahl / *Hardened steel* | H | |

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **SCGT-ALX** | **09 T3 02 - ALX** | | | | | | | | | | | | | | | | ○ | 9.30 | 9.52 | 3.97 | 4.40 | 0,02~0,40 | 0,10~4,00 | | |
| | **09 T3 04 - ALX** | | ● | | ○ | | | | | | | | | | | | ● | 9.10 | 9.52 | 3.97 | 4.40 | 0,02~0,40 | 0,10~4,00 | | |
| | **09 T3 08 - ALX** | | ○ | | | | | | | | | | | | | | ● | 8.70 | 9.52 | 3.97 | 4.40 | 0,03~0,50 | 0,10~5,00 | SSSC R/L / 1.17 | SSSC R/L / 1.28 |
| | **12 04 04 - ALX** | | ● | | ○ | | | | | | | | | | | | ● | 12.30 | 12.70 | 4.76 | 5.50 | 0,02~0,40 | 0,10~5,00 | | |
| | **12 04 08 - ALX** | | ○ | | | | | | | | | | | | | | ● | 11.90 | 12.70 | 14.76 | 5.50 | 0,03~0,50 | 0,10~5,00 | | |

| Werkstück / *Workpiece* | | | Machinentyp *Machining types* |
|---|---|---|---|
| | Stahl / *Steel* | A (P) | ● Gute Bearbeitungsbedingungen / *Continuous cutting* |
| | Rostfreier Stahl / *Stainless steel* | R (M) | ⇕ Normale Bearbeitungsbedingungen / *General cutting* |
| | Guss / *Cast iron* | F (K) | ✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting* |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | |
| | Gehärteter Stahl / *Hardened steel* | H | |

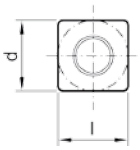
| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **SCMT-F19** | **09 T3 04 - F19** | | | | | | ● | | | | | | ● | | | | | 9.10 | 9.52 | 3.97 | 4.40 | 0,06~0,23 | 0,11~2,00 | | |
| | **09 T3 08 - F19** | | | | | | ● | | | | | | ○ | | | | | 8.70 | 9.52 | 3.97 | 4.40 | 0,08~0,30 | 0,15~2,00 | | |
| | **12 04 08 - F19** | | | | | | | | | | | | ○ | | | | | 11.90 | 12.70 | 4.76 | 5.50 | 0,07~0,27 | 0,14~2,00 | SSSC R/L / 1.17 | SSSC R/L / 1.28 |
| **SCMT-M17** | **09 T3 04 - M17** | | | | | | | ○ | | | | | | | | | | 9.10 | 9.52 | 3.97 | 4.40 | 0,05~0,30 | 0,15~2,70 | | |
| | **09 T3 08 - M17** | | | | | | | ○ | | | | | | | | | | 8.70 | 9.52 | 3.97 | 4.40 | 0,05~0,45 | 0,15~2,70 | | |
| | **12 04 08 - M17** | | | | | | | ● | | | | | | | | | | 11.90 | 12.70 | 4.76 | 5.50 | 0,05~0,30 | 0,15~2,70 | SSSC R/L / 1.17 | SSSC R/L / 1.28 |
| **SCMT-M18** | **09 T3 04 - M18** | | | ○ | | | | | | | | | | | | ● | | 9.10 | 9.52 | 3.97 | 4.40 | 0,06~0,25 | 0,20~3,00 | | |
| | **09 T3 08 - M18** | | | ○ | | | | | | | | | | | | ● | | 8.70 | 9.52 | 3.97 | 4.40 | 0,07~0,35 | 0,20~3,00 | | |
| | | | | | | | | | | | | | | | | | | | | | | | | SSSC R/L / 1.17 | SSSC R/L / 1.28 |
| **SCMT-MD** | **09 T3 04 - MD** | | | | | | | | | | ● | ○ | | | ○ | | | 9.10 | 9.52 | 3.97 | 4.40 | 0,06~0,17 | 0,20~2,50 | | |
| | **09 T3 08 - MD** | | | | | | | | | | ○ | ○ | | | ○ | | | 8.70 | 9.52 | 3.97 | 4.40 | 0,08~0,23 | 0,30~2,50 | | |
| | **12 04 04 - MD** | | | | | | | | | | ○ | ○ | | | ○ | | | 12.30 | 12.70 | 4.76 | 5.50 | 0,06~0,17 | 0,30~3,50 | SSSC R/L / 1.17 | SSSC R/L / 1.28 |
| | **12 04 08 - MD** | | | | | | | | | | ○ | ○ | | | ○ | | | 11.90 | 12.70 | 4.76 | 5.50 | 0,08~0,23 | 0,50~3,50 | | |

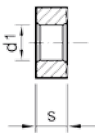


● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# SN □□

90°




| Werkstück / *Workpiece* | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Stahl / *Steel* | A (P) | | | | | | | ✣ | ⇕ | ⇕ | ⇕ | ✣ | ⇕ | ⇕ | ● | ⇕ | |
| Rostfreier Stahl / *Stainless steel* | R (M) | ⇕ | ● | | ● | ● | ⇕ | ⇕ | | | ● | ✣ | | ⇕ | | ● | |
| Guss / *Cast iron* | F (K) | | | ⇕ | | | | | | | | | | | ⇕ | | |
| Nichtmet. Werkstoffe / *Non-fer. metall.* | N | | ⇕ | | ⇕ | | | | | | | | | ✣ | | | ⇕ |
| Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | ● | ● | | ● | | | | | | | | | ⇕ | | | ● |
| Gehärteter Stahl / *Hardened steel* | H | | ● | | | | | | | | | | | | | | |

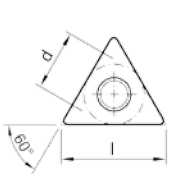
**Machinentyp** *Machining types*

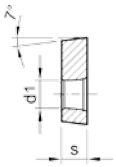
● Gute Bearbeitungsbedingungen / *Continuous cutting*
⇕ Normale Bearbeitungsbedingungen / *General cutting*
✣ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | Beschichtet *Coated* | | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
| **SNMG-M15** | **12 04 08 - M15** | | | ○ | | | | | | | | | | | | ● | | 11.90 | 12.70 | 4.76 | 5.16 | 0,23~0,60 | 0,50~5,00 | PSBN R/L / 1.10<br>PSKN R/L / 1.11<br>PSSN R/L / 1.11 | PSKN R/L / 1.25 |
| | **12 04 12 - M15** | | | ○ | | | | | | | | | | | | ● | | 11.50 | 12.70 | 4.76 | 5.16 | 0,15~0,45 | 0,30~5,00 | | |

# TC □□

60°




| Werkstück / *Workpiece* | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Stahl / *Steel* | A (P) | | | | | | | ✣ | ⇕ | ⇕ | ⇕ | ✣ | ⇕ | ⇕ | ● | ⇕ | |
| Rostfreier Stahl / *Stainless steel* | R (M) | ⇕ | ● | | ● | ● | ⇕ | ⇕ | | | ● | ✣ | | ⇕ | | ● | |
| Guss / *Cast iron* | F (K) | | | ⇕ | | | | | | | | | | | ⇕ | | |
| Nichtmet. Werkstoffe / *Non-fer. metall.* | N | | ⇕ | | ⇕ | | | | | | | | | ✣ | | | ⇕ |
| Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | ● | ● | | ● | | | | | | | | | ⇕ | | | ● |
| Gehärteter Stahl / *Hardened steel* | H | | ● | | | | | | | | | | | | | | |

**Machinentyp** *Machining types*

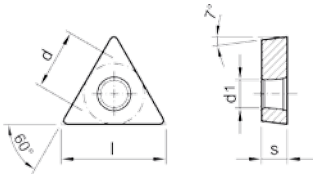
● Gute Bearbeitungsbedingungen / *Continuous cutting*
⇕ Normale Bearbeitungsbedingungen / *General cutting*
✣ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | Beschichtet *Coated* | | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
| **TCGT-ALX** | **11 02 02 - ALX** | | ○ | | | | | | | | | | | | | | ● | 10.50 | 6.35 | 2.38 | 2.80 | 0,01~0,30 | 0,05~5,50 | STGC R/L / 1.17 | STFC R/L / 1.28 |
| | **11 02 04 - ALX** | | ○ | | ○ | | | | | | | | | | | | ● | 10.00 | 6.35 | 2.38 | 2.80 | 0,02~0,40 | 0,10~4,00 | | |
| | **11 02 08 - ALX** | | ○ | | | | | | | | | | | | | | ● | 9.00 | 6.35 | 2.38 | 2.80 | 0,03~0,50 | 0,10~5,00 | | |
| | **16 T3 02 - ALX** | | ○ | | | | | | | | | | | | | | ○ | 15.00 | 9.52 | 3.97 | 4.40 | 0,01~0,30 | 0,05~4,50 | | |
| | **16 T3 04 - ALX** | | ○ | | ○ | | | | | | | | | | | | ● | 15.50 | 9.52 | 3.97 | 4.40 | 0,02~0,40 | 0,10~5,00 | | |
| | **16 T3 08 - ALX** | | ○ | | | | | | | | | | | | | | ● | 14.50 | 9.52 | 3.97 | 4.40 | 0,03~0,50 | 0,10~5,00 | | |

● JD-Lager / *JD-Stock*  ○ begrenzte Lagerhaltung / *limited stock*

# TC □□

60°




| Werkstück / *Workpiece* | | | Machinentyp / *Machining types* |
|---|---|---|---|
| | Stahl / *Steel* | A (P) | ● Gute Bearbeitungsbedingungen / *Continuous cutting* |
| | Rostfreier Stahl / *Stainless steel* | R (M) | ⬍ Normale Bearbeitungsbedingungen / *General cutting* |
| | Guss / *Cast iron* | F (K) | ✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting* |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | |
| | Gehärteter Stahl / *Hardened steel* | H | |

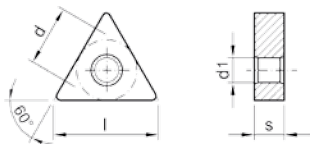
| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **TCMT-F19** | **09 02 02 - F19** | | | | | | ○ | | | | | | ○ | | | | | 9.10 | 5.56 | 2.38 | 2.50 | 0,03~0,13 | 0,06~1,70 | | |
| | **09 02 04 - F19** | | | | | | ○ | | | | | | ○ | | | | | 8.60 | 5.56 | 2.38 | 2.50 | 0,05~0,19 | 0,10~1,70 | | |
| | **11 02 02 - F19** | | | | | | ○ | | | | | | ○ | | | | | 10.50 | 6.35 | 2.38 | 2.80 | 0,03~0,13 | 0,06~1,70 | | |
| | **11 02 04 - F19** | | | | | | ○ | | | | | | ○ | | | | | 10.00 | 6.35 | 2.38 | 2.80 | 0,05~0,19 | 0,10~1,70 | | |
| | **11 02 08 - F19** | | | | | | ○ | | | | | | ○ | | | | | 9.00 | 6.35 | 2.38 | 2.80 | 0,07~0,26 | 0,13~1,70 | STGC R/L / 1.17 | STFC R/L / 1.28 |
| | **11 03 02 - F19** | | | | | | ○ | | | | | | ○ | | | | | 10.50 | 6.35 | 3.18 | 3.40 | 0,03~0,13 | 0,06~1,70 | | |
| | **11 03 04 - F19** | | | | | | ○ | | | | | | ○ | | | | | 10.00 | 6.35 | 3.18 | 3.40 | 0,05~0,19 | 0,10~1,70 | | |
| | **11 03 08 - F19** | | | | | | ○ | | | | | | ○ | | | | | 9.00 | 6.35 | 3.18 | 3.40 | 0,07~0,26 | 0,13~1,70 | | |
| | **16 T3 04 - F19** | | | | | | ○ | | | | | | ○ | | | | | 15.50 | 9.52 | 3.97 | 4.40 | 0,06~0,23 | 0,11~2,00 | | |
| **TCMT-M17** | **11 02 04 - M17** | | | | | | | ○ | | | | | | | | | | 10.00 | 6.35 | 2.38 | 2.80 | 0,07~0,25 | 0,20~2,50 | | |
| | **16 T3 04 - M17** | | | | | | | ○ | | | | | | | | | | 15.50 | 9.52 | 3.97 | 4.40 | 0,07~0,25 | 0,30~2,50 | | |
| | **16 T3 08 - M17** | | | | | | | ○ | | | | | | | | | | 14.50 | 9.52 | 3.97 | 4.40 | 0,10~0,30 | 0,50~2,50 | STGC R/L / 1.17 | STFC R/L / 1.28 |
| **TCMT-M18** | **11 02 04 - M18** | | | ○ | | | | | | | | | | | | ● | | 10.00 | 6.35 | 2.38 | 2.80 | 0,07~0,25 | 0,20~2,50 | | |
| | **11 02 08 - M18** | | | ○ | | | | | | | | | | | | ● | | 9.00 | 6.35 | 2.38 | 2.80 | 0,10~0,30 | 0,30~2,50 | | |
| | **16 T3 04 - M18** | | | ○ | | | | | | | | | | | | ● | | 15.50 | 9.52 | 3.97 | 4.40 | 0,07~0,25 | 0,30~2,50 | STGC R/L / 1.17 | STFC R/L / 1.28 |
| | **16 T3 08 - M18** | | | ○ | | | | | | | | | | | | ● | | 14.50 | 9.52 | 3.97 | 4.40 | 0,10~0,30 | 0,50~2,50 | | |
| | **16 T3 12 - M18** | | | ○ | | | | | | | | | | | | ○ | | 13.50 | 9.52 | 3.97 | 4.40 | 0,12~0,35 | 0,70~2,50 | | |



● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# TN □□

60°




| Werkstück / *Workpiece* | | | Machinentyp *Machining types* |
|---|---|---|---|
| | Stahl / *Steel* | A (P) | ● Gute Bearbeitungsbedingungen / *Continuous cutting* |
| | Rostfreier Stahl / *Stainless steel* | R (M) | ⧓ Normale Bearbeitungsbedingungen / *General cutting* |
| | Guss / *Cast iron* | F (K) | ✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting* |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | |
| | Gehärteter Stahl / *Hardened steel* | H | |

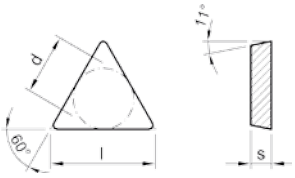
| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **TNGG-A20** | **16 04 04 - A20** | | | | | | | | | | | | | | | | ○ | 15.50 | 9.52 | 4.76 | 3.81 | 0,12~0,30 | 1,00~3,50 | MTJN R/L / 1.08<br>PTFN R/L / 1.12<br>PTGN R/L / 1.12 | PTFN R/L / 1.25 |
| | **16 04 08 - A20** | | | | | | | | | | | | | | | | ○ | 14.50 | 9.52 | 4.76 | 3.81 | 0,15~0,35 | 1,30~3,50 | | |

| Werkstück / *Workpiece* | | | Machinentyp *Machining types* |
|---|---|---|---|
| | Stahl / *Steel* | A (P) | ● Gute Bearbeitungsbedingungen / *Continuous cutting* |
| | Rostfreier Stahl / *Stainless steel* | R (M) | ⧓ Normale Bearbeitungsbedingungen / *General cutting* |
| | Guss / *Cast iron* | F (K) | ✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting* |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | |
| | Gehärteter Stahl / *Hardened steel* | H | |

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **TNMG-M15** | **16 04 04 - M15** | | | ○ | | | | | | | | | | | | ● | | 15.50 | 9.52 | 4.76 | 3.81 | 0,08~0,23 | 0,20~3,50 | MTJN R/L / 1.08<br>PTFN R/L / 1.12<br>PTGN R/L / 1.12 | PTFN R/L / 1.25 |
| | **16 04 08 - M15** | | | ○ | | | | | | | | | | | | ● | | 14.50 | 9.52 | 4.76 | 3.81 | 0,15~0,45 | 0,50~5,00 | | |
| | **16 04 12 - M15** | | | ○ | | | | | | | | | | | | | | 13.50 | 9.52 | 4.76 | 3.81 | 0,23~0,60 | 0,50~6,00 | | |
| **TNMG-MD** | **16 04 04 - MD** | | | | | | | | | | ○ | ○ | | | ○ | | | 15.50 | 9.52 | 4.76 | 3.81 | 0,05~0,35 | 0,80~4,50 | MTJN R/L / 1.08<br>PTFN R/L / 1.12<br>PTGN R/L / 1.12 | PTFN R/L / 1.25 |
| | **16 04 08 - MD** | | | | | | | | | | ○ | ○ | | | ○ | | | 14.50 | 9.52 | 4.76 | 3.81 | 0,08~0,45 | 1,00~4,50 | | |

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# TP □□




| Werkstück / *Workpiece* | | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | Stahl / *Steel* | A (P) | | | | | | | ✱ | ↕ | ↕ | ↕ | ✱ | ↕ | ↕ | ● | ↕ | |
| | Rostfreier Stahl / *Stainless steel* | R (M) | ↕ | ● | | ● | ● | ↕ | ↕ | | | ● | ✱ | | ↕ | | ● | |
| | Guss / *Cast iron* | F (K) | | | ↕ | | | | | | | | | | | ↕ | | |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | | ↕ | | ↕ | | | | | | | | | ✱ | | | ↕ |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | ● | ● | | ● | | | | | | | | | ↕ | | | ● |
| | Gehärteter Stahl / *Hardened steel* | H | | ● | | | | | | | | | | | | | | |

**Machinentyp** ***Machining types***

● Gute Bearbeitungsbedingungen / *Continuous cutting*
↕ Normale Bearbeitungsbedingungen / *General cutting*
✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **TPMR-EL** | **16 03 04 - EL** | | | | | | | ● | | | | | | | | | | | 15.50 | 9.52 | 3.18 | - | 0,08~0,25 | 0,50~4,00 | | |
| **TPMR-ER** | **16 03 04 - ER** | | | | | | | ● | | | | | | | | | | | 15.50 | 9.52 | 3.18 | - | 0,08~0,25 | 0,50~4,00 | | |
| **TPMR-M17** | **16 03 04 - M17** | | | | | | | ○ | | | | | | | | | | | 15.50 | 9.52 | 3.18 | - | 0,07~0,25 | 0,30~2,50 | | |
| **TPMR-M18** | **16 03 04 - M18**<br>**16 03 08 - M18** | | | ○<br>○ | | | | | | | | | | | | ●<br>● | | | 15.50<br>14.50 | 9.52<br>9.52 | 3.18<br>3.18 | -<br>- | 0,07~0,25<br>0,10~0,30 | 0,30~2,50<br>0,50~2,50 | | |

| Werkstück / *Workpiece* | | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | Stahl / *Steel* | A (P) | | | | | | | ✱ | ↕ | ↕ | ↕ | ✱ | ↕ | ↕ | ● | ↕ | |
| | Rostfreier Stahl / *Stainless steel* | R (M) | ↕ | ● | | ● | ● | ↕ | ↕ | | | ● | ✱ | | ↕ | | ● | |
| | Guss / *Cast iron* | F (K) | | | ↕ | | | | | | | | | | | ↕ | | |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | | ↕ | | ↕ | | | | | | | | | ✱ | | | ↕ |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | ● | ● | | ● | | | | | | | | | ↕ | | | ● |
| | Gehärteter Stahl / *Hardened steel* | H | | ● | | | | | | | | | | | | | | |

**Machinentyp** ***Machining types***

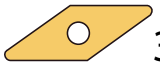
● Gute Bearbeitungsbedingungen / *Continuous cutting*
↕ Normale Bearbeitungsbedingungen / *General cutting*
✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

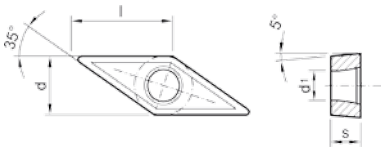
| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **TPUN-EN** | **16 03 04 - EN** | | | | | | | ○ | | | | | | | | | | | 15.50 | 9.52 | 3.18 | - | 0,08~0,25 | 1,00~5,00 | | |



● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# VB □□




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

**Machinentyp** *Machining types*

- ● Gute Bearbeitungsbedingungen / *Continuous cutting*
- ⧗ Normale Bearbeitungsbedingungen / *General cutting*
- ✠ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **VBGT-ALX** | **16 04 04 - ALX** | | ○ | | ○ | | | | | | | | | | | | ● | 15.6 | 9.52 | 4.76 | 4.40 | 0,02~0,40 | 0,10~5,00 | | |
| | **16 04 08 - ALX** | | | | | | | | | | | | | | | | ● | 14.6 | 9.52 | 4.76 | 4.40 | 0,02~0,40 | 0,10~5,00 | SVJB R/L / 1.18 | |

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

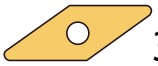
**Machinentyp** *Machining types*

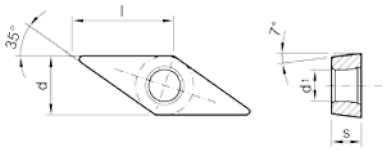
- ● Gute Bearbeitungsbedingungen / *Continuous cutting*
- ⧗ Normale Bearbeitungsbedingungen / *General cutting*
- ✠ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **VBMT-F19** | **11 03 02 - F19** | | | | | | ○ | | | | | | ○ | | | | | 10.50 | 6.35 | 3.18 | 2.80 | 0,03~0,13 | 0,06~1,70 | | |
| | **11 03 04 - F19** | | | | | | ○ | | | | | | ○ | | | | | 10.00 | 6.35 | 3.18 | 2.80 | 0,05~0,19 | 0,10~1,70 | | |
| | **11 03 08 - F19** | | | | | | ○ | | | | | | ○ | | | | | 9.00 | 6.35 | 3.18 | 2.80 | 0,07~0,26 | 0,13~1,70 | SVJB R/L / 1.18 | |
| | **16 04 02 - F19** | | | | | | ○ | | | | | | ○ | | | | | 16.10 | 9.52 | 4.76 | 4.40 | 0,04~0,14 | 0,07~1,70 | | |
| | **16 04 04 - F19** | | | | | | ● | | | | | | ● | | | | | 15.60 | 9.52 | 4.76 | 4.40 | 0,05~0,20 | 0,10~1,80 | | |
| | **16 04 08 - F19** | | | | | | ● | | | | | | ● | | | | | 14.60 | 9.52 | 4.76 | 4.40 | 0,07~0,27 | 0,14~1,80 | | |
| **VBMT-M17** | **16 04 04 - M17** | | | | | | | ● | | | | | | | | | | 15.60 | 9.52 | 4.76 | 4.40 | 0,07~0,25 | 0,30~2,50 | | |
| | **16 04 08 - M17** | | | | | | | ○ | | | | | | | | | | 14.60 | 9.52 | 4.76 | 4.40 | 0,10~0,30 | 0,50~2,50 | SVJB R/L / 1.18 | |
| **VBMT-M18** | **11 03 04 - M18** | | | ○ | | | | | | | | | | | | ● | | 10.00 | 6.35 | 3.18 | 2.80 | 0,07~0,25 | 0,20~2,50 | | |
| | **16 04 04 - M18** | | | ○ | | | | | | | | | | | | ● | | 15.60 | 9.52 | 4.76 | 4.40 | 0,07~0,25 | 0,30~2,50 | | |
| | **16 04 08 - M18** | | | ○ | | | | | | | | | | | | ● | | 14.60 | 9.52 | 4.76 | 4.40 | 0,10~0,30 | 0,50~2,50 | SVJB R/L / 1.18 | |
| **VBMT-MD** | **16 04 04 - MD** | | | | | | | | | | ○ | ○ | | | ○ | | | 15.60 | 9.52 | 4.76 | 4.40 | 0,09~0,19 | 0,30~2,70 | | |
| | **16 04 08 - MD** | | | | | | | | | | ○ | ○ | | | ○ | | | 14.60 | 9.52 | 4.76 | 4.40 | 0,09~0,23 | 0,50~2,70 | SVJB R/L / 1.18 | |

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# VC □□




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

**Machinentyp** / ***Machining types***

● Gute Bearbeitungsbedingungen / *Continuous cutting*
⇕ Normale Bearbeitungsbedingungen / *General cutting*
✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten / *Inserts* | Bezeichnung / *Part Number* | Beschichtet / *Coated* | | | | | | | | | | | | | | Unbeschichtet / *Uncoated* | Maße / *Dimensions* [mm] | | | | Schnittdaten / *Cutting Data* [mm] | | Passende Trägerwerkzeuge / *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **VCGT-ALX** | **11 03 02 - ALX** | | ● | | ● | | | | | | | | | ● | | | ● | 10.50 | 6.35 | 3.18 | 2.80 | 0,01~0,30 | 0,05~3,50 | SVHC R/L / 1.18<br>SVJC R/L / 1.19<br>SVVCN / 1.19 | SVQC R/L / 1.29<br>SVUC R/L / 1.29 |
| | **11 03 04 - ALX** | | ● | | ● | | | | | | | | | ● | | | ● | 10.00 | 6.35 | 3.18 | 2.80 | 0,02~0,40 | 0,10~4,00 | | |
| | **11 03 08 - ALX** | | ○ | | ○ | | | | | | | | | | | | ● | 9.00 | 6.35 | 3.18 | 2.80 | 0,03~0,50 | 0,10~5,00 | | |
| | **13 03 02 - ALX** | | ● | | ○ | | | | | | | | | | | | ● | 10.50 | 7.94 | 3.18 | 3.40 | 0,01~0,30 | 0,10~4,50 | | |
| | **13 03 04 - ALX** | | ○ | | | | | | | | | | | | | | ● | 10.00 | 7.94 | 3.18 | 3.40 | 0,02~0,40 | 0,10~4,50 | | |
| | **16 04 02 - ALX** | | ○ | | ○ | | | | | | | | | | | | ● | 16.10 | 9.52 | 4.76 | 4.40 | 0,01~0,30 | 0,05~4,50 | | |
| | **16 04 04 - ALX** | | ● | | ● | | | | | | | | | ● | | | ● | 15.60 | 9.52 | 4.76 | 4.40 | 0,02~0,40 | 0,10~5,00 | | |
| | **16 04 08 - ALX** | | ● | | ● | | | | | | | | | ● | | | ● | 14.00 | 9.52 | 4.76 | 4.40 | 0,03~0,50 | 0,10~5,00 | | |
| | **16 04 12 - ALX** | | | | | | | | | | | | | | | | ● | 13.60 | 9.52 | 4.76 | 4.40 | 0,03~0,50 | 0,10~5,00 | | |
| | **22 05 30 - ALX** | | ○ | | ○ | | | | | | | | | | | | ● | 14.30 | 12.70 | 5.56 | 5.60 | 0,08~1,00 | 0,15~7,00 | | |

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

**Machinentyp** / ***Machining types***

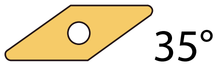
● Gute Bearbeitungsbedingungen / *Continuous cutting*
⇕ Normale Bearbeitungsbedingungen / *General cutting*
✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

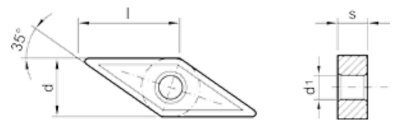
| Wendeplatten / *Inserts* | Bezeichnung / *Part Number* | Beschichtet / *Coated* | | | | | | | | | | | | | | Unbeschichtet / *Uncoated* | Maße / *Dimensions* [mm] | | | | Schnittdaten / *Cutting Data* [mm] | | Passende Trägerwerkzeuge / *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **VCMT-F19** | **11 03 02 - F19** | | | | | | ● | | | | | | ● | | | | | 10.50 | 6.35 | 3.18 | 2.80 | 0,03~0,13 | 0,07~1,50 | SVHC R/L / 1.18<br>SVJC R/L / 1.19<br>SVVCN / 1.19 | SVQC R/L / 1.29<br>SVUC R/L / 1.29 |
| | **11 03 04 - F19** | | | | | | ● | | | | | | ● | | | | | 10.00 | 6.35 | 3.18 | 2.80 | 0,05~0,20 | 0,10~1,50 | | |
| | **16 04 02 - F19** | | | | | | ○ | | | | | | ● | | | | | 16.10 | 9.52 | 4.76 | 4.40 | 0,04~0,14 | 0,07~1,80 | | |
| | **16 04 04 - F19** | | | | | | ● | | | | | | ● | | | | | 15.60 | 9.52 | 4.76 | 4.40 | 0,05~0,20 | 0,10~1,80 | | |
| | **16 04 08 - F19** | | | | | | ● | | | | | | ● | | | | | 14.00 | 9.52 | 4.76 | 4.40 | 0,07~0,27 | 0,14~1,80 | | |
| **VCMT-M18** | **16 04 04 - M18** | | | ○ | | | | | | | | | | | | ● | | 15.60 | 9.52 | 4.76 | 4.40 | 0,07~0,25 | 0,30~2,50 | SVHC R/L / 1.18<br>SVJC R/L / 1.19<br>SVVCN / 1.19 | SVQC R/L / 1.29<br>SVUC R/L / 1.29 |
| | **16 04 08 - M18** | | | ○ | | | | | | | | | | | | ● | | 14.00 | 9.52 | 4.76 | 4.40 | 0,10~0,30 | 0,50~2,50 | | |
| **VCMT-MD** | **11 03 04 - MD** | | | | | | | | | | ○ | ○ | | | ○ | | | 10.00 | 6.35 | 3.18 | 2.80 | 0,06~0,19 | 0,20~2,50 | SVHC R/L / 1.18<br>SVJC R/L / 1.19<br>SVVCN / 1.19 | SVQC R/L / 1.29<br>SVUC R/L / 1.29 |
| | **16 04 04 - MD** | | | | | | | | | | ○ | ○ | | | ○ | | | 15.60 | 9.52 | 4.76 | 4.40 | 0,06~0,19 | 0,30~2,70 | | |
| | **16 04 08 - MD** | | | | | | | | | | ○ | ○ | | | ○ | | | 14.00 | 9.52 | 4.76 | 4.40 | 0,09~0,23 | 0,50~2,70 | | |



● JD-Lager / *JD-Stock*  ○ begrenzte Lagerhaltung / *limited stock*

# VN □□

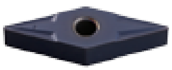



| Werkstück / *Workpiece* | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Stahl / *Steel* | A (P) | | | | | | | ✚ | ◐ | ◐ | ◐ | ✚ | ◐ | ◐ | ● | ◐ | |
| Rostfreier Stahl / *Stainless steel* | R (M) | ◐ | ● | | ● | ● | ◐ | ◐ | | | ● | ✚ | | ◐ | | ● | |
| Guss / *Cast iron* | F (K) | | | ◐ | | | | | | | | | | | ◐ | | |
| Nichtmet. Werkstoffe / *Non-fer. metall.* | N | | ◐ | | ◐ | | | | | | | | | ✚ | | | ◐ |
| Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | ● | ● | | ● | | | | | | | | | ◐ | | | ● |
| Gehärteter Stahl / *Hardened steel* | H | | ● | | | | | | | | | | | | | | |

**Machinentyp**
***Machining types***

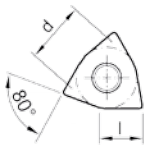
- ● Gute Bearbeitungsbedingungen / *Continuous cutting*
- ◐ Normale Bearbeitungsbedingungen / *General cutting*
- ✚ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **VNMG-M15**  | **16 04 04 - M15** | | | ○ | | | | | | | | | | | | ● | | 15.60 | 9.52 | 4.76 | 3.80 | 0,08~0,23 | 0,20~3,50 | | |
| | **16 04 08 - M15** | | | ○ | | | | | | | | | | | | ● | | 14.60 | 9.52 | 4.76 | 3.80 | 0,15~0,45 | 0,50~5,00 | | |

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# WN□□

80°




| Werkstück / *Workpiece* | | | Machinentyp / *Machining types* |
|---|---|---|---|
| | Stahl / *Steel* | A (P) | ● Gute Bearbeitungsbedingungen / *Continuous cutting* |
| | Rostfreier Stahl / *Stainless steel* | R (M) | ⧓ Normale Bearbeitungsbedingungen / *General cutting* |
| | Guss / *Cast iron* | F (K) | ✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting* |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | |
| | Gehärteter Stahl / *Hardened steel* | H | |

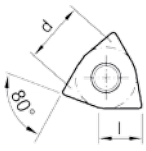
| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **WNGG-A20** | **08 04 04 - A20** | | | | ○ | ● | | | | | | | | | | | ● | 8.40 | 12.70 | 4.76 | 5.16 | 0,10~0,45 | 0,50~4,50 | DWLN R/L / 1.07<br>PWLN R/L / 1.13 | |
| | **08 04 08 - A20** | | | | ○ | ● | | | | | | | | | | | ● | 8.30 | 12.70 | 4.76 | 5.16 | 0,10~0,45 | 0,50~4,50 | | |
| **WNMG-A20** | **06 04 04 - A20** | | | | | | | | | | | | | | | | ○ | 6.20 | 9.52 | 4.76 | 3.81 | 0,10~0,30 | 0,50~3,00 | PWLN R/L / 1.13 | |
| | **06 04 08 - A20** | | | | | | | | | | | | | | | | ○ | 6.10 | 9.52 | 4.76 | 3.81 | 0,10~0,40 | 0,50~4,00 | | |
| **WNMG-C12** | **08 04 08 - C12** | | | | | | | ○ | | | | | | | | | | 8.30 | 12.70 | 4.76 | 5.16 | 0,08~0,40 | 0,80~4,00 | DWLN R/L / 1.07<br>PWLN R/L / 1.13 | |
| **WNMG-M14** | **08 04 08 - M14** | | | | | | | ● | | | | | | | | | | 8.30 | 12.70 | 4.76 | 5.16 | 0,08~0,45 | 1,00~5,00 | DWLN R/L / 1.07<br>PWLN R/L / 1.13 | |
| **WNMG-M15** | **06 04 04 - M15** | | | ○ | | | | | | | | | | | | | | 6.20 | 9.52 | 4.76 | 3.81 | 0,08~0,23 | 0,20~3,00 | DWLN R/L / 1.07<br>PWLN R/L / 1.13 | |
| | **06 04 08 - M15** | | | ○ | | | | | | | | | | | | ○ | | 6.10 | 9.52 | 4.76 | 3.81 | 0,15~0,45 | 0,50~3,50 | | |
| | **08 04 04 - M15** | | | ○ | | | | | | | | | | | | ● | | 8.40 | 12.70 | 4.76 | 5.16 | 0,08~0,23 | 0,20~3,00 | | |
| | **08 04 08 - M15** | | | ○ | | | | | | | | | | | | ● | | 8.30 | 12.70 | 4.76 | 5.16 | 0,08~0,45 | 1,00~5,00 | | |
| | **08 04 12 - M15** | | | ○ | | | | | | | | | | | | | | 8.20 | 12.70 | 4.76 | 5.16 | 0,12~0,35 | 1,00~5,00 | | |
| **WNMG-MD** | **08 04 04 - MD** | | | | | | | | | | ● | ● | | | | ○ | | 8.40 | 12.70 | 4.76 | 5.16 | 0,05~0,35 | 0,80~4,00 | DWLN R/L / 1.07<br>PWLN R/L / 1.13 | |
| | **08 04 08 - MD** | | | | | | | | | | ● | ● | | | | ● | | 8.30 | 12.70 | 4.76 | 5.16 | 0,08~0,45 | 1,00~4,00 | | |
| | **08 04 12 - MD** | | | | | | | | | | ● | ● | | | | ○ | | 8.20 | 12.70 | 4.76 | 5.16 | 0,10~0,50 | 1,20~4,00 | | |

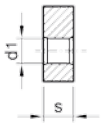


● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# WN□□

80°




| Werkstück / *Workpiece* | | | Machinentyp *Machining types* |
|---|---|---|---|
| | Stahl / *Steel* | A (P) | ● Gute Bearbeitungsbedingungen / *Continuous cutting* |
| | Rostfreier Stahl / *Stainless steel* | R (M) | ⬍ Normale Bearbeitungsbedingungen / *General cutting* |
| | Guss / *Cast iron* | F (K) | ✠ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting* |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | |
| | Gehärteter Stahl / *Hardened steel* | H | |

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Beschichtet *Coated* | | | | | | | | | | | | | | | Unbeschichtet *Uncoated* | Maße *Dimensions* [mm] | | | | Schnittdaten *Cutting Data* [mm] | | Passende Trägerwerkzeuge *Suitable Toolholders* | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | TK 5210 | TK 5310 | TK 5515 | TK 5710 | TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 3015 | TU 5525 | TK 1210 | l | Ø d | s | Ø $d_1$ | fn (mm/rev) | $a_p$ (mm) | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **WNMG-S12** | **08 04 04 - S12** | | | | | ○ | | | | | | | | | | | | 8.40 | 12.70 | 4.76 | 5.16 | 0,05~0,80 | 1,00~4,50 | DWLN R/L / 1.07<br>PWLN R/L / 1.13 | |
| | **08 04 08 - S12** | | | | | ● | | | | | | | | | | | | 8.30 | 12.70 | 4.76 | 5.16 | 0,10~0,40 | 1,00~4,50 | | |

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# ALUMINIUM

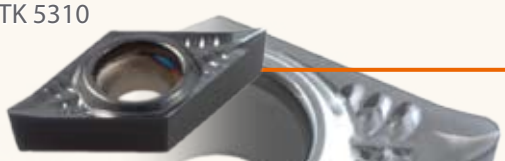
**Für jede Anwendung die richtige Sorte.**

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

DCGT-TK 1210

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

DCGT-TK 5310



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

DCGT-TK 5710

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

für *for*
Niro *Stainless Steel*

DCGT-TP 5245

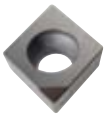
# CBN

80°

**CCMW CNMA CPMW**

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

**Machinentyp** *Machining types*
● Gute Bearbeitungsbedingungen / *Continuous cutting*
⇕ Normale Bearbeitungsbedingungen / *General cutting*
✠ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Ecke *Corner* EW CDX 09 F | Ecke *Corner* EW CDX 09 T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Passende Trägerwerkzeuge / *Suitable Toolholders* Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **CCMW**  | **06 02 02** | ○ | ○ | SCLC R/L / 1.13 | SCLC R/L / 1.26 |
| | **06 02 04** | ○ | ○ | | |
| | **06 02 08** | ○ | ○ | | |
| | **09 T3 02** | ○ | ○ | | |
| | **09 T3 04** | ○ | ○ | | |
| | **09 T3 08** | ○ | ○ | | |
| | **12 04 02** | ○ | ○ | | |
| | **12 04 04** | ○ | ○ | | |
| | **12 04 08** | ○ | ○ | | |

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

**Machinentyp** *Machining types*
● Gute Bearbeitungsbedingungen / *Continuous cutting*
⇕ Normale Bearbeitungsbedingungen / *General cutting*
✠ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Ecke *Corner* EW CDX 09 F | Ecke *Corner* EW CDX 09 T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Passende Trägerwerkzeuge / *Suitable Toolholders* Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **CNMA** | **09 03 02** | ○ | ○ | DCLN R/L / 1.06<br>PCBN R/L / 1.08<br>PCLN R/L / 1.09 | DCLN R/L / 1.23<br>PCLN R/L / 1.24 |
| | **09 03 04** | ○ | ○ | | |
| | **09 03 08** | ○ | ○ | | |
| | **12 04 02** | ○ | ○ | | |
| | **12 04 04** | ○ | ○ | | |
| | **12 04 08** | ○ | ○ | | |
| | **12 04 12** | ○ | ○ | | |

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

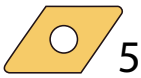
**Machinentyp** *Machining types*
● Gute Bearbeitungsbedingungen / *Continuous cutting*
⇕ Normale Bearbeitungsbedingungen / *General cutting*
✠ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Ecke *Corner* EW CDX 09 F | Ecke *Corner* EW CDX 09 T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Passende Trägerwerkzeuge / *Suitable Toolholders* Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **CPMW** | **05 02 02** | ○ | ○ | | |
| | **05 02 04** | ○ | ○ | | |
| | **06 02 02** | ○ | ○ | | |
| | **06 02 04** | ○ | ○ | | |
| | **09 T3 02** | ○ | ○ | | |
| | **09 T3 04** | ○ | ○ | | |
| | **09 T3 08** | ○ | ○ | | |
| | **12 04 02** | ○ | ○ | | |
| | **12 04 04** | ○ | ○ | | |
| | **12 04 08** | ○ | ○ | | |

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

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# CBN




**DCMW DNMA**

**EPMW**

| Werkstück *Workpiece* | | | | | **Machinentyp** *Machining types* |
|---|---|---|---|---|---|
| | Stahl / *Steel* | A (P) | | | ● Gute Bearbeitungsbedingungen / *Continuous cutting* |
| | Rostfreier Stahl / *Stainless steel* | R (M) | | | ⇕ Normale Bearbeitungsbedingungen / *General cutting* |
| | Guss / *Cast iron* | F (K) | ● | ⇕ | ✠ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting* |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | | | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | | ● | |
| | Gehärteter Stahl / *Hardened steel* | H | ● | ⇕ | |

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Ecke *Corner* EW CDX 09 F | Ecke *Corner* EW CDX 09 T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Passende Trägerwerkzeuge / *Suitable Toolholders* Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **DCMW** | **07 02 02** | ○ | ○ | SDAC R/L / 1.14<br>SDHC R/L / 1.14<br>SDJC R/L / 1.15<br>SDNCN / 1.15 | SDQC R/L / 1.27<br>SDUC R/L / 1.27 |
| | **07 02 04** | ○ | ○ | | |
| | **07 02 08** | ○ | ○ | | |
| | **11 T3 02** | ○ | ○ | | |
| | **11 T3 04** | ○ | ○ | | |
| | **11 T3 08** | ○ | ○ | | |

| Werkstück *Workpiece* | | | | | **Machinentyp** *Machining types* |
|---|---|---|---|---|---|
| | Stahl / *Steel* | A (P) | | | ● Gute Bearbeitungsbedingungen / *Continuous cutting* |
| | Rostfreier Stahl / *Stainless steel* | R (M) | | | ⇕ Normale Bearbeitungsbedingungen / *General cutting* |
| | Guss / *Cast iron* | F (K) | ● | ⇕ | ✠ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting* |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | | | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | | ● | |
| | Gehärteter Stahl / *Hardened steel* | H | ● | ⇕ | |

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Ecke *Corner* EW CDX 09 F | Ecke *Corner* EW CDX 09 T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Passende Trägerwerkzeuge / *Suitable Toolholders* Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **DNMA** | **15 04 02** | ○ | ○ | DDJN R/L / 1.07<br>PDJN R/L / 1.10 | DDUN R/L / 1.23<br>PDUN R/L / 1.24 |
| | **15 04 04** | ○ | ○ | | |
| | **15 04 08** | ○ | ○ | | |
| | **15 06 02** | ○ | ○ | | |
| | **15 06 04** | ○ | ○ | | |
| | **15 06 08** | ○ | ○ | | |
| | **15 06 12** | ○ | ○ | | |

| Werkstück *Workpiece* | | | | | **Machinentyp** *Machining types* |
|---|---|---|---|---|---|
| | Stahl / *Steel* | A (P) | | | ● Gute Bearbeitungsbedingungen / *Continuous cutting* |
| | Rostfreier Stahl / *Stainless steel* | R (M) | | | ⇕ Normale Bearbeitungsbedingungen / *General cutting* |
| | Guss / *Cast iron* | F (K) | ● | ⇕ | ✠ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting* |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | | | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | | ● | |
| | Gehärteter Stahl / *Hardened steel* | H | ● | ⇕ | |

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Ecke *Corner* EW CDX 09 F | Ecke *Corner* EW CDX 09 T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Passende Trägerwerkzeuge / *Suitable Toolholders* Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **EPMW** | **05 02 02** | ○ | ○ | | |
| | **05 02 04** | ○ | ○ | | |
| | **06 02 02** | ○ | ○ | | |
| | **06 02 04** | ○ | ○ | | |
| | **08 03 02** | ○ | ○ | | |
| | **08 03 04** | ○ | ○ | | |
| | **08 03 08** | ○ | ○ | | |

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



● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# CBN

90°

**SCMW SNMA SNMN**

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

**Machinentyp** / ***Machining types***

● Gute Bearbeitungsbedingungen / *Continuous cutting*
⇕ Normale Bearbeitungsbedingungen / *General cutting*
⇳ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Ecke *Corner* EW CDX 09 F | Ecke *Corner* EW CDX 09 T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Passende Trägerwerkzeuge / *Suitable Toolholders* Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **SCMW** | **09 03 02** | ○ | ○ | SSSC R/L / 1.17 | SSSC R/L / 1.28 |
| | **09 03 04** | ○ | ○ | | |
| | **09 03 08** | ○ | ○ | | |
| | **09 T3 02** | ○ | ○ | | |
| | **09 T3 04** | ○ | ○ | | |
| | **09 T3 08** | ○ | ○ | | |
| | **12 04 02** | ○ | ○ | | |
| | **12 04 04** | ○ | ○ | | |
| | **12 04 08** | ○ | ○ | | |

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

**Machinentyp** / ***Machining types***

● Gute Bearbeitungsbedingungen / *Continuous cutting*
⇕ Normale Bearbeitungsbedingungen / *General cutting*
⇳ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Ecke *Corner* EW CDX 09 F | Ecke *Corner* EW CDX 09 T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Passende Trägerwerkzeuge / *Suitable Toolholders* Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **SNMA** | **12 03 02** | ○ | ○ | PSBN R/L / 1.10<br>PSKN R/L / 1.25<br>PSSN R/L / 1.11 | PSKN R/L / 1.25 |
| | **12 04 02** | ○ | ○ | | |
| | **12 04 08** | ○ | ○ | | |

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

**Machinentyp** / ***Machining types***

● Gute Bearbeitungsbedingungen / *Continuous cutting*
⇕ Normale Bearbeitungsbedingungen / *General cutting*
⇳ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Ecke *Corner* EW CDX 09 F | Ecke *Corner* EW CDX 09 T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Passende Trägerwerkzeuge / *Suitable Toolholders* Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **SNMN** | **12 03 04** | ○ | ○ | PSBN R/L / 1.10<br>PSKN R/L / 1.25<br>PSSN R/L / 1.11 | PSKN R/L / 1.25 |
| | **12 03 08** | ○ | ○ | | |
| | **12 04 04** | ○ | ○ | | |

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

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# CBN

90°

60°

**SPMN** **TCMW TNMA**

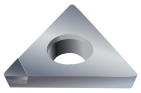
| Werkstück *Workpiece* | | | | |
|---|---|---|---|---|
| Stahl / *Steel* | A (P) | | |
| Rostfreier Stahl / *Stainless steel* | R (M) | | |
| Guss / *Cast iron* | F (K) | ● | ⇕ |
| Nichtmet. Werkstoffe / *Non-fer. metall.* | N | | |
| Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | | ●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

**Machinentyp** ***Machining types***
● Gute Bearbeitungsbedingungen / *Continuous cutting*
⇕ Normale Bearbeitungsbedingungen / *General cutting*
⇵ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Ecke *Corner* EW CDX 09 F | Ecke *Corner* EW CDX 09 T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Passende Trägerwerkzeuge / *Suitable Toolholders* Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **SPMN** | **09 03 02** | ○ | ○ | | |
| | **09 03 04** | ○ | ○ | | |
| | **09 03 08** | ○ | ○ | | |
| | **12 03 02** | ○ | ○ | | |
| | **12 03 04** | ○ | ○ | | |
| | **12 03 08** | ○ | ○ | | |

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

**Machinentyp** ***Machining types***
● Gute Bearbeitungsbedingungen / *Continuous cutting*
⇕ Normale Bearbeitungsbedingungen / *General cutting*
⇵ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Ecke *Corner* EW CDX 09 F | Ecke *Corner* EW CDX 09 T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Passende Trägerwerkzeuge / *Suitable Toolholders* Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **TCMW**  | **09 02 02** | ○ | ○ | | |
| | **09 02 04** | ○ | ○ | | |
| | **09 02 08** | ○ | ○ | | |
| | **11 02 02** | ○ | ○ | | |
| | **11 02 04** | ○ | ○ | STGC R/L / 1.17 | STFC R/L / 1.28 |
| | **11 02 08** | ○ | ○ | | |
| | **16 T3 02** | ○ | ○ | | |
| | **16 T3 04** | ○ | ○ | | |
| | **16 T3 08** | ○ | ○ | | |

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

**Machinentyp** ***Machining types***
● Gute Bearbeitungsbedingungen / *Continuous cutting*
⇕ Normale Bearbeitungsbedingungen / *General cutting*
⇵ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Ecke *Corner* EW CDX 09 F | Ecke *Corner* EW CDX 09 T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Passende Trägerwerkzeuge / *Suitable Toolholders* Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **TNMA** | **16 04 02** | ○ | ○ | | |
| | **16 04 04** | ○ | ○ | MTJN R/L / 1.08 | |
| | **16 04 08** | ○ | ○ | PTFN R/L / 1.12 | PTFN R/L / 1.25 |
| | | | | PTGN R/L / 1.12 | |

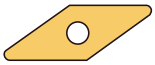
**Bitte angeben / *Please state* :** **F**: scharfe Ausführung / *sharp version* **T**: gefaste Ausführung / *chamfered version*



● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# CBN

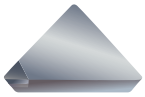
60°


35°

**TPMN** **VBMW VCMW**

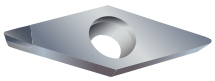
| Werkstück *Workpiece* | | | | |
|---|---|---|---|---|
| | Stahl / *Steel* | A (P) | | |
| | Rostfreier Stahl / *Stainless steel* | R (M) | | |
| | Guss / *Cast iron* | F (K) | ● | ⇕ |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.*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

**Machinentyp** *Machining types*
● Gute Bearbeitungsbedingungen / *Continuous cutting*
⇕ Normale Bearbeitungsbedingungen / *General cutting*
⇳ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Ecke *Corner* EW CDX 09 F | Ecke *Corner* EW CDX 09 T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Passende Trägerwerkzeuge / *Suitable Toolholders* Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **TPMN**  | **11 03 02** | ○ | ○ | | |
| | **11 03 04** | ○ | ○ | | |
| | **11 02 08** | ○ | ○ | | |

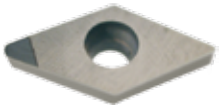
| Werkstück *Workpiece* | | | | |
|---|---|---|---|---|
| | Stahl / *Steel* | A (P) | | |
| | Rostfreier Stahl / *Stainless steel* | R (M) | | |
| | Guss / *Cast iron* | F (K) | ● | ⇕ |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.*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

**Machinentyp** *Machining types*
● Gute Bearbeitungsbedingungen / *Continuous cutting*
⇕ Normale Bearbeitungsbedingungen / *General cutting*
⇳ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Ecke *Corner* EW CDX 09 F | Ecke *Corner* EW CDX 09 T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Passende Trägerwerkzeuge / *Suitable Toolholders* Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **VBMW**  | **16 04 02** | ○ | ○ | | |
| | **16 04 04** | ○ | ○ | | |
| | **16 04 08** | ○ | ○ | SVJB R/L / 1.18 | |

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

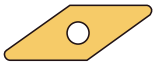
**Machinentyp** *Machining types*
● Gute Bearbeitungsbedingungen / *Continuous cutting*
⇕ Normale Bearbeitungsbedingungen / *General cutting*
⇳ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Ecke *Corner* EW CDX 09 F | Ecke *Corner* EW CDX 09 T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Passende Trägerwerkzeuge / *Suitable Toolholders* Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **VCMW**  | **11 03 02** | ○ | ○ | | |
| | **11 03 04** | ○ | ○ | | |
| | **11 03 08** | ○ | ○ | SVHC R/L / 1.18 | SVQC R/L / 1.29 |
| | **16 04 02** | ○ | ○ | SVJC R/L / 1.19 | SVUC R/L / 1.29 |
| | **16 04 04** | ○ | ○ | SVVCN / 1.19 | |
| | **16 04 08** | ○ | ○ | | |
| | **16 04 12** | ○ | ○ | | |

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

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# CBN



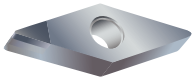
35°

**VNMA**

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

**Machinentyp** ***Machining types***

● Gute Bearbeitungsbedingungen / *Continuous cutting*
⇕ Normale Bearbeitungsbedingungen / *General cutting*
⇔ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Ecke *Corner* EW CDX 09 | | Passende Trägerwerkzeuge / *Suitable Toolholders* | |
|---|---|---|---|---|---|
| | | F | T | Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
| **VNMA**  | **16 04 02** | ○ | ○ | | |
| | **16 04 04** | ○ | ○ | | |
| | **16 04 08** | ○ | ○ | | |

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



● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# PKD

80°

**CCMW CNMA**

55°

**DCMW**

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

**Machinentyp** / ***Machining types***

- ● Gute Bearbeitungsbedingungen / *Continuous cutting*
- ⇕ Normale Bearbeitungsbedingungen / *General cutting*
- ✠ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten / *Inserts* | Bezeichnung / *Part Number* | 1 Ecke / *Corner* PKD F | 1 Ecke / *Corner* PKD T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Passende Trägerwerkzeuge / *Suitable Toolholders* Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **CCMW** | **06 02 01** | | | SCLC R/L / 1.13 | SCLC R/L / 1.26 |
| | **06 02 02** | | | | |
| | **06 02 04** | | | | |
| | **09 T3 02** | | | | |
| | **09 T3 04** | | | | |
| | **09 T3 08** | | | | |
| | **12 04 04** | | | | |
| | **12 04 08** | | | | |

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

**Machinentyp** / ***Machining types***

- ● Gute Bearbeitungsbedingungen / *Continuous cutting*
- ⇕ Normale Bearbeitungsbedingungen / *General cutting*
- ✠ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten / *Inserts* | Bezeichnung / *Part Number* | 1 Ecke / *Corner* PKD F | 1 Ecke / *Corner* PKD T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Passende Trägerwerkzeuge / *Suitable Toolholders* Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **CNMA** | **12 04 04** | | | DCLN R/L / 1.06<br>PCBN R/L / 1.08<br>PCLN R/L / 1.09 | DCLN R/L / 1.23<br>PCLN R/L / 1.24 |
| | **12 04 08** | | | | |

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

**Machinentyp** / ***Machining types***

- ● Gute Bearbeitungsbedingungen / *Continuous cutting*
- ⇕ Normale Bearbeitungsbedingungen / *General cutting*
- ✠ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten / *Inserts* | Bezeichnung / *Part Number* | 1 Ecke / *Corner* PKD F | 1 Ecke / *Corner* PKD T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Passende Trägerwerkzeuge / *Suitable Toolholders* Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **DCMW** | **07 02 01** | | | SDAC R/L / 1.14<br>SDHC R/L / 1.14<br>SDJC R/L / 1.15<br>SDNCN / 1.15 | SDQC R/L / 1.27<br>SDUC R/L / 1.27 |
| | **07 02 02** | | | | |
| | **07 02 04** | | | | |
| | **11 T3 02** | | | | |
| | **11 T3 04** | | | | |
| | **11 T3 08** | | | | |

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

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# PKD

**DNMA**

**RCMW**

**TCMW**

| Werkstück *Workpiece* | | | | | Machinentyp *Machining types* |
|---|---|---|---|---|---|
| | Stahl / *Steel* | A (P) | | | ● Gute Bearbeitungsbedingungen / *Continuous cutting* |
| | Rostfreier Stahl / *Stainless steel* | R (M) | | | ⧗ Normale Bearbeitungsbedingungen / *General cutting* |
| | Guss / *Cast iron* | F (K) | | | ✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting* |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | ● | ⧗ | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | | | |
| | Gehärteter Stahl / *Hardened steel* | H | | | |

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | **1** Ecke / *Corner* PKD F | **1** Ecke / *Corner* PKD T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Passende Trägerwerkzeuge / *Suitable Toolholders* Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **DNMA** | **11 04 04** | ○ | ○ | DDJN R/L / 1.07<br>PDJN R/L / 1.10 | DDUN R/L / 1.23<br>PDUN R/L / 1.24 |
| | **11 04 08** | ○ | ○ | | |
| | **15 06 04** | ○ | ○ | | |
| | **15 06 08** | | | | |

| Werkstück *Workpiece* | | | | | Machinentyp *Machining types* |
|---|---|---|---|---|---|
| | Stahl / *Steel* | A (P) | | | ● Gute Bearbeitungsbedingungen / *Continuous cutting* |
| | Rostfreier Stahl / *Stainless steel* | R (M) | | | ⧗ Normale Bearbeitungsbedingungen / *General cutting* |
| | Guss / *Cast iron* | F (K) | | | ✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting* |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | ● | ⧗ | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | | | |
| | Gehärteter Stahl / *Hardened steel* | H | | | |

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | Fullface PKD F | Fullface PKD T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Passende Trägerwerkzeuge / *Suitable Toolholders* Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **RCMW** | **06 02 00** | | | SRDCN / 1.16 | |
| | **08 03 00** | | | | |
| | **10 03 00** | | | | |
| | **12 T3 00** | | | | |

| Werkstück *Workpiece* | | | | | Machinentyp *Machining types* |
|---|---|---|---|---|---|
| | Stahl / *Steel* | A (P) | | | ● Gute Bearbeitungsbedingungen / *Continuous cutting* |
| | Rostfreier Stahl / *Stainless steel* | R (M) | | | ⧗ Normale Bearbeitungsbedingungen / *General cutting* |
| | Guss / *Cast iron* | F (K) | | | ✱ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting* |
| | Nichtmet. Werkstoffe / *Non-fer. metall.* | N | ● | ⧗ | |
| | Warmf. Leg.,Titanleg. / *Heat res. alloys,Titan. all.* | S | | | |
| | Gehärteter Stahl / *Hardened steel* | H | | | |

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | **1** Ecke / *Corner* PKD F | **1** Ecke / *Corner* PKD T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Passende Trägerwerkzeuge / *Suitable Toolholders* Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **TCMW** | **09 02 01** | | | STGC R/L / 1.17 | STFC R/L / 1.28 |
| | **09 02 02** | | | | |
| | **09 02 04** | | | | |
| | **11 02 02** | | | | |
| | **11 02 04** | | | | |
| | **11 02 08** | | | | |
| | **16 T3 04** | | | | |
| | **16 T3 08** | | | | |

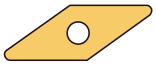
**Bitte angeben / *Please state* :** **F**: scharfe Ausführung / *sharp version* **T**: gefaste Ausführung / *chamfered version*



● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

# PKD

60°



35°

**TNMA** **VCMW**

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

**Machinentyp** ***Machining types***

● Gute Bearbeitungsbedingungen / *Continuous cutting*
⬍ Normale Bearbeitungsbedingungen / *General cutting*
⬌ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | **1** Ecke / *Corner* PKD F | PKD T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **TNMA** | **16 04 02** | | | MTJN R/L / 1.08<br>PTFN R/L / 1.12<br>PTGN R/L / 1.12 | PTFN R/L / 1.25 |
| | **16 04 04** | | | | |
| | **16 04 08** | | | | |

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

**Machinentyp** ***Machining types***

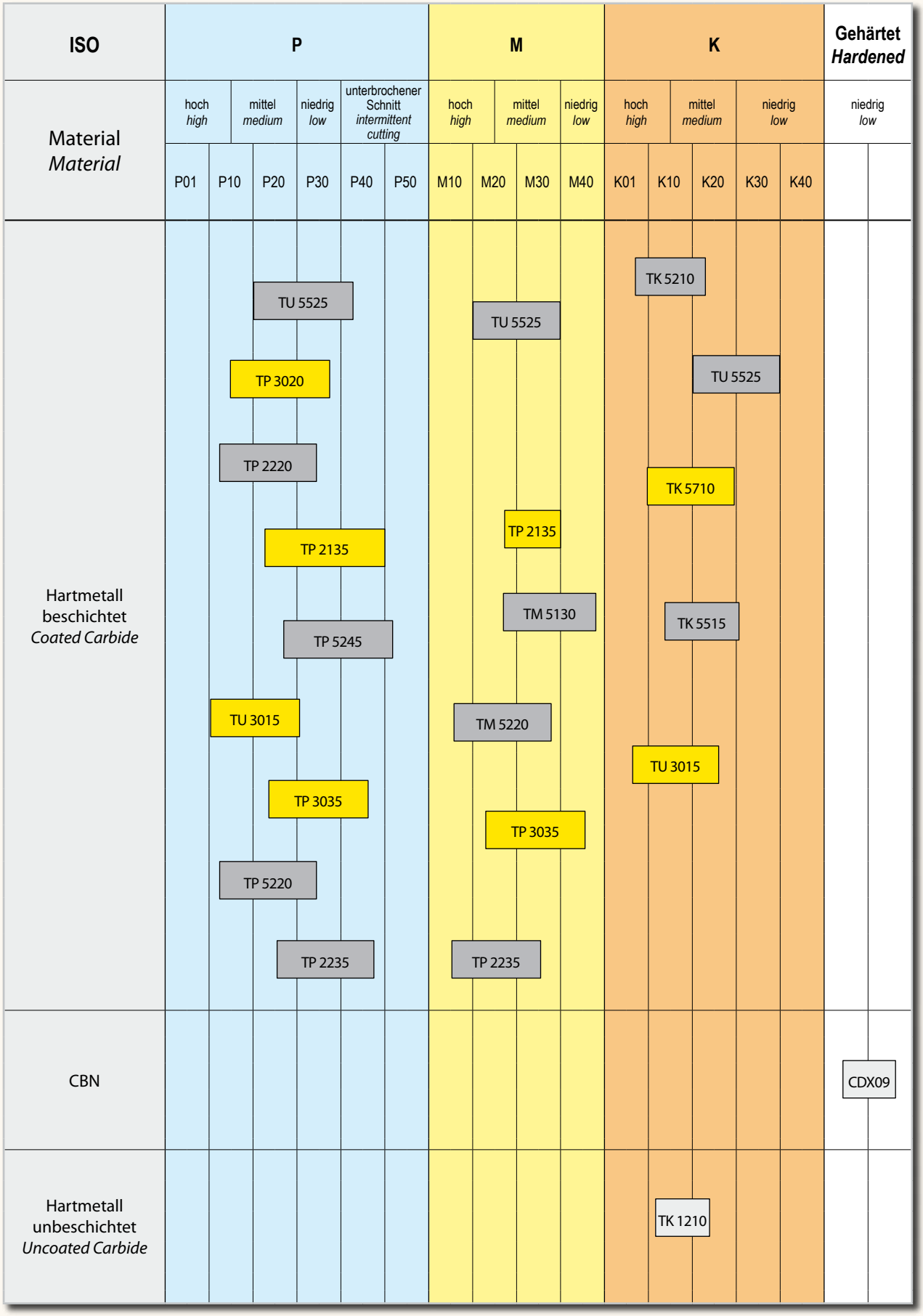
● Gute Bearbeitungsbedingungen / *Continuous cutting*
⬍ Normale Bearbeitungsbedingungen / *General cutting*
⬌ Ungünstige Bearbeitungsbedingungen / *Interrupted cutting*

| Wendeplatten *Inserts* | Bezeichnung *Part Number* | **1** Ecke / *Corner* PKD F | PKD T | Passende Trägerwerkzeuge / *Suitable Toolholders* Klemmhalter / Seite *Toolholder / Page* | Bohrstange / Seite *Boring Bar / Page* |
|---|---|---|---|---|---|
| **VCMW** | **11 03 02** | | | SVHC R/L / 1.18<br>SVJB R/L / 1.18<br>SVJC R/L / 1.19<br>SVVCN / 1.19 | SVQC R/L / 1.29<br>SVUC R/L / 1.29 |
| | **11 03 04** | | | | |
| | **11 03 08** | | | | |
| | **16 04 02** | | | | |
| | **16 04 04** | | | | |
| | **16 04 08** | | | | |

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

● JD-Lager / *JD-Stock* ○ begrenzte Lagerhaltung / *limited stock*

## Schneidstoffsorten-Übersicht zum Drehen
## *Description of Carbide Grades for Turning*



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

# C N M G 120404 - A20 T K 12 10

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

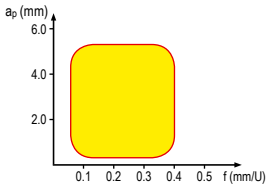
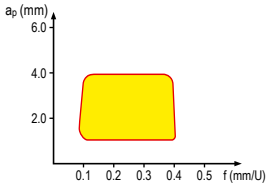
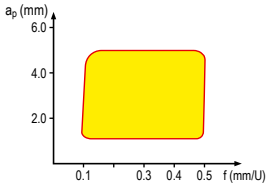
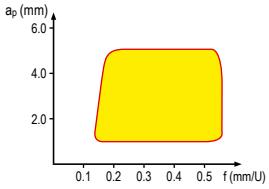
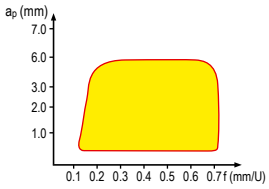
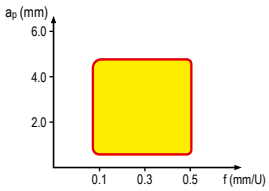
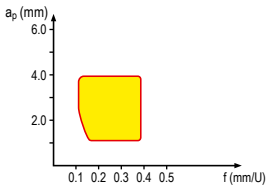
| | | |
|---|---|---|
| Anwendung 2 *Application 2* | P | Stahl / *Steel* |
| | M | Niro / *Stainless Steel* |
| | K | Nichteisen, Kunststoff, Aluminium *Non Metallic Materials* |
| | S | warmfeste Legierungen / *Heat Resistant Alloys* |
| | H | gehärteter Stahl / *Hardened Steel* |
| | U | universell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

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

| | | |
|---|---|---|
| ISO | 10 | |
| | 20 | |
| | 30 | |
| | 40 | |
| | 50 | |
| | ... | |

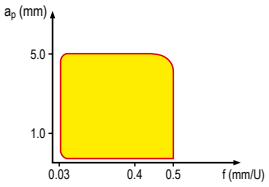
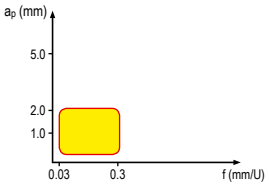
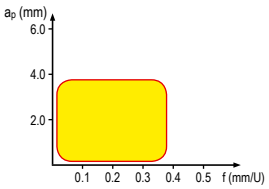
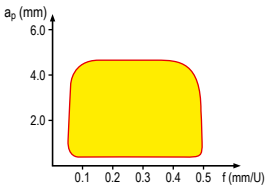
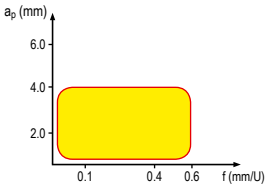
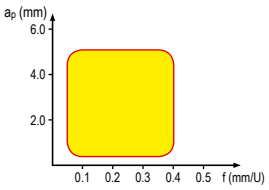
# Spanleitstufen zum Drehen / *Chipbreakers for Turning*

**Negative Wendeschneidplatten / *Negative Inserts***

| Spanleitstufe *Chipbreaker* | Anwendungsbereich *Application Range* | Highlights | *Highlights* |
|---|---|---|---|
| **A20** |   | Alu-Legierungen, Niro, St 37<br>• scharfe Schneidkanten ( Umfangsschliff )<br>• extrem großer Spanwinkel | *Alu-alloys, stainless steel*<br>• *Sharp cutting edge (ground circumference)*<br>• *Extremely high helix* |
| **C12** |   | Vorschlichten / Schlichten von Stahl und Niro<br>• gute Spankontrolle, vor allem beim Kopieren | *Medium to finish cutting of steel and stainless steel*<br>• *Excellent for copying of special shape*<br>• *Smooth chip control at shallow cut as well as deep depth of cut* |
| **M12** |   | Standard-Geometrie im mittleren Bereich<br>• vor allem CNC-Bearbeitung<br>• sehr gute Spankontrolle<br>• geeignet für Niro - Bearbeitung | *Medium cutting*<br>• *Wide available chip control range from medium-finishing to medium-roughing*<br>• *Suitable chip breaker for CNC machining*<br>• *Suitable for stainless steel machining* |
| **M14** |   | Schlichten / Schruppen von Stahl und Niro<br>• exzellente Spanumleitung<br>• stabile Schneidkante | *Finishing / Roughing for steel and stainless steel*<br>• *Excellent chip control at varied depth of cut*<br>• *Strong cutting edge toughness due to special design* |
| **M15** |   | Universelle Geometrie im mittleren Bereich<br>• spezielles Substrat für höchste Verschleiß beständigkeit<br>• breites Anwendungsspektrum durch PVD-Mehrlagenbeschichtung | *Universal geometry for medium range*<br>• *Special substrate for highest wear resistance*<br>• *Wide field of stainless steel machining* |
| **MD** |   | Standard-Geometrie im mittleren Bereich<br>• vor allem CNC-Bearbeitung<br>• sehr gute Spankontrolle<br>• geeignet für Niro - Bearbeitung | *Medium cutting*<br>• *Wide available chip control range from medium-finishing to medium-roughing*<br>• *Suitable chip breaker for CNC machining*<br>• *Suitable for stainless steel machining* |
| **S12** |   | Standard-Geometrie für die mittlere Zerspanung von Niro<br>• längere Standzeiten durch besondere Niro - Spanleitstufe<br>• verschleißfester durch großen Spanwinkel | *Medium cutting of stainless steel*<br>• *Exclusive design for stainless steel cutting provide longer tool life*<br>• *Wear resistance has been reinforced through high rake angle of chip breaker land* |

## Spanleitstufen zum Drehen / *Chipbreakers for Turning*

**Positive Wendeschneidplatten / *Positive Inserts***

| Spanleitstufe *Chipbreaker* | Anwendungsbereich *Application Range* | Highlights | *Highlights* |
|---|---|---|---|
| **ALX** |   | Aluminiumbearbeitung<br>• sehr großer Spanwinkel, geschliffene Schneidkante<br>• Bearbeitung von Aluminium, Kunststoffen, Feinstbearbeitung von Niro | *Aluminium cutting*<br>• *Exclusive chipbreaker for aluminium and aluminium alloy, finishing of stainless steel*<br>• *High rake angle, precision - ground cutting edge* |
| **F19** |   | Schlichtbearbeitung<br>• großer Spanwinkel, scharfe Schneidkante<br>• hohe Oberflächengüten, auch bei der Innenbearbeitung | *Finishing*<br>• *High helix, sharp cutting edge*<br>• *Very good surface quality, also in case of internal machining* |
| **M12** |   | Mittlere Bearbeitung<br>• auf antriebsschwachen Maschinen und Bohrungsbearbeitung | *Medium cutting*<br>• *Excellent chip control at wide range of cutting conditions*<br>• *Suitable for stainless steel cutting* |
| **M17** |   | Schlichten / Schruppen von Stahl und Niro<br>• exzellente Spanumleitung<br>• stabile Schneidkante | *Finishing / Roughing for steel and stainless steel*<br>• *Excellent chip control at varied depth of cut*<br>• *Strong cutting edge toughness due to special design* |
| **M18** |   | Universelle Geometrie im mittleren Bereich<br>• spezielles Substrat für höchste Verschleißbeständigkeit<br>• breites Anwendungsspektrum durch PVD-Mehrlagenbeschichtung | *Universal geometry for medium range*<br>• *Special substrate for highest wear resistance*<br>• *Wide field of applications through PVD-Multilayer-coating* |
| **MD** |   | Mittlere Bearbeitung<br>• auf antriebsschwachen Maschinen und Bohrungsbearbeitung | *Medium cutting*<br>• *Excellent chip control at wide range of cutting conditions*<br>• *Suitable for stainless steel cutting* |

**Anwendung / *Application***

# C N M G 120408 M...

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

# Schnittdaten-Empfehlungen zum Drehen
## *Cutting Data Recommendations for Turning*

| Werkstückwerkstoff *Material* | | Legierung *Alloy* | Brinell-Härte *hardness* HB | VDI 3323 Gruppe | Schnittgeschwindigkeiten / *Cutting feeds* $v_c$ [m/min] | | | |
|---|---|---|---|---|---|---|---|---|
| | | | | | TK 1210 | TK5310 | TK 5515 | TK 5710 |
| A (P) | unlegierter Stahl / *mild steel* | geglüht / *annealed* ≤0,15% C | 125 | 1 | | | | 100 - 150 |
| | | geglüht / *annealed* 0,15% - 0,45% C | 150-250 | 2 | | | | 80 - 140 |
| | | vergütet / *heat treated* ≥0,45% C | 300 | 3 | | | | 70 - 110 |
| | niedriglegierter Stahl / *lower alloyed steel* | geglüht / *annealed* | 180 | 6 | | | | 80 - 130 |
| | | vergütet / *heat treated* | 275 | 7 | | | | 70 - 120 |
| | | vergütet / *heat treated* | 300 | 8 | | | | 60 - 90 |
| | | vergütet / *heat treated* | 350 | 9 | | | | |
| | hochlegierter Stahl / *highly alloyed steel* | geglüht / *annealed* | 200 | 10 | | | | 80 - 110 |
| | | vergütet / *heat treated* | 350 | 11 | | | | |
| | Nichtrostender Stahl / *corrosion-resistant steel* | geglüht / *annealed* | 200 | 12 | | | | 130 - 180 |
| | | vergütet / *heat treated* | 350 | 13 | | | | |
| R (M) | rostfreier Stahl / *stainless steel* | ferritisch, martensitisch, geglüht / *ferritic, martensitic, annealed* | 200 | 14 | | | 130 - 200 | |
| | | austenitisch / *austenitic* | 180 | 14 | | | 90 - 190 | 90 - 130 |
| | | Duplex | 230-260 | 14 | | | | |
| | | austenitisch, ferritisch / *austenitic, ferritic* | 330 | 14 | | | | |
| F (K) | Grauguß / *grey cast iron* | perlitisch, ferritisch / *pearlitic, ferritic* | 180 | 15 | 140 - 200 | 100 - 200 | 180 - 280 | 160 - 220 |
| | | perlitisch, martensitisch / *pearlitic, martensitic* | 260 | 16 | 100 - 160 | 100 - 220 | 170 - 230 | 130 - 180 |
| | Grauguß mit Kugelgraphit / *nodular cast iron* | ferritisch / *ferritic* | 160 | 17 | 160 - 200 | 120 - 200 | 150 - 230 | 150 - 220 |
| | | perlitisch / *pearlitic* | 250 | 18 | 110 - 150 | 120 - 250 | 120 - 180 | 120 - 170 |
| | Temperguß / *malleable cast iron* | ferritisch / *ferritic* | 130 | 19 | 160 - 220 | 120 - 200 | 180 - 300 | 160 - 220 |
| | | perlitisch / *pearlitic* | 230 | 20 | 140 - 180 | 100 - 200 | 180 - 250 | 140 - 200 |
| N | Aluminium - Knetlegierungen / *forging alloy* | nicht aushärtbar / *not hardenable* | 60 | 21 | 300 - 3000 | 250 - 3000 | | 250 - 2800 |
| | | aushärtbar / *hardenable* | 100 | 22 | 200 - 2000 | 250 - 2500 | | 180 - 2500 |
| | Aluminium - Gußlegierungen / *casting alloy* | nicht aushärtbar / *not hardenable* < 12% Si | 80 | 23 | 400 - 2000 | 400 - 2000 | | 300 - 1800 |
| | | aushärtbar / *hardenable* < 12% Si | 90 | 24 | 400 - 1100 | 300 - 1200 | | 300 - 1800 |
| | | nicht aushärtbar / *not hardenable* > 12% Si | 130 | 25 | 200 - 1000 | 200 - 700 | | 170 - 1000 |
| | Kupfer und Kupfer-legierungen (Bronze, Messing) / *copper and copper alloys (bronze, brass)* | Automatenlegierungen / *free cutting alloys (1% Pb)* | | 26 | 250 - 800 | | | 220 - 900 |
| | | Messing, Rotguß / *brass, red bronze* | | 27 | 200 110 | | | 190 - 800 |
| | | Bronze / *bronze* | 90 | 28 | 150 - 600 | | | 150 - 650 |
| | | bleifreies Kupfer und Elektrolytkupfer / *unleaded copper* | 100 | 29 | 150 - 400 | | | 130 - 500 |
| | nichtmetallische Werkstoffe / *non metallic materials* | Duroplaste / *thermoset* | 100 | 29 | 100 - 220 | | | 70 - 200 |
| | | faserverstärkte Kunststoffe / *fiber reinforced plastic* | | 29 | 80 - 200 | | | 70 - 220 |
| | | Hartgummi / *ebonite* | | 30 | 100 - 300 | | | 90 - 280 |
| S | warmfeste Legierungen / *heat resistant alloys* | Fe-Basis/base, geglüht / *annealed* | 200 | 31 | 35 - 50 | | | 30 - 60 |
| | | Fe-Basis/base(Incoloy), ausgehärtet / *hardened* | 280 | 32 | 25 - 40 | | | 20 - 50 |
| | | Ni-Basis/base (Inconel), geglüht / *annealed* | 250 | 33 | 25 - 40 | | | 20 - 50 |
| | | Ni- oder Co-Basis, ausgehärtet / *hardened* | 30-58 HRC | 24 | 20 - 30 | | | 20 - 40 |
| | | Ni- oder Co-Basis, gegossen / *cast* | 1500-2200 Nmm² | 35 | 15 - 25 | | | 20 - 30 |
| | Titanlegierungen / *titanium alloys* | Reintitan / *Pure titanium* | Rm 400 | 36 | 80 - 150 | | | 60 - 150 |
| | | Alpha- + Beta-Legierungen / *alloys* | Rm 1050 | 37 | 40 - 120 | | | 30 - 70 |
| H | gehärteter Stahl / *hardened steel* | gehärtet und angelassen / *hardened and tempered* | 55 HRC | 38 | | | | |
| | | | 60 HRC | 39 | | | | |
| | Hartguß / *chilled cast iron* | gegossen / *cast* | 400 | 40 | | | | |
| | Gehärtetes Gußeisen / *hardened cast iron* | gehärtet und angelassen / *hardened and tempered* | 55 HRC | 40 | | | | |

## Schnittdaten-Empfehlungen zum Drehen
## *Cutting Data Recommendations for Turning*

**Schnittgeschwindigkeiten / *Cutting feeds***
**$v_c$ [m/min]**

| TM 5130 | TM 5220 | TP 2135 | TP 2220 | TP 2235 | TP 3020 | TP 3035 | TP 5220 | TP 5245 | TU 5525 | TU 3015 | CDX09 | PKD |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | 170 - 230 | 220 - 350 | 160 - 210 | 180 - 300 | 160 - 220 | 120 - 280 | 180 - 240 | 180 - 400 | 250 - 450 | | |
| | | 150 - 180 | 200 - 300 | 130 - 180 | 150 - 220 | 170 - 180 | 130 - 250 | 150 - 200 | 170 - 350 | 220 - 400 | | |
| | | 110 - 150 | 160 - 250 | 100 - 130 | 120 - 200 | 130 - 150 | 100 - 180 | 150 - 200 | 140 - 200 | 180 - 280 | | |
| | | 160 - 190 | 200 - 310 | 140 - 170 | 160 - 250 | 160 - 180 | 100 - 230 | 170 - 200 | 120 - 300 | 240 - 400 | | |
| | | 80 - 140 | 150 - 250 | 80 - 120 | 90 - 180 | 90 - 150 | 80 - 200 | 100 - 160 | 120 - 210 | 160 - 290 | | |
| | | 70 - 130 | 130 - 220 | 60 - 140 | 80 - 170 | 70 - 120 | 60 - 180 | 90 - 150 | 110 - 200 | 140 - 270 | | |
| | | 60 - 120 | 120 - 200 | 70 - 110 | 120 - 190 | 50 - 100 | 50 - 130 | 80 - 140 | 100 - 180 | 120 - 250 | | |
| | | 110 - 200 | 140 - 250 | 100 - 180 | 80 - 160 | 130 - 200 | 80 - 180 | 130 - 170 | 70 - 200 | 180 - 300 | | |
| | | 40 - 80 | 100 - 200 | | 120 - 180 | 60 - 100 | 50 - 120 | 80 - 130 | 70 - 130 | 100 - 250 | | |
| | | 130 - 170 | 140 - 185 | 120 - 150 | 100 - 170 | 140 - 200 | 100 - 180 | 140 - 180 | 80 - 200 | 160 - 300 | | |
| | | 100 - 160 | 120 - 170 | | 90 - 180 | 100 - 150 | 70 - 150 | 115 - 170 | 80 - 180 | 150 - 260 | | |
| 100 - 200 | 120 - 220 | 130 - 200 | 150 - 220 | 120 - 180 | 140 - 200 | 120 - 200 | | 140 - 200 | 170 - 250 | 200 - 260 | | |
| 60 - 180 | 80 - 200 | 90 - 190 | 180 - 220 | 70 - 150 | 90 - 180 | 100 - 180 | | 110 - 190 | 170 - 270 | | | |
| 40 - 90 | 60 - 140 | 70 - 150 | | | | 80 - 130 | | 80 - 150 | 120 - 210 | | | |
| | 50 - 120 | 40 - 60 | | | 60 - 90 | 50 - 90 | | 55 - 75 | 100 - 180 | | 80 - 150 | |
| | | | 120 - 180 | | 100 - 200 | | | | 170 - 280 | 140 - 350 | 300 - 1000 | |
| | | | 120 - 180 | | 90 - 180 | | | | 170 - 250 | 130 - 300 | 300 - 800 | |
| | | | 120 - 200 | | 100 - 180 | | | | 150 - 230 | 190 - 390 | 300 - 450 | |
| | | | 120 - 180 | | | | | | 150 - 190 | 120 - 250 | 250 - 350 | |
| | | | 150 - 230 | | 150 - 220 | | | | 120 - 230 | 180 - 450 | | |
| | | | 120 - 170 | | 100 - 180 | | | | 120 - 190 | 150 - 300 | | |
| | | | | | | | | 100 - 500 | | | | 250 - 3500 |
| | | | | | | | | 100 - 400 | | | | 250 - 1300 |
| | | | | | | | | 100 - 350 | | | | 250 - 3500 |
| | | | | | | | | 100 - 800 | | | | 250 - 1500 |
| | | | | | | | | 80 - 250 | | | | 200 - 500 |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | 100 - 600 |
| | | | | | | | | | | | | 100 - 1300 |
| | | | | | | | | | | | | 250 - 2500 |
| | | | | | | | | | | | | 60 - 320 |
| | | | | | | | | | | | | 80 - 250 |
| | | | | | | | | | | | | 60 - 180 |
| | | 20 - 45 | | | | | | | 20 - 40 | | | |
| | | 20 - 40 | | | | | | | 15 - 36 | | | |
| | | 8 - 22 | | | | | | | 10 - 30 | | | |
| | | 4 - 16 | | | | | | | 5 - 20 | | | |
| | | 4 - 16 | | | | | | | 5 - 20 | | | |
| | | 80 - 140 | | | | | | | 80 - 140 | | | |
| | | 15 - 35 | | | | | | | 20 - 40 | | | |
| | | | | | | | | | | | 80 - 200 | |
| | | | | | | | | | | | 40 - 180 | |
| | | | | | | | | | | | 40 - 180 | |
| | | | | | | | | | | | | |

# Notizen *Notes*

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**JÖRN DETJENS**
**Zerspanungstechnik GmbH**

**Bültbek 19 • DE-22962 Siek • Germany**

**Fon: +49 (0) 4107 - 90 73 - 0**
**Fax: +49 (0) 4107 - 90 73 - 22**
**E-Mail: info@jd-tools.de**
**Web: www.jd-tools.de**