It couldn't be easier
Ordering via the Online Shop
http://cuttingtools.ceratizit.com

Competent advice also available on call
Application engineers with know-how
Monday to Friday from 8:00 am – 6:30 pm

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Customer Service Centre
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VALID TO: 01.06.2020 – 31.08.2020

CERATIZIT GROUP

The multi-application grade

SPECIAL SELECTION

TEAM CUTTING TOOLS

CUTTING SOLUTIONS BY CERATIZIT · KOMET · WNT · KLENK

CERATIZIT is a high-tech engineering group specialised in tooling and hard material technologies.

Tooling the Future

www.ceratizit.com

Table of contents

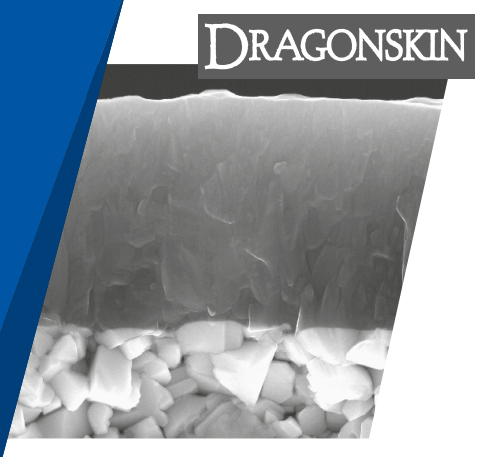
The multi-application grade

Many materials,
many requirements...
... only one indexable insert!

CUTTING SOLUTIONS BY CERATIZIT

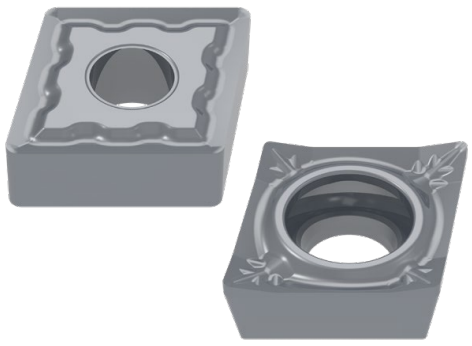
Features

- CTPX710 is the first multi-application grade for turning from CERATIZIT. It impresses thanks to outstanding performance in the processing of steel, stainless steel, super alloys and non-ferrous metals.
- The AlTiN coating revamped with Dragonskin technology in connection with the optimised microstructure and a special fine-grained carbide ensure this grade can be used for a wide range of applications.
- From now on, users wanting to process several materials only need one grade: the CTPX710. You not only benefit from the universal application options and the excellent machining characteristics. With this grade, you also avoid incorrect applications and improve the clarity of your tool selection.



The perfect combination of state-of-the-art high-performance substrates and advanced coating structure achieves high cutting speeds and increased process security.

- **The Dragonskin technology guarantees a revolutionary smooth coating without imperfections, resulting in perfect removal of the chips.**
- **The extremely high layer thickness precision guarantees ultimate precision of shape and dimensional stability in the indexable insert.**



Further information on the product can be found on page 27+28

> Our X7 Line impresses with universal application options and a wide range of uses.
>
> CERATIZIT Product Manager, Stefan Karl

WTX – HFDS

The first four-edged drilling tool on the market!

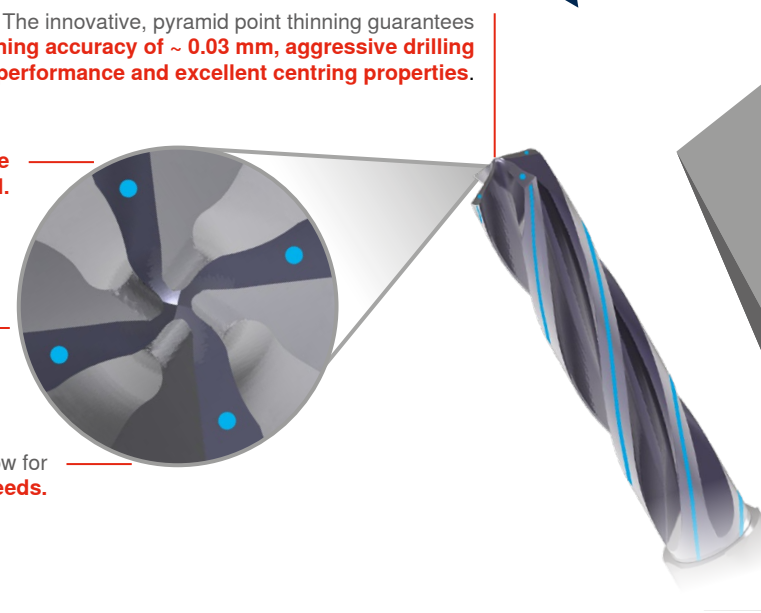
Reduce your machining time with four effective cutting edges!

The innovative, pyramid point thinning guarantees **ultimate positioning accuracy of ~ 0.03 mm, aggressive drilling performance and excellent centring properties**.

Four chip flutes **ensure secure and quick chip removal.**

Each cutting edge is **optimally cooled** by the four spiral coolant holes. The tool core nonetheless remains very stable.

Four cutting edges allow for **extremely high feeds.**



Further information on the product can be found in the UP2DATE May catalogue on page 16–19

WTX – High-feed drills, DIN 6537

- Four fluted high-feed drill
- Specialises in steel processing
- Has four spiral coolant holes
- Innovative cutting edge geometry guarantees high positioning accuracy
- Outstanding drilling quality in terms of tolerance, surface finish and position

≤ 3xD

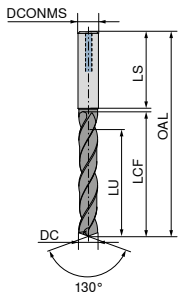
NOF = 4

HFDS

DPX14S

DRAGONSKIN

WNT \ Performance



HA

NEW

DC m7	DCONMS h6	OAL	LCF	LU	LS	Article no.	£
mm	mm	mm	mm	mm	mm		
6.0	8	79	41	29	36	10 797 06000	81.26
6.1	10	89	47	35	40	10 797 06100	110.77
6.2	10	89	47	35	40	10 797 06200	110.77
6.3	10	89	47	35	40	10 797 06300	110.77
6.4	10	89	47	35	40	10 797 06400	110.77
6.5	10	89	47	35	40	10 797 06500	110.77
6.6	10	89	47	35	40	10 797 06600	110.77
6.7	10	89	47	35	40	10 797 06700	110.77
6.8	10	89	47	35	40	10 797 06800	110.77
6.9	10	89	47	35	40	10 797 06900	110.77
7.0	10	89	47	35	40	10 797 07000	110.77
7.1	10	89	47	35	40	10 797 07100	110.77
7.2	10	89	47	35	40	10 797 07200	110.77
7.3	10	89	47	35	40	10 797 07300	110.77
7.4	10	89	47	35	40	10 797 07400	110.77
7.5	10	89	47	35	40	10 797 07500	110.77
7.6	10	89	47	35	40	10 797 07600	110.77
7.7	10	89	47	35	40	10 797 07700	110.77
7.8	10	89	47	35	40	10 797 07800	110.77
7.9	10	89	47	35	40	10 797 07900	110.77
8.0	10	89	47	35	40	10 797 08000	110.77
8.1	12	102	55	40	45	10 797 08100	150.26
8.2	12	102	55	40	45	10 797 08200	150.26
8.3	12	102	55	40	45	10 797 08300	150.26
8.4	12	102	55	40	45	10 797 08400	150.26
8.5	12	102	55	40	45	10 797 08500	150.26
8.6	12	102	55	40	45	10 797 08600	150.26
8.7	12	102	55	40	45	10 797 08700	150.26
8.8	12	102	55	40	45	10 797 08800	150.26
8.9	12	102	55	40	45	10 797 08900	150.26
9.0	12	102	55	40	45	10 797 09000	150.26
9.1	12	102	55	40	45	10 797 09100	150.26
9.2	12	102	55	40	45	10 797 09200	150.26
9.3	12	102	55	40	45	10 797 09300	150.26
9.4	12	102	55	40	45	10 797 09400	150.26
9.5	12	102	55	40	45	10 797 09500	150.26
9.6	12	102	55	40	45	10 797 09600	150.26
9.7	12	102	55	40	45	10 797 09700	150.26
9.8	12	102	55	40	45	10 797 09800	150.26
9.9	12	102	55	40	45	10 797 09900	150.26
10.0	12	102	55	40	45	10 797 10000	150.26
10.2	14	107	60	43	45	10 797 10200	199.43
10.5	14	107	60	43	45	10 797 10500	199.43
11.0	14	107	60	43	45	10 797 11000	199.43
11.5	14	107	60	43	45	10 797 11500	199.43
12.0	14	107	60	43	45	10 797 12000	199.43
12.5	16	115	65	45	48	10 797 12500	270.82
13.0	16	115	65	45	48	10 797 13000	270.82
14.0	16	115	65	45	48	10 797 14000	270.82
14.3	18	123	73	51	48	10 797 14300	337.37
14.5	18	123	73	51	48	10 797 14500	337.37

Steel	●
Stainless steel	○
Cast iron	●
Non ferrous metals	○
Heat resistant alloys	○
Hardened materials	○

WTX – High-feed drills, DIN 6537

- Four fluted high-feed drill
- Specialises in steel processing
- Has four spiral coolant holes
- Innovative cutting edge geometry guarantees high positioning accuracy
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≤ 5xD

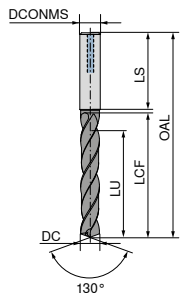
NOF = 4

HFDS

DPX14S

DRAGONSKIN

WNT \ Performance



HA

NEW

DC m7	DCONMS h6	OAL	LCF	LU	LS	Article no.	£
mm	mm	mm	mm	mm	mm		
6.0	8	89	51	40	36	10 798 06000	96.03
6.1	10	102	59	47	40	10 798 06100	128.04
6.2	10	102	59	47	40	10 798 06200	128.04
6.3	10	102	59	47	40	10 798 06300	128.04
6.4	10	102	59	47	40	10 798 06400	128.04
6.5	10	102	59	47	40	10 798 06500	128.04
6.6	10	102	59	47	40	10 798 06600	128.04
6.7	10	102	59	47	40	10 798 06700	128.04
6.8	10	102	59	47	40	10 798 06800	128.04
6.9	10	102	59	47	40	10 798 06900	128.04
7.0	10	102	59	47	40	10 798 07000	128.04
7.1	10	102	59	47	40	10 798 07100	128.04
7.2	10	102	59	47	40	10 798 07200	128.04
7.3	10	102	59	47	40	10 798 07300	128.04
7.4	10	102	59	47	40	10 798 07400	128.04
7.5	10	102	59	47	40	10 798 07500	128.04
7.6	10	102	59	47	40	10 798 07600	128.04
7.7	10	102	59	47	40	10 798 07700	128.04
7.8	10	102	59	47	40	10 798 07800	128.04
7.9	10	102	59	47	40	10 798 07900	128.04
8.0	10	102	59	47	40	10 798 08000	128.04
8.1	12	118	70	55	45	10 798 08100	180.29
8.2	12	118	70	55	45	10 798 08200	180.29
8.3	12	118	70	55	45	10 798 08300	180.29
8.4	12	118	70	55	45	10 798 08400	180.29
8.5	12	118	70	55	45	10 798 08500	180.29
8.6	12	118	70	55	45	10 798 08600	180.29
8.7	12	118	70	55	45	10 798 08700	180.29
8.8	12	118	70	55	45	10 798 08800	180.29
8.9	12	118	70	55	45	10 798 08900	180.29
9.0	12	118	70	55	45	10 798 09000	180.29
9.1	12	118	70	55	45	10 798 09100	180.29
9.2	12	118	70	55	45	10 798 09200	180.29
9.3	12	118	70	55	45	10 798 09300	180.29
9.4	12	118	70	55	45	10 798 09400	180.29
9.5	12	118	70	55	45	10 798 09500	180.29
9.6	12	118	70	55	45	10 798 09600	180.29
9.7	12	118	70	55	45	10 798 09700	180.29
9.8	12	118	70	55	45	10 798 09800	180.29
9.9	12	118	70	55	45	10 798 09900	180.29
10.0	12	118	70	55	45	10 798 10000	180.29
10.2	14	124	76	60	45	10 798 10200	239.36
10.5	14	124	76	60	45	10 798 10500	239.36
11.0	14	124	76	60	45	10 798 11000	239.36
11.5	14	124	76	60	45	10 798 11500	239.36
12.0	14	124	76	60	45	10 798 12000	239.36
12.5	16	142	91	73	48	10 798 12500	325.05
13.0	16	142	91	73	48	10 798 13000	325.05
14.0	16	142	91	73	48	10 798 14000	325.05
14.3	16	142	91	73	48	10 798 14300	404.80
14.5	16	142	91	73	48	10 798 14500	404.80
15.0	18	142	91	73	48	10 798 15000	404.80
16.0	18	142	91	73	48	10 798 16000	404.80

Steel	●
Stainless steel	○
Cast iron	●
Non ferrous metals	○
Heat resistant alloys	○
Hardened materials	○

Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

KUB Centron

The cost-effective variant for large and deep holes is now available from stock

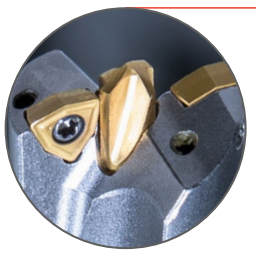
KOMET

The KUB Centron is the ideal tool for holes with a large length to diameter ratio. Cost-effective and process-secure drilling in hole depths of up to 9xD and virtually all materials is no problem at all with the modular drill.

APPLICATION

- For large and deep holes from 4xD to 9xD
- Suitable for rotating and stationary as well as for vertical and horizontal applications
- The drill bits of the KUB Centron are available with a diameter from Ø 20.00 to Ø 81.00 mm. From a diameter of Ø 65.00 mm and above, the drill head is available with 4 indexable inserts and therefore a slightly different design.
- Suitable, for example, to transverse holes in housings, cylinder blocks and forged parts
- The KUB Centron is designed for use with WOEX indexable inserts and is therefore universal, powerful and process-secure.

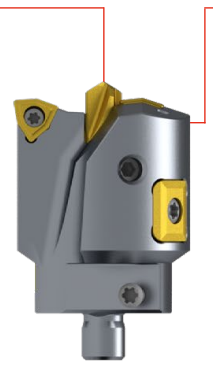
The best thing of all: The indexable insert drill with exchangeable head is now available from stock in our standard range.



CENTRING TIP

EXACT POSITIONING

HSS or solid carbide centring tips ensure exact positioning. The KUB Centron cutting data is also selected using the centring tips.



DRILL BIT

STABILITY THROUGHOUT THE MACHINING PROCESS

Carbide guide pads give the modular drill stability when drilling and exiting the hole. This counteracts deflection.

TOOL HOLDER

TRIED-AND-TESTED ABS CONNECTION

An ABS connection is particularly advantageous when drilling large, deep holes. The improved force transmission produces optimised machining results.

HIGH FLEXIBILITY

Thanks to its modular design, the holder covers multiple diameter ranges.

COST REDUCTION

Tool costs can be reduced by combining drill bits, indexable inserts and holders.

INSERTS

UNIVERSAL APPLICATION

The tried-and-tested, specialised high-performance grades of the WOEX indexable inserts enable use in virtually all materials. They can also be used for all KUB Trigon drilling systems.

INTERFACE

PRECISE, CENTRICAL POSITIONING

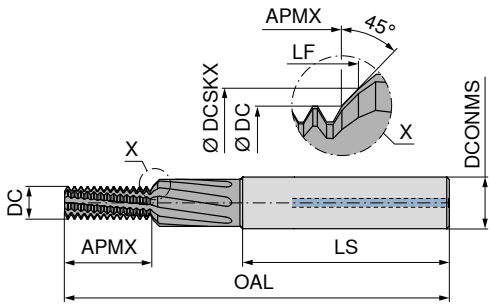
Interface with custom-fit centring pins on the drill bit.

Further information on the product can be found in the UP2DATE May catalogue on page 20–33

Thread Milling Cutter with Chamfer Facet

SFSE | IR/IL | ≤ 2xD | 60° | M

AlCrN



HA

Solid carbide

WNT \ Performance

DC mm	Thread	KOMET no.	TP mm	OAL mm	APMX mm	LS mm	DCONMS h6 mm	DCSKX mm	LF mm	ZEFP	NEW Article no.	£
3.14	M4	88296001000015	0.70	49	8.0	36	6	4.3	8.6	5	50 806 04000	166.98
3.95	M5	88296001000017	0.80	55	9.9	36	6	5.3	10.6	5	50 806 05000	171.60
4.68	M6	88296001000018	1.00	62	12.3	36	8	6.3	13.2	6	50 806 06000	183.04
6.22	M8	88296001000020	1.25	74	16.6	40	10	8.3	17.8	7	50 806 08000	219.67
7.79	M10	88296001000022	1.50	79	19.9	45	12	10.3	21.3	7	50 806 10000	260.81
9.38	M12	88296001000024	1.75	89	24.9	45	14	12.3	26.6	7	50 806 12000	369.49
10.92	M14	88296001000025	2.00	102	28.5	48	16	14.3	30.4	7	50 806 14000	432.41
12.83	M16	88296001000026	2.00	102	32.4	48	18	16.3	34.4	8	50 806 16000	538.78

MF | 60°

WNT \ Performance

DC mm	Thread	KOMET no.	TP mm	OAL mm	APMX mm	LS mm	DCONMS h6 mm	DCSKX mm	LF mm	ZEFP	NEW Article no.	£
3.95	M5x0,5	88296002000037	0.50	55	10.2	36	6	5.3	10.8	5	50 807 05100	189.86
4.68	M6x0,75	88296002000048	0.75	62	12.2	36	8	6.3	13.0	5	50 807 06200	209.33
6.22	M8x1	88296002000070	1.00	74	16.2	40	10	8.3	17.3	6	50 807 08300	245.96
7.79	M10x1	88296002000094	1.00	79	20.1	45	12	10.3	21.5	7	50 807 10300	286.00
9.38	M12x1	88296002000111	1.00	89	24.0	45	14	12.3	25.6	7	50 807 12300	388.96
9.38	M12x1,5	88296002000113	1.50	89	24.3	45	14	12.3	25.9	7	50 807 12500	398.09
10.92	M14x1,5	88296002000131	1.50	102	28.7	48	16	14.3	30.6	7	50 807 14500	437.03
12.82	M16X1,5	88296002000147	1.50	102	31.7	48	18	16.3	33.6	8	50 807 16500	546.81

Steel	●
Stainless steel	●
Cast iron	●
Non ferrous metals	
Heat resistant alloys	●
Hardened materials	

Cutting data approximate values

	Index	Material	Strength N/mm² / HB / HRC	v_c m/min with through coolant	HPC solid carbide thread milling cutters 50 806..., 50 807... Ø 3–5 fz mm/tooth	Ø 6–10 fz mm/tooth	Ø 10–13 fz mm/tooth
P	1.1	General construction steel	< 800 N/mm²	80–100	0,015–0,02	0,02–0,03	0,03–0,04
	1.2	Free cutting steel	< 800 N/mm²	80–100	0,015–0,02	0,02–0,03	0,03–0,04
	1.3	Hardened steel, non alloyed	< 800 N/mm²	80–100	0,015–0,02	0,02–0,03	0,03–0,04
	1.4	Alloyed hardened steel	< 1000 N/mm²	80–100	0,015–0,02	0,02–0,03	0,03–0,04
	1.5	Tempering steel, unalloyed	< 850 N/mm²	80–100	0,015–0,02	0,02–0,03	0,03–0,04
	1.6	Tempering steel, unalloyed	< 1000 N/mm²	80–100	0,015–0,02	0,02–0,03	0,03–0,04
	1.7	Tempering steel, alloyed	< 800 N/mm²	80–100	0,015–0,02	0,02–0,03	0,03–0,04
	1.8	Tempering steel, alloyed	< 1300 N/mm²	80–100	0,015–0,02	0,02–0,03	0,03–0,04
	1.9	Steel castings	< 850 N/mm²	80–100	0,015–0,02	0,02–0,03	0,03–0,04
	1.10	Nitriding steel	< 1000 N/mm²	80–100	0,015–0,02	0,02–0,03	0,03–0,04
	1.11	Nitriding steel	< 1200 N/mm²	80–100	0,015–0,02	0,02–0,03	0,03–0,04
	1.12	Roller bearing steel	< 1200 N/mm²	80–100	0,015–0,02	0,02–0,03	0,03–0,04
	1.13	Spring steel	< 1200 N/mm²	80–100	0,015–0,02	0,02–0,03	0,03–0,04
	1.14	High-speed steel	< 1300 N/mm²	80–100	0,015–0,02	0,02–0,03	0,03–0,04
	1.15	Cold working tool steel	< 1300 N/mm²	80–100	0,015–0,02	0,02–0,03	0,03–0,04
	1.16	Hot working tool steel	< 1300 N/mm²	80–100	0,015–0,02	0,02–0,03	0,03–0,04
M	2.1	Cast steel and sulphured stainless steel	< 850 N/mm²	60–80	0,015–0,03	0,04–0,06	0,06–0,10
	2.2	Stainless steel, ferritic	< 750 N/mm²	60–80	0,015–0,03	0,04–0,06	0,06–0,10
	2.3	Stainless steel, martensitic	< 900 N/mm²	60–80	0,015–0,03	0,04–0,06	0,06–0,10
	2.4	Stainless steel, ferritic / martensitic	<1100 N/mm²	60–80	0,015–0,03	0,04–0,06	0,06–0,10
	2.5	Stainless steel, austenitic / ferritic	< 850 N/mm²	60–80	0,015–0,03	0,04–0,06	0,06–0,10
	2.6	Stainless steel, austenitic	< 750 N/mm²	60–80	0,015–0,03	0,04–0,06	0,06–0,10
	2.7	Heat resistant steel	< 1100 N/mm²				
K	3.1	Grey cast iron with lamellar graphite	100–350 N/mm²	100–120	0,02–0,04	0,04–0,08	0,06–0,10
	3.2	Grey cast iron with lamellar graphite	300–500 N/mm²	100–120	0,02–0,04	0,04–0,08	0,06–0,08
	3.3	Gray cast iron with spheroidal graphite	300–500 N/mm²	100–120	0,02–0,04	0,04–0,08	0,06–0,08
	3.4	Gray cast iron with spheroidal graphite	500–900 N/mm²	80–100	0,02–0,04	0,04–0,08	0,06–0,08
	3.5	White malleable cast iron	270–450 N/mm²	80–100	0,02–0,04	0,04–0,08	0,06–0,08
	3.6	White malleable cast iron	500–650 N/mm²	80–100	0,02–0,04	0,04–0,08	0,06–0,08
	3.7	Black malleable cast iron	300–450 N/mm²	80–100	0,02–0,04	0,04–0,08	0,06–0,08
	3.8	Black malleable cast iron	500–800 N/mm²	80–100	0,02–0,04	0,04–0,08	0,06–0,08
S	5.1	Pure nickel					
	5.2	Nickel alloys					
	5.3	Nickel alloys	< 850 N/mm²				
	5.4	Nickel molybdenum alloys					
	5.5	Nickel-chromium alloys	< 1300 N/mm²				
	5.6	Cobalt Chrome Alloys	< 1300 N/mm²				
	5.7	Heat resistant alloys	< 1300 N/mm²				
	5.8	Nickel-cobalt-chromium alloys	< 1400 N/mm²				
	5.9	Pure titanium	< 900 N/mm²	60–80	0,015–0,02	0,02–0,03	0,03–0,04
	5.10	Titanium alloys	< 700 N/mm²	60–80	0,015–0,02	0,02–0,03	0,03–0,04
	5.11	Titanium alloys	< 1200 N/mm²	60–80	0,01–0,015	0,015–0,02	0,025–0,035

Technical support: 0800 073 2 075
3 time served engineers, available from 8:00 am to 6:30 pm, Monday to Friday

Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

HOT DEALS

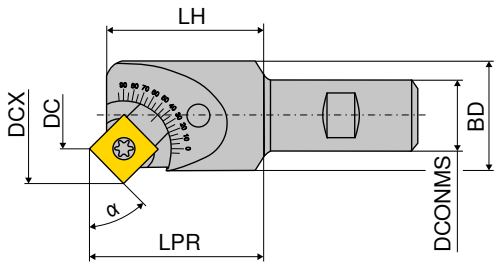
Zero Height Setting Gauge

Designation	Ref height mm	Article no.	£
Zero height setting gauge	100	85 900 018	45.00

HSS Twist Drill Set DIN 338 type N short

Set ø mm	Article no.	£
1.0 – 5.9	10 158 050	17.00
6.0 – 10	10 158 100	38.00

Adjustable single angle milling cutter C4500



Designation	DC	DCX	ZNF	LPR	DCONMS	LH	BD	Article no.	£
mm	mm	mm		mm	mm	mm	mm		
C4500.20.R.01	3,7 - 27,8	27,3 - 32,2	1	35,9 - 40,5	20	37	25	50 668 020	38.00

Countersink 90° HSS DIN 335, from C

*Set	Article no.	£
	30 100 999	9.60

* 6.3 mm, 8.3 mm, 10.4 mm, 12.4 mm, 16.5 mm & 20.5 mm included in set.

HSS Drill Set 118°

UNI

TiN

*Set	Article no.	£
	10 107 999	5.00

* 2.5 mm, 3.3 mm, 4.2 mm, 5.0 mm, 6.8 mm included in set.

UltraMini Set

*Set	Article no.	£
	73 085 999	110.00

*Set 1: Internal turning, grooving and chamfering

Collet Set

Set	Article no.	£
470 E / ER32 BD = 33 mm, OAL = 40 mm 18 PIECES 3 – 20 mm in 1 mm steps	82 676 99900	70.00

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NC spot drills, factory standard and high-performance twist drills





	NC-A	UNI	WT	VX	UNI	VX	UNI
		TiN	TiN	TiN	TiN	TiN	TiN
		≤ 3xD	≤ 3xD	≤ 3xD	≤ 5xD	≤ 5xD	≤ 10xD
		DIN 1897	DIN 1897	≈DIN 1897	DIN 338	≈DIN 338	DIN 340
				A		A	

DC h8/h6 mm	WNT \ Performance Article no.	£	WNT \ Performance Article no.	£	WNT \ Performance Article no.	£	WNT \ Performance Article no.	£	WNT \ Performance Article no.	£	WNT \ Performance Article no.	£	WNT \ Performance Article no.	£
0.90									10 171 009	3.54				
1.00			10 107 010	4.11	10 110 010	4.25			10 171 010	3.54			10 270 010	6.40
1.10			10 107 011	4.11	10 110 011	4.48			10 171 011	3.54			10 270 011	7.15
1.20			10 107 012	3.88	10 110 012	4.25			10 171 012	4.00			10 270 012	7.98
1.25									10 171 125	3.77				
1.30			10 107 013	4.11	10 110 013	4.48			10 171 013	3.77			10 270 013	7.86
1.40			10 107 014	4.00	10 110 014	4.48			10 171 014	3.54			10 270 014	7.77
1.45									10 171 145	3.54				
1.50			10 107 015	3.72	10 110 015	4.25			10 171 015	3.30			10 270 015	6.76
1.55									10 171 155	3.54				
1.60			10 107 016	3.72	10 110 016	4.25			10 171 016	3.54			10 270 016	7.98
1.65									10 171 165	3.65				
1.70			10 107 017	3.52	10 110 017	4.00			10 171 017	3.65			10 270 017	8.72
1.80			10 107 018	3.72	10 110 018	4.25			10 171 018	3.54			10 270 018	8.32
1.90			10 107 019	3.72	10 110 019	4.25			10 171 019	3.65			10 270 019	8.90
2.00			10 107 020	3.27	10 110 020	3.72	10 122 020	8.01	10 171 020	3.27	10 124 020	10.39	10 270 020	6.60
2.10			10 107 021	3.52	10 110 021	4.00	10 122 021	9.07	10 171 021	4.00	10 124 021	11.88	10 270 021	7.62
2.20			10 107 022	3.88	10 110 022	4.25	10 122 022	9.78	10 171 022	4.00	10 124 022	11.88	10 270 022	7.77
2.30			10 107 023	3.77	10 110 023	4.25	10 122 023	9.78	10 171 023	4.00	10 124 023	11.88	10 270 023	7.62
2.38			10 107 238	3.77					10 171 238	4.00				
2.40			10 107 024	3.88	10 110 024	4.48	10 122 024	10.23	10 171 024	4.00	10 124 024	11.88	10 270 024	7.06
2.50			10 107 025	3.52	10 110 025	3.88	10 122 025	8.94	10 171 025	3.38	10 124 025	11.88	10 270 025	6.76
2.55									10 171 255	4.00				
2.60			10 107 026	3.88	10 110 026	4.48	10 122 026	10.23	10 171 026	4.00	10 124 026	11.88	10 270 026	7.77
2.70			10 107 027	4.11	10 110 027	4.73	10 122 027	10.59	10 171 027	4.00	10 124 027	11.88	10 270 027	8.22
2.78			10 107 278	4.11					10 171 278	4.73				
2.80			10 107 028	4.11	10 110 028	4.73	10 122 028	10.59	10 171 028	4.00	10 124 028	11.88	10 270 028	7.86
2.90			10 107 029	4.11	10 110 029	4.73	10 122 029	10.59	10 171 029	4.11	10 124 029	11.88	10 270 029	8.22
3.00	10 520 030	6.32	10 107 030	3.72	10 110 030	4.00	10 122 030	9.78	10 171 030	3.38	10 124 030	11.30	10 270 030	7.28
3.10			10 107 031	4.00	10 110 031	4.62	10 122 031	9.78	10 171 031	4.11	10 124 031	12.95	10 270 031	8.72
3.17			10 107 317	3.88					10 171 317	3.88				
3.20			10 107 032	3.77	10 110 032	4.37	10 122 032	9.78	10 171 032	3.72	10 124 032	12.95	10 270 032	8.08
3.25									10 171 325	4.24				
3.30			10 107 033	4.11	10 110 033	4.73	10 122 033	9.78	10 171 033	3.72	10 124 033	12.95	10 270 033	8.57
3.40			10 107 034	4.25	10 110 034	4.73	10 122 034	9.78	10 171 034	4.35	10 124 034	12.95	10 270 034	8.90
3.50			10 107 035	4.11	10 110 035	4.25	10 122 035	9.29	10 171 035	3.72	10 124 035	12.95	10 270 035	8.72
3.57			10 107 357	4.25					10 171 357	4.47				
3.60			10 107 036	4.25	10 110 036	4.73	10 122 036	10.39	10 171 036	4.47	10 124 036	14.41	10 270 036	9.03
3.70			10 107 037	4.47	10 110 037	5.12	10 122 037	10.59	10 171 037	4.47	10 124 037	14.41	10 270 037	8.78
3.80			10 107 038	4.37	10 110 038	4.73	10 122 038	10.36	10 171 038	4.73	10 124 038	14.41	10 270 038	8.44
3.90			10 107 039	4.95	10 110 039	5.12	10 122 039	10.59	10 171 039	4.95	10 124 039	14.41	10 270 039	9.46
3.97			10 107 397	4.70					10 171 397	5.19				
4.00	10 520 040	6.43	10 107 040	4.37	10 110 040	4.37	10 122 040	8.59	10 171 040	3.88	10 124 040	14.41	10 270 040	9.24
4.10			10 107 041	4.62	10 110 041	4.73	10 122 041	8.59	10 171 041	4.70	10 124 041	16.70	10 270 041	9.40
4.20			10 107 042	4.47	10 110 042	4.73	10 122 042	9.07	10 171 042	4.70	10 124 042	17.65	10 270 042	9.03
4.25									10 171 425	4.96				
4.30			10 107 043	4.73	10 110 043	5.34	10 122 043	9.53	10 171 043	4.95	10 124 043	16.70	10 270 043	10.07
4.37			10 107 437	6.32					10 171 437	5.30				
4.40			10 107 044	5.34	10 110 044	5.46	10 122 044	10.82	10 171 044	4.96	10 124 044	16.70	10 270 044	8.90
4.50			10 107 045	4.73	10 110 045	4.48	10 122 045	8.94	10 171 045	4.95	10 124 045	16.70	10 270 045	9.46
4.60			10 107 046	5.19	10 110 046	5.93	10 122 046	11.30	10 171 046	5.30	10 124 046	18.95	10 270 046	9.12
4.65					10 110 465	6.17			10 171 465	5.41	10 124 465	18.95		
4.70			10 107 047	5.46	10 110 047	6.17	10 122 047	11.53	10 171 047	5.46	10 124 047	18.95	10 270 047	10.56
4.76			10 107 476	5.46					10 171 476	5.41				
4.80			10 107 048	5.53	10 110 048	6.17	10 122 048	11.53	10 171 048	5.30	10 124 048	18.95	10 270 048	10.28
4.90			10 107 049	6.12	10 110 049	6.17	10 122 049	11.53	10 171 049	5.41	10 124 049	18.95	10 270 049	10.41
4.95									10 171 495	5.41				
5.00	10 520 050	6.79	10 107 050	4.84	10 110 050	4.96	10 122 050	9.78	10 171 050	4.73	10 124 050	20.60	10 270 050	10.56
5.05									10 171 505	5.41				
5.10			10 107 051	6.47	10 110 051	6.17	10 122 051	11.30	10 171 051	5.41	10 124 051	20.60	10 270 051	11.67
5.16			10 107 516	8.36					10 171 516	5.93				
5.20			10 107 052	8.01	10 110 052	6.17	10 122 052	11.65	10 171 052	5.81	10 124 052	20.60	10 270 052	11.45
5.30			10 107 053	8.47	10 110 053	6.43	10 122 053	11.77	10 171 053	5.81	10 124 053	22.73	10 270 053	12.60
5.40			10 107 054	8.36	10 110 054	7.14	10 122 054	13.06	10 171 054	6.32	10 124 054	22.73	10 270 054	13.76
5.50			10 107 055	6.24	10 110 055	5.34	10 122 055	10.36	10 171 055	6.47	10 124 055	20.60	10 270 055	10.97
5.55					10 110 555	6.79	10 122 555	13.06	10 171 555	7.38	10 124 555	23.64		
5.56			10 107 556	6.95					10 171 556	7.38				
5.60			10 107 056	10.23	10 110 056	6.79	10 122 056	13.06	10 171 056	6.43	10 124 056	23.64	10 270 056	14.34
5.70			10 107 057	10.36	10 110 057	6.79	10 122 057	13.06	10 171 057	6.43	10 124 057	23.64	10 270 057	15.84
5.75									10 171 575	6.43				
5.80			10 107 058	10.94	10 110 058	6.79	10 122 058	13.06	10 171 058	6.43	10 124 058	23.64	10 270 058	13.91
5.90			10 107 059	11.08	10 110 059	7.03	10 122 059	13.06	10 171 059	6.43	10 124 059	23.64	10 270 059	15.50
5.95			10 107 595	12.14					10 171 595	8.23				
6.00	10 520 060	6.79	10 107 060	6.24	10 110 060	5.81	10 122 060	10.94	10 171 060	6.32	10 124 060	22.47	10 270 060	13.18
6.10			10 107 061	11.77	10 110 061	8.74	10 122 061	16.94	10 171 061	7.14	10 124 061	27.76	10 270 061	15.63
6.20			10 107 062	11.99	10 110 062	9.10	10 122 062	16.94	10 171 062	7.14	10 124 062	27.76	10 270 062	14.02
6.30			10 107 063	13.06	10 110 063	9.21	10 122 063	20.23	10 171 063	7.14	10 124 063	27.76	10 270 063	15.63
6.35			10 107 635	12.95					10 171 635	7.63				
6.40			10 107 064	13.29	10 110 064	9.51	10 122 064	17.57	10 171 064	7.63	10 124 064	27.76	10 270 064	14.21
6.50			10 107 065	7.30	10 110 065	6.79	10 122 065	12.84	10 171 065	7.05	10 124 065	27.76	10 270 065	13.66
6.60			10 107 066	13.76	10 110 066	9.51	10 122 066	20.60	10 171 066	7.63	10 124 066	29.77	10 270 066	15.74
6.70			10 107 067	14.01	10 110 067	9.51	10 122 067	20.60	10 171 067	7.63	10 124 067	29.77	10 270 067	16.15
6.75			10 107 675	10.73					10 171 675	10.46				
6.80			10 107 068	14.36	10 110 068	9.93	10 122 068	22.53	10 171 068	8.65	10 124 068	29.77	10 270 068	17.33
6.90			10 107 069	14.47	10 110 069	9.93	10 122 069	22.24	10 171 069	8.65	10 124 069	29.77	10 270 069	17.96
7.00			10 107 070	8.36	10 110 070	8.23	10 122 070	16.94	10 171 070	7.38	10 124 070	29.77	10 270 070	16.30
7.10			10 107 071	15.05	10 110 071	11.14	10 122 071	24.93	10 171 071	9.82	10 124 071	30.99	10 270 071	15.74
7.14			10 107 714	15.41					10 171 714	14.66				
7.20			10 107 072	15.19	10 110 072	11.14	10 122 072	25.31	10 171 072	9.82	10 124 072	30.99	10 270 072	18.03

Steel	●	●	●	●	●	●	●
Stainless steel	○	●	○	●	●	●	○
Cast iron	●	●	○	●	●	●	●
Non ferrous metals	○	●	○	●	●	●	●
Heat resistant alloys		○	○	○	○	○	

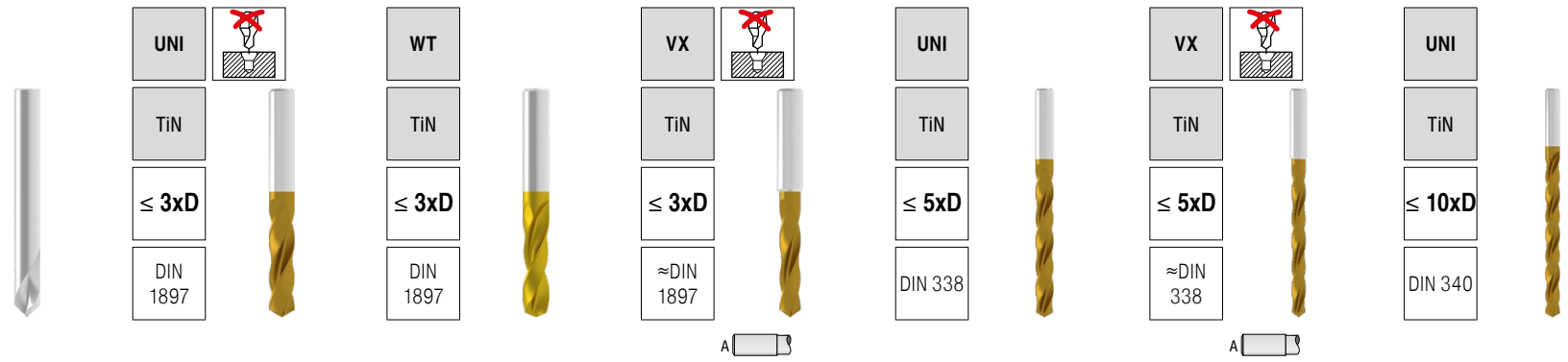
Ø DC $_{h8}$ for Type UNI, WT and VX / **Ø DC**$_{h6}$ for Type NC-A

Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

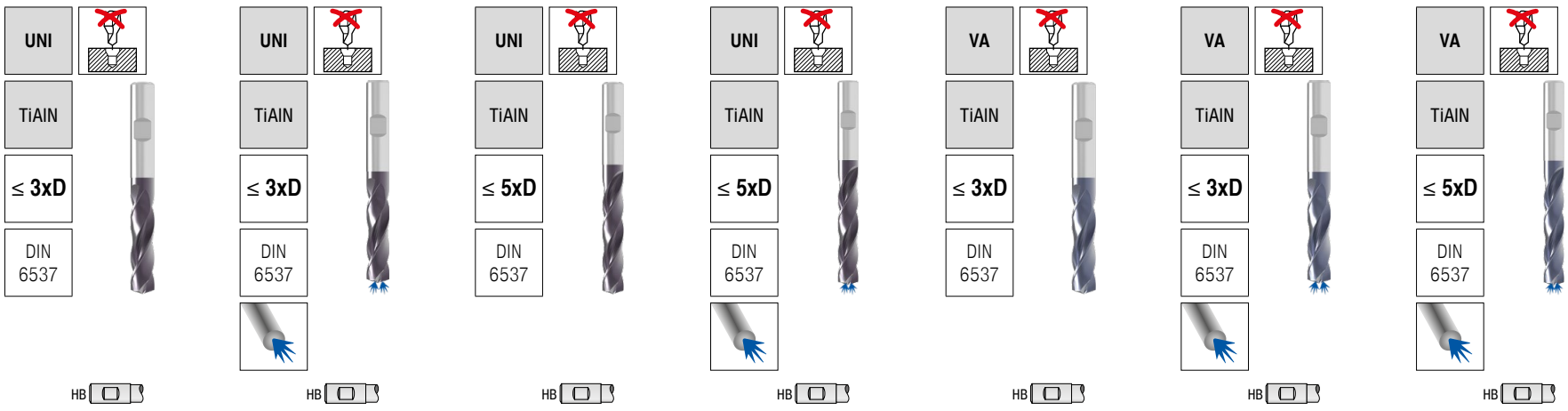
NC spot drills, factory standard and high-performance twist drills



	NC-A	UNI	WT	VX	UNI	VX	UNI
		TiN	TiN	TiN	TiN	TiN	TiN
		≤ 3xD	≤ 3xD	≤ 3xD	≤ 5xD	≤ 5xD	≤ 10xD
		DIN 1897	DIN 1897	≈DIN 1897	DIN 338	≈DIN 338	DIN 340
				A		A	
	WNT \ Performance	WNT \ Performance	WNT \ Performance	WNT \ Performance	WNT \ Performance	WNT \ Performance	WNT \ Performance
DC h8/h6	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
mm	£	£	£	£	£	£	£
7.30		10 107 073 15.29	10 110 073 11.27	10 122 073 25.31	10 171 073 9.82	10 124 073 30.99	10 270 073 18.84
7.40		10 107 074 15.19	10 110 074 11.27	10 122 074 25.31	10 171 074 9.82	10 124 074 30.99	10 270 074 19.52
7.45				10 122 745 25.31	10 171 745 7.89		
7.50		10 107 075 9.53	10 110 075 8.60	10 122 075 17.88	10 171 075 7.89	10 124 075 30.99	10 270 075 19.86
7.55						10 124 755 30.94	
7.60		10 107 076 14.23	10 110 076 12.23	10 122 076 25.69	10 171 076 11.53	10 124 076 30.94	10 270 076 21.32
7.70		10 107 077 17.65	10 110 077 12.23	10 122 077 27.64	10 171 077 11.87	10 124 077 30.94	10 270 077 20.14
7.80		10 107 078 17.06	10 110 078 12.23	10 122 078 27.64	10 171 078 11.53	10 124 078 30.94	10 270 078 22.19
7.90		10 107 079 18.70	10 110 079 12.23	10 122 079 27.64	10 171 079 11.87	10 124 079 30.94	10 270 079 21.39
7.94		10 107 794 9.64			10 171 794 11.53		
8.00	10 520 080 11.61	10 107 080 9.21	10 110 080 8.86	10 122 080 18.35	10 171 080 9.57	10 124 080 30.94	10 270 080 18.16
8.10		10 107 081 19.18	10 110 081 12.23	10 122 081 31.37	10 171 081 11.53	10 124 081 34.65	10 270 081 20.02
8.20		10 107 082 20.01	10 110 082 12.23	10 122 082 31.37	10 171 082 12.34	10 124 082 34.65	10 270 082 21.84
8.30		10 107 083 21.51	10 110 083 12.85	10 122 083 31.37	10 171 083 12.34	10 124 083 34.65	10 270 083 23.15
8.40		10 107 084 22.11	10 110 084 12.85	10 122 084 31.37	10 171 084 12.95	10 124 084 34.65	10 270 084 24.88
8.50		10 107 085 10.94	10 110 085 10.64	10 122 085 20.82	10 171 085 9.45	10 124 085 34.94	10 270 085 21.32
8.60		10 107 086 13.15	10 110 086 13.22	10 122 086 32.60	10 171 086 21.13	10 124 086 32.24	10 270 086 21.17
8.70		10 107 087 15.13	10 110 087 13.22	10 122 087 32.60	10 171 087 21.13	10 124 087 32.24	10 270 087 21.39
8.73		10 107 873 17.33			10 171 873 13.88		
8.80		10 107 088 14.23	10 110 088 13.22	10 122 088 32.60	10 171 088 14.71	10 124 088 32.24	10 270 088 21.73
8.90		10 107 089 18.71	10 110 089 13.58	10 122 089 32.60	10 171 089 18.16	10 124 089 32.24	10 270 089 22.09
9.00		10 107 090 11.53	10 110 090 10.80	10 122 090 22.71	10 171 090 11.88	10 124 090 32.24	10 270 090 22.40
9.10		10 107 091 15.77	10 110 091 17.30	10 122 091 40.88	10 171 091 19.75	10 124 091 34.65	10 270 091 22.40
9.20		10 107 092 15.88	10 110 092 17.30	10 122 092 40.88	10 171 092 20.26	10 124 092 34.65	10 270 092 22.40
9.30		10 107 093 27.99	10 110 093 17.30	10 122 093 40.88	10 171 093 17.99	10 124 093 34.65	10 270 093 22.40
9.35				10 122 935 40.88	10 171 935 14.01		
9.40		10 107 094 18.41	10 110 094 17.30	10 122 094 40.88	10 171 094 22.24	10 124 094 34.65	10 270 094 22.40
9.50		10 107 095 12.34	10 110 095 14.06	10 122 095 28.39	10 171 095 14.01	10 124 095 34.65	10 270 095 22.40
9.55						10 124 955 37.80	
9.60		10 107 096 19.25	10 110 096 17.57	10 122 096 30.63	10 171 096 20.11	10 124 096 37.80	10 270 096 23.72
9.70		10 107 097 18.71	10 110 097 17.57	10 122 097 30.63	10 171 097 23.62	10 124 097 37.80	10 270 097 24.88
9.80		10 107 098 28.82	10 110 098 18.79	10 122 098 30.63	10 171 098 20.11	10 124 098 37.80	10 270 098 26.58
9.90		10 107 099 19.99	10 110 099 18.79	10 122 099 30.63	10 171 099 18.51	10 124 099 37.80	10 270 099 28.88
10.00	10 520 100 12.14	10 107 100 14.36	10 110 100 13.22	10 122 100 27.29	10 171 100 14.08	10 124 100 37.80	10 270 100 31.23
10.10		10 107 101 19.25		10 122 101 42.28	10 171 101 18.18	10 124 101 47.91	10 270 101 34.11
10.20		10 107 102 22.81	10 110 102 18.66	10 122 102 40.39	10 171 102 19.05	10 124 102 47.91	10 270 102 36.44
10.30		10 107 103 17.88		10 122 103 41.11	10 171 103 15.88	10 124 103 47.91	10 270 103 39.31
10.40		10 107 104 20.94		10 122 104 43.75	10 171 104 19.66	10 124 104 47.91	10 270 104 39.31
10.50		10 107 105 24.71	10 110 105 17.78	10 122 105 39.25	10 171 105 19.76	10 124 105 47.91	10 270 105 39.91
10.55					10 171 955 21.66		
10.60				10 122 106 47.00		10 124 106 52.62	
10.70				10 122 107 42.90		10 124 107 52.62	
10.80			10 110 108 39.65	10 122 108 41.23		10 124 108 52.62	
10.90				10 122 109 60.58		10 124 109 52.62	
11.00		10 107 110 26.34	10 110 110 17.78	10 122 110 39.25	10 171 110 21.66	10 124 110 44.35	10 270 110 47.37
11.10				10 122 111 38.39		10 124 111 47.49	
11.11		10 107 111 31.05			10 171 111 41.76		
11.20					10 171 112 41.76	10 124 112 47.49	
11.30					10 171 113 41.98	10 124 113 47.49	
11.40					10 171 114 41.98	10 124 114 47.49	
11.50		10 107 115 29.89	10 110 115 18.54	10 122 115 40.88	10 171 115 27.64	10 124 115 47.49	10 270 115 47.99
11.60					10 171 116 48.10	10 124 116 52.36	
11.70				10 122 117 45.95		10 124 117 52.36	
11.80			10 110 118 22.24	10 122 118 47.98		10 124 118 52.36	
11.90				10 122 119 60.67		10 124 119 52.36	
12.00	10 520 120 18.66	10 107 120 35.16	10 110 120 21.21	10 122 120 46.94	10 171 120 30.82	10 124 120 52.36	10 270 120 48.54
12.10				10 122 121 34.19		10 124 121 60.15	
12.15					10 171 121 31.64		
12.20				10 122 122 50.90		10 124 122 60.15	
12.30		10 107 123 32.71	10 110 123 32.60	10 122 123 62.57	10 171 123 32.71	10 124 123 60.15	
12.40				10 122 124 74.66		10 124 124 60.15	
12.50		10 107 125 35.41	10 110 125 22.24	10 122 125 48.35	10 171 925 31.64	10 124 125 60.15	10 270 125 53.18
12.60				10 122 126 98.01		10 124 126 63.35	
12.70		10 107 127 27.01		10 122 127 107.26	10 171 127 24.81	10 124 127 63.35	
12.80			10 110 128 41.07	10 122 128 50.92		10 124 128 63.35	
12.90				10 122 129 75.08		10 124 129 63.35	
13.00		10 107 130 35.41	10 110 130 22.41	10 122 130 51.97	10 171 130 33.75	10 124 130 69.88	10 270 130 57.83
13.10					10 171 131 42.69		
13.30					10 171 133 42.69		
13.50		10 107 135 35.41	10 110 135 24.49	10 122 135 77.80	10 171 135 42.69	10 124 135 90.63	10 270 135 58.96
13.80			10 110 138 26.42				
14.00		10 107 140 37.63	10 110 140 25.69	10 122 140 77.80	10 171 140 40.93	10 124 140 90.63	10 270 140 61.29
14.50			10 110 145 26.31	10 122 145 99.65		10 124 145 115.95	
15.00			10 110 150 27.18	10 122 150 93.85		10 124 150 108.92	
15.50			10 110 155 35.45	10 122 155 101.50		10 124 155 118.05	
15.75			10 110 157 37.43				
16.00	10 520 160 24.32		10 110 160 34.96	10 122 160 98.05		10 124 160 113.98	
16.50			10 110 165 51.48	10 122 165 152.01		10 124 165 176.70	
17.00			10 110 170 50.76	10 122 170 152.01		10 124 170 176.70	
17.50			10 110 175 47.49	10 122 175 152.01		10 124 175 176.70	
17.75			10 110 177 57.55				
18.00			10 110 180 55.56	10 122 180 152.01		10 124 180 176.70	
18.50			10 110 185 62.25	10 122 185 152.01		10 124 185 176.70	
19.00			10 110 190 60.98	10 122 190 152.01		10 124 190 176.70	
19.50			10 110 195 68.42	10 122 195 152.01		10 124 195 176.70	
19.75			10 110 197 68.44				
20.00	10 520 200 39.16		10 110 200 65.44	10 122 200 135.21		10 124 200 157.08	
Steel	●	●	●	●	●	●	●
Stainless steel	○	●	○	●	●	●	○
Cast iron	●	●	○	●	●	●	●
Non ferrous metals	○	●	○	●	●	●	●
Heat resistant alloys		○	○	○	○	○	

Ø DC $_{h8}$ for Type UNI, WT and VX / **Ø DC**$_{h6}$ for Type NC-A

WPC – High Performance Drill, DIN 6537



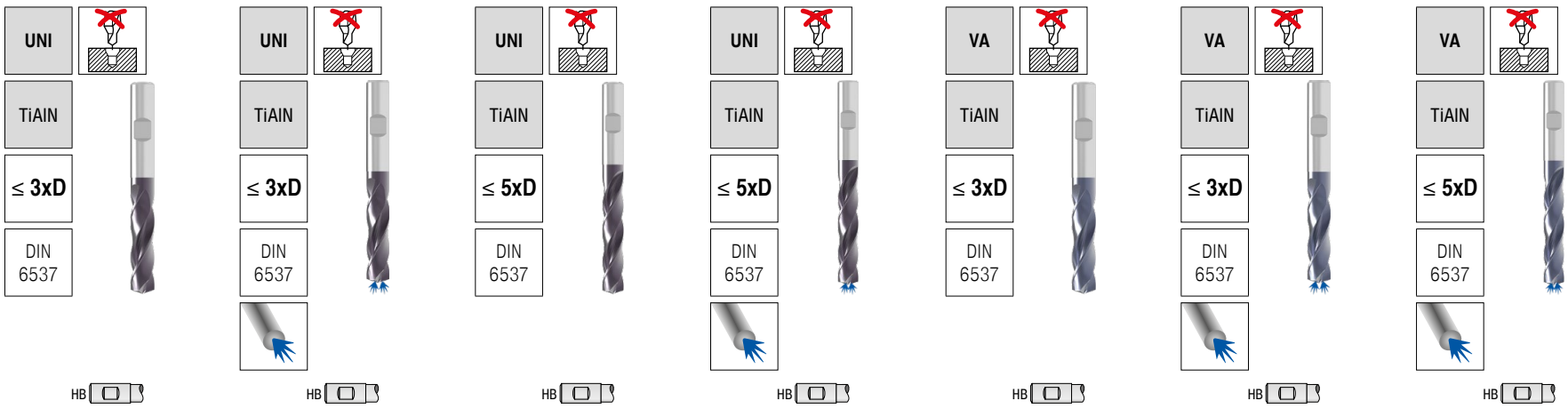
DC m7	WNT \ Standard		WNT \ Standard		WNT \ Standard		WNT \ Standard		WNT \ Standard		WNT \ Standard		WNT \ Standard	
	Article no.		Article no.		Article no.		Article no.		Article no.		Article no.		Article no.	
mm		£		£		£		£		£		£		£
2.00	11 601 020	20.35							11 621 020	20.35				
2.10	11 601 021	20.35							11 621 021	20.35				
2.20	11 601 022	20.35							11 621 022	20.35				
2.30	11 601 023	20.35							11 621 023	20.35				
2.40	11 601 024	20.35							11 621 024	20.35				
2.50	11 601 025	20.35							11 621 025	20.35				
2.60	11 601 026	20.35							11 621 026	20.35				
2.70	11 601 027	20.35							11 621 027	20.35				
2.80	11 601 028	20.35							11 621 028	20.35				
2.90	11 601 029	20.35							11 621 029	20.35				
3.00	11 601 030	20.35	11 604 030	26.16	11 607 030	23.25	11 610 030	35.00	11 621 030	20.35	11 624 030	26.16	11 630 030	35.00
3.10	11 601 031	20.35	11 604 031	26.16	11 607 031	23.25	11 610 031	35.00	11 621 031	20.35	11 624 031	26.16	11 630 031	35.00
3.20	11 601 032	20.35	11 604 032	26.16	11 607 032	23.25	11 610 032	35.00	11 621 032	20.35	11 624 032	26.16	11 630 032	35.00
3.25			11 604 890	26.16			11 610 890	34.87						
3.30	11 601 033	20.35	11 604 033	26.16	11 607 033	23.25	11 610 033	35.00	11 621 033	20.35	11 624 033	26.16	11 630 033	35.00
3.40	11 601 034	20.35	11 604 034	26.16	11 607 034	23.25	11 610 034	35.00	11 621 034	20.35	11 624 034	26.16	11 630 034	35.00
3.50	11 601 035	20.35	11 604 035	26.16	11 607 035	23.25	11 610 035	35.00	11 621 035	20.35	11 624 035	26.16	11 630 035	35.00
3.60	11 601 036	20.35	11 604 036	26.16	11 607 036	23.25	11 610 036	35.00	11 621 036	20.35	11 624 036	26.16	11 630 036	35.00
3.70	11 601 037	20.35	11 604 037	26.16	11 607 037	23.25	11 610 037	35.00	11 621 037	20.35	11 624 037	26.16	11 630 037	35.00
3.80	11 601 038	20.35	11 604 038	26.16	11 607 038	23.25	11 610 038	35.00	11 621 038	20.35	11 624 038	26.16	11 630 038	35.00
3.90	11 601 039	20.35	11 604 039	26.16	11 607 039	23.25	11 610 039	35.00	11 621 039	20.35	11 624 039	26.16	11 630 039	35.00
4.00	11 601 040	20.35	11 604 040	27.61	11 607 040	23.25	11 610 040	36.33	11 621 040	20.35	11 624 040	27.61	11 630 040	36.33
4.10	11 601 041	20.35	11 604 041	27.61	11 607 041	23.25	11 610 041	36.33	11 621 041	20.35	11 624 041	27.61	11 630 041	36.33
4.20	11 601 042	20.35	11 604 042	27.61	11 607 042	23.25	11 610 042	36.33	11 621 042	20.35	11 624 042	27.61	11 630 042	36.33
4.30	11 601 043	20.35	11 604 043	27.61	11 607 043	23.25	11 610 043	36.33	11 621 043	20.35	11 624 043	27.61	11 630 043	36.33
4.40	11 601 044	20.35	11 604 044	27.61	11 607 044	23.25	11 610 044	36.33	11 621 044	20.35	11 624 044	27.61	11 630 044	36.33
4.50	11 601 045	20.35	11 604 045	27.61	11 607 045	23.25	11 610 045	36.33	11 621 045	20.35	11 624 045	27.61	11 630 045	36.33
4.60	11 601 046	20.35	11 604 046	27.61	11 607 046	23.25	11 610 046	36.33	11 621 046	20.35	11 624 046	27.61	11 630 046	36.33
4.65	11 601 900	20.35	11 604 900	27.61	11 607 900	23.25	11 610 900	36.33	11 621 900	20.35	11 624 900	27.61	11 630 900	36.33
4.70	11 601 047	20.35	11 604 047	27.61	11 607 047	23.25	11 610 047	36.33	11 621 047	20.35	11 624 047	27.61	11 630 047	36.33
4.80	11 601 048	20.35	11 604 048	27.61	11 607 048	23.25	11 610 048	36.33	11 621 048	20.35	11 624 048	27.61	11 630 048	36.33
4.90	11 601 049	20.35	11 604 049	27.61	11 607 049	23.25	11 610 049	36.33	11 621 049	20.35	11 624 049	27.61	11 630 049	36.33
5.00	11 601 050	20.35	11 604 050	27.61	11 607 050	23.25	11 610 050	36.33	11 621 050	20.35	11 624 050	27.61	11 630 050	36.33
5.10	11 601 051	20.35	11 604 051	27.61	11 607 051	23.25	11 610 051	36.33	11 621 051	20.35	11 624 051	27.61	11 630 051	36.33
5.20	11 601 052	20.35	11 604 052	27.61	11 607 052	23.25	11 610 052	36.33	11 621 052	20.35	11 624 052	27.61	11 630 052	36.33
5.30	11 601 053	20.35	11 604 053	27.61	11 607 053	23.25	11 610 053	36.33	11 621 053	20.35	11 624 053	27.61	11 630 053	36.33
5.40	11 601 054	20.35	11 604 054	27.61	11 607 054	23.25	11 610 054	36.33	11 621 054	20.35	11 624 054	27.61	11 630 054	36.33
5.50	11 601 055	20.35	11 604 055	27.61	11 607 055	23.25	11 610 055	36.33	11 621 055	20.35	11 624 055	27.61	11 630 055	36.33
5.55	11 601 902	20.35	11 604 902	27.61	11 607 902	23.25	11 610 902	36.33	11 621 902	20.35	11 624 902	27.61	11 630 902	36.33
5.60	11 601 056	20.35	11 604 056	27.61	11 607 056	23.25	11 610 056	36.33	11 621 056	20.35	11 624 056	27.61	11 630 056	36.33
5.70	11 601 057	20.35	11 604 057	27.61	11 607 057	23.25	11 610 057	36.33	11 621 057	20.35	11 624 057	27.61	11 630 057	36.33
5.80	11 601 058	20.35	11 604 058	27.61	11 607 058	23.25	11 610 058	36.33	11 621 058	20.35	11 624 058	27.61	11 630 058	36.33
5.90	11 601 059	20.35	11 604 059	27.61	11 607 059	23.25	11 610 059	36.33	11 621 059	20.35	11 624 059	27.61	11 630 059	36.33
6.00	11 601 060	20.35	11 604 060	27.61	11 607 060	23.25	11 610 060	36.33	11 621 060	20.35	11 624 060	27.61	11 630 060	36.33
6.10	11 601 061	20.35	11 604 061	36.33	11 607 061	23.25	11 610 061	36.83	11 621 061	20.35	11 624 061	36.33	11 630 061	39.23
6.20	11 601 062	20.35	11 604 062	36.33	11 607 062	23.25	11 610 062	36.83	11 621 062	20.35	11 624 062	36.33	11 630 062	39.23
6.30	11 601 063	20.35	11 604 063	36.33	11 607 063	23.25	11 610 063	36.83	11 621 063	20.35	11 624 063	36.33	11 630 063	39.23
6.40	11 601 064	20.35	11 604 064	36.33	11 607 064	23.25	11 610 064	36.83	11 621 064	20.35	11 624 064	36.33	11 630 064	39.23
6.50	11 601 065	20.35	11 604 065	37.78	11 607 065	23.25	11 610 065	40.69	11 621 065	20.35	11 624 065	37.78	11 630 065	40.69
6.60	11 601 066	20.35	11 604 066	37.78	11 607 066	23.25	11 610 066	40.69	11 621 066	20.35	11 624 066	37.78	11 630 066	40.69
6.70	11 601 067	20.35	11 604 067	37.78	11 607 067	23.25	11 610 067	40.69	11 621 067	20.35	11 624 067	37.78	11 630 067	40.69
6.80	11 601 068	20.35	11 604 068	37.78	11 607 068	23.25	11 610 068	40.69	11 621 068	20.35	11 624 068	37.78	11 630 068	40.69
6.90	11 601 069	20.35	11 604 069	37.78	11 607 069	23.25	11 610 069	40.69	11 621 069	20.35	11 624 069	37.78	11 630 069	40.69
7.00	11 601 070	20.35	11 604 070	37.78	11 607 070	23.25	11 610 070	40.69	11 621 070	20.35	11 624 070	37.78	11 630 070	40.69
7.10	11 601 071	20.35	11 604 071	37.78	11 607 071	23.25	11 610 071	40.69	11 621 071	20.35	11 624 071	37.78	11 630 071	40.69
7.20	11 601 072	20.35	11 604 072	37.78	11 607 072	23.25	11 610 072	40.69	11 621 072	20.35	11 624 072	37.78	11 630 072	40.69
7.30	11 601 073	20.35	11 604 073	37.78	11 607 073	23.25	11 610 073	40.69	11 621 073	20.35	11 624 073	37.78	11 630 073	40.69
7.40	11 601 074	20.35	11 604 074	37.78	11 607 074	23.25	11 610 074	40.69	11 621 074	20.35	11 624 074	37.78	11 630 074	40.69
7.45			11 604 924	36.33			11 610 924	39.23						
7.50	11 601 075	20.35	11 604 075	37.78	11 607 075	23.25	11 610 075	40.69	11 621 075	20.35	11 624 075	37.78	11 630 075	40.69
7.55	11 601 975	20.35	11 604 975	37.78	11 607 975	23.25	11 610 975	40.69	11 621 975	20.35	11 624 975	37.78	11 630 975	40.69
7.60	11 601 076	20.35	11 604 076	37.78	11 607 076	23.25	11 610 076	40.69	11 621 076	20.35	11 624 076	37.78	11 630 076	40.69
7.70	11 601 077	20.35	11 604 077	37.78	11 607 077	23.25	11 610 077	40.69	11 621 077	20.35	11 624 077	37.78	11 630 077	40.69
7.80	11 601 078	20.35	11 604 078	37.78	11 607 078	23.25	11 610 078	40.69	11 621 078	20.35	11 624 078	37.78	11 630 078	40.69
7.90	11 601 079	20.35	11 604 079	37.78	11 607 079	23.25	11 610 079	40.69	11 621 079	20.35	11 624 079	37.78	11 630 079	40.69
8.00	11 601 080	20.35	11 604 080	37.78	11 607 080	23.25	11 610 080	40.69	11 621 080	20.35	11 624 080	37.78	11 630 080	40.69
8.10	11 601 081	23.25	11 604 081	43.60	11 607 081	26.16	11 610 081	46.49	11 621 081	23.25	11 624 081	43.60	11 630 081	45.05
8.20	11 601 082	23.25	11 604 082	43.60	11 607 082	26.16	11 610 082	46.49	11 621 082	23.25	11 624 082	43.60	11 630 082	45.05
8.30	11 601 083	23.25	11 604 083	43.60	11 607 083	26.16	11 610 083	46.49	11 621 083	23.25	11 624 083	43.60	11 630 083	45.05
8.40	11 601 084	23.25	11 604 084	43.60	11 607 084	26.16	11 610 084	46.49	11 621 084	23.25	11 624 084	43.60	11 630 084	45.05
8.50	11 601 085	23.25	11 604 085	43.60	11 607 085	26.16	11 610 085	46.49	11 621 085	23.25	11 624 085	43.60	11 630 085	45.05
8.60	11 601 086	23.25	11 604 086	43.60	11 607 086	26.16	11 610 086	46.49	11 621 086	23.25	11 624 086	43.60	11 630 086	45.05
8.70	11 601 087	23.25	11 604 087	43.60	11 607 087	26.16	11 610 087	46.49	11 621 087	23.25	11 624 087	43.60	11 630 087	45.05
8.80	11 601 088	23.25	11 604 088	43.60	11 607 088	26.16	11 610 088	46.49	11 621 088	23.25	11 624 088	43.60	11 630 088	45.05
8.90	11 601 089	23.25	11 604 089	43.60	11 607 089	26.16	11 610 089	46.49	11 621 089	23.25	11 624 089	43.60	11 630 089	45.05
9.00	11 601 090	23.25	11 604 090	43.60	11 607 090	26.16	11 610 090	46.49	11 621 090	23.25	11 624 090	43.60	11 630 090	45.05
9.10	11 601 091	23.25	11 604 091	43.60	11 607 091	26.16	11 610 091	46.49	11 621 091	23.25	11 624 091	43.60	11 630 091	45.05
9.20	11 601 092	23.25	11 604 092	43.60	11 607 092	26.16	11 610 092	46.49	11 621 092	23.25	11 624 092	43.60	11 630 092	45.05
Steel	●		●		●		●		○		○		○	
Stainless steel			○				○		●		●		●	
Cast iron	●		●		●		●		○		○		○	
Non ferrous metals	○		○		○		○		●		●		●	
Heat resistant alloys											●		●	

Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

WPC – High Performance Drill, DIN 6537



DC m7	WNT \ Standard		WNT \ Standard		WNT \ Standard		WNT \ Standard		WNT \ Standard		WNT \ Standard		WNT \ Standard	
	Article no.		Article no.		Article no.		Article no.		Article no.		Article no.		Article no.	
mm		£		£		£		£		£		£		£
9.25	11 601 925	23.25	11 604 925	43.60	11 607 925	26.16	11 610 925	46.49	11 621 925	23.25	11 624 925	43.60	11 630 925	45.05
9.30	11 601 093	23.25	11 604 093	43.60	11 607 093	26.16	11 610 093	46.49	11 621 093	23.25	11 624 093	43.60	11 630 093	45.05
9.35			11 604 930	42.13			11 610 930	45.05						
9.40	11 601 094	23.25	11 604 094	43.60	11 607 094	26.16	11 610 094	46.49	11 621 094	23.25	11 624 094	43.60	11 630 094	45.05
9.50	11 601 095	23.25	11 604 095	43.60	11 607 095	26.16	11 610 095	46.49	11 621 095	23.25	11 624 095	43.60	11 630 095	45.05
9.60	11 601 096	23.25	11 604 096	43.60	11 607 096	26.16	11 610 096	46.49	11 621 096	23.25	11 624 096	43.60	11 630 096	45.05
9.70	11 601 097	23.25	11 604 097	43.60	11 607 097	26.16	11 610 097	46.49	11 621 097	23.25	11 624 097	43.60	11 630 097	45.05
9.80	11 601 098	23.25	11 604 098	43.60	11 607 098	26.16	11 610 098	46.49	11 621 098	23.25	11 624 098	43.60	11 630 098	45.05
9.90	11 601 099	23.25	11 604 099	43.60	11 607 099	26.16	11 610 099	46.49	11 621 099	23.25	11 624 099	43.60	11 630 099	45.05
10.00	11 601 100	23.25	11 604 100	43.60	11 607 100	26.16	11 610 100	46.49	11 621 100	23.25	11 624 100	43.60	11 630 100	45.05
10.10	11 601 101	34.87	11 604 101	62.47	11 607 101	39.23	11 610 101	68.29	11 621 101	34.87	11 624 101	62.47	11 630 101	68.29
10.20	11 601 102	34.87	11 604 102	62.47	11 607 102	39.23	11 610 102	68.29	11 621 102	34.87	11 624 102	62.47	11 630 102	68.29
10.30	11 601 103	34.87	11 604 103	62.47	11 607 103	39.23	11 610 103	68.29	11 621 103	34.87	11 624 103	62.47	11 630 103	68.29
10.40	11 601 104	34.87	11 604 104	62.47	11 607 104	39.23	11 610 104	68.29	11 621 104	34.87	11 624 104	62.47	11 630 104	68.29
10.50	11 601 105	34.87	11 604 105	62.47	11 607 105	39.23	11 610 105	68.29	11 621 105	34.87	11 624 105	62.47	11 630 105	68.29
10.60	11 601 106	34.87	11 604 106	62.47	11 607 106	39.23	11 610 106	68.29	11 621 106	34.87	11 624 106	62.47	11 630 106	68.29
10.70	11 601 107	34.87	11 604 107	62.47	11 607 107	39.23	11 610 107	68.29	11 621 107	34.87	11 624 107	62.47	11 630 107	68.29
10.75			11 604 904	59.54			11 610 904	65.36						
10.80	11 601 108	34.87	11 604 108	62.47	11 607 108	39.23	11 610 108	68.29	11 621 108	34.87	11 624 108	62.47	11 630 108	68.29
10.90	11 601 109	34.87	11 604 109	62.47	11 607 109	39.23	11 610 109	68.29	11 621 109	34.87	11 624 109	62.47	11 630 109	68.29
11.00	11 601 110	34.87	11 604 110	62.47	11 607 110	39.23	11 610 110	68.29	11 621 110	34.87	11 624 110	62.47	11 630 110	68.29
11.10	11 601 111	34.87	11 604 111	62.47	11 607 111	39.23	11 610 111	68.29	11 621 111	34.87	11 624 111	62.47	11 630 111	68.29
11.20	11 601 112	34.87	11 604 112	62.47	11 607 112	39.23	11 610 112	68.29	11 621 112	34.87	11 624 112	62.47	11 630 112	68.29
11.25			11 604 912	59.54			11 610 912	65.36						
11.30	11 601 113	34.87	11 604 113	62.47	11 607 113	39.23	11 610 113	68.29	11 621 113	34.87	11 624 113	62.47	11 630 113	68.29
11.40	11 601 114	34.87	11 604 114	62.47	11 607 114	39.23	11 610 114	68.29	11 621 114	34.87	11 624 114	62.47	11 630 114	68.29
11.50	11 601 115	34.87	11 604 115	62.47	11 607 115	39.23	11 610 115	68.29	11 621 115	34.87	11 624 115	62.47	11 630 115	68.29
11.60	11 601 116	34.87	11 604 116	62.47	11 607 116	39.23	11 610 116	68.29	11 621 116	34.87	11 624 116	62.47	11 630 116	68.29
11.70	11 601 117	34.87	11 604 117	62.47	11 607 117	39.23	11 610 117	68.29	11 621 117	34.87	11 624 117	62.47	11 630 117	68.29
11.80	11 601 118	34.87	11 604 118	62.47	11 607 118	39.23	11 610 118	68.29	11 621 118	34.87	11 624 118	62.47	11 630 118	68.29
11.90	11 601 119	34.87	11 604 119	62.47	11 607 119	39.23	11 610 119	68.29	11 621 119	34.87	11 624 119	62.47	11 630 119	68.29
12.00	11 601 120	34.87	11 604 120	62.47	11 607 120	39.23	11 610 120	68.29	11 621 120	34.87	11 624 120	62.47	11 630 120	68.29
12.25	11 601 122	45.05	11 604 122	84.25	11 607 122	50.84	11 610 122	88.61						
12.50	11 601 125	46.49	11 604 125	87.16	11 607 125	50.84	11 610 125	92.97	11 621 125	46.49	11 624 125	87.16	11 630 125	92.97
12.70	11 601 127	46.49	11 604 127	87.16	11 607 127	50.84	11 610 127	92.97	11 621 127	46.49	11 624 127	87.16	11 630 127	92.97
12.80	11 601 128	45.05	11 604 128	84.25	11 607 128	50.84	11 610 128	88.61						
12.90	11 601 129	45.05	11 604 129	84.25	11 607 129	50.84	11 610 129	88.61						
13.00	11 601 130	46.49	11 604 130	87.16	11 607 130	50.84	11 610 130	92.97	11 621 130	46.49	11 624 130	87.16	11 630 130	92.97
13.10			11 604 131	84.25			11 610 131	88.61						
13.30	11 601 133	45.05	11 604 133	84.25	11 607 133	50.84	11 610 133	88.61						
13.50	11 601 135	46.49	11 604 135	87.16	11 607 135	50.84	11 610 135	92.97	11 621 135	46.49	11 624 135	87.16	11 630 135	92.97
13.70	11 601 137	46.49	11 604 137	87.16	11 607 137	50.84	11 610 137	92.97	11 621 137	46.49	11 624 137	87.16	11 630 137	92.97
13.80	11 601 138	45.05	11 604 138	84.25	11 607 138	50.84	11 610 138	88.61						
14.00	11 601 140	46.49	11 604 140	87.16	11 607 140	50.84	11 610 140	92.97	11 621 140	46.49	11 624 140	87.16	11 630 140	92.97
14.20	11 601 142	59.54	11 604 142	103.14	11 607 142	66.83	11 610 142	110.41						
14.50	11 601 145	61.02	11 604 145	107.51	11 607 145	66.83	11 610 145	114.76	11 621 145	61.02	11 624 145	107.51	11 630 145	114.76
14.70	11 601 147	61.02	11 604 147	107.51	11 607 147	66.83	11 610 147	114.76	11 621 147	61.02	11 624 147	107.51	11 630 147	114.76
14.80	11 601 148	59.54	11 604 148	103.14	11 607 148	66.83	11 610 148	110.41						
15.00	11 601 150	61.02	11 604 150	107.51	11 607 150	66.83	11 610 150	114.76	11 621 150	61.02	11 624 150	107.51	11 630 150	114.76
15.10			11 604 151	103.14			11 610 151	110.41						
15.25	11 601 152	59.54	11 604 152	103.14	11 607 152	66.83	11 610 152	110.41						
15.30	11 601 153	59.54	11 604 153	103.14	11 607 153	66.83	11 610 153	110.41						
15.50	11 601 155	61.02	11 604 155	107.51	11 607 155	66.83	11 610 155	114.76	11 621 155	61.02	11 624 155	107.51	11 630 155	114.76
15.60			11 604 156	103.14			11 610 156	110.41						
15.70	11 601 157	61.02	11 604 157	107.51	11 607 157	66.83	11 610 157	114.76	11 621 157	61.02	11 624 157	107.51	11 630 157	114.76
15.80	11 601 158	59.54	11 604 158	103.14	11 607 158	66.83	11 610 158	110.41						
16.00	11 601 160	61.02	11 604 160	107.51	11 607 160	66.83	11 610 160	114.76	11 621 160	61.02	11 624 160	107.51	11 630 160	114.76
16.50	11 601 165	103.14	11 604 165	172.88	11 607 165	107.51	11 610 165	183.03	11 621 165	103.14	11 624 165	172.88	11 630 165	183.03
16.80	11 601 168	100.22	11 604 168	165.61	11 607 168	107.51	11 610 168	177.24						
16.90			11 604 169	165.61			11 610 169	177.24						
17.00	11 601 170	103.14	11 604 170	172.88	11 607 170	107.51	11 610 170	183.03	11 621 170	103.14	11 624 170	172.88	11 630 170	183.03
17.50	11 601 175	103.14	11 604 175	172.88	11 607 175	107.51	11 610 175	183.03	11 621 175	103.14	11 624 175	172.88	11 630 175	183.03
17.60			11 604 176	165.61			11 610 176	177.24						
17.80	11 601 178	100.22	11 604 178	165.61	11 607 178	107.51	11 610 178	177.24						
18.00	11 601 180	103.14	11 604 180	172.88	11 607 180	107.51	11 610 180	183.03	11 621 180	103.14	11 624 180	172.88	11 630 180	183.03
18.50	11 601 185	114.76	11 604 185	188.86	11 607 185	116.21	11 610 185	199.01	11 621 185	114.76	11 624 185	188.86	11 630 185	199.01
18.80	11 601 188	108.95	11 604 188	180.14	11 607 188	116.21	11 610 188	191.76						
18.90			11 604 189	180.14			11 610 189	191.76						
19.00	11 601 190	114.76	11 604 190	188.86	11 607 190	116.21	11 610 190	199.01	11 621 190	114.76	11 624 190	188.86	11 630 190	199.01
19.50	11 601 195	114.76	11 604 195	188.86	11 607 195	116.21	11 610 195	199.01	11 621 195	114.76	11 624 195	188.86	11 630 195	199.01
19.60			11 604 196	180.14			11 610 196	191.76						
19.80	11 601 198	108.95	11 604 198	180.14	11 607 198	116.21	11 610 198	191.76						
20.00	11 601 200	114.76	11 604 200	188.86	11 607 200	116.21	11 610 200	199.01	11 621 200	114.76	11 624 200	188.86	11 630 200	199.01
Steel	●		●		●		●		○		○		○	
Stainless steel			○				○		●		●		●	
Cast iron	●		●		●		●		○		○		○	
Non ferrous metals	○		○		○		○		●		●		●	
Heat resistant alloys											●		●	

WPC – High Performance Drill, factory standard

UNI | TiAlN | ≤ 8xD | DIN 6537

UNI | TiAlN | ≤ 12xD | DIN 6537

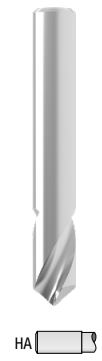
WNT \ Standard

WNT \ Standard

DC h7 mm	Article no.	£	Article no.	£
3.0	11 612 030	87.71	11 615 030	131.14
3.1	11 612 031	87.71	11 615 031	131.14
3.2	11 612 032	87.71	11 615 032	131.14
3.3	11 612 033	87.71	11 615 033	131.14
3.4	11 612 034	87.71	11 615 034	131.14
3.5	11 612 035	87.71	11 615 035	131.14
3.6	11 612 036	87.71	11 615 036	131.14
3.7	11 612 037	87.71	11 615 037	131.14
3.8	11 612 038	87.71	11 615 038	131.14
3.9	11 612 039	87.71	11 615 039	131.14
4.0	11 612 040	87.71	11 615 040	131.14
4.1	11 612 041	87.71	11 615 041	131.14
4.2	11 612 042	87.71	11 615 042	131.14
4.3	11 612 043	87.71	11 615 043	131.14
4.4	11 612 044	87.71	11 615 044	131.14
4.5	11 612 045	87.71	11 615 045	131.14
4.6	11 612 046	87.71	11 615 046	131.14
4.7	11 612 047	87.71	11 615 047	131.14
4.8	11 612 048	87.71	11 615 048	131.14
4.9	11 612 049	87.71	11 615 049	131.14
5.0	11 612 050	87.71	11 615 050	131.14
5.1	11 612 051	87.71		
5.2	11 612 052	87.71		
5.3	11 612 053	87.71		
5.5	11 612 055	87.71	11 615 055	131.14
5.8	11 612 058	87.71	11 615 058	131.14
5.9	11 612 059	87.71		
6.0	11 612 060	87.71	11 615 060	131.14
6.1	11 612 061	112.47		
6.2	11 612 062	112.47		
6.3	11 612 063	112.47	11 615 063	150.94
6.5	11 612 065	112.47	11 615 065	150.94
6.6	11 612 066	112.47	11 615 066	150.94
6.8	11 612 068	112.47	11 615 068	150.94
7.0	11 612 070	112.47	11 615 070	150.94
7.4	11 612 074	112.47		
7.5	11 612 075	112.47	11 615 075	150.94
7.7	11 612 077	112.47		
7.8	11 612 078	112.47	11 615 078	150.94
7.9	11 612 079	112.47		
8.0	11 612 080	112.47	11 615 080	150.94
8.1	11 612 081	141.40		
8.2	11 612 082	141.40	11 615 082	217.74
8.3	11 612 083	141.40		
8.5	11 612 085	141.40	11 615 085	217.74
8.6	11 612 086	141.40		
8.7	11 612 087	141.40		
8.8	11 612 088	141.40		
9.0	11 612 090	141.40	11 615 090	217.74
9.1	11 612 091	141.40		
9.2	11 612 092	141.40		
9.3	11 612 093	141.40		
9.4	11 612 094	141.40		
9.5	11 612 095	141.40	11 615 095	217.74
9.7	11 612 097	141.40		
9.8	11 612 098	141.40	11 615 098	217.74
9.9	11 612 099	141.40		
10.0	11 612 100	141.40	11 615 100	217.74
10.2	11 612 102	188.17		
10.5	11 612 105	188.17	11 615 105	300.63
10.8	11 612 108	188.17		
11.0	11 612 110	188.17	11 615 110	300.63
11.2	11 612 112	188.17		
11.5	11 612 115	188.17	11 615 115	300.63
11.8	11 612 118	188.17		
12.0	11 612 120	188.17	11 615 120	300.63
12.5	11 612 125	276.15		
13.0	11 612 130	276.15	11 615 130	377.33
13.5	11 612 135	276.15		
14.0	11 612 140	276.15	11 615 140	377.33
14.5	11 612 145	360.75		
15.0	11 612 150	360.75	11 615 150	498.57
15.5	11 612 155	360.75		
16.0	11 612 160	360.75	11 615 160	498.57
16.5	11 612 165	448.72		
17.0	11 612 170	448.72		
17.5	11 612 175	448.72		
18.0	11 612 180	448.72	11 615 180	570.32
18.5	11 612 185	499.95		
19.0	11 612 190	499.95		
20.0	11 612 200	499.95		
Steel	●		●	
Stainless steel	○		○	
Cast iron	●		●	
Non ferrous metals	○		○	
Heat resistant alloys				

NC Spot Drill, factory standard

NC-A



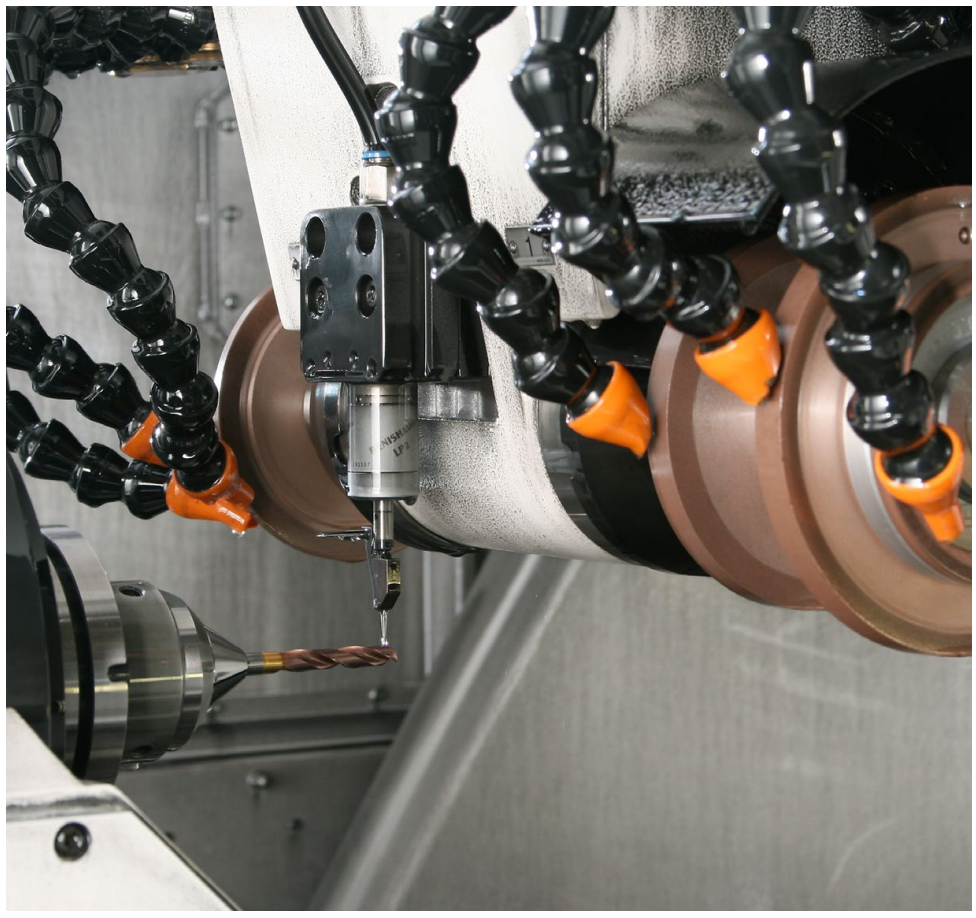
WNT \ Standard

DC h5 mm	Article no.	£
2	10 702 002	15.40
3	10 702 003	15.40
4	10 702 004	12.08
5	10 702 005	13.87
6	10 702 006	15.48
8	10 702 008	23.79
10	10 702 010	33.36
12	10 702 012	48.11
14	10 702 014	55.32
16	10 702 016	80.75
18	10 702 018	156.60
20	10 702 020	131.47
Steel	●	
Stainless steel		
Cast iron	●	
Non ferrous metals	●	
Heat resistant alloys		

New for old

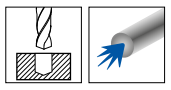
Regrind instead of buying new

Your used precision tool is in the best possible hands with us. We return your tool to you with the original finish, coating and geometry – as good as new and ready for use back in the machine.

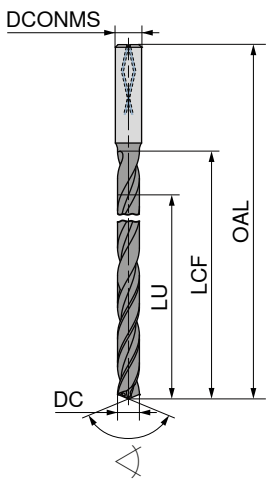


WTX – High performance deep hole drills

- Pilot hole necessary
- Excellent alignment precision
- Secure chip evacuation



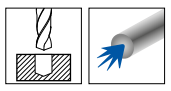
WNT \ Performance



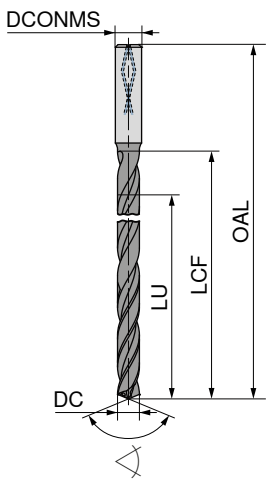
	TB 16 UNI		TB 16 ALU		TB 20 UNI		TB 20 ALU	
	TiAlN		DLC		TiAlN		DLC	
	≤ 16xD		≤ 16xD		≤ 20xD		≤ 20xD	
	HA		HA		HA		HA	
	◁ 135°		◁ 135°		◁ 135°		◁ 135°	
	Solid carbide		Solid carbide		Solid carbide		Solid carbide	
DC h7	Article no.		Article no.		Article no.		Article no.	
mm		£		£		£		£
2.0	11 016 020	100.29	11 017 020	100.29	11 020 020	106.11	11 021 020	106.11
2.2	11 016 022	100.29	11 017 022	100.29	11 020 022	102.52	11 021 022	106.11
2.3	11 016 023	100.29	11 017 023	100.29	11 020 023	106.11	11 021 023	106.11
2.4	11 016 024	111.95	11 017 024	111.95	11 020 024	114.92	11 021 024	118.94
2.5	11 016 025	111.95	11 017 025	111.95	11 020 025	118.94	11 021 025	118.94
2.7	11 016 027	111.95	11 017 027	111.95	11 020 027	114.92	11 021 027	118.94
2.8	11 016 028	111.95	11 017 028	111.95	11 020 028	118.94	11 021 028	118.94
3.0	11 016 030	142.27	11 017 030	142.27	11 020 030	153.23	11 021 030	158.59
3.2	11 016 032	142.27	11 017 032	142.27	11 020 032	158.59	11 021 032	158.59
3.3	11 016 033	142.27	11 017 033	142.27	11 020 033	153.23	11 021 033	158.59
3.5	11 016 035	142.27	11 017 035	142.27	11 020 035	158.59	11 021 035	158.59
3.8	11 016 038	148.10	11 017 038	148.10	11 020 038	159.99	11 021 038	165.58
4.0	11 016 040	148.10	11 017 040	148.10	11 020 040	165.58	11 021 040	165.58
4.2	11 016 042	159.76	11 017 042	159.76	11 020 042	171.25	11 021 042	177.25
4.5	11 016 045	159.76	11 017 045	159.76	11 020 045	177.25	11 021 045	177.25
4.8	11 016 048	169.09	11 017 048	169.09	11 020 048	181.39	11 021 048	187.75
5.0	11 016 050	169.09	11 017 050	169.09	11 020 050	187.75	11 021 050	187.75
5.5	11 016 055	176.09	11 017 055	176.09	11 020 055	189.29	11 021 055	195.92
5.8	11 016 058	176.09	11 017 058	176.09	11 020 058	195.92	11 021 058	195.92
6.0	11 016 060	176.09	11 017 060	176.09	11 020 060	195.92	11 021 060	195.92
6.5	11 016 065	187.75	11 017 065	187.75	11 020 065	208.74	11 021 065	208.74
6.8	11 016 068	201.75	11 017 068	201.75	11 020 068	225.07	11 021 068	225.07
7.0	11 016 070	201.75	11 017 070	201.75	11 020 070	225.07	11 021 070	225.07
7.5	11 016 075	226.24	11 017 075	226.24	11 020 075	250.72	11 021 075	250.72
7.8	11 016 078	226.24	11 017 078	226.24	11 020 078	250.72	11 021 078	250.72
8.0	11 016 080	226.24	11 017 080	226.24	11 020 080	250.72	11 021 080	250.72
8.5	11 016 085	249.55	11 017 085	249.55	11 020 085	276.37	11 021 085	276.37
8.8	11 016 088	277.55	11 017 088	277.55	11 020 088	310.19	11 021 088	310.19
9.0	11 016 090	277.55	11 017 090	277.55	11 020 090	310.19	11 021 090	310.19
9.8	11 016 098	277.55	11 017 098	277.55	11 020 098	310.19	11 021 098	310.19
10.0	11 016 100	277.55	11 017 100	277.55	11 020 100	310.19	11 021 100	310.19
10.2	11 016 102	310.19	11 017 102	310.19	11 020 102	340.51	11 021 102	340.51
10.8	11 016 108	310.19	11 017 108	299.71	11 020 108	340.51	11 021 108	340.51
11.8	11 016 118	310.19	11 017 118	310.19	11 020 118	340.51	11 021 118	340.51
12.0	11 016 120	310.19	11 017 120	299.71	11 020 120	340.51	11 021 120	340.51
Steel	●				●			
Stainless steel	●				●			
Cast iron	●				●			
Non ferrous metals			●				●	
Heat resistant alloys								

WTX – High performance deep hole drills

- Pilot hole necessary
- Excellent alignment precision
- Secure chip evacuation



WNT \ Performance



	TB 25 UNI	TB 25 ALU	TB 30 UNI	TB 30 ALU	TB 40 UNI	TB 50 UNI
	TiAlN	DLC	TiAlN	DLC	TiAlN	TiAlN
	≤ 25xD	≤ 25xD	≤ 30xD	≤ 30xD	≤ 40xD	≤ 50xD






HA 135° Solid carbide

DC fg6/h7 mm	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£
2.0	11 025 020	113.12	11 026 020	113.12	11 030 020	120.12	11 031 020	120.12				
2.2	11 025 022	113.12	11 026 022	113.12	11 030 022	120.12	11 031 022	120.12				
2.3	11 025 023	113.12	11 026 023	113.12	11 030 023	120.12	11 031 023	120.12				
2.4	11 025 024	128.28	11 026 024	128.28	11 030 024	139.94	11 031 024	139.94				
2.5	11 025 025	128.28	11 026 025	128.28	11 030 025	139.94	11 031 025	139.94				
2.7	11 025 027	128.28	11 026 027	128.28	11 030 027	139.94	11 031 027	139.94				
2.8	11 025 028	128.28	11 026 028	128.28	11 030 028	139.94	11 031 028	139.94				
3.0	11 025 030	184.25	11 026 030	184.25	11 030 030	235.56	11 031 030	235.56	11 040 030	299.69	11 050 030	406.99
3.2	11 025 032	184.25	11 026 032	184.25	11 030 032	235.56	11 031 032	235.56				
3.3	11 025 033	204.07	11 026 033	202.92	11 030 033	242.57	11 031 033	242.57				
3.5	11 025 035	204.07	11 026 035	202.92	11 030 035	242.57	11 031 035	242.57				
3.8	11 025 038	209.90	11 026 038	209.90	11 030 038	242.57	11 031 038	242.57				
4.0	11 025 040	209.90	11 026 040	209.90	11 030 040	242.57	11 031 040	242.57	11 040 040	299.69	11 050 040	406.99
4.2	11 025 042	209.90	11 026 042	209.90	11 030 042	242.57	11 031 042	242.57	11 040 042	331.19	11 050 042	452.46
4.5	11 025 045	219.24	11 026 045	219.24	11 030 045	249.55	11 031 045	249.55	11 040 045	331.19	11 050 045	452.46
4.8	11 025 048	219.24	11 026 048	219.24	11 030 048	249.55	11 031 048	249.55	11 040 048	353.34	11 050 048	510.77
5.0	11 025 050	219.24	11 026 050	219.24	11 030 050	249.55	11 031 050	249.55	11 040 050	353.34	11 050 050	510.77
5.5	11 025 055	235.56	11 026 055	235.56	11 030 055	261.22	11 031 055	261.22	11 040 055	380.16	11 050 055	574.91
5.8	11 025 058	235.56	11 026 058	235.56	11 030 058	261.22	11 031 058	261.22	11 040 058	380.16	11 050 058	583.08
6.0	11 025 060	235.56	11 026 060	235.56	11 030 060	261.22	11 031 060	261.22	11 040 060	380.16	11 050 060	583.08
6.5	11 025 065	262.39	11 026 065	262.39	11 030 065	286.87	11 031 065	286.87	11 040 065	409.32	11 050 065	648.38
6.8	11 025 068	262.39	11 026 068	262.39	11 030 068	299.69	11 031 068	299.69	11 040 068	409.32	11 050 068	703.19
7.0	11 025 070	262.39	11 026 070	262.39	11 030 070	299.69	11 031 070	299.69	11 040 070	409.32		
7.5	11 025 075	291.54	11 026 075	291.54	11 030 075	299.69	11 031 075	299.69	11 040 075	454.79		
7.8	11 025 078	291.54	11 026 078	291.54	11 030 078	333.51	11 031 078	333.51	11 040 078	454.79		
8.0	11 025 080	291.54	11 026 080	291.54	11 030 080	333.51	11 031 080	333.51	11 040 080	454.79		
8.5	11 025 085	328.84	11 026 085	328.84	11 030 085	384.84	11 031 085	384.84	11 040 085	501.44		
8.8	11 025 088	356.84	11 026 088	356.84	11 030 088	404.65	11 031 088	404.65	11 040 088	501.44		
9.0	11 025 090	356.84	11 026 090	356.84	11 030 090	404.65	11 031 090	404.65	11 040 090	501.44		
9.8	11 025 098	356.84	11 026 098	356.84	11 030 098	404.65	11 031 098	404.65				
10.0	11 025 100	356.84	11 026 100	356.84	11 030 100	404.65	11 031 100	404.65				
10.2	11 025 102	429.15	11 026 102	429.15	11 030 102	516.61	11 031 102	516.61				
10.8	11 025 108	429.15	11 026 108	429.15	11 030 108	516.61	11 031 108	516.61				
11.8	11 025 118	429.15	11 026 118	429.15	11 030 118	516.61	11 031 118	516.61				
12.0	11 025 120	429.15	11 026 120	429.15	11 030 120	516.61	11 031 120	516.61				

Steel	●		●		●	●
Stainless steel	●		●		●	●
Cast iron	●		●		●	●
Non ferrous metals		●		●		
Heat resistant alloys						

Technical support: 0800 073 2 075
3 time served engineers, available from 8:00 am to 6:30 pm, Monday to Friday

Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

Indexable Insert Drilling

MaxiDrill 900

The specialist for high productivity in rough machining

- provides perfect drilling quality even under enormous loads
- ideal for large drilling depths: The high feed rates increase productivity
- for stable machining situations

Drilling guide (Main catalogue 2019)

Cutting data	39–50	Coding example	54
Maximum adjustment range	51–53	Grade description	56+57

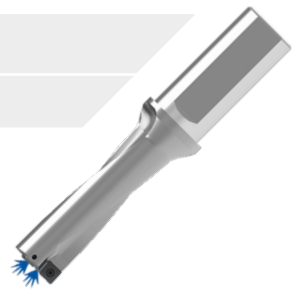
MaxiDrill Classic

The drilling tool for universal application

- ideal for use on machines with limited power
- suitable for use under unstable conditions

KUB Pentron

The specialist for large hole depths



- the all-rounder for process-secure drilling under a wide variety of conditions
- ideal for extreme machining situations

KUB 100

Ideal for robust machining situations

- the high performance all-rounder for outstanding productivity and reliability
- offers consistent hole quality and a constant diameter across all materials and feed rates

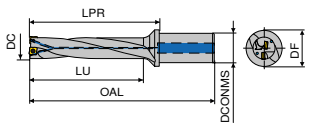
KUB Trigon

The solution for unstable conditions and high accuracy

- ideal for machining under unstable conditions
- well-suited to machining on less powerful machines
- the first choice for creating dimensionally accurate holes

MaxiDrill 900

Scope of supply:
Indexable Insert Drill including clamping screws and key



≤ 2xD

KOMET \ Performance

Designation	DC	DF	DCONMS	OAL	LU	LPR	Insert	Article no.	
	mm	mm	mm	mm	mm	mm			£
MD900.2D.120.R.03-C20	12.0	28	20	90	24	40	SONT 031804	10 852 120	155.15
MD900.2D.125.R.03-C20	12.5	28	20	91	25	41	SONT 031804	10 852 125	155.15
MD900.2D.130.R.03-C20	13.0	28	20	92	26	42	SONT 031804	10 852 130	155.15
MD900.2D.135.R.03-C20	13.5	28	20	93	27	43	SONT 031804	10 852 135	155.15
MD900.2D.140.R.04-C20	14.0	30	20	96	28	46	SONT 042105	10 852 140	165.14
MD900.2D.145.R.04-C20	14.5	30	20	97	29	47	SONT 042105	10 852 145	165.14
MD900.2D.150.R.04-C20	15.0	30	20	98	30	48	SONT 042105	10 852 150	165.14
MD900.2D.155.R.04-C20	15.5	30	20	99	31	49	SONT 042105	10 852 155	165.14
MD900.2D.160.R.05-C20	16.0	30	20	100	32	50	SONT 052306	10 852 160	165.14
MD900.2D.165.R.05-C20	16.5	30	20	101	33	51	SONT 052306	10 852 165	165.14
MD900.2D.170.R.05-C20	17.0	30	20	102	34	52	SONT 052306	10 852 170	175.76
MD900.2D.175.R.05-C20	17.5	30	20	103	35	53	SONT 052306	10 852 175	175.76
MD900.2D.180.R.06-C25	18.0	32	25	111	36	55	SONT 062506	10 852 180	175.76
MD900.2D.185.R.06-C25	18.5	32	25	112	37	56	SONT 062506	10 852 185	175.76
MD900.2D.190.R.06-C25	19.0	32	25	113	38	57	SONT 062506	10 852 190	188.87
MD900.2D.195.R.06-C25	19.5	32	25	114	39	58	SONT 062506	10 852 195	188.87
MD900.2D.200.R.06-C25	20.0	32	25	115	40	59	SONT 062506	10 852 200	188.87
MD900.2D.205.R.06-C25	20.5	32	25	116	41	60	SONT 062506	10 852 205	188.87
MD900.2D.210.R.07-C25	21.0	32	25	118	42	62	SONT 072907	10 852 210	188.87
MD900.2D.220.R.07-C25	22.0	32	25	120	44	64	SONT 072907	10 852 220	188.87
MD900.2D.230.R.07-C25	23.0	32	25	122	46	66	SONT 072907	10 852 230	194.79
MD900.2D.240.R.08-C32	24.0	40	32	132	48	72	SONT 083308	10 852 240	194.79
MD900.2D.250.R.08-C32	25.0	40	32	134	50	74	SONT 083308	10 852 250	194.79
MD900.2D.260.R.08-C32	26.0	40	32	136	52	76	SONT 083308	10 852 260	215.66
MD900.2D.270.R.08-C32	27.0	40	32	138	54	78	SONT 083308	10 852 270	215.66
MD900.2D.280.R.09-C32	28.0	40	32	140	56	80	SONT 093808	10 852 280	215.66
MD900.2D.290.R.09-C32	29.0	40	32	142	58	82	SONT 093808	10 852 290	215.66
MD900.2D.300.R.09-C32	30.0	40	32	144	60	84	SONT 093808	10 852 300	215.66
MD900.2D.310.R.09-C32	31.0	40	32	146	62	86	SONT 093808	10 852 310	233.93
MD900.2D.320.R.09-C32	32.0	40	32	148	64	88	SONT 093808	10 852 320	233.93
MD900.2D.330.R.10-C40	33.0	50	40	163	66	93	SONT 104408	10 852 330	233.93
MD900.2D.340.R.10-C40	34.0	50	40	165	68	95	SONT 104408	10 852 340	233.93

Designation	DC	DF	DCONMS	OAL	LU	LPR	Insert	Article no.	
	mm	mm	mm	mm	mm	mm			£
MD900.2D.350.R.10-C40	35.0	50	40	167	70	97	SONT 104408	10 852 350	239.21
MD900.2D.360.R.10-C40	36.0	50	40	169	72	99	SONT 104408	10 852 360	239.21
MD900.2D.370.R.12-C40	37.0	56	40	174	74	104	SONT 124810	10 852 370	246.97
MD900.2D.380.R.12-C40	38.0	56	40	176	76	106	SONT 124810	10 852 380	246.97
MD900.2D.390.R.12-C40	39.0	56	40	178	78	108	SONT 124810	10 852 390	246.97
MD900.2D.400.R.12-C40	40.0	56	40	180	80	110	SONT 124810	10 852 400	246.97
MD900.2D.410.R.12-C40	41.0	56	40	182	82	112	SONT 124810	10 852 410	246.97
MD900.2D.420.R.13-C40	42.0	60	40	187	84	117	SONT 135012	10 852 420	259.45
MD900.2D.430.R.13-C40	43.0	60	40	189	86	119	SONT 135012	10 852 430	259.45
MD900.2D.440.R.13-C40	44.0	60	40	191	88	121	SONT 135012	10 852 440	259.45
MD900.2D.450.R.13-C40	45.0	60	40	193	90	123	SONT 135012	10 852 450	259.45
MD900.2D.460.R.13-C40	46.0	60	40	195	92	125	SONT 135012	10 852 460	259.45
MD900.2D.470.R.15-C40	47.0	60	40	198	94	128	SONT 155312	10 852 470	272.55
MD900.2D.480.R.15-C40	48.0	60	40	200	96	130	SONT 155312	10 852 480	272.55
MD900.2D.490.R.15-C40	49.0	60	40	202	98	132	SONT 155312	10 852 490	294.06
MD900.2D.500.R.15-C40	50.0	60	40	204	100	134	SONT 155312	10 852 500	294.06
MD900.2D.510.R.15-C40	52.0	60	40	208	104	138	SONT 155312	10 852 520	301.95
MD900.2D.520.R.15-C40	51.0	60	40	206	102	136	SONT 155312	10 852 510	301.95
MD900.2D.530.R.15-C40	53.0	60	40	210	106	140	SONT 155312	10 852 530	301.95
MD900.2D.540.R.15-C40	54.0	60	40	212	108	142	SONT 155312	10 852 540	301.95
MD900.2D.550.R.17-C40	55.0	60	40	215	110	145	SONT 175612	10 852 550	301.95
MD900.2D.560.R.17-C40	56.0	60	40	217	112	147	SONT 175612	10 852 560	313.03
MD900.2D.570.R.17-C40	57.0	60	40	219	114	149	SONT 175612	10 852 570	313.03
MD900.2D.580.R.17-C40	58.0	60	40	221	116	151	SONT 175612	10 852 580	313.03
MD900.2D.590.R.17-C40	59.0	60	40	223	118	153	SONT 175612	10 852 590	313.03
MD900.2D.600.R.17-C40	60.0	62	40	225	120	155	SONT 175612	10 852 600	313.03
MD900.2D.610.R.17-C40	61.0	62	40	227	122	157	SONT 175612	10 852 610	313.03
MD900.2D.620.R.17-C40	62.0	64	40	229	124	159	SONT 175612	10 852 620	313.03
MD900.2D.630.R.17-C40	63.0	64	40	231	126	161	SONT 175612	10 852 630	313.03

Key D

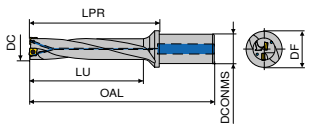
Clamping screw

Spare parts DC		Article no. £			Article no. £	
12 - 13,5	T06 - IP	7.52	80 950 123	M1,8x3,6 - IP	2.85	70 950 862
14 - 17,5	T06 - IP	7.52	80 950 123	M2x4,3 - IP	2.53	70 950 863
18 - 23	T07 - IP	7.42	80 950 124	M2,2x5 - IP	2.46	70 950 856
24 - 27	T08 - IP	7.42	80 950 125	M2,5x6 - IP	3.16	70 950 857
28 - 32	T09 - IP	8.12	80 950 126	M3x7 - IP	2.42	70 950 819
33 - 41	T15 - IP	8.67	80 950 128	M3,5x8,6 - IP	2.42	70 950 859
42 - 63	T20 - IP	9.11	80 950 129	M4,5x10,5 - IP	2.42	70 950 864

MaxiDrill 900

Scope of supply:

Indexable Insert Drill including clamping screws and key



≤ 3xD

KOMET \ Performance

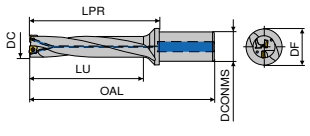
Designation	DC	DF	DCONMS	OAL	LU	LPR	Insert	Article no.	
	mm	mm	mm	mm	mm	mm			£
MD900.3D.120.R.03-C20	12.0	28	20	102	36.0	52	SONT 031804	10 853 120	165.26
MD900.3D.125.R.03-C20	12.5	28	20	104	37.5	54	SONT 031804	10 853 125	165.26
MD900.3D.130.R.03-C20	13.0	28	20	105	39.0	55	SONT 031804	10 853 130	165.26
MD900.3D.135.R.03-C20	13.5	28	20	107	40.5	57	SONT 031804	10 853 135	165.26
MD900.3D.140.R.04-C20	14.0	30	20	109	42.0	59	SONT 042105	10 853 140	174.05
MD900.3D.145.R.04-C20	14.5	30	20	111	44.0	61	SONT 042105	10 853 145	174.05
MD900.3D.150.R.04-C20	15.0	30	20	112	45.0	62	SONT 042105	10 853 150	174.05
MD900.3D.155.R.04-C20	15.5	30	20	114	47.0	64	SONT 042105	10 853 155	178.19
MD900.3D.160.R.05-C20	16.0	30	20	115	48.0	65	SONT 052306	10 853 160	178.19
MD900.3D.165.R.05-C20	16.5	30	20	117	50.0	67	SONT 052306	10 853 165	178.19
MD900.3D.170.R.05-C20	17.0	30	20	118	51.0	68	SONT 052306	10 853 170	185.05
MD900.3D.175.R.05-C20	17.5	30	20	120	53.0	70	SONT 052306	10 853 175	185.05
MD900.3D.180.R.06-C25	18.0	32	25	128	54.0	72	SONT 062506	10 853 180	185.05
MD900.3D.185.R.06-C25	18.5	32	25	130	56.0	74	SONT 062506	10 853 185	185.05
MD900.3D.190.R.06-C25	19.0	32	25	131	57.0	75	SONT 062506	10 853 190	198.80
MD900.3D.195.R.06-C25	19.5	32	25	133	59.0	77	SONT 062506	10 853 195	198.80
MD900.3D.200.R.06-C25	20.0	32	25	134	60.0	78	SONT 062506	10 853 200	198.80
MD900.3D.205.R.06-C25	20.5	32	25	136	62.0	80	SONT 062506	10 853 205	198.80
MD900.3D.210.R.07-C25	21.0	32	25	138	63.0	82	SONT 072907	10 853 210	198.80
MD900.3D.215.R.07-C25	21.5	32	25	140	65.0	84	SONT 072907	10 853 215	198.80
MD900.3D.220.R.07-C25	22.0	32	25	141	66.0	85	SONT 072907	10 853 220	198.80
MD900.3D.225.R.07-C25	22.5	32	25	143	68.0	87	SONT 072907	10 853 225	204.97
MD900.3D.230.R.07-C25	23.0	32	25	144	69.0	88	SONT 072907	10 853 230	204.97
MD900.3D.235.R.07-C25	23.5	32	25	146	71.0	90	SONT 072907	10 853 235	204.97
MD900.3D.240.R.08-C32	24.0	40	32	155	72.0	95	SONT 083308	10 853 240	204.97
MD900.3D.245.R.08-C32	24.5	40	32	157	74.0	97	SONT 083308	10 853 245	204.97
MD900.3D.250.R.08-C32	25.0	40	32	158	75.0	98	SONT 083308	10 853 250	204.97
MD900.3D.255.R.08-C32	25.5	40	32	160	77.0	100	SONT 083308	10 853 255	204.97
MD900.3D.260.R.08-C32	26.0	40	32	161	78.0	101	SONT 083308	10 853 260	226.99
MD900.3D.265.R.08-C32	26.5	40	32	163	80.0	103	SONT 083308	10 853 265	226.99
MD900.3D.270.R.08-C32	27.0	40	32	164	81.0	104	SONT 083308	10 853 270	226.99
MD900.3D.275.R.08-C32	27.5	40	32	166	83.0	106	SONT 083308	10 853 275	226.99
MD900.3D.280.R.09-C32	28.0	40	32	167	84.0	107	SONT 093808	10 853 280	226.99
MD900.3D.285.R.09-C32	28.5	40	32	169	86.0	109	SONT 093808	10 853 285	226.99
MD900.3D.290.R.09-C32	29.0	40	32	170	87.0	110	SONT 093808	10 853 290	226.99
MD900.3D.295.R.09-C32	29.5	40	32	172	89.0	112	SONT 093808	10 853 295	226.99
MD900.3D.300.R.09-C32	30.0	40	32	173	90.0	113	SONT 093808	10 853 300	226.99
MD900.3D.305.R.09-C32	30.5	40	32	175	92.0	115	SONT 093808	10 853 305	226.99
MD900.3D.310.R.09-C32	31.0	40	32	176	93.0	116	SONT 093808	10 853 310	246.27
MD900.3D.315.R.09-C32	31.5	40	32	178	95.0	118	SONT 093808	10 853 315	246.27

Designation	DC	DF	DCONMS	OAL	LU	LPR	Insert	Article no.	
	mm	mm	mm	mm	mm	mm			£
MD900.3D.320.R.09-C32	32.0	40	32	179	96.0	119	SONT 093808	10 853 320	246.27
MD900.3D.325.R.10-C40	32.5	50	40	192	98.0	124	SONT 104408	10 853 325	246.27
MD900.3D.330.R.10-C40	33.0	50	40	193	99.0	125	SONT 104408	10 853 330	246.27
MD900.3D.335.R.10-C40	33.5	50	40	195	101.0	127	SONT 104408	10 853 335	246.27
MD900.3D.340.R.10-C40	34.0	50	40	196	102.0	128	SONT 104408	10 853 340	246.27
MD900.3D.345.R.10-C40	34.5	50	40	198	104.0	130	SONT 104408	10 853 345	246.27
MD900.3D.350.R.10-C40	35.0	50	40	199	105.0	131	SONT 104408	10 853 350	251.75
MD900.3D.355.R.10-C40	35.5	50	40	201	107.0	133	SONT 104408	10 853 355	251.75
MD900.3D.360.R.10-C40	36.0	50	40	202	108.0	134	SONT 104408	10 853 360	251.75
MD900.3D.365.R.10-C40	36.5	50	40	204	110.0	136	SONT 104408	10 853 365	251.75
MD900.3D.370.R.12-C40	37.0	56	40	211	111.0	141	SONT 124810	10 853 370	260.02
MD900.3D.380.R.12-C40	38.0	56	40	214	114.0	144	SONT 124810	10 853 380	260.02
MD900.3D.390.R.12-C40	39.0	56	40	217	117.0	147	SONT 124810	10 853 390	260.02
MD900.3D.400.R.12-C40	40.0	56	40	220	120.0	150	SONT 124810	10 853 400	260.02
MD900.3D.410.R.12-C40	41.0	56	40	223	123.0	153	SONT 124810	10 853 410	260.02
MD900.3D.420.R.13-C40	42.0	60	40	229	126.0	159	SONT 135012	10 853 420	273.06
MD900.3D.430.R.13-C40	43.0	60	40	232	129.0	162	SONT 135012	10 853 430	273.06
MD900.3D.440.R.13-C40	44.0	60	40	235	132.0	165	SONT 135012	10 853 440	273.06
MD900.3D.450.R.13-C40	45.0	60	40	238	135.0	168	SONT 135012	10 853 450	273.06
MD900.3D.460.R.13-C40	46.0	60	40	241	138.0	171	SONT 135012	10 853 460	273.06
MD900.3D.470.R.15-C40	47.0	60	40	245	141.0	175	SONT 155312	10 853 470	286.81
MD900.3D.480.R.15-C40	48.0	60	40	248	144.0	178	SONT 155312	10 853 480	286.81
MD900.3D.490.R.15-C40	49.0	60	40	251	147.0	181	SONT 155312	10 853 490	309.53
MD900.3D.500.R.15-C40	50.0	60	40	254	150.0	184	SONT 155312	10 853 500	309.53
MD900.3D.510.R.15-C40	51.0	60	40	257	153.0	187	SONT 155312	10 853 510	317.80
MD900.3D.520.R.15-C40	52.0	60	40	260	156.0	190	SONT 155312	10 853 520	317.80
MD900.3D.530.R.15-C40	53.0	60	40	263	159.0	193	SONT 155312	10 853 530	317.80
MD900.3D.540.R.15-C40	54.0	60	40	266	162.0	196	SONT 155312	10 853 540	317.80
MD900.3D.550.R.17-C40	55.0	60	40	270	165.0	200	SONT 175612	10 853 550	317.80
MD900.3D.560.R.17-C40	56.0	60	40	273	168.0	203	SONT 175612	10 853 560	329.51
MD900.3D.570.R.17-C40	57.0	60	40	276	171.0	206	SONT 175612	10 853 570	329.51
MD900.3D.580.R.17-C40	58.0	60	40	279	174.0	209	SONT 175612	10 853 580	329.51
MD900.3D.590.R.17-C40	59.0	60	40	282	177.0	212	SONT 175612	10 853 590	329.51
MD900.3D.600.R.17-C40	60.0	62	40	285	180.0	215	SONT 175612	10 853 600	329.51
MD900.3D.610.R.17-C40	61.0	62	40	288	183.0	218	SONT 175612	10 853 610	329.51
MD900.3D.620.R.17-C40	62.0	64	40	291	186.0	221	SONT 175612	10 853 620	329.51
MD900.3D.630.R.17-C40	63.0	64	40	294	189.0	224	SONT 175612	10 853 630	329.51

MaxiDrill 900

Scope of supply:

Indexable Insert Drill including clamping screws and key



≤ 4xD

KOMET \ Performance

Designation	DC	DF	DCONMS	OAL	LU	LPR	Insert	Article no.	
	mm	mm	mm	mm	mm	mm			£
MD900.4D.120.R.03-C20	12	28	20	114	48	64	SONT 031804	10 854 120	227.95
MD900.4D.130.R.03-C20	13	28	20	118	52	68	SONT 031804	10 854 130	227.95
MD900.4D.140.R.04-C20	14	30	20	123	56	73	SONT 042105	10 854 140	234.56
MD900.4D.150.R.04-C20	15	30	20	127	60	77	SONT 042105	10 854 150	234.56
MD900.4D.160.R.05-C20	16	30	20	131	64	81	SONT 052306	10 854 160	240.04
MD900.4D.170.R.05-C20	17	30	20	135	68	85	SONT 052306	10 854 170	249.07
MD900.4D.180.R.06-C25	18	32	25	146	72	90	SONT 062506	10 854 180	249.07
MD900.4D.190.R.06-C25	19	32	25	150	76	94	SONT 062506	10 854 190	267.59
MD900.4D.200.R.06-C25	20	32	25	154	80	98	SONT 062506	10 854 200	267.59
MD900.4D.210.R.07-C25	21	32	25	159	84	103	SONT 072907	10 854 210	267.59
MD900.4D.220.R.07-C25	22	32	25	163	88	107	SONT 072907	10 854 220	267.59
MD900.4D.230.R.07-C25	23	32	25	167	92	111	SONT 072907	10 854 230	276.50
MD900.4D.240.R.08-C32	24	40	32	179	96	119	SONT 083308	10 854 240	276.50
MD900.4D.250.R.08-C32	25	40	32	183	100	123	SONT 083308	10 854 250	276.50
MD900.4D.260.R.08-C32	26	40	32	187	104	127	SONT 083308	10 854 260	305.45
MD900.4D.270.R.08-C32	27	40	32	191	108	131	SONT 083308	10 854 270	305.45
MD900.4D.280.R.09-C32	28	40	32	195	112	135	SONT 093808	10 854 280	305.45
MD900.4D.290.R.09-C32	29	40	32	199	116	139	SONT 093808	10 854 290	305.45
MD900.4D.300.R.09-C32	30	40	32	203	120	143	SONT 093808	10 854 300	305.45
MD900.4D.310.R.09-C32	31	40	32	207	124	147	SONT 093808	10 854 310	331.55
MD900.4D.320.R.09-C32	32	40	32	211	128	151	SONT 093808	10 854 320	331.55
MD900.4D.330.R.10-C40	33	50	40	228	132	158	SONT 104408	10 854 330	331.55
MD900.4D.340.R.10-C40	34	50	40	232	136	162	SONT 104408	10 854 340	331.55
MD900.4D.350.R.10-C40	35	50	40	236	140	166	SONT 104408	10 854 350	338.49

Designation	DC	DF	DCONMS	OAL	LU	LPR	Insert	Article no.	
	mm	mm	mm	mm	mm	mm			£
MD900.4D.360.R.10-C40	36	50	40	240	144	170	SONT 104408	10 854 360	338.49
MD900.4D.370.R.12-C40	37	56	40	248	148	178	SONT 124810	10 854 370	350.13
MD900.4D.380.R.12-C40	38	56	40	252	152	182	SONT 124810	10 854 380	350.13
MD900.4D.390.R.12-C40	39	56	40	256	156	186	SONT 124810	10 854 390	350.13
MD900.4D.400.R.12-C40	40	56	40	260	160	190	SONT 124810	10 854 400	350.13
MD900.4D.410.R.12-C40	41	56	40	264	164	194	SONT 124810	10 854 410	350.13
MD900.4D.420.R.13-C40	42	60	40	271	168	201	SONT 135012	10 854 420	367.31
MD900.4D.430.R.13-C40	43	60	40	275	172	205	SONT 135012	10 854 430	367.31
MD900.4D.440.R.13-C40	44	60	40	279	176	209	SONT 135012	10 854 440	367.31
MD900.4D.450.R.13-C40	45	60	40	283	180	213	SONT 135012	10 854 450	367.31
MD900.4D.460.R.13-C40	46	60	40	287	184	217	SONT 135012	10 854 460	367.31
MD900.4D.470.R.15-C40	47	60	40	292	188	222	SONT 155312	10 854 470	387.29
MD900.4D.480.R.15-C40	48	60	40	296	192	226	SONT 155312	10 854 480	387.29
MD900.4D.490.R.15-C40	49	60	40	300	196	230	SONT 155312	10 854 490	387.29
MD900.4D.500.R.15-C40	50	60	40	304	200	234	SONT 155312	10 854 500	387.29
MD900.4D.510.R.15-C40	51	60	40	308	204	238	SONT 155312	10 854 510	387.29
MD900.4D.520.R.15-C40	52	60	40	312	208	242	SONT 155312	10 854 520	387.29
MD900.4D.530.R.15-C40	53	60	40	316	212	246	SONT 155312	10 854 530	387.29
MD900.4D.540.R.15-C40	54	60	40	320	216	250	SONT 155312	10 854 540	387.29

Key D

Clamping screw

Spare parts DC	Key D	Article no.		Clamping screw	Article no.	
		£			£	
12 - 13,5	T06 - IP	7.52	80 950 123	M1,8x3,6 - IP	2.85	70 950 862
14 - 17,5	T06 - IP	7.52	80 950 123	M2x4,3 - IP	2.53	70 950 863
18 - 23,5	T07 - IP	7.42	80 950 124	M2,2x5 - IP	2.46	70 950 856
24 - 27,5	T08 - IP	7.42	80 950 125	M2,5x6 - IP	3.16	70 950 857
28 - 32	T09 - IP	8.12	80 950 126	M3x7 - IP	2.42	70 950 819
32,5 - 41	T15 - IP	8.67	80 950 128	M3,5x8,6 - IP	2.42	70 950 859
42 - 63	T20 - IP	9.11	80 950 129	M4,5x10,5 - IP	2.42	70 950 864

Technical support: 0800 073 2 075

3 time served engineers, available from 8:00 am to 6:30 pm, Monday to Friday

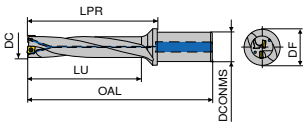
Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

MaxiDrill 900

Scope of supply:
Indexable Insert Drill including clamping screws and key



≤ 5xD

KOMET \ Performance

Designation	DC	DF	DCONMS	OAL	LU	LPR	Insert	Article no.	
	mm	mm	mm	mm	mm	mm			£
MD900.5D.120.R.03-C20	12	28	20	126	60	76	SONT 031804	10 855 120	272.49
MD900.5D.130.R.03-C20	13	28	20	131	65	81	SONT 031804	10 855 130	272.49
MD900.5D.140.R.04-C20	14	30	20	137	70	87	SONT 042105	10 855 140	278.60
MD900.5D.150.R.04-C20	15	30	20	142	75	92	SONT 042105	10 855 150	278.60
MD900.5D.160.R.05-C20	16	30	20	147	80	97	SONT 052306	10 855 160	285.47
MD900.5D.170.R.05-C20	17	30	20	152	85	102	SONT 052306	10 855 170	295.79
MD900.5D.180.R.06-C25	18	32	25	164	90	108	SONT 062506	10 855 180	295.79
MD900.5D.190.R.06-C25	19	32	25	169	95	113	SONT 062506	10 855 190	317.80
MD900.5D.200.R.06-C25	20	32	25	174	100	118	SONT 062506	10 855 200	317.80
MD900.5D.210.R.07-C25	21	32	25	180	105	124	SONT 072907	10 855 210	317.80
MD900.5D.220.R.07-C25	22	32	25	184	110	128	SONT 072907	10 855 220	317.80
MD900.5D.230.R.07-C25	23	32	25	189	115	133	SONT 072907	10 855 230	329.13
MD900.5D.240.R.08-C32	24	40	32	203	120	143	SONT 083308	10 855 240	329.13
MD900.5D.250.R.08-C32	25	40	32	208	125	148	SONT 083308	10 855 250	329.13
MD900.5D.260.R.08-C32	26	40	32	212	130	152	SONT 083308	10 855 260	363.24

Designation	DC	DF	DCONMS	OAL	LU	LPR	Insert	Article no.	
	mm	mm	mm	mm	mm	mm			£
MD900.5D.270.R.08-C32	27	40	32	217	135	157	SONT 083308	10 855 270	363.24
MD900.5D.280.R.09-C32	28	40	32	221	140	161	SONT 093808	10 855 280	363.24
MD900.5D.290.R.09-C32	29	40	32	226	145	166	SONT 093808	10 855 290	363.24
MD900.5D.300.R.09-C32	30	40	32	230	150	170	SONT 093808	10 855 300	363.24
MD900.5D.310.R.09-C32	31	40	32	235	155	175	SONT 093808	10 855 310	393.46
MD900.5D.320.R.09-C32	32	40	32	239	160	179	SONT 093808	10 855 320	393.46
MD900.5D.330.R.10-C40	33	50	40	259	165	191	SONT 104408	10 855 330	393.46
MD900.5D.340.R.10-C40	34	50	40	264	170	196	SONT 104408	10 855 340	393.46
MD900.5D.350.R.10-C40	35	50	40	269	175	201	SONT 104408	10 855 350	402.37
MD900.5D.360.R.10-C40	36	50	40	274	180	206	SONT 104408	10 855 360	402.37
MD900.5D.370.R.12-C40	37	56	40	285	185	215	SONT 124810	10 855 370	416.19
MD900.5D.380.R.12-C40	38	56	40	290	190	220	SONT 124810	10 855 380	416.19
MD900.5D.390.R.12-C40	39	56	40	295	195	225	SONT 124810	10 855 390	416.19
MD900.5D.400.R.12-C40	40	56	40	300	200	230	SONT 124810	10 855 400	416.19
MD900.5D.410.R.12-C40	41	56	40	305	205	235	SONT 124810	10 855 410	416.19

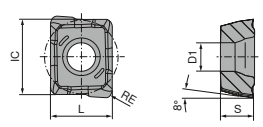
Key D


Clamping screw

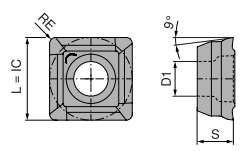
Spare parts DC		Article no.			Article no.	
		£			£	
12 - 13	T06 - IP	7.52	80 950 123	M1,8x3,6 - IP	2.85	70 950 862
14 - 17	T06 - IP	7.52	80 950 123	M2x4,3 - IP	2.53	70 950 863
18 - 23	T07 - IP	7.42	80 950 124	M2,2x5 - IP	2.46	70 950 856
24 - 27	T08 - IP	7.42	80 950 125	M2,5x6 - IP	3.16	70 950 857
28 - 32	T09 - IP	8.12	80 950 126	M3x7 - IP	2.42	70 950 819
33 - 41	T15 - IP	8.67	80 950 128	M3,5x8,6 - IP	2.42	70 950 859

SONT

Designation	IC	D1	L	S
	mm	mm	mm	mm
SONT 0318..	5.4	2.10	3.8	1.80
SONT 0421..	4.6	2.25	4.2	2.10
SONT 0523..	5.3	2.25	4.8	2.30
SONT 0625..	5.9	2.50	5.5	2.50
SONT 0729..	6.5	2.50	6.1	2.90
SONT 0833..	7.7	2.90	7.3	3.30
SONT 0938..	8.9	3.50	8.5	3.80
SONT 1044..	10.1	4.10	9.6	4.40
SONT 1248..	11.6	4.10	11.0	4.80
SONT 1350..	13.0	5.30	12.2	5.00
SONT 1553..	15.2	5.30	14.4	5.30
SONT 1756..	17.5	5.30	16.7	5.60



SONT 03..



SONT 04../05../06../07../08../09../10../12../13../15../17..

SONT

KOMET \ Performance

ISO	RE	-M30 CTCP420 / -M30 DCX1420 DRAGONSKIN		-M30 CTPP430 / -M30 CCN1430 DRAGONSKIN	
	mm	Article no.	£	Article no.	£
031804	0.4	10 830 703 [1]	8.26	10 830 103 [1]	8.26
Steel		●		●	
Stainless steel		○		●	
Cast iron		●		○	
Non ferrous metals				○	
Heat resistant alloys				○	

1) two usable cutting edges

SONT

KOMET \ Performance

ISO	RE	-M30 CTCP420 / -M30 DCX1420 DRAGONSKIN		-M30 CTPP430 / -M30 CCN1430 DRAGONSKIN	
	mm	Article no.	£	Article no.	£
042105	0.5	10 830 704	9.47	10 830 104	9.47
052306	0.6	10 830 705	9.59	10 830 105	9.59
062506	0.6	10 830 706	9.75	10 830 106	9.75
072907	0.7	10 830 707	9.97	10 830 107	9.97
083308	0.8	10 830 708	10.19	10 830 108	10.19
093808	0.8	10 830 709	10.43	10 830 109	10.43
104408	0.8	10 830 710	10.93	10 830 110	10.93
124810	1.0	10 830 712	11.58	10 830 112	11.58
135012	1.2	10 830 713	12.26	10 830 113	12.26
155312	1.2	10 830 715	13.91	10 830 115	13.91
175612	1.2	10 830 717	14.74	10 830 117	14.74
Steel		●		●	
Stainless steel		○		●	
Cast iron		●		○	
Non ferrous metals				○	
Heat resistant alloys				○	

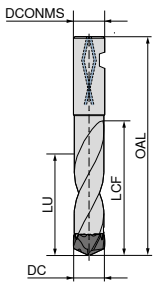
WTX – Holder for Exchangeable drills

▲ with radial teeth

≤ 1xD

Change

WNT \ Performance



HB

DC mm	DCONMS h6 mm	OAL mm	LCF mm	LU mm	Article no.	£
12,00 - 12,49	14	81	29	12.5	10 911 120	211.60
12,50 - 12,99	14	81	29	13.0	10 911 125	211.60
13,00 - 13,49	14	81	31	13.5	10 911 130	211.60
13,50 - 13,99	16	86	32	14.0	10 911 135	211.60
14,00 - 14,49	16	86	33	14.5	10 911 140	211.60
14,50 - 14,99	16	91	34	15.0	10 911 145	211.60
15,00 - 15,49	16	91	36	15.5	10 911 150	211.60
15,50 - 16,49	20	97	38	16.5	10 911 161	218.63
15,50 - 16,49	18	92	38	16.5	10 911 160	218.63
16,50 - 17,49	18	94	40	17.5	10 911 165	218.63
16,50 - 17,49	20	99	40	17.5	10 911 166	218.63
17,50 - 18,49	20	104	43	18.5	10 911 176	218.63
17,50 - 18,49	18	99	43	18.5	10 911 175	218.63
18,50 - 19,49	20	99	45	19.5	10 911 185	258.38
19,50 - 20,49	20	104	47	20.5	10 911 195	258.38
20,50 - 21,49	25	111	49	21.5	10 911 205	286.43
21,50 - 22,49	25	116	52	22.5	10 911 215	286.43
22,50 - 23,49	25	116	54	23.5	10 911 225	313.34
23,50 - 24,49	25	121	56	24.5	10 911 235	313.34
24,50 - 25,49	25	123	59	25.5	10 911 245	340.21
25,50 - 26,49	25	123	61	26.5	10 911 255	340.21
26,50 - 27,49	25	128	63	27.5	10 911 265	340.21
27,50 - 28,49	25	128	66	28.5	10 911 275	340.21
28,50 - 29,49	32	134	68	29.5	10 911 285	395.16
29,50 - 30,49	32	139	70	30.5	10 911 295	395.16
30,50 - 31,49	32	139	75	31.5	10 911 305	436.07
31,50 - 32,49	32	139	75	32.5	10 911 315	436.07
32,50 - 33,49	32	150	78	33.5	10 911 325	469.98
33,50 - 34,49	32	150	79	34.5	10 911 335	469.98
34,50 - 35,49	32	150	82	35.5	10 911 345	469.98
35,50 - 37,49	32	152	86	37.5	10 911 355	541.30
37,50 - 39,49	32	157	91	39.5	10 911 375	561.18
39,50 - 41,00	32	167	95	41.5	10 911 395	575.21

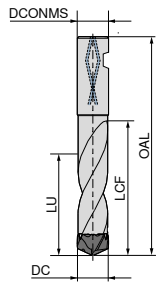
WTX – Holder for Exchangeable drills

▲ with radial teeth

≤ 3xD

Change

WNT \ Performance



HB

DC mm	DCONMS h6 mm	OAL mm	LCF mm	LU mm	Article no.	£
12,00 - 12,49	14	100	53	38.0	10 913 120	239.26
12,50 - 12,99	14	105	55	39.0	10 913 125	239.26
13,00 - 13,49	14	105	57	40.0	10 913 130	239.26
13,50 - 13,99	16	110	59	42.0	10 913 135	239.26
14,00 - 14,49	16	115	61	43.0	10 913 140	239.26
14,50 - 14,99	16	115	63	45.0	10 913 145	239.26
15,00 - 15,49	16	115	65	46.0	10 913 150	239.26
15,50 - 16,49	20	125	70	50.0	10 913 161	233.38
15,50 - 16,49	18	120	70	50.0	10 913 160	233.38
16,50 - 17,49	18	125	74	53.0	10 913 165	233.38
16,50 - 17,49	20	130	74	50.0	10 913 166	233.38
17,50 - 18,49	20	135	78	50.0	10 913 176	233.38
17,50 - 18,49	18	130	78	55.0	10 913 175	233.38
18,50 - 19,49	20	135	82	58.0	10 913 185	275.99
19,50 - 20,49	20	140	87	62.0	10 913 195	275.99
20,50 - 21,49	25	150	91	65.0	10 913 205	304.77
21,50 - 22,49	25	155	95	67.0	10 913 215	304.77
22,50 - 23,49	25	160	99	70.0	10 913 225	333.65
23,50 - 24,49	25	165	103	73.0	10 913 235	333.65
24,50 - 25,49	25	165	108	77.0	10 913 245	362.39
25,50 - 26,49	25	175	112	80.0	10 913 255	362.39
26,50 - 27,49	25	175	116	82.0	10 913 265	362.39
27,50 - 28,49	25	180	120	85.0	10 913 275	362.39
28,50 - 29,49	32	190	124	88.0	10 913 285	420.08
29,50 - 30,49	32	195	129	92.0	10 913 295	420.08
30,50 - 31,49	32	195	133	94.0	10 913 305	464.00
31,50 - 32,49	32	200	137	97.0	10 913 315	464.00
32,50 - 33,49	32	210	144	100.5	10 913 325	547.15
33,50 - 34,49	32	215	148	103.5	10 913 335	547.15
34,50 - 35,49	32	220	153	106.5	10 913 345	547.15
35,50 - 37,49	32	227	161	112.5	10 913 355	628.99
37,50 - 39,49	32	237	170	118.5	10 913 375	652.37
39,50 - 41,00	32	247	178	124.5	10 913 395	668.75

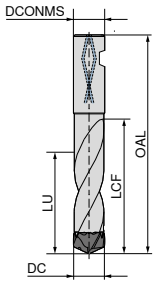
WTX – Holder for Exchangeable drills

▲ with radial teeth

≤ 5xD

Change

WNT \ Performance



HB

DC mm	DCONMS h6 mm	OAL mm	LCF mm	LU mm	Article no.	£
12,00 - 12,49	14	125	78	62.0	10 915 120	269.33
12,50 - 12,99	14	130	81	65.0	10 915 125	269.33
13,00 - 13,49	14	130	84	67.0	10 915 130	269.33
13,50 - 13,99	16	140	88	70.0	10 915 135	269.33
14,00 - 14,49	16	140	90	72.0	10 915 140	269.33
14,50 - 14,99	16	145	94	75.0	10 915 145	269.33
15,00 - 15,49	16	145	96	77.0	10 915 150	269.33
15,50 - 16,49	20	160	103	82.0	10 915 161	275.99
15,50 - 16,49	18	155	103	82.0	10 915 160	275.99
16,50 - 17,49	18	160	109	87.0	10 915 165	275.99
16,50 - 17,49	20	165	109	87.0	10 915 166	275.99
17,50 - 18,49	20	170	115	92.0	10 915 176	275.99
17,50 - 18,49	18	165	115	92.0	10 915 175	275.99
18,50 - 19,49	20	175	121	97.0	10 915 185	319.92
19,50 - 20,49	20	180	128	102.0	10 915 195	319.92
20,50 - 21,49	25	195	134	107.0	10 915 205	347.38
21,50 - 22,49	25	200	140	112.0	10 915 215	347.38
22,50 - 23,49	25	205	146	117.0	10 915 225	377.57
23,50 - 24,49	25	210	152	122.0	10 915 235	377.57
24,50 - 25,49	25	220	159	127.0	10 915 245	406.35
25,50 - 26,49	25	225	165	132.0	10 915 255	406.35
26,50 - 27,49	25	230	171	137.0	10 915 265	406.35
27,50 - 28,49	25	240	177	142.0	10 915 275	406.35
28,50 - 29,49	32	250	183	146.0	10 915 285	464.00
29,50 - 30,49	32	255	190	152.0	10 915 295	464.00
30,50 - 31,49	32	260	196	157.0	10 915 305	506.60
31,50 - 32,49	32	265	202	162.0	10 915 315	506.60
32,50 - 33,49	32	275	210	167.5	10 915 325	618.46
33,50 - 34,49	32	285	217	172.5	10 915 335	618.46
34,50 - 35,49	32	290	224	177.5	10 915 345	618.46
35,50 - 37,49	32	302	236	187.5	10 915 355	695.61
37,50 - 39,49	32	317	249	197.5	10 915 375	721.36
39,50 - 41,00	32	327	261	207.5	10 915 395	737.70

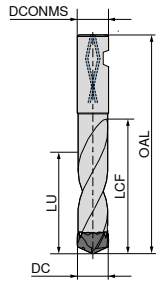
WTX – Holder for Exchangeable drills

▲ with radial teeth

≤ 8xD

Change

WNT \ Performance



HB

DC mm	DCONMS h6 mm	OAL mm	LCF mm	LU mm	Article no.	£
12,00 - 12,49	14	165	116	100	10 918 120	342.54
12,50 - 12,99	14	170	121	104	10 918 125	342.54
13,00 - 13,49	14	175	126	108	10 918 130	342.54
13,50 - 13,99	16	180	129	111	10 918 135	342.54
14,00 - 14,49	16	185	134	115	10 918 140	342.54
14,50 - 14,99	16	190	139	120	10 918 145	342.54
15,00 - 15,49	16	195	144	124	10 918 150	342.54
15,50 - 16,49	20	210	152	131	10 918 161	349.08
15,50 - 16,49	18	205	152	131	10 918 160	349.08
16,50 - 17,49	20	220	161	138	10 918 166	349.08
16,50 - 17,49	18	215	161	138	10 918 165	349.08
17,50 - 18,49	18	220	171	147	10 918 175	349.08
17,50 - 18,49	20	225	171	147	10 918 176	349.08
18,50 - 19,49	20	235	180	155	10 918 185	401.37
19,50 - 20,49	20	240	189	163	10 918 195	401.37
20,50 - 21,49	25	260	198	170	10 918 205	436.67
21,50 - 22,49	25	270	207	178	10 918 215	436.67
22,50 - 23,49	25	275	217	187	10 918 225	490.28
23,50 - 24,49	25	285	226	194	10 918 235	490.28
24,50 - 25,49	25	295	235	202	10 918 245	560.85
25,50 - 26,49	25	305	244	210	10 918 255	560.85
26,50 - 27,49	25	315	253	218	10 918 265	560.85
27,50 - 28,49	25	325	263	226	10 918 275	560.85
28,50 - 29,49	32	340	272	234	10 918 285	648.46
29,50 - 30,49	32	345	281	242	10 918 295	648.46
30,50 - 31,49	32	355	290	249	10 918 305	719.07
31,50 - 32,00	32	360	299	257	10 918 315	719.07

Drilling Head for Exchangeable drills can be found on → **Page 18.**

Speed Calculation

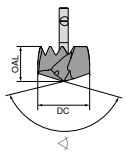
$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

WTX – Drilling Head for Exchangeable drills

▲ extra long head type

WNT \ Performance



Change UNI	Change VA	Change AL
DPX74S	Ti700	TiB
		
◁ 140° Solid carbide	◁ 138° Solid carbide	◁ 140° Solid carbide

DC h7/m7 mm	OAL mm	Article no.	£	Article no.	£	Article no.	£
12.0	10.7	10 919 12000	90.43	10 921 120	90.43	10 922 120	90.43
12.1	10.7	10 919 12100	90.43	10 921 121	90.43	10 922 121	90.43
12.2	10.7	10 919 12200	90.43	10 921 122	90.43	10 922 122	90.43
12.3	10.7	10 919 12300	90.43	10 921 123	90.43	10 922 123	90.43
12.4	10.7	10 919 12400	90.43	10 921 124	90.43	10 922 124	90.43
12.5	10.7	10 919 12500	90.43	10 921 125	90.43	10 922 125	90.43
12.6	10.7	10 919 12600	90.43	10 921 126	90.43	10 922 126	90.43
12.7	10.7	10 919 12700	90.43	10 921 127	90.43	10 922 127	90.43
12.8	10.7	10 919 12800	90.43	10 921 128	90.43	10 922 128	90.43
12.9	10.7	10 919 12900	90.43	10 921 129	90.43	10 922 129	90.43
13.0	10.7	10 919 13000	90.43	10 921 130	90.43	10 922 130	90.43
13.1	10.7	10 919 13100	90.43	10 921 131	90.43	10 922 131	90.43
13.2	10.7	10 919 13200	90.43	10 921 132	90.43	10 922 132	90.43
13.3	10.7	10 919 13300	90.43	10 921 133	90.43	10 922 133	90.43
13.4	10.7	10 919 13400	90.43	10 921 134	90.43	10 922 134	90.43
13.5	11.3	10 919 13500	90.43	10 921 135	90.43	10 922 135	90.43
13.6	11.3	10 919 13600	90.43	10 921 136	90.43	10 922 136	90.43
13.7	11.3	10 919 13700	90.43	10 921 137	90.43	10 922 137	90.43
13.8	11.3	10 919 13800	90.43	10 921 138	90.43	10 922 138	90.43
13.9	11.3	10 919 13900	90.43	10 921 139	90.43	10 922 139	90.43
14.0	11.3	10 919 14000	90.43	10 921 140	90.43	10 922 140	90.43
14.1	11.3	10 919 14100	90.43	10 921 141	90.43	10 922 141	90.43
14.2	11.3	10 919 14200	90.43	10 921 142	90.43	10 922 142	90.43
14.3	11.3	10 919 14300	90.43	10 921 143	90.43	10 922 143	90.43
14.4	11.3	10 919 14400	90.43	10 921 144	90.43	10 922 144	90.43
14.5	11.3	10 919 14500	90.43	10 921 145	90.43	10 922 145	90.43
14.6	11.3	10 919 14600	90.43	10 921 146	90.43	10 922 146	90.43
14.7	11.3	10 919 14700	90.43	10 921 147	90.43	10 922 147	90.43
14.8	11.3	10 919 14800	90.43	10 921 148	90.43	10 922 148	90.43
14.9	11.3	10 919 14900	90.43	10 921 149	90.43	10 922 149	90.43
15.0	11.3	10 919 15000	90.43	10 921 150	90.43	10 922 150	90.43
15.1	11.3	10 919 15100	90.43	10 921 151	90.43	10 922 151	90.43
15.2	11.3	10 919 15200	90.43	10 921 152	90.43	10 922 152	90.43
15.3	11.3	10 919 15300	90.43	10 921 153	90.43	10 922 153	90.43
15.4	11.3	10 919 15400	90.43	10 921 154	90.43	10 922 154	90.43
15.5	11.9	10 919 15500	90.43	10 921 155	90.43	10 922 155	90.43
15.6	11.9	10 919 15600	90.43	10 921 156	90.43	10 922 156	90.43
15.7	11.9	10 919 15700	90.43	10 921 157	90.43	10 922 157	90.43
15.8	11.9	10 919 15800	90.43	10 921 158	90.43	10 922 158	90.43
15.9	11.9	10 919 15900	90.43	10 921 159	90.43	10 922 159	90.43
16.0	11.9	10 919 16000	90.43	10 921 160	90.43	10 922 160	90.43
16.1	11.9	10 919 16100	90.43	10 921 161	90.43	10 922 161	90.43
16.2	11.9	10 919 16200	90.43	10 921 162	90.43	10 922 162	90.43
16.3	11.9	10 919 16300	90.43	10 921 163	90.43	10 922 163	90.43
16.4	11.9	10 919 16400	90.43	10 921 164	90.43	10 922 164	90.43
16.5	13.4	10 919 16500	90.43	10 921 165	90.43	10 922 165	90.43
16.6	13.4	10 919 16600	90.43	10 921 166	90.43	10 922 166	90.43
16.7	13.4	10 919 16700	90.43	10 921 167	90.43	10 922 167	90.43
16.8	13.4	10 919 16800	90.43	10 921 168	90.43	10 922 168	90.43
16.9	13.4	10 919 16900	90.43	10 921 169	90.43	10 922 169	90.43
17.0	13.4	10 919 17000	90.43	10 921 170	90.43	10 922 170	90.43
17.1	13.4	10 919 17100	90.43	10 921 171	90.43	10 922 171	90.43
17.2	13.4	10 919 17200	90.43	10 921 172	90.43	10 922 172	90.43
17.3	13.4	10 919 17300	90.43	10 921 173	90.43	10 922 173	90.43
17.4	13.4	10 919 17400	90.43	10 921 174	90.43	10 922 174	90.43
17.5	13.4	10 919 17500	90.43	10 921 175	90.43	10 922 175	90.43
17.6	13.4	10 919 17600	90.43	10 921 176	90.43	10 922 176	90.43
17.7	13.4	10 919 17700	90.43	10 921 177	90.43	10 922 177	90.43
17.8	13.4	10 919 17800	90.43	10 921 178	90.43	10 922 178	90.43
17.9	13.4	10 919 17900	90.43	10 921 179	90.43	10 922 179	90.43
18.0	13.4	10 919 18000	90.43	10 921 180	90.43	10 922 180	90.43
18.1	13.4	10 919 18100	98.39	10 921 181	98.39	10 922 181	98.39
18.2	13.4	10 919 18200	98.39	10 921 182	98.39	10 922 182	98.39
18.3	13.4	10 919 18300	98.39	10 921 183	98.39	10 922 183	98.39
18.4	13.4	10 919 18400	98.39	10 921 184	98.39	10 922 184	98.39
18.5	13.4	10 919 18500	98.39	10 921 185	98.39	10 922 185	98.39
18.6	13.4	10 919 18600	98.39	10 921 186	98.39	10 922 186	98.39
18.7	13.4	10 919 18700	98.39	10 921 187	98.39	10 922 187	98.39
18.8	13.4	10 919 18800	98.39	10 921 188	98.39	10 922 188	98.39
18.9	13.4	10 919 18900	98.39	10 921 189	98.39	10 922 189	98.39
19.0	13.4	10 919 19000	98.39	10 921 190	98.39	10 922 190	98.39
19.1	13.4	10 919 19100	98.39	10 921 191	98.39	10 922 191	98.39
19.2	13.4	10 919 19200	98.39	10 921 192	98.39	10 922 192	98.39
19.3	13.4	10 919 19300	98.39	10 921 193	98.39	10 922 193	98.39
19.4	13.4	10 919 19400	98.39	10 921 194	98.39	10 922 194	98.39
19.5	13.4	10 919 19500	98.39	10 921 195	98.39	10 922 195	98.39
19.6	13.4	10 919 19600	98.39	10 921 196	98.39	10 922 196	98.39
19.7	13.4	10 919 19700	98.39	10 921 197	98.39	10 922 197	98.39
19.8	13.4	10 919 19800	98.39	10 921 198	98.39	10 922 198	98.39
19.9	13.4	10 919 19900	98.39	10 921 199	98.39	10 922 199	98.39
20.0	13.4	10 919 20000	98.39	10 921 200	98.39	10 922 200	98.39
20.1	13.4	10 919 20100	108.74	10 921 201	108.74	10 922 201	81.98
20.2	13.4	10 919 20200	108.74	10 921 202	108.74	10 922 202	108.74
20.3	13.4	10 919 20300	108.74	10 921 203	108.74	10 922 203	108.74
20.4	13.4	10 919 20400	108.74	10 921 204	108.74	10 922 204	108.74
20.5	15.4	10 919 20500	108.74	10 921 205	108.74	10 922 205	108.74
20.6	15.4	10 919 20600	108.74	10 921 206	108.74	10 922 206	108.74
20.7	15.4	10 919 20700	108.74	10 921 207	108.74	10 922 207	108.74
20.8	15.4	10 919 20800	108.74	10 921 208	108.74	10 922 208	108.74
20.9	15.4	10 919 20900	108.74	10 921 209	108.74	10 922 209	108.74
21.0	15.4	10 919 21000	108.74	10 921 210	108.74	10 922 210	108.74
21.1	15.4	10 919 21100	108.74	10 921 211	108.74	10 922 211	108.74
21.2	15.4	10 919 21200	108.74	10 921 212	108.74	10 922 212	108.74
21.3	15.4	10 919 21300	108.74	10 921 213	108.74	10 922 213	108.74
21.4	15.4	10 919 21400	108.74	10 921 214	108.74	10 922 214	108.74
21.5	15.4	10 919 21500	108.74	10 921 215	108.74	10 922 215	108.74
21.6	15.4	10 919 21600	108.74	10 921 216	108.74	10 922 216	108.74
21.7	15.4	10 919 21700	108.74	10 921 217	108.74	10 922 217	108.74
21.8	15.4	10 919 21800	108.74	10 921 218	108.74	10 922 218	108.74
21.9	15.4	10 919 21900	108.74	10 921 219	108.74	10 922 219	108.74
22.0	15.4	10 919 22000	108.74	10 921 220	108.74	10 922 220	108.74
22.1	15.4	10 919 22100	116.69	10 921 221	116.69	10 922 221	116.69
22.2	15.4	10 919 22200	116.69	10 921 222	116.69	10 922 222	116.69
22.3	15.4	10 919 22300	116.69	10 921 223	116.69	10 922 223	116.69
22.4	15.4	10 919 22400	116.69	10 921 224	116.69	10 922 224	116.69
22.5	15.4	10 919 22500	116.69	10 921 225	116.69	10 922 225	116.69
22.6	15.4	10 919 22600	116.69	10 921 226	116.69	10 922 226	116.69
22.7	15.4	10 919 22700	116.69	10 921 227	116.69	10 922 227	116.69
22.8	15.4	10 919 22800	116.69	10 921 228	116.69	10 922 228	116.69
22.9	15.4	10 919 22900	116.69	10 921 229	116.69	10 922 229	116.69
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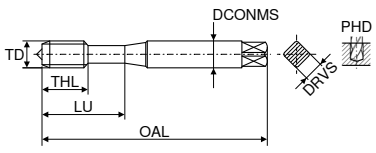
23.1	15.4	10 919 23100	116.69	10 921 231	116.69	10 922 231	116.69
23.2	15.4	10 919 23200	116.69	10 921 232	116.69	10 922 232	116.69
23.3	15.4	10 919 23300	116.69	10 921 233	116.69	10 922 233	116.69
23.4	15.4	10 919 23400	116.69	10 921 234	116.69	10 922 234	116.69
23.5	15.4	10 919 23500	116.69	10 921 235	116.69	10 922 235	116.69
23.6	15.4	10 919 23600	116.69	10 921 236	116.69	10 922 236	116.69
23.7	15.4	10 919 23700	116.69	10 921 237	116.69	10 922 237	116.69
23.8	15.4	10 919 23800	116.69	10 921 238	116.69	10 922 238	116.69
23.9	15.4	10 919 23900	116.69	10 921 239	116.69	10 922 239	116.69
24.0	15.4	10 919 24000	116.69	10 921 240	116.69	10 922 240	116.69
24.1	15.4	10 919 24100	127.04	10 921 241	134.99	10 922 241	134.99
24.2	15.4	10 919 24200	127.04	10 921 242	134.99	10 922 242	134.99
24.3	15.4	10 919 24300	127.04	10 921 243	134.99	10 922 243	134.99
24.4	15.4	10 919 24400	127.04	10 921 244	134.99	10 922 244	134.99
24.5	17.4	10 919 24500	127.04	10 921 245	134.99	10 922 245	134.99
24.6	17.4	10 919 24600	127.04	10 921 246	134.99	10 922 246	134.99
24.7	17.4	10 919 24700	127.04	10 921 247	134.99	10 922 247	134.99
24.8	17.4	10 919 24800	127.04	10 921 248	134.99	10 922 248	134.99
24.9	17.4	10 919 24900	127.04	10 921 249	134.99	10 922 249	134.99
25.0	17.4	10 919 25000	127.04	10 921 250	134.99	10 922 250	134.99
25.1	17.4	10 919 25100	127.04	10 921 251	134.99	10 922 251	134.99
25.2	17.4	10 919 25200	127.04	10 921 252	134.99	10 922 252	134.99
25.3	17.4	10 919 25300	127.04	10 921 253	134.99	10 922 253	134.99
25.4	17.4	10 919 25400	127.04	10 921 254	134.99	10 922 254	134.99
25.5	17.4	10 919 25500	127.04	10 921 255	134.99	10 922 255	134.99
25.6	17.4	10 919 25600	134.99	10 921 256	134.99	10 922 256	134.99
25.7	17.4	10 919 25700	134.99	10 921 257	134.99	10 922 257	134.99
25.8	17.4	10 919 25800	134.99	10 921 258	134.99	10 922 258	134.99
25.9	17.4	10 919 25900	134.99	10 921 259	134.99	10 922 259	134.99
26.0	17.4	10 919 26000	134.99	10 921 260	134.99	10 922 260	134.99
26.1	17.4	10 919 26100	134.99	10 921 261	134.99	10 922 261	134.99
26.2	17.4	10 919 26200	134.99	10 921 262	134.99	10 922 262	134.99
26.3	17.4	10 919 26300	134.99	10 921 263	134.99	10 922 263	134.99
26.4	17.4	10 919 26400	134.99	10 921 264	134.99	10 922 264	134.99
26.5	17.4	10 919 26500	134.99	10 921 265	134.99	10 922 265	134.99
26.6	17.4	10 919 26600	134.99	10 921 266	134.99	10 922 266	134.99
26.7	17.4	10 919 26700	134.99	10 921 267	134.99	10 922 267	134.99
26.8	17.4	10 919 26800	134.99	10 921 268	134.99	10 922 268	134.99
26.9	17.4	10 919 26900	134.99	10 921 269	134.99	10 922 269	134.99
27.0	17.4	10 919 27000	134.99	10 921 270	134.99	10 922 270	134.99
27.1	17.4	10 919 27100	134.99	10 921 271	134.99	10 922 271	134.99
27.2	17.4	10 919 27200	134.99	10 921 272	134.99	10 922 272	134.99
27.3	17.4	10 919 27300	134.99	10 921 273	134.99	10 922 273	134.99
27.4	17.4	10 919 27400	134.99	10 921 274	134.99	10 922 274	134.99
27.5	17.4	10 919 27500	134.99	10 921 275	134.99	10 922 275	134.99
27.6	17.4	10 919 27600	134.99	10 921 276	134.99	10 922 276	134.99
27.7	17.4	10 919 27700	134.99	10 921 277	134.99	10 922 277	134.99
27.8	17.4	10 919 27800	134.99	10 921 278	134.99	10 922 278	134.99
27.9	17.4	10 919 27900	134.99	10 921 279	134.99	10 922 279	134.99
28.0	17.4	10 919 28000	134.99	10 921 280	134.99	10 922 280	134.99
28.1	17.4	10 919 28100	147.64	10 921 281	147.64	10 922 281	147.64
28.2	17.4	10 919 28200	147.64	10 921 282	147.64	10 922 282	147.64
28.3	17.4	10 919 28300	147.64	10 921 283	147.64	10 922 283	147.64
28.4	17.4	10 919 28400	147.64	10 921 284	147.64	10 922 284	147.64
28.5	18.4	10 919 28500	147.64	10 921 285	147.64	10 922 285	147.64
28.6	18.4	10 919 28600	147.64	10 921 286	147.64	10 922 286	147.64
28.7	18.4	10 919 28700	147.64	10 921 287	147.64	10 922 287	147.64
28.8	18.4	10 919 28800	147.64	10 921 288	147.64	10 922 288	147.64
28.9	18.4	10 919 28900	147.64	10 921 289	147.64	10 922 289	147.64
29.0	18.4	10 919 29000	147.64	10 921 290	147.64	10 922 290	147.64
29.1	18.4	10 919 29100	147.64	10 921 291	147.64	10 922 291	147.64
29.2	18.4	10 919 29200	147.64	10 921 292	147.64	10 922 292	147.64
29.3	18.4	10 919 29300	147.64	10 921 293	147.64	10 922 293	147.64
29.4	18.4	10 919 29400	147.64	10 921 294	147.64	10 922 294	147.64
29.5	18.4	10 919 29500	147.64	10 921 295	147.64	10 922 295	147.64
29.6	18.4	10 919 29600	147.64	10 921 296	147.64	10 922 296	147.64
29.7	18.4	10 919 29700	147.64	10 921 297	147.64	10 922 297	147.64
29.8	18.4	10 919 29800	147.64	10 921 298	147.64	10 922 298	147.64
29.9	18.4	10 919 29900	147.64	10 921 299	147.64	10 922 299	147.64
30.0	18.4	10 919 30000	147.64	10 921 300	147.64	10 922 300	147.64
30.1	18.4	10 919 30100	164.74	10 921 301	164.74	10 922 301	164.74
30.2	18.4	10 919 30200	164.74	10 921 302	164.74	10 922 302	164.74
30.3	18.4	10 919 30300	164.74	10 921 303	164.74	10 922 303	164.74
30.4	18.4	10 919 30400	164.74	10 921 304	164.74	10 922 304	164.74
30.5	18.4	10 919 30500	164.74	10 921 305	164.74	10 922 305	164.74
30.6	18.4	10 919 30600	164.74	10 921 306	164.74	10 922 306	164.74
30.7	18.4	10 919 30700	164.74	10 921 307	164.74	10 922 307	164.74
30.8	18.4	10 919 30800	164.74	10 921 308	164.74	10 922 308	164.74
30.9	18.4	10 919 30900	164.74	10 921 309	164.74	10 922 309	164.74
31.0	18.4	10 919 31000	164.74	10 921 310	164.74	10 922 310	164.74
31.1	18.4	10 919 31100	164.74	10 921 311	164.74	10 922 311	164.74
31.2	18.4	10 919 31200	164.74	10 921 312	164.74	10 922 312	164.74
31.3	18.4	10 919 31300	164.74	10 921 313	164.74	10 922 313	164.74
31.4	18.4	10 919 31400	164.74	10 921 314	164.74	10 922 314	164.74
31.5	18.4	10 919 31500	164.74	10 921 315	164.74	10 922 315	164.74
31.6	18.4	10 919 31600	164.74	10 921 316	164.74	10 922 316	164.74
31.7	18.4	10 919 31700	164.74	10 921 317	164.74	10 922 317	164.74
31.8	18.4	10 919 31800	164.74	10 921 318	164.74	10 922 318	164.74
31.9	18.4	10 919 31900	164.74	10 921 319	164.74	10 922 319	164.74
32.0	18.4	10 919 32000	164.74	10 921 320	164.74	10 922 320	164.74
32.5	24.3	10 919 32500	176.33				
33.0	24.3	10 919 33000	176.33				
33.5	24.3	10 919 33500	176.33				
34.0	24.3	10 919 34000	176.33				
34.5	24.3	10 919 34500	176.33				
35.0	24.3	10 919 35000	176.33				
35.5	26.3	10 919 35500	201.68				
36.0	26.3	10 919 36000	201.68				
36.5	26.3	10 919 36500	201.68				
37.0	26.3	10 919 37000	201.68				
37.5	26.3	10 919 37500	201.68				
38.0	26.3	10 919 38000	201.68				
38.5	26.3	10 919 38500	219.22				
39.0	26.3	10 919 39000	219.22				
39.5	26.3	10 919 39500	219.22				
40.0	26.3	10 919 40000	219.22				
40.5	26.3	10 919 40500	219.22				
41.0	26.3	10 919 41000	219.22				

Steel	●	○	
Stainless steel		●	
Cast iron	●	○	
Non ferrous metals			●
Heat resistant alloys			

Through hole – Machine taps, right hand

M | Stabil

WNT \ Performance



DIN 371 with reinforced shank

	UNI	VA
	B 4–5	B 4–5
	ISO 2 6H	ISO 2 6H
	nitr. + vap.	nitr.

	HSS-E	HSS-E
	◁ 0° ≤ 1100 N/mm² ≤ 4xD	◁ 0° ≤ 900 N/mm² ≤ 4xD

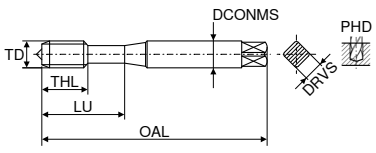
TD	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes	Article no.		Article no.	
mm	mm	mm	mm	mm	mm	mm	mm			£		£
M1	0.25	40	2.5	2.1	0.75	5	13	2	22 501 010 [1]	84.57		
M1,2	0.25	40	2.5	2.1	0.95	5	13	2	22 501 012 [1]	81.44		
M1,4	0.30	40	2.5	2.1	1.10	7	13	3	22 501 014 [1]	72.46		
M1,6	0.35	40	2.5	2.1	1.25	8	11	3	22 501 016	51.39		
M1,7	0.35	40	2.5	2.1	1.35	6	11	2	22 501 017	78.71		
M1,8	0.35	40	2.5	2.1	1.45	6	11	2	22 501 018	109.13		
M2	0.40	45	2.8	2.1	1.60	7	12	3	22 501 020	37.82		
M2	0.40	45	2.8	2.1	1.60	7	12	2			22 056 020	29.17
M2,2	0.45	45	2.8	2.1	1.75	7	12	2	22 501 022	39.16		
M2,5	0.45	50	2.8	2.1	2.05	9	14	2	22 501 025	36.89	22 056 025	28.05
M3	0.50	56	3.5	2.7	2.50	11	18	3	22 501 030	24.52	22 056 030	23.05
M3,5	0.60	56	4.0	3.0	2.90	12	20	3	22 501 035	30.22	22 056 035	32.33
M4	0.70	63	4.5	3.4	3.30	13	21	3	22 501 040	21.63	22 056 040	24.18
M5	0.80	70	6.0	4.9	4.20	15	25	3	22 501 050	22.67	22 056 050	25.58
M6	1.00	80	6.0	4.9	5.00	17	30	3	22 501 060	22.67	22 056 060	26.72
M7	1.00	80	7.0	5.5	6.00	17	30	3	22 501 070	36.54		
M8	1.25	90	8.0	6.2	6.80	20	35	3	22 501 080	26.85	22 056 080	29.08
M10	1.50	100	10.0	8.0	8.50	22	39	3	22 501 100	32.21	22 056 100	35.58
M12	1.75	110	12.0	9.0	10.20	24	44	3	22 501 120	44.66		

1) Tol. ISO 1 4H ≤ M1.4

Blind hole – Machine taps, right hand

M | Salo-Rex

WNT \ Performance

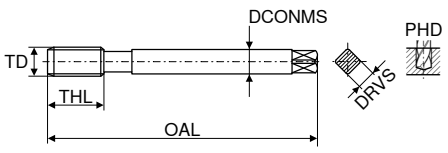


DIN 371 with reinforced shank

	UNI	VA
	C 2–3	C 2–3
	ISO 2 6H	ISO 2 6H
	vap.	vap.

	HSS-E	HSS-E
	◁ 42° ≤ 1100 N/mm² ≤ 3xD	◁ 42° ≤ 900 N/mm² ≤ 3xD

TD	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes	Article no.		Article no.	
mm	mm	mm	mm	mm	mm	mm	mm			£		£
M2	0.40	45	2.8	2.1	1.60	4.0	12	2	22 518 020	29.50	22 090 020	44.34
M2,2	0.45	45	2.8	2.1	1.75	4.5	12	2	22 518 022	33.24		
M2,3	0.40	45	2.8	2.1	1.90	4.5	12	2	22 518 023	36.04		
M2,5	0.45	50	2.8	2.1	2.05	5.0	15	2	22 518 025	27.66	22 090 025	35.70
M2,6	0.45	50	2.8	2.1	2.15	5.0	15	2	22 518 026	34.18		
M3	0.50	56	3.5	2.7	2.50	6.0	18	3	22 518 030	25.24	22 090 030	26.72
M3,5	0.60	56	4.0	3.0	2.90	7.0	20	3	22 518 035	27.09		
M4	0.70	63	4.5	3.4	3.30	7.0	21	3	22 518 040	25.69	22 090 040	27.66
M5	0.80	70	6.0	4.9	4.20	8.0	25	3	22 518 050	25.66	22 090 050	28.02
M6	1.00	80	6.0	4.9	5.00	10.0	30	3	22 518 060	26.72	22 090 060	27.94
M7	1.00	80	7.0	5.5	6.00	10.0	30	3	22 518 070	40.79		
M8	1.25	90	8.0	6.2	6.80	14.0	35	3	22 518 080	30.34	22 090 080	32.62
M10	1.50	100	10.0	8.0	8.50	16.0	39	3	22 518 100	37.19	22 090 100	39.86
M12	1.75	110	12.0	9.0	10.20	18.0	44	3	22 518 120	42.54		



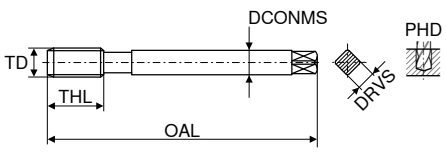
DIN 376 with reduced shank

	UNI	VA
	B 4–5	B 4–5
	ISO 2 6H	ISO 2 6H
	nitr. + vap.	nitr.

	HSS-E	HSS-E
	◁ 0° ≤ 1100 N/mm² ≤ 4xD	◁ 0° ≤ 900 N/mm² ≤ 4xD

TD	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes	Article no.		Article no.	
mm	mm	mm	mm	mm	mm	mm			£		£
M3	0.50	56	2.2		2.5	11	3	22 502 030	49.68		
M4	0.70	63	2.8	2.1	3.3	13	3	22 502 040	33.06		
M5	0.80	70	3.5	2.7	4.2	15	3	22 502 050	31.06		
M6	1.00	80	4.5	3.4	5.0	17	3	22 502 060	31.19		
M8	1.25	90	6.0	4.9	6.8	20	3	22 502 080	34.59		
M10	1.50	100	7.0	5.5	8.5	22	3	22 502 100	40.59		
M12	1.75	110	9.0	7.0	10.2	24	3	22 502 120	39.98	22 057 120	45.04
M14	2.00	110	11.0	9.0	12.0	26	3	22 502 140	50.56	22 057 140	62.28
M16	2.00	110	12.0	9.0	14.0	27	3	22 502 160	56.10	22 057 160	63.73
M18	2.50	125	14.0	11.0	15.5	30	3	22 502 180	105.19	22 057 180	156.06
M20	2.50	140	16.0	12.0	17.5	32	3	22 502 200	83.46	22 057 200	92.91
M22	2.50	140	18.0	14.5	19.5	32	3	22 502 220	141.46	22 057 220	244.82
M24	3.00	160	18.0	14.5	21.0	34	3	22 502 240	111.55	22 057 240	127.72
M27	3.00	160	20.0	16.0	24.0	36	3	22 502 270	159.91	22 057 270	267.84
M30	3.50	180	22.0	18.0	26.5	40	4	22 502 300	181.53	22 057 300	206.28
M33	3.50	180	25.0	20.0	29.5	40	4	22 502 330	452.52		
M36	4.00	200	28.0	22.0	32.0	50	4	22 502 360	520.98		
M42	4.50	200	32.0	24.0	37.5	56	4	22 502 420	989.46		
M48	5.00	250	36.0	29.0	43.0	65	4	22 502 480	1,045.09		

Steel	6-20	
Stainless steel	4-8	5-10
Cast iron	6-15	
Non ferrous metals		
Heat resistant alloys		
Hardened materials		



DIN 376 with reduced shank

	UNI	VA
	C 2–3	C 2–3
	ISO 2 6H	ISO 2 6H
	vap.	vap.

	HSS-E	HSS-E
	◁ 42° ≤ 1100 N/mm² ≤ 3xD	◁ 42° ≤ 900 N/mm² ≤ 3xD

TD	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes	Article no.		Article no.	
mm	mm	mm	mm	mm	mm	mm			£		£
M3	0.50	56	2.2		2.5	6	3	22 519 030	41.89		
M4	0.70	63	2.8	2.1	3.3	7	3	22 519 040	39.98		
M5	0.80	70	3.5	2.7	4.2	8	3	22 519 050	30.22		
M6	1.00	80	4.5	3.4	5.0	10	3	22 519 060	31.38		
M8	1.25	90	6.0	4.9	6.8	14	3	22 519 080	34.78		
M10	1.50	100	7.0	5.5	8.5	16	3	22 519 100	44.29		
M12	1.75	110	9.0	7.0	10.2	18	3	22 519 120	46.62		
M12	1.75	110	9.0	7.0	10.2	18	4			22 091 120	49.28
M14	2.00	110	11.0	9.0	12.0	20	4			22 091 140	72.54
M14	2.00	110	11.0	9.0	12.0	20	3	22 519 140	59.74		
M16	2.00	110	12.0	9.0	14.0	22	3	22 519 160	65.77		
M16	2.00	110	12.0	9.0	14.0	22	4			22 091 160	69.85
M18	2.50	125	14.0	11.0	15.5	25	3	22 519 180	95.07		
M20	2.50	140	16.0	12.0	17.5	25	3	22 519 200	98.55		
M20	2.50	140	16.0	12.0	17.5	25	4			22 091 200	104.36
M22	2.50	140	18.0	14.5	19.5	27	5			22 091 220	223.80
M22	2.50	140	18.0	14.5	19.5	27	4	22 519 220	141.46		
M24	3.00	160	18.0	14.5	21.0	30	4	22 519 240	124.68		
M24	3.00	160	18.0	14.5	21.0	30	5			22 091 240	132.49
M27	3.00	160	20.0	16.0	24.0	30	4	22 519 270	163.74		
M30	3.50	180	22.0	18.0	26.5	35	4	22 519 300	210.23		
M30	3.50	180	22.0	18.0	26.5	35	5			22 091 300	280.30
M33	3.50	180	25.0	20.0	29.5	35	4	22 519 330	413.14		
M36	4.00	200	28.0	22.0	32.0	40	4	22 519 360	341.90		

Steel	6-20	
Stainless steel	4-8	5-10
Cast iron	6-15	
Non ferrous metals		
Heat resistant alloys		
Hardened materials		

Speed Calculation

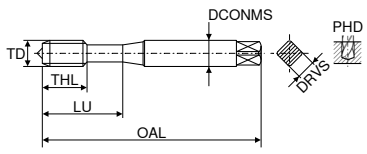
$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

Through hole / Blind hole – Machine thread formers, right hand

M | Spanlos

WNT \ Performance



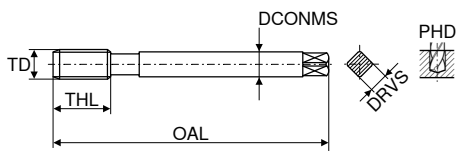
DIN 2174 with reinforced shank

	EC	EC SN
	C 2–3	C 2–3
	ISO 2X 6HX	ISO 2X 6HX
	TiN	TiN

									HSS-E ≤ 1100 N/mm² ≤ 1,5xD		HSS-E ≤ 1100 N/mm² ≤ 3xD	
TD	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes	Article no.		Article no.	
mm	mm	mm	mm	mm	mm	mm	mm			£		£
M1	0.25	40	2.5	2.1	0.90	5	6.5		22 100 010 [1]	64.03		
M1,2	0.25	40	2.5	2.1	1.10	5	6.5		22 100 012 [1]	58.72		
M1,4	0.30	40	2.5	2.1	1.28	6	9.0		22 100 014 [1]	55.30		
M1,6	0.35	40	2.5	2.1	1.47	6	9.0		22 100 016	53.81		
M1,7	0.35	40	2.5	2.1	1.57	6	9.0		22 100 017	55.30		
M2	0.40	45	2.8	2.1	1.85	7	10.0		22 100 020	35.92		
M2	0.40	45	2.8	2.1	1.85	7	10.0	3			22 105 020	42.20
M2,5	0.45	50	2.8	2.1	2.33	9	14.0		22 100 025	36.38		
M2,5	0.45	50	2.8	2.1	2.33	9	14.0	3			22 105 025	39.34
M2,6	0.45	50	2.8	2.1	2.43	9	14.0		22 100 026	38.24		
M3	0.50	56	3.5	2.7	2.80	11	18.0		22 100 030	33.13		
M3	0.50	56	3.5	2.7	2.80	11	18.0	4			22 105 030	36.38
M3,5	0.60	56	4.0	3.0	3.25	12	20.0		22 100 035	31.81		
M3,5	0.60	56	4.0	3.0	3.25	12	20.0	3			22 105 035	39.34
M4	0.70	63	4.5	3.4	3.70	13	21.0		22 100 040	33.94		
M4	0.70	63	4.5	3.4	3.70	13	21.0	5			22 105 040	37.78
M5	0.80	70	6.0	4.9	4.65	15	25.0		22 100 050	35.57		
M5	0.80	70	6.0	4.9	4.65	15	25.0	5			22 105 050	39.05
M6	1.00	80	6.0	4.9	5.60	17	30.0		22 100 060	40.79		
M6	1.00	80	6.0	4.9	5.60	17	30.0	5			22 105 060	44.63
M8	1.25	90	8.0	6.2	7.40	20	35.0		22 100 080	44.86		
M8	1.25	90	8.0	6.2	7.45	20	35.0	6			22 105 080	49.28
M10	1.50	100	10.0	8.0	9.35	22	39.0	6			22 105 100	61.49
M10	1.50	100	10.0	8.0	9.35	22	39.0		22 100 100	56.62		

1) Tol. ISO 1X 4HX ≤ M1.4

	EC	EC SN
	C 2–3	C 2–3
	ISO 2X 6HX	ISO 2X 6HX
	TiN	TiN



DIN 2174 with reduced shank

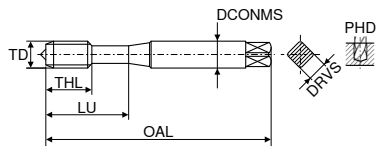
								HSS-E ≤ 1100 N/mm² ≤ 1,5xD		HSS-E ≤ 1100 N/mm² ≤ 3xD	
TD	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes	Article no.		Article no.	
mm	mm	mm	mm	mm	mm	mm			£		£
M12	1.75	110	9	7	11.25	24		22 101 120	69.50		
M12	1.75	110	9	7	11.25	24	6			22 106 120	84.73
M14	2.00	110	11	9	13.10	26	5			22 106 140	147.84
M16	2.00	110	12	9	15.10	27	7			22 106 160	124.12
M16	2.00	110	12	9	15.10	27		22 101 160	104.33		

Steel	8-30	8-30
Stainless steel	8-15	8-15
Cast iron		
Non ferrous metals	12-25	12-25
Heat resistant alloys		
Hardened materials		

Through hole – Machine taps, right hand

M

WNT \ Standard

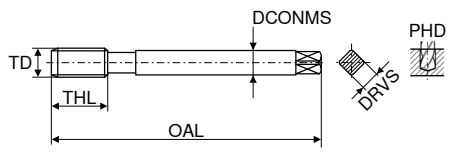


DIN 371 with reinforced shank

	UNI	VA
	B 4–5	B 4–5
	ISO 2 6H	ISO 2 6H
	TiN	nitr.

									POWDERSTEEL HSS-PM ◁ 0° ≤ 1000 N/mm² ≤ 3xD		POWDERSTEEL HSS-PM ◁ 0° ≤ 1200 N/mm² ≤ 3xD	
TD	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes	Article no.		Article no.	
mm	mm	mm	mm	mm	mm	mm	mm			£		£
M2	0.40	45	2.8	2.1	1.6	4	13.5	2	23 010 020	7.80		
M3	0.50	56	3.5	2.7	2.5	11	18.0	3	23 010 030	9.80	23 450 030	9.14
M4	0.70	63	4.5	3.4	3.3	13	21.0	3	23 010 040	8.94	23 450 040	9.22
M5	0.80	70	6.0	4.9	4.2	15	25.0	3	23 010 050	10.00	23 450 050	10.00
M6	1.00	80	6.0	4.9	5.0	17	30.0	3	23 010 060	11.99	23 450 060	10.08
M8	1.25	90	8.0	6.2	6.8	20	35.0	3	23 010 080	13.31	23 450 080	11.32
M10	1.50	100	10.0	8.0	8.5	22	39.0	3	23 010 100	17.60	23 450 100	12.84

	UNI	VA
	B 4–5	B 4–5
	ISO 2 6H	ISO 2 6H
	TiN	nitr.



DIN 376 with reduced shank

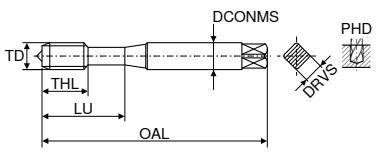
									POWDERSTEEL HSS-PM ◁ 0° ≤ 1000 N/mm² ≤ 3xD		POWDERSTEEL HSS-PM ◁ 0° ≤ 1200 N/mm² ≤ 3xD	
TD	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes		Article no.		Article no.	
mm	mm	mm	mm	mm	mm	mm				£		£
M12	1.75	110	9	7	10.2	24	3		23 021 120	21.02	23 451 120	22.92
M14	2.00	110	11	9	12.0	26	3				23 451 140	30.35
M14	2.00	110	11	9	12.0	20	4		23 021 140	31.87		
M16	2.00	110	12	9	14.0	27	3		23 021 160	29.59	23 451 160	32.06
M18	2.50	125	14	11	15.5	25	4		23 021 180	51.84		
M20	2.50	140	16	12	17.5	32	3		23 021 200	53.56	23 451 200	47.94

Steel	10-20	
Stainless steel	8-15	5-10
Cast iron	20-25	
Non ferrous metals	20-25	
Heat resistant alloys		
Hardened materials		

Blind hole – Machine taps, right hand

M

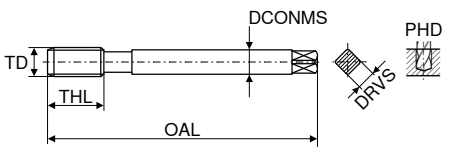
WNT \ Standard



DIN 371 with reinforced shank

	UNI	VA	VA
	C 2–3	C 2–3	C 2–3
	ISO 2 6H	ISO 2 6H	ISO 2 6H
	TiN		TiN
	POWDERSTEEL HSS-PM	POWDERSTEEL HSS-PM	POWDERSTEEL HSS-PM
	◁ 50° ≤ 1000 N/mm² ≤ 2,5xD	◁ 40° ≤ 1200 N/mm² ≤ 2,5xD	◁ 40° ≤ 1200 N/mm² ≤ 2,5xD

TD	TP	OAL	DCONMS	DRVS	PHD	THL	LU	Flutes	Article no.	£	Article no.	£	Article no.	£
mm	mm	mm	mm	mm	mm	mm	mm							
M3	0.50	56	3.5	2.7	2.5	6	18	3	23 026 030	11.13	23 426 030	10.00	23 456 030	11.13
M4	0.70	63	4.5	3.4	3.3	7	21	3	23 026 040	11.13	23 426 040	10.08	23 456 040	12.18
M5	0.80	70	6.0	4.9	4.2	8	25	3	23 026 050	11.99	23 426 050	10.37	23 456 050	12.37
M6	1.00	80	6.0	4.9	5.0	10	30	3	23 026 060	13.88	23 426 060	10.56	23 456 060	15.89
M8	1.25	90	8.0	6.2	6.8	14	35	3	23 026 080	16.46	23 426 080	12.37	23 456 080	17.03
M10	1.50	100	10.0	8.0	8.5	16	39	3	23 026 100	20.74	23 426 100	14.84	23 456 100	23.49



DIN 376 with reduced shank

	UNI	VA	VA
	C 2–3	C 2–3	C 2–3
	ISO 2 6H	ISO 2 6H	ISO 2 6H
	TiN		TiN
	POWDERSTEEL HSS-PM	POWDERSTEEL HSS-PM	POWDERSTEEL HSS-PM
	◁ 50° ≤ 1000 N/mm² ≤ 2,5xD	◁ 40° ≤ 1200 N/mm² ≤ 2,5xD	◁ 40° ≤ 1200 N/mm² ≤ 2,5xD

TD	TP	OAL	DCONMS	DRVS	PHD	THL	Flutes	Article no.	£	Article no.	£	Article no.	£
mm	mm	mm	mm	mm	mm	mm							
M12	1.75	110	9	7.0	10.2	18	4	23 027 120	24.54				
M12	1.75	110	9	7.0	10.2	18	3			23 427 120	24.54	23 457 120	33.68
M14	2.00	110	11	9.0	12.0	20	4	23 027 140	35.29	23 427 140	32.35		
M16	2.00	110	12	9.0	14.0	22	4	23 027 160	35.29				
M16	2.00	110	12	9.0	14.0	22	3			23 427 160	35.20	23 457 160	42.33
M20	2.50	140	16	12.0	17.5	25	3	23 027 200	40.43	23 427 200	52.42	23 457 200	84.08
M24	3.00	160	18	14.5	21.0	30	4			23 427 240	66.30		

Steel	**10-20**		
Stainless steel	**8-15**	**5-10**	**8-20**
Cast iron	**20-25**		
Non ferrous metals	**20-25**		
Heat resistant alloys			
Hardened materials			

Speed Calculation

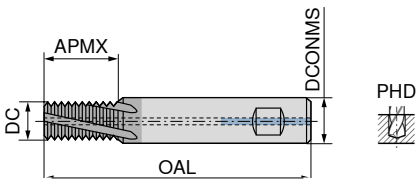
$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

Thread milling cutter

▲ Profile corrected
▲ Hard machining to Ø DC = 4 mm possible

SGF | IR/IL | ≤ 2xD | 60° | M



Ti500

WNT \ Standard

HB Solid carbide

DC mm	Thread	TP mm	APMX mm	DCONMS h6 mm	OAL mm	ZEFP	PHD mm	Article no.	£
2.40	M3	0.50	6.5	4	42	2	2.50	54 800 030 1)	71.95
3.15	M4	0.70	9.0	6	55	3	3.30	54 800 040 2)	71.95
4.00	M5	0.80	11.0	6	55	3	4.20	54 800 050 2)	71.95
4.80	M6	1.00	13.0	6	55	3	5.00	54 800 060 2)	71.95
6.00	M8	1.25	18.0	6	60	3	6.75	54 800 080	75.54
8.00	M10	1.50	21.0	8	70	3	8.50	54 800 100	91.33
9.90	M12	1.75	26.0	10	75	4	10.25	54 800 120	110.42
11.60	M14	2.00	30.0	12	85	4	12.00	54 800 140	127.85
12.00	M16	2.00	34.0	12	85	4	14.00	54 800 160	133.66
14.00	M18	2.50	40.0	14	90	4	15.50	54 800 180	158.28
16.00	M20	2.50	42.0	16	90	4	17.50	54 800 200	164.37

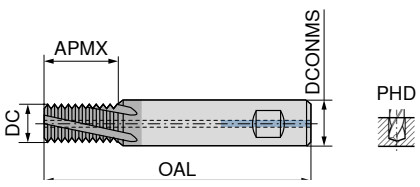
Steel	●
Stainless steel	●
Cast iron	●
Non ferrous metals	●
Heat resistant alloys	●
Hardened materials	●

1) DIN 6535 HA Shank / Without Through Coolant
2) Without Through Coolant

Thread milling cutter

▲ Profile corrected
▲ Hard machining to Ø DC = 4 mm possible

SGF | IR/IL | ≤ 2xD | 60° | MF



Ti500

WNT \ Standard

HB Solid carbide

DC mm	Thread	TP mm	APMX mm	DCONMS h6 mm	OAL mm	ZEFP	PHD mm	Article no.	£
4.0	M5	0.50	11	6	55	3	4.50	54 802 050 1)	71.95
4.8	M6	0.75	13	6	55	3	5.25	54 802 060 1)	71.95
6.0	M8	1.00	18	6	60	3	7.00	54 802 080	75.54
8.0	M10	1.25	21	8	70	3	8.75	54 802 100	91.33
9.9	M12	1.50	26	10	75	4	10.50	54 802 122	110.42
9.9	M12	1.25	26	10	75	4	10.75	54 802 121	110.42
9.9	M12	1.00	26	10	75	4	11.00	54 802 120	110.42
11.6	M14	1.50	30	12	85	4	12.50	54 802 141	127.85
11.6	M14	1.00	30	12	85	4	13.00	54 802 140	127.85
12.0	M16	1.50	34	12	85	4	14.50	54 802 160	133.66
14.0	M18	1.50	40	14	90	4	16.50	54 802 180	158.28
16.0	M20	1.50	42	16	90	4	18.50	54 802 200	164.37

Steel	●
Stainless steel	●
Cast iron	●
Non ferrous metals	●
Heat resistant alloys	●
Hardened materials	●

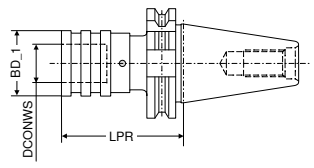
1) DIN 6535 HA Shank / Without Through Coolant

Please Note: G, UNF, NPT, BSF, BSW, Pg and UN also available in the main catalogue.

Quick change tap chuck with length compensation

▲ With length compensation under tension and compression (LZD)

WNT \ Standard



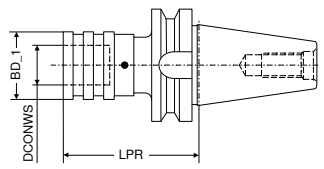
A

Adapter	cutting range	SZID	LPR mm	BD_1 mm	DCONWS mm	LZD± mm	Article no.	£
SK 30	M6 - M20	02	101	55	31	15	83 428 320	288.19
SK 30	M3 - M12	01	60	38	19	9	83 428 312	253.67
SK 40	M6 - M20	02	100	55	31	15	83 428 420	212.29
SK 40	M3 - M12	01	60	38	19	9	83 428 412	195.91
SK 50	M3 - M12	01	62	38	19	9	83 428 512	292.59
SK 50	M6 - M20	02	83	55	31	15	83 428 520	316.94

Quick change tap chuck with length compensation

▲ With length compensation under tension and compression (LZD)

WNT \ Standard



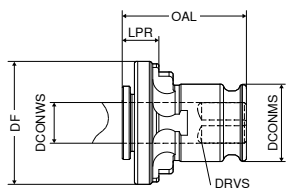
A

Adapter	cutting range	SZID	LPR mm	BD_1 mm	DCONWS mm	LZD± mm	Article no.	£
BT 30	M3 - M12	01	63	38	19	9	83 528 312	255.02
BT 30	M6 - M20	02	96	55	31	15	83 528 320	319.82
BT 40	M3 - M12	01	68	38	19	9	83 528 412	204.62
BT 40	M6 - M20	02	93	55	31	15	83 528 420	212.29
BT 50	M3 - M12	01	80	38	19	9	83 528 512	342.91
BT 50	M6 - M20	02	102	55	31	15	83 528 520	394.76

Quick change tap adapter

▲ Normal version without overload clutch
▲ For mounting taps
▲ For right-hand and left-hand threads

WNT \ Standard



A

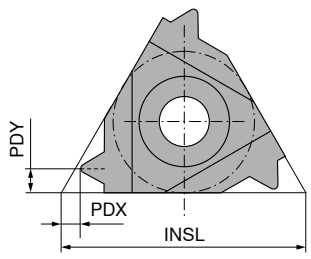
SZID	DCONWS mm	DRVS mm	DIN 371	DIN 374 / 376	DF mm	DCONMS mm	OAL mm	LPR mm	Article no.	£
01	3.5	2.7	M3		30	19	28.5	7	83 610 100	21.10
01	4.5	3.4	M4		30	19	28.5	7	83 610 101	21.10
01	4.0	3.0	M3,5		30	19	28.5	7	83 610 102	21.10
01	2.8	2.1	M2 - M2,6		30	19	28.5	7	83 610 103	21.10
01	5.5	4.3		M7	30	19	28.5	7	83 610 104	21.10
01	6.0	4.9	M4,5 - M6	M8	30	19	28.5	7	83 610 105	21.10
01	7.0	5.5	M7	M10	30	19	28.5	7	83 610 106	21.10
01	8.0	6.2	M8	M11	30	19	28.5	7	83 610 107	21.10
01	9.0	7.0	M9	M12	30	19	28.5	7	83 610 108	21.10
01	10.0	8.0	M10		30	19	28.5	7	83 610 109	21.10
01	11.0	9.0		M14	30	19	28.5	7	83 610 110	21.10
02	6.0	4.9	M4,5 - M6		46	31	46.0	11	83 610 200	29.01
02	7.0	5.5	M7		46	31	46.0	11	83 610 201	29.01
02	8.0	6.2	M8		46	31	46.0	11	83 610 202	29.01
02	9.0	7.0	M9		46	31	46.0	11	83 610 203	29.01
02	10.0	8.0	M10		46	31	46.0	11	83 610 204	29.01
02	11.0	9.0		M14	46	31	46.0	11	83 610 205	29.01
02	12.0	9.0		M16	46	31	46.0	11	83 610 206	29.01
02	14.0	11.0		M18	46	31	46.0	11	83 610 207	29.01
02	16.0	12.0		M20	46	31	46.0	11	83 610 208	29.01
02	18.0	14.5		M22 - M24	46	31	46.0	11	83 610 209	29.01

Right hand external thread turning insert

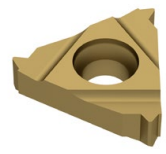
- Full profile
- CCN7525 grade with sintered chip breaker for universal application

M | MF | 60°

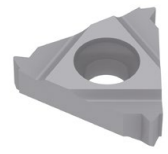
WNT \ Performance



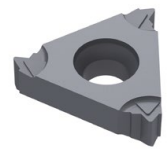
CWN1525



HCN2525

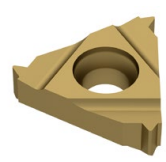


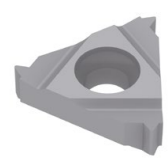
CCN7525

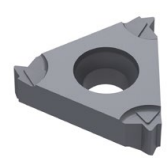


Designation	TP	INSL	PDX	PDY	ER Article no.	£	ER Article no.	£	ER Article no.	£
	mm	mm	mm	mm						
16 ER 0,35	0.35	16	0.8	0.4			71 220 734	15.27		
16 ER 0,4	0.40	16	0.7	0.4			71 220 736	15.27		
16 ER 0,5	0.50	16	0.6	0.6	71 220 140	10.48	71 220 740	11.89	71 220 940	11.89
16 ER 0,7	0.70	16	0.6	0.6	71 220 141	11.60	71 220 741	12.28		
16 ER 0,75	0.75	16	0.6	0.6	71 220 142	10.89	71 220 742	11.89	71 220 942	11.89
16 ER 0,8	0.80	16	0.6	0.6	71 220 143	10.89	71 220 743	11.89	71 220 943	11.89
16 ER 1,0	1.00	16	0.7	0.7	71 220 144	10.17	71 220 744	11.60	71 220 944	11.60
16 ER 1,25	1.25	16	0.8	0.9	71 220 146	10.17	71 220 746	11.60	71 220 946	11.60
16 ER 1,5	1.50	16	0.8	1.0	71 220 148	10.17	71 220 748	11.60	71 220 948	11.60
16 ER 1,75	1.75	16	0.9	1.2	71 220 150	10.17	71 220 750	11.60		
16 ER 2,0	2.00	16	1.0	1.3	71 220 152	10.17	71 220 752	11.60	71 220 952	11.60
16 ER 2,5	2.50	16	1.1	1.5	71 220 154	10.17	71 220 754	11.60	71 220 954	11.60
16 ER 3,0	3.00	16	1.2	1.6	71 220 156	10.17	71 220 756	11.60	71 220 956	11.60
22 ER 3,5	3.50	22	1.6	2.3	71 220 170	15.88	71 220 770	17.47		
22 ER 4,0	4.00	22	1.6	2.3	71 220 172	16.56	71 220 772	18.42		
22 ER 4,5	4.50	22	1.7	2.4	71 220 174	17.86	71 220 774	19.45		
22 ER 5,0	5.00	22	1.7	2.5	71 220 176	17.86	71 220 776	19.45		
22 ER 5,5	5.50	22	1.7	2.6	71 220 178	17.86				
22 ER 6,0	6.00	22	1.9	2.7	71 220 180	17.86	71 220 780	19.45		

BSW | 55°

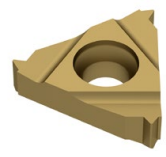


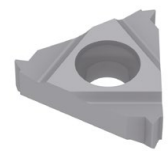


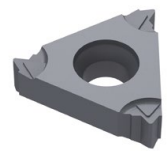


Designation	TPI	INSL	PDX	PDY	ER Article no.	£	ER Article no.	£	ER Article no.	£
	1/"	mm	mm	mm						
16 ER 11	11	16	1.1	1.5	71 228 166	11.87	71 228 766	13.34	71 228 966	13.34
16 ER 12	12	16	1.1	1.4	71 228 164	14.47	71 228 764	15.96		
16 ER 14	14	16	1.0	1.2	71 228 162	11.87	71 228 762	13.34	71 228 962	13.34
16 ER 16	16	16	0.9	1.1	71 228 160	14.47	71 228 760	15.96		
16 ER 19	19	16	0.8	1.0	71 228 156	11.87	71 228 756	13.34	71 228 956	13.34
16 ER 20	20	16	0.8	0.9			71 228 754	17.47		
16 ER 26	26	16	0.7	0.7			71 228 748	17.47		
16 ER 28	28	16	0.6	0.7	71 228 146	13.17	71 228 746	14.64		

UN | UNC | UNEF | UNF | 60°







Designation	TPI	INSL	PDX	PDY	ER Article no.	£	ER Article no.	£	ER Article no.	£
	1/"	mm	mm	mm						
16 ER 8	8	16	1.1	1.5	71 264 174	16.26				
16 ER 8	8	16	1.1	1.1					71 264 974	17.47
16 ER 11	11	16	1.1	1.5	71 264 168	16.26				
16 ER 12	12	16	1.1	1.4	71 264 164	13.17	71 264 764	14.64		
16 ER 14	14	16	1.0	1.2	71 264 160	13.17	71 264 760	14.64		
16 ER 16	16	16	0.9	1.1	71 264 158	12.46	71 264 758	13.94	71 264 958	13.94
16 ER 18	18	16	0.8	1.0	71 264 156	13.17	71 264 756	14.64		
16 ER 20	20	16	0.8	0.9	71 264 154	12.46	71 264 754	13.94	71 264 954	13.94
16 ER 24	24	16	0.7	0.8	71 264 152	13.17	71 264 752	14.64		
16 ER 28	28	16	0.6	0.7			71 264 748	15.96		
16 ER 32	32	16	0.6	0.6			71 264 746	17.09		

Steel	●	○	●
Stainless steel	○	●	●
Cast iron	●	○	●
Non ferrous metals	●	○	○
Heat resistant alloys		○	●

Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

FreeTurn

Be part of the
FreeTurn generation!

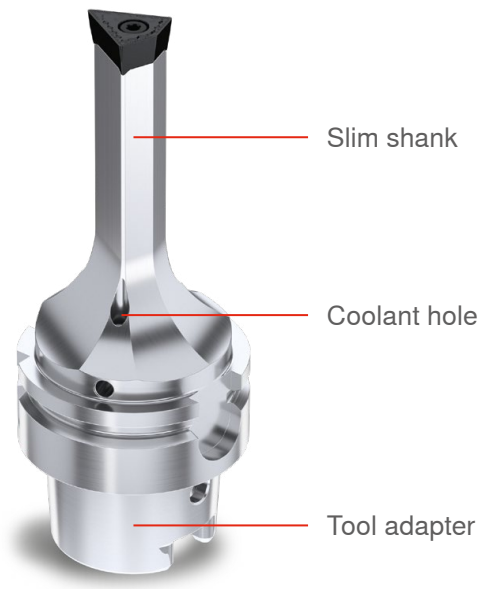
Multi-award-winning:

MM MaschinenMarkt AWARD zur AMB 2018

BEST OF INDUSTRY AWARD

High Dynamic Turning (HDT)

With High Dynamic Turning, HDT for short, and the dynamic FreeTurn turning tools, CERATIZIT is turning the conventional method of turning completely on its head. All familiar turning operations such as roughing, finishing, contour turning, facing and longitudinal turning can now be completed using just one tool.



Conventional application: **5 tools**

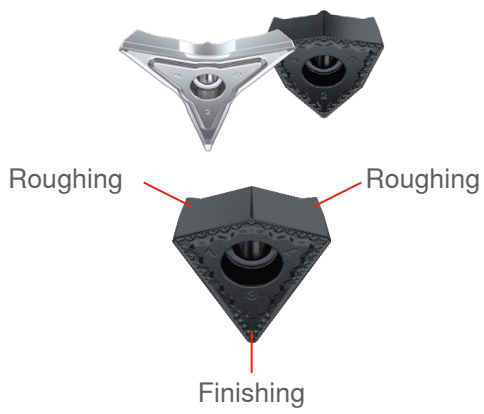
Application with FreeTurn: **1 tool**

Productivity

- Almost all workpiece contours can be machined
- 40 % higher feed rate value
- Up to 90 % fewer empty runs
- Adjustable feed rates during the process
- Improved surface quality thanks to ideal adjustment of the approach angle
- The versatility of the FreeTurn means fewer tool changes
- Fewer tool spaces required in the machine

Flexibility

- Turning with just one tool
- Huge savings on tool types
- No tool changes = huge time savings
- Indexable inserts with up to three ISO geometries can be used on one holder
- An indexable insert with multiple cutters can consist of different point angles, flanging radii, chip breakers, coatings and cutting materials and can be customised for use.

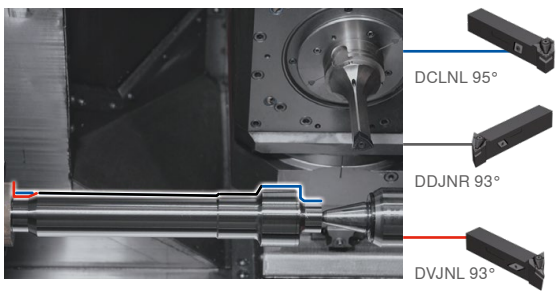


Time comparison

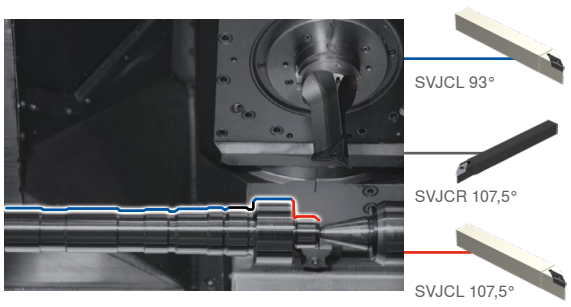
Material 42CrMo4

Dynamic cutting parameters in the process based on catalogue cutting data

Roughing



Finishing



Conventional production

Conventional production time for a single part with six different tools

= 3:32 minutes

Production with FreeTurn

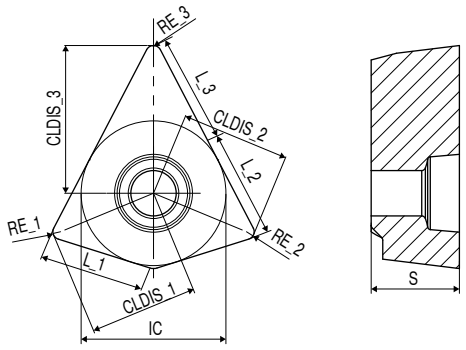
Production time for a single part with the HDT

= 2:50 minutes

25 %
Time savings

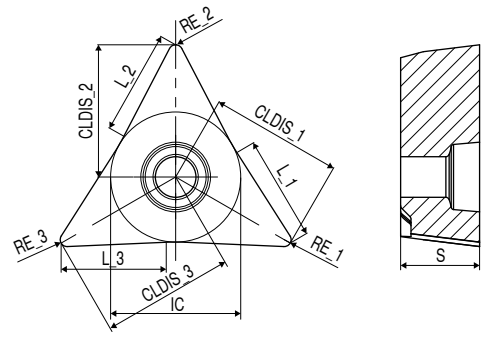
Follow our video:
A time comparison between conventional machining and the HDT. You'll be amazed!

FT15 . 808055...



Designation	IC	CLDIS_1	L_1	CLDIS_2	L_2	CLDIS_3	L_3	S
	mm	mm	mm	mm	mm	mm	mm	mm
FT15 M 808055R080804-MMF	15	11.22	10.8	11.22	11.4	15.78	11.4	9.14
FT15 M 808055R08-MMF	15	11.22	10.8	11.22	11.2	15.31	11.2	9.14
FT15 M 808055R121208-MMF	15	11.00	10.7	11.00	11.2	15.31	11.2	9.14

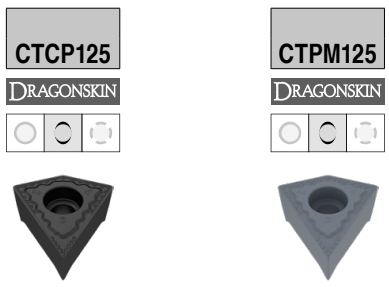
FT15 . 555555...



Designation	IC	CLDIS_1	L_1	CLDIS_2	L_2	CLDIS_3	L_3	S
	mm	mm	mm	mm	mm	mm	mm	mm
FT15 M 555555R04-FFF	15	15.78	12.6	15.78	12.6	15.78	12.6	9.14
FT15 M 555555R08-FFF	15	15.31	12.3	15.31	12.3	15.31	12.3	9.14

FT15 . 808055...

CERATIZIT \ Performance

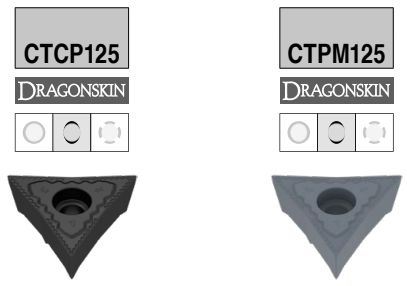


ISO	RE_1	RE_2	RE_3	M M F NEW Article no.	£	M M F NEW Article no.	£
	mm	mm	mm				
FT15 M 808055R080804-MMF	0.8	0.8	0.4	74 003 00400	15.66		
FT15 M 808055R08-MMF	0.8	0.8	0.8	74 003 00200	15.66	74 003 10200	15.66
FT15 M 808055R121208-MMF	1.2	1.2	0.8	74 003 00600	15.66		

Steel	●	○
Stainless steel	○	●
Cast iron	○	
Non ferrous metals		
Heat resistant alloys		

FT15 . 555555...

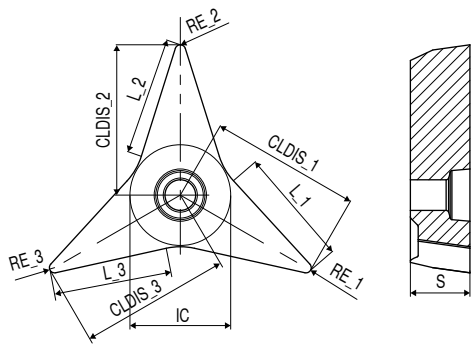
CERATIZIT \ Performance



ISO	RE_1	RE_2	RE_3	F F F NEW Article no.	£	F F F NEW Article no.	£
	mm	mm	mm				
FT15 M 555555R04-FFF	0.4	0.4	0.4	74 002 00200	13.47		
FT15 M 555555R08-FFF	0.8	0.8	0.8	74 002 00400	13.47	74 002 10400	13.47

Steel	●	○
Stainless steel	○	●
Cast iron	○	
Non ferrous metals		
Heat resistant alloys		

FT15 . 353535...



Designation	IC	CLDIS_1	L_1	CLDIS_2	L_2	CLDIS_3	L_3	S
	mm	mm	mm	mm	mm	mm	mm	mm
FT15 G 353535R04-28P	15	24.01	16.1	24.01	16.1	24.01	16.1	9.14
FT15 G 353535R08-28P	15	23.08	15.2	23.08	15.2	23.08	15.2	9.14

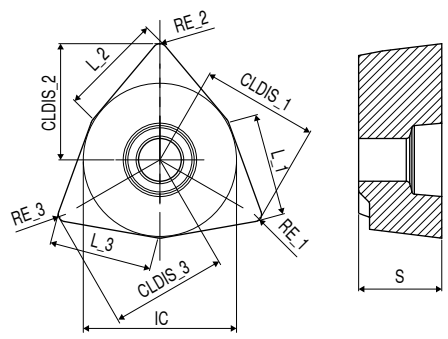
FT15 . 353535...

CERATIZIT \ Performance

ISO	RE_1	RE_2	RE_3	F F F NEW Article no.	£
	mm	mm	mm		
FT15 G 353535R04-28P	0.4	0.4	0.4	74 001 20200	26.17
FT15 G 353535R08-28P	0.8	0.8	0.8	74 001 20400	26.17

Steel	
Stainless steel	
Cast iron	
Non ferrous metals	●
Heat resistant alloys	

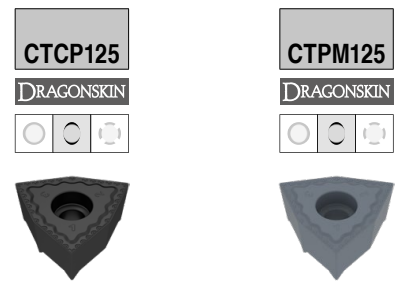
FT17 . 808080...



Designation	IC	CLDIS_1	L_1	CLDIS_2	L_2	CLDIS_3	L_3	S
	mm	mm	mm	mm	mm	mm	mm	mm
FT17 M 808080R04-MMM	17	13.00	11.3	13.00	11.3	13.00	11.3	9.14
FT17 M 808080R08-MMM	17	12.78	11.3	12.78	11.3	12.78	11.3	9.14
FT17 M 808080R12-MMM	17	12.56	11.2	12.56	11.2	12.56	11.2	9.14

FT17 . 808080...

CERATIZIT \ Performance



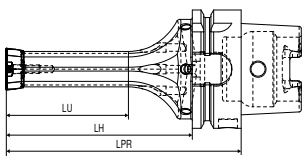
ISO	RE_1	RE_2	RE_3	M M M NEW Article no.	£	M M M NEW Article no.	£
	mm	mm	mm				
FT17 M 808080R04-MMM	0.4	0.4	0.4	74 000 00200	18.07		
FT17 M 808080R08-MMM	0.8	0.8	0.8	74 000 00400	18.07	74 000 10400	18.07
FT17 M 808080R12-MMM	1.2	1.2	1.2	74 000 00600	18.07		

Steel	●	○
Stainless steel	○	●
Cast iron	○	
Non ferrous metals		
Heat resistant alloys		

FreeTurn – HSK-T tool holder FT15

- Tool holder for FreeTurn indexable insert
- DirectCooling coolant supply

CERATIZIT \ Performance



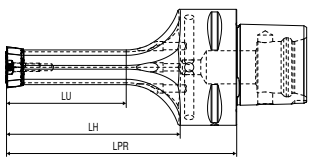
Figures show version FT15 . 808055...

ISO designation	Adapter	LPR	LH	LU	Insert	NEW Article no.	
		mm	mm	mm			£
HSK-T63-100-FT15 353535	HSK-T 63	100	74	40	FT15 . 353535...	74 700 00137	505.76
HSK-T63-100-FT15 555555	HSK-T 63	100	74	40	FT15 . 555555...	74 700 00337	505.76
HSK-T63-100-FT15 808055	HSK-T 63	100	74	40	FT15 . 808055...	74 700 00537	505.76
HSK-T63-125-FT15 353535	HSK-T 63	125	99	65	FT15 . 353535...	74 700 00237	514.81
HSK-T63-125-FT15 555555	HSK-T 63	125	99	65	FT15 . 555555...	74 700 00437	514.81
HSK-T63-125-FT15 808055	HSK-T 63	125	99	65	FT15 . 808055...	74 700 00637	514.81

FreeTurn – PSC tool holder FT15

- Tool holder for FreeTurn indexable insert
- DirectCooling coolant supply

CERATIZIT \ Performance



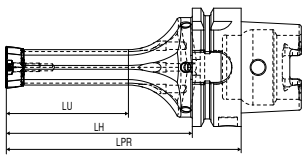
Figures show version FT15 . 808055...

ISO designation	Adapter	LPR	LH	LU	Insert	NEW Article no.	
		mm	mm	mm			£
PSC-63-100-FT15 353535	PSC 63	100	69.4	40	FT15 . 353535...	74 700 00193	587.20
PSC-63-100-FT15 555555	PSC 63	100	69.6	40	FT15 . 555555...	74 700 00393	587.20
PSC-63-100-FT15 808055	PSC 63	100	69.3	40	FT15 . 808055...	74 700 00593	587.20
PSC-63-125-FT15 353535	PSC 63	125	94.4	65	FT15 . 353535...	74 700 00293	596.24
PSC-63-125-FT15 555555	PSC 63	125	94.6	65	FT15 . 555555...	74 700 00493	596.24
PSC-63-125-FT15 808055	PSC 63	125	94.3	65	FT15 . 808055...	74 700 00693	596.24

FreeTurn – HSK-T tool holder FT17

- Tool holder for FreeTurn indexable insert
- DirectCooling coolant supply

CERATIZIT \ Performance

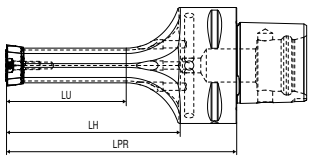


ISO designation	Adapter	LPR	LH	LU	Insert	NEW Article no.	
		mm	mm	mm			£
HSK-T63-100-FT17 808080	HSK-T 63	100	74	40	FT17 . 808080...	74 701 00737	505.76
HSK-T63-125-FT17 808080	HSK-T 63	125	99	65	FT17 . 808080...	74 701 00837	514.81

FreeTurn – PSC tool holder FT17

- Tool holder for FreeTurn indexable insert
- DirectCooling coolant supply

CERATIZIT \ Performance



ISO designation	Adapter	LPR	LH	LU	Insert	NEW Article no.	
		mm	mm	mm			£
PSC-63-100-FT17 808080	PSC 63	100	69.3	40	FT17 . 808080...	74 701 00793	587.20
PSC-63-125-FT17 808080	PSC 63	125	94.3	65	FT17 . 808080...	74 701 00893	596.24

Spare parts

Clamping screw

Adapter			Article no.
		£	
HSK-T 63+PSC	M4,5x18 - IP	6.64	70 950 25900

Cutting data standard values

	Index	Material	Strength N/mm² / HB / HRC	F DRAGONSKIN CTCP125 v_c in m/min	F DRAGONSKIN CTPM125 v_c in m/min	M DRAGONSKIN CTCP125 v_c in m/min	M DRAGONSKIN CTPM125 v_c in m/min	-28P DRAGONSKIN H216T v_c in m/min
P	1.1	General construction steel	< 800 N/mm²	**200–270**	120–260	**200–260**	120–250	
P	1.2	Free cutting steel	< 800 N/mm²	**230–280**	130–220	**230–280**	120–220	
P	1.3	Hardened steel, non alloyed	< 800 N/mm²	**240–290**	130–250	**240–290**	120–250	
P	1.4	Alloyed hardened steel	< 1000 N/mm²	**200–270**	130–220	**200–250**	130–200	
P	1.5	Tempering steel, unalloyed	< 850 N/mm²	**220–260**	100–180	**210–250**	100–170	
P	1.6	Tempering steel, unalloyed	< 1000 N/mm²	**210–250**	100–180	**190–240**	100–170	
P	1.7	Tempering steel, alloyed	< 800 N/mm²	**210–280**	60–180	**200–270**	50– 160	
P	1.8	Tempering steel, alloyed	< 1300 N/mm²	**190–240**	60–180	**180–230**	50– 160	
P	1.9	Steel castings	< 850 N/mm²	**170–240**	80–180	**160–220**	60– 160	
P	1.10	Nitriding steel	< 1000 N/mm²	**180–240**	100–180	**180–230**	100–180	
P	1.11	Nitriding steel	< 1200 N/mm²	**170–240**	100–180	**170–240**	80–180	
P	1.12	Roller bearing steel	< 1200 N/mm²	**200–270**	80–180	**190–260**	70–170	
P	1.13	Spring steel	< 1200 N/mm²	**170–240**	60–180	**170–230**	60–170	
P	1.14	High-speed steel	< 1300 N/mm²	**180–230**	80–180	**170–210**	70–160	
P	1.15	Cold working tool steel	< 1300 N/mm²	**150–230**	80–150	**130–220**	60–120	
P	1.16	Hot working tool steel	< 1300 N/mm²	**140–220**	80–150	**130–220**	60–120	
M	2.1	Cast steel and sulphured stainless steel	< 850 N/mm²	200–280	**200–280**	200–280	**120–280**	
M	2.2	Stainless steel, ferritic	< 750 N/mm²	200–280	**200–280**	200–280	**120–280**	
M	2.3	Stainless steel, martensitic	< 900 N/mm²	190–260	**190–260**	190–260	**120–260**	
M	2.4	Stainless steel, ferritic / martensitic	<1100 N/mm²	190–240	**190–240**	190–240	**120–240**	
M	2.5	Stainless steel, austenitic / ferritic	< 850 N/mm²		**100–220**		**100–220**	
M	2.6	Stainless steel, austenitic	< 750 N/mm²		**100–220**		**100–220**	
M	2.7	Heat resistant steel	< 1100 N/mm²		**40–100**		**40–100**	
K	3.1	Grey cast iron with lamellar graphite	100–350 N/mm²	200–260		120–210		
K	3.2	Grey cast iron with lamellar graphite	300–500 N/mm²	190–250		160–200		
K	3.3	Gray cast iron with spheroidal graphite	300–500 N/mm²	170–240		150–200		
K	3.4	Gray cast iron with spheroidal graphite	500–900 N/mm²	140–190		130–190		
K	3.5	White malleable cast iron	270–450 N/mm²	240–290		160–230		
K	3.6	White malleable cast iron	500–650 N/mm²	170–290		150–210		
K	3.7	Black malleable cast iron	300–450 N/mm²	240–290		160–230		
K	3.8	Black malleable cast iron	500–800 N/mm²	170–290		150–210		
N	4.1	Aluminium (non alloyed, low alloyed)	< 350 N/mm²					**300–2500**
N	4.2	Aluminium alloys < 0.5 % Si	< 500 N/mm²					**200–2000**
N	4.3	Aluminium alloy 0.5–10 % Si	< 400 N/mm²					**400–1500**
N	4.4	Aluminium alloys 10–15 % Si	< 400 N/mm²					**400–1500**
N	4.5	Aluminum alloys > 15 % Si	< 400 N/mm²					**200–800**
N	4.6	Copper (non alloyed, low alloyed)	< 350 N/mm²					**150–300**
N	4.7	Copper wrought alloys	< 700 N/mm²					**150–400**
N	4.8	Special copper alloys	< 200 HB					**150–400**
N	4.9	Special copper alloys	< 300 HB					**150–400**
N	4.10	Special copper alloys	> 300 HB					**150–400**
N	4.11	Short-chipping brass, bronze, red bronze	< 600 N/mm²					**200–600**
N	4.12	Long-chipping brass	< 600 N/mm²					**150–400**
N	4.13	Thermoplastics						**100–200**
N	4.14	Duroplastics						**80–180**
N	4.15	Fibre-reinforced plastics						**60–150**
N	4.16	Magnesium and magnesium alloys	< 850 N/mm²					
N	4.17	Graphite						
N	4.18	Tungsten and tungsten alloys						
N	4.19	Molybdenum and molybdenum alloys						**100–140**

-F

RE	f min.	f Recom-mended	f max.	a_p min.	a_p Recom-mended	a_p max.
mm		mm/rev.			mm	
0,4	0,07	**0,15**	0,22	0,2	**1**	2
0,8	0,1	**0,2**	0,3	0,4	**1,4**	2,6
1,2						

-M

RE	f min.	f Recom-mended	f max.	a_p min.	a_p Recom-mended	a_p max.
mm		mm/rev.			mm	
0,4	0,1	**0,17**	0,25	0,3	**1,3**	2,5
0,8	0,15	**0,25**	0,4	0,5	**2**	3,2
1,2	0,17	**0,3**	0,5	0,5	**2,5**	3,5

-M

RE	f min.	f Recom-mended	f max.	a_p min.	a_p Recom-mended	a_p max.
mm		mm/rev.			mm	
0,4	0,1	**0,15**	0,22	0,3	**1,3**	2,5
0,8	0,15	**0,22**	0,35	0,5	**2**	3,2
1,2	0,17	**0,25**	0,4	0,5	**2,5**	3,5

-F

RE	f min.	f Recom-mended	f max.	a_p min.	a_p Recom-mended	a_p max.
mm		mm/rev.			mm	
0,4	0,07	**0,12**	0,2	0,2	**1**	2
0,8	0,1	**0,17**	0,27	0,4	**1,4**	2,6
1,2						

-28P

RE	f min.	f Recom-mended	f max.	a_p min.	a_p Recom-mended	a_p max.
mm		mm/rev.			mm	
0,4	0,07	**0,15**	0,25	0,3	**1,5**	3,5
0,8	0,15	**0,25**	0,4	0,5	**2**	3,5
1,2						

Correction Factor

Feedrate f [mm/U] should be multiplied by correction factor f_k

Approach angle	Correction Factor
◁	f_k
95° – 120°	0,90
85° – 95°	1,00
85° – 65°	1,10
65° – 30°	1,20

The cutting data depends extremely on the external conditions, e.g. stability of the tool and tool clamping, material and machine type. The indicated values are possible cutting data which have to be increased or reduced according to the application conditions.

X7-Line

Grade description

CTP X7 10/15

Degree of hardness

10	ISO 10
15	ISO 15
...	

Main application – material

P	Steel
M	Stainless steel
K	Cast iron
N	Light and non ferrous metals
S	Super alloys, titanium
H	Hard materials
X	**Universal application**

Application

1	Turning
2	Milling
3	Grooving
4	Drilling
5	Thread turning
6	Others
7	Multiple procedures*

Universal application range

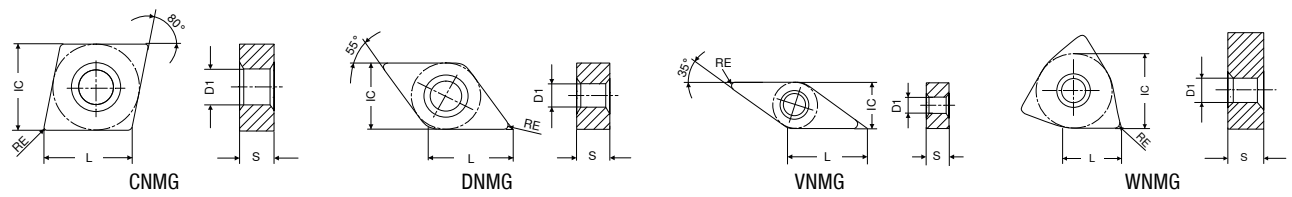
P M K N S

*In future multiple procedures possible
turning | grooving | milling

Further information on the product can be found in the UP2DATE January catalogue on page 28–43

CNMG / DNMG / VNMG / WNMG

Designation	L	S	D1	IC
	mm	mm	mm	mm
CNMG 1204..	12.9	4.76	5.16	12.70
DNMG 1504..	15.5	4.76	5.16	12.70
VNMG 1604..	16.6	4.76	3.81	9.52
WNMG 0804..	8.6	4.76	5.16	12.70

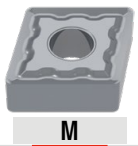


CNMG

CERATIZIT \ Performance

-M34 CTPX710

DRAGONSKIN



ISO	RE mm	M NEW Article no.	£
120404EN	0.4	75 003 62800	8.39
120408EN	0.8	75 003 63000	8.39
120412EN	1.2	75 003 63200	8.39
120416EN	1.6	75 003 63400	8.39

Steel	●
Stainless steel	●
Cast iron	○
Non ferrous metals	○
Heat resistant alloys	●

VNMG

CERATIZIT \ Performance

-M34 CTPX710

DRAGONSKIN

ISO	RE mm	M NEW Article no.	£
160404EN	0.4	75 009 61600	14.41
160408EN	0.8	75 009 61800	14.41
160412EN	1.2	75 009 62000	14.41

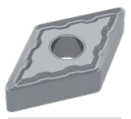
Steel	●
Stainless steel	●
Cast iron	○
Non ferrous metals	○
Heat resistant alloys	●

DNMG

CERATIZIT \ Performance

-M34 CTPX710

DRAGONSKIN



ISO	RE mm	M NEW Article no.	£
150404EN	0.4	75 004 61600	11.59
150408EN	0.8	75 004 61800	11.59
150412EN	1.2	75 004 62000	11.59
150608EN	0.8	75 004 63000	12.59
150612EN	1.2	75 004 63200	12.59

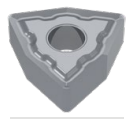
Steel	●
Stainless steel	●
Cast iron	○
Non ferrous metals	○
Heat resistant alloys	●

WNMG

CERATIZIT \ Performance

-M34 CTPX710

DRAGONSKIN



ISO	RE mm	M NEW Article no.	£
080408EN	0.8	75 008 61800	9.99
080412EN	1.2	75 008 62000	9.99

Steel	●
Stainless steel	●
Cast iron	○
Non ferrous metals	○
Heat resistant alloys	●

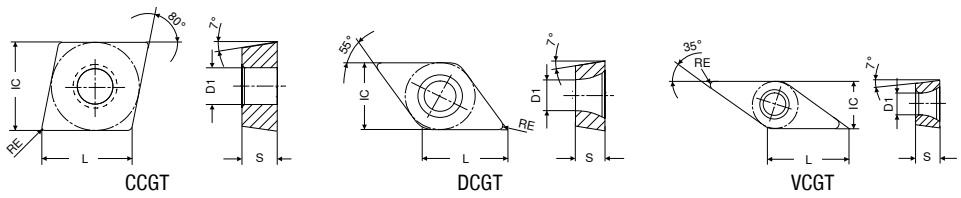
Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

CCGT / DCGT / VCGT

Designation	L	S	D1	IC
	mm	mm	mm	mm
CCGT 0602..	6.40	2.38	2.8	6.35
CCGT 09T3..	9.70	3.97	4.4	9.52
CCGT 1204..	12.90	4.76	5.5	12.70
DCGT 0702..	7.75	2.38	2.8	6.35
DCGT 11T3..	11.60	3.97	4.4	9.52
VCGT 1103..	11.10	3.18	2.9	6.35
VCGT 1604..	16.60	4.76	4.4	9.52
VCGT 2205..	22.10	5.56	5.5	12.70



CCGT

CERATIZIT \ Performance

ISO	RE mm	-27 CTPX715 DRAGONSKIN M NEW Article no.	£	-25Q CTPX710 DRAGONSKIN M NEW Article no.	£	-25P CTPX710 DRAGONSKIN M NEW Article no.	£
060202FN	0.2	70 254 80200	9.93			70 248 70200	10.28
060204FN	0.4	70 254 80400	9.93	70 248 75400	12.41	70 248 70400	10.28
09T302FN	0.2	70 254 81400	10.28			70 248 71400	10.99
09T304FN	0.4	70 254 81600	10.28	70 248 76600	12.77	70 248 71600	10.99
09T308FN	0.8	70 254 81800	10.28	70 248 76800	12.77	70 248 71800	10.99
120402FN	0.2	70 254 82600	12.41				
120404FN	0.4	70 254 82800	12.41	70 248 77800	14.25	70 248 72800	13.12
120408FN	0.8	70 254 83000	12.41	70 248 78000	14.25	70 248 73000	13.12
Steel		●		●		●	
Stainless steel		●		●		●	
Cast iron		○		○		○	
Non ferrous metals		●		●		●	
Heat resistant alloys		●		●		●	

DCGT

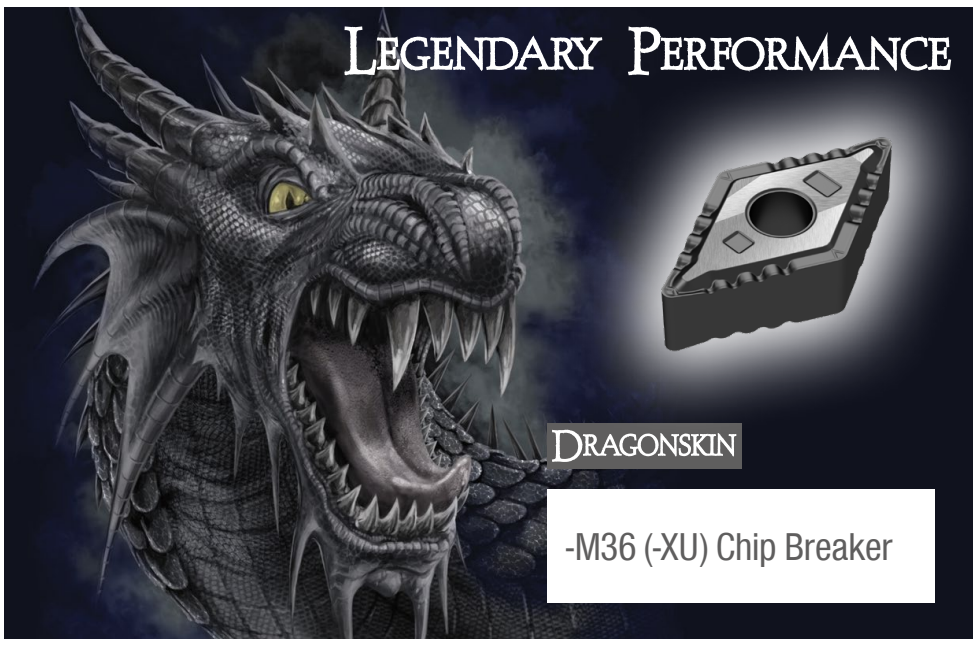
CERATIZIT \ Performance

ISO	RE mm	-27 CTPX715 DRAGONSKIN M NEW Article no.	£	-25Q CTPX710 DRAGONSKIN M NEW Article no.	£	-25P CTPX710 DRAGONSKIN M NEW Article no.	£
070202FN	0.2	70 260 80200	9.29			70 263 70200	9.86
070204FN	0.4	70 260 80400	9.29			70 263 70400	9.86
11T302FN	0.2	70 260 81400	10.99			70 263 71400	11.42
11T304FL	0.4			70 263 75700	13.12		
11T304FN	0.4	70 260 81600	10.99	70 263 75600	13.12	70 263 71600	11.42
11T304FR	0.4			70 263 75800	13.12		
11T308FN	0.8	70 260 81800	10.99	70 263 76000	13.12	70 263 71800	11.42
Steel		●		●		●	
Stainless steel		●		●		●	
Cast iron		○		○		○	
Non ferrous metals		●		●		●	
Heat resistant alloys		●		●		●	

VCGT

CERATIZIT \ Performance

ISO	RE mm	-25P CTPX710 DRAGONSKIN M NEW Article no.	£	-27 CTPX715 DRAGONSKIN M NEW Article no.	£
110302FN	0.2	70 282 71400	13.54	70 280 81400	13.33
110304FN	0.4	70 282 71600	13.54	70 280 81600	13.33
160404FN	0.4	70 282 72800	16.46	70 280 82800	15.20
160408FN	0.8	70 282 73000	16.46	70 280 83000	15.81
160412FN	1.2	70 282 73200	16.46		
220530FN	3.0	70 282 75000	22.19		
Steel		●		●	
Stainless steel		●		●	
Cast iron		○		○	
Non ferrous metals		●		●	
Heat resistant alloys		●		●	



CERATIZIT -M36 (-XU) chip breaker

The -M36 (-XU) chip breaker is for close contour machining and general turning with varying depth of cut ideally up to light roughing and covers a very large machining range.
In Europe-wide market testing the -M36 (-XU) showed itself as a problem solver for materials and applications where perfect chip breaking is required.
The -M36 (-XU) focus is on long chipping materials and guarantees highest process reliability.

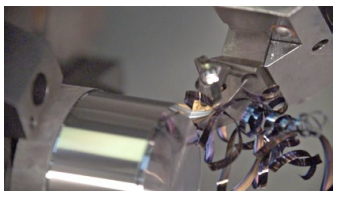
Advantages/Benefits

- Optimum process reliability for turning centers and unmanned production
- Secure transport of chips and small space requirement for swarf
- Reduced downtime and tooling costs
- Minimized risk of injury from stringing swarf

Field test reports

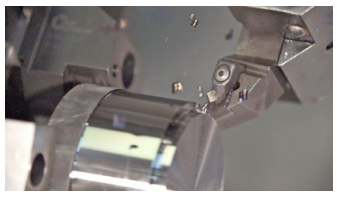
Steel CK60 1.1221 AISt 1060

Competitor



v_c = 160 m/min
a_p = 5.0 mm
f = 0.35 mm/U

CERATIZIT Dragonskin CTCP125 (HCX1125) -M36 (-XU)



v_c = 160 m/min
a_p = 5.0 mm
f = 0.35 mm/U

Application

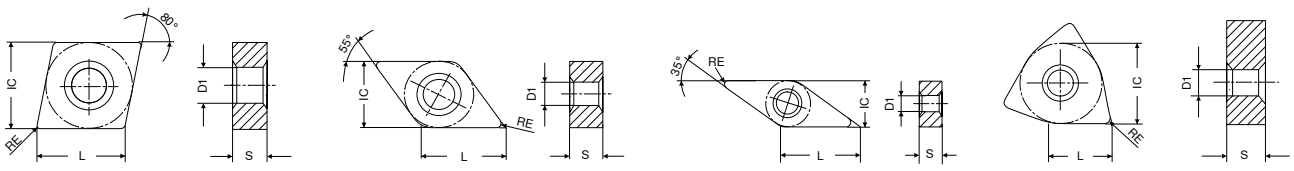
- Finishing to light roughing
- Steel
- Universal chip breaker
- Low cutting forces
- Ideally suited to general turning
- Draw turning
- For chip breaking problems

Turning guide (Main catalogue 2019)

Cutting Data	144–159	Chip breakers	168–175
ISO designation system	178–183	Grade overview and description	186+187

CNMG / DNMG / VNMG / WNMG

Designation	L	S	D1	IC
	mm	mm	mm	mm
CNMG 1204..	12.9	4.76	5.16	12.70
DNMG 1506..	15.5	6.35	5.16	12.70
VNMG 1604..	16.6	4.76	3.81	9.52
WNMG 0804..	8.6	4.76	5.16	12.70



CNMG

CERATIZIT \ Performance

ISO	RE mm	-M36 CTCP115 -XU HCX1115 M Article no.	£	-M36 CTCP125 -XU HCX1125 M Article no.	£
120404EN	0.4	76 290 328	7.82	76 290 528	7.82
120408EN	0.8	76 290 330	7.82	76 290 530	7.82
120412EN	1.2	76 290 332	7.82	76 290 532	7.82

Steel	●	●
Stainless steel	○	○
Cast iron	○	○
Non ferrous metals		
Heat resistant alloys		

VNMG

CERATIZIT \ Performance

ISO	RE mm	-M36 CTCP115 -XU HCX1115 M Article no.	£	-M36 CTCP125 -XU HCX1125 M Article no.	£
160404EN	0.4	76 294 316	14.00	76 294 516	14.00
160408EN	0.8	76 294 318	14.00	76 294 518	14.00

Steel	●	●
Stainless steel	○	○
Cast iron	○	○
Non ferrous metals		
Heat resistant alloys		

DNMG

CERATIZIT \ Performance

ISO	RE mm	-M36 CTCP115 -XU HCX1115 M Article no.	£	-M36 CTCP125 -XU HCX1125 M Article no.	£
150604EN	0.4	76 291 328	10.91	76 291 528	10.91
150608EN	0.8	76 291 330	10.91	76 291 530	10.91
150612EN	1.2	76 291 332	10.91	76 291 532	10.91

Steel	●	●
Stainless steel	○	○
Cast iron	○	○
Non ferrous metals		
Heat resistant alloys		

WNMG

CERATIZIT \ Performance

ISO	RE mm	-M36 CTCP115 -XU HCX1115 M Article no.	£	-M36 CTCP125 -XU HCX1125 M Article no.	£
080404EN	0.4	76 295 316	8.55	76 295 516	8.55
080408EN	0.8	76 295 318	8.55	76 295 518	8.55
080412EN	1.2	76 295 320	8.55	76 295 520	8.55

Steel	●	●
Stainless steel	○	○
Cast iron	○	○
Non ferrous metals		
Heat resistant alloys		

Technical support: 0800 073 2 075
3 time served engineers, available from 8:00 am to 6:30 pm, Monday to Friday

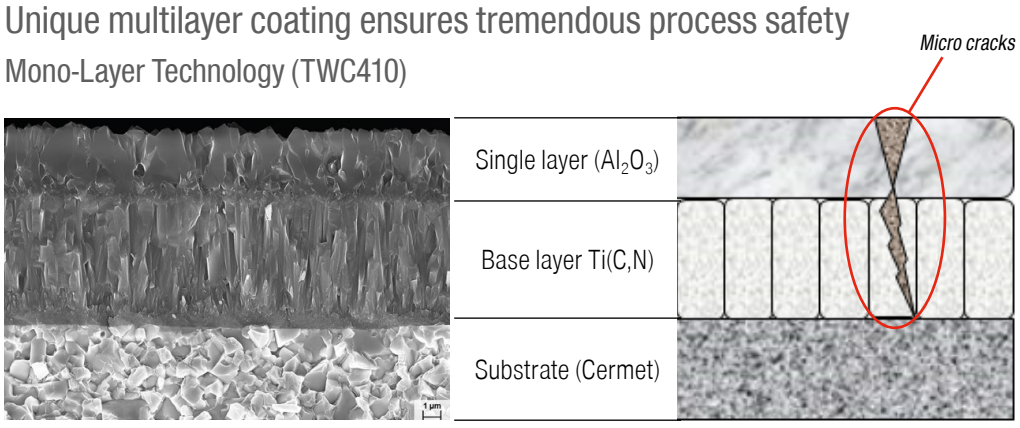
Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

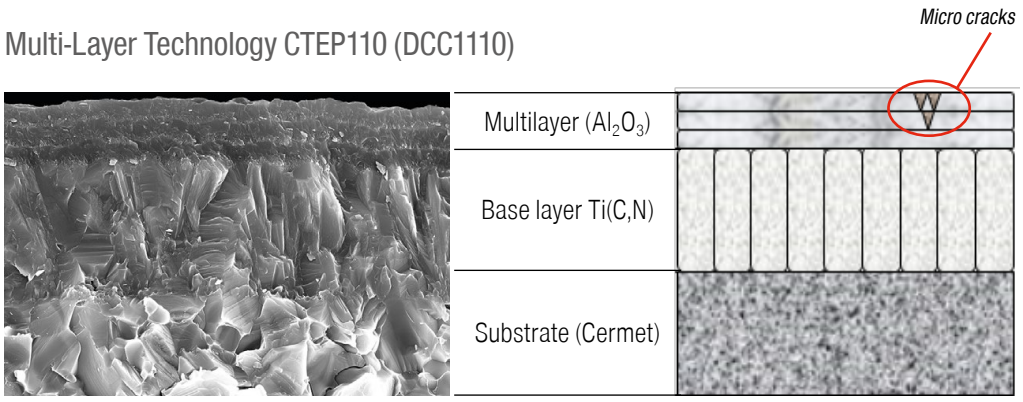
Unique multilayer coating ensures tremendous process safety

Mono-Layer Technology (TWC410)



The monolayer structure allows cracks to penetrate to the base substrate.

Multi-Layer Technology CTEP110 (DCC1110)



Due to the multilayer coating structure, the formation of cracks between the layers is stopped.

Turning Inserts – Cermet Grade CTEP110 (DCC1110)

The more powerful CTEP110 (DCC1110) grade replaces the TWC410 and TWC10 grades in our cermet range. The combination of the latest CVD coating technology and proven cermet substrate produces a very high wear resistance with unprecedented toughness. This offers significant advantages in terms of performance and service life of the inserts compared to the TWC410 and TWC10 grades.

Advantages/Benefits

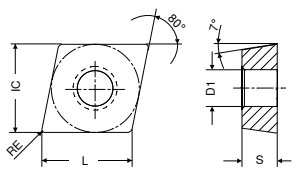
- Combination of the proven cermet substrate and the latest PVD coating technology
- Unique multilayer nano coating
- Combines very high wear resistance and unprecedented toughness
- Optimized chip breakers

Turning guide (Main catalogue 2019)

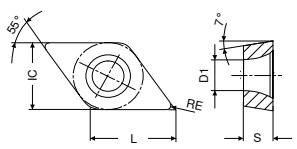
Cutting Data	144–159	Chip breakers	168–175
ISO designation system	178–183	Grade overview and description	186+187

CCMT / CCGT / DCGT / DCMT

Designation	L	S	D1	IC
	mm	mm	mm	mm
CC.T 0602..	6.40	2.38	2.8	6.35
CC.T 09T3..	9.70	3.97	4.4	9.52
CCMT 1204..	12.90	4.76	5.5	12.70
DC.T 0702..	7.75	2.38	2.8	6.35
DC.T 11T3..	11.60	3.97	4.4	9.52



CCMT / CCGT



DCGT / DCMT

CCMT / CCGT

CERATIZIT \ Performance

ISO	RE mm	-CF55 CTEP110 -PF15 DCC1110 CCMT F Article no.	£	-CF05 CTEP110 -PF14 DCC1110 CCGT F Article no.	£
060202EN	0.2			76 247 002	9.45
060204EN	0.4	76 248 004	5.14	76 247 004	9.45
09T302EN	0.2			76 247 014	10.07
09T304EN	0.4	76 248 016	6.60	76 247 016	10.07
09T308EN	0.8	76 248 018	6.60	76 247 018	10.07
120404EN	0.4	76 248 028	9.32		
Steel		●		●	
Stainless steel		○		○	
Cast iron		○		○	
Non ferrous metals					
Heat resistant alloys					

DCGT / DCMT

CERATIZIT \ Performance

ISO	RE mm	-CF05 CTEP110 -PF14 DCC1110 DCGT F Article no.	£	-CF55 CTEP110 -PF15 DCC1110 DCMT F Article no.	£
070202EN	0.2	76 245 002	9.45	76 246 002	5.36
070204EN	0.4	76 245 004	9.45	76 246 004	5.36
11T302EN	0.2	76 245 014	12.51		
11T304EN	0.4	76 245 016	12.51	76 246 016	7.44
11T308EN	0.8	76 245 018	12.51	76 246 018	7.44
Steel		●		●	
Stainless steel		○		○	
Cast iron		○		○	
Non ferrous metals					
Heat resistant alloys					

There are no minimum order quantities

From single items to large orders!

No matter which tool you need, we promise you quick and uncomplicated delivery. Even if you only order one item! We do not have minimum order quantities.

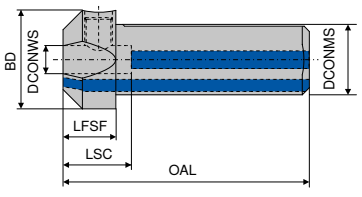
The Original Multi Function Tool

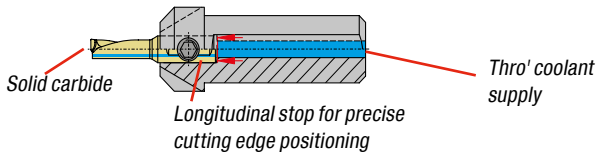
The trend in machining is unmistakable: Workpieces are becoming increasingly complex and technically challenging. Production often requires a variety of tools, which can not be economically accomodated with the existing turret locations. The answer to this challenge from CERATIZIT is the multi-function tool EcoCut.

EcoCut guide (Main catalogue 2019)

EcoCut – Adapter Mini

CERATIZIT \ Performance

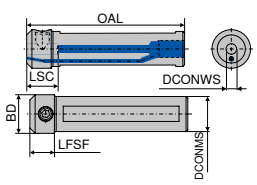


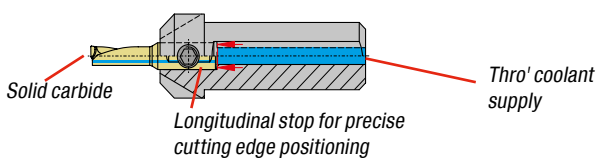


Designation	DCONWS	DCONMS	BD	OAL	LFSF	LSC	Article no.	
	mm	mm	mm	mm	mm	mm		£
EC-ADX16-04	4	16.00	22	59.0	14	18	70 800 716	145.89
EC-ADX12-04-E	4	19.05	25	63.5	14	18	70 800 719	145.89
EC-ADX20-04	4	20.00	25	64.0	14	18	70 800 720	145.89
EC-ADX16-06	6	16.00	22	59.0	14	18	70 800 976	145.89
EC-ADX12-06-E	6	19.05	25	63.5	14	18	70 800 986	145.89
EC-ADX20-06	6	20.00	25	64.0	14	18	70 800 996	145.89
EC-ADX16-08	8	16.00	22	59.0	14	18	70 800 978	145.89
EC-ADX12-08-E	8	19.05	25	63.5	14	18	70 800 988	145.89
EC-ADX20-08	8	20.00	25	64.0	14	18	70 800 998	145.89

EcoCut – Mini adapter with coolant connection thread

CERATIZIT \ Performance





Designation	DCONWS	DCONMS	BD	OAL	LFSF	LSC	Thread	Article no.	
	mm	mm	mm	mm	mm	mm			£
ECA 16-04	4	16.00	20.0	75	14	18	G 1/8	70 801 716	77.89
ECA 0750-04	4	19.05	20.0	100	14	18	G 1/8	70 801 719	79.52
ECA 20-04	4	20.00	19.6	90	14	18	G 1/8	70 801 720	79.52
ECA 22-04	4	22.00	21.6	110	14	18	G 1/8	70 801 722	81.91
ECA 25-04	4	25.00	24.6	110	14	18	G 1/8	70 801 725	82.68
ECA 1000-04	4	25.40	25.0	110	14	18	G 1/8	70 801 726	82.68
ECA 16-06	6	16.00	22.0	75	14	18	G 1/8	70 801 816	77.89
ECA 0750-06	6	19.05	22.0	100	14	18	G 1/8	70 801 819	79.52
ECA 20-06	6	20.00	22.0	90	14	18	G 1/8	70 801 820	79.52
ECA 22-06	6	22.00	21.6	110	14	18	G 1/8	70 801 822	81.91
ECA 25-06	6	25.00	24.6	110	14	18	G 1/8	70 801 825	82.68
ECA 1000-06	6	25.40	25.0	110	14	18	G 1/8	70 801 826	82.68
ECA 16-08	8	16.00	22.0	75	14	18	G 1/8	70 801 916	77.89
ECA 0750-08	8	19.05	22.0	100	14	18	G 1/8	70 801 919	79.52
ECA 20-08	8	20.00	22.0	90	14	18	G 1/8	70 801 920	79.52
ECA 22-08	8	22.00	21.6	110	14	18	G 1/8	70 801 922	81.91
ECA 25-08	8	25.00	24.6	110	14	18	G 1/8	70 801 925	82.68
ECA 1000-08	8	25.40	25.0	110	14	18	G 1/8	70 801 926	82.68

Clamping screw

Spare parts DCONWS			Article no.
		£	
4	M5x10 ISO 4026	2.30	70 950 867
6	M8x1x8 - SW4	2.30	70 950 123
8	M8x1x8 - SW4	2.30	70 950 123

Technical support: 0800 073 2 075
3 time served engineers, available from 8:00 am to 6:30 pm, Monday to Friday

Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

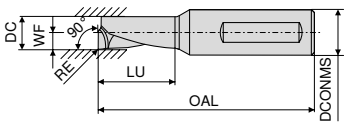
v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

EcoCut – Mini

▲ Drilling and turning tool for small diameters

≥ Ø 2 mm

CERATIZIT \ Performance



Designation	DC	DCONMS	OAL	LU	WF	RE	CTPP435 / HCN1435 DRAGONSKIN Solid carbide Left-hand Article no.	£	CTPP435 / HCN1435 DRAGONSKIN Solid carbide Right-hand Article no.	£	CTWN425 / CWK4425 Solid carbide Left-hand Article no.	£	CTWN425 / CWK4425 Solid carbide Right-hand Article no.	£
	mm	mm	mm	mm	mm	mm								
ECM 02 R/L 2,25D	2.0	4	28	4.50	1.00	0.1	70 805 320	46.33	70 804 320	39.38				
ECM 02 R/L 2,25D AL	2.0	4	28	4.50	1.00	0.1					70 805 420	34.72	70 804 420	34.72
ECM 02 R/L 4,00D	2.0	4	31	8.00	1.00	0.1	70 805 321	48.60	70 804 321	41.31				
ECM 02 R/L 4,00D AL	2.0	4	31	8.00	1.00	0.1					70 805 421	36.41	70 804 421	36.41
ECM 02,5 R/L 2,25D	2.5	4	29	5.63	1.25	0.1	70 805 325	47.75	70 804 325	40.59				
ECM 02,5 R/L 2,25D AL	2.5	4	29	5.63	1.25	0.1					70 805 425	35.76	70 804 425	35.76
ECM 02,5 R/L 4,00D	2.5	4	33	10.00	1.25	0.1	70 805 326	50.11	70 804 326	42.59				
ECM 02,5 R/L 4,00D AL	2.5	4	33	10.00	1.25	0.1					70 805 426	37.53	70 804 426	37.53
ECM 03 R/L 2,25D	3.0	4	31	6.75	1.50	0.1	70 805 330	49.25	70 804 330	41.86				
ECM 03 R/L 2,25D AL	3.0	4	31	6.75	1.50	0.1					70 805 430	36.89	70 804 430	36.89
ECM 03 R/L 4,00D	3.0	4	35	12.00	1.50	0.1	70 805 331	51.72	70 804 331	43.96				
ECM 03 R/L 4,00D AL	3.0	4	35	12.00	1.50	0.1					70 805 431	38.73	70 804 431	38.73
ECM 03,5 R/L 2,25D	3.5	4	32	7.88	1.75	0.1	70 805 335	51.15	70 804 335	43.48				
ECM 03,5 R/L 2,25D AL	3.5	4	32	7.88	1.75	0.1					70 805 435	38.34	70 804 435	38.34
ECM 03,5 R/L 4,00D	3.5	4	37	14.00	1.75	0.1	70 805 336	53.70	70 804 336	45.65				
ECM 03,5 R/L 4,00D AL	3.5	4	37	14.00	1.75	0.1					70 805 436	40.26	70 804 436	40.26
ECM 04 R/L 2,25D	4.0	6	35	9.00	2.00	0.2	70 805 300	54.32	70 804 300	46.17				
ECM 04 R/L 2,25D AL	4.0	6	35	9.00	2.00	0.2					70 805 450	40.67	70 804 450	40.67
ECM 04 R/L 4,00D	4.0	6	41	16.00	2.00	0.2	70 805 301	57.02	70 804 301	48.47				
ECM 04 R/L 4,00D AL	4.0	6	41	16.00	2.00	0.2					70 805 451	42.71	70 804 451	42.71
ECM 05 R/L 2,25D	5.0	6	37	11.25	2.50	0.2	70 805 302	56.20	70 804 302	47.77				
ECM 05 R/L 2,25D AL	5.0	6	37	11.25	2.50	0.2					70 805 452	41.82	70 804 452	41.82
ECM 05 R/L 4,00D	5.0	6	45	20.00	2.50	0.2	70 805 303	58.80	70 804 303	49.98				
ECM 05 R/L 4,00D AL	5.0	6	45	20.00	2.50	0.2					70 805 453	43.86	70 804 453	43.86
ECM 06 R/L 2,25D	6.0	8	38	13.50	3.00	0.2	70 805 306	57.65	70 804 306	49.00				
ECM 06 R/L 2,25D AL	6.0	8	38	13.50	3.00	0.2					70 805 456	43.24	70 804 456	43.24
ECM 06 R/L 4,00D	6.0	8	49	24.00	3.00	0.2	70 805 312	60.56	70 804 312	51.48				
ECM 06 R/L 4,00D AL	6.0	8	49	24.00	3.00	0.2					70 805 462	45.19	70 804 462	45.19
ECM 07 R/L 2,25D	7.0	8	42	15.75	3.50	0.2	70 805 308	59.43	70 804 308	50.52				
ECM 07 R/L 2,25D AL	7.0	8	42	15.75	3.50	0.2					70 805 458	44.57	70 804 458	44.57
ECM 07 R/L 4,00D	7.0	8	53	28.00	3.50	0.2	70 805 314	62.55	70 804 314	53.17				
ECM 07 R/L 4,00D AL	7.0	8	53	28.00	3.50	0.2					70 805 464	46.61	70 804 464	46.61
ECM 08 R/L 2,25D	8.0	8	45	18.00	4.00	0.2	70 805 310	61.40	70 804 310	52.19				
ECM 08 R/L 2,25D AL	8.0	8	45	18.00	4.00	0.2					70 805 460	45.82	70 804 460	45.82
ECM 08 R/L 4,00D	8.0	8	57	32.00	4.00	0.2	70 805 316	64.32	70 804 316	54.67				
ECM 08 R/L 4,00D AL	8.0	8	57	32.00	4.00	0.2					70 805 466	48.03	70 804 466	48.03
Steel							●		●					
Stainless steel							●		●					
Cast iron							○		○		○		○	
Non ferrous metals											●		●	
Heat resistant alloys							●		●					

On the latest technology

Technical Training

Our engineers are provided with constant training to keep them up to speed on all technical matters. We will gladly share this knowledge with you. Use our Service for the further education of your metal cutting technicians in the Technical Centre.

EcoCut – Classic 1.5xD

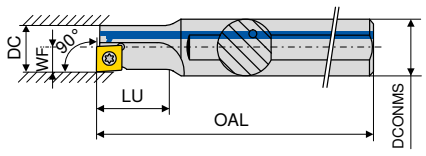
▲ Drilling and turning tool

Scope of supply:

Toolholder with 1 clamping screw + 2 spare screws and screwdriver

≥ Ø 8 mm

CERATIZIT \ Performance



Steel
Left-hand

Steel
Right-hand

Designation	DC mm	DCONMS mm	OAL mm	LU mm	WF mm	torque moment Nm	Insert	Article no.	£	Article no.	£
ECC 08 L 1,5D 04	8	12	80	12.0	4.0	0,4	XC.T 0401..EL	70 805 008 [2]	122.94		
ECC 08 R 1,5D 04	8	12	80	12.0	4.0	0,4	XC.T 0401..ER			70 804 008 [1]	122.94
ECC 10 R/L 1,5D 05	10	12	90	15.0	5.0	0,7	XC.T 0502..	70 805 010	122.94	70 804 010	122.94
ECC 12 R/L 1,5D 06	12	16	100	18.0	6.0	1,0	XC.T 0602..	70 805 012	124.95	70 804 012	124.95
ECC 14 R/L 1,5D 07	14	16	110	21.0	7.0	1,2	XC.T 0703..	70 805 014	127.97	70 804 014	127.97
ECC 16 R/L 1,5D 08	16	20	125	24.0	8.0	2,2	XC.T 0803..	70 805 016	129.97	70 804 016	129.97
ECC 18 R/L 1,5D 09	18	25	135	27.0	9.0	2,2	XC.T 09T3..	70 805 018	149.91	70 804 018	149.91
ECC 20 R/L 1,5D 10	20	25	150	30.0	10.0	3,2	XC.T 10T3..	70 805 020	169.00	70 804 020	169.00
ECC 25 R/L 1,5D 13	25	32	180	37.5	12.5	5,0	XC.T 1304..	70 805 025	194.88	70 804 025	194.88
ECC 32 R/L 1,5D 17	32	40	200	48.0	16.0	5,0	XC.T 1705..	70 805 032	220.92	70 804 032	220.92

EcoCut – Classic 2.25xD

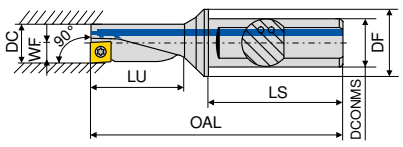
▲ Drilling and turning tool

Scope of supply:

Toolholder with 1 clamping screw + 2 spare screws and screwdriver

≥ Ø 8 mm

CERATIZIT \ Performance



Steel
Left-hand

Steel
Right-hand

Designation	DC mm	DCONMS mm	OAL mm	LU mm	LS mm	WF mm	torque moment Nm	Insert	Article no.	£	Article no.	£
ECC 08 L 2,25D 04	8	10	60.0	18.0	38	4.0	0,4	XC.T 0401..EL	70 805 108 [2]	182.90		
ECC 08 R 2,25D 04	8	10	60.0	18.0	38	4.0	0,4	XC.T 0401..ER			70 804 108 [1]	182.90
ECC 10 R/L 2,25D 05	10	12	69.5	22.5	42	5.0	0,7	XC.T 0502..	70 805 110	182.90	70 804 110	182.90
ECC 12 R/L 2,25D 06	12	16	78.0	27.0	45	6.0	1,0	XC.T 0602..	70 805 112	187.93	70 804 112	187.93
ECC 14 R/L 2,25D 07	14	16	83.5	31.5	45	7.0	1,2	XC.T 0703..	70 805 114	192.02	70 804 114	192.02
ECC 16 R/L 2,25D 08	16	20	94.0	36.0	50	8.0	2,2	XC.T 0803..	70 805 116	196.04	70 804 116	196.04
ECC 18 R/L 2,25D 09	18	25	109.5	40.5	56	9.0	2,2	XC.T 09T3..	70 805 118	215.98	70 804 118	215.98
ECC 20 R/L 2,25D 10	20	25	111.0	45.0	56	10.0	3,2	XC.T 10T3..	70 805 120	235.07	70 804 120	235.07
ECC 25 R/L 2,25D 13	25	32	129.0	56.5	60	12.5	5,0	XC.T 1304..	70 805 125	272.93	70 804 125	272.93
ECC 32 R/L 2,25D 17	32	40	158.0	72.0	70	16.0	5,0	XC.T 1705..	70 805 132	306.85	70 804 132	306.85

Spare parts DC	Key D		Article no.		Clamping screw		Article no.
		£				£	
8	T06 - IP	7.52	80 950 123	M1,8x3,6 - IP		2.85	70 950 862
10	T06 - IP	7.52	80 950 123	M2x4,3 - IP		2.53	70 950 863
12	T07 - IP	7.42	80 950 124	M2,2x5 - IP		2.46	70 950 856
14	T08 - IP	7.42	80 950 125	M2,5x6 - IP		3.16	70 950 857
16 - 18	T09 - IP	8.12	80 950 126	M3x7 - IP		2.42	70 950 819
20	T15 - IP	8.67	80 950 128	M3,5x8,6 - IP		2.42	70 950 859
25 - 32	T20 - IP	9.11	80 950 129	M4,5x10,5 - IP		2.42	70 950 864

Technical support: 0800 073 2 075
3 time served engineers, available from 8:00 am to 6:30 pm, Monday to Friday

Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

EcoCut – Classic 3xD – Heavy metal

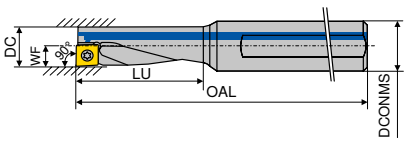
- ▲ Drilling and turning tool
- ▲ vibration-damped

Scope of supply:

Toolholder with 1 clamping screw + 2 spare screws and screwdriver

≥ Ø 8 mm

CERATIZIT \ Performance



heavy metal
Left-hand

heavy metal
Right-hand

Designation	DC	DCONMS	OAL	LU	WF	Insert	Article no.	£	Article no.	£
	mm	mm	mm	mm	mm					
ECC 08 L 3,00D 04 H	8	12	80	24	4.0	XC.T 0401..EL	70 805 608 [2]	451.04		
ECC 08 R 3,00D 04 H	8	12	80	24	4.0	XC.T 0401..ER			70 804 608 [1]	451.04
ECC 10 R/L 3,00D 05 H	10	12	85	30	5.0	XC.T 0502..	70 805 610	453.05	70 804 610	453.05
ECC 12 R/L 3,00D 06 H	12	16	95	36	6.0	XC.T 0602..	70 805 612	488.98	70 804 612	488.98
ECC 14 R/L 3,00D 07 H	14	16	100	42	7.0	XC.T 0703..	70 805 614	500.34	70 804 614	500.34
ECC 16 R/L 3,00D 08 H	16	20	110	48	8.0	XC.T 0803..	70 805 616	548.63	70 804 616	548.63
ECC 18 R/L 3,00D 09 H	18	25	125	54	9.0	XC.T 09T3..	70 805 618	664.16	70 804 618	664.16
ECC 20 R/L 3,00D 10 H	20	25	130	60	10.0	XC.T 10T3..	70 805 620	677.60	70 804 620	677.60
ECC 25 R/L 3,00D 13 H	25	32	150	75	12.5	XC.T 1304..	70 805 625	863.13	70 804 625	863.13
ECC 32 R/L 3,00D 17 H	32	40	185	96	16.0	XC.T 1705..	70 805 632	1,129.73	70 804 632	1,129.73

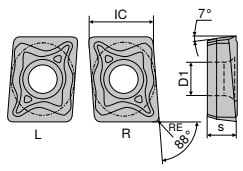
Key D

Clamping screw

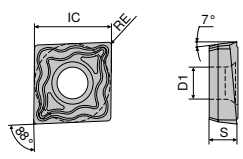
Spare parts DC		Article no.	£			Article no.	£	
8	T06 - IP	7.52	80 950 123		M1,8x3,6 - IP	2.85	70 950 862
10	T06 - IP	7.52	80 950 123		M2x4,3 - IP	2.53	70 950 863
12	T07 - IP	7.42	80 950 124		M2,2x5 - IP	2.46	70 950 856
14	T08 - IP	7.42	80 950 125		M2,5x6 - IP	3.16	70 950 857
16 - 18	T09 - IP	8.12	80 950 126		M3x7 - IP	2.42	70 950 819
20	T15 - IP	8.67	80 950 128		M3,5x8,6 - IP	2.42	70 950 859
25 - 32	T20 - IP	9.11	80 950 129		M4,5x10,5 - IP	2.42	70 950 864

XCNT

Designation	S	D1	IC
	mm	mm	mm
XCNT 0401..	1.80	2.10	4.5
XCNT 0502..	2.10	2.25	5.8
XCNT 0602..	2.38	2.50	6.5
XCNT 0703..	3.18	2.80	7.6
XCNT 0803..	3.18	3.40	8.5
XCNT 09T3..	3.97	3.40	9.6
XCNT 10T3..	3.97	4.40	10.6
XCNT 1304..	4.76	5.30	13.5
XCNT 1705..	5.56	5.30	17.5



XC. T 04..



XC. T 05../06../07../08../09../10../13../17..

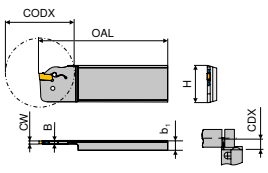
XCNT

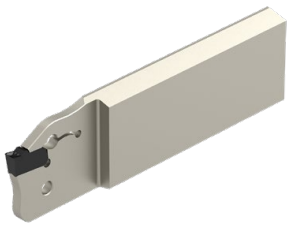
CERATIZIT \ Performance

		CTCP425		-M50Q CTCP425		CTCP435		CTPP430	
		HCR1425		-M50Q HCR1425		HCR1435		HCN2430	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		XCNT		XCNT		XCNT		XCNT	
ISO	RE	Article no.	£	Article no.	£	Article no.	£	Article no.	£
	mm								
040102EL	0.2	70 386 720	10.55			70 386 820	10.55	70 386 920	10.55
040102ER	0.2	70 386 722	10.55			70 386 822	10.55	70 386 922	10.55
040104EL	0.4	70 386 700	10.55	70 386 750	11.01	70 386 800	10.55	70 386 900	10.55
040104ER	0.4	70 386 702	10.55	70 386 752	11.01	70 386 802	10.55	70 386 902	10.55
050202EN	0.2	70 386 723	10.55			70 386 823	10.55	70 386 923	10.55
050204EN	0.4	70 386 703	10.55	70 386 753	11.01	70 386 803	10.55	70 386 903	10.55
060202EN	0.2	70 386 724	10.55			70 386 824	10.55	70 386 924	10.55
060204EN	0.4	70 386 704	10.55	70 386 754	11.01	70 386 804	10.55	70 386 904	10.55
070304EN	0.4	70 386 705	10.55	70 386 755	11.01	70 386 805	10.55	70 386 905	10.55
080304EN	0.4	70 386 706	10.71	70 386 756	11.18	70 386 806	10.71	70 386 906	10.71
09T304EN	0.4	70 386 707	10.87	70 386 757	11.42	70 386 807	10.87	70 386 907	10.87
10T304EN	0.4	70 386 708	11.42	70 386 758	11.89	70 386 808	11.42	70 386 908	11.42
10T308EN	0.8	70 386 738	11.42	70 386 788	11.89	70 386 838	11.42	70 386 938	11.42
130404EN	0.4	70 386 710	13.06	70 386 760	13.68	70 386 810	13.06	70 386 910	13.06
130408EN	0.8	70 386 740	13.06	70 386 790	13.68	70 386 840	13.06	70 386 940	13.06
170508EN	0.8	70 386 712	13.76	70 386 762	14.47	70 386 812	13.76	70 386 912	13.76
Steel		●		●		●		●	
Stainless steel		○		○		○		●	
Cast iron		●		●		●		○	
Non ferrous metals								○	
Heat resistant alloys								●	

MonoClamp – Radial Blade SX reinforced

CERATIZIT \ Performance



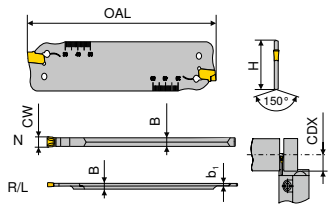


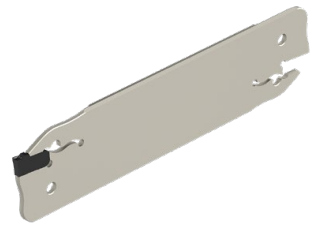
Designation	CW mm	H mm	B mm	OAL mm	b_1 mm	CODX mm	CDX mm	for grooving inserts	R/L/N	Article no.	£
XLCF L 2608-SX2	2	26	1.5	110	8	44	22	SX .2..	L	70 879 212 1)	61.59
XLCF L 2608-SX3	3	26	2.5	110	8	44	22	SX .3..	L	70 879 213 1)	61.59
XLCF L 3208-SX3	3	32	2.5	110	8	66	33	SX .3..	L	70 879 203	57.91
XLCF L 3208-SX4	4	32	3.4	110	8	66	33	SX .4..	L	70 879 204	57.91
XLCF R 2608-SX2	2	26	1.5	110	8	44	22	SX .2..	R	70 879 012 1)	61.59
XLCF R 2608-SX3	3	26	2.5	110	8	44	22	SX .3..	R	70 879 013 1)	61.59
XLCF R 3208-SX3	3	32	2.5	110	8	66	33	SX .3..	R	70 879 003	57.91
XLCF R 3208-SX4	4	32	3.4	110	8	66	33	SX .4..	R	70 879 004	57.91

1) can be used in both directions

MonoClamp – Radial Blade SX Standard

CERATIZIT \ Performance





Designation	CW mm	H mm	B mm	b_1 mm	OAL mm	CDX mm	for grooving inserts	R/L/N	Article no.	£
XLCF L 2602-SX2	2	26	2.4	1.5	110	25	SX .2..	L	70 884 212	40.23
XLCF L 3202-SX2	2	32	2.4	1.5	150	25	SX .2..	L	70 884 202	42.09
XLCF R 2602-SX2	2	26	2.4	1.5	110	25	SX .2..	R	70 884 012	40.23
XLCF R 3202-SX2	2	32	2.4	1.5	150	25	SX .2..	R	70 884 002	42.09
XLCF N 2603-SX3	3	26	2.4		110	35	SX .3..	N	70 884 113	40.23
XLCF N 3203-SX3	3	32	2.4		150	50	SX .3..	N	70 884 103	42.09
XCLF N 2604-SX4	4	26	3.2		110	40	SX .4..	N	70 884 114	40.23
XLCF N 3204-SX4	4	32	3.2		150	50	SX .4..	N	70 884 104	42.09
XLCF N 3205-SX5	5	32	4.2		150	55	SX .5..	N	70 884 105	42.09
XLCF N 3206-SX6	6	32	5.2		150	60	SX .6..	N	70 884 106	42.09

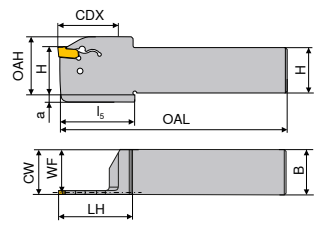
Ejector SX

Spare parts

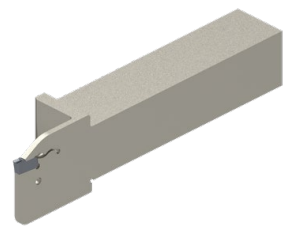
for grooving inserts		Article no. £	
SX .2..	SX 2-3	20.54	70 950 836
SX .3..	SX 2-3	20.54	70 950 836
SX .4..	SX 4-6	20.96	70 950 837
SX .5..	SX 4-6	20.96	70 950 837
SX .6..	SX 4-6	20.96	70 950 837

MonoClamp – Radial Monoholder SX

CERATIZIT \ Performance



Illustrations show right-hand versions



Designation	H mm	B mm	CW mm	WF mm	OAL mm	LH mm	l_5 mm	OAH mm	CDX mm	a mm	for grooving inserts	Left-hand Article no.	£	Right-hand Article no.	£
E16 R/L 0026-1616K-K-SX2	16	16	2	15.2	125	33	33	26	26	4	SX .2..	70 846 21601	77.89	70 846 21600	77.89
E20 R/L 0026-2020K-K-SX2	20	20	2	19.2	125	33	33	31	26	5	SX .2..	70 846 22001	91.42	70 846 22000	91.42
E16 R/L 0026-1616K-K-SX3	16	16	3	14.8	125	33	33	26	26	4	SX .3..	70 846 31601	77.89	70 846 31600	77.89
E20 R/L 0026-2020K-K-SX3	20	20	3	18.8	125	31	33	31	26	5	SX .3..	70 846 32001	91.42	70 846 32000	91.42
E25 R/L 0026-2525M-K-SX3	25	25	3	23.8	150	33		31	26		SX .3..	70 846 32501	96.98	70 846 32500	96.98
E20 R/L 0033-2020K-K-SX4	20	20	4	18.3	125	40	40	32	33	5	SX .4..	70 846 42001	91.42	70 846 42000	91.42
E25 R/L 0033-2525M-K-SX4	25	25	4	23.3	150	42	42	36	33	5	SX .4..	70 846 42501	96.98	70 846 42500	96.98
E25 R/L 0040-2525M-K-SX5	25	25	5	22.9	150	49	49	38	40	6	SX .5..	70 846 52501	96.98	70 846 52500	96.98
E25 R/L 0040-2525M-K-SX6	25	25	6	22.4	150	49	49	38	40	6	SX .6..	70 846 62501	96.98	70 846 62500	96.98

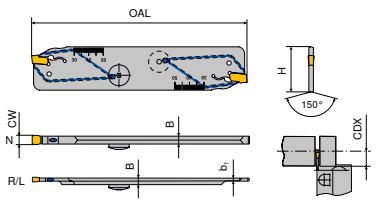
Ejector SX

Spare parts

for grooving inserts		Article no. £	
SX .2..	SX 2-3	20.54	70 950 836
SX .3..	SX 2-3	20.54	70 950 836
SX .4..	SX 4-6	20.96	70 950 837
SX .5..	SX 4-6	20.96	70 950 837
SX .6..	SX 4-6	20.96	70 950 837

MonoClamp – Radial Blade SX-DC Standard

CERATIZIT \ Performance



Designation	CW mm	H mm	B mm	OAL mm	b_1 mm	CDX mm	for grooving inserts	R/L/N	Article no.	£
XLCF R 2602-DC-SX2	2	26	2.4	110	1.6	25	SX .2..	R	70 884 512	68.64
XLCF N 2603-DC-SX3	3	26	2.5	110		35	SX .3..	N	70 884 613	68.64
XLCF N 3203-DC-SX3	3	32	2.5	150		50	SX .3..	N	70 884 603	74.37
XLCF N 3204-DC-SX4	4	32	3.3	150		50	SX .4..	N	70 884 604	74.37

Key D

Ejector SX

Spare parts

for grooving inserts		Article no. £			Article no. £	
SX .2..	T15 - IP	8.67	80 950 128	SX 2-3	20.54	70 950 836
SX .3..	T15 - IP	8.67	80 950 128	SX 2-3	20.54	70 950 836
SX .4..	T15 - IP	8.67	80 950 128	SX 4-6	20.96	70 950 837

Technical support: 0800 073 2 075
3 time served engineers, available from 8:00 am to 6:30 pm, Monday to Friday

Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

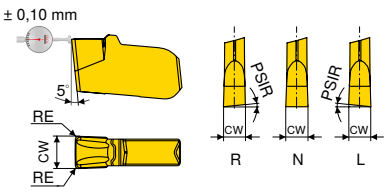
v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

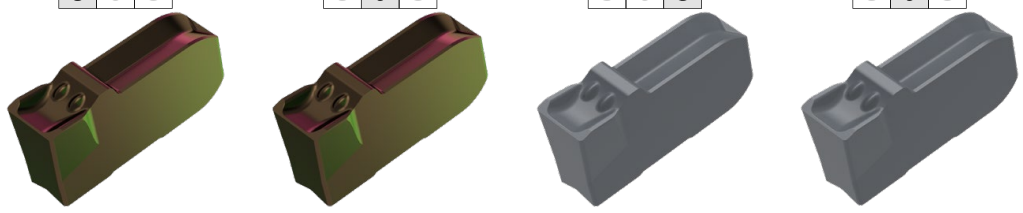
Insert SX

▲ Specially developed geometry with negative edge-chamfers available in right, left and neutral types

F	M	R

CERATIZIT \ Performance





Designation	IH	CW +/-0,05 mm	for tool holder	-M1 CTCP325 / -M1 HCR1325 DRAGONSKIN Article no.	£	-M1 CTCP335 / -M1 HCR1335 DRAGONSKIN Article no.	£	-M1 CTPP345 / -M1 HCN1345 DRAGONSKIN Article no.	£	-M1 CTP1340 / -M1 CCN1340 DRAGONSKIN Article no.	£
SX E2.00 L 6	L	2	-SX2							70 342 612	8.24
SX E3.00 L 6	L	3	-SX3	70 342 913	8.77					70 342 613	8.77
SX E4.00 L 6	L	4	-SX4							70 342 614	9.23
SX E2.00 N 0.20	N	2	-SX2	70 342 922	8.24			70 342 822	8.24	70 342 622	8.24
SX E3.00 N 0.20	N	3	-SX3	70 342 923	8.77	70 342 523	8.77	70 342 823	8.77	70 342 623	8.77
SX E4.00 N 0.30	N	4	-SX4	70 342 924	9.23	70 342 524	9.23	70 342 824	9.23	70 342 624	9.23
SX E5.00 N 0.30	N	5	-SX5	70 342 925	9.83			70 342 825	9.83	70 342 625	9.83
SX E6.00 N 0.40	N	6	-SX6	70 342 926	10.61			70 342 826	10.61	70 342 626	10.61
SX E2.00 R 6	R	2	-SX2							70 342 602	8.24
SX E3.00 R 6	R	3	-SX3	70 342 903	8.77					70 342 603	8.77
SX E4.00 R 6	R	4	-SX4							70 342 604	9.23

	-M1 CTCP325	-M1 CTCP335	-M1 CTPP345	-M1 CTP1340
Steel	●	●	●	●
Stainless steel	○	○	●	●
Cast iron	●	●		●
Non ferrous metals				○
Heat resistant alloys			○	●
Hardened materials	○			

SX-M1

Parting / Grooving

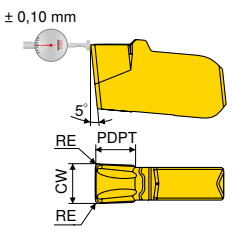
SX-M1 Cutting width in mm	Feed rate f in mm/rev.
2	0,05–0,15
3	0,10–0,20
4	0,10–0,25
5	0,15–0,30
6	0,15–0,35

Insert SX

▲ All purpose geometry for parting, grooving & turning.

F	M	R

CERATIZIT \ Performance



Designation	CW +/-0,05 mm	RER +/-0,05 mm	PDPT mm	for tool holder	-M2 CTCP325 / -M2 HCR1325 DRAGONSKIN Article no.	£	-M2 CTCP335 / -M2 HCR1335 DRAGONSKIN Article no.	£	-M2 CTPP345 / -M2 HCN1345 DRAGONSKIN Article no.	£	-M2 CTP1340 / -M2 CCN1340 DRAGONSKIN Article no.	£
SX E2.00 N 0.20	2	0.2	1.5	-SX2	70 343 922	8.24	70 343 522	8.24	70 343 822	8.24	70 343 622	8.24
SX E3.00 N 0.30	3	0.3	2.0	-SX3	70 343 923	8.77	70 343 523	8.77	70 343 823	8.77	70 343 623	8.77
SX E4.00 N 0.40	4	0.4	2.5	-SX4	70 343 924	9.23	70 343 524	9.23	70 343 824	9.23	70 343 624	9.23
SX E5.00 N 0.40	5	0.4	2.7	-SX5	70 343 925	9.83	70 343 525	9.83	70 343 825	9.83	70 343 625	9.83
SX E6.00 N 0.50	6	0.5	3.0	-SX6	70 343 926	10.61	70 343 526	10.61	70 343 826	10.61	70 343 626	10.61

	-M2 CTCP325	-M2 CTCP335	-M2 CTPP345	-M2 CTP1340
Steel	●	●	●	●
Stainless steel	○	○	●	●
Cast iron	●	●		●
Non ferrous metals				○
Heat resistant alloys			○	●
Hardened materials	○			

SX-M2

Turning

SX–M2 Cutting width in mm	Depth of Cut a_p in mm 0,5	1,0	1,5	2,0	2,5	3,0	3,5	4,0
	Feed rate f in mm/rev.							
2	0,05–0,17	0,05–0,13	0,05–0,10					
3	0,07–0,20	0,07–0,20	0,07–0,18	0,07–0,15				
4	0,10–0,25	0,10–0,25	0,10–0,25	0,10–0,22	0,10–0,18			
5	0,12–0,27	0,12–0,27	0,12–0,27	0,12–0,25	0,12–0,22			
6	0,15–0,30	0,15–0,30	0,15–0,30	0,15–0,30	0,15–0,25	0,15–0,20		
8	0,17–0,45	0,17–0,45	0,17–0,45	0,17–0,45	0,17–0,40	0,17–0,37	0,17–0,35	
10	0,20–0,50	0,20–0,50	0,20–0,50	0,20–0,50	0,20–0,46	0,20–0,42	0,20–0,38	0,20–0,35

Parting / Grooving

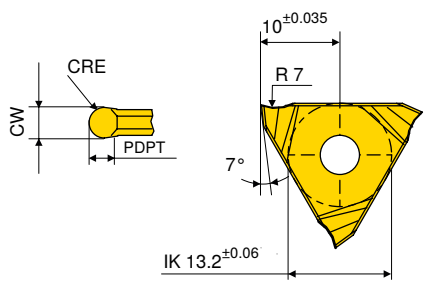
SX–M2 Feed rate f in mm/rev.
0,05–0,15
0,075–0,20
0,10–0,25
0,10–0,30
0,15–0,35
0,20–0,50
0,20–0,50

Radial TX insert for corner recessing

▲ Full radius for cutting width 2.0–5.0 mm

CERATIZIT \ Performance

CWX500



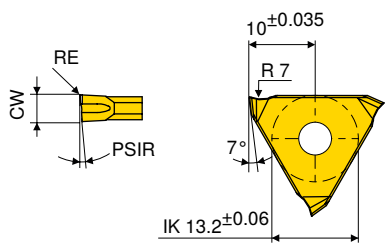
Designation	CRE	CW +/-0,05	PDPT	for tool holder	Neutral Article no.	£
	mm	mm	mm			
TX N 0010.20.2	1.0	2	0.7	R/L .. .2	73 304 204	25.57
TX N 0015.30.3	1.5	3	1.0	R/L .. .3	73 304 206	27.03
TX N 0020.40.4	2.0	4	1.2	R/L .. .4	73 304 208	26.85
TX N 0025.50.4	2.5	5	1.5	R/L .. .4	73 304 210	27.30

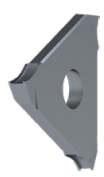
TX Insert for parting

▲ Cutting depth 5.0 mm
▲ Cutting width 1.99–2.79 mm

CERATIZIT \ Performance

CWX500



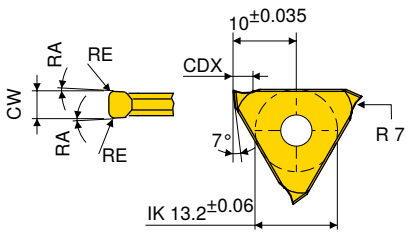


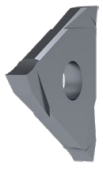
Designation	CW -0,05	for tool holder	Right-hand Article no.	£
	mm			
TX R 0518.00.1	1.99	R/L 207 .. . / 780 .. . 1	73 301 204	24.66
TX R 0521.00.2	2.29	R/L 207 .. . / 780 .. . 2	73 301 206	25.46
TX R 0526.00.2	2.79	R/L 207 .. . / 780 .. . 2	73 301 208	25.46

TX insert for fine and copy turning

CERATIZIT \ Performance

CWX500





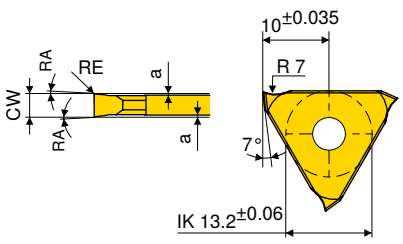
Designation	CW +0,03	for tool holder	Neutral Article no.	£
	mm			
TX N 0150.02.1	1.5	R/L 207 .. . / 738 .. . / 660 .. . 1	73 303 204	21.03
TX N 0200.02.1	2.0	R/L 207 .. . / 738 .. . / 660 .. . 1	73 303 206	21.03
TX N 0200.04.1	2.0	R/L 207 .. . / 738 .. . / 660 .. . 1	73 303 208	21.59
TX N 0300.06.2	3.0	R/L 207 .. . / 738 .. . / 660 .. . 2	73 303 212	22.17
TX N 0300.08.2	3.0	R/L 207 .. . / 738 .. . / 660 .. . 2	73 303 214	22.17
TX N 0300.02.2	3.0	R/L 207 .. . / 738 .. . / 660 .. . 2	73 303 210	21.59
TX N 0400.02.3	4.0	R/L 207 .. . / 738 .. . / 660 .. . 3	73 303 216	22.36
TX N 0400.12.3	4.0	R/L 207 .. . / 738 .. . / 660 .. . 3	73 303 220	22.36
TX N 0400.08.3	4.0	R/L 207 .. . / 738 .. . / 660 .. . 3	73 303 218	22.36

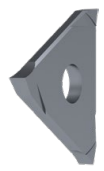
TX insert for circlip grooves

▲ For circlip grooves according to DIN 471 / 472

CERATIZIT \ Performance

CWX500





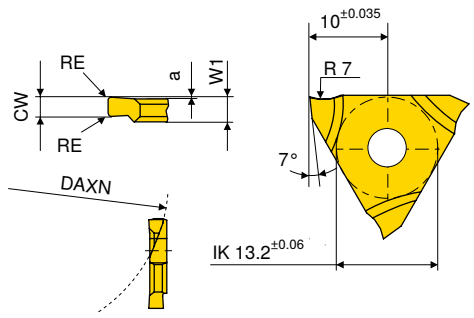
Designation	CW -0,05	a +/-0,02	for tool holder	Neutral Article no.	£
	mm	mm			
TX N 0050.00.1	0.57	0.07	R/L .. .1	73 300 204	16.85
TX N 0060.00.1	0.67	0.07	R/L .. .1	73 300 206	16.85
TX N 0070.00.1	0.77	0.08	R/L .. .1	73 300 208	16.85
TX N 0080.00.1	0.87	0.08	R/L .. .1	73 300 210	16.85
TX N 0090.00.1	0.97	0.08	R/L .. .1	73 300 212	16.85
TX N 0100.00.1	1.07	0.09	R/L .. .1	73 300 214	16.85
TX N 0110.00.1	1.24	0.15	R/L .. .1	73 300 216	16.85
TX N 0130.00.1	1.44	0.15	R/L .. .1	73 300 218	16.85
TX N 0160.00.1	1.74	0.20	R/L .. .1	73 300 220	16.85
TX N 0185.00.1	1.99	0.20	R/L .. .1	73 300 222	16.85
TX N 0215.00.2	2.29	0.20	R/L .. .2	73 300 224	16.85
TX N 0265.00.2	2.79	0.20	R/L .. .2	73 300 226	16.85
TX N 0315.00.3	3.29	0.20	R/L .. .3	73 300 228	19.22
TX N 0415.00.4	4.29	0.20	R/L .. .4	73 300 230	19.32
TX N 0515.00.4	5.29	0.20	R/L .. .4	73 300 232	19.94

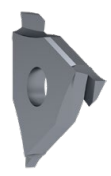
TX insert for axial grooving

▲ Up to cutting depth 3.5 mm
▲ Cutting width 1.5–5.0 mm
▲ Groove-Ø external $D_a \geq 20$ mm

CERATIZIT \ Performance

CWX500 CWX500





Illustrations show right-hand versions

Designation	CW	W1	CDX	a	DAXN	for tool holder	Left-hand Article no.	£	Right-hand Article no.	£
	mm	mm	mm	mm	mm					
TX R/L 2015.2.2	1.5	2.7	2.0	0.2	20	R/L 207 .. . 2	73 306 204	24.11	73 305 204	24.11
TX R/L 3020.2.2	2.0	2.7	3.0	0.2	30	R/L 207 .. . 2	73 306 206	24.11	73 305 206	24.11
TX R/L 3030.2.3	3.0	3.7	3.0	0.2	30	R/L 207 .. . 3	73 306 208	24.38	73 305 208	24.38
TX R/L 3040.2.4	4.0	4.3	3.5	0.2	30	R/L 207 .. . 4	73 306 210	24.66	73 305 210	24.66
TX R/L 3050.2.4	5.0	5.3	3.5	0.2	30	R/L 207 .. . 4	73 306 212	25.78	73 305 212	25.78

Speed Calculation

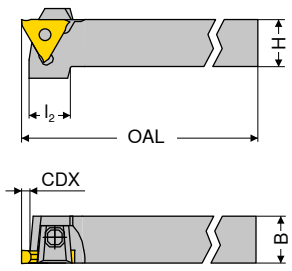
$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

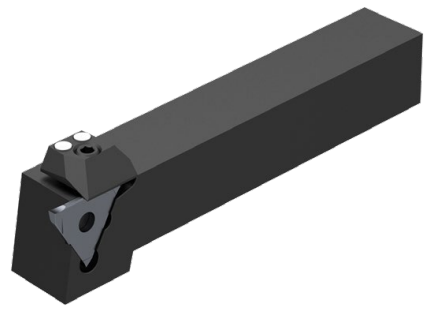
v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

MonoClamp – Radial/Axial TX Grooving Holder 0°, 6 mm cutting depth

- For radial and axial grooving
- Cutting width 0.5 – 6.3 mm

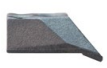
CERATIZIT \ Performance





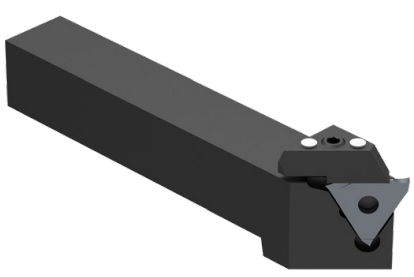
Illustrations show right-hand versions

Designation	H mm	B +/-0,1 mm	OAL mm	l_2 mm	CDX mm	for grooving inserts	Right-hand Article no.	£
R 207.1212.1	12	12	100	24	4	TX R/N/L ...1	73 500 112	106.58
R 207.1616.1	16	16	125	22	4	TX R/N/L ...1	73 500 116	95.12
R 207.2020.1	20	20	125	21	4	TX R/N/L ...1	73 500 120	73.77
R 207.2525.1	25	25	150		4	TX R/N/L ...1	73 500 125	77.63
R 207.3232.1	32	32	170		4	TX R/N/L ...1	73 500 132	90.23
R 207.1212.2	12	12	100	24	6	TX R/N/L ...2	73 500 212	106.58
R 207.1616.2	16	16	125	22	6	TX R/N/L ...2	73 500 216	95.12
R 207.2020.2	20	20	125	21	6	TX R/N/L ...2	73 500 220	73.77
R 207.2525.2	25	25	150		6	TX R/N/L ...2	73 500 225	77.63
R 207.3232.2	32	32	170		6	TX R/N/L ...2	73 500 232	90.23
R 207.1212.3	12	12	100	24	6	TX R/N/L ...3	73 500 312	106.58
R 207.1616.3	16	16	125	22	6	TX R/N/L ...3	73 500 316	95.12
R 207.2020.3	20	20	125	21	6	TX R/N/L ...3	73 500 320	73.77
R 207.2525.3	25	25	150		6	TX R/N/L ...3	73 500 325	77.63
R 207.3232.3	32	32	170		6	TX R/N/L ...3	73 500 332	90.23
R 207.1616.4	16	16	125	22	6	TX R/N/L ...4	73 500 416	96.14
R 207.2020.4	20	20	125	21	6	TX R/N/L ...4	73 500 420	74.55
R 207.2525.4	25	25	150		6	TX R/N/L ...4	73 500 425	78.42
R 207.3232.4	32	32	170		6	TX R/N/L ...4	73 500 432	91.15

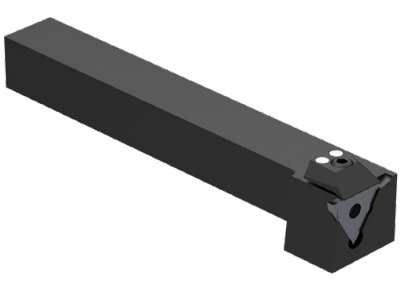
Spare parts		 Key I		 right hand			 Clamping screw			 Guide pin	
		Article no.		Article no.			Article no.			Article no.	
for grooving inserts		£		£			£			£	
TX R/N/L ...1	SW3	1.90	70 950 176	21.67	73 950 020	M6x20	4.56	73 950 028	Ø 4x18	0.55	73 950 030
TX R/N/L ...2	SW3	1.90	70 950 176	21.67	73 950 020	M6x20	4.56	73 950 028	Ø 4x18	0.55	73 950 030
TX R/N/L ...3	SW3	1.90	70 950 176	21.67	73 950 020	M6x20	4.56	73 950 028	Ø 4x18	0.55	73 950 030
TX R/N/L ...4	SW3	1.90	70 950 176	24.07	73 950 022	M6x20	4.56	73 950 028	Ø 4x18	0.55	73 950 030

Left hand tooling and the rest of the comprehensive TX range are available in the main catalogue.

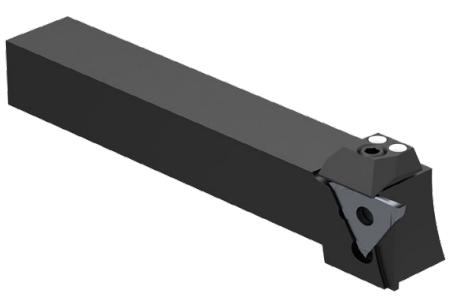
TX – Boring Bar



TX – 45° Tool Holder



TX – 90° Tool Holder
6 mm cutting depth



TX – 0° Tool Holder
8 mm cutting depth

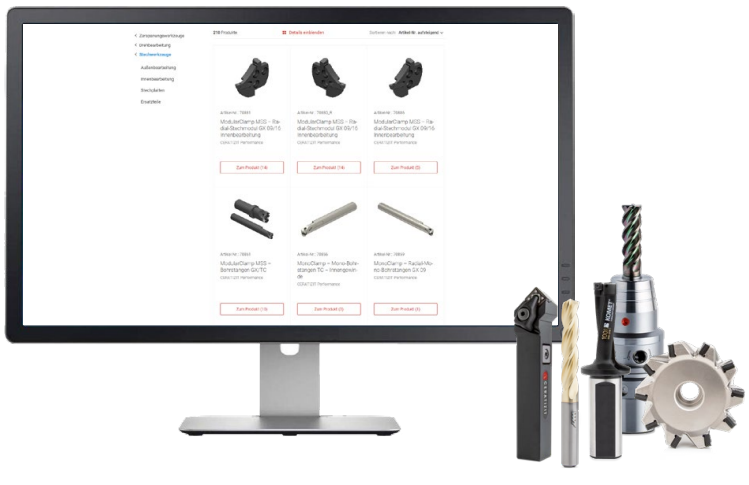
Grooving Tools guide (Main catalogue 2019)

Cutting Data 100–109 Chip Breakers Overview 121–124

It couldn't be easier

Ordering via the Online Shop

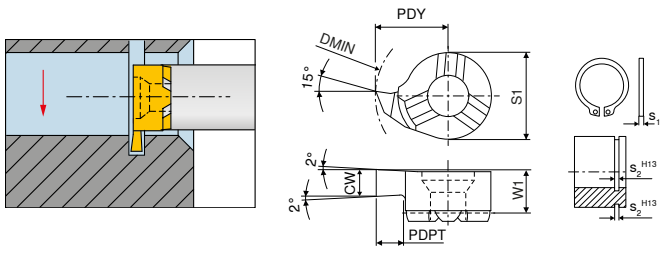
In the Online Shop you can select and order your tool with a mouse click, 24 hours a day, 7 days a week. All your transactions including those in the past can be viewed clearly and easily in the online shop. Register and use our Service: **cuttingtools.ceratizit.com**



MiniCut – Grooving insert

WNT \ Performance

CWX500



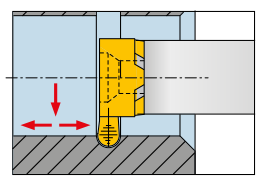
Size	Designation	DMIN	CW	PDPT	W1	PDY	S1	Right-hand Article no.	£
		mm	mm	mm	mm	mm	mm		
08	8,00. R .0,73.1,0	8	0.73	1.0	3.3	4.8	6	73 310 073	17.61
	8,00. R .0,83.1,0	8	0.83	1.0	3.3	4.8	6	73 310 083	17.61
	8,00. R .0,93.1,0	8	0.93	1.0	3.3	4.8	6	73 310 093	17.61
	8,00. R .1,00.1,0	8	1.00	1.0	3.3	4.8	6	73 310 110	17.61
	8,00. R .1,20.1,0	8	1.20	1.0	3.3	4.8	6	73 310 112	17.61
	8,00. R .1,40.1,0	8	1.40	1.0	3.3	4.8	6	73 310 114	17.61
	8,00. R .1,50.1,0	8	1.50	1.0	3.3	4.8	6	73 310 115	17.61
	8,00. R .1,70.1,0	8	1.70	1.0	3.3	4.8	6	73 310 117	17.61
	8,00. R .2,00.1,0	8	2.00	1.0	3.3	4.8	6	73 310 120	17.61
11	11,00. R .0,73.1,2	11	0.73	1.2	4.2	6.7	8	73 310 373	17.61
	11,00. R .0,83.1,3	11	0.83	1.3	4.2	6.7	8	73 310 383	17.61
	11,00. R .0,93.1,5	11	0.93	1.5	4.2	6.7	8	73 310 393	17.61
	11,00. R .1,00.2,3	11	1.00	2.3	4.2	6.7	8	73 310 310	17.61
	11,00. R .1,20.2,3	11	1.20	2.3	4.2	6.7	8	73 310 312	17.61
	11,00. R .1,40.2,3	11	1.40	2.3	4.2	6.7	8	73 310 314	17.61
	11,00. R .1,50.2,3	11	1.50	2.3	4.2	6.7	8	73 310 315	17.61
	11,00. R .1,70.2,3	11	1.70	2.3	4.2	6.7	8	73 310 317	17.61
	11,00. R .2,00.2,3	11	2.00	2.3	4.2	6.7	8	73 310 320	17.61
	11,00. R .2,50.2,3	11	2.50	2.3	4.2	6.7	8	73 310 325	17.61
	11,00. R .3,00.2,3	11	3.00	2.3	4.2	6.7	8	73 310 330	17.61
14	14,00. R .0,73.1,2	14	0.73	1.2	5.3	9.0	9	73 310 573	17.61
	14,00. R .0,83.1,3	14	0.83	1.3	5.3	9.0	9	73 310 583	17.61
	14,00. R .0,93.1,5	14	0.93	1.5	5.3	9.0	9	73 310 593	17.61
	14,00. R .1,20.4,0	14	1.20	4.0	5.3	9.0	9	73 310 512	17.61
	14,00. R .1,40.4,0	14	1.40	4.0	5.3	9.0	9	73 310 514	17.61
	14,00. R .1,50.4,0	14	1.50	4.0	5.3	9.0	9	73 310 515	17.61
	14,00. R .1,70.4,0	14	1.70	4.0	5.3	9.0	9	73 310 517	17.61
	14,00. R .2,00.4,0	14	2.00	4.0	5.3	9.0	9	73 310 520	17.61
	14,00. R .2,50.4,0	14	2.50	4.0	5.3	9.0	9	73 310 525	17.61
	14,00. R .3,00.4,0	14	3.00	4.0	5.3	9.0	9	73 310 530	17.61
16	16,00. R .0,73.1,2	16	0.73	1.2	5.4	10.2	11	73 310 773	21.45
	16,00. R .0,83.1,3	16	0.83	1.3	5.4	10.2	11	73 310 783	21.45
	16,00. R .0,93.1,5	16	0.93	1.5	5.4	10.2	11	73 310 793	21.45
	16,00. R .1,20.4,3	16	1.20	4.3	5.4	10.2	11	73 310 712	19.38
	16,00. R .1,40.4,3	16	1.40	4.3	5.4	10.2	11	73 310 714	19.38
	16,00. R .1,50.4,3	16	1.50	4.3	5.4	10.2	11	73 310 715	19.38
	16,00. R .1,70.4,3	16	1.70	4.3	5.4	10.2	11	73 310 717	19.38
	16,00. R .2,00.4,3	16	2.00	4.3	5.4	10.2	11	73 310 720	19.38
	16,00. R .2,50.4,3	16	2.50	4.3	5.4	10.2	11	73 310 725	19.38
	16,00. R .3,00.4,3	16	3.00	4.3	5.4	10.2	11	73 310 730	19.38
	16,00. R .3,50.4,3	16	3.50	4.3	5.4	10.2	11	73 310 735	19.38
	16,00. R .4,00.4,3	16	4.00	4.3	5.4	10.2	11	73 310 740	19.38

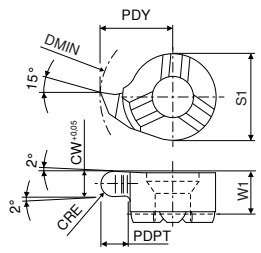
Steel	●
Stainless steel	●
Cast iron	●
Non ferrous metals	●
Heat resistant alloys	●
Hardened materials	

MiniCut – Full radius grooving and turning insert

WNT \ Performance

CWX500





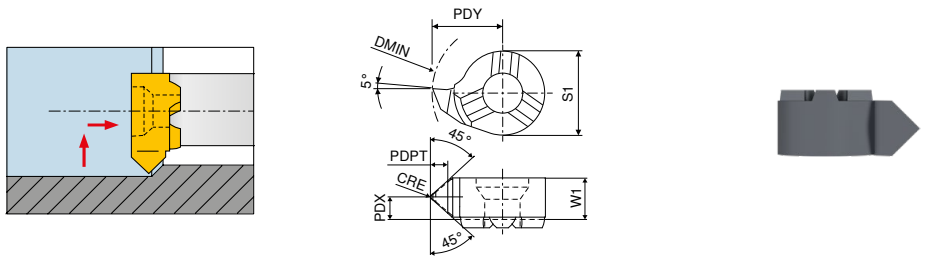
Size	Designation	DMIN	CW	PDPT	W1	PDY	S1	CRE	Right-hand Article no.	£
		mm	mm	mm	mm	mm	mm	mm		
08	8,00. R .0,80.1,0	8	0.8	1.0	3.3	4.8	6	0.4	73 318 008	21.95
	8,00. R .1,20.1,0	8	1.2	1.0	3.3	4.8	6	0.6	73 318 012	21.95
	8,00. R .1,80.1,0	8	1.8	1.0	3.3	4.8	6	0.9	73 318 018	21.95
11	11,00. R .0,80.2,3	11	0.8	2.3	4.2	6.7	8	0.4	73 318 308	22.23
	11,00. R .1,20.2,3	11	1.2	2.3	4.2	6.7	8	0.6	73 318 312	22.23
	11,00. R .1,80.2,3	11	1.8	2.3	4.2	6.7	8	0.9	73 318 318	22.23
	11,00. R .2,00.2,3	11	2.0	2.3	4.2	6.7	8	1.0	73 318 320	22.23
	11,00. R .3,00.2,3	11	3.0	2.3	4.2	6.7	8	1.5	73 318 330	22.23
14	14,00. R .1,20.4,0	14	1.2	4.0	5.3	9.0	9	0.6	73 318 512	23.52
	14,00. R .1,80.4,0	14	1.8	4.0	5.3	9.0	9	0.9	73 318 518	23.52
	14,00. R .2,00.4,0	14	2.0	4.0	5.3	9.0	9	1.0	73 318 520	23.52
	14,00. R .2,20.4,0	14	2.2	4.0	5.3	9.0	9	1.1	73 318 522	23.52
	14,00. R .3,00.4,0	14	3.0	4.0	5.3	9.0	9	1.5	73 318 530	23.52
16	16,00. R .1,80.4,3	16	1.8	4.3	5.4	10.2	11	0.9	73 318 718	23.77
	16,00. R .2,20.4,3	16	2.2	4.3	5.4	10.2	11	1.1	73 318 722	23.77
	16,00. R .3,00.4,3	16	3.0	4.3	5.4	10.2	11	1.5	73 318 730	23.77
	16,00. R .4,00.4,3	16	4.0	4.3	5.4	10.2	11	2.0	73 318 740	23.77

Steel	●
Stainless steel	●
Cast iron	●
Non ferrous metals	●
Heat resistant alloys	●
Hardened materials	

MiniCut – Internal turning and chamfering insert

WNT \ Performance

CWX500



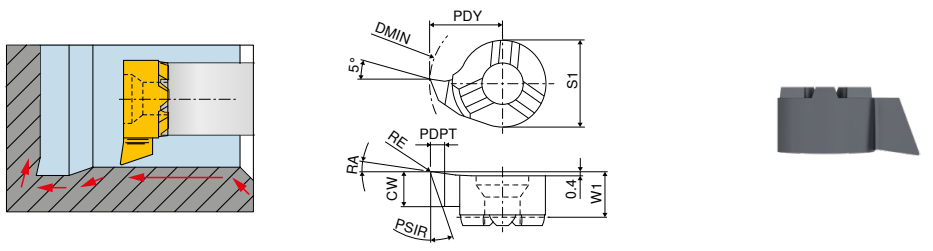
Size	Designation	DMIN	PDPT	W1	PDX	PDY	S1	CRE	CDX	Right-hand Article no.	£
		mm	mm	mm	mm	mm	mm	mm	mm		
08	8,00. R .45°.1,4	8	1.4	3.5	1.8	4.8	6	0.2	0.6	73 334 010	19.59
11	11,00. R .45°.1,5	11	1.5	4.3	2.2	6.7	8	0.2	1.0	73 334 310	19.59
14	14,00. R .45°.1,5	14	1.5	5.4	2.8	9.0	9	0.2	1.2	73 334 510	21.16

Steel	●
Stainless steel	●
Cast iron	●
Non ferrous metals	●
Heat resistant alloys	●
Hardened materials	

MiniCut – Insert for turning and profiling

WNT \ Performance

CWX500



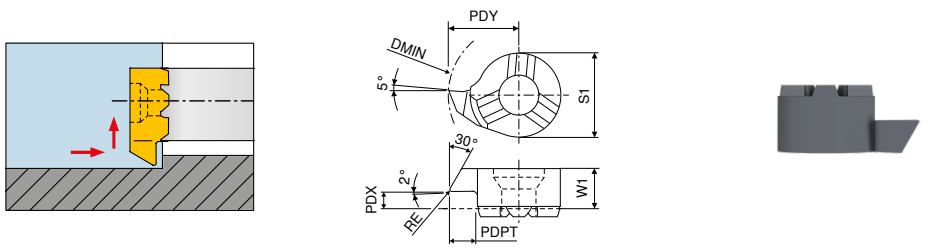
Size	Designation	DMIN	CW	W1	PDY	S1	RE	PDPT	PSIR	RA	Right-hand Article no.	£
		mm	mm	mm	mm	mm	mm	mm	°	°		
08	8,00. R .3,30.18°	7.8	3.3	3.5	4.65	6	0.2	0.6	18	8	73 322 033	20.38
11	9,80. R .3,90.18°	9.8	3.9	4.2	5.50	8	0.2	1.0	18	8	73 322 139	20.38
	11,00. R .3,90.18°	11.0	3.9	4.2	6.70	8	0.2	1.0	18	8	73 322 339	20.16
14	14,00. R .5,00.18°	13.8	5.0	5.1	8.70	9	0.2	1.5	18	8	73 322 550	20.16
16	15,50. R .5,00.18°	15.5	5.0	5.4	9.70	11	0.2	1.5	18	8	73 322 750	22.03

Steel	●
Stainless steel	●
Cast iron	●
Non ferrous metals	●
Heat resistant alloys	●
Hardened materials	

MiniCut – Back boring insert

WNT \ Performance

CWX500



Size	Designation	DMIN	PDPT	W1	PDX	PDY	S1	RE	CDX	Right-hand Article no.	£
		mm	mm	mm	mm	mm	mm	mm	mm		
08	8,00. R .30°.1,3	7.8	1.3	3.5	1.0	4.65	6	0.2	0.6	73 330 013	23.45
11	11,00. R .30°.2,3	11.0	2.3	4.3	1.6	6.70	8	0.2	1.0	73 330 323	22.96
14	14,00. R .30°.3,5	13.8	3.5	5.4	2.4	8.70	9	0.2	1.5	73 330 535	23.45

Steel	●
Stainless steel	●
Cast iron	●
Non ferrous metals	●
Heat resistant alloys	●
Hardened materials	

Technical support: 0800 073 2 075
3 time served engineers, available from 8:00 am to 6:30 pm, Monday to Friday

Speed Calculation

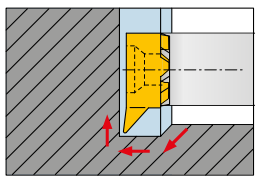
$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

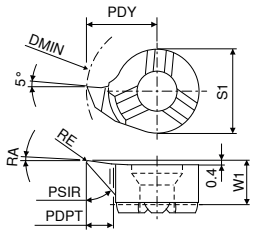
v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

MiniCut – Internal undercut insert

WNT \ Performance

CWX500





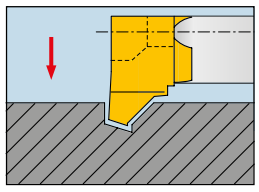
Size	Designation	DMIN	PDPT	W1	PDY	S1	RE	CDX	PSIR	RA	Right-hand Article no.	£
		mm	mm	mm	mm	mm	mm	mm	°	°		
08	8,00. R .30°.1,0	7.8	1.0	3.5	4.65	6	0.2	0.4	30	3	73 326 010	23.54
	8,00. R .47°.1,2	7.8	1.2	3.5	4.65	6	0.2	0.4	47	3	73 326 012	20.45
11	11,00. R .30°.2,3	11.0	2.3	4.2	6.70	8	0.2	0.6	30	3	73 326 423	22.99
	11,00. R .47°.2,3	11.0	2.3	4.2	6.70	8	0.2	0.6	47	3	73 326 323	19.91
14	13,70. R .47°.3,0	13.7	3.0	5.3	8.70	9	0.2	0.8	47	3	73 326 530	20.45
	13,70. R .30°.4,0	13.7	4.0	5.3	8.70	9	0.2	0.8	30	3	73 326 540	23.54

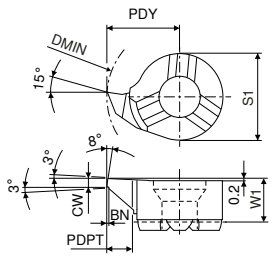
Steel	●
Stainless steel	●
Cast iron	●
Non ferrous metals	●
Heat resistant alloys	●
Hardened materials	

MiniCut – Insert for pregrooving and chamfering

WNT \ Performance

CWX500



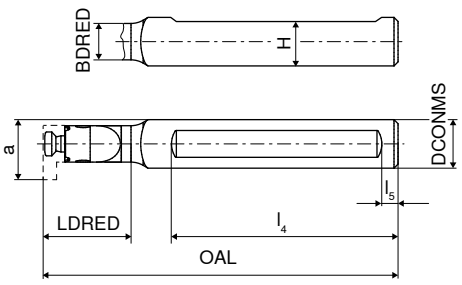


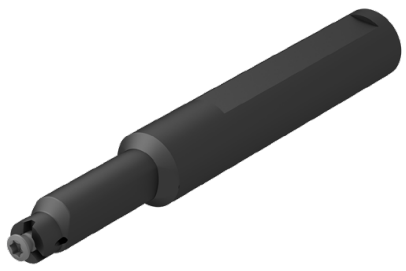
Size	Designation	DMIN	CW	PDPT	W1	PDY	S1	BN	Right-hand Article no.	£
		mm	mm	mm	mm	mm	mm	mm		
08	8,00. R .1,00.45°	8	1	1.0	3.3	4.8	6	0.2	73 338 100	19.91
11	11,00. R .1,00.45°	11	1	1.5	4.2	6.7	8	0.2	73 338 315	19.91
14	14,00. R .1,00.45°	14	1	1.5	5.3	9.0	9	0.2	73 338 515	19.91
16	16,00. R .1,00.45°	16	1	1.5	5.4	10.2	11	0.2	73 338 715	19.91

Steel	●
Stainless steel	●
Cast iron	●
Non ferrous metals	●
Heat resistant alloys	●
Hardened materials	

MiniCut – Steel Tool holder

WNT \ Performance





Designation	a mm	DCONMS f7 mm	OAL mm	l_4 mm	LDRED mm	BDRED mm	H mm	l_5 mm	Article no.	£
8,00/16.N.12.1,0	7.8	16	80	60	12	6	15.0	5	73 522 012	105.33
8,00/16.N.22.1,0	7.8	16	90	60	22	6	15.0	5	73 522 122	120.86
11,00/16.N.16.2,3	10.7	16	97	60	16	8	14.5	5	73 522 016	105.33
11,00/16.N.29.2,3	10.7	16	110	60	29	8	14.5	5	73 522 129	120.86
14,00/16.N.18.4,0	13.8	16	100	60	18	11	14.5	5	73 522 018	120.86
14,00/16.N.38.4,0	13.8	16	120	60	38	11	14.5	5	73 522 138	120.86
16,00/16.N.22.4,3	15.7	16	100	60	22	11	14.5	5	73 522 022	105.33
16,00/16.N.42.4,3	15.7	16	120	60	42	11	14.5	5	73 522 142	120.86

Key D

Clamping screw

Spare parts

Size		Key D £	Key D Article no.		Clamping screw £	Clamping screw Article no.
08	T08	5.67	80 950 110	M2,6	3.93	73 082 002
11	T10	6.63	80 950 112	M3,5	3.93	73 082 003
14	T15	6.74	80 950 113	M4	3.93	73 082 004
16	T20	7.21	80 950 114	M5	3.93	73 082 005

Team Cutting Tools

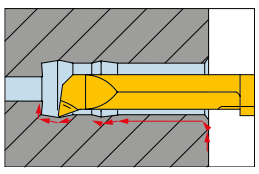
The new complete supplier in the field of machining

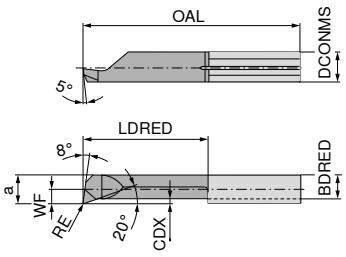
- Uniquely broad know-how in the field of machining
- Highly attractive, holistic service promise
- One of the largest product ranges on the market
- An enormously efficient distribution
- Leading expertise in future technologies from digitization to nanotechnology
- Deep industry expertise based on many years of experience
- All under one roof

UltraMini – Inserts for internal turning and profiling

WNT \ Performance

TiN | TiAlN





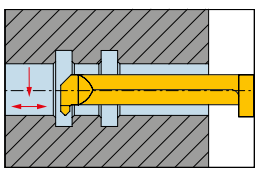
Designation	DCONMS h6 mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm	Standard tool holder	Right-hand Article no.	£	Right-hand Article no.	£
R 050.2-5	4		2.0	1.7	19	5	0.1	1.5	0.05	645.00..-D	73 004 520	25.24		
R 050.2-10	4		2.0	1.7	24	10	0.1	1.5	0.05	645.00..-D	73 004 521	27.51		
R 050.2-15	4		2.0	1.7	29	15	0.1	1.5	0.05	645.00..-D	73 004 522	27.28		
R 050.3-10	4	0.6	2.8	2.6	24	10	0.2	2.3	0.10	645.00..-D	73 004 531	29.01		
R 050.3-16	4	0.6	2.8	2.6	30	16	0.2	2.3	0.10	645.00..-D	73 004 530	31.82		
R 050.3-20	4	0.6	2.8	2.6	34	20	0.2	2.3	0.10	645.00..-D	73 004 532	31.78		
R 050.4-10	4	1.5	4.0	3.5	24	10	0.3	3.0	0.10	645.00..-D	73 004 541	28.61	73 004 841	27.44
R 050.4-16	4	1.5	4.0	3.5	30	16	0.3	3.0	0.10	645.00..-D	73 004 540	28.61	73 004 840	29.01
R 050.4-20	4	1.5	4.0	3.5	34	20	0.3	3.0	0.10	645.00..-D	73 004 542	30.49	73 004 842	32.44
R 050.4-24	4	1.5	4.0	3.5	38	24	0.3	3.0	0.10	645.00..-D	73 004 545	35.74	73 004 845	36.83
R 050.4-28	4	1.5	4.0	3.5	42	28	0.3	3.0	0.10	645.00..-D	73 004 546	39.14	73 004 846	41.00
R 050.5-10	5	1.9	5.0	4.4	25	10	0.5	3.8	0.15	645.00..-D	73 004 551	27.07	73 004 851	25.71
R 050.5-15	5	1.9	5.0	4.4	30	15	0.5	3.8	0.15	645.00..-D	73 004 552	28.84	73 004 852	27.44
R 050.5-20	5	1.9	5.0	4.4	35	20	0.5	3.8	0.15	645.00..-D	73 004 550	29.60	73 004 850	31.59
R 050.5-25	5	1.9	5.0	4.4	40	25	0.5	3.8	0.15	645.00..-D	73 004 553	33.44	73 004 853	35.74
R 050.5-30	5	1.9	5.0	4.4	45	30	0.5	3.8	0.15	645.00..-D	73 004 554	36.76	73 004 854	40.29
R 050.5-35	5	1.9	5.0	4.4	50	35	0.5	3.8	0.15	645.00..-D	73 004 556	42.67	73 004 856	44.68
R/L 050.5-40	5	1.9	5.0	4.4	55	40	0.5	3.8	0.15	645.00..-D			73 004 857	48.56
R 050.6-15	6	2.3	6.0	5.3	30	15	0.5	4.5	0.15	676.00..-D	73 004 561	28.30	73 004 861	27.44
R 050.6-22	6	2.3	6.0	5.3	37	22	0.5	4.5	0.15	676.00..-D	73 004 560	30.81	73 004 860	31.59
R 050.6-25	6	2.3	6.0	5.3	40	25	0.5	4.5	0.15	676.00..-D	73 004 562	32.76	73 004 862	35.74
R 050.6-30	6	2.3	6.0	5.3	45	30	0.5	4.5	0.15	676.00..-D	73 004 563	37.24	73 004 863	40.29
R 050.6-35	6	2.3	6.0	5.3	50	35	0.5	4.5	0.15	676.00..-D	73 004 564	42.67	73 004 864	44.68
R 050.6-42	6	2.3	6.0	5.3	57	42	0.5	4.5	0.15	676.00..-D	73 004 565	48.53	73 004 865	49.93
R 050.7-20	7	2.8	6.8	6.3	35	20	0.6	5.5	0.15	676.00..-D	73 004 572	31.44	73 004 872	31.14
R 050.7-25	7	2.8	6.8	6.3	40	25	0.6	5.5	0.15	676.00..-D	73 004 573	38.87	73 004 873	36.14
R 050.7-30	7	2.8	6.8	6.3	45	30	0.6	5.5	0.15	676.00..-D	73 004 574	39.42	73 004 874	40.13
R 050.7-35	7	2.8	7.0	6.3	50	35	0.6	5.5	0.15	676.00..-D	73 004 575	45.45	73 004 875	45.45
R 050.7-40	7	2.8	7.0	6.3	55	40	0.6	5.5	0.15	676.00..-D	73 004 576	50.63	73 004 876	50.63
R 050.7-45	7	2.8	7.0	6.3	60	45	0.6	5.5	0.15	676.00..-D	73 004 577	52.67	73 004 877	52.67
R 050.7-50	7	2.8	7.0	6.3	65	50	0.6	5.5	0.15	676.00..-D	73 004 578	57.76	73 004 878	57.76

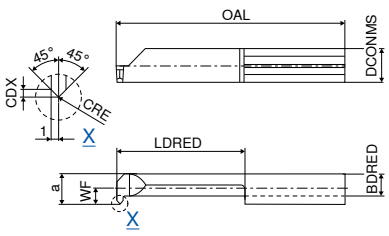
Steel	●	●
Stainless steel	●	●
Cast iron	○	●
Non ferrous metals	○	●
Heat resistant alloys	○	●
Hardened materials		

UltraMini – Inserts for internal turning and chamfering

WNT \ Performance

TiN





Designation	DCONMS h6 mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	CRE mm	Standard tool holder	Right-hand Article no.	£
R 060.5-15	5	1.9	5.0	4.4	30	15	0.7	3.3	0.2	645.00..-D	73 006 551	25.86
R 060.5-20	5	1.9	5.0	4.4	35	20	0.7	3.3	0.2	645.00..-D	73 006 550	28.78
R 060.7-20	7	2.7	6.8	6.3	35	20	0.7	3.8	0.2	676.00..-D	73 006 570	30.02

Steel	●
Stainless steel	●
Cast iron	○
Non ferrous metals	○
Heat resistant alloys	○
Hardened materials	

Speed Calculation

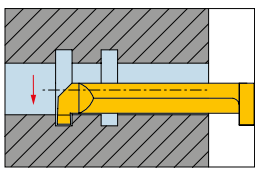
$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

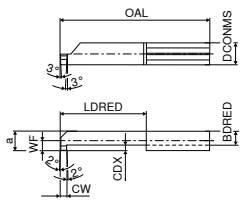
v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

UltraMini – Inserts for Internal Grooving

WNT \ Performance

TiN





Designation	DCONMS h6 mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	CW mm	Standard tool holder	Right-hand Article no.	£
R 004.0100-10	4	1.5	4.0	3.5	24	10	0.8	2.4	1.0	645.00..-D	73 002 540	25.48
R 004.0100-16	4	1.5	4.0	3.5	30	16	0.8	2.4	1.0	645.00..-D	73 002 541	31.12
R 004.0100-20	4	1.5	4.0	3.5	34	20	0.8	2.4	1.0	645.00..-D	73 002 542	33.54
R 005.0100-10	5	1.9	5.0	4.4	25	10	1.0	3.3	1.0	645.00..-D	73 002 650	25.07
R 005.0200-10	5	1.9	5.0	4.4	25	10	1.0	3.3	2.0	645.00..-D	73 002 658	25.95
R 005.0150-10	5	1.9	5.0	4.4	25	10	1.0	3.3	1.5	645.00..-D	73 002 654	25.95
R 005.0100-15	5	1.9	5.0	4.4	30	15	1.0	3.3	1.0	645.00..-D	73 002 651	29.37
R 005.0150-15	5	1.9	5.0	4.4	30	15	1.0	3.3	1.5	645.00..-D	73 002 655	29.37
R 005.0200-15	5	1.9	5.0	4.4	30	15	1.0	3.3	2.0	645.00..-D	73 002 659	29.37
R 005.0200-20	5	1.9	5.0	4.4	35	20	1.0	3.3	2.0	645.00..-D	73 002 553	33.25
R 005.0150-20	5	1.9	5.0	4.4	35	20	1.0	3.3	1.5	645.00..-D	73 002 552	33.25
R 005.0100-20	5	1.9	5.0	4.4	35	20	1.0	3.3	1.0	645.00..-D	73 002 551	33.25
R 005.0100-25	5	1.9	5.0	4.4	40	25	1.0	3.3	1.0	645.00..-D	73 002 652	36.83
R 005.0200-25	5	1.9	5.0	4.4	40	25	1.0	3.3	2.0	645.00..-D	73 002 750	37.08
R 005.0150-25	5	1.9	5.0	4.4	40	25	1.0	3.3	1.5	645.00..-D	73 002 656	36.83
R 005.0100-30	5	1.9	5.0	4.4	45	30	1.0	3.3	1.0	645.00..-D	73 002 653	41.00
R 005.0200-30	5	1.9	5.0	4.4	45	30	1.0	3.3	2.0	645.00..-D	73 002 751	41.31
R 005.0150-30	5	1.9	5.0	4.4	45	30	1.0	3.3	1.5	645.00..-D	73 002 657	41.00
R 005.0100-35	5	1.9	5.0	4.4	50	35	1.0	3.3	1.0	645.00..-D	73 002 680	44.75
R 006.0100-10	6	2.3	6.0	5.3	25	10	1.8	3.4	1.0	676.00..-D	73 002 660	25.53
R 006.0150-10	6	2.3	6.0	5.3	25	10	1.8	3.4	1.5	676.00..-D	73 002 664	24.45
R 006.0200-10	6	2.3	6.0	5.3	25	10	1.8	3.4	2.0	676.00..-D	73 002 668	25.53
R 006.0150-15	6	2.3	6.0	5.3	30	15	1.8	3.4	1.5	676.00..-D	73 002 665	29.60
R 006.0200-15	6	2.3	6.0	5.3	30	15	1.8	3.4	2.0	676.00..-D	73 002 669	29.60
R 006.0100-15	6	2.3	6.0	5.3	30	15	1.8	3.4	1.0	676.00..-D	73 002 661	29.60
R 006.0200-22	6	2.3	6.0	5.3	37	22	1.8	3.4	2.0	676.00..-D	73 002 563	33.48
R 006.0150-22	6	2.3	6.0	5.3	37	22	1.8	3.4	1.5	676.00..-D	73 002 562	33.48
R 006.0100-22	6	2.3	6.0	5.3	37	22	1.8	3.4	1.0	676.00..-D	73 002 561	33.48
R 006.0100-25	6	2.3	6.0	5.3	40	25	1.8	3.4	1.0	676.00..-D	73 002 662	37.08
R 006.0200-25	6	2.3	6.0	5.3	40	25	1.8	3.4	2.0	676.00..-D	73 002 760	37.08
R 006.0150-25	6	2.3	6.0	5.3	40	25	1.8	3.4	1.5	676.00..-D	73 002 666	37.08
R 006.0150-30	6	2.3	6.0	5.3	45	30	1.8	3.4	1.5	676.00..-D	73 002 667	41.31
R 006.0200-30	6	2.3	6.0	5.3	45	30	1.8	3.4	2.0	676.00..-D	73 002 761	41.31
R 006.0100-30	6	2.3	6.0	5.3	45	30	1.8	3.4	1.0	676.00..-D	73 002 663	41.31
R 006.0150-35	6	2.3	6.0	5.3	50	35	1.8	3.4	1.5	676.00..-D	73 002 684	44.75
R 006.0100-35	6	2.3	6.0	5.3	50	35	1.8	3.4	1.0	676.00..-D	73 002 682	44.75
R 006.0100-42	6	2.3	6.0	5.3	57	42	1.8	3.4	1.0	676.00..-D	73 002 685	50.24
R 007.0200-10	7	2.7	6.8	6.3	25	10	2.5	3.8	2.0	676.00..-D	73 002 670	25.95
R 007.0150-10	7	2.7	6.8	6.3	25	10	2.5	3.8	1.5	676.00..-D	73 002 575	25.95
R 007.0100-10	7	2.7	6.8	6.3	25	10	2.5	3.8	1.0	676.00..-D	73 002 570	25.95
R 007.0150-15	7	2.7	6.8	6.3	30	15	2.5	3.8	1.5	676.00..-D	73 002 576	29.91
R 007.0200-15	7	2.7	6.8	6.3	30	15	2.5	3.8	2.0	676.00..-D	73 002 671	28.61
R 007.0100-15	7	2.7	6.8	6.3	30	15	2.5	3.8	1.0	676.00..-D	73 002 571	29.91
R 007.0200-22	7	2.7	6.8	6.3	37	22	2.5	3.8	2.0	676.00..-D	73 002 672	34.17
R 007.0150-22	7	2.7	6.8	6.3	37	22	2.5	3.8	1.5	676.00..-D	73 002 577	34.17
R 007.0100-22	7	2.7	6.8	6.3	37	22	2.5	3.8	1.0	676.00..-D	73 002 572	34.17
R 007.0150-25	7	2.7	6.8	6.3	40	25	2.5	3.8	1.5	676.00..-D	73 002 578	37.47
R 007.0200-25	7	2.7	6.8	6.3	40	25	2.5	3.8	2.0	676.00..-D	73 002 673	36.92
R 007.0100-25	7	2.7	6.8	6.3	40	25	2.5	3.8	1.0	676.00..-D	73 002 573	37.47
R 007.0200-30	7	2.7	6.8	6.3	45	30	2.5	3.8	2.0	676.00..-D	73 002 674	39.42
R 007.0150-30	7	2.7	6.8	6.3	45	30	2.5	3.8	1.5	676.00..-D	73 002 579	40.67
R 007.0100-30	7	2.7	6.8	6.3	45	30	2.5	3.8	1.0	676.00..-D	73 002 574	42.01
R 007.0200-35	7	2.7	7.0	6.3	50	35	2.5	3.8	2.0	676.00..-D	73 002 692	46.01
R 007.0150-35	7	2.7	7.0	6.3	50	35	2.5	3.8	1.5	676.00..-D	73 002 690	46.01
R 007.0100-35	7	2.7	7.0	6.3	50	35	2.5	3.8	1.0	676.00..-D	73 002 688	46.01
R 007.0150-40	7	2.7	7.0	6.3	55	40	2.5	3.8	1.5	676.00..-D	73 002 702	51.02
R 007.0100-40	7	2.7	7.0	6.3	55	40	2.5	3.8	1.0	676.00..-D	73 002 700	51.02
R 007.0100-45	7	2.7	7.0	6.3	60	45	2.5	3.8	1.0	676.00..-D	73 002 712	55.42
R 007.0100-50	7	2.7	7.0	6.3	65	50	2.5	3.8	1.0	676.00..-D	73 002 714	59.25

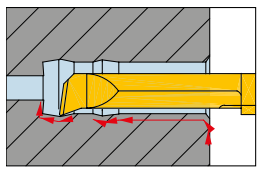
Steel	●
Stainless steel	●
Cast iron	○
Non ferrous metals	○
Heat resistant alloys	○
Hardened materials	

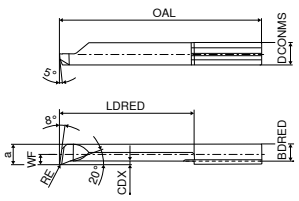
UltraMini – Inserts for internal turning and profiling

▲ with chip former

WNT \ Performance

TiAlN





Designation	DCONMS h6 mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm	Standard tool holder	Right-hand Article no.	£
R 050.4-10C	4	1.5	4	3.5	24	10	0.3	3.0	0.2	645.00..-D	73 016 410	27.44
R 050.4-16C	4	1.5	4	3.5	30	16	0.3	3.0	0.2	645.00..-D	73 016 416	29.01
R 050.4-20C	4	1.5	4	3.5	34	20	0.3	3.0	0.2	645.00..-D	73 016 420	32.44
R 050.4-24C	4	1.5	4	3.5	38	24	0.3	3.0	0.2	645.00..-D	73 016 424	36.83
R 050.4-28C	4	1.5	4	3.5	42	28	0.3	3.0	0.2	645.00..-D	73 016 428	41.00
R 050.5-10C	5	1.9	5	4.4	25	10	0.5	3.8	0.2	645.00..-D	73 016 510	25.71
R 050.5-15C	5	1.9	5	4.4	30	15	0.5	3.8	0.2	645.00..-D	73 016 515	27.44
R 050.5-20C	5	1.9	5	4.4	35	20	0.5	3.8	0.2	645.00..-D	73 016 520	31.59
R 050.5-25C	5	1.9	5	4.4	40	25	0.5	3.8	0.2	645.00..-D	73 016 525	35.74
R 050.5-30C	5	1.9	5	4.4	45	30	0.5	3.8	0.2	645.00..-D	73 016 530	40.29
R 050.5-35C	5	1.9	5	4.4	50	35	0.5	3.8	0.2	645.00..-D	73 016 535	44.68
R 050.6-15C	6	2.3	6	5.3	30	15	0.5	4.5	0.2	676.00..-D	73 016 615	27.44
R 050.6-22C	6	2.3	6	5.3	37	22	0.5	4.5	0.2	676.00..-D	73 016 622	31.59
R 050.6-25C	6	2.3	6	5.3	40	25	0.5	4.5	0.2	676.00..-D	73 016 625	35.74
R 050.6-30C	6	2.3	6	5.3	45	30	0.5	4.5	0.2	676.00..-D	73 016 630	40.29
R 050.6-35C	6	2.3	6	5.3	50	35	0.5	4.5	0.2	676.00..-D	73 016 635	44.68
R 050.6-42C	6	2.3	6	5.3	57	42	0.5	4.5	0.2	676.00..-D	73 016 642	49.93
R 050.7-20C	7	2.8	7	6.3	35	20	0.6	5.5	0.2	676.00..-D	73 016 720	31.14
R 050.7-25C	7	2.8	7	6.3	40	25	0.6	5.5	0.2	676.00..-D	73 016 725	36.14
R 050.7-30C	7	2.8	7	6.3	45	30	0.6	5.5	0.2	676.00..-D	73 016 730	40.13
R 050.7-35C	7	2.8	7	6.3	50	35	0.6	5.5	0.2	676.00..-D	73 016 735	45.45
R 050.7-40C	7	2.8	7	6.3	55	40	0.6	5.5	0.2	676.00..-D	73 016 740	50.63
R 050.7-45C	7	2.8	7	6.3	60	45	0.6	5.5	0.2	676.00..-D	73 016 745	52.67
R 050.7-50C	7	2.8	7	6.3	65	50	0.6	5.5	0.2	676.00..-D	73 016 750	57.76

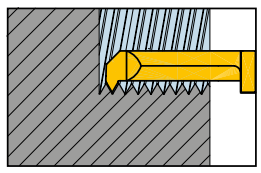
Steel	●
Stainless steel	●
Cast iron	●
Non ferrous metals	●
Heat resistant alloys	●
Hardened materials	

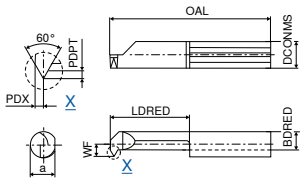
UltraMini – Inserts for internal threading (Partial profile)

M 60°

WNT \ Performance

TiN





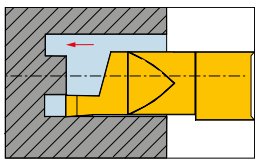
Designation	DCONMS h6 mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	BDRED mm	PDPT mm	PDX mm	Standard tool holder	Right-hand Article no.	£
R 005.0510-15	5	1.9	4.8	4.4	30	15	3.3	0.55	0.55	645.00..-D	73 100 545	28.74
R 005.0510-20	5	1.9	4.8	4.4	35	20	3.3	0.55	0.55	645.00..-D	73 100 544	29.94
R 006.0612-15	6	2.3	6.0	5.3	30	15	3.4	0.68	0.65	676.00..-D	73 100 547	28.74
R 006.0815-15	6	2.3	6.0	5.3	30	15	3.4	0.81	0.75	676.00..-D	73 100 549	29.11
R 006.0815-22	6	2.3	6.0	5.3	37	22	3.4	0.81	0.75	676.00..-D	73 100 548	29.72
R 006.0612-22	6	2.3	6.0	5.3	37	22	3.4	0.68	0.65	676.00..-D	73 100 546	29.72
R 007.0815-15	7	2.7	7.0	6.3	30	15	3.8	0.81	0.75	676.00..-D	73 100 550	29.72

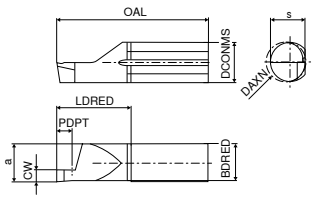
Steel	●
Stainless steel	●
Cast iron	○
Non ferrous metals	○
Heat resistant alloys	○
Hardened materials	

UltraMini – Inserts for axial grooving

WNT \ Performance

TiN



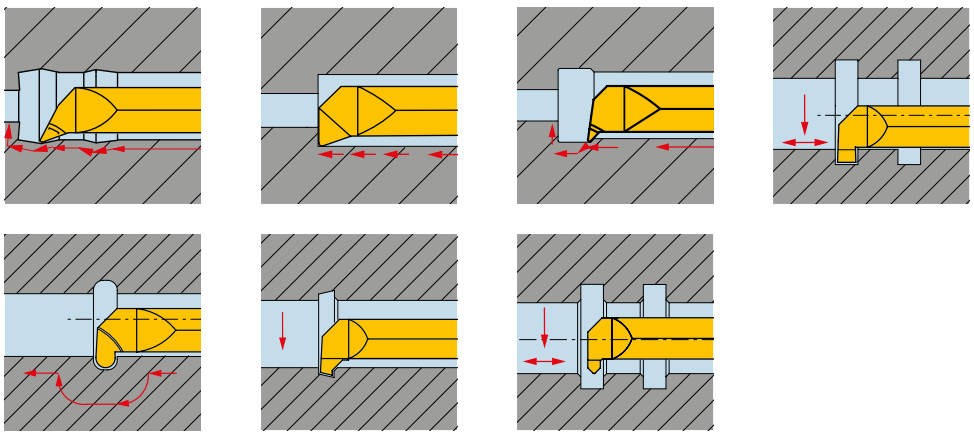


Designation	DCONMS h6	a	DAXN	s	OAL	LDRED	BDRED	PDPT	CW	Standard tool holder	Right-hand Article no.	£
	mm	mm	mm	mm	mm	mm	mm	mm	mm			
R 010.1006-10	6	5.2	6	5.3	26	11	4.9	1.5	1.0	676.00..-D	73 050 561	31.98
R 010.1506-10	6	5.2	6	5.3	26	11	4.9	2.0	1.5	676.00..-D	73 050 563	31.98
R 010.1008-10	7	5.9	8	6.3	26	11	5.6	1.5	1.0	676.00..-D	73 050 571	32.69
R 010.1008-30	7	5.9	8	6.3	45	30	5.6	1.5	1.0	676.00..-D	73 050 771	36.83
R 010.1008-20	7	5.9	8	6.3	35	20	5.6	1.5	1.0	676.00..-D	73 050 671	34.95
R 010.1508-20	7	5.9	8	6.3	35	20	5.6	2.5	1.5	676.00..-D	73 050 673	33.75
R 010.1508-30	7	5.9	8	6.3	45	30	5.6	2.5	1.5	676.00..-D	73 050 773	36.83
R 010.1508-10	7	5.9	8	6.3	26	11	5.6	2.5	1.5	676.00..-D	73 050 573	31.68
R 010.2008-20	7	5.9	8	6.3	35	20	5.6	3.0	2.0	676.00..-D	73 050 675	33.75
R 010.2008-30	7	5.9	8	6.3	45	30	5.6	3.0	2.0	676.00..-D	73 050 775	36.83
R 010.2008-10	7	5.9	8	6.3	26	11	5.6	3.0	2.0	676.00..-D	73 050 575	31.68
R 010.2508-20	7	5.9	8	6.3	35	20	5.6	3.5	2.5	676.00..-D	73 050 677	34.95
R 010.3008-20	7	5.9	8	6.3	35	20	5.6	3.5	3.0	676.00..-D	73 050 679	33.75
R 010.2508-30	7	5.9	8	6.3	45	30	5.6	3.5	2.5	676.00..-D	73 050 777	36.83
R 010.3008-10	7	5.9	8	6.3	26	11	5.6	3.5	3.0	676.00..-D	73 050 579	32.69
R 010.3008-30	7	5.9	8	6.3	45	30	5.6	3.5	3.0	676.00..-D	73 050 779	36.83
R 010.2508-10	7	5.9	8	6.3	26	11	5.6	3.5	2.5	676.00..-D	73 050 577	32.69

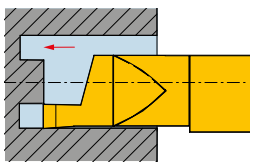
Steel	●
Stainless steel	●
Cast iron	○
Non ferrous metals	○
Heat resistant alloys	○
Hardened materials	

Internal turning and profiling, grooving and chamfering

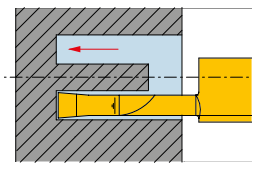
From Diameter 2.0 mm onwards up to a turning depth of 15.0 mm



Axial grooving

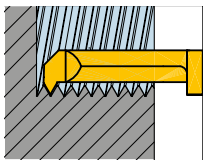


Minimum external diameter of groove 6.0 mm
At 1.5 mm grooving width
Up to 2.0 mm grooving depth



Minimum external diameter of groove 15.0 mm
At 3.0 mm grooving width
Up to 30.0 mm grooving depth

Thread turning



Turning of external threads from diameter 4.0 mm onwards
- Metric standard and fine thread
- Whitworth pipe threads

Miniature turning tools guide (Main catalogue 2019)

Cutting Data	59–61	Broaching – Recommendations for Correct Use	62
Coatings and thread types	63		

The rest of the comprehensive UltraMini range is available in the main catalogue.

UltraMini – Standard tool holder for cutting inserts

- Double ended
- Machining diameter from Ø 0.2 mm

Scope of supply:
Tool holder with allen key

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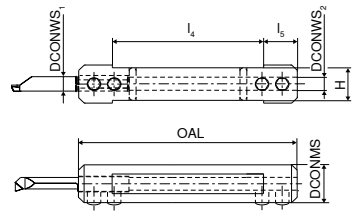


Designation	DCONWS$_1$	DCONWS$_2$	DCONMS	OAL	l_4	l_5	H	Article no.	£
	mm	mm	mm	mm	mm	mm	mm		
645.0012-D	4	5	12	75	55	10	10.3	73 080 163	95.14
645.0016-D	4	5	16	75	55	10	14.0	73 080 164	99.94
645.0020-D	4	5	20	90	70	10	18.0	73 080 165	107.62
676.0016-D	6	7	16	75	55	10	14.0	73 080 166	99.94
676.0020-D	6	7	20	90	70	10	18.0	73 080 167	107.62

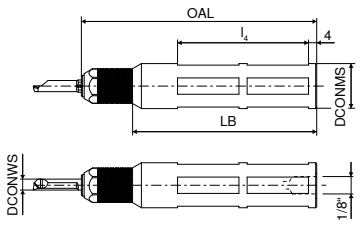
Clamping screw

Spare parts DCONWS$_1$		Article no. £	Article no.
4	M5x6	3.16	73 082 001
6	M5x6	3.16	73 082 001

UltraMini – Quick change tool holder for cutting inserts

Scope of supply:
Tool holder, lock nut and clamping wedge

WNT \ Performance



Designation	DCONWS	DCONMS g6	OAL	LB	l_4	Article no.	£
	mm	mm	mm	mm	mm		
UM600H.0012.4	4	12.00	115	90	64	73 089 124	179.60
UM600H.0016.4	4	16.00	115	90	64	73 089 164	162.95
UM600H.001905.4	4	19.05	115	90	64	73 089 194	174.85
UM600H.0020.4	4	20.00	115	90	64	73 089 204	172.47
UM600H.0022.4	4	22.00	115	90	64	73 089 224	175.44
UM600H.0025.4	4	25.00	115	90	64	73 089 254	179.01
UM600H.00254.4	4	25.40	115	90	64	73 089 264	182.58
UM600H.0028.4	4	28.00	115	90	64	73 089 284	182.58
UM600H.0012.5	5	12.00	115	90	64	73 089 125	179.60
UM600H.0016.5	5	16.00	115	90	64	73 089 165	162.95
UM600H.001905.5	5	19.05	115	90	64	73 089 195	174.85
UM600H.0020.5	5	20.00	115	90	64	73 089 205	172.47
UM600H.0022.5	5	22.00	115	90	64	73 089 225	175.44
UM600H.0025.5	5	25.00	115	90	64	73 089 255	179.01
UM600H.00254.5	5	25.40	115	90	64	73 089 265	182.58
UM600H.0028.5	5	28.00	115	90	64	73 089 285	182.58
UM600H.0012.6	6	12.00	115	90	64	73 089 126	179.60
UM600H.0016.6	6	16.00	115	90	64	73 089 166	162.95
UM600H.001905.6	6	19.05	115	90	64	73 089 196	174.85
UM600H.0020.6	6	20.00	115	90	64	73 089 206	172.47
UM600H.0022.6	6	22.00	115	90	64	73 089 226	175.44
UM600H.0025.6	6	25.00	115	90	64	73 089 256	179.01
UM600H.00254.6	6	25.40	115	90	64	73 089 266	182.58
UM600H.0028.6	6	28.00	115	90	64	73 089 286	182.58
UM600H.0012.7	7	12.00	115	90	64	73 089 127	179.60
UM600H.0016.7	7	16.00	115	90	64	73 089 167	162.95
UM600H.001905.7	7	19.05	115	90	64	73 089 197	174.85
UM600H.0020.7	7	20.00	115	90	64	73 089 207	172.47
UM600H.0022.7	7	22.00	115	90	64	73 089 227	175.44
UM600H.0025.7	7	25.00	115	90	64	73 089 257	179.01
UM600H.00254.7	7	25.40	115	90	64	73 089 267	182.58
UM600H.0028.7	7	28.00	115	90	64	73 089 287	182.58

Avoid pulling cuts. When using thro' coolant supply, tighten using key!

Lock nut UM600H

Clamping wedge UM600H

Spare parts DCONWS		Article no. £	Article no.	Article no. £	Article no.
4	M4	40.44	73 950 104	26.17	73 950 111
5	M5	40.44	73 950 105	26.17	73 950 111
6	M6	40.44	73 950 106	26.17	73 950 111
7	M7	40.44	73 950 107	26.17	73 950 111

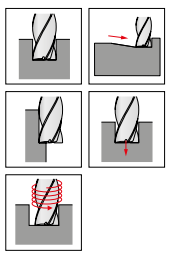
Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

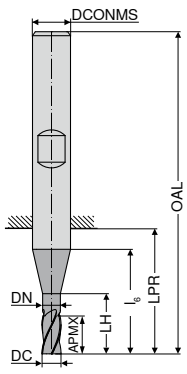
v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

Slot milling cutter HSS-E Co 8

N | λ_s=30° γ_s=10° | ZEFP



WNT \ Performance



DC mm	Tol.	APMX mm	DN mm	LH mm	l_6 mm	LPR mm	OAL mm	DCONMS h6 mm	ZEFP	Ti100 Pro DIN 327 B Article no.	£	Ti100 Pro Factory standard B Article no.	£
1.00	h10	2.5		2.5	9	11	47	6	2	54 025 010 [1]	14.93		
1.50	h10	3.0		3.0	9	11	47	6	2	54 025 015 [1]	14.36		
1.80	h10	4.0		4.0	10	12	48	6	2	54 025 018	18.90		
2.00	e8	4.0		4.0	10	12	48	6	2	54 025 020	16.74		
2.50	e8	5.0		5.0	11	13	49	6	2	54 025 025	16.74		
2.80	h10	5.0		5.0	11	13	49	6	2	54 025 028	13.79		
3.00	e8	5.0		5.0	11	13	49	6	2	54 025 030	13.53		
3.00	e8	8.0		8.0	18	20	56	6	2			54 020 030	26.45
3.50	h10	6.0		6.0	12	14	50	6	2	54 025 035	12.66		
3.50	h10	10.0		10.0	21	23	59	6	2			54 020 035	28.42
3.80	h10	7.0		7.0	13	15	51	6	2	54 025 038	17.69		
4.00	e8	7.0		7.0	13	15	51	6	2	54 025 040	11.47		
4.00	e8	11.0		11.0	25	27	63	6	2			54 020 040	17.82
4.50	h10	7.0		7.0	13	15	51	6	2	54 025 045	12.66		
4.50	h10	11.0		11.0	25	27	63	6	2			54 020 045	19.83
4.80	h10	8.0		8.0	14	16	52	6	2	54 025 048	18.26		
5.00	e8	8.0		8.0	14	16	52	6	2	54 025 050	12.91		
5.00	e8	13.0		13.0	30	32	68	6	2			54 020 050	17.82
5.50	h10	8.0		8.0	14	16	52	6	2	54 025 055	13.48		
5.50	h10	13.0		13.0	30	32	68	6	2			54 020 055	19.83
5.75	h10	8.0		8.0	14	16	52	6	2	54 025 057	18.26		
6.00	e8	8.0	5.50	14.0	14	16	52	6	2	54 025 060	12.71		
6.00	e8	13.0	5.50	30.0	30	32	68	6	2			54 020 060	18.71
6.50	h10	10.0	6.00	16.0	18	20	60	10	2	54 025 065	16.57		
6.50	h10	16.0	6.35	36.0	38	40	80	10	2			54 020 065	24.68
6.75	h10	10.0	6.50	16.0	18	20	60	10	2	54 025 067	16.57		
7.00	e8	10.0	6.50	16.0	18	20	60	10	2	54 025 070	16.57		
7.00	e8	16.0	6.35	36.0	38	40	80	10	2			54 020 070	23.67
7.50	h10	10.0	7.00	16.0	18	20	60	10	2	54 025 075	16.62		
7.50	h10	16.0	7.35	36.0	38	40	80	10	2			54 020 075	24.68
7.75	h10	11.0	7.50	17.0	19	21	61	10	2	54 025 077	26.45		
8.00	e8	11.0	7.50	17.0	19	21	61	10	2	54 025 080	17.69		
8.00	e8	19.0	7.35	44.0	46	48	88	10	2			54 020 080	22.22
8.50	h10	11.0	8.00	18.0	19	21	61	10	2	54 025 085	18.71		
8.50	h10	19.0	8.35	45.0	46	48	88	10	2			54 020 085	26.05
8.70	h10	11.0	8.50	18.0	19	21	61	10	2	54 025 087	28.05		
9.00	h10	11.0	8.50	18.0	19	21	61	10	2	54 025 090	26.50		
9.00	h10	19.0	8.35	45.0	46	48	88	10	2			54 020 090	36.32
9.50	h10	11.0	9.00	18.0	19	21	61	10	2	54 025 095	27.05		
9.50	h10	19.0	9.35	45.0	46	48	88	10	2			54 020 095	35.19
9.70	h10	13.0	9.50	21.0	21	23	63	10	2	54 025 097	28.03		
10.00	e8	13.0	9.50	21.0	21	23	63	10	2	54 025 100	17.58		
10.00	e8	22.0	9.35	53.0	53	55	95	10	2			54 020 100	23.54
10.50	h10	13.0	10.00	21.0	23	25	70	12	2	54 025 105	28.27		
10.70	h10	13.0	10.50	21.0	23	25	70	12	2	54 025 107	29.97		
11.00	h10	13.0	10.50	21.0	23	25	70	12	2	54 025 110	25.56		
11.00	h10	22.0	10.50	53.0	55	57	102	12	2			54 020 110	28.45
11.50	h10	13.0	11.00	21.0	23	25	70	12	2	54 025 115	28.71		
11.70	h10	16.0	11.50	26.0	26	28	73	12	2	54 025 117	30.36		
12.00	e8	16.0	11.50	26.0	26	28	73	12	2	54 025 120	22.98		
12.00	e8	26.0	11.50	63.0	63	65	110	12	2			54 020 120	27.01
12.70	h10	16.0	11.50	26.0	26	28	73	12	2	54 025 127	40.93		
13.00	h10	16.0	11.50	26.0	26	28	73	12	2	54 025 130	36.58		
13.00	h10	26.0	11.50	63.0	63	65	110	12	2			54 020 130	39.55
13.70	h10	16.0	11.50	26.0	26	28	73	12	2	54 025 137	34.25		
14.00	e8	16.0	11.50	26.0	26	28	73	12	2	54 025 140	30.65		
14.00	e8	26.0	11.50	63.0	63	65	110	12	2			54 020 140	36.26
15.00	h10	16.0	11.50	26.0	26	28	73	12	2	54 025 150	34.00		
15.00	h10	26.0	11.50	63.0	63	65	110	12	2			54 020 150	60.26
15.70	h10	19.0	15.00	29.0	29	31	79	16	2	54 025 157	47.02		
16.00	e8	19.0	15.00	29.0	29	31	79	16	2	54 025 160	32.99		
16.00	e8	32.0	15.00	73.0	73	75	123	16	2			54 020 160	40.16
17.00	h10	19.0	15.00	29.0	29	31	79	16	2	54 025 170	52.70		
17.00	h10	32.0	15.00	73.0	73	75	123	16	2			54 020 170	76.81
17.70	h10	19.0	15.00	29.0	29	31	79	16	2	54 025 177	52.51		
18.00	e8	19.0	15.00	29.0	29	31	79	16	2	54 025 180	40.24		
18.00	e8	32.0	15.00	73.0	73	75	123	16	2			54 020 180	54.89
19.00	h10	19.0	15.00	29.0	29	31	79	16	2	54 025 190	56.28		
19.00	h10	32.0	15.00	73.0	73	75	123	16	2			54 020 190	79.25
19.70	h10	22.0	19.00	36.0	36	38	88	20	2	54 025 197	61.83		
20.00	e8	22.0	19.00	36.0	36	38	88	20	2	54 025 200	48.48		
20.00	e8	38.0	19.00	89.0	89	91	141	20	2			54 020 200	55.83
21.70	h10	22.0	19.00	36.0	36	38	88	20	2	54 025 217	81.22		
22.00	e8	22.0	19.00	36.0	36	38	88	20	2	54 025 220	74.22		
22.00	e8	38.0	19.00	89.0	89	91	141	20	2			54 020 220	95.06
23.70	h10	26.0	23.00	42.0	44	46	102	25	2	54 025 237	97.83		
24.00	e8	26.0	23.00	42.0	44	46	102	25	2	54 025 240	92.47		
24.00	e8	45.0	23.00	106.0	108	110	166	25	2			54 020 240	147.60
24.70	h10	26.0	24.00	44.0	44	46	102	25	2	54 025 247	94.56		
25.00	e8	26.0	24.00	44.0	44	46	102	25	2	54 025 250	93.05		
25.00	e8	45.0	24.00	108.0	108	110	166	25	2			54 020 250	98.38
26.00	h10	26.0	24.00	44.0	44	46	102	25	2	54 025 260	103.29		

	Ti100 Pro DIN 327	Ti100 Pro Factory standard
Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	○	○
Heat resistant alloys	○	○
Hardened materials		

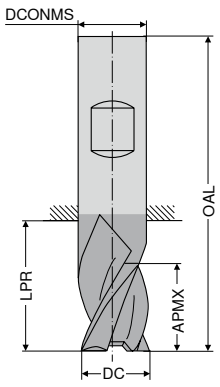
1) Factory standard

Throw-away milling cutter, HSS-E Co 8

▲ Shank similar to DIN 1835 B

N | λ_s=30° γ_s=12° | ZEFP

WNT \ Performance



Ti100 Pro

Ti100 Pro

DC e8 mm	APMX mm	LPR mm	OAL mm	DCONMS h6 mm	ZEFP	Factory standard Article no.	£	Factory standard Article no.	£
1.00	2	8	34	6	3	54 014 010	10.11		
1.50	3	8	34	6	3	54 014 015	10.11		
1.50	4	10	35	6	3			54 042 015 1)	11.19
1.80	3	8	34	6	3	54 014 018	10.11		
2.00	4	9	35	6	3	54 014 020	10.11		
2.00	7	12	38	6	3			54 042 020	11.19
2.30	4	9	35	6	3	54 014 023	10.11		
2.50	5	10	36	6	3	54 014 025	10.11		
2.50	8	13	39	6	3			54 042 025	11.19
2.80	5	10	36	6	3	54 014 028	10.11		
3.00	5	10	36	6	3	54 014 030	10.11		
3.00	8	13	39	6	3			54 042 030	11.19
3.30	6	11	37	6	3	54 014 033	10.11		
3.50	6	11	37	6	3	54 014 035	10.11		
3.50	10	15	41	6	3			54 042 035	11.19
3.80	7	12	38	6	3	54 014 038	10.11		
4.00	7	12	38	6	3	54 014 040	10.11		
4.00	11	16	42	6	3			54 042 040	11.19
4.30	7	12	38	6	3	54 014 043	10.11		
4.50	7	12	38	6	3	54 014 045	10.11		
4.50	11	16	42	6	3			54 042 045	11.19
4.80	8	13	39	6	3	54 014 048	10.11		
5.00	8	13	39	6	3	54 014 050	10.11		
5.00	13	18	44	6	3			54 042 050	11.19
5.30	8	13	39	6	3	54 014 053	10.11		
5.50	8	13	39	6	3	54 014 055	10.11		
5.50	13	18	44	6	3			54 042 055	11.19
5.75	8	13	39	6	3	54 014 057	10.11		
6.00	8	13	39	6	3	54 014 060	10.11		
6.00	13	18	44	6	3			54 042 060	11.19
6.50	10	14	42	8	3	54 014 065	13.33		
6.50	16	20	48	8	3			54 042 065	14.83
7.00	10	14	42	8	3	54 014 070	13.33		
7.00	16	20	48	8	3			54 042 070	14.83
7.50	10	14	42	8	3	54 014 075	13.33		
7.50	16	20	48	8	3			54 042 075	14.83
8.00	11	15	43	8	3	54 014 080	13.33		
8.00	19	23	51	8	3			54 042 080	14.83
8.50	11	16	48	10	3	54 014 085	15.73		
8.50	19	24	56	10	3			54 042 085	16.83
9.00	11	16	48	10	3	54 014 090	15.73		
9.00	19	24	56	10	3			54 042 090	16.83
9.50	11	16	48	10	3	54 014 095	15.73		
9.50	19	24	56	10	3			54 042 095	16.83
10.00	13	18	50	10	3	54 014 100	15.73		
10.00	22	27	59	10	3			54 042 100	16.83

	Factory standard	Factory standard
Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	○	○
Heat resistant alloys	○	○
Hardened materials		

1) Shank tolerance -0,025 / -0,0323

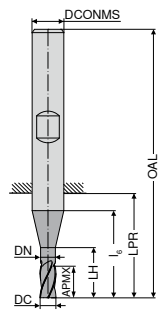
End milling cutter HSS-E Co 8

▲ > Ø 28,0 mm recessed centre

N | λ_s=30° γ_s=12° | ZEFP

≤ Ø 28,0 mm | > Ø 28,0 mm

WNT \ Performance



Ti100 Pro

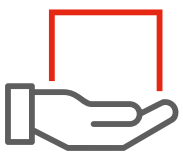
Ti100 Pro

DC k10 mm	APMX mm	DN mm	LH mm	l_6 mm	LPR mm	OAL mm	DCONMS h6 mm	ZEFP	DIN 69844 Article no.	£	DIN 844 Article no.	£
2.0	7		7	13	15	51	6	4	54 018 020	14.55		
2.5	8		8	14	16	52	6	4	54 018 025	14.55		
3.0	8		8	14	16	52	6	4	54 018 030	14.55		
3.0	12		12	18	20	56	6	4			54 019 030	19.27
3.5	10		10	16	18	54	6	4	54 018 035	14.55		
4.0	11		11	17	19	55	6	4	54 018 040	14.39		
4.0	19		19	25	27	63	6	4			54 019 040	19.52
4.5	11		11	17	19	55	6	4	54 018 045	14.55		
5.0	13		13	19	21	57	6	4	54 018 050	14.39		
5.0	24		24	30	32	68	6	4			54 019 050	19.52
5.5	13		13	19	21	57	6	4	54 018 055	14.55		
6.0	13	5.5	19	19	21	57	6	4	54 018 060	14.63		
6.0	24	5.5	30	30	32	68	6	4			54 019 060	18.26
6.5	16	6.0	22	24	26	66	10	4	54 018 065	23.81		
7.0	16	6.5	22	24	26	66	10	4	54 018 070	18.10		
7.0	30	6.5	36	38	40	80	10	4			54 019 070	28.39
7.5	16	7.0	22	24	26	66	10	4	54 018 075	23.81		
8.0	19	7.5	25	27	29	69	10	4	54 018 080	20.27		
8.0	38	7.5	44	46	48	88	10	4			54 019 080	25.62
8.5	19	8.0	26	27	29	69	10	4	54 018 085	18.91		
9.0	19	8.5	26	27	29	69	10	4	54 018 090	24.37		
9.0	38	8.5	45	46	48	88	10	4			54 019 090	30.36
9.5	19	9.0	26	27	29	69	10	4	54 018 095	27.66		
10.0	22	9.5	30	30	32	72	10	4	54 018 100	21.39		
10.0	45	9.5	53	53	55	95	10	4			54 019 100	27.38
10.5	22	10.0	30	32	34	79	12	4	54 018 105	31.28		
11.0	22	10.5	30	32	34	79	12	4	54 018 110	24.29		
11.0	45	10.5	53	55	57	102	12	4			54 019 110	33.05
11.5	22	11.0	30	32	34	79	12	4	54 018 115	24.29		
12.0	26	11.5	36	36	38	83	12	4	54 018 120	23.32		
12.0	53	11.5	63	63	65	110	12	4			54 019 120	29.84
13.0	26	11.5	36	36	38	83	12	4	54 018 130	33.29		
14.0	26	11.5	36	36	38	83	12	4	54 018 140	27.42		
14.0	53	11.5	63	63	65	110	12	4			54 019 140	35.32
15.0	26	11.5	36	36	38	83	12	4	54 018 150	34.58		
15.0	53	11.5	63	63	65	110	12	4			54 019 150	48.08
16.0	32	15.0	42	42	44	92	16	4	54 018 160	38.68		
16.0	63	15.0	73	73	75	123	16	4			54 019 160	47.90
18.0	32	15.0	42	42	44	92	16	4	54 018 180	44.40		
18.0	63	15.0	73	73	75	123	16	4			54 019 180	57.73
20.0	38	19.0	52	52	54	104	20	4	54 018 200	48.73		
20.0	75	19.0	89	89	91	141	20	4			54 019 200	64.97
22.0	38	19.0	52	52	54	104	20	5	54 018 220	60.95		
22.0	75	19.0	89	89	91	141	20	5			54 019 220	93.48
24.0	45	23.0	61	63	65	121	25	5	54 018 240	75.43		
24.0	90	23.0	106	108	110	166	25	5			54 019 240	130.99
25.0	45	24.0	63	63	65	121	25	5	54 018 250	74.95		
25.0	90	24.0	108	108	110	166	25	5			54 019 250	130.25
28.0	45	24.0	63	63	65	121	25	5	54 018 280	84.67		
28.0	90	24.0	108	108	110	166	25	5			54 019 280	154.04
30.0	45	24.0	63	63	65	121	25	5	54 018 300	122.48		
30.0	90	24.0	108	108	110	166	25	5			54 019 300	168.76
32.0	53	31.0	70	70	73	133	32	5	54 018 320	97.23		
32.0	106	31.0	123	123	126	186	32	6			54 019 320	185.88
36.0	53	31.0	70	70	73	133	32	6	54 018 360	161.88		
40.0	63	38.0	80	80	85	155	40	6	54 018 400	191.96		
40.0	125	38.0	142	142	147	217	40	6			54 019 400	229.26
45.0	125	38.0	142	142	147	217	40	8			54 019 450	397.20
50.0	150	48.0	172	172	172	252	50	8			54 019 500	490.05

	DIN 69844	DIN 844
Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	○	○
Heat resistant alloys	○	○
Hardened materials		

Where is my order right now?

Order Delivery Tracking



For those who do not want to lose sight of their order: With the shipment number you can track the current status of your order online – no matter how your order was placed.

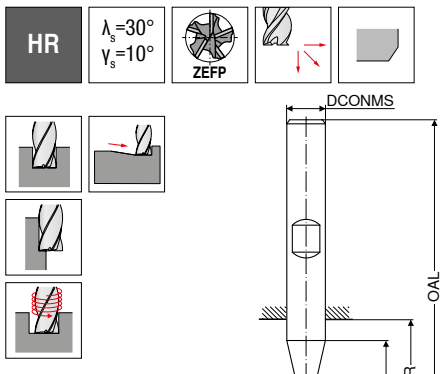
Technical support: 0800 073 2 075
3 time served engineers, available from 8:00 am to 6:30 pm, Monday to Friday

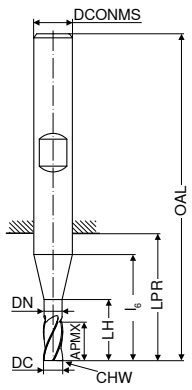
Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

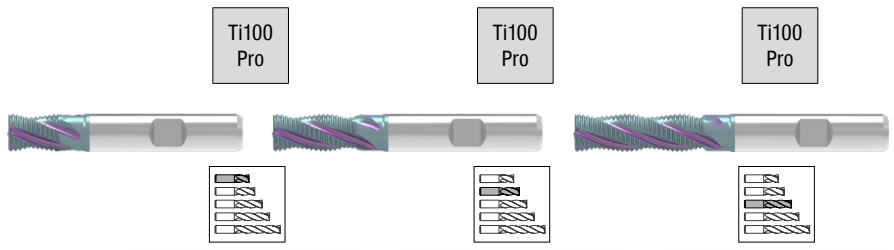
v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

Powdersteel Fine rough milling cutter



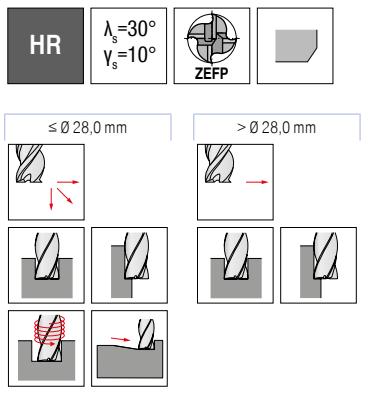


WNT \ Performance

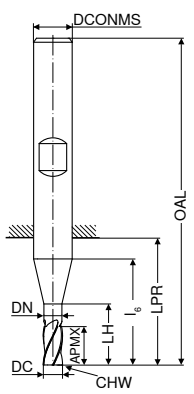


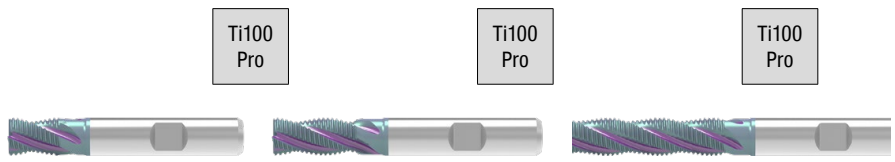
DC k12 mm	APMX mm	DN mm	LH mm	l6 mm	LPR mm	OAL mm	DCONMS h6 mm	CHW mm	ZEFP	Ti100 Pro Factory standard B Article no.	£	Ti100 Pro DIN 844 B Article no.	£	Ti100 Pro Factory standard B Article no.	£
6	8	5.5	14	14	16	52	6	0.35	4	54 031 060	31.79				
6	13	5.5	19	19	21	57	6	0.35	4			54 032 060	23.32		
8	11	7.5	17	19	21	61	10	0.45	4	54 031 080	35.41				
8	19	7.5	25	27	29	69	10	0.45	4			54 032 080	31.60		
8	28	7.5	34	36	38	78	10	0.45	4					54 033 080	40.75
10	13	9.5	21	21	23	63	10	0.45	4	54 031 100	35.95				
10	22	9.5	30	30	32	72	10	0.45	4			54 032 100	32.88		
10	34	9.5	42	42	44	84	10	0.45	4					54 033 100	50.17
12	16	11.5	26	26	28	73	12	0.60	4	54 031 120	42.97				
12	26	11.5	36	36	38	83	12	0.60	4			54 032 120	36.26		
12	40	11.5	50	50	52	97	12	0.60	4					54 033 120	59.49
14	16	11.5	26	26	28	73	12	0.60	4	54 031 140	55.11				
14	26	11.5	36	36	38	83	12	0.60	4			54 032 140	41.33		
14	40	11.5	50	50	52	97	12	0.60	4					54 033 140	75.48
16	19	15.0	29	29	31	79	16	0.70	4	54 031 160	59.42				
16	32	15.0	42	42	44	92	16	0.70	4			54 032 160	54.92		
16	48	15.0	58	58	60	108	16	0.70	4					54 033 160	97.06
18	19	15.0	29	29	31	79	16	0.70	4	54 031 180	72.11				
18	32	15.0	42	42	44	92	16	0.70	4			54 032 180	63.45		
18	48	15.0	58	58	60	108	16	0.70	4					54 033 180	122.42
20	22	19.0	36	36	38	88	20	0.70	4	54 031 200	80.26				
20	38	19.0	52	52	54	104	20	0.70	4			54 032 200	70.53		
20	56	19.0	70	70	72	122	20	0.70	4					54 033 200	147.70
22	22	19.0	36	36	38	88	20	0.70	4	54 031 220	108.47				
22	38	19.0	52	52	54	104	20	0.70	4			54 032 220	113.46		
22	56	19.0	70	70	72	122	20	0.70	4					54 033 220	185.21
25	26	24.0	44	44	46	102	25	0.70	4	54 031 250	126.94				
25	45	24.0	63	63	65	121	25	0.70	4			54 032 250	106.32		
25	68	24.0	86	86	88	144	25	0.70	4					54 033 250	216.31
28	26	24.0	44	44	46	102	25	0.90	5	54 031 280	176.71				
30	45	24.0	63	63	65	121	25	0.90	5			54 032 300	168.71		
32	32	31.0	49	49	52	112	32	0.90	6	54 031 320	215.14				
32	53	31.0	70	70	73	133	32	0.90	6			54 032 320	149.73		
Steel										●		●		●	
Stainless steel										●		●		●	
Cast iron										●		●		●	
Non ferrous metals										○		○		○	
Heat resistant alloys										○		○		○	
Hardened materials															

Fine profile milling cutter HSS-E Co 8



WNT \ Performance





DC k12 mm	APMX mm	DN mm	LH mm	l6 mm	LPR mm	OAL mm	DCONMS h6 mm	CHW mm	ZEFP	Ti100 Pro Factory standard B Article no.	£	Ti100 Pro DIN 69844 B Article no.	£	Ti100 Pro DIN 844 B Article no.	£
4	11		11	17	19	55	6	0.35	3			54 023 040	29.75		
5	13		13	19	21	57	6	0.35	3			54 023 050	17.86		
6	8	5.5	14	14	16	52	6	0.35	4	54 022 060	22.72				
6	13	5.5	19	19	21	57	6	0.35	4			54 023 060	16.08		
6	24	5.5	30	30	32	68	6	0.35	4					54 024 060	30.75
8	11	7.5	17	19	21	61	10	0.45	4	54 022 080	26.63				
8	19	7.5	25	27	29	69	10	0.45	4			54 023 080	19.47		
8	38	7.5	44	46	48	88	10	0.45	4					54 024 080	42.90
10	13	9.5	21	21	23	63	10	0.45	4	54 022 100	24.36				
10	22	9.5	30	30	32	72	10	0.45	4			54 023 100	21.63		
10	45	9.5	53	53	55	95	10	0.45	4					54 024 100	44.73
12	16	11.5	26	26	28	73	12	0.60	4	54 022 120	29.09				
12	26	11.5	36	36	38	83	12	0.60	4			54 023 120	23.96		
12	53	11.5	63	63	65	110	12	0.60	4					54 024 120	49.10
14	16	11.5	26	26	28	73	12	0.60	4	54 022 140	38.66				
14	26	11.5	36	36	38	83	12	0.60	4			54 023 140	31.93		
14	53	11.5	63	63	65	110	12	0.60	4					54 024 140	64.38
16	19	15.0	29	29	31	79	16	0.70	4	54 022 160	39.41				
16	32	15.0	42	42	44	92	16	0.70	4			54 023 160	34.66		
16	63	15.0	73	73	75	123	16	0.70	4					54 024 160	71.27
18	19	15.0	29	29	31	79	16	0.70	4	54 022 180	52.20				
18	32	15.0	42	42	44	92	16	0.70	4			54 023 180	45.68		
18	63	15.0	73	73	75	123	16	0.70	4					54 024 180	84.12
20	22	19.0	36	36	38	88	20	0.70	4	54 022 200	53.07				
20	38	19.0	52	52	54	104	20	0.70	4			54 023 200	48.00		
20	75	19.0	89	89	91	141	20	0.70	4					54 024 200	92.54
22	38	19.0	52	52	54	114	20	0.70	4			54 023 220	61.85		
22	75	19.0	89	89	91	141	20	0.70	4					54 024 220	115.35
25	45	24.0	63	63	65	121	25	0.70	4			54 023 250	72.87		
25	90	24.0	108	108	110	166	25	0.70	4					54 024 250	184.05
28	45	24.0	63	63	65	121	25	0.90	5			54 023 280	86.29		
28	90	24.0	108	108	110	166	25	0.90	5					54 024 280	206.16
30	45	24.0	63	63	65	121	25	0.90	5			54 023 300	94.33		
30	90	24.0	108	108	110	166	25	0.90	5					54 024 300	215.28
32	53	31.0	70	70	73	133	32	0.90	6			54 023 320	105.91		
32	106	31.0	123	123	126	186	32	0.90	6					54 024 320	217.44
Steel										●		●		●	
Stainless steel										●		●		●	
Cast iron										●		●		●	
Non ferrous metals										○		○		○	
Heat resistant alloys										○		○		○	
Hardened materials															

THE UPGRADE – FEEL THE DIFFERENCE!

Increased process security

Optimised core geometry

- ▲ Less vibration even with high angles of contact
- ▲ Significantly increased fracture resistance

Improved performance

Latest Dragonskin coating

- ▲ Processing of almost all materials
- ▲ Increased temperature resistance
- ▲ Wet and dry machining

Increased stability

Improved chip clearance

- ▲ Smoother processing
- ▲ Lower forces during chip formation
- ▲ Reduced heat generation

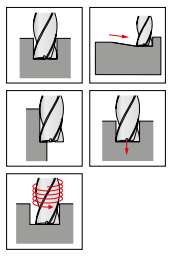
More flexibility

Expanded product range

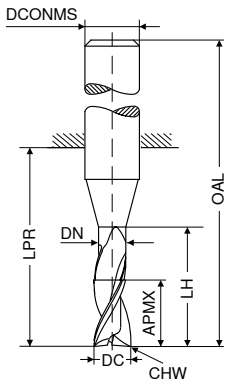
- ▲ Greater range of diameters
- ▲ Increased range of flute options
- ▲ HA shank options
- ▲ Versions with thro' coolant
- ▲ Roughing-finishing, rough and full slot milling cutters

SilverLine – End milling cutter

N | λ_s=30° γ_s=14° | ZEFP | HPC



WNT \ Performance



DPB72S

DRAGONSKIN

≈DIN 6527

HB

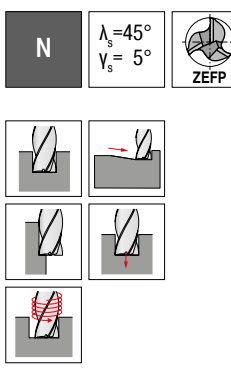
NEW

DC e8 mm	APMX mm	DN mm	LH mm	LPR mm	OAL mm	DCONMS h6 mm	CHW mm	ZEFP	Article no.	£
3.0	8	2.8	15	21	57	6	0.1	2	50 958 03200	34.66
3.5	11	3.3	15	21	57	6	0.1	2	50 958 03700	34.66
4.0	11	3.8	15	21	57	6	0.1	2	50 958 04200	34.66
4.5	13	4.3	21	21	57	6	0.1	2	50 958 04700	34.66
5.0	13	4.8	21	21	57	6	0.1	2	50 958 05200	34.66
5.5	13	5.3	21	21	57	6	0.1	2	50 958 05700	34.66
6.0	13	5.8	21	21	57	6	0.1	2	50 958 06200	34.66
7.0	16	6.8	27	27	63	8	0.1	2	50 958 07200	40.37
8.0	19	7.8	27	27	63	8	0.1	2	50 958 08200	40.37
9.0	19	8.8	32	32	72	10	0.1	2	50 958 09200	56.18
10.0	22	9.8	32	32	72	10	0.1	2	50 958 10200	56.18
11.0	26	10.8	38	38	83	12	0.1	2	50 958 11200	81.40
12.0	26	11.8	38	38	83	12	0.1	2	50 958 12200	81.40
14.0	26	13.8	38	38	83	14	0.1	2	50 958 14200	101.47
15.0	32	14.7	44	44	92	16	0.1	2	50 958 15200	131.59
16.0	32	15.7	44	44	92	16	0.1	2	50 958 16200	131.59
17.0	32	16.7	44	44	92	18	0.1	2	50 958 17200	159.80
18.0	32	17.7	44	44	92	18	0.1	2	50 958 18200	159.80
19.0	38	18.7	54	54	104	20	0.1	2	50 958 19200	197.74
20.0	38	19.7	54	54	104	20	0.1	2	50 958 20200	197.74

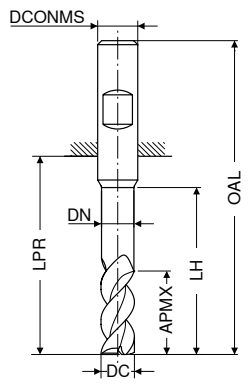
Steel	●
Stainless steel	●
Cast iron	●
Non ferrous metals	○
Heat resistant alloys	●
Hardened materials	

SilverLine – End milling cutter

N | λ_s=45° γ_s= 5° | ZEFP | HPC



WNT \ Performance



DPB72S | DPB72S | DPB72S

DRAGONSKIN | DRAGONSKIN | DRAGONSKIN

Factory standard | Factory standard | Factory standard

HB | HB | HB

NEW | NEW | NEW

DC f8 mm	APMX mm	DN mm	LH mm	LPR mm	OAL mm	DCONMS h6 mm	ZEFP	Article no.	£	Article no.	£	Article no.	£
3.0	8	2.9	15	21	57	6	3			50 992 03200	42.02		
3.5	11	3.4	16	21	57	6	3			50 992 03700	42.02		
4.0	8	3.9	15	18	54	6	3	50 992 04100	40.52				
4.0	11	3.9	16	21	57	6	3			50 992 04200	40.52		
4.0	16			26	62	6	3					50 992 04400	42.71
4.5	13	4.4	19	21	57	6	3			50 992 04700	42.02		
5.0	9	4.9	16	18	54	6	3	50 992 05100	40.52				
5.0	13	4.9	19	21	57	6	3			50 992 05200	40.52		
5.0	17			26	62	6	3					50 992 05400	42.71
5.5	13	5.4	19	21	57	6	3			50 992 05700	44.09		
6.0	10	5.9	17	18	54	6	3	50 992 06100	42.13				
6.0	13	5.9	19	21	57	6	3			50 992 06200	42.64		
6.0	18			26	62	6	3					50 992 06400	47.38
6.5	19	6.3	25	27	63	8	3			50 992 06700	51.26		
7.0	19	6.8	25	27	63	8	3			50 992 07200	51.26		
7.5	19	7.3	25	27	63	8	3			50 992 07700	51.26		
8.0	12		20	22	58	8	3	50 992 08100	47.87				
8.0	19	7.8	25	27	63	8	3			50 992 08200	49.78		
8.0	24			32	68	8	3					50 992 08400	53.21
8.5	22	8.2	30	32	72	10	3			50 992 08700	85.43		
9.0	22	8.7	30	32	72	10	3			50 992 09200	85.43		
9.5	22	9.2	30	32	72	10	3			50 992 09700	85.43		
10.0	14	9.7	24	26	66	10	3	50 992 10100	75.67				
10.0	22	9.7	30	32	72	10	3			50 992 10200	83.86		
10.0	30			40	80	10	3					50 992 10400	94.73
12.0	16	11.7	26	28	73	12	3	50 992 12100	106.11				
12.0	26	11.7	36	38	83	12	3			50 992 12200	113.57		
12.0	36			48	93	12	3					50 992 12400	128.58
14.0	18	13.7	28	30	75	14	3	50 992 14100	131.04				
14.0	26	13.7	36	38	83	14	3			50 992 14200	149.79		
14.0	42			54	99	14	3					50 992 14400	166.53
16.0	22	15.5	32	34	82	16	3	50 992 16100	158.61				
16.0	32	15.5	42	44	92	16	3			50 992 16200	254.16		
16.0	48			60	108	16	3					50 992 16400	256.98
18.0	24	17.5	34	36	84	18	3	50 992 18100	218.86				
18.0	32	17.5	42	44	92	18	3			50 992 18200	261.99		
18.0	54			66	114	18	3					50 992 18400	331.33
20.0	26	19.5	40	42	92	20	3	50 992 20100	268.18				
20.0	38	19.5	52	54	104	20	3			50 992 20200	305.67		
20.0	60			76	126	20	3					50 992 20400	382.56

Steel	●	●	●
Stainless steel	●	●	●
Cast iron	●	●	●
Non ferrous metals	○	○	○
Heat resistant alloys	●	●	●
Hardened materials			

Technical support: 0800 073 2 075
3 time served engineers, available from 8:00 am to 6:30 pm, Monday to Friday

Speed Calculation

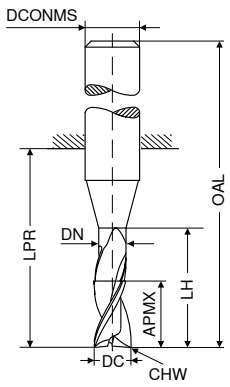
$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

SilverLine – End milling cutter

N | λ_s=45° γ_s= 5° | ZEFP | HPC

WNT \ Performance



DC f8	APMX	DN	LH	LPR	OAL	DCONMS h6	CHW	ZEFP	≈DIN 6527 HB NEW Article no.	£	≈DIN 6527 HB NEW Article no.	£	≈DIN 6527 HB NEW Article no.	£
mm	mm	mm	mm	mm	mm	mm	mm							
3.0	8	2.9	15	21	57	6	0.1	3			50 966 03200	42.02		
3.5	11	3.4	16	21	57	6	0.1	3			50 966 03700	42.02		
4.0	8	3.9	15	18	54	6	0.1	3	50 966 04100	40.52				
4.0	11	3.9	16	21	57	6	0.1	3			50 966 04200	40.52		
4.0	16			26	62	6	0.1	3					50 966 04400	42.71
4.5	13	4.4	19	21	57	6	0.1	3			50 966 04700	42.02		
5.0	9	4.9	16	18	54	6	0.1	3	50 966 05100	40.52				
5.0	13	4.9	19	21	57	6	0.1	3			50 966 05200	40.52		
5.0	17			26	62	6	0.1	3					50 966 05400	42.71
5.5	13	5.4	19	21	57	6	0.1	3			50 966 05700	44.09		
6.0	10	5.9	17	18	54	6	0.2	3	50 966 06100	42.13				
6.0	13	5.9	19	21	57	6	0.2	3			50 966 06200	42.64		
6.0	18			26	62	6	0.2	3					50 966 06400	47.38
6.5	19	6.3	25	27	63	8	0.2	3			50 966 06700	51.26		
7.0	19	6.8	25	27	63	8	0.2	3			50 966 07200	51.26		
7.5	19	7.3	25	27	63	8	0.2	3			50 966 07700	51.26		
8.0	12	7.8	20	22	58	8	0.2	3	50 966 08100	47.87				
8.0	19	7.8	25	27	63	8	0.2	3			50 966 08200	49.78		
8.0	24			32	68	8	0.2	3					50 966 08400	53.21
8.5	22	8.2	30	32	72	10	0.2	3			50 966 08700	85.43		
9.0	22	8.7	30	32	72	10	0.2	3			50 966 09200	85.43		
9.5	22	9.2	30	32	72	10	0.2	3			50 966 09700	85.43		
10.0	14	9.7	24	26	66	10	0.2	3	50 966 10100	75.67				
10.0	22	9.7	30	32	72	10	0.2	3			50 966 10200	83.86		
10.0	30			40	80	10	0.2	3					50 966 10400	94.73
12.0	16	11.7	26	28	73	12	0.2	3	50 966 12100	106.11				
12.0	26	11.7	36	38	83	12	0.2	3			50 966 12200	113.57		
12.0	36			48	93	12	0.2	3					50 966 12400	128.58
14.0	18	13.7	28	30	75	14	0.2	3	50 966 14100	131.04				
14.0	26	13.7	36	38	83	14	0.2	3			50 966 14200	149.79		
14.0	42			54	99	14	0.2	3					50 966 14400	166.53
16.0	22	15.5	32	34	82	16	0.2	3	50 966 16100	158.61				
16.0	32	15.5	42	44	92	16	0.2	3			50 966 16200	254.16		
16.0	48			60	108	16	0.2	3					50 966 16400	256.98
18.0	24	17.5	34	36	84	18	0.2	3	50 966 18100	218.86				
18.0	32	17.5	42	44	92	18	0.2	3			50 966 18200	261.99		
18.0	54			66	114	18	0.2	3					50 966 18400	331.33
20.0	26	19.5	40	42	92	20	0.2	3	50 966 20100	268.18				
20.0	38	19.5	52	54	104	20	0.2	3			50 966 20200	305.67		
20.0	60			76	126	20	0.2	3					50 966 20400	382.56

Steel	●	●	●
Stainless steel	●	●	●
Cast iron	●	●	●
Non ferrous metals	○	○	○
Heat resistant alloys	●	●	●
Hardened materials			

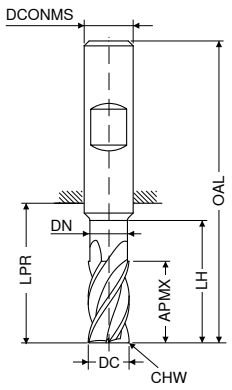
DC f8	RE	APMX	DN	LH	LPR	OAL	DCONMS h6	ZEFP	≈DIN 6527 HB NEW Article no.	£	≈DIN 6527 HB NEW Article no.	£	≈DIN 6527 HB NEW Article no.	£
mm	mm	mm	mm	mm	mm	mm	mm							
4	0.5	8	3.9	15	18	54	6	3	50 967 04105	49.41				
4	0.5	11	3.9	16	21	57	6	3			50 967 04205	50.90		
4	0.5	16			26	62	6	3					50 967 04405	54.05
5	0.5	9	4.9	16	18	54	6	3	50 967 05105	49.41				
5	0.5	13	4.9	19	21	57	6	3			50 967 05205	50.90		
5	0.5	17			26	62	6	3					50 967 05405	54.05
6	0.5	10	5.9	17	18	54	6	3	50 967 06105	50.74				
6	0.5	13	5.9	19	21	57	6	3			50 967 06205	59.26		
6	0.5	18			26	62	6	3					50 967 06405	59.95
8	1.0	12	7.8	20	22	58	8	3	50 967 08110	59.68				
8	1.0	19	7.8	25	27	63	8	3			50 967 08210	68.09		
8	1.0	24			32	68	8	3					50 967 08410	67.37
10	1.0	14	9.7	24	26	66	10	3	50 967 10110	107.56				
10	1.0	22	9.7	30	32	72	10	3			50 967 10210	116.57		
10	1.0	30			40	80	10	3					50 967 10410	119.85
12	1.5	16	11.7	26	28	73	12	3	50 967 12115	148.60				
12	1.5	26	11.7	36	38	83	12	3			50 967 12215	158.43		
12	1.5	36			48	93	12	3					50 967 12415	162.71
16	2.0	22	15.5	32	34	82	16	3	50 967 16120	301.21				
16	2.0	32	15.5	42	44	92	16	3			50 967 16220	306.22		
16	2.0	48			60	108	16	3					50 967 16420	325.14
20	2.0	26	19.5	40	42	92	20	3	50 967 20120	435.89				
20	2.0	38	19.5	52	54	104	20	3			50 967 20220	446.36		
20	2.0	60			76	126	20	3					50 967 20420	484.03

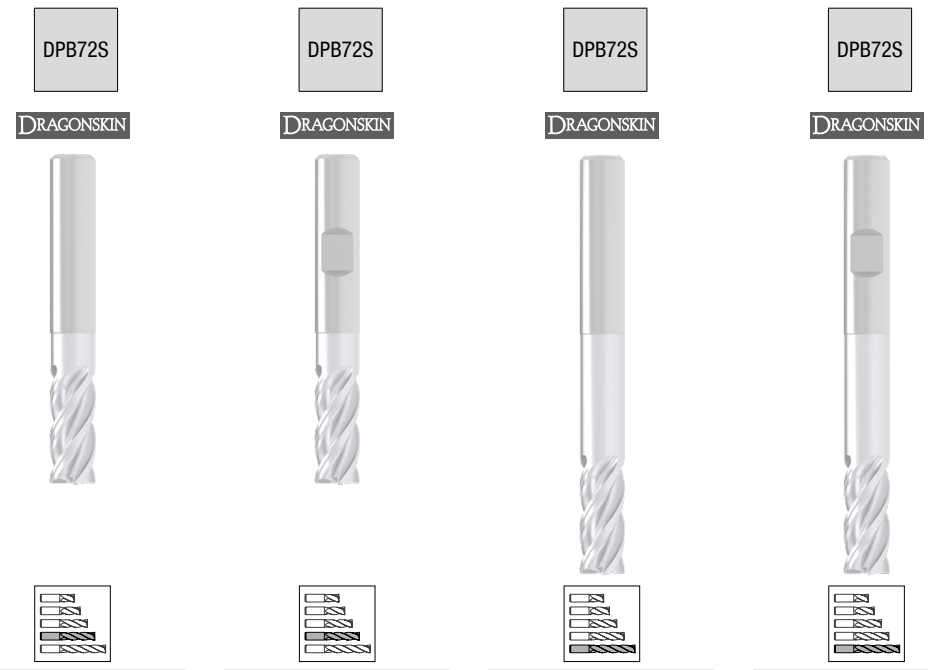
Steel	●	●	●
Stainless steel	●	●	●
Cast iron	●	●	●
Non ferrous metals	○	○	○
Heat resistant alloys	●	●	●
Hardened materials			

SilverLine – End milling cutter

N | λ_s=35° 38° | γ_s= 9° | ZEFP | HPC

WNT \ Performance





DC f8	APMX	DN	LH	LPR	OAL	DCONMS h6	α°	ZEFP	DPB72S DRAGONSKIN DIN 6527 HA NEW Article no.	£	DPB72S DRAGONSKIN DIN 6527 HB NEW Article no.	£	DPB72S DRAGONSKIN DIN 6527 HA NEW Article no.	£	DPB72S DRAGONSKIN DIN 6527 HB NEW Article no.	£
mm	mm	mm	mm	mm	mm	mm										
3	6.5	2.8	9	19	55	6	15	4	50 974 03200	32.30	50 975 03200	32.30				
3	6.5	2.8	15	22	58	6	15	4					50 974 03400	33.86	50 975 03400	33.86
4	8.5	3.8	12	19	55	6	15	4	50 974 04200	32.30	50 975 04200	32.30				
4	8.5	3.8	20	26	62	6	15	4					50 974 04400	33.86	50 975 04400	33.86
5	10.5	4.8	15	22	58	6	15	4	50 974 05200	32.30	50 975 05200	32.30				
5	10.5	4.8	25	34	70	6	15	4					50 974 05400	33.86	50 975 05400	33.86
6	13.0	5.8	18	22	58	6	15	4	50 974 06200	32.30	50 975 06200	32.30				
6	13.0	5.8	30	34	70	6	15	4					50 974 06400	33.86	50 975 06400	33.86
8	17.0	7.7	24	28	64	8	45	4	50 974 08200	44.04	50 975 08200	44.04				
8	17.0	7.7	40	44	80	8	45	4					50 974 08400	48.46	50 975 08400	48.46
10	21.0	9.7	30	34	74	10	45	4	50 974 10200	64.46	50 975 10200	64.46				
10	21.0	9.7	50	54	94	10	45	4					50 974 10400	71.25	50 975 10400	71.25
12	25.0	11.6	36	40	85	12	45	4	50 974 12200	81.22	50 975 12200	81.22				
12	25.0	11.6	60	64	109	12	45	4					50 974 12400	89.09	50 975 12400	89.09
14	29.0	13.6	42	46	91	14	45	4	50 974 14200	113.84	50 975 14200	113.84				
14	29.0	13.6	70	74	119	14	45	4					50 974 14400	125.22	50 975 14400	125.22
16	33.0	15.5	48	52	100	16	45	4	50 974 16200	182.27	50 975 16200	182.27				
16	33.0	15.5	80	84	132	16	45	4					50 974 16400	200.56	50 975 16400	200.56
18	38.0	17.5	54	58	106	18	45	4	50 974 18200	230.50	50 975 18200	230.50				
18	38.0	17.5	90	94	142	18	45	4					50 974 18400	253.62	50 975 18400	253.62
20	42.0	19.5	60	64	114	20	45	4	50 974 20200	249.34	50 975 20200	249.34				
20	42.0	19.5	100	104	154	20	45	4					50 974 20400	276.09	50 975 20400	276.09

Steel	●	●	●	●
Stainless steel	●	●	●	●
Cast iron	●	●	●	●
Non ferrous metals	○	○	○	○
Heat resistant alloys	●	●	●	●
Hardened materials				

DC f8	APMX	LPR	OAL	DCONMS h6	CHW	ZEFP	≈DIN 6527 HA NEW Article no.	£	≈DIN 6527 HB NEW Article no.	£	≈DIN 6527 HA NEW Article no.	£	≈DIN 6527 HB NEW Article no.	£
mm	mm	mm	mm	mm	mm									
3.0	5	14	50	6	0.1	4	50 972 03100	34.77	50 973 03100	34.77				
3.0	8	21	57	6	0.1	4					50 972 03200	34.77	50 973 03200	34.77
3.5	8	18	54	6	0.1	4	50 972 03600	34.77	50 973 03600	34.77				
3.5	11	21	57	6	0.1	4					50 972 03700	34.77	50 973 03700	34.77
4.0	8	18	54	6	0.1	4	50 972 04100	34.77	50 973 04100	34.77				
4.0	11	21	57	6	0.1	4					50 972 04200	34.77	50 973 04200	34.77
4.5	9	18	54	6	0.1	4	50 972 04600	35.49	50 973 04600	35.49				
4.5	13	21	57	6	0.1	4					50 972 04700	35.49	50 973 04700	35.49
5.0	9	18	54	6	0.1	4	50 972 05100	35.49	50 973 05100	35.49				
5.0	13	21	57	6	0.1	4					50 972 05200	35.49	50 973 05200	35.49
5.5	10	18	54	6	0.1	4	50 972 05600	34.34	50 973 05600	34.34				
5.5	13	21	57	6	0.1	4					50 972 05700	34.34	50 973 05700	34.34
6.0	10	18	54	6	0.1	4	50 972 06100	34.34	50 973 06100	34.34				
6.0	13	21	57	6	0.1	4					50 972 06200	34.34	50 973 06200	34.34
7.0	12	22	58	8	0.2	4	50 972 07100	45.66	50 973 07100	45.66				
7.0	21	27	63	8	0.2	4					50 972 07200	45.66	50 973 07200	45.66
8.0	12	22	58	8	0.2	4	50 972 08100	45.66	50 973 08100	45.66				
8.0	21	27	63	8	0.2	4					50 972 08200	45.66	50 973 08200	45.66
9.0	14	26	66	10	0.2	4	50 972 09100	59.58	50 973 09100	59.58				
9.0	22	32	72	10	0.2	4					50 972 09200	59.58	50 973 09200	59.58
10.0	14	26	66	10	0.2	4	50 972 10100	59.58	50 973 10100	59.58				
10.0	22	32	72	10	0.2	4					50 972 10200	59.58	50 973 10200	59.58
11.0	16	28	73	12	0.3	4	50 972 11100	94.19	50 973 11100	94.19				
11.0	26	38	83	12	0.3	4					50 972 11200	94.19	50 973 11200	94.19
12.0	16	28	73	12	0.3	4	50 972 12100	94.19	50 973 12100	94.19				
12.0	26	38	83	12	0.3	4					50 972 12200	94.19	50 973 12200	94.19
14.0	16	28	73	14	0.3	4	50 972 14100	121.03	50 973 14100	121.03				
14.0	26	38	83	14	0.3	4					50 972 14200	121.03	50 973 14200	121.03
15.0	22	34	82	16	0.3	4	50 972 15100	149.51	50 973 15100	149.51				
15.0	36	44	92	16	0.3	4					50 972 15200	149.51	50 973 15200	149.51
16.0	22	34	82	16	0.3	4	50 972 16100	149.51	50 973 16100	149.51				
16.0	36	44	92	16	0.3	4					50 972 16200	149.51	50 973 16200	149.51
17.0	22	34	82	18	0.3	4	50 972 17100	203.29	50 973 17100	203.29				
17.0	36	44	92	18	0.3	4					50 972 17200	203.29	50 973 17200	203.29
18.0	22	34	82	18	0.3	4	50 972 18100	203.29	50 973 18100	203.29				
18.0	36	44	92	18	0.3	4					50 972 18200	203.29	50 973 18200	203.29
19.0	26	42	92	20	0.3	4	50 972 19100	230.69	50 973 19100	230.69				
19.0	41	54	104	20	0.3	4					50 972 19200	230.69	50 973 19200	230.69
20.0	26	42	92	20	0.3	4	50 972 20100	230.69	50 973 20100	230.69				
20.0	41	54	104	20	0.3	4					50 972 20200	230.69	50 973 20200	230.69

Steel	●	●	●	●
Stainless steel	●	●	●	●
Cast iron	●	●	●	●
Non ferrous metals	○	○	○	○
Heat resistant alloys	●	●	●	●
Hardened materials				

Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

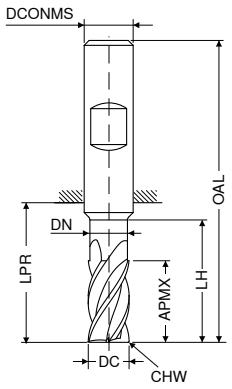
v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

SilverLine – End milling cutter

▲ Specially for full slot milling

N | λ_s=17° 45° γ_s=15° | ZEFP | HPC

WNT \ Performance



DPB72S | DRAGONSKIN

DPB72S | DRAGONSKIN

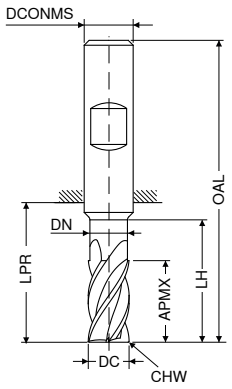
DC f8 mm	APMX mm	DN mm	LH mm	LPR mm	OAL mm	DCONMS h6 mm	CHW mm	ZEFP	DIN 6527 HA NEW Article no.	£	DIN 6527 HB NEW Article no.	£
3	8	2.8	13	21	57	6	0.1	4	50 976 03200	48.56	50 977 03200	48.56
4	11	3.8	17	21	57	6	0.1	4	50 976 04200	48.56	50 977 04200	48.56
5	13	4.8	19	21	57	6	0.1	4	50 976 05200	48.56	50 977 05200	48.56
6	13	5.8	19	21	57	6	0.1	4	50 976 06200	51.02	50 977 06200	51.02
8	21	7.7	25	27	63	8	0.2	4	50 976 08200	58.49	50 977 08200	58.49
10	22	9.7	30	32	72	10	0.2	4	50 976 10200	100.46	50 977 10200	100.46
12	26	11.6	36	38	83	12	0.3	4	50 976 12200	136.14	50 977 12200	136.14
14	26	13.6	36	38	83	14	0.3	4	50 976 14200	200.47	50 977 14200	200.47
16	36	15.5	42	44	92	16	0.3	4	50 976 16200	254.25	50 977 16200	254.25
18	36	17.5	42	44	92	18	0.3	4	50 976 18200	350.99	50 977 18200	350.99
20	41	19.5	52	54	104	20	0.3	4	50 976 20200	365.37	50 977 20200	365.37

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	○	○
Heat resistant alloys		
Hardened materials		

SilverLine – End milling cutter

NF | λ_s=35° 38° γ_s= 9° | ZEFP | HPC

WNT \ Performance



DPB72S | DRAGONSKIN

DIN 6527 HB NEW

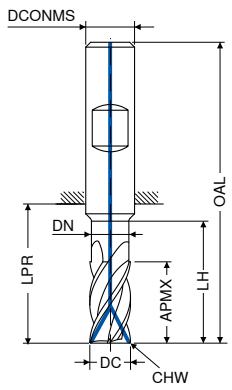
DC f8 mm	APMX mm	DN mm	LH mm	LPR mm	OAL mm	DCONMS h6 mm	CHW mm	ZEFP	Article no.	£
3.0	8	2.8	13	21	57	6	0.1	4	50 969 03200	100.10
3.5	11	3.3	17	21	57	6	0.1	4	50 969 03700	100.10
4.0	11	3.8	17	21	57	6	0.1	4	50 969 04200	100.10
4.5	13	4.3	19	21	57	6	0.1	4	50 969 04700	100.10
5.0	13	4.8	19	21	57	6	0.1	4	50 969 05200	100.10
5.5	13	5.3	19	21	57	6	0.1	4	50 969 05700	100.10
6.0	13	5.8	19	21	57	6	0.1	4	50 969 06200	100.10
7.0	21	6.7	25	27	63	8	0.2	4	50 969 07200	107.84
8.0	21	7.7	25	27	63	8	0.2	4	50 969 08200	107.84
9.0	22	8.7	30	32	72	10	0.2	4	50 969 09200	113.30
10.0	22	9.7	30	32	72	10	0.2	4	50 969 10200	113.30
11.0	26	10.6	36	38	83	12	0.3	4	50 969 11200	158.16
12.0	26	11.6	36	38	83	12	0.3	4	50 969 12200	158.16
14.0	26	13.6	36	38	83	14	0.3	4	50 969 14200	226.41
15.0	36	14.5	42	44	92	16	0.3	4	50 969 15200	226.41
16.0	36	15.5	42	44	92	16	0.3	4	50 969 16200	226.41
17.0	36	16.5	42	44	92	18	0.3	4	50 969 17200	264.99
18.0	36	17.5	42	44	92	18	0.3	4	50 969 18200	264.99
19.0	41	18.5	52	54	104	20	0.3	4	50 969 19200	356.63
20.0	41	19.5	52	54	104	20	0.3	4	50 969 20200	356.63

Steel	●
Stainless steel	●
Cast iron	●
Non ferrous metals	○
Heat resistant alloys	●
Hardened materials	

SilverLine – End milling cutter

N | λ_s=35° 38° γ_s= 9° | ZEFP | HPC

WNT \ Performance



DPB72S | DRAGONSKIN

DIN 6527 HB NEW

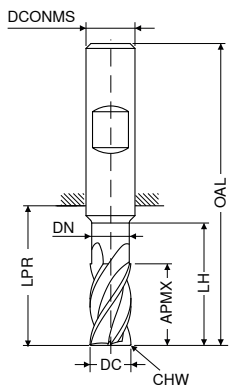
DC f8 mm	APMX mm	DN mm	LH mm	LPR mm	OAL mm	DCONMS h6 mm	CHW mm	ZEFP	Article no.	£
6	13	5.8	19	21	57	6	0.1	4	50 978 06200	96.55
8	21	7.7	25	27	63	8	0.2	4	50 978 08200	112.57
10	22	9.7	30	32	72	10	0.2	4	50 978 10200	127.22
12	26	11.6	36	38	83	12	0.3	4	50 978 12200	177.91
14	26	13.6	36	38	83	14	0.3	4	50 978 14200	272.91
16	36	15.5	42	44	92	16	0.3	4	50 978 16200	272.91
18	36	17.5	42	44	92	18	0.3	4	50 978 18200	363.27
20	41	19.5	52	54	104	20	0.3	4	50 978 20200	363.27

Steel	●
Stainless steel	●
Cast iron	●
Non ferrous metals	○
Heat resistant alloys	●
Hardened materials	

SilverLine – End milling cutter

NR | λ_s=35° 38° γ_s= 9° | ZEFP | HPC

WNT \ Performance



DPB72S | DRAGONSKIN

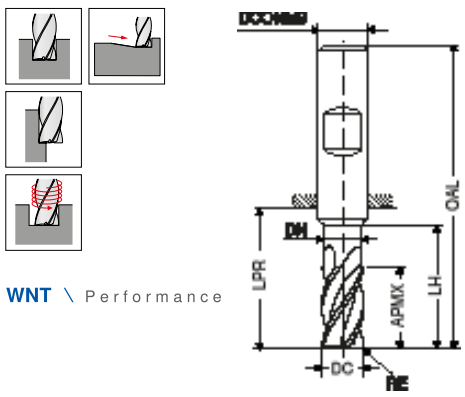
DIN 6527 HB NEW

DC f8 mm	APMX mm	DN mm	LH mm	LPR mm	OAL mm	DCONMS h6 mm	CHW mm	ZEFP	Article no.	£
3.0	8	2.8	13	21	57	6	0.1	4	50 979 03200	100.10
3.5	11	3.3	17	21	57	6	0.1	4	50 979 03700	100.10
4.0	11	3.8	17	21	57	6	0.1	4	50 979 04200	100.10
4.5	13	4.3	19	21	57	6	0.1	4	50 979 04700	100.10
5.0	13	4.8	19	21	57	6	0.1	4	50 979 05200	100.10
5.5	13	5.3	19	21	57	6	0.1	4	50 979 05700	100.10
6.0	13	5.8	19	21	57	6	0.1	4	50 979 06200	100.10
7.0	21	6.7	25	27	63	8	0.2	4	50 979 07200	107.84
8.0	21	7.7	25	27	63	8	0.2	4	50 979 08200	107.84
9.0	22	8.7	30	32	72	10	0.2	4	50 979 09200	113.30
10.0	22	9.7	30	32	72	10	0.2	4	50 979 10200	113.30
11.0	26	10.6	36	38	83	12	0.3	4	50 979 11200	158.16
12.0	26	11.6	36	38	83	12	0.3	4	50 979 12200	158.16
14.0	26	13.6	36	38	83	14	0.3	4	50 979 14200	226.41
15.0	36	14.5	42	44	92	16	0.3	4	50 979 15200	226.41
16.0	36	15.5	42	44	92	16	0.3	4	50 979 16200	226.41
17.0	36	16.5	42	44	92	18	0.3	4	50 979 17200	264.99
18.0	36	17.5	42	44	92	18	0.3	4	50 979 18200	264.99
19.0	41	18.5	52	54	104	20	0.3	4	50 979 19200	356.63
20.0	41	19.5	52	54	104	20	0.3	4	50 979 20200	356.63

Steel	●
Stainless steel	●
Cast iron	●
Non ferrous metals	○
Heat resistant alloys	●
Hardened materials	

SilverLine – End milling cutter with corner radius

N | λ_s=35° 38° | γ_s= 9° | ZEFP | HPC



WNT \ Performance

DC f8	RE ±0,01	APMX	DN	LH	LPR	OAL	DCONMS h6	ZEFP	DPB72S Dragonskin Factory standard HA NEW Article no.	£	DPB72S Dragonskin Factory standard HB NEW Article no.	£	DPB72S Dragonskin Factory standard HA NEW Article no.	£	DPB72S Dragonskin Factory standard HB NEW Article no.	£
mm	mm	mm	mm	mm	mm	mm	mm									
3	0.10	8.0	2.8	13	21	57	6	4	50 970 03201	46.86	50 971 03201	46.86				
3	0.40	8.0	2.8	13	21	57	6	4	50 970 03204	46.86	50 971 03204	46.86				
3	1.00	8.0	2.8	13	21	57	6	4	50 970 03210	46.86	50 971 03210	46.86				
3	0.50	8.0	2.8	13	21	57	6	4	50 970 03205	46.86	50 971 03205	46.86				
3	0.80	6.5	2.8	15	22	58	6	4					50 970 03408	55.08	50 971 03408	55.08
3	0.50	6.5	2.8	15	22	58	6	4					50 970 03405	55.08	50 971 03405	55.08
3	0.30	6.5	2.8	15	22	58	6	4					50 970 03403	55.08	50 971 03403	55.08
4	0.40	11.0	3.8	17	21	57	6	4	50 970 04204	46.86	50 971 04204	46.86				
4	0.10	11.0	3.8	17	21	57	6	4	50 970 04201	46.86	50 971 04201	46.86				
4	1.00	11.0	3.8	17	21	57	6	4	50 970 04210	46.86	50 971 04210	46.86				
4	0.50	11.0	3.8	17	21	57	6	4	50 970 04205	46.86	50 971 04205	46.86				
4	0.80	8.5	3.8	20	26	62	6	4					50 970 04408	55.08	50 971 04408	55.08
4	0.50	8.5	3.8	20	26	62	6	4					50 970 04405	55.08	50 971 04405	55.08
4	0.40	8.5	3.8	20	26	62	6	4					50 970 04404	55.08	50 971 04404	55.08
5	0.50	13.0	4.8	19	21	57	6	4	50 970 05205	47.62	50 971 05205	47.62				
5	0.10	13.0	4.8	19	21	57	6	4	50 970 05201	47.62	50 971 05201	47.62				
5	1.00	13.0	4.8	19	21	57	6	4	50 970 05210	47.62	50 971 05210	47.62				
5	0.80	10.5	4.8	25	34	70	6	4					50 970 05408	55.94	50 971 05408	55.94
5	0.50	10.5	4.8	25	34	70	6	4					50 970 05405	55.94	50 971 05405	55.94
6	0.50	13.0	5.8	19	21	57	6	4	50 970 06205	46.47	50 971 06205	46.47				
6	0.10	13.0	5.8	19	21	57	6	4	50 970 06201	46.47	50 971 06201	46.47				
6	1.50	13.0	5.8	19	21	57	6	4	50 970 06215	46.47	50 971 06215	46.47				
6	1.00	13.0	5.8	19	21	57	6	4	50 970 06210	46.47	50 971 06210	46.47				
6	1.00	13.0	5.8	30	34	70	6	4					50 970 06410	55.94	50 971 06410	55.94
6	0.80	13.0	5.8	30	34	70	6	4					50 970 06408	55.94	50 971 06408	55.94
6	0.60	13.0	5.8	30	34	70	6	4					50 970 06406	55.94	50 971 06406	55.94
8	0.15	21.0	7.7	25	27	63	8	4	50 970 08202	58.26	50 971 08202	58.26				
8	1.50	21.0	7.7	25	27	63	8	4	50 970 08215	58.26	50 971 08215	58.26				
8	2.00	21.0	7.7	25	27	63	8	4	50 970 08220	58.26	50 971 08220	58.26				
8	1.00	21.0	7.7	25	27	63	8	4	50 970 08210	58.26	50 971 08210	58.26				
8	0.50	21.0	7.7	25	27	63	8	4	50 970 08205	58.26	50 971 08205	58.26				
8	1.50	17.0	7.7	40	44	80	8	4					50 970 08415	67.73	50 971 08415	67.73
8	1.00	17.0	7.7	40	44	80	8	4					50 970 08410	67.73	50 971 08410	67.73
8	2.00	17.0	7.7	40	44	80	8	4					50 970 08420	67.73	50 971 08420	67.73
8	0.80	17.0	7.7	40	44	80	8	4					50 970 08408	67.73	50 971 08408	67.73
10	0.15	22.0	9.7	30	32	72	10	4	50 970 10202	72.80	50 971 10202	72.80				
10	1.50	22.0	9.7	30	32	72	10	4	50 970 10215	72.80	50 971 10215	72.80				
10	1.00	22.0	9.7	30	32	72	10	4	50 970 10210	72.80	50 971 10210	72.80				
10	2.00	22.0	9.7	30	32	72	10	4	50 970 10220	72.80	50 971 10220	72.80				
10	0.50	22.0	9.7	30	32	72	10	4	50 970 10205	72.80	50 971 10205	72.80				
10	1.50	21.0	9.7	50	54	94	10	4					50 970 10415	83.78	50 971 10415	83.78
10	1.00	21.0	9.7	50	54	94	10	4					50 970 10410	83.78	50 971 10410	83.78
10	2.00	21.0	9.7	50	54	94	10	4					50 970 10420	83.78	50 971 10420	83.78
10	0.50	21.0	9.7	50	54	94	10	4					50 970 10405	83.78	50 971 10405	83.78
12	0.20	26.0	11.6	36	38	83	12	4	50 970 12202	112.39	50 971 12202	112.39				
12	1.00	26.0	11.6	36	38	83	12	4	50 970 12210	112.39	50 971 12210	112.39				
12	1.50	26.0	11.6	36	38	83	12	4	50 970 12215	112.39	50 971 12215	112.39				
12	0.50	26.0	11.6	36	38	83	12	4	50 970 12205	112.39	50 971 12205	112.39				
12	2.00	26.0	11.6	36	38	83	12	4	50 970 12220	112.39	50 971 12220	112.39				
12	4.00	26.0	11.6	36	38	83	12	4	50 970 12240	112.39	50 971 12240	112.39				
12	3.00	26.0	11.6	36	38	83	12	4	50 970 12230	112.39	50 971 12230	112.39				
12	2.00	25.0	11.6	60	64	109	12	4					50 970 12420	127.22	50 971 12420	127.22
12	1.50	25.0	11.6	60	64	109	12	4					50 970 12415	127.22	50 971 12415	127.22
12	3.00	25.0	11.6	60	64	109	12	4					50 970 12430	127.22	50 971 12430	127.22
12	1.00	25.0	11.6	60	64	109	12	4					50 970 12410	127.22	50 971 12410	127.22
12	4.00	25.0	11.6	60	64	109	12	4					50 970 12440	127.22	50 971 12440	127.22
12	0.50	25.0	11.6	60	64	109	12	4					50 970 12405	127.22	50 971 12405	127.22
14	0.30	26.0	13.6	36	38	83	14	4	50 970 14203	169.99	50 971 14203	169.99				
14	4.00	26.0	13.6	36	38	83	14	4	50 970 14240	169.99	50 971 14240	169.99				
14	3.00	26.0	13.6	36	38	83	14	4	50 970 14230	169.99	50 971 14230	169.99				
14	2.00	26.0	13.6	36	38	83	14	4	50 970 14220	169.99	50 971 14220	169.99				
14	1.00	26.0	13.6	36	38	83	14	4	50 970 14210	169.99	50 971 14210	169.99				
14	4.00	29.0	13.6	70	74	119	14	4					50 970 14440	190.65	50 971 14440	190.65
14	2.00	29.0	13.6	70	74	119	14	4					50 970 14420	190.65	50 971 14420	190.65
14	3.00	29.0	13.6	70	74	119	14	4					50 970 14430	190.65	50 971 14430	190.65
14	1.00	29.0	13.6	70	74	119	14	4					50 970 14410	190.65	50 971 14410	190.65
16	0.30	36.0	15.5	42	44	92	16	4	50 970 16203	169.99	50 971 16203	169.99				
16	3.00	36.0	15.5	42	44	92	16	4	50 970 16230	169.99	50 971 16230	169.99				
16	4.00	36.0	15.5	42	44	92	16	4	50 970 16240	169.99	50 971 16240	169.99				
16	2.00	36.0	15.5	42	44	92	16	4	50 970 16220	169.99	50 971 16220	169.99				
16	1.00	36.0	15.5	42	44	92	16	4	50 970 16210	169.99	50 971 16210	169.99				
16	3.00	33.0	15.5	80	84	132	16	4					50 970 16430	209.12	50 971 16430	209.12
16	2.00	33.0	15.5	80	84	132	16	4					50 970 16420	209.12	50 971 16420	209.12
16	4.00	33.0	15.5	80	84	132	16	4					50 970 16440	209.12	50 971 16440	209.12
16	1.00	33.0	15.5	80	84	132	16	4					50 970 16410	209.12	50 971 16410	209.12
18	1.00	36.0	17.5	42	44	92	18	4	50 970 18210	226.14	50 971 18210	226.14				
18	4.00	36.0	17.5	42	44	92	18	4	50 970 18240	226.14	50 971 18240	226.14				
18	3.00	36.0	17.5	42	44	92	18	4	50 970 18230	226.14	50 971 18230	226.14				
18	2.00	36.0	17.5	42	44	92	18	4	50 970 18220	226.14	50 971 18220	226.14				
18	3.00	38.0	17.5	90	94	142	18	4					50 970 18430	252.25	50 971 18430	252.25
18	2.00	38.0	17.5	90	94	142	18	4					50 970 18420	252.25	50 971 18420	252.25
18	4.00	38.0	17.5	90	94	142	18	4					50 970 18440	252.25	50 971 18440	252.25
18	1.00	38.0	17.5	90	94	142	18	4					50 970 18410	252.25	50 971 18410	252.25
20	0.30	41.0	19.5	52	54	104	20	4	50 970 20203	254.62	50 971 20203	254.62				
20	3.00	41.0	19.5	52	54	104	20	4	50 970 20230	254.62	50 971 20230	254.62				
20	2.00	41.0	19.5	52	54	104	20	4	50 970 20220	254.62	50 971 20220	254.62				
20	4.00	41.0	19.5	52	54	104	20	4	50 970 20240	254.62	50 971 20240	254.62				
20	1.00	41.0	19.5	52	54	104	20	4	50 970 20210	254.62	50 971 20210	254.62				
20	4.00	42.0	19.5	100	104	154	20	4					50 970 20440	283.56	50 971 20440	283.56
20	2.00	42.0	19.5	100	104	154	20	4					50 970 20420	283.56	50 971 20420	283.56
20	3.00	42.0	19.5	100	104	154	20	4					50 970 20430	283.56	50 971 20430	283.56
20	1.00	42.0	19.5	100	104	154	20	4					50 970 20410	283.56	50 971 20410	283.56

Steel	●	●	●	●
Stainless steel	●	●	●	●
Cast iron	●	●	●	●
Non ferrous metals	○	○	○	○
Heat resistant alloys	●	●	●	●
Hardened materials				

Technical support: 0800 073 2 075
3 time served engineers, available from 8:00 am to 6:30 pm, Monday to Friday

Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

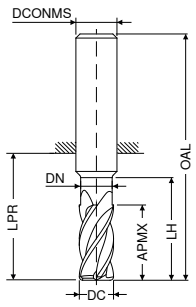
v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

SilverLine – High Accuracy Finish Milling Cutter

▲ max. taper of 0.005 mm for high precision and parallelism of vertical walls
▲ Tool with cutting edge correction

N | λ_s=48° γ_s=50° γ_s=13° | ZEFP

WNT \ Performance



DPB72S | DRAGONSKIN

DPB72S | DRAGONSKIN

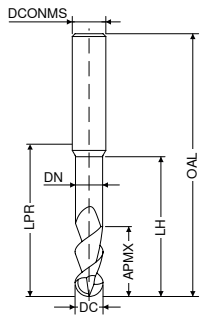
DC f8 mm	APMX mm	DN mm	LH mm	LPR mm	OAL mm	DCONMS h5 mm	ZEFP	≈DIN 6527 NEW Article no.	£	Factory standard NEW Article no.	£
6	13	5.6	19	21	57	6	6	50 991 06700	51.71		
6	10	5.8	18	22	58	6	6	50 991 06200	51.74		
6	13	5.8	27	31	67	6	6			50 991 06400	70.15
6	13	5.8	36	40	76	6	6			50 991 06900	87.63
6	15	5.6	42	44	80	6	6			50 991 90000	70.13
8	19	7.6	25	27	63	8	6	50 991 08700	59.40		
8	13	7.7	24	28	64	8	6	50 991 08200	59.18		
8	17	7.7	36	40	76	8	6			50 991 08400	86.78
8	17	7.7	48	53	89	8	6			50 991 08900	108.47
8	20	7.6	62	64	100	8	6			50 991 90100	86.67
10	22	9.6	30	32	72	10	6	50 991 10700	101.74		
10	16	9.7	30	34	74	10	6	50 991 10200	102.01		
10	21	9.7	45	49	89	10	6			50 991 10400	130.04
10	25	9.6	58	60	100	10	6			50 991 10900	129.68
10	21	9.7	60	64	104	10	6			50 991 90200	162.53
12	26	11.5	36	38	83	12	6	50 991 12700	137.87		
12	19	11.6	36	40	85	12	6	50 991 12200	138.23		
12	25	11.6	54	58	103	12	6			50 991 12400	201.29
12	30	11.5	73	75	120	12	6			50 991 12900	201.02
12	25	11.6	72	76	121	12	6			50 991 90300	251.52
16	32	15.0	42	44	92	16	6	50 991 16700	257.08		
16	25	15.5	48	52	100	16	6	50 991 16200	257.17		
16	33	15.5	72	76	124	16	6			50 991 16400	354.26
16	33	15.5	96	100	148	16	6			50 991 16900	442.81
16	40	15.0	100	102	150	16	6			50 991 90400	353.90
20	38	19.0	52	54	104	20	6	50 991 20700	370.37		
20	32	19.5	60	64	114	20	6	50 991 20200	370.55		
20	42	19.5	90	94	144	20	6			50 991 20400	487.85
20	50	19.0	98	100	150	20	6			50 991 20900	487.67
20	42	19.5	120	124	174	20	6			50 991 90500	609.79
25	40	24.5	75	80	136	25	6	50 991 25200	464.10		
25	52	24.5	113	118	174	25	6			50 991 25400	610.43
25	52	24.5	150	154	210	25	6			50 991 25900	763.04

	≈DIN 6527	Factory standard
Steel	●	●
Stainless steel	●	●
Cast iron	○	○
Non ferrous metals	○	○
Heat resistant alloys	●	●
Hardened materials		

SilverLine – Ball Nosed Cutter

N | λ_s=30° γ_s= 6° | ZEFP

WNT \ Performance



DPB72S | DRAGONSKIN

DPB72S | DRAGONSKIN

DC f8 mm	APMX mm	DN mm	LH mm	LPR mm	OAL mm	DCONMS h6 mm	ZEFP	Factory standard NEW Article no.	£	Factory standard NEW Article no.	£
3	4	2.8	10.0	14	50	6	2	50 963 03115	44.16		
3	7	3.0	8.8	24	60	6	2			50 963 03415	59.23
4	8	3.8	12.0	18	54	6	2	50 963 04120	44.16		
4	10	4.0	12.5	39	75	6	2			50 963 04420	59.23
5	9	4.8	16.0	18	54	6	2	50 963 05125	44.16		
5	12	5.0	15.0	39	75	6	2			50 963 05425	61.61
6	10	5.7	16.0	18	54	6	2	50 963 06130	44.16		
6	12	6.0	15.0	64	100	6	2			50 963 06430	71.34
7	11	6.6	20.0	22	58	8	2	50 963 07135	53.75		
8	12	7.6	20.0	22	58	8	2	50 963 08140	53.75		
8	14	8.0	17.5	64	100	8	2			50 963 08440	83.39
10	14	9.6	24.0	26	66	10	2	50 963 10150	67.21		
10	18	10.0	22.5	60	100	10	2			50 963 10450	113.39
12	16	11.5	26.0	28	73	12	2	50 963 12160	97.64		
12	22	12.0	27.5	55	100	12	2			50 963 12460	146.24
14	18	13.3	28.0	30	75	14	2	50 963 14170	113.39		
14	26	14.0	32.5	75	120	14	2			50 963 14470	233.23
16	22	15.2	32.0	34	82	16	2	50 963 16180	143.87		
16	30	16.0	37.5	102	150	16	2			50 963 16480	314.22
18	24	17.1	34.0	36	84	18	2	50 963 18190	237.06		
20	26	19.0	40.0	42	92	20	2	50 963 20110	237.06		
20	38	20.0	47.5	100	150	20	2			50 963 20410	416.42

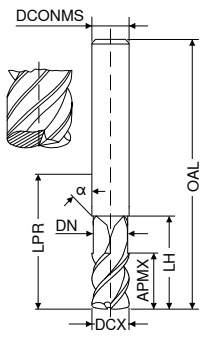
	Factory standard	Factory standard
Steel	●	●
Stainless steel		
Cast iron	●	●
Non ferrous metals	○	○
Heat resistant alloys		
Hardened materials	○	○

SilverLine – Torus Face Milling Cutter

▲ APMX does not correspond to the maximum cutting depth
▲ r_{3D} = corner radius to be programmed

N | λ_s=52° γ_s= 4° | ZEFP | HPC

WNT \ Performance



DPB72S | DRAGONSKIN

DPB72S | DRAGONSKIN

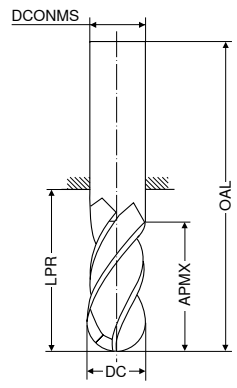
DCX f8 mm	r_{3D} mm	APMX mm	DN mm	LH mm	LPR mm	OAL mm	α°	DCONMS h6 mm	ZEFP	Factory standard NEW Article no.	£	Factory standard NEW Article no.	£
6	1.12	6	5.5	21	21	57	45	6	4	50 989 06110	62.18		
8	1.23	8	7.4	27	27	63	45	8	4	50 989 08110	70.46		
10	1.17	10	9.2	32	32	72	45	10	4	50 989 10115	120.48		
12	1.86	12	11.0	32	38	83	45	12	4	50 989 12115	157.89		
16	2.47	16	15.0	38	44	92	45	16	4	50 989 16120	296.66		
20	2.61	20	18.5	40	42	92	45	20	4	50 989 20120	426.79		
6	1.12	6	5.5	64	64	100	45	6	4			50 989 06410	82.17
8	1.23	8	7.4	64	64	100	45	8	4			50 989 08410	107.20
10	1.17	10	9.2	60	60	100	45	10	4			50 989 10415	176.27
12	1.86	12	11.0	65	65	110	45	12	4			50 989 12415	194.47
16	2.47	16	15.0	65	102	150	45	16	4			50 989 16420	433.71
20	2.61	20	18.5	65	100	150	45	20	4			50 989 20420	641.64

	Factory standard	Factory standard
Steel	●	●
Stainless steel	○	○
Cast iron	●	●
Non ferrous metals	○	○
Heat resistant alloys		
Hardened materials	○	○

SilverLine – Ball Nosed Cutter

N | λ_s=35° γ_s= 38° γ_s= 7° | ZEFP

WNT \ Performance



DPB72S | DRAGONSKIN

DC f8 mm	APMX mm	LPR mm	OAL mm	DCONMS h6 mm	ZEFP	Factory standard NEW Article no.	£
4	11	21	57	6	4	50 990 04220	42.99
5	13	21	57	6	4	50 990 05225	42.99
6	13	21	57	6	4	50 990 06230	50.30
8	19	36	72	8	4	50 990 08280	62.31
10	22	32	72	10	4	50 990 10250	78.67
12	26	38	83	12	4	50 990 12260	124.49
16	32	44	92	16	4	50 990 16280	183.73
20	38	54	104	20	4	50 990 20210	266.27

	Factory standard
Steel	●
Stainless steel	○
Cast iron	●
Non ferrous metals	○
Heat resistant alloys	
Hardened materials	

AluLine

With optimised coating and geometry for the effective machining of aluminium and non-ferrous metals

Solid carbide milling tools from CERATIZIT ensure you always do a good job: We have added milling tools for machining aluminium and non-ferrous metals to our product portfolio. This means you will now be able to find the ideal product for any application.

This AluLine milling cutter allows you to master even the toughest demands when working with aluminium and non-ferrous metals. This is all made possible thanks to the special geometry and the specifically tailored coating.

> Our AluLine milling cutter impresses with its outstanding coating. It achieves first-rate results even in dry machining.
> Product Manager CERATIZIT, Michael Wucher

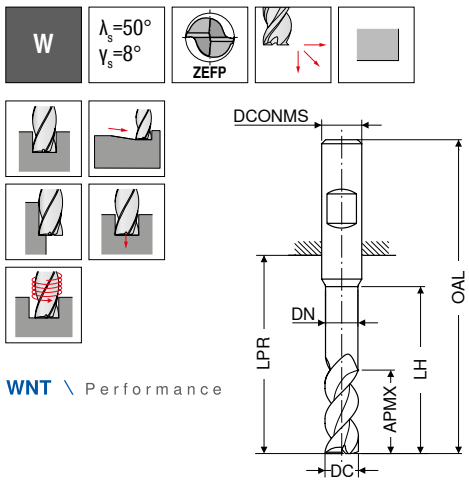
Advantages/benefits

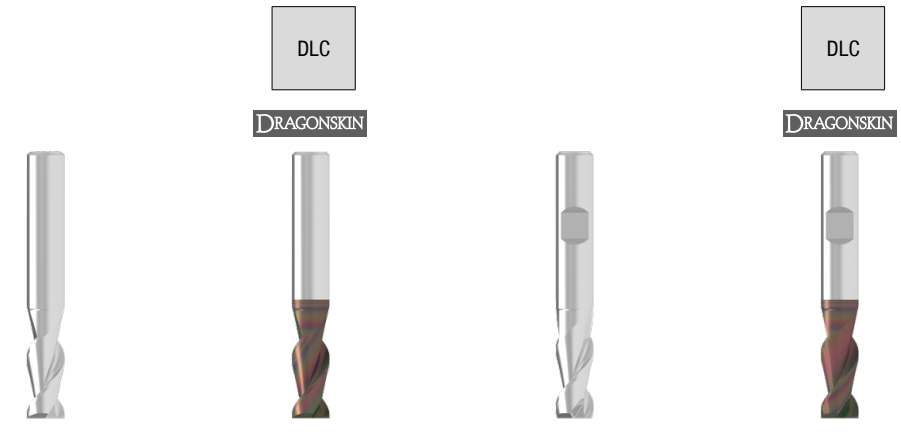
- **Economical and process-secure machining of aluminium and non-ferrous metals.**
  Optimal performance thanks to the perfectly coordinated combination of geometry, substrate and coating.
- **Optimal/versatile tool selection for almost all applications in the machining of non-ferrous metals**
  The product portfolio has increased in size following the program extension and now offers access to around 2500 items.
- **Extremely long tool service life possible**
  Thanks to the wear-resistant DLC coating.

Cutting datas can be found in our UP2DATE September catalogue on page 62+63

AluLine – End milling cutter

▲ With polished chip flutes



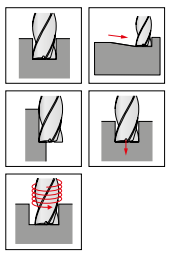


DC h6	APMX	DN	LH	LPR	OAL	DCONMS h6	ZEFP	Factory standard HA		Factory standard HA		Factory standard HB		Factory standard HB	
								NEW		NEW		NEW		NEW	
								Article no.		Article no.		Article no.		Article no.	
mm	mm	mm	mm	mm	mm	mm			£		£		£		£
5.0	10.5	4.8	15	22	58	6	2	53 623 05100	25.25	53 625 05100	32.07	53 624 05100	25.25	53 626 05100	32.07
5.5	13.0	5.3	18	22	58	6	2	53 623 05600	30.71	53 625 05600	37.53	53 624 05600	30.71	53 626 05600	37.53
6.0	13.0	5.8	18	22	58	6	2	53 623 06100	28.66	53 625 06100	36.17	53 624 06100	28.66	53 626 06100	36.17
6.5	17.0	6.2	24	28	64	8	2	53 623 06600	32.75	53 625 06600	40.26	53 624 06600	32.75	53 626 06600	40.26
7.0	17.0	6.7	24	28	64	8	2	53 623 07100	32.07	53 625 07100	39.58	53 624 07100	32.07	53 626 07100	39.58
7.5	17.0	7.2	24	28	64	8	2	53 623 07600	31.39	53 625 07600	38.90	53 624 07600	31.39	53 626 07600	38.90
8.0	17.0	7.7	24	28	64	8	2	53 623 08100	30.02	53 625 08100	38.21	53 624 08100	30.02	53 626 08100	38.21
8.5	21.0	8.2	30	34	74	10	2	53 623 08600	50.50	53 625 08600	59.36	53 624 08600	50.50	53 626 08600	59.36
9.0	21.0	8.7	30	34	74	10	2	53 623 09100	49.13	53 625 09100	58.00	53 624 09100	49.13	53 626 09100	58.00
9.5	21.0	9.2	30	34	74	10	2	53 623 09600	47.77	53 625 09600	56.63	53 624 09600	47.77	53 626 09600	56.63
10.0	21.0	9.7	30	34	74	10	2	53 623 10100	45.72	53 625 10100	55.27	53 624 10100	45.72	53 626 10100	55.27
10.5	25.0	10.1	36	40	85	12	2	53 623 10600	69.60	53 625 10600	79.16	53 624 10600	69.60	53 626 10600	79.16
11.0	25.0	10.6	36	40	85	12	2	53 623 11100	68.24	53 625 11100	77.79	53 624 11100	68.24	53 626 11100	77.79
11.5	25.0	11.1	36	40	85	12	2	53 623 11600	66.19	53 625 11600	75.74	53 624 11600	66.19	53 626 11600	75.74
12.0	25.0	11.6	36	40	85	12	2	53 623 12100	64.82	53 625 12100	77.79	53 624 12100	64.82	53 626 12100	77.79
12.5	29.0	12.1	42	46	91	14	2					53 624 12600	93.48	53 626 12600	106.45
13.0	29.0	12.6	42	46	91	14	2					53 624 13100	92.80	53 626 13100	105.77
13.5	29.0	13.1	42	46	91	14	2					53 624 13600	91.44	53 626 13600	105.09
14.0	29.0	13.6	42	46	91	14	2					53 624 14100	92.80	53 626 14100	110.55
14.5	33.0	14.0	48	52	100	16	2					53 624 14600	126.92	53 626 14600	144.66
15.0	33.0	14.5	48	52	100	16	2					53 624 15100	123.51	53 626 15100	141.93
15.5	33.0	15.0	48	52	100	16	2					53 624 15600	120.78	53 626 15600	138.52
16.0	33.0	15.5	48	52	100	16	2					53 624 16100	126.92	53 626 16100	148.08
16.5	38.0	16.0	54	58	106	18	2					53 624 16600	164.45	53 626 16600	185.61
17.0	38.0	16.5	54	58	106	18	2					53 624 17100	159.67	53 626 17100	180.83
17.5	38.0	17.0	54	58	106	18	2					53 624 17600	155.58	53 626 17600	176.05
18.0	38.0	17.5	54	58	106	18	2					53 624 18100	153.54	53 626 18100	176.05
18.5	42.0	18.0	60	64	114	20	2					53 624 18600	203.35	53 626 18600	225.86
19.0	42.0	18.5	60	64	114	20	2					53 624 19100	197.89	53 626 19100	220.41
19.5	42.0	19.0	60	64	114	20	2					53 624 19600	191.74	53 626 19600	214.95
20.0	42.0	19.5	60	64	114	20	2					53 624 20100	188.33	53 626 20100	217.00
Steel															
Stainless steel															
Cast iron															
Non ferrous metals								●		●		●		●	
Heat resistant alloys															
Hardened materials															

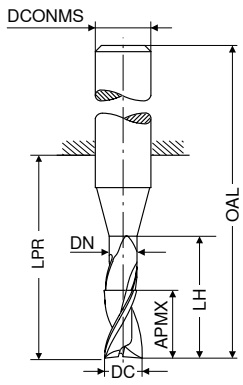
AluLine – End milling cutter

▲ With polished chip flutes

W | λ_s=45° γ_s= 7° | ZEFP



WNT \ Performance



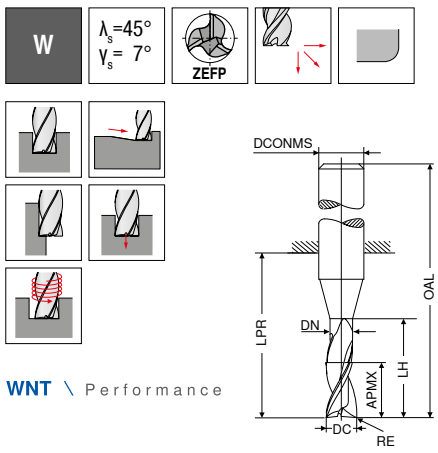
DC h6	APMX	DN	LH	LPR	OAL	DCONMS h6	ZEFP	Factory standard HA NEW Article no.	£	DLC DRAGONSKIN Factory standard HA NEW Article no.	£	Factory standard HB NEW Article no.	£	DLC DRAGONSKIN Factory standard HB NEW Article no.	£
mm	mm	mm	mm	mm	mm	mm									
2.0	4.5	1.8	6.0	14	50	6	3	53 615 02100	23.20	53 617 02100	30.02	53 616 02100	23.20	53 618 02100	30.02
2.5	5.5	2.3	7.5	19	55	6	3	53 615 02600	23.20	53 617 02600	29.34	53 616 02600	23.20	53 618 02600	29.34
3.0	6.5	2.8	9.0	19	55	6	3	53 615 03100	23.20	53 617 03100	30.02	53 616 03100	23.20	53 618 03100	30.02
3.5	8.5	3.3	12.0	19	55	6	3	53 615 03600	24.56	53 617 03600	31.39	53 616 03600	24.56	53 618 03600	31.39
4.0	8.5	3.8	12.0	19	55	6	3	53 615 04100	25.25	53 617 04100	31.39	53 616 04100	25.25	53 618 04100	31.39
4.5	10.5	4.3	15.0	22	58	6	3	53 615 04600	32.07	53 617 04600	38.21	53 616 04600	32.07	53 618 04600	38.21
5.0	10.5	4.8	15.0	22	58	6	3	53 615 05100	27.98	53 617 05100	34.12	53 616 05100	27.98	53 618 05100	34.12
5.5	13.0	5.3	18.0	22	58	6	3	53 615 05600	32.75	53 617 05600	38.90	53 616 05600	32.75	53 618 05600	38.90
6.0	13.0	5.8	18.0	22	58	6	3	53 615 06100	28.66	53 617 06100	36.17	53 616 06100	28.66	53 618 06100	36.17
6.5	17.0	6.2	24.0	28	64	8	3	53 615 06600	34.12	53 617 06600	42.31	53 616 06600	34.12	53 618 06600	42.31
7.0	17.0	6.7	24.0	28	64	8	3	53 615 07100	33.44	53 617 07100	40.94	53 616 07100	33.44	53 618 07100	40.94
7.5	17.0	7.2	24.0	28	64	8	3	53 615 07600	32.75	53 617 07600	40.26	53 616 07600	32.75	53 618 07600	40.26
8.0	17.0	7.7	24.0	28	64	8	3	53 615 08100	31.39	53 617 08100	39.58	53 616 08100	31.39	53 618 08100	39.58
8.5	21.0	8.2	30.0	34	74	10	3	53 615 08600	53.22	53 617 08600	61.41	53 616 08600	53.22	53 618 08600	61.41
9.0	21.0	8.7	30.0	34	74	10	3	53 615 09100	51.86	53 617 09100	60.05	53 616 09100	51.86	53 618 09100	60.05
9.5	21.0	9.2	30.0	34	74	10	3	53 615 09600	50.50	53 617 09600	58.68	53 616 09600	50.50	53 618 09600	58.68
10.0	21.0	9.7	30.0	34	74	10	3	53 615 10100	47.77	53 617 10100	57.32	53 616 10100	47.77	53 618 10100	57.32
10.5	25.0	10.1	36.0	40	85	12	3	53 615 10600	73.70	53 617 10600	82.57	53 616 10600	73.70	53 618 10600	82.57
11.0	25.0	10.6	36.0	40	85	12	3	53 615 11100	71.65	53 617 11100	81.20	53 616 11100	71.65	53 618 11100	81.20
11.5	25.0	11.1	36.0	40	85	12	3	53 615 11600	69.60	53 617 11600	78.47	53 616 11600	69.60	53 618 11600	78.47
12.0	25.0	11.6	36.0	40	85	12	3	53 615 12100	68.24	53 617 12100	81.20	53 616 12100	68.24	53 618 12100	81.20
12.5	29.0	12.1	42.0	46	91	14	3					53 616 12600	93.48	53 618 12600	106.45
13.0	29.0	12.6	42.0	46	91	14	3					53 616 13100	92.80	53 618 13100	105.77
13.5	29.0	13.1	42.0	46	91	14	3					53 616 13600	91.44	53 618 13600	105.09
14.0	29.0	13.6	42.0	46	91	14	3					53 616 14100	92.80	53 618 14100	110.55
14.5	33.0	14.0	48.0	52	100	16	3					53 616 14600	126.92	53 618 14600	144.66
15.0	33.0	14.5	48.0	52	100	16	3					53 616 15100	123.51	53 618 15100	141.93
15.5	33.0	15.0	48.0	52	100	16	3					53 616 15600	120.78	53 618 15600	138.52
16.0	33.0	15.5	48.0	52	100	16	3					53 616 16100	126.92	53 618 16100	148.08
16.5	38.0	16.0	54.0	58	106	18	3					53 616 16600	164.45	53 618 16600	185.61
17.0	38.0	16.5	54.0	58	106	18	3					53 616 17100	159.67	53 618 17100	180.83
17.5	38.0	17.0	54.0	58	106	18	3					53 616 17600	155.58	53 618 17600	176.05
18.0	38.0	17.5	54.0	58	106	18	3					53 616 18100	153.54	53 618 18100	176.05
18.5	42.0	18.0	60.0	64	114	20	3					53 616 18600	203.35	53 618 18600	225.86
19.0	42.0	18.5	60.0	64	114	20	3					53 616 19100	197.89	53 618 19100	220.41
19.5	42.0	19.0	60.0	64	114	20	3					53 616 19600	191.74	53 618 19600	214.95
20.0	42.0	19.5	60.0	64	114	20	3					53 616 20100	188.33	53 618 20100	217.00

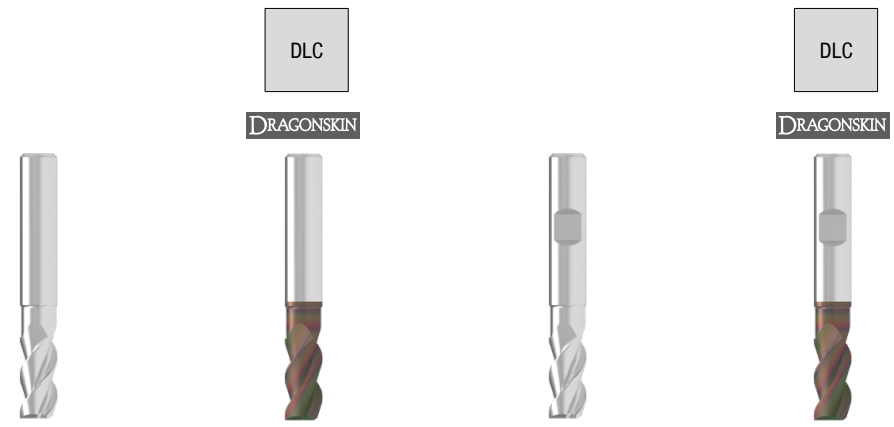
DC h10/h6	APMX	DN	LH	LPR	OAL	DCONMS h6	ZEFP	Factory standard HA NEW Article no.	£	Factory standard HA NEW Article no.	£	Factory standard HB NEW Article no.	£	Factory standard HB NEW Article no.	£
mm	mm	mm	mm	mm	mm	mm									
2.0	5.5	1.8	10.0	19	55	6	3	53 615 02200	27.98	53 617 02200	34.12	53 616 02200	27.98	53 618 02200	34.12
2.5	6.5	2.3	12.5	22	58	6	3	53 615 02700	27.29	53 617 02700	34.12	53 616 02700	27.29	53 618 02700	34.12
3.0	8.0	2.8	15.0	22	58	6	3	53 615 03200	27.98	53 617 03200	34.80	53 616 03200	27.98	53 618 03200	34.80
3.5	10.5	3.3	20.0	26	62	6	3	53 615 03700	29.34	53 617 03700	36.17	53 616 03700	29.34	53 618 03700	36.17
4.0	10.5	3.8	20.0	26	62	6	3	53 615 04200	30.02	53 617 04200	36.85	53 616 04200	30.02	53 618 04200	36.85
4.5	13.0	4.3	25.0	34	70	6	3	53 615 04700	38.21	53 617 04700	44.36	53 616 04700	38.21	53 618 04700	44.36
5.0	13.0	4.8	25.0	34	70	6	3	53 615 05200	33.44	53 617 05200	40.26	53 616 05200	33.44	53 618 05200	40.26
5.5	16.0	5.3	30.0	34	70	6	3	53 615 05700	38.90	53 617 05700	45.72	53 616 05700	38.90	53 618 05700	45.72
6.0	16.0	5.8	30.0	34	70	6	3	53 615 06200	34.12	53 617 06200	41.63	53 616 06200	34.12	53 618 06200	41.63
6.5	21.0	6.2	40.0	44	80	8	3	53 615 06700	41.63	53 617 06700	49.13	53 616 06700	41.63	53 618 06700	49.13
7.0	21.0	6.7	40.0	44	80	8	3	53 615 07200	40.26	53 617 07200	47.77	53 616 07200	40.26	53 618 07200	47.77
7.5	21.0	7.2	40.0	44	80	8	3	53 615 07700	38.90	53 617 07700	47.09	53 616 07700	38.90	53 618 07700	47.09
8.0	21.0	7.7	40.0	44	80	8	3	53 615 08200	37.53	53 617 08200	45.72	53 616 08200	37.53	53 618 08200	45.72
8.5	26.0	8.2	50.0	54	94	10	3	53 615 08700	63.46	53 617 08700	72.33	53 616 08700	63.46	53 618 08700	72.33
9.0	26.0	8.7	50.0	54	94	10	3	53 615 09200	62.09	53 617 09200	70.28	53 616 09200	62.09	53 618 09200	70.28
9.5	26.0	9.2	50.0	54	94	10	3	53 615 09700	60.05	53 617 09700	68.92	53 616 09700	60.05	53 618 09700	68.92
10.0	26.0	9.7	50.0	54	94	10	3	53 615 10200	57.32	53 617 10200	66.87	53 616 10200	57.32	53 618 10200	66.87
10.5	31.0	10.1	60.0	64	109	12	3	53 615 10700	88.02	53 617 10700	97.58	53 616 10700	88.02	53 618 10700	97.58
11.0	31.0	10.6	60.0	64	109	12	3	53 615 11200	85.98	53 617 11200	94.85	53 616 11200	85.98	53 618 11200	94.85
11.5	31.0	11.1	60.0	64	109	12	3	53 615 11700	83.25	53 617 11700	92.80	53 616 11700	83.25	53 618 11700	92.80
12.0	31.0	11.6	60.0	64	109	12	3	53 615 12200	81.89	53 617 12200	94.85	53 616 12200	81.89	53 618 12200	94.85
12.5	36.0	12.1	70.0	74	119	14	3					53 616 12700	111.91	53 618 12700	124.87
13.0	36.0	12.6	70.0	74	119	14	3					53 616 13200	111.23	53 618 13200	124.19
13.5	36.0	13.1	70.0	74	119	14	3					53 616 13700	109.86	53 618 13700	123.51
14.0	36.0	13.6	70.0	74	119	14	3					53 616 14200	111.23	53 618 14200	128.97
14.5	41.0	14.0	80.0	84	132	16	3					53 616 14700	152.17	53 618 14700	169.91
15.0	41.0	14.5	80.0	84	132	16	3					53 616 15200	148.76	53 618 15200	166.50
15.5	41.0	15.0	80.0	84	132	16	3					53 616 15700	145.35	53 618 15700	163.09
16.0	41.0	15.5	80.0	84	132	16	3					53 616 16200	152.85	53 618 16200	173.32
16.5	47.0	16.0	90.0	94	142	18	3					53 616 16700	197.20	53 618 16700	218.36
17.0	47.0	16.5	90.0	94	142	18	3					53 616 17200	191.74	53 618 17200	212.90
17.5	47.0	17.0	90.0	94	142	18	3					53 616 17700	186.29	53 618 17700	207.44
18.0	47.0	17.5	90.0	94	142	18	3					53 616 18200	184.24	53 618 18200	206.76
18.5	52.0	18.0	100.0	104	154	20	3					53 616 18700	264.08	53 618 18700	287.28
19.0	52.0	18.5	100.0	104	154	20	3					53 616 19200	257.25	53 618 19200	279.77
19.5	52.0	19.0	100.0	104	154	20	3					53 616 19700	249.75	53 618 19700	272.27
20.0	52.0	19.5	100.0	104	154	20	3					53 616 20200	244.97	53 618 20200	273.63

Steel				
Stainless steel				
Cast iron				
Non ferrous metals	●	●	●	●
Heat resistant alloys				
Hardened materials				

AluLine – End milling cutter with corner radius

▲ With polished chip flutes





DC h6	RE ±0,05	APMX	DN	LH	LPR	OAL	DCONMS h6	ZEFP	Factory standard HA NEW Article no.	£	Factory standard HA NEW Article no.	£	Factory standard HB NEW Article no.	£	Factory standard HB NEW Article no.	£
mm	mm	mm	mm	mm	mm	mm	mm									
2	0.5	4.5	1.8	6	14	50	6	3	53 708 02105	24.56	53 710 02105	30.71	53 709 02105	24.56	53 711 02105	30.71
2	0.3	4.5	1.8	6	14	50	6	3	53 708 02103	24.56	53 710 02103	30.71	53 709 02103	24.56	53 711 02103	30.71
3	1.0	6.5	2.7	9	19	55	6	3	53 708 03110	25.25	53 710 03110	31.39	53 709 03110	25.25	53 711 03110	31.39
3	0.5	6.5	2.7	9	19	55	6	3	53 708 03105	25.25	53 710 03105	31.39	53 709 03105	25.25	53 711 03105	31.39
3	0.3	6.5	2.7	9	19	55	6	3	53 708 03103	25.25	53 710 03103	31.39	53 709 03103	25.25	53 711 03103	31.39
4	0.3	8.5	3.7	12	19	55	6	3	53 708 04103	26.61	53 710 04103	33.44	53 709 04103	26.61	53 711 04103	33.44
4	1.0	8.5	3.7	12	19	55	6	3	53 708 04110	26.61	53 710 04110	33.44	53 709 04110	26.61	53 711 04110	33.44
4	0.5	8.5	3.7	12	19	55	6	3	53 708 04105	26.61	53 710 04105	33.44	53 709 04105	26.61	53 711 04105	33.44
5	1.0	10.5	4.7	15	22	58	6	3	53 708 05110	30.02	53 710 05110	36.85	53 709 05110	30.02	53 711 05110	36.17
5	0.5	10.5	4.7	15	22	58	6	3	53 708 05105	30.02	53 710 05105	36.85	53 709 05105	30.02	53 711 05105	36.17
5	0.3	10.5	4.7	15	22	58	6	3	53 708 05103	30.02	53 710 05103	36.85	53 709 05103	30.02	53 711 05103	36.17
6	1.5	13.0	5.7	18	22	58	6	3	53 708 06115	30.02	53 710 06115	38.21	53 709 06115	30.02	53 711 06115	38.21
6	0.5	13.0	5.7	18	22	58	6	3	53 708 06105	30.02	53 710 06105	38.21	53 709 06105	30.02	53 711 06105	38.21
6	1.0	13.0	5.7	18	22	58	6	3	53 708 06110	30.02	53 710 06110	38.21	53 709 06110	30.02	53 711 06110	38.21
6	0.3	13.0	5.7	18	22	58	6	3	53 708 06103	30.02	53 710 06103	38.21	53 709 06103	30.02	53 711 06103	38.21
8	0.5	17.0	7.4	24	28	64	8	3	53 708 08105	33.44	53 710 08105	41.63	53 709 08105	33.44	53 711 08105	41.63
8	1.5	17.0	7.4	24	28	64	8	3	53 708 08115	33.44	53 710 08115	41.63	53 709 08115	33.44	53 711 08115	41.63
8	1.0	17.0	7.4	24	28	64	8	3	53 708 08110	33.44	53 710 08110	41.63	53 709 08110	33.44	53 711 08110	41.63
8	2.0	17.0	7.4	24	28	64	8	3	53 708 08120	33.44	53 710 08120	41.63	53 709 08120	33.44	53 711 08120	41.63
8	0.3	17.0	7.4	24	28	64	8	3	53 708 08103	33.44	53 710 08103	41.63	53 709 08103	33.44	53 711 08103	41.63
10	1.5	21.0	9.2	30	34	74	10	3	53 708 10115	51.18	53 710 10115	60.73	53 709 10115	51.18	53 711 10115	60.73
10	1.0	21.0	9.2	30	34	74	10	3	53 708 10110	51.18	53 710 10110	60.73	53 709 10110	51.18	53 711 10110	60.73
10	2.0	21.0	9.2	30	34	74	10	3	53 708 10120	51.18	53 710 10120	60.73	53 709 10120	51.18	53 711 10120	60.73
10	0.5	21.0	9.2	30	34	74	10	3	53 708 10105	51.18	53 710 10105	60.73	53 709 10105	51.18	53 711 10105	60.73
10	3.0	21.0	9.2	30	34	74	10	3	53 708 10130	51.18	53 710 10130	60.73	53 709 10130	51.18	53 711 10130	60.73
10	0.3	21.0	9.2	30	34	74	10	3	53 708 10103	51.18	53 710 10103	60.73	53 709 10103	51.18	53 711 10103	60.73
12	0.5	25.0	11.0	36	40	85	12	3	53 708 12105	72.33	53 710 12105	85.98	53 709 12105	72.33	53 711 12105	85.98
12	2.0	25.0	11.0	36	40	85	12	3	53 708 12120	72.33	53 710 12120	85.98	53 709 12120	72.33	53 711 12120	85.98
12	1.5	25.0	11.0	36	40	85	12	3	53 708 12115	72.33	53 710 12115	85.98	53 709 12115	72.33	53 711 12115	85.98
12	3.0	25.0	11.0	36	40	85	12	3	53 708 12130	72.33	53 710 12130	85.98	53 709 12130	72.33	53 711 12130	85.98
12	1.0	25.0	11.0	36	40	85	12	3	53 708 12110	72.33	53 710 12110	85.98	53 709 12110	72.33	53 711 12110	85.98
12	4.0	25.0	11.0	36	40	85	12	3	53 708 12140	72.33	53 710 12140	85.98	53 709 12140	72.33	53 711 12140	85.98
12	0.3	25.0	11.0	36	40	85	12	3	53 708 12103	72.33	53 710 12103	85.98	53 709 12103	72.33	53 711 12103	85.98
16	0.3	33.0	15.0	48	52	100	16	3					53 709 16103	116.69	53 711 16103	137.16
16	2.0	33.0	15.0	48	52	100	16	3					53 709 16120	116.69	53 711 16120	137.16
16	1.5	33.0	15.0	48	52	100	16	3					53 709 16115	116.69	53 711 16115	137.16
16	3.0	33.0	15.0	48	52	100	16	3					53 709 16130	116.69	53 711 16130	137.16
16	1.0	33.0	15.0	48	52	100	16	3					53 709 16110	116.69	53 711 16110	137.16
16	4.0	33.0	15.0	48	52	100	16	3					53 709 16140	116.69	53 711 16140	137.16
16	0.5	33.0	15.0	48	52	100	16	3					53 709 16105	116.69	53 711 16105	137.16
20	0.5	42.0	19.0	60	64	114	20	3					53 709 20105	183.56	53 711 20105	212.22
20	2.0	42.0	19.0	60	64	114	20	3					53 709 20120	183.56	53 711 20120	212.22
20	3.0	42.0	19.0	60	64	114	20	3					53 709 20130	183.56	53 711 20130	212.22
20	1.5	42.0	19.0	60	64	114	20	3					53 709 20115	183.56	53 711 20115	212.22
20	4.0	42.0	19.0	60	64	114	20	3					53 709 20140	183.56	53 711 20140	212.22
20	1.0	42.0	19.0	60	64	114	20	3					53 709 20110	183.56	53 711 20110	212.22

Steel				
Stainless steel				
Cast iron				
Non ferrous metals	●	●	●	●
Heat resistant alloys				
Hardened materials				

Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

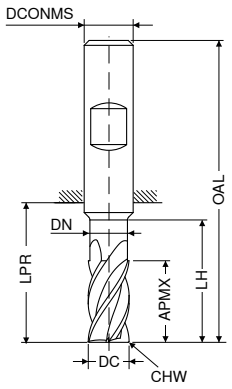
v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

CircularLine – End milling cutter

▲ Chip breaker 0.9 x DC

CCR UNI | λ_s=30° 31° | γ_s= 8° | ZEFP | HPC

WNT \ Performance



DPX72S | DRAGONSKIN

DPX72S | DRAGONSKIN

Factory standard | HB

Factory standard | HB

DC e8 mm	OAL mm	APMX mm	DN mm	LH mm	LPR mm	DCONMS h6 mm	CHW mm	ZEFP	Article no.	£	Article no.	£
6	57	13	5.8	19	21	6	0.2	6	53 585 060	34.89		
6	63	19	5.8	25	27	6	0.2	6			53 587 060	34.20
8	71	25	7.7	33	35	8	0.2	6			53 587 080	44.38
8	63	21	7.7	25	27	8	0.2	6	53 585 080	45.49		
10	83	31	9.7	41	43	10	0.2	6			53 587 100	62.56
10	72	22	9.7	30	32	10	0.2	6	53 585 100	58.45		
12	94	37	11.6	47	49	12	0.2	6			53 587 120	73.48
12	83	26	11.6	36	38	12	0.2	6	53 585 120	75.17		
16	111	49	15.5	61	63	16	0.2	6			53 587 160	152.04
16	92	36	15.5	42	44	16	0.2	6	53 585 160	149.94		
20	127	61	19.5	75	77	20	0.2	6			53 587 200	213.15
20	104	41	19.5	52	54	20	0.2	6	53 585 200	215.57		

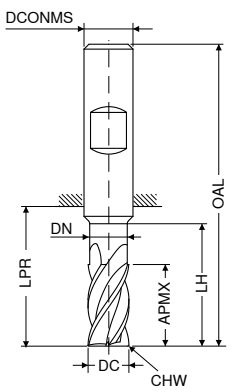
Steel	●	●
Stainless steel	○	○
Cast iron	●	●
Non ferrous metals		
Heat resistant alloys	○	○
Hardened materials		

CircularLine – End milling cutter

▲ Chip breaker 0.9 x DC

CCR UNI | λ_s=35° 36° | γ_s= 8° | ZEFP | HPC

WNT \ Performance



DPX72S | DRAGONSKIN

Factory standard | HB

DC e8 mm	OAL mm	APMX mm	DN mm	LH mm	LPR mm	DCONMS h6 mm	CHW mm	ZEFP	Article no.	£
6	67	25	5.8	29	31	6	0.2	5	53 589 060	35.65
8	76	33	7.7	38	40	8	0.2	5	53 589 080	45.84
10	89	41	9.7	47	49	10	0.2	5	53 589 100	63.29
12	102	49	11.6	55	57	12	0.2	5	53 589 120	77.11
16	123	65	15.5	73	75	16	0.2	5	53 589 160	154.95
20	143	82	19.5	91	93	20	0.2	5	53 589 200	218.24

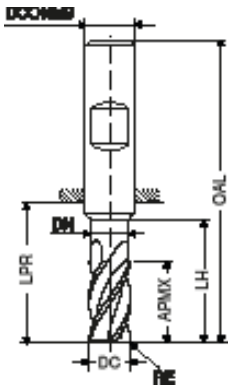
Steel	●
Stainless steel	○
Cast iron	●
Non ferrous metals	
Heat resistant alloys	○
Hardened materials	

CircularLine – End milling cutter

▲ Chip breaker 0.9 x DC

CCR UNI | λ_s=30° 31° | γ_s= 8° | ZEFP | HPC

WNT \ Performance



DPX72S | DRAGONSKIN

Factory standard | HB

DC e8 mm	OAL mm	RE ±0,05 mm	APMX mm	DN mm	LH mm	LPR mm	DCONMS h6 mm	ZEFP	Article no.	£
6	57	1.0	13	5.8	19	21	6	6	53 586 06010	35.07
6	57	1.5	13	5.8	19	21	6	6	53 586 06015	35.07
6	57	0.2	13	5.8	19	21	6	6	53 586 06002	34.89
8	63	1.5	21	7.7	25	27	8	6	53 586 08015	46.58
8	63	1.0	21	7.7	25	27	8	6	53 586 08010	46.58
8	63	2.0	21	7.7	25	27	8	6	53 586 08020	46.58
8	63	0.2	21	7.7	25	27	8	6	53 586 08002	45.49
10	72	1.0	22	9.7	30	32	10	6	53 586 10010	60.05
10	72	1.6	22	9.7	30	32	10	6	53 586 10016	60.05
10	72	1.5	22	9.7	30	32	10	6	53 586 10015	60.05
10	72	2.0	22	9.7	30	32	10	6	53 586 10020	60.05
10	72	0.2	22	9.7	30	32	10	6	53 586 10002	58.45
12	83	1.5	26	11.6	36	38	12	6	53 586 12015	75.51
12	83	1.6	26	11.6	36	38	12	6	53 586 12016	75.51
12	83	2.0	26	11.6	36	38	12	6	53 586 12020	75.51
12	83	1.0	26	11.6	36	38	12	6	53 586 12010	75.51
12	83	3.0	26	11.6	36	38	12	6	53 586 12030	75.51
12	83	0.2	26	11.6	36	38	12	6	53 586 12002	75.17
16	92	1.6	36	15.5	42	44	16	6	53 586 16016	156.24
16	92	4.0	36	15.5	42	44	16	6	53 586 16040	156.24
16	92	1.5	36	15.5	42	44	16	6	53 586 16015	156.24
16	92	2.0	36	15.5	42	44	16	6	53 586 16020	156.24
16	92	1.0	36	15.5	42	44	16	6	53 586 16010	161.66
16	92	3.0	36	15.5	42	44	16	6	53 586 16030	156.24
16	92	0.2	36	15.5	42	44	16	6	53 586 16002	149.94
20	104	1.0	41	19.5	52	54	20	6	53 586 20010	217.74
20	104	2.0	41	19.5	52	54	20	6	53 586 20020	217.74
20	104	1.6	41	19.5	52	54	20	6	53 586 20016	217.74
20	104	3.0	41	19.5	52	54	20	6	53 586 20030	217.74
20	104	1.5	41	19.5	52	54	20	6	53 586 20015	217.74
20	104	4.0	41	19.5	52	54	20	6	53 586 20040	217.74
20	104	0.2	41	19.5	52	54	20	6	53 586 20002	215.57

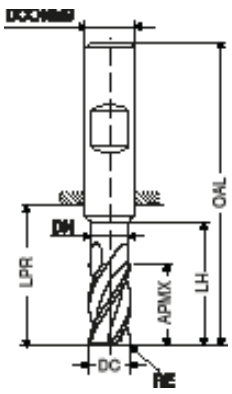
Steel	●
Stainless steel	○
Cast iron	●
Non ferrous metals	
Heat resistant alloys	○
Hardened materials	

CircularLine – End milling cutter

▲ Chip breaker 0.9 x DC

CCR UNI | λ_s=35° 36° | γ_s= 9° | ZEFP | HPC

WNT \ Performance



DPX72S | DRAGONSKIN

Factory standard | HB | NEW

DC e8 mm	OAL mm	RE ±0,05 mm	APMX mm	DN mm	LH mm	LPR mm	DCONMS h6 mm	ZEFP	Article no.	£
6	67	1.5	25	5.8	29	31	6	5	53 593 06015	36.37
6	67	0.2	25	5.8	29	31	6	5	53 593 06002	35.65
6	67	1.0	25	5.8	29	31	6	5	53 593 06010	36.37
8	76	1.5	33	7.7	38	40	8	5	53 593 08015	46.56
8	76	2.0	33	7.7	38	40	8	5	53 593 08020	46.56
8	76	0.2	33	7.7	38	40	8	5	53 593 08002	45.84
8	76	1.0	33	7.7	38	40	8	5	53 593 08010	46.56
10	89	1.5	41	9.7	47	49	10	5	53 593 10015	64.75
10	89	2.0	41	9.7	47	49	10	5	53 593 10020	64.75
10	89	1.6	41	9.7	47	49	10	5	53 593 10016	64.75
10	89	0.2	41	9.7	47	49	10	5	53 593 10002	63.29
10	89	1.0	41	9.7	47	49	10	5	53 593 10010	64.75
12	102	1.0	49	11.6	55	57	12	5	53 593 12010	79.29
12	102	2.0	49	11.6	55	57	12	5	53 593 12020	79.29
12	102	3.0	49	11.6	55	57	12	5	53 593 12030	79.29
12	102	1.6	49	11.6	55	57	12	5	53 593 12016	79.29
12	102	0.2	49	11.6	55	57	12	5	53 593 12002	77.11
12	102	1.5	49	11.6	55	57	12	5	53 593 12015	79.29
16	123	1.6	65	15.5	73	75	16	5	53 593 16016	157.86
16	123	3.0	65	15.5	73	75	16	5	53 593 16030	157.86
16	123	2.0	65	15.5	73	75	16	5	53 593 16020	157.86
16	123	4.0	65	15.5	73	75	16	5	53 593 16040	157.86
16	123	1.5	65	15.5	73	75	16	5	53 593 16015	157.86
16	123	0.2	65	15.5	73	75	16	5	53 593 16002	154.95
16	123	1.0	65	15.5	73	75	16	5	53 593 16010	157.86
20	143	1.5	82	19.5	91	93	20	5	53 593 20015	221.87
20	143	3.0	82	19.5	91	93	20	5	53 593 20030	221.87
20	143	2.0	82	19.5	91	93	20	5	53 593 20020	221.87
20	143	4.0	82	19.5	91	93	20	5	53 593 20040	221.87
20	143	1.6	82	19.5	91	93	20	5	53 593 20016	221.87
20	143	0.2	82	19.5	91	93	20	5	53 593 20002	218.24
20	143	1.0	82	19.5	91	93	20	5	53 593 20010	221.87

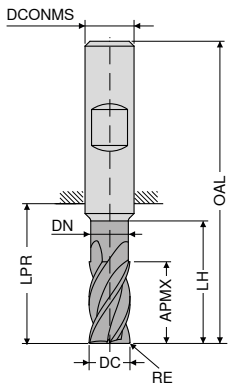
Steel	●
Stainless steel	○
Cast iron	●
Non ferrous metals	
Heat resistant alloys	○
Hardened materials	

CircularLine – End milling cutter

▲ Chip breaker 1.8 x DC

CCR UNI | λ_s=30° 31° | γ_s= 8° | ZEFP | HPC | DPX72S

WNT \ Performance



Factory standard

HB

DC e8	RE ±0,05	APMX	DN	LH	LPR	OAL	DCONMS h6	ZEFP	Article no.	£
mm	mm	mm	mm	mm	mm	mm	mm			
6	0.2	19	5.8	25	27	63	6	6	53 592 06002	34.20
6	1.0	19	5.8	25	27	63	6	6	53 592 06010	34.92
6	1.5	19	5.8	25	27	63	6	6	53 592 06015	34.92
8	0.2	25	7.7	33	35	71	8	6	53 592 08002	44.38
8	1.0	25	7.7	33	35	71	8	6	53 592 08010	45.84
8	1.5	25	7.7	33	35	71	8	6	53 592 08015	45.84
8	2.0	25	7.7	33	35	71	8	6	53 592 08020	45.84
10	0.2	31	9.7	41	43	83	10	6	53 592 10002	62.56
10	1.0	31	9.7	41	43	83	10	6	53 592 10010	64.01
10	1.5	31	9.7	41	43	83	10	6	53 592 10015	64.01
10	1.6	31	9.7	41	43	83	10	6	53 592 10016	64.01
10	2.0	31	9.7	41	43	83	10	6	53 592 10020	64.01
12	0.2	37	11.6	47	49	94	12	6	53 592 12002	73.48
12	1.0	37	11.6	47	49	94	12	6	53 592 12010	75.65
12	1.5	37	11.6	47	49	94	12	6	53 592 12015	75.65
12	1.6	37	11.6	47	49	94	12	6	53 592 12016	75.65
12	2.0	37	11.6	47	49	94	12	6	53 592 12020	75.65
12	3.0	37	11.6	47	49	94	12	6	53 592 12030	75.65
16	0.2	49	15.5	61	63	111	16	6	53 592 16002	152.04
16	1.0	49	15.5	61	63	111	16	6	53 592 16010	153.49
16	1.5	49	15.5	61	63	111	16	6	53 592 16015	153.49
16	1.6	49	15.5	61	63	111	16	6	53 592 16016	153.49
16	2.0	49	15.5	61	63	111	16	6	53 592 16020	153.49
16	3.0	49	15.5	61	63	111	16	6	53 592 16030	153.49
16	4.0	49	15.5	61	63	111	16	6	53 592 16040	153.49
20	0.2	61	19.5	75	77	127	20	6	53 592 20002	213.15
20	1.0	61	19.5	75	77	127	20	6	53 592 20010	215.32
20	1.5	61	19.5	75	77	127	20	6	53 592 20015	215.32
20	1.6	61	19.5	75	77	127	20	6	53 592 20016	215.32
20	2.0	61	19.5	75	77	127	20	6	53 592 20020	215.32
20	3.0	61	19.5	75	77	127	20	6	53 592 20030	215.32
20	4.0	61	19.5	75	77	127	20	6	53 592 20040	215.32

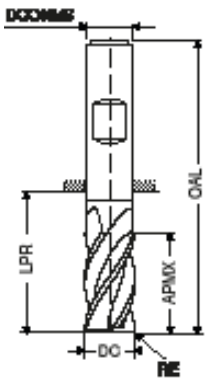
Steel	●
Stainless steel	○
Cast iron	●
Non ferrous metals	
Heat resistant alloys	○
Hardened materials	

CircularLine – End milling cutter

▲ Chip breaker 0.9 x DC

CCR UNI | λ_s=35° 36° | γ_s= 9° | ZEFP | HPC | DPX72S

WNT \ Performance



Factory standard

HB

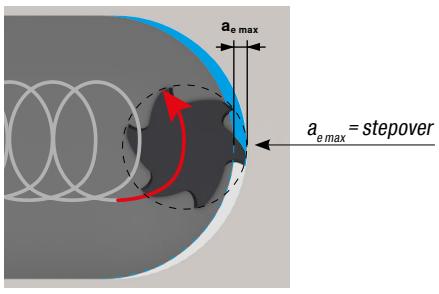
NEW

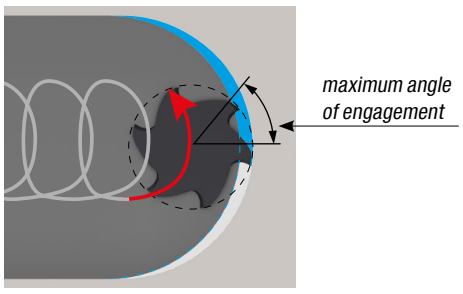
DC e8	RE ±0,05	APMX	LPR	OAL	DCONMS h6	ZEFP	Article no.	£
mm	mm	mm	mm	mm	mm			
6	0.2	31	39	75	6	5	53 593 06402	51.80
6	1.0	31	39	75	6	5	53 593 06410	51.80
6	1.5	31	39	75	6	5	53 593 06415	51.80
8	0.2	41	49	85	8	5	53 593 08402	59.71
8	1.0	41	49	85	8	5	53 593 08410	59.71
8	1.5	41	49	85	8	5	53 593 08415	59.71
8	2.0	41	49	85	8	5	53 593 08420	59.71
10	0.2	51	60	100	10	5	53 593 10402	82.44
10	1.0	51	60	100	10	5	53 593 10410	82.44
10	1.5	51	60	100	10	5	53 593 10415	82.44
10	1.6	51	60	100	10	5	53 593 10416	82.44
10	2.0	51	60	100	10	5	53 593 10420	82.44
12	0.2	61	70	115	12	5	53 593 12402	102.19
12	1.0	61	70	115	12	5	53 593 12410	102.19
12	1.5	61	70	115	12	5	53 593 12415	102.19
12	1.6	61	70	115	12	5	53 593 12416	102.19
12	2.0	61	70	115	12	5	53 593 12420	102.19
12	3.0	61	70	115	12	5	53 593 12430	102.19
14	0.2	71	81	126	14	5	53 593 14402	102.19
14	1.0	71	81	126	14	5	53 593 14410	209.90
14	1.5	71	81	126	14	5	53 593 14415	209.90
14	1.6	71	81	126	14	5	53 593 14416	209.90
14	2.0	71	81	126	14	5	53 593 14420	209.90
14	3.0	71	81	126	14	5	53 593 14430	209.90
16	0.2	81	92	140	16	5	53 593 16402	207.66
16	1.0	81	92	140	16	5	53 593 16410	207.66
16	1.5	81	92	140	16	5	53 593 16415	207.66
16	1.6	81	92	140	16	5	53 593 16416	207.66
16	2.0	81	92	140	16	5	53 593 16420	207.66
16	3.0	81	92	140	16	5	53 593 16430	207.66
16	4.0	81	92	140	16	5	53 593 16440	207.66
18	0.2	91	102	150	18	5	53 593 18402	237.48
18	1.0	91	102	150	18	5	53 593 18410	237.48
18	1.5	91	102	150	18	5	53 593 18415	237.48
18	1.6	91	102	150	18	5	53 593 18416	237.48
18	2.0	91	102	150	18	5	53 593 18420	237.48
18	3.0	91	102	150	18	5	53 593 18430	237.48
18	4.0	91	102	150	18	5	53 593 18440	237.48
20	0.2	102	113	163	20	5	53 593 20402	286.75
20	1.0	102	113	163	20	5	53 593 20410	286.75
20	1.5	102	113	163	20	5	53 593 20415	286.75
20	1.6	102	113	163	20	5	53 593 20416	286.75
20	2.0	102	113	163	20	5	53 593 20420	286.75
20	3.0	102	113	163	20	5	53 593 20430	286.75
20	4.0	102	113	163	20	5	53 593 20440	286.75

Steel	●
Stainless steel	○
Cast iron	●
Non ferrous metals	
Heat resistant alloys	○
Hardened materials	

Trochoidal milling

When programming the various CAM systems different information is required.





Features & benefits of trochoidal milling

- ▲ reduced tool wear
- ▲ higher material removal rate than HPC machining possible
- ▲ spindle and machine-friendly
- ▲ suitable for low-power machines
- ▲ suitable for thin-walled components and unstable workpiece clamping

Calculation of the average chip thickness

$$h_m \approx f_z \sqrt{\frac{a_e}{DC}}$$

$$f_z \approx h_m \sqrt{\frac{DC}{a_e}}$$

$a_{e\,max}$ = maximum lateral infeed (depending on the material to be machined)
f_z = maximum feed per tooth
h_m = average chip thickness
DC = tool diameter

Technical support: 0800 073 2 075
3 time served engineers, available from 8:00 am to 6:30 pm, Monday to Friday

Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

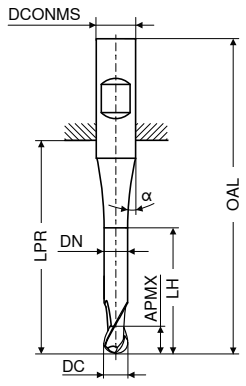
v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

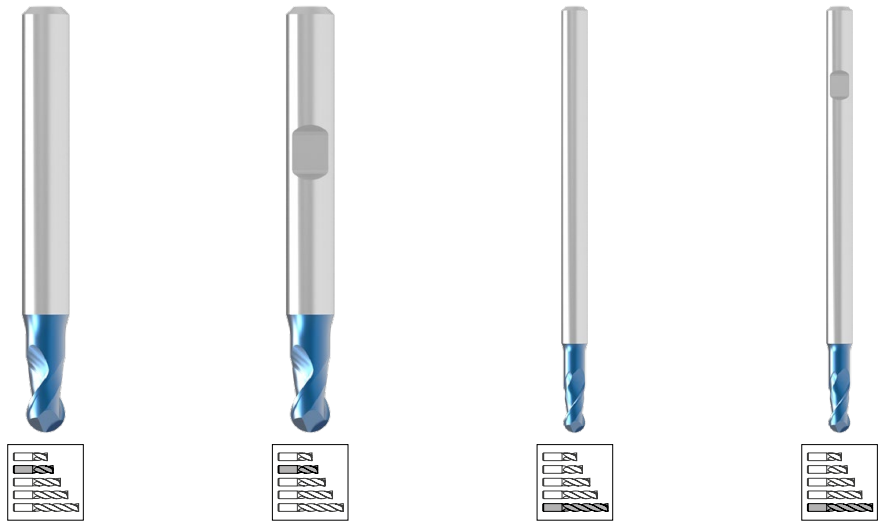
BlueLine – Ball Nosed Cutter

▲ Radius accuracy: ± 0,005 mm

H | λ_s=30° γ_s= 0° | ZEFP | 54–70 HRC

WNT \ Performance



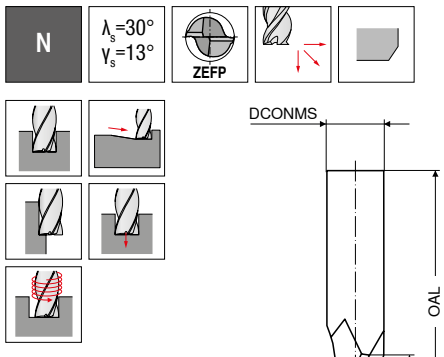


DC f8	APMX	DN	LH	LPR	OAL	DCONMS h6	α° ±0,5	ZEFP	Ti2000 Factory standard HA Article no.	£	Ti2000 Factory standard HB Article no.	£	Ti2000 Factory standard HA Article no.	£	Ti2000 Factory standard HB Article no.	£
mm	mm	mm	mm	mm	mm	mm										
0.10	0.2			10	38	3	8	2	52 256 910	74.85						
0.15	0.3			10	38	3	7,5	2	52 256 915	68.82						
0.20	0.4			10	38	3	7	2	52 256 920	64.65						
0.25	0.5	0.20	0.8	10	38	3	7	2	52 256 925	72.16						
0.30	1.0	0.25	1.3	10	38	3	7	2	52 256 930	67.93						
0.35	1.0	0.30	1.3	10	38	3	7	2	52 256 935	60.16						
0.40	1.0	0.35	1.3	10	38	3	7	2	52 256 940	44.92						
0.50	1.5	0.40	2.0	10	38	3	7,5	2	52 256 950	37.32						
0.50	1.5	0.40	2.0	18	54	6	10,5	2	52 256 005	37.44	52 257 005	37.44				
0.50	1.5	0.40	2.0	47	75	3	7	2					52 258 950	54.01		
0.50	1.5	0.40	2.0	44	80	6	10,5	2					52 258 005	62.06	52 259 005	64.58
0.60	1.5	0.50	2.0	10	38	3	7	2	52 256 960	40.50						
0.70	2.0	0.60	2.5	10	38	3	7,5	2	52 256 970	37.32						
0.80	2.0	0.70	2.5	10	38	3	7,5	2	52 256 980	37.32						
0.90	2.5	0.80	3.5	10	38	3	7	2	52 256 990	37.32						
1.00	2.0	0.90	3.0	22	50	3	6	2	52 256 011	39.19						
1.00	2.0	0.90	3.0	18	54	6	9,5	2	52 256 106	43.84	52 257 010	43.84				
1.00	3.0	0.90	4.0	47	75	3	6	2					52 258 011	54.01		
1.00	3.0	0.90	4.0	44	80	6	9,5	2					52 258 010	58.61	52 259 010	64.58
1.10	3.0	1.00	4.0	22	50	3	7	2	52 256 911	37.32						
1.20	3.0	1.10	4.0	22	50	3	7	2	52 256 012	37.32						
1.40	3.0	1.30	4.0	22	50	3	5	2	52 256 014	37.32						
1.50	3.0	1.40	4.0	22	50	3	5,5	2	52 256 016	39.19						
1.50	3.0	1.40	4.0	18	54	6	9	2	52 256 156	43.84	52 257 015	43.84				
1.50	4.0	1.40	6.0	47	75	3	7	2					52 258 016	52.89		
1.50	4.0	1.40	6.0	44	80	6	10	2					52 258 015	58.73	52 259 015	64.58
1.60	4.0	1.50	5.0	22	50	3	5	2	52 256 916	37.32						
1.80	4.0	1.70	5.0	22	50	3	5	2	52 256 018	37.32						
2.00	4.0	1.90	5.5	22	50	3	5	2	52 256 021	41.50						
2.00	4.0	1.90	5.5	18	54	6	9	2	52 256 206	43.84	52 257 020	43.84				
2.00	6.0	1.90	8.0	47	75	3	8	2					52 258 021	49.51		
2.00	6.0	1.90	8.0	44	80	6	11	2					52 258 020	55.21	52 259 020	63.52
2.50	5.0	2.30	6.5	22	50	3	7	2	52 256 025	37.32						
2.50	5.0	2.30	6.5	18	54	6	10	2	52 256 026	39.19	52 257 026	39.19				
2.50	8.0	2.30	10.0	47	75	3	5,5	2					52 258 026	49.47		
2.50	8.0	2.30	10.0	44	80	6	10	2					52 258 025	54.01	52 259 025	63.52
3.00	6.0	2.80	8.0	22	50	3		2	52 256 031	41.50						
3.00	6.0	2.80	8.0	18	54	6	9	2	52 256 306	43.84	52 257 030	43.84				
3.00	10.0	2.80	13.0	47	75	3		2					52 258 031	47.42		
3.00	10.0	2.80	15.0	44	80	6	11	2					52 258 030	54.01	52 259 030	62.37
4.00	7.0	3.80	10.0	18	54	6	11	2	52 256 406	43.84	52 257 040	43.84				
4.00	7.0	3.80	10.0	26	54	4		2	52 256 041	42.79						
4.00	13.0	3.80	20.0	47	75	4		2					52 258 041	46.25		
4.00	13.0	3.80	18.0	44	80	6	12,5	2					52 258 040	50.80	52 259 040	62.37
5.00	8.0	4.80	11.0	18	54	6	8	2	52 256 506	43.84	52 257 050	43.84				
5.00	8.0	4.80	11.0	26	54	5		2	52 256 051	43.84						
5.00	14.0	4.80	19.0	47	75	5		2					52 258 051	52.89		
5.00	14.0	4.80	19.0	64	100	6	13	2					52 258 050	58.73	52 259 050	62.37
6.00	10.0	5.80	15.0	18	54	6		2	52 256 061	43.84	52 257 060	43.84				
6.00	16.0	5.80	25.0	64	100	6		2					52 258 060	65.73	52 259 060	65.73
8.00	12.0	7.80	17.0	23	59	8		2	52 256 081	53.63	52 257 080	53.63				
8.00	22.0	7.80	35.0	64	100	8		2					52 258 080	78.78	52 259 080	78.78
10.00	13.0	9.80	18.0	27	67	10		2	52 256 101	70.04	52 257 100	70.04				
10.00	25.0	9.80	40.0	60	100	10		2					52 258 100	102.77	52 259 100	102.77
12.00	16.0	11.90	21.0	28	73	12		2	52 256 121	99.50	52 257 120	99.50				
12.00	26.0	11.80	40.0	55	100	12		2					52 258 120	135.67	52 259 120	135.67
14.00	16.0	13.80	21.0	30	75	14		2	52 256 141	125.79	52 257 140	125.79				
14.00	26.0	13.80	40.0	55	100	14		2					52 258 140	183.75	52 259 140	183.75
16.00	20.0	15.80	25.0	35	83	16		2	52 256 161	144.24	52 257 160	144.24				
16.00	30.0	15.80	50.0	102	150	16		2					52 258 160	298.25	52 259 160	298.25
20.00	25.0	19.80	30.0	43	93	20		2	52 256 201	236.07	52 257 200	236.07				
20.00	40.0	19.80	60.0	100	150	20		2					52 258 200	363.97	52 259 200	363.97

Steel	○	○	○	○
Stainless steel				
Cast iron				
Non ferrous metals				
Heat resistant alloys				
Hardened materials	●	●	●	●

End milling cutter

N | λ_s=30° γ_s=13° | ZEFP

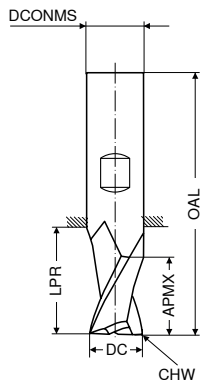


WNT \ Standard

≈DIN 6527

HA

DC e8	APMX	OAL	DCONMS h5	CHW	ZEFP	Article no.	£
mm	mm	mm	mm	mm			
0.25	0.5	38	3		2	50 594 925	20.76
0.30	1.0	38	3		2	50 594 930	19.08
0.35	1.0	38	3		2	50 594 935	19.08
0.40	1.0	38	3		2	50 594 940	19.08
0.50	1.5	38	3		2	50 594 950	19.08
0.60	1.5	38	3		2	50 594 960	19.08
0.70	2.0	38	3		2	50 594 970	19.08
0.80	2.0	38	3		2	50 594 980	19.08
0.90	2.5	38	3		2	50 594 990	19.08
1.00	3.0	50	3		2	50 594 010	20.06
1.10	3.0	50	3		2	50 594 011	20.06
1.20	4.0	50	3		2	50 594 012	20.06
1.40	4.0	50	3		2	50 594 014	20.06
1.50	4.0	50	3		2	50 594 015	20.06
1.60	4.0	50	3		2	50 594 016	20.06
1.80	5.0	50	3		2	50 594 018	20.06
2.00	5.0	50	3	0.07	2	50 594 020	18.46
2.50	6.0	50	3	0.07	2	50 594 025	20.06



≈DIN 6527

HB

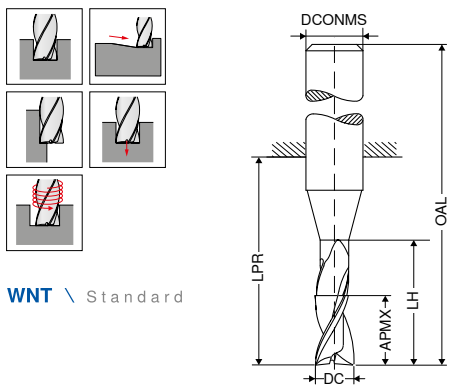
DC e8	APMX	LPR	OAL	DCONMS h5	CHW	ZEFP	Article no.	£
mm	mm	mm	mm	mm	mm			
2.8	8	21	57	6	0.07	2	50 594 028	16.77
3.0	8	21	57	6	0.15	2	50 594 030	16.77
3.8	11	21	57	6	0.15	2	50 594 038	16.77
4.0	11	21	57	6	0.15	2	50 594 040	16.77
4.8	13	21	57	6	0.15	2	50 594 048	16.77
5.0	13	21	57	6	0.15	2	50 594 050	16.77
5.8	13	21	57	6	0.15	2	50 594 058	16.77
6.0	13	21	57	6	0.15	2	50 594 060	16.77
6.8	16	27	63	8	0.15	2	50 594 068	19.36
7.0	16	27	63	8	0.15	2	50 594 070	19.36
7.8	19	27	63	8	0.15	2	50 594 078	19.36
8.0	19	27	63	8	0.15	2	50 594 080	19.36
8.7	19	32	72	10	0.15	2	50 594 087	29.94
9.0	19	32	72	10	0.15	2	50 594 090	29.94
9.7	22	32	72	10	0.15	2	50 594 097	29.94
10.0	22	32	72	10	0.15	2	50 594 100	29.94
10.7	26	38	83	12	0.15	2	50 594 107	46.59
11.0	26	38	83	12	0.15	2	50 594 110	46.59
11.7	26	38	83	12	0.15	2	50 594 117	46.59
12.0	26	38	83	12	0.15	2	50 594 120	44.49
13.7	26	38	83	14	0.15	2	50 594 137	56.96
14.0	26	38	83	14	0.15	2	50 594 140	56.96
15.7	32	44	92	16	0.15	2	50 594 157	75.12
16.0	32	44	92	16	0.15	2	50 594 160	66.84
17.7	32	44	92	18	0.15	2	50 594 177	124.49
18.0	32	44	92	18	0.15	2	50 594 180	88.49
19.7	38	54	104	20	0.15	2	50 594 197	164.08
20.0	38	54	104	20	0.15	2	50 594 200	112.12

Steel	●
Stainless steel	○
Cast iron	●
Non ferrous metals	○
Heat resistant alloys	○
Hardened materials	

Mini milling cutter

▲ Shank similar to DIN 6535

N | λ_s=30° γ_s=18° | ZEFP



Ti1000

WNT \ Standard

Factory standard

HB

Factory standard

HB

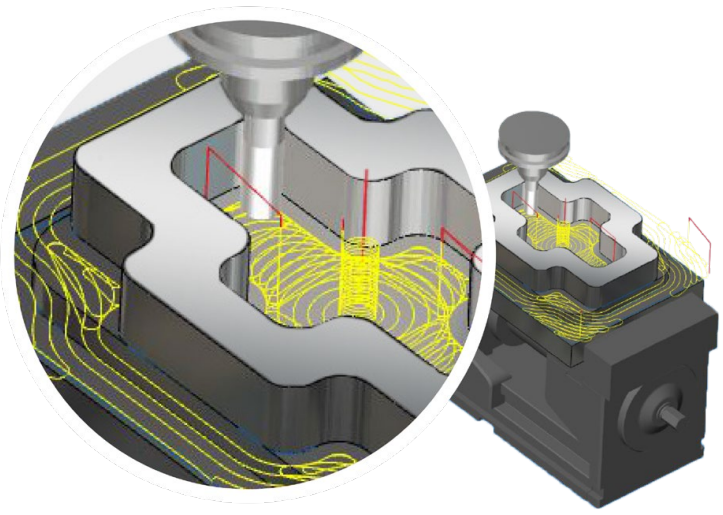
DC e8	APMX	LH	LPR	OAL	DCONMS h5	ZEFP	Article no.	£	Article no.	£
mm	mm	mm	mm	mm	mm					
2.00	4	4.0	10	35	6	3	50 598 020	11.68	50 599 020	16.25
2.50	4	4.0	10	35	6	3	50 598 025	12.25	50 599 025	16.77
3.00	5	5.0	10	36	6	3	50 598 030	11.68	50 599 030	16.25
3.50	5	5.0	10	36	6	3	50 598 035	12.25	50 599 035	16.77
4.00	7	7.0	12	38	6	3	50 598 040	11.66	50 599 040	15.37
4.50	7	7.0	12	38	6	3	50 598 045	12.25	50 599 045	16.77
5.00	8	8.0	13	39	6	3	50 598 050	11.66	50 599 050	15.46
5.50	8	8.0	13	39	6	3	50 598 055	12.25	50 599 055	16.93
5.75	8	8.0	13	39	6	3	50 598 057	12.25	50 599 057	16.93
6.00	8	8.5	13	39	6	3	50 598 060	11.66	50 599 060	15.46
6.75	11	11.5	16	43	8	3	50 598 067	16.37	50 599 067	20.76
7.00	11	11.5	16	43	8	3	50 598 070	15.67	50 599 070	19.66
7.75	11	11.5	16	43	8	3	50 598 077	16.67	50 599 077	21.25
8.00	11	11.5	16	43	8	3	50 598 080	18.07	50 599 080	20.96
8.70	13	13.5	18	50	10	3	50 598 087	25.66	50 599 087	31.24
9.00	13	13.5	18	50	10	3	50 598 090	23.01	50 599 090	28.29
9.70	13	13.5	18	50	10	3	50 598 097	25.66	50 599 097	31.24
10.00	13	13.5	18	50	10	3	50 598 100	25.05	50 599 100	30.04
12.00	15	15.5	24	55	12	3	50 598 120	33.23	50 599 120	38.91
14.00	15	15.5	26	58	14	3	50 598 140	56.86	50 599 140	61.45
16.00	18	18.5	28	62	16	3	50 598 160	63.55	50 599 160	70.13
18.00	20	20.5	35	70	18	3	50 598 180	80.12	50 599 180	87.78
20.00	22	22.5	40	75	20	3	50 598 200	102.25	50 599 200	108.63

Steel	●	●
Stainless steel	○	○
Cast iron	●	●
Non ferrous metals	○	○
Heat resistant alloys	○	○
Hardened materials		○

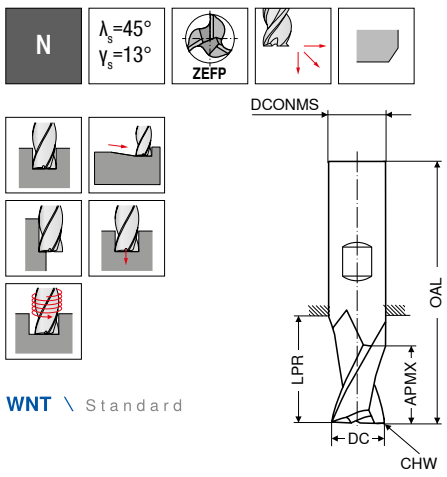
Tool data always at your fingertips

Cutting data and CAD models for day-to-day assistance

In addition to detailed cutting data we also offer 2D and 3D models to assist you with your tool management or for simulating an operation. All data for this Service is available for you in our Online Shop.



Mini milling cutter

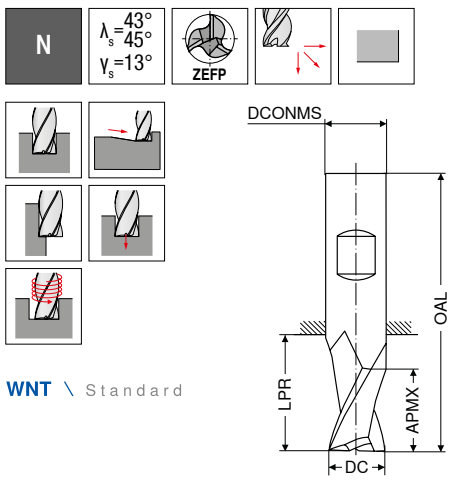


WNT \ Standard

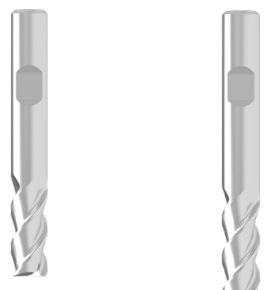
DC e8	APMX	LPR	OAL	DCONMS h5	CHW	ZEFP	Ti1000 Factory standard ~HA Article no.	£	Ti1000 Factory standard ~HA Article no.	£	Factory standard HB Article no.	£	Factory standard HB Article no.	£
mm	mm	mm	mm	mm	mm									
0.5	1.5	17	45	3	0.08	3	50 608 005	12.53	50 609 005	15.67				
1.0	2.0	17	45	3	0.08	3	50 608 010	12.53	50 609 010	15.67				
1.5	3.0	17	45	3	0.08	3	50 608 015	12.53	50 609 015	15.67				
1.8	3.0	17	45	3	0.08	3			50 609 018	15.67				
2.0	4.0	19	45	6	0.08	3					50 608 020	13.22	50 609 020	16.25
2.5	6.0	19	45	6	0.15	3					50 608 025	13.22	50 609 025	16.25
2.8	6.0	19	45	6	0.15	3							50 609 028	16.25
3.0	6.0	19	45	6	0.15	3					50 608 030	13.22	50 609 030	16.25
3.8	7.0	19	45	6	0.15	3							50 609 038	16.25
4.0	7.0	19	45	6	0.15	3					50 608 040	14.07	50 609 040	16.25
4.8	8.0	19	45	6	0.15	3							50 609 048	16.25
5.0	8.0	19	45	6	0.15	3					50 608 050	14.36	50 609 050	16.25
5.7	10.0	19	45	6	0.15	3							50 609 057	16.25
6.0	10.0	19	45	6	0.15	3					50 608 060	14.36	50 609 060	16.25
6.7	10.0	26	55	8	0.15	3							50 609 067	16.25
7.0	12.0	26	55	8	0.15	3					50 608 070	20.46	50 609 070	16.25
7.8	12.0	26	55	8	0.15	3							50 609 078	23.10
8.0	13.0	26	55	8	0.15	3					50 608 080	20.46	50 609 080	23.10
8.7	14.0	28	55	10	0.15	3							50 609 087	27.99
9.7	16.0	28	55	10	0.15	3							50 609 097	27.99
10.0	16.0	28	55	10	0.15	3					50 608 100	28.96	50 609 100	27.99

Steel	○	○	○	○
Stainless steel	●	●	●	●
Cast iron	○	○	○	○
Non ferrous metals	○	○	○	○
Heat resistant alloys	●	●	●	●
Hardened materials		●		●

End milling cutter



WNT \ Standard



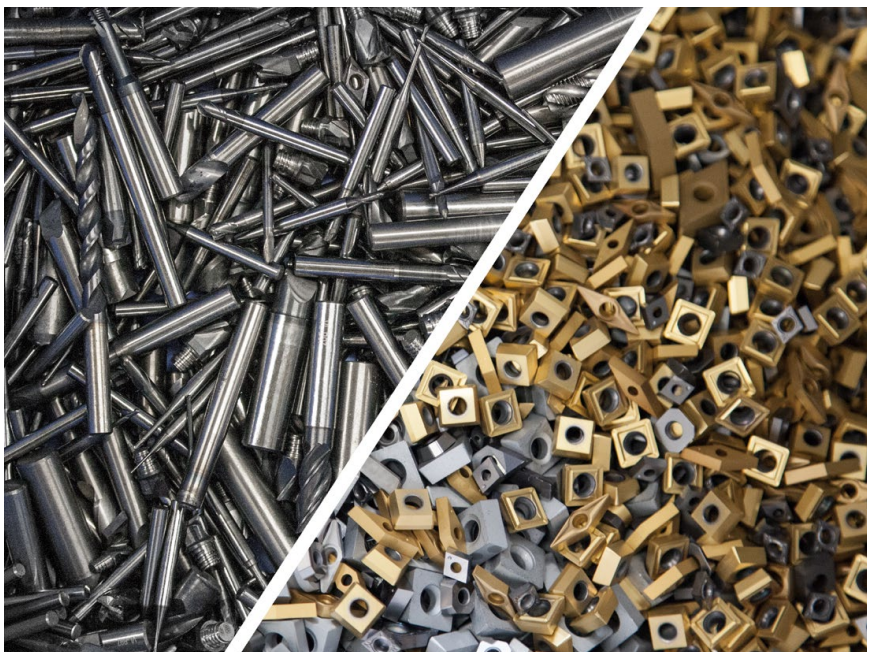
DC e8	APMX	LPR	OAL	DCONMS h5	ZEFP	≈DIN 6527 HB Article no.	£	≈DIN 6527 HB Article no.	£
mm	mm	mm	mm	mm					
3.0	8	21	57	6	3	50 614 030	17.83		
3.5	11	21	57	6	3	50 614 035	19.66		
3.5	15	23	59	6	3			50 614 036	30.32
4.0	11	21	57	6	3	50 614 040	17.83		
4.0	19	27	63	6	3			50 614 041	30.32
4.5	13	21	57	6	3	50 614 045	19.66		
4.5	19	27	63	6	3			50 614 046	30.32
5.0	13	21	57	6	3	50 614 050	17.52		
5.0	24	32	68	6	3			50 614 051	32.91
5.5	13	21	57	6	3	50 614 055	19.66		
5.5	24	32	68	6	3			50 614 056	32.91
6.0	13	21	57	6	3	50 614 060	17.83		
6.0	24	32	68	6	3			50 614 061	31.93
6.5	16	27	63	8	3	50 614 065	23.10		
6.5	30	44	80	8	3			50 614 066	45.30
7.0	16	27	63	8	3	50 614 070	22.41		
7.0	30	44	80	8	3			50 614 071	45.30
7.5	19	27	63	8	3	50 614 075	21.13		
7.5	30	44	80	8	3			50 614 076	45.30
8.0	19	27	63	8	3	50 614 080	20.76		
8.0	38	52	88	8	3			50 614 081	41.70
8.5	19	32	72	10	3	50 614 085	31.91		
8.5	38	48	88	10	3			50 614 086	71.43
9.0	19	32	72	10	3	50 614 090	31.91		
9.0	38	48	88	10	3			50 614 091	71.43
9.5	22	32	72	10	3	50 614 095	37.23		
9.5	38	48	88	10	3			50 614 096	71.43
10.0	22	32	72	10	3	50 614 100	33.31		
10.0	45	55	95	10	3			50 614 101	69.55
11.0	26	38	83	12	3	50 614 110	52.87		
11.0	45	57	102	12	3			50 614 111	100.07
12.0	26	38	83	12	3	50 614 120	47.88		
12.0	53	65	110	12	3			50 614 121	100.07
14.0	26	38	83	14	3	50 614 140	61.45		
14.0	53	65	110	14	3			50 614 141	127.08
16.0	32	44	92	16	3	50 614 160	84.20		
16.0	63	75	123	16	3			50 614 161	174.76
18.0	32	44	92	18	3	50 614 180	102.05		
18.0	63	75	123	18	3			50 614 181	210.97
20.0	38	54	104	20	3	50 614 200	132.48		
20.0	75	91	141	20	3			50 614 201	281.70

Steel	○	○
Stainless steel	●	●
Cast iron	○	○
Non ferrous metals	○	○
Heat resistant alloys	●	●
Hardened materials		

We come full circle

Our recycling service

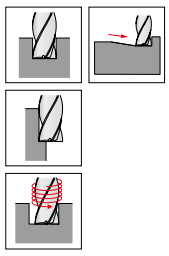
Our joint contribution for the good of the environment: we take back your carbide and process it appropriately. You receive a credit from us that you can redeem with your next tool purchase.

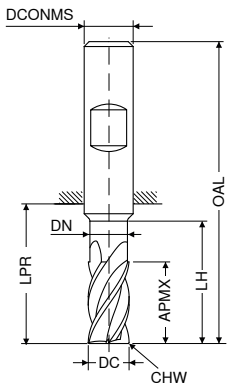


End milling cutter

- irregular helix angle
- special cutting edge preperation for the machining of stainless steel

N | λ_s=35° 38° γ_s=10° | ZEFP | HPC





WNT \ Standard

Ti1000

≈DIN 6527

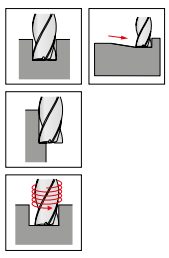
HB

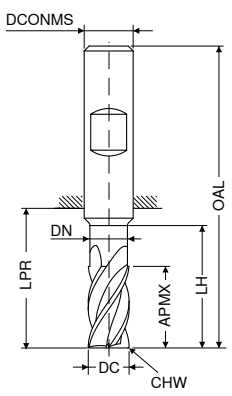
DC mm	APMX mm	DN mm	LH mm	LPR mm	OAL mm	DCONMS h6 mm	CHW mm	ZEFP	Article no.	£
3.0	8	2.8	12.0	21	57	6	0.15	4	54 006 030	15.75
4.0	11	3.8	15.0	21	57	6	0.15	4	54 006 040	15.75
5.0	13	4.8	17.0	21	57	6	0.15	4	54 006 050	15.75
6.0	13	5.8	21.0	21	57	6	0.15	4	54 006 060	18.42
8.0	19	7.7	27.0	27	63	8	0.25	4	54 006 080	23.79
10.0	22	9.7	32.0	32	72	10	0.25	4	54 006 100	31.26
12.0	26	11.6	38.0	38	83	12	0.35	4	54 006 120	49.68
16.0	32	15.5	44.0	44	92	16	0.35	4	54 006 160	76.62
20.0	38	19.5	54.0	54	104	20	0.35	4	54 006 200	115.91

Steel	●
Stainless steel	●
Cast iron	○
Non ferrous metals	○
Heat resistant alloys	●
Hardened materials	

Rough milling cutter

NR | λ_s=35° 38° γ_s=10° | ZEFP | HPC





WNT \ Standard

Ti1000 | Ti1000 | Ti1000

DIN 6527 | Factory standard | Factory standard

HB | HB | HB

DC h10 mm	APMX mm	DN mm	LH mm	LPR mm	OAL mm	DCONMS h6 mm	CHW mm	ZEFP	NEW Article no.	£	NEW Article no.	£	NEW Article no.	£
3	5			14	50	6	0.15	4	54 000 03100	20.28				
3	8	2.8	12	21	57	6	0.15	4			54 015 03200	20.32		
3	8	2.8	15	34	70	6	0.15	4					54 015 03400	29.62
4	8			18	54	6	0.15	4	54 000 04100	20.26				
4	11	3.8	15	21	57	6	0.15	4			54 015 04200	20.32		
4	11	3.8	20	34	70	6	0.15	4					54 015 04400	29.62
5	9			18	54	6	0.15	4	54 000 05100	20.26				
5	13	4.8	17	21	57	6	0.15	4			54 015 05200	20.32		
5	13	4.8	25	34	70	6	0.15	4					54 015 05400	33.88
6	10			18	54	6	0.15	4	54 000 06100	20.26				
6	13	5.8	21	21	57	6	0.15	4			54 015 06200	24.38		
6	13	5.8	30	34	70	6	0.15	4					54 015 06400	38.36
8	12			22	58	8	0.25	4	54 000 08100	27.98				
8	19	7.7	27	27	63	8	0.25	4			54 015 08200	30.42		
8	19	7.7	40	44	80	8	0.25	4					54 015 08400	46.90
10	14			26	66	10	0.25	4	54 000 10100	34.80				
10	22	9.7	32	32	72	10	0.25	4			54 015 10200	38.78		
10	22	9.7	50	54	94	10	0.25	4					54 015 10400	64.06
12	16			28	73	12	0.35	4	54 000 12100	51.50				
12	26	11.6	38	38	83	12	0.35	4			54 015 12200	62.92		
12	26	11.6	64	65	109	12	0.35	4					54 015 12400	76.56
16	22			34	82	16	0.35	4	54 000 16100	88.34				
16	32	15.5	44	44	92	16	0.35	4			54 015 16200	94.72		
16	32	15.5	80	84	132	16	0.35	4					54 015 16400	144.36
20	26			42	92	20	0.35	4	54 000 20100	129.10				
20	38	19.5	54	54	104	20	0.35	4			54 015 20200	140.42		
20	38	19.5	100	104	154	20	0.35	4					54 015 20400	188.60

Steel	●	●	●
Stainless steel	●	●	●
Cast iron	○	○	○
Non ferrous metals	○	○	○
Heat resistant alloys	●	●	●
Hardened materials			

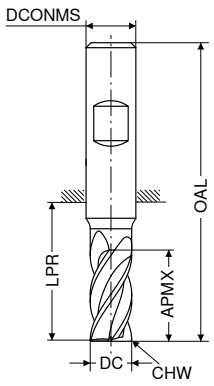
Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

Finish milling cutter

N | λ_s=43° 45° | γ_s=13° | ZEFP



WNT \ Standard

Ti1000

Ti1000

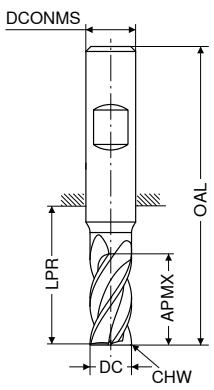
≈DIN 6527 | HB

Factory standard | HB

DC f8 mm	APMX mm	LPR mm	OAL mm	DCONMS h5 mm	CHW mm	ZEFP	Article no. ≈DIN 6527	£	Article no. Factory standard	£
4	11	21	57	6	0.15	6	50 633 040	28.23		
4	16	26	62	6	0.15	6			50 633 041	39.05
5	13	21	57	6	0.15	6	50 633 050	28.23		
5	18	26	62	6	0.15	6			50 633 051	39.05
6	13	21	57	6	0.15	6	50 633 060	28.23		
6	18	26	62	6	0.15	6			50 633 061	39.05
7	16	27	63	8	0.15	6	50 633 070	33.77		
7	21	32	68	8	0.15	6			50 633 071	52.18
8	19	27	63	8	0.15	6	50 633 080	32.91		
8	24	32	68	8	0.15	6			50 633 081	45.99
9	19	32	72	10	0.15	6	50 633 090	54.26		
9	27	40	80	10	0.15	6			50 633 091	82.79
10	22	32	72	10	0.15	6	50 633 100	52.87		
10	30	40	80	10	0.15	6			50 633 101	80.61
12	26	38	83	12	0.15	6	50 633 120	68.70		
12	36	48	93	12	0.15	6			50 633 121	110.52
14	26	38	83	14	0.15	6	50 633 140	95.06		
14	42	54	99	14	0.15	6			50 633 141	148.44
16	32	44	92	16	0.15	6	50 633 160	125.59		
16	48	60	108	16	0.15	6			50 633 161	191.12
16	65	77	125	16	0.15	6			50 633 162	239.99
16	75	102	150	16	0.15	6			50 633 163	268.30
16	95	102	150	16	0.15	6			50 633 164	310.32
18	32	44	92	18	0.15	8	50 633 180	145.64		
18	54	66	114	18	0.15	8			50 633 181	234.02
20	38	54	104	20	0.15	8	50 633 200	178.75		
20	60	76	126	20	0.15	8			50 633 201	297.95
20	75	85	135	20	0.15	8			50 633 202	316.92
20	95	100	150	20	0.15	8			50 633 203	327.88
25	75	94	150	25	0.15	8			50 633 250	391.72
25	95	104	160	25	0.15	8			50 633 251	571.80
32	75	90	150	32	0.15	8	50 633 320	783.13		
32	95	100	160	32	0.15	8			50 633 321	763.98
Steel							○		○	
Stainless steel							●		●	
Cast iron							○		○	
Non ferrous metals							○		○	
Heat resistant alloys							●		●	
Hardened materials							●		●	

Rough milling cutter

NR | λ_s=20° | γ_s=10° | ZEFP



WNT \ Standard

Ti400

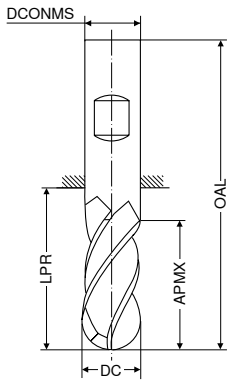
DIN 6527 | HB

DC d11 mm	APMX mm	LPR mm	OAL mm	DCONMS h5 mm	CHW mm	ZEFP	Article no.	£
4	8	21	57	6	0.6	4	50 624 040	54.86
5	13	21	57	6	0.6	4	50 624 050	54.86
6	13	21	57	6	0.6	4	50 624 060	51.18
7	19	27	63	8	0.6	4	50 624 070	68.14
8	19	27	63	8	0.6	4	50 624 080	60.65
9	22	32	72	10	0.6	4	50 624 090	74.61
10	22	32	72	10	0.6	4	50 624 100	70.42
11	26	38	83	12	0.6	4	50 624 110	88.49
12	26	38	83	12	0.6	4	50 624 120	83.50
13	26	38	83	14	0.6	4	50 624 130	123.68
14	26	38	83	14	0.6	4	50 624 140	116.61
16	32	44	92	16	0.6	4	50 624 160	132.77
18	32	44	92	18	0.6	4	50 624 180	176.46
20	38	54	104	20	0.6	4	50 624 200	197.90
25	45	65	121	25	0.6	5	50 624 250	256.87
Steel							●	
Stainless steel							○	
Cast iron							●	
Non ferrous metals							○	
Heat resistant alloys							○	
Hardened materials								

Ball Nosed Cutter

▲ Radius accuracy: ± 0,01 mm

N | λ_s=30° | γ_s= 6° | ZEFP



WNT \ Standard

Ti1000

Ti1000

DIN 6527 | HB

DIN 6527 | HB

Factory standard | HB

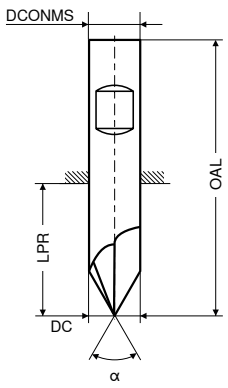
DIN 6527 | HB

DC f8 mm	APMX mm	LPR mm	OAL mm	DCONMS h5 mm	ZEFP	Article no. DIN 6527	£	Article no. DIN 6527	£	Article no. Factory standard	£	Article no. DIN 6527	£
3	8	21	57	6	4	50 642 030	29.04	50 643 030	33.31				
4	11	21	57	6	4	50 642 040	29.04	50 643 040	33.31				
6	13	21	57	6	4	50 642 060	29.04	50 643 060	33.31				
6	40	64	100	6	4					50 642 061	35.82	50 643 061	42.99
8	19	27	63	8	4	50 642 080	33.31	50 643 080	36.41				
8	40	64	100	8	4					50 642 081	41.20	50 643 081	47.68
10	22	32	72	10	4	50 642 100	56.86	50 643 100	58.24				
10	40	60	100	10	4					50 642 101	72.92	50 643 101	79.60
12	26	38	83	12	4	50 642 120	76.22	50 643 120	77.41				
12	45	55	100	12	4					50 642 121	98.95	50 643 121	105.65
12	75	105	150	12	4					50 642 122	153.52	50 643 122	159.99
14	26	38	83	14	4	50 642 140	96.37	50 643 140	94.43				
14	45	55	100	14	4					50 642 141	137.17	50 643 141	143.65
16	32	44	92	16	4	50 642 160	135.77	50 643 160	133.27				
16	75	102	150	16	4					50 642 161	187.94	50 643 161	194.51
20	38	54	104	20	4	50 642 200	188.13	50 643 200	171.58				
20	75	100	150	20	4					50 642 201	298.17	50 643 201	304.73
Steel						●		●		●		●	
Stainless steel						○		○		○		○	
Cast iron						●		●		●		●	
Non ferrous metals						○		○		○		○	
Heat resistant alloys						○		○		○		○	
Hardened materials								○				○	

NC deburring cutter

N | λ_s=0° γ_s=0° | Ti1000

WNT \ Performance



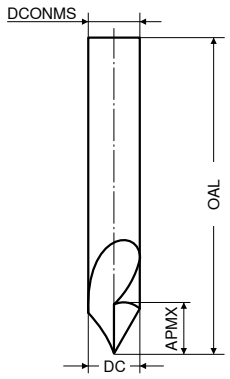
DC h6 mm	OAL mm	LPR mm	DCONMS h6 mm	ZEFP	α = 90° Factory standard HB Article no.	£	α = 90° Factory standard HB Article no.	£
4	50	22	4	4	52 151 040 1)	22.42	52 154 040 1)	28.85
6	54	18	6	4	52 151 060	28.76	52 154 060	38.56
8	59	23	8	4	52 151 080	34.14	52 154 080	47.11
10	60	20	10	4	52 151 100	41.91	52 154 100	57.25
12	70	25	12	4	52 151 120	58.94	52 154 120	77.98
Steel					●		●	
Stainless steel					○		○	
Cast iron					●		●	
Non ferrous metals					○		○	
Heat resistant alloys					○		○	
Hardened materials							○	

1) DIN 6535 HA Shank

Engraving cutter 60°

W | λ_s=15° γ_s=20° | ZEFP

WNT \ Standard

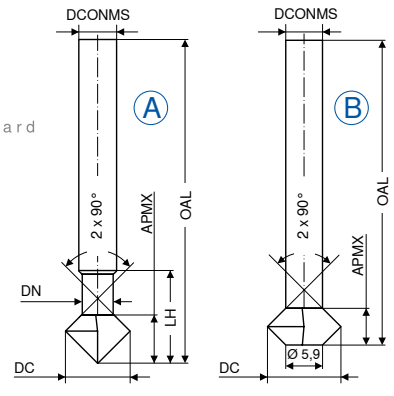


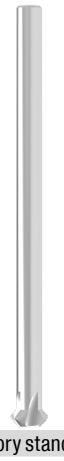
DC h6 mm	APMX mm	OAL mm	DCONMS h6 mm	ZEFP	Factory standard HA Article no.	£
3	15	50	3	1	52 195 030	33.06
4	18	50	4	1	52 195 040	34.71
6	20	54	6	1	52 195 060	37.79
Steel					○	
Stainless steel					○	
Cast iron					○	
Non ferrous metals					●	
Heat resistant alloys					○	
Hardened materials						

NC front and rear chamfer milling cutter

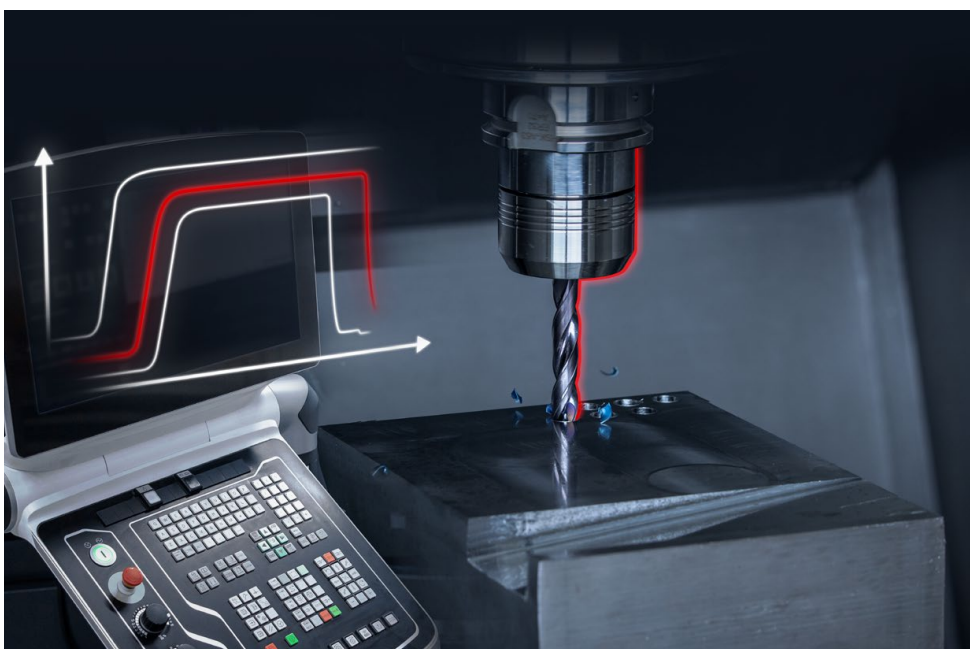
N | λ_s=0° γ_s=0° | ZEFP | Ti1000

WNT \ Standard





DC mm	APMX mm	DN mm	LH mm	OAL mm	DCONMS h5 mm	ZEFP	Fig.	Factory standard HA Article no.	£	Factory standard HA Article no.	£
3	2.0	2.2	12.0	75	4	4	A	52 158 030	54.29	52 159 030	61.69
4	2.7	2.9	17.7	75	4	4	A	52 158 040	54.29	52 159 040	61.35
5	3.0	3.9	18.0	75	5	4	A	52 158 050	55.67	52 159 050	63.73
6	4.0	3.9	19.0	100	6	4	A	52 158 060	57.80	52 159 060	63.79
8	2.0			100	6	4	B	52 158 080	75.12	52 159 080	84.48
10	4.0			100	6	4	B	52 158 100	93.85	52 159 100	104.30
12	6.0			100	6	4	B	52 158 120	112.55	52 159 120	124.31
Steel								●		●	
Stainless steel								○		○	
Cast iron								●		●	
Non ferrous metals								○		○	
Heat resistant alloys								○		○	
Hardened materials										○	



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Speed Calculation

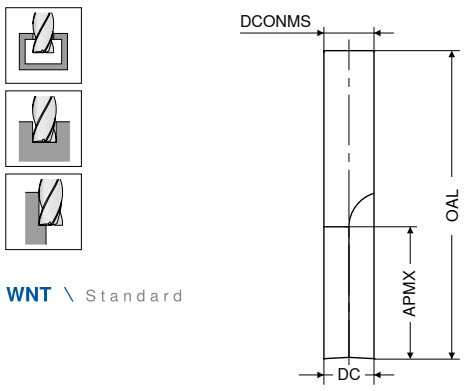
$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

Cutter for plastics

▲ With polished flutes

W | ZEFP | Ti40



WNT \ Standard

Factory standard

HA

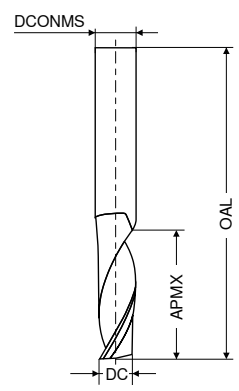
DC h10	APMX	OAL	DCONMS h6	ZEFP	Article no.	
mm	mm	mm	mm			£
1.5	6	40	3	1	50 946 015	20.43
2.0	6	40	3	1	50 946 020	20.43
2.0	10	40	2	1	50 946 022	14.63
2.0	10	60	6	1	50 946 024	29.74
2.0	12	60	6	1	50 946 026	30.50
3.0	12	40	3	1	50 946 030	15.39
3.0	12	60	6	1	50 946 032	29.74
3.0	15	60	6	1	50 946 034	29.74
4.0	15	60	6	1	50 946 040	29.74
4.0	20	75	6	1	50 946 042	44.94
5.0	16	60	6	1	50 946 050	29.74
5.0	28	75	6	1	50 946 052	49.69
6.0	20	60	6	1	50 946 060	25.85
6.0	30	60	6	1	50 946 062	29.36
6.0	35	75	6	1	50 946 064	41.34
8.0	22	63	8	1	50 946 080	40.10
8.0	40	100	8	1	50 946 082	64.40
10.0	25	72	10	1	50 946 100	59.56
10.0	55	100	10	1	50 946 102	105.55
12.0	30	83	12	1	50 946 120	77.15

Steel	
Stainless steel	
Cast iron	
Non ferrous metals	●
Heat resistant alloys	
Hardened materials	

Single flute cutter

▲ With polished chip flutes

W | λ_s=25° γ_s=20° | ZEFP



WNT \ Standard

Right-hand helix
right-hand cutting

Left-hand helix
right-hand cutting

Factory standard

HA

Factory standard

HA

DC h10	APMX	OAL	DCONMS h6	ZEFP	Article no.		Article no.	
mm	mm	mm	mm			£		£
1.5	6	40	3.0	1	50 610 015	16.53	50 611 015	16.53
2.0	6	40	3.0	1	50 610 019	16.53	50 611 019	16.53
2.0	10	40	2.0	1	50 610 020	13.40	50 611 020	13.40
2.0	10	60	6.0	1	50 610 022	24.43	50 611 022	24.43
2.0	12	60	6.0	1	50 610 024	25.19	50 611 024	25.19
2.5	6	40	2.5	1	50 610 025	16.53	50 611 025	16.53
3.0	12	40	3.0	1	50 610 030	13.30	50 611 030	13.30
3.0	10	40	6.0	1	50 610 032	24.04	50 611 032	24.04
3.0	12	60	6.0	1	50 610 034	24.43	50 611 034	24.43
3.0	15	60	6.0	1	50 610 036	24.43	50 611 036	24.43
4.0	15	40	4.0	1	50 610 040	16.25	50 611 040	16.25
4.0	15	60	6.0	1	50 610 042	24.43	50 611 042	24.43
4.0	20	75	6.0	1	50 610 044	39.61	50 611 044	39.61
5.0	16	50	5.0	1	50 610 050	20.76	50 611 050	20.76
5.0	16	60	6.0	1	50 610 052	24.43	50 611 052	24.43
5.0	28	75	6.0	1	50 610 054	44.37	50 611 054	44.37
6.0	20	60	6.0	1	50 610 060	24.25	50 611 060	24.25
6.0	30	60	6.0	1	50 610 062	24.04	50 611 062	24.04
6.0	35	75	6.0	1	50 610 064	36.01	50 611 064	36.01
8.0	22	63	8.0	1	50 610 080	39.30	50 611 080	39.30
8.0	40	100	8.0	1	50 610 084	57.56	50 611 084	57.56
10.0	25	72	10.0	1	50 610 100	57.95	50 611 100	57.95
10.0	55	100	10.0	1	50 610 105	95.86	50 611 105	95.86
12.0	30	83	12.0	1	50 610 120	78.20	50 611 120	78.20
14.0	30	83	14.0	1	50 610 140	117.02	50 611 140	117.02
16.0	35	92	16.0	1	50 610 160	165.90	50 611 160	165.90
18.0	35	92	18.0	1	50 610 180	198.50	50 611 180	198.50
20.0	40	104	20.0	1	50 610 200	223.24	50 611 200	223.24

Steel		
Stainless steel		
Cast iron		
Non ferrous metals	●	●
Heat resistant alloys		
Hardened materials		

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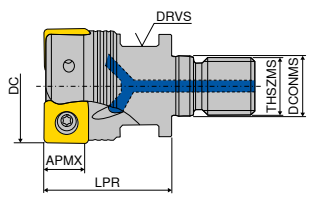
MaxiMill – Screw in cutter G 491

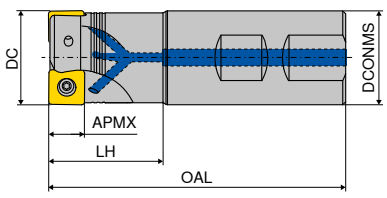
CERATIZIT \ Performance



ISO designation	DC	LPR	THSZMS	DCONMS	APMX	DRVS	Insert	ZNF	Article no.	£
	mm	mm		mm	mm	mm				
G491.25.R.03-09	25	35	M12	12.5	6	17	SNHU 09T3	3	50 773 125	159.68
G491.32.R.03-09	32	35	M16	17.0	6	24	SNHU 09T3	3	50 773 132	162.09
G491.32.R.04-09	32	35	M16	17.0	6	24	SNHU 09T3	4	50 773 232	181.09
G491.32.R.02-12	32	35	M16	17.0	8	24	SNHU 1204	2	50 773 032	152.55

MaxiMill – End milling cutter C 491

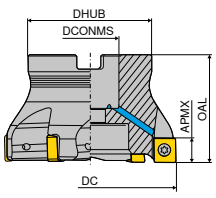
CERATIZIT \ Performance

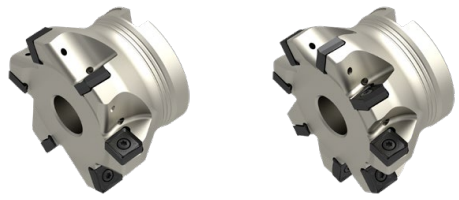


ISO designation	DC	OAL	LH	DCONMS h6	APMX	Insert	ZNF	Article no.	£	Article no.	£
	mm	mm	mm	mm	mm						
C491.25.R.03-09-A-50-225	25	225	50	25	6	SNHU 09T3	3	50 774 325	162.09		
C491.25.R.03-09-B-32	25	59	32	25	6	SNHU 09T3	3			50 774 425	162.09
C491.32.R.03-09-A-63-250	32	250	63	32	6	SNHU 09T3	3	50 774 532	166.82		
C491.32.R.04-09-B-40	32	101	40	32	6	SNHU 09T3	4			50 774 432	181.09
C491.32.R.04-09-A-63-250	32	250	63	32	6	SNHU 09T3	4	50 774 332	181.09		
C491.32.R.03-09-B-40	32	101	40	32	6	SNHU 09T3	3			50 774 632	166.82
C491.32.R.02-12-A-63-250	32	250	63	32	8	SNHU 1204	2	50 774 232	152.55		
C491.32.R.02-12-B-40	32	102	40	32	8	SNHU 1204	2			50 774 032	152.55

MaxiMill – Shell mill A 491

CERATIZIT \ Performance





ISO designation	DC	OAL	DHUB	DCONMS H6	APMX	Insert	ZNF	Article no.	£	Article no.	£
	mm	mm	mm	mm	mm						
A491.40.R.03-09	40	40	38	16	6	SNHU 09T3	3	50 775 240	176.32		
A491.40.R.05-09	40	40	38	16	6	SNHU 09T3	5			50 776 240	204.96
A491.50.R.04-09	50	40	43	22	6	SNHU 09T3	4	50 775 250	195.41		
A491.50.R.06-09	50	40	43	22	6	SNHU 09T3	6			50 776 250	224.00
A491.63.R.05-09	63	40	48	22	6	SNHU 09T3	5	50 775 263	233.55		
A491.63.R.08-09	63	40	48	22	6	SNHU 09T3	8			50 776 263	276.41
A491.80.R.06-09	80	50	58	27	6	SNHU 09T3	6	50 775 280	247.87		
A491.80.R.10-09	80	50	58	27	6	SNHU 09T3	10			50 776 280	305.05
A491.100.R.07-09	100	50	78	32	6	SNHU 09T3	7	50 775 300	314.55		
A491.100.R.12-09	100	50	78	32	6	SNHU 09T3	12			50 776 300	386.05
A491.125.R.08-09	125	63	88	40	6	SNHU 09T3	8	50 775 325	381.28		
A491.125.R.15-09	125	63	88	40	6	SNHU 09T3	15			50 776 325	467.28
A491.40.R.03-12	40	40	38	16	8	SNHU 1204	3	50 775 040	176.32		
A491.40.R.04-12	40	40	38	16	8	SNHU 1204	4			50 776 040	190.64
A491.50.R.04-12	50	40	43	22	8	SNHU 1204	4	50 775 050	195.41		
A491.50.R.05-12	50	40	43	22	8	SNHU 1204	5			50 776 050	209.73
A491.63.R.05-12	63	40	48	22	8	SNHU 1204	5	50 775 063	233.55		
A491.63.R.06-12	63	40	48	22	8	SNHU 1204	6			50 776 063	247.87
A491.80.R.06-12	80	50	58	27	8	SNHU 1204	6	50 775 080	247.87		
A491.80.R.08-12	80	50	58	27	8	SNHU 1204	8			50 776 080	285.96
A491.100.R.07-12	100	50	78	32	8	SNHU 1204	7	50 775 100	314.55		
A491.100.R.10-12	100	50	78	32	8	SNHU 1204	10			50 776 100	357.50
A491.125.R.08-12	125	63	88	40	8	SNHU 1204	8	50 775 125	381.28		
A491.125.R.12-12	125	63	88	40	8	SNHU 1204	12			50 776 125	438.50
A491.160.R.09-12	160	63	98	40	8	SNHU 1204	9	50 775 160 [1]	443.28		
A491.160.R.14-12	160	63	98	40	8	SNHU 1204	14			50 776 160 [1]	515.00

1) With threaded holes M12 on the front face, pitch circle diameter = 66.7 mm

Spare parts	TORX® blade		Clamping key - T		Key D		Power Screw		Clamping screw	
	Article no.		Article no.		Article no.		Article no.		Article no.	
	£		£		£		£		£	
SNHU 09T3..	3.68	80 950 053			6.45	80 950 119			2.39	70 950 710
SNHU 09T3.. (Ø40)	3.68	80 950 053	2.63	80 397 040	6.45	80 950 119	9.65	70 950 151	2.39	70 950 710
SNHU 1204..					8.67	80 950 128			2.42	70 950 859
SNHU 1204.. (Ø40)			2.63	80 397 040	8.67	80 950 128	9.65	70 950 151	2.42	70 950 859

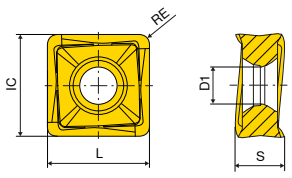
Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

SNHU

Designation	IC	D1	L	S
	mm	mm	mm	mm
SNHU 09T3..	9.15	3.85	9.15	3.70
SNHU 1204..	12.20	4.40	12.20	5.00



SNHU

CERATIZIT \ Performance

ISO	RE mm	-F50 CTPM240 (-F50 DPX2240) Article no.	£	-F10 CTWN215 (-F10 CWK4615) Article no.	£
120408FR	0.8			51 101 358	18.28
120408SR	0.8	51 102 408	18.28		
120412FR	1.2			51 101 362	18.28
120412SR	1.2	51 102 412	18.28		
120416FR	1.6			51 101 366	18.28
120416SR	1.6	51 102 416	18.28		
120420FR	2.0			51 101 370	18.28
120420SR	2.0	51 102 420	18.28		

	-F50 CTPM240	-F10 CTWN215
Steel	○	
Stainless steel	●	
Cast iron		○
Non ferrous metals		●
Heat resistant alloys		

SNHU

CERATIZIT \ Performance

ISO	RE mm	-M50 CTCP230 (-M50 DCX1230) Article no.	£	-M50 CTPP235 (-M50 DPX1235) Article no.	£	-M50 CTPM240 (-M50 DPX2240) Article no.	£	-R50 CTCK215 (-R50 DCX3215) Article no.	£	-R50 CTPK220 (-R50 DPX3220) Article no.	£
120408SR	0.8	51 100 008	18.28	51 100 108	18.28	51 100 408	18.28	51 103 508	18.28	51 103 608	18.28
120412SR	1.2			51 100 112	18.28			51 103 512	18.28		
120416SR	1.6			51 100 116	18.28			51 103 516	18.28		
120420SR	2.0			51 100 120	18.28			51 103 520	18.28		

	-M50 CTCP230	-M50 CTPP235	-M50 CTPM240	-R50 CTCK215	-R50 CTPK220
Steel	●	●	○	○	○
Stainless steel	○	○	●		
Cast iron				●	●
Non ferrous metals					
Heat resistant alloys					

SNHU

CERATIZIT \ Performance

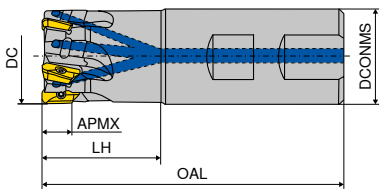
ISO	RE mm	-M50 CTCP230 (-M50 DCX1230) Article no.	£	-M50 CTPP235 (-M50 DPX1235) Article no.	£	-F50 CTPM240 (-F50 DPX2240) Article no.	£	-M50 CTPM240 (-M50 DPX2240) Article no.	£	-R50 CTCK215 (-R50 DCX3215) Article no.	£	-F10 CTWN215 (-F10 CWK4615) Article no.	£
09T308FR	0.8											51 118 358	14.96
09T308SR	0.8	51 120 008	14.96	51 120 108	14.96	51 119 408	14.96	51 120 408	14.96	51 121 508	14.96		

	-M50 CTCP230	-M50 CTPP235	-F50 CTPM240	-M50 CTPM240	-R50 CTCK215	-F10 CTWN215
Steel	●	●	○	○	○	
Stainless steel	○	○	●	●		
Cast iron					●	○
Non ferrous metals						●
Heat resistant alloys						

MaxiMill – End milling cutter C 211-11

▲ Insert radius >1,6 mm: Modify cutter body

CERATIZIT \ Performance

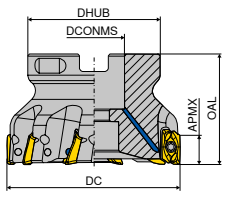


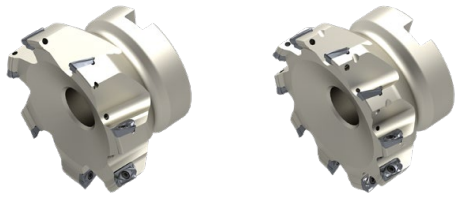
ISO designation	DC	OAL	LH	DCONMS h6	APMX	RPMX	Insert	ZNF	Article no. (A)	£	Article no. (B)	£
	mm	mm	mm	mm	mm	1/min.						
C211.12.R.01-11-B-20	12	75	20	16	10	55000	XD.T 11T3	1			50 737 012	93.46
C211.16.R.02-11-A-25	16	75	25	16	10	42000	XD.T 11T3	2	50 737 116	104.78		
C211.16.R.02-11-B-25	16	75	25	16	10	42000	XD.T 11T3	2			50 737 016	104.78
C211.16.R.02-11-A15-32-165	16	165	32	15	10	14800	XD.T 11T3	2	50 737 316	104.78		
C211.16.R.02-11-A-32-165	16	165	32	16	10	14800	XD.T 11T3	2	50 737 216	104.78		
C211.20.R.03-11-A-25	20	77	25	20	10	36900	XD.T 11T3	3	50 737 120	118.96		
C211.20.R.03-11-B-25	20	77	25	20	10	36900	XD.T 11T3	3			50 737 020	118.96
C211.20.R.03-11-A-32-165	20	165	32	20	10	15800	XD.T 11T3	3	50 737 320	118.96		
C211.20.R.02-11-A19-40-200	20	200	40	19	10	10500	XD.T 11T3	2	50 737 620	110.46		
C211.20.R.02-11-A-40-200	20	200	40	20	10	10500	XD.T 11T3	2	50 737 420	110.46		
C211.25.R.03-11-A-32	25	90	32	25	10	33200	XD.T 11T3	3	50 737 625	124.64		
C211.25.R.03-11-B-32	25	90	32	25	10	33200	XD.T 11T3	3			50 737 725	124.64
C211.25.R.04-11-A-32	25	90	32	25	10	33200	XD.T 11T3	4	50 737 125	133.14		
C211.25.R.04-11-B-32	25	90	32	25	10	33200	XD.T 11T3	4			50 737 025	133.14
C211.25.R.04-11-A-40-165	25	165	40	25	10	19900	XD.T 11T3	4	50 737 325	133.14		
C211.25.R.03-11-A-50-225	25	225	50	25	10	9400	XD.T 11T3	3	50 737 425	124.64		
C211.25.R.03-11-A24-50-225	25	225	50	24	10	9400	XD.T 11T3	3	50 737 825	124.64		
C211.32.R.05-11-A-40	32	102	40	32	10	30200	XD.T 11T3	5	50 737 132	147.32		
C211.32.R.05-11-B-40	32	102	40	32	10	30200	XD.T 11T3	5			50 737 032	147.32
C211.32.R.05-11-A-50-165	32	165	50	32	10	20900	XD.T 11T3	5	50 737 332	147.32		
C211.32.R.04-11-A-64-250	32	250	64	32	10	8500	XD.T 11T3	4	50 737 432	138.78		

MaxiMill – Shell mill A 211-11

▲ Insert radius >1,6 mm: Modify cutter body

CERATIZIT \ Performance





ISO designation	DC	OAL	DCONMS H6	DHUB	APMX	RPMX	Insert	ZNF	Article no.	£	Article no.	£
	mm	mm	mm	mm	mm	1/min.						
A211.40.R.04-11	40	40	16	38	10	27700	XD.T 11T3	4	50 738 040	144.50		
A211.40.R.06-11	40	40	16	38	10	27700	XD.T 11T3	6			50 739 040	161.41
A211.50.R.05-11	50	40	22	43	10	25400	XD.T 11T3	5	50 738 050	169.91		
A211.50.R.08-11	50	40	22	43	10	25400	XD.T 11T3	8			50 739 050	195.46
A211.63.R.06-11	63	40	22	48	10	23300	XD.T 11T3	6	50 738 063	195.46		
A211.63.R.10-11	63	40	22	48	10	23300	XD.T 11T3	10			50 739 063	229.41
A211.80.R.07-11	80	50	27	58	10	21300	XD.T 11T3	7	50 738 080	220.96		
A211.80.R.10-11	80	50	27	58	10	21300	XD.T 11T3	10			50 739 180	246.41



Spare parts DC	TORX® blade £	Article no.	Clamping key - T £	Article no.	Key D £	Article no.	Power Screw £	Article no.	Clamping screw £	Article no.	Torque screwdriver £	Article no.
12	3.68	80 950 043			7.42	80 950 125			1.99	70 950 116	89.97	80 950 191
16 - 32	3.68	80 950 043			7.42	80 950 125			3.16	70 950 128	89.97	80 950 191
40	3.68	80 950 043	2.63	80 397 040	7.42	80 950 125	9.65	70 950 151	3.16	70 950 131	89.97	80 950 191
40	3.68	80 950 043			7.42	80 950 125	9.65	70 950 151	3.16	70 950 131	89.97	80 950 191
50	3.68	80 950 043	3.35	80 397 050	7.42	80 950 125	13.24	70 950 154	3.16	70 950 131	89.97	80 950 191
63 - 80	3.68	80 950 043			7.42	80 950 125			3.16	70 950 131	89.97	80 950 191

Technical support: 0800 073 2 075
3 time served engineers, available from 8:00 am to 6:30 pm, Monday to Friday

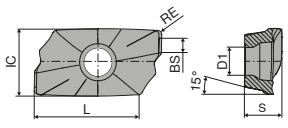
Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

XDKT / XDHT

Designation	IC	D1	L	BS	S
	mm	mm	mm	mm	mm
XD.T 11T302..	6.8	2.8	10.6	2	3.80
XD.T 11T304..	6.8	2.8	10.6	1.8	3.80
XD.T 11T308..	6.8	2.8	10.6	1.4	3.80
XD.T 11T312..	6.8	2.8	10.6	1.4	3.80
XD.T 11T316..	6.8	2.8	10.6	1.4	3.80
XD.T 11T320..	6.8	2.8	10.6	1.4	3.80
XD.T 11T325..	6.8	2.8	10.6	1.4	3.80
XD.T 11T332..	6.8	2.8	10.6	0.8	3.80
XD.T 11T340..	6.8	2.8	10.6	-	3.80
XDHT 11T350..	6.8	2.8	10.6	-	3.80
XDKT 11T332..	6.8	2.8	10.6	1.4	3.80



XDKT / XDHT

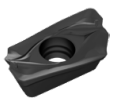
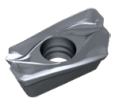
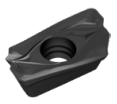
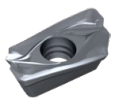
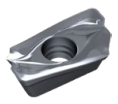
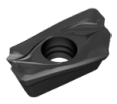
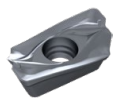
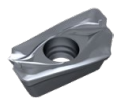
CERATIZIT \ Performance

ISO	RE	-F40 CTPM245		-F50 CTPM245		-F40 CTC5240		-F20 CTWN215		-27P H216T	
		-F40 DPX2245		-F50 DPX2245		-F40 HCF5240		-F20 CWK4615		-ALP CWK26	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN					
											
		XDKT		XDKT		XDKT		XDKT		XDHT	
		Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£
11T302FR	0.2							50 478 502	12.05	50 477 502	18.16
11T304ER	0.4	51 113 454	12.34			50 463 504	12.34				
11T304FR	0.4							50 478 504	12.05	50 477 504	18.16
11T308ER	0.8	51 113 458	12.34			50 463 500	12.34				
11T308FR	0.8							50 478 508	12.05	50 477 508	18.16
11T308SR	0.8			51 034 458	12.34						
11T312ER	1.2	51 113 462	12.34			50 463 512	12.34				
11T312FR	1.2									50 477 512	18.16
11T316ER	1.6	51 113 466	12.34			50 463 516	12.34				
11T316FR	1.6									50 477 516	18.16
11T320ER	2.0	51 113 470 [1]	12.34								
11T320FR	2.0							50 478 520 [1]	12.05	50 477 520 [1]	18.16
11T325ER	2.5	51 113 475 [1]	12.34			50 463 525 [1]	12.34				
11T325FR	2.5							50 478 525 [1]	12.05	50 477 525 [1]	18.16
11T332ER	3.2	51 113 482 [1]	12.34			50 463 532 [1]	12.34				
11T332FR	3.2									50 477 532 [1]	18.16
11T340ER	4.0	51 113 490 [1]	12.34			50 463 540 [1]	12.34				
11T340FR	4.0									50 477 540 [1]	18.16
11T350FR	5.0									50 477 550 [1]	18.16
Steel		●		●							
Stainless steel		●		●							
Cast iron								○		○	
Non ferrous metals								●		●	
Heat resistant alloys						●					

1) Insert radius >1.6 mm: Modify cutter body

XDKT

CERATIZIT \ Performance

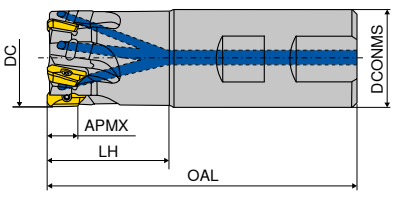
ISO	RE	-M50 CTCP220		-M50 CTPP225		-M50 CTCP230		-M50 CTPP235		-M50 CTPM225		-M50 CTCM235		-M50 CTPM240		-M50 CTCK215		-M50 CTPK220	
		-M50 DCX1220		-M50 DPX1225		-M50 DCX1230		-M50 DPX1235		-M50 DPX2225		-M50 DCX2235		-M50 DPX2240		-M50 DCX3215		-M50 DPX3220	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
																	
		XDKT		XDKT		XDKT		XDKT		XDKT		XDKT		XDKT		XDKT		XDKT	
		Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£
11T304SR	0.4					51 037 004	9.59	51 037 104	9.59					51 037 404	9.59	51 037 504	9.59		
11T308SR	0.8	51 037 258	9.59	51 037 058	9.59	51 037 008	9.59	51 037 108	9.59	51 037 208	9.59	51 037 308	9.59	51 037 408	9.59	51 037 508	9.59	51 037 608	9.59
11T312SR	1.2					51 037 012	9.59							51 037 412	9.59				
11T320SR	2.0					51 037 020 [1]	9.59	51 037 120 [1]	9.59					51 037 420 [1]	9.59				
11T325SR	2.5					51 037 025 [1]	9.59	51 037 125 [1]	9.59										
11T332SR	3.2													51 037 432 [1]	9.59				
Steel		●		●		●		●		○		○		○		○		○	
Stainless steel						○		○		●		●		●					
Cast iron																●		●	
Non ferrous metals																			
Heat resistant alloys																			

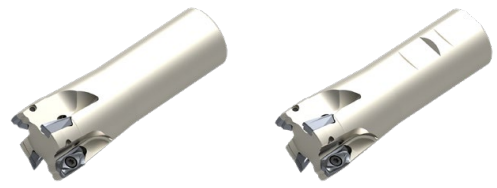
1) Insert radius >1.6 mm: Modify cutter body

MaxiMill – End milling cutter C 211-15

▲ Insert radius >2,5 mm: Modify cutter body

CERATIZIT \ Performance



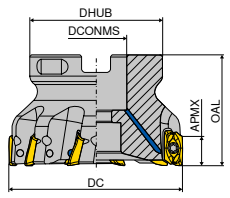


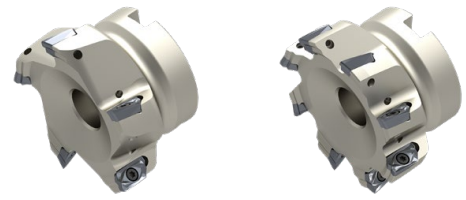
ISO designation	DC	OAL	LH	DCONMS	APMX	RPMX	Insert	ZNF	A Article no.	A £	B Article no.	B £
	mm	mm	mm	mm	mm	1/min.						
C211.25.R.02-15-B20-32	25	83	32	20	14	26560	XD.T 1505	2			50 747 125	120.32
C211.25.R.02-15-A-32	25	90	32	25	14	26560	XD.T 1505	2	50 747 225	120.32		
C211.25.R.02-15-B-32	25	90	32	25	14	26560	XD.T 1505	2			50 747 025	120.32
C211.25.R.02-15-A-50-225	25	225	50	25	14	7520	XD.T 1505	2	50 747 325	112.14		
C211.32.R.03-15-B25-40	32	96	40	25	14	22160	XD.T 1505	3			50 747 132	133.96
C211.32.R.03-15-A-40	32	103	40	32	14	24160	XD.T 1505	3	50 747 232	133.96		
C211.32.R.03-15-B-40	32	103	40	32	14	24160	XD.T 1505	3			50 747 032	133.96
C211.32.R.03-15-A-63-250	32	250	63	32	14	6800	XD.T 1505	3	50 747 332	125.82		
C211.40.R.04-15-A-50	40	110	50	32	14	22160	XD.T 1505	4	50 747 240	147.73		
C211.40.R.04-15-B32-50	40	110	50	32	14	22160	XD.T 1505	4			50 747 040	147.73
C211.40.R.03-15-A-50-275	40	275	50	32	14	6120	XD.T 1505	3	50 747 340	139.41		

MaxiMill – Shell mill A 211-15

▲ Insert radius >2,5 mm: Modify cutter body

CERATIZIT \ Performance



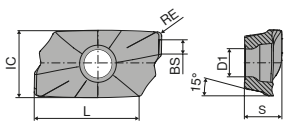


ISO designation	DC	OAL	DCONMS H6	DHUB	APMX	RPMX	Insert	ZNF	Article no.	£	Article no.	£
	mm	mm	mm	mm	mm	1/min.						
A211.40.R.03-15	40	40	16	38	14	22160	XD.T 1505	3	50 748 040	131.28		
A211.40.R.04-15	40	40	16	38	14	22160	XD.T 1505	4			50 749 040	147.73
A211.50.R.03-15	50	40	22	43	14	20320	XD.T 1505	3	50 748 050	155.87		
A211.50.R.05-15	50	40	22	43	14	20320	XD.T 1505	5			50 749 050	172.28
A211.63.R.04-15	63	45	22	48	14	18640	XD.T 1505	4	50 748 063	188.64		
A211.63.R.06-15	63	45	22	48	14	18640	XD.T 1505	6			50 749 063	205.23
A211.80.R.05-15	80	50	27	58	14	17040	XD.T 1505	5	50 748 080	213.28		
A211.80.R.08-15	80	50	27	58	14	17040	XD.T 1505	8			50 749 080	229.64
A211.100.R.06-15	100	50	32	78	14	15680	XD.T 1505	6	50 748 100	237.96		
A211.100.R.10-15	100	50	32	78	14	15680	XD.T 1505	10			50 749 100	254.32
A211.125.R.07-15	125	63	40	88	14	14320	XD.T 1505	7	50 748 125	251.55		
A211.125.R.11-15	125	63	40	88	14	14320	XD.T 1505	11			50 749 125	267.96
A211.160.R.08-15	160	63	40	93	14	13200	XD.T 1505	8	50 748 160	352.41		
A211.160.R.12-15	160	63	40	93	14	13200	XD.T 1505	12			50 749 160	368.82

Spare parts DC	Clamping key - T Article no. £		Key D Article no. £		Power Screw Article no. £		Clamping screw Article no. £	
40	2.63	80 397 040	8.67	80 950 128	9.65	70 950 151	2.46	70 950 839
50	3.35	80 397 050	8.67	80 950 128	13.24	70 950 154	2.46	70 950 839
63 - 160			8.67	80 950 128			2.46	70 950 839

XDKT

Designation	IC	D1	L	BS	S
	mm	mm	mm	mm	mm
XDKT 150508..	9.3	4.4	14.8	1.6	5.56
XDKT 150532..	9.3	4.4	14.8	1.9	5.56
XDKT 150540..	9.3	4.4	14.8	1.2	5.56



XDKT

XDKT

CERATIZIT \ Performance

ISO	RE	-F40 CTPM245 / -F40 DPX2245 DRAGONSKIN XDKT Article no.	£	-F40 CTC5240 / -F40 HCF5240 DRAGONSKIN XDKT Article no.	£	-F20 CTWN215 / -F20 CWK4615 XDKT Article no.	£
	mm						
150508ER	0.8	51 114 458	15.39	50 473 508	15.39	50 479 508	15.11
150508FR	0.8						
150532ER	3.2	51 114 482 [2]	15.39	50 473 532 [1]	15.39		
150540ER	4.0	51 114 490 [2]	15.39	50 473 540 [1]	15.39		
Steel		●					
Stainless steel		●					
Cast iron						○	
Non ferrous metals						●	
Heat resistant alloys				●			

1) Insert radius >2.5 mm: Modify cutter body
2) Insert radius >1.6 mm: Modify cutter body

Technical support: 0800 073 2 075
3 time served engineers, available from 8:00 am to 6:30 pm, Monday to Friday

Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

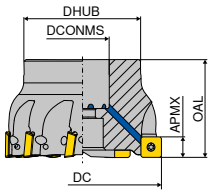
XDKT

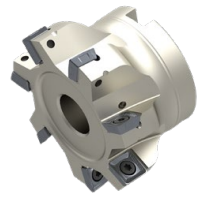
CERATIZIT \ Performance

ISO	RE mm	-M50 CTCP220 / -M50 DCX1220 / DRAGONSKIN / XDKT		-M50 CTPP225 / -M50 DPX1225 / DRAGONSKIN / XDKT		-M50 CTCP230 / -M50 DCX1230 / DRAGONSKIN / XDKT		-M50 CTPP235 / -M50 DPX1235 / DRAGONSKIN / XDKT		-M50 CTPM225 / -M50 DPX2225 / DRAGONSKIN / XDKT		-M50 CTCM235 / -M50 DCX2235 / DRAGONSKIN / XDKT		-M50 CTPM240 / -M50 DPX2240 / DRAGONSKIN / XDKT		-M50 CTCK215 / -M50 DCX3215 / DRAGONSKIN / XDKT		-M50 CTPK220 / -M50 DPX3220 / DRAGONSKIN / XDKT	
		Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£
150508SR	0.8	51 038 258	12.79	51 038 058	12.79	51 038 008	12.79	51 038 108	12.79	51 038 208	12.79	51 038 308	12.79	51 038 408	12.79	51 038 508	12.79	51 038 608	12.79
150512SR	1.2					51 038 012	12.79	51 038 112	12.79					51 038 412	12.79				
150516SR	1.6					51 038 016	12.79	51 038 116	12.79					51 038 416	12.79				
150520SR	2.0							51 038 120	12.79										
150530SR	3.0					51 038 030	12.79	51 038 130	12.79					51 038 430	12.79				
150540SR	4.0					51 038 040	12.79	51 038 140	12.79					51 038 440	12.79				
Steel		●		●		●		●		○		○		○		○		○	
Stainless steel						○		○		●		●		●					
Cast iron																●		●	
Non ferrous metals																			
Heat resistant alloys																			

MaxiMill – Shell mill A 490-12

CERATIZIT \ Performance



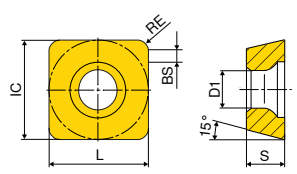


ISO designation	DC mm	DHUB mm	DCONMS mm	OAL mm	APMX mm	Insert	ZNF	Article no.	£
A490.50.R.05-12	50	43	22	40	11	SD.. 1205..	5	50 703 550	177.23
A490.63.R.06-12	63	48	22	40	11	SD.. 1205..	6	50 703 563	194.96
A490.80.R.07-12	80	58	27	50	11	SD.. 1205..	7	50 703 580	269.23
A490.100.R.08-12	100	75	32	50	11	SD.. 1205..	8	50 703 600	295.73
A490.125.R.10-12	125	88	40	63	11	SD.. 1205..	10	50 703 625	316.96

Spare parts DC		Key D			Power Screw			Clamping screw		
		Article no.	£		Article no.	£		Article no.	£	
50 - 125	T20		7.21	80 950 114	M8x30	9.65	70 950 151	M4,5x10,5	1.60	70 950 280

SDMT / SDHT

Designation	IC mm	D1 mm	L mm	BS mm	S mm
SDHT 120508F..	12.7	5.5	12.7	2.2	5.00
SDHT 120512S..	12.7	5.5	12.7	1.8	5.00
SDMT 120508E..	12.7	5.5	12.7	3.0	5.00
SDMT 1205ZZS..	12.7	5.5	12.7	0.9	5.00



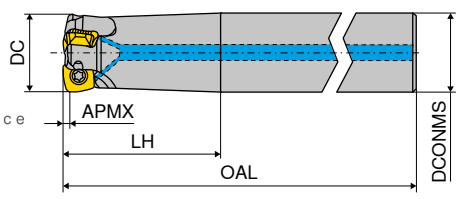
SDMT / SDHT

CERATIZIT \ Performance

ISO	RE mm	-29 CTCP230 / -29 DCX1230 / DRAGONSKIN / SDMT		-29 CTPP235 / -29 DPX1235 / DRAGONSKIN / SDMT		-31 CTCK215 / -31 DCX3215 / DRAGONSKIN / SDMT		-33 CTPM240 / -33 DPX2240 / DRAGONSKIN / SDHT		-F50 CTPM245 / -F50 DPX2245 / DRAGONSKIN / SDMT		-M31 CTC5240 / -M31 HCF5240 / DRAGONSKIN / SDMT		-27P H216T / -ALP CWK26 / SDHT	
		Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£
120508ER	0.8									51 110 458	12.56	50 580 508	12.56		
120508FR	0.8													50 426 555	12.46
120512SR	1.2							51 028 412	12.46						
1205ZZSN	0.8	51 081 020	10.75	51 081 120	10.75	51 059 521	10.40								
Steel		●		●		○		○		●					
Stainless steel		○		○				●		●					
Cast iron						●								○	
Non ferrous metals														●	
Heat resistant alloys												●			

MaxiMill – End milling cutter C HFC

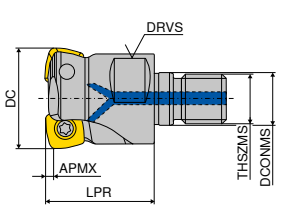
CERATIZIT \ Performance



ISO designation	DC	OAL	LH	DCONMS h6	APMX	RPMX	Insert	ZNF	Article no.	£
	mm	mm	mm	mm	mm	1/min.				
CHFC.25.R.02-09-A-50-225	25	225	50	25	1	9000	XDLX 09T3..	2	50 681 025	63.00
CHFC.25.R.03-09-A-50-225	25	225	50	25	1	9000	XDLX 09T3..	3	50 681 125	67.00
CHFC.32.R.03-09-A-63-250	32	250	63	32	1	8100	XDLX 09T3..	3	50 681 032	70.00
CHFC.32.R.02-12-A-63-250	32	250	63	32	2	6480	XOLX 1204..	2	50 681 132	66.00
CHFC.35.R.03-12-A-63-250	35	250	63	32	2	6480	XOLX 1204..	3	50 681 035	70.00

MaxiMill – Screw in cutter G HFC

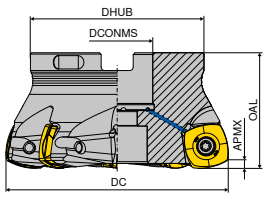
CERATIZIT \ Performance



ISO designation	DC	LPR	DCONMS	THSZMS	DRVS	APMX	RPMX	Insert	ZNF	Article no.	£
	mm	mm	mm		mm	mm	1/min.				
GHFC.25.R.02-09	25	35	12.5	M12	17	1	30000	XDLX 09T3..	2	50 682 025	63.00
GHFC.25.R.03-09	25	35	12.5	M12	17	1	30000	XDLX 09T3..	3	50 682 125	67.00
GHFC.32.R.03-09	32	35	17.0	M16	24	1	27000	XDLX 09T3..	3	50 682 032	70.00
GHFC.32.R.02-12	32	35	17.0	M16	24	2	21600	XOLX 1204..	2	50 682 132	66.00
GHFC.35.R.03-12	35	35	17.0	M16	24	2	21360	XOLX 1204..	3	50 682 035	70.00

MaxiMill – Shell mill A HFC

CERATIZIT \ Performance



ISO designation	DC	OAL	DCONMS H6	DHUB	APMX	RPMX	Insert	ZNF	Article no.	£	Article no.	£
	mm	mm	mm	mm	mm	1/min.						
AHFC.32.R.03-09	32	40	16	38	1.0	27700	XDLX 09T3..	3	50 683 032	70.00		
AHFC.35.R.04-09	35	40	16	38	1.0	26700	XDLX 09T3..	4	50 683 035	75.00		
AHFC.40.R.04-09	40	40	16	38	1.0	26400	XDLX 09T3..	4	50 683 140	78.00		
AHFC.42.R.05-09	42	40	16	38	1.0	26100	XDLX 09T3..	5	50 683 142	83.00		
AHFC.50.R.05-09	50	40	22	43	1.0	23500	XDLX 09T3..	5	50 683 150	92.00		
AHFC.52.R.06-09	52	40	22	43	1.0	23000	XDLX 09T3..	6	50 683 152	96.00		
AHFC.63.R.06-09	63	40	22	48	1.0	20500	XDLX 09T3..	6	50 683 163	106.00		
AHFC.40.R.03-12	40	40	16	38	2.0	21120	XOLX 1204..	3	50 683 040	73.00		
AHFC.42.R.04-12	42	40	16	38	2.0	20880	XOLX 1204..	4	50 683 042	78.00		
AHFC.50.R.04-12	50	40	22	43	2.0	18800	XOLX 1204..	4	50 683 050	87.00		
AHFC.52.R.05-12	52	40	22	43	2.0	18400	XOLX 1204..	5	50 683 052	92.00		
AHFC.63.R.05-12	63	40	22	48	2.0	16400	XOLX 1204..	5	50 683 063	101.00		
AHFC.66.R.06-12	66	40	22	48	2.0	16000	XOLX 1204..	6	50 683 066	106.00		
AHFC.80.R.07-12	80	50	27	58	2.0	14000	XOLX 1204..	7	50 683 080	119.00		
AHFC.100.R.08-12	100	50	32	78	2.0	12000	XOLX 1204..	8	50 683 100	133.00		
AHFC.63.R.05-19	63	40	22	48	3.3	5500	XOLX 1906..	5			50 683 263	106.00
AHFC.80.R.06-19	80	50	27	58	3.3	4700	XOLX 1906..	6			50 683 280	128.00
AHFC.100.R.08-19	100	52	32	78	3.3	4100	XOLX 1906..	8			50 683 300	153.00
AHFC.125.R.10-19	125	63	40	88	3.3	3600	XOLX 1906..	10			50 683 325	192.00
AHFC.160.R.11-19	160	63	40	98	3.3	3100	XOLX 1906..	11			50 683 360 [1]	232.00

1) With threaded holes M12 on the front face, pitch circle diameter = 66.7 mm

Key D

Power Screw

Clamping screw

Spare parts		Key D Article no. £		Power Screw	Article no. £		Clamping screw	Article no. £	
XDLX 09T3..	T15	6.74	80 950 113				M3,5x7,2	2.42	70 950 110
XDLX 09T3.. (Ø32 – Ø42)	T15	6.74	80 950 113	M8x30	9.65	70 950 151	M3,5x7,2	2.42	70 950 110
XOLX 1204..	T20	7.21	80 950 114				M4,5x10,5	1.60	70 950 280
XOLX 1204.. (Ø40 – Ø42)	T20	7.21	80 950 114	M8x30	9.65	70 950 151	M4,5x10,5	1.60	70 950 280
XOLX 1906..	T20	7.21	80 950 114				M5x14	3.16	70 950 302

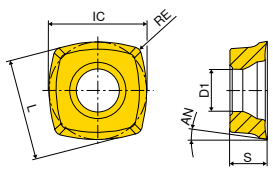
Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

XDLX / XOLX

Designation	IC	D1	L	AN	S
	mm	mm	mm	°	mm
XDLX 09T308..	9.52	4.4	9	15	3.97
XOLX 120410..	12.70	5.5	12	10	4.76



XDLX

CERATIZIT \ Performance

ISO	RE	-M50 CTCP220		-M50 CTPP225		-M50 CTCP230		-M50 CTPP235	
		-M50 DCX1220		-M50 DPX1225		-M50 DCX1230		-M50 DPX1235	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
									
		XDLX		XDLX		XDLX		XDLX	
	mm	Article no.	£	Article no.	£	Article no.	£	Article no.	£
09T308SR	0.8	51 016 258	8.67	51 016 058	8.67	51 016 008	8.67	51 016 108	8.67
Steel		●		●		●		●	
Stainless steel						○		○	
Cast iron									
Non ferrous metals									
Heat resistant alloys									

XDLX

CERATIZIT \ Performance

ISO	RE	-F40 CTPM245		-M50 CTPM225		-M50 CTCM235		-M50 CTPM240		-M50 CTPM245		-M50 CTCK215		-F40 CTC5240	
		-F40 DPX2245		-M50 DPX2225		-M50 DCX2235		-M50 DPX2240		-M50 DPX2245		-M50 DCX3215		-F40 HCF5240	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
		XDLX		XDLX		XDLX		XDLX		XDLX		XDLX		XDLX	
	mm	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£
09T308ER	0.8	51 115 458	10.47											50 503 558	10.47
09T308SR	0.8			51 016 208	8.67	51 016 308	8.67	51 016 408	8.67	51 016 458	10.47	51 016 508	8.67		
Steel		●		○		○		○		●		○			
Stainless steel		●		●		●		●		●					
Cast iron												●			
Non ferrous metals															
Heat resistant alloys														●	

XOLX

CERATIZIT \ Performance

ISO	RE	-M50 CTCP220		-M50 CTPP225		-M50 CTCP230		-M50 CTPP235		-R50 CTPP235	
		-M50 DCX1220		-M50 DPX1225		-M50 DCX1230		-M50 DPX1235		-R50 DPX1235	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
											
		XOLX		XOLX		XOLX		XOLX		XOLX	
	mm	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£
120410SR	1.0	51 017 260	10.40	51 017 060	10.40	51 017 010	10.40	51 017 110	10.40	51 018 110	10.40
Steel				●		●		●		●	
Stainless steel						○		○		○	
Cast iron											
Non ferrous metals											
Heat resistant alloys											

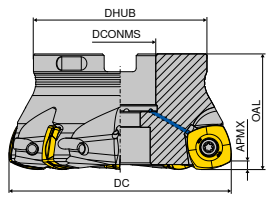
XOLX

CERATIZIT \ Performance

ISO	RE	-F40 CTPM245		-M50 CTPM225		-M50 CTCM235		-M50 CTPM240		-M50 CTPM245		-M50 CTCK215		-F40 CTC5240	
		-F40 DPX2245		-M50 DPX2225		-M50 DCX2235		-M50 DPX2240		-M50 DPX2245		-M50 DCX3215		-F40 HCF5240	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
		XOLX		XOLX		XOLX		XOLX		XOLX		XOLX		XOLX	
	mm	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£
120410ER	1.0	51 022 460	12.25											50 504 558	12.25
120410SR	1.0			51 017 210	10.40	51 017 310	10.40	51 017 410	10.40	51 017 460	12.25	51 017 510	10.40		
Steel		●		○		○		○		●		○			
Stainless steel		●		●		●		●		●					
Cast iron												●			
Non ferrous metals															
Heat resistant alloys														●	

MaxiMill – Shell mill A HFC

CERATIZIT \ Performance



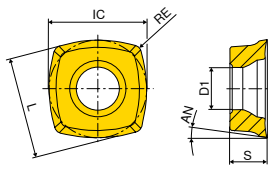
ISO designation	DC	OAL	DCONMS H6	DHUB	APMX	RPMX	Insert	ZNF	Article no.	£
	mm	mm	mm	mm	mm	1/min.				
AHFC.63.R.05-19	63	40	22	48	3.3	5500	XOLX 1906..	5	50 683 263	106.00
AHFC.80.R.06-19	80	50	27	58	3.3	4700	XOLX 1906..	6	50 683 280	128.00
AHFC.100.R.08-19	100	52	32	78	3.3	4100	XOLX 1906..	8	50 683 300	153.00
AHFC.125.R.10-19	125	63	40	88	3.3	3600	XOLX 1906..	10	50 683 325	192.00
AHFC.160.R.11-19	160	63	40	98	3.3	3100	XOLX 1906..	11	50 683 360 [1]	232.00

1) With threaded holes M12 on the front face, pitch circle diameter = 66.7 mm

Spare parts	TORX® blade		Key D		Clamping screw	
	Article no.		Article no.		Article no.	
Insert	£		£		£	
XOLX 1906..	3.68	80 950 037	7.21	80 950 114	3.16	70 950 302

XOLX

Designation	IC	D1	L	S	AN
	mm	mm	mm	mm	°
XOLX 1906..	19.14	6	19	6.35	10



XOLX

CERATIZIT \ Performance

ISO	RE	-F40 CTPM245 / -F40 DPX2245 DRAGONSKIN XOLX		-F40 CTC5240 / -F40 HCF5240 DRAGONSKIN XOLX	
	mm	Article no.	£	Article no.	£
190615ER	1.5	51 022 465	18.59	50 504 515	18.59
Steel		●			
Stainless steel		●			
Cast iron					
Non ferrous metals					
Heat resistant alloys				●	

XOLX

CERATIZIT \ Performance

ISO	RE	-M50 CTCP230 / -M50 DCX1230 DRAGONSKIN XOLX		-M50 CTPP235 / -M50 DPX1235 DRAGONSKIN XOLX		-M50 CTPM240 / -M50 DPX2240 DRAGONSKIN XOLX		-M50 CTCK215 / -M50 DCX3215 DRAGONSKIN XOLX	
	mm	Article no.	£	Article no.	£	Article no.	£	Article no.	£
190615SR	1.5	51 017 015	15.11	51 017 115	15.11	51 017 415	15.11	51 017 515	15.11
Steel		●		●		○		○	
Stainless steel		○		○		●			
Cast iron								●	
Non ferrous metals									
Heat resistant alloys									

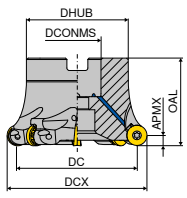
Speed Calculation

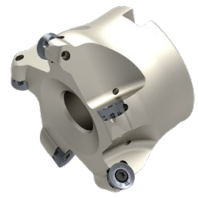
$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

MaxiMill – Shell mill A 251 RS

CERATIZIT \ Performance



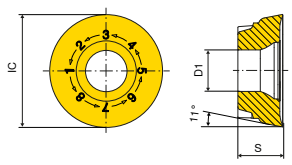


ISO designation	DCX	DC	OAL	APMX	DHUB	DCONMS H6	RPMX	Insert	ZNF	Article no.	£
	mm	mm	mm	mm	mm	mm	1/min.				
A251.40.R.03-10-RS	40	30	40	5	38	16	15900	RP.X 10T3..	3	50 686 240	143.46
A251.40.R.05-10-RS	40	30	40	5	38	16	16000	RP.X 10T3..	5	50 686 140	161.68
A251.42.R.06-10-RS	42	32	40	5	38	16	16000	RP.X 10T3..	6	50 686 142	185.82
A251.50.R.04-10-RS	50	40	40	5	43	22	12700	RP.X 10T3..	4	50 686 350	157.55
A251.50.R.06-10-RS	50	40	40	5	43	22	12500	RP.X 10T3..	6	50 686 150	192.28
A251.52.R.06-10-RS	52	42	40	5	43	22	12500	RP.X 10T3..	6	50 686 152	192.28
A251.40.R.04-12-RS	40	28	40	6	38	16	15900	RP.X 1204..	4	50 686 340	148.73
A251.50.R.04-12-RS	50	38	40	6	43	22	12700	RP.X 1204..	4	50 686 250	153.50
A251.50.R.05-12-RS	50	38	40	6	43	22	12500	RP.X 1204..	5	50 686 050	180.50
A251.63.R.06-12-RS	63	51	40	6	48	22	10000	RP.X 1204..	6	50 686 063	222.87
A251.80.R.05-12-RS	80	68	50	6	58	27	7950	RP.X 1204..	5	50 686 180	203.41
A251.80.R.07-12-RS	80	68	50	6	58	27	8000	RP.X 1204..	7	50 686 080	251.41
A251.100.R.06-12-RS	100	88	50	6	78	32	6350	RP.X 1204..	6	50 686 100	227.00
A251.100.R.10-12-RS	100	88	50	6	78	32	6350	RP.X 1204..	10	50 686 200	331.64

Spare parts		Clamping key - T		Key D		Power Screw		Clamping screw	
		Article no.		Article no.		Article no.		Article no.	
Insert			£		£		£		£
RP.X 10T3..	SW4	80 397 040	2.63	T10	80 950 112	M8x30	70 950 151	M3x7,3	70 950 840
RP.X 1204..	SW4	80 397 040	2.63	T15	80 950 113	M8x30	70 950 151	M3,5x8,6	70 950 304

RPHX

Designation	IC	D1	S
	mm	mm	mm
RPHX 10T3..	10	3.4	3.97
RPHX 1204..	12	4.4	4.76



RPHX

CERATIZIT \ Performance

ISO	-F50 CTPP235		-F50 CTPM225		-F50 CTCM235		-F50 CTPM240		-M30 CTPM225		-M30 CTCM235		-M30 CTPM240		-M50 CTPM240	
	-F50 DPX1235		-F50 DPX2225		-F50 DCX2235		-F50 DPX2240		-M30 DPX2225		-M30 DCX2235		-M30 DPX2240		-M50 DPX2240	
	DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
																
	RPHX		RPHX		RPHX		RPHX		RPHX		RPHX		RPHX		RPHX	
	Article no.		Article no.		Article no.		Article no.		Article no.		Article no.		Article no.		Article no.	
		£		£		£		£		£		£		£		£
1204M8EN									51 049 225	9.59	51 049 325	9.59	51 049 425	9.59		
1204M8SN	51 051 125	9.59	51 051 225	9.59	51 051 325	9.59	51 051 425	9.59							51 050 425	9.59
Steel	●		○		○		○		○		○		○		○	
Stainless steel	○		●		●		●		●		●		●		●	
Cast iron																
Non ferrous metals																
Heat resistant alloys																

RPHX

CERATIZIT \ Performance

ISO	-SN CTPM225		-F50 CTPM245		-M50 CTPM245		-SN CTCK215		-M31 CTC5240		-27P H216T	
	-SN DPX2225		-F50 DPX2245		-M50 DPX2245		-SN DCX3215		-M31 HCF5240		-ALP CWK26	
	DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN			
												
	RPHX		RPHX		RPHX		RPHX		RPHX		RPHX	
	Article no.		Article no.		Article no.		Article no.		Article no.		Article no.	
		£		£		£		£		£		£
10T3M4SN			51 051 470 [1]	11.04	51 050 470 [1]	11.04						
10T3M8EN									50 493 551	11.04		
10T3M8SN					51 050 471	11.04						
1204M4SN					51 050 475 [1]	12.17						
1204M6SN					51 050 476	12.17						
1204M8EN									50 493 582	12.17		
1204M8FN											50 483 602	11.07
1204M8SN	51 052 225	9.59	51 051 477	12.17	51 050 477	12.17	51 052 525	9.59				
Steel	○		●		●		○					
Stainless steel	●		●		●							
Cast iron							●				○	
Non ferrous metals											●	
Heat resistant alloys									●			

1) Insert with 4 indexes

New system size for more economy

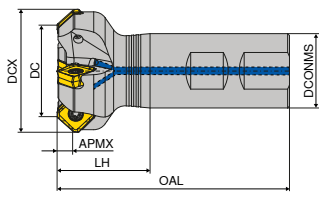
Efficiency, process security and flexibility. That's what MaxiMill 271 stands for. The extremely soft-cutting tool system can be used in a wide range of applications thanks to the fine and standard pitch holders, while the wiper insert also helps achieve first-class finishes. Furthermore, the system stands out thanks to the cutter's excellent wear behaviour and also impresses with optimal chip formation and removal.

Find more Information in the UP2DATE catalogue (September 2019)

Cutting Data	98+99	Chip Breakers Overview	99

MaxiMill – End milling cutter C 271-12

CERATIZIT \ Performance



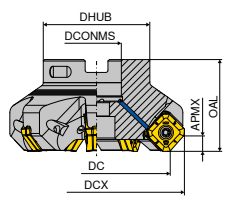
ISO designation	DC mm	DCX mm	ZNF	APMX mm	OAL mm	LH mm	DCONMS h6 mm	RPMX 1/min.	torque moment Nm	Insert	NEW Article no.	£
C271.32.R.03-12-B-40	32	45	3	6.8	100	40	32	18400	3,2	SOHU 1204.. / XOHU 1204..	50 786 03203	251.98
C271.40.R.04-12-B32-40	40	53	4	6.8	100	40	32	16800	3,2	SOHU 1204.. / XOHU 1204..	50 786 04004	314.97

Spare parts DC	Clamping screw Article no. £		Torque screwdriver Article no. £	
32 - 40	2.42	70 950 859	67.73	80 021 032

MaxiMill – A 271-12 Face mill

▲ 8 cutting edges per insert

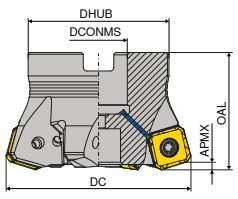
CERATIZIT \ Performance

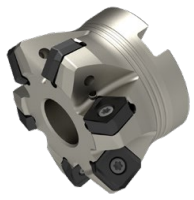


ISO designation	DC mm	DCX mm	ZNF	APMX mm	OAL mm	DHUB mm	DCONMS H6 mm	RPMX 1/min.	torque moment Nm	Insert	NEW Article no.	£	NEW Article no.	£
A271.40.R.04-12	40	53	4	6.8	40	38	16	17900	3,2	SOHU 1204.. / XOHU 1204..	50 787 04004	314.97		
A271.50.R.05-12	50	63	5	6.8	40	43	22	15200	3,2	SOHU 1204.. / XOHU 1204..	50 787 05005	322.85		
A271.63.R.07-12	63	76	7	6.8	40	48	22	13100	3,2	SOHU 1204.. / XOHU 1204..	50 787 06307	409.47		
A271.80.R.06-12	80	93	6	6.8	50	58	27	11300	3,2	SOHU 1204.. / XOHU 1204..			50 787 08006	409.47
A271.80.R.08-12	80	93	8	6.8	50	58	27	11300	3,2	SOHU 1204.. / XOHU 1204..	50 787 08008	472.45		
A271.100.R.07-12	100	113	7	6.8	63	78	32	9900	3,2	SOHU 1204.. / XOHU 1204..			50 787 10007	519.66
A271.100.R.10-12	100	113	10	6.8	63	78	32	9900	3,2	SOHU 1204.. / XOHU 1204..	50 787 10010	590.60		
A271.125.R.08-12	125	138	8	6.8	63	88	40	8700	3,2	SOHU 1204.. / XOHU 1204..			50 787 12508	629.93
A271.125.R.12-12	125	138	12	6.8	63	88	40	8700	3,2	SOHU 1204.. / XOHU 1204..	50 787 12512	724.43		
A271.160.R.09-12	160	173	9	6.8	63	98	40	7600	3,2	SOHU 1204.. / XOHU 1204..			50 787 16009	732.32
A271.160.R.14-12	160	173	14	6.8	63	98	40	7600	3,2	SOHU 1204.. / XOHU 1204..	50 787 16014	850.77		
A271.200.R.11-12	200	213	11	6.8	63	132	60	6700	3,2	SOHU 1204.. / XOHU 1204..			50 787 20011	918.00
A271.200.R.17-12	200	213	17	6.8	63	132	60	6700	3,2	SOHU 1204.. / XOHU 1204..	50 787 20017	1,037.77		
A271.250.R.13-12	250	263	13	6.8	63	132	60	6000	3,2	SOHU 1204.. / XOHU 1204..			50 787 25013	1,105.00
A271.250.R.21-12	250	263	21	6.8	63	132	60	6000	3,2	SOHU 1204.. / XOHU 1204..	50 787 25021	1,298.18		

MaxiMill – A 271-12 HFC Face mill

CERATIZIT \ Performance





ISO designation	DC mm	ZNF	APMX mm	OAL mm	DHUB mm	DCONMS H6 mm	RPMX 1/min.	torque moment Nm	Insert	NEW Article no.	£
A271.50.R.04-12-HFC	50	4	2.6	40	43	22	14600	3,2	SOHU 1204..	50 788 05004	322.85
A271.63.R.06-12-HFC	63	6	2.6	40	48	22	12500	3,2	SOHU 1204..	50 788 06306	409.47
A271.80.R.07-12-HFC	80	7	2.6	50	58	27	10800	3,2	SOHU 1204..	50 788 08007	472.45

Spare parts	Clamping key - T Article no. £		Power Screw Article no. £		Clamping screw Article no. £		Torque screwdriver Article no. £	
40 (5078704004)	2.63	80 397 040	9.65	70 950 151	2.42	70 950 859	67.73	80 021 032
50 - 250					2.42	70 950 859	67.73	80 021 032
50 (5078805004)	3.35	80 397 050	13.24	70 950 154	2.42	70 950 859	67.73	80 021 032

Technical support: 0800 073 2 075
3 time served engineers, available from 8:00 am to 6:30 pm, Monday to Friday

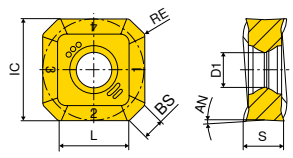
Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

SOHU

Designation	IC	D1	L	BS	S	AN
	mm	mm	mm	mm	mm	°
SOHU 1204..	13.36	4.4	8.8	1.7	5.00	7.4



SOHU

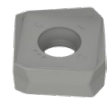
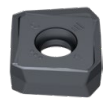
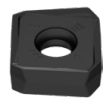
SOHU

CERATIZIT \ Performance

ISO	RE mm	-M50 CTPM240		-M50 CTPP235		-M50 CTCM235		-M50 CTCP230	
		 SOHU NEW Article no.	£	 SOHU NEW Article no.	£	 SOHU NEW Article no.	£	 SOHU NEW Article no.	£
1204ABSR	0.8	51 138 42000	17.58	51 138 12000	17.58	51 138 32000	17.58	51 138 02000	17.58
Steel		○		●		○		●	
Stainless steel		●		○		●		○	
Cast iron									
Non ferrous metals									
Heat resistant alloys									

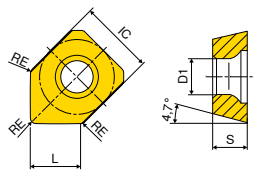
SOHU

CERATIZIT \ Performance

ISO	RE mm	-F50 CTC5240		-R50 CTPK220		-R50 CTCK215		-F50 CTPM245	
		 SOHU NEW Article no.	£	 SOHU NEW Article no.	£	 SOHU NEW Article no.	£	 SOHU NEW Article no.	£
1204ABSR	0.8	51 140 17000	24.50	51 139 62000	17.58	51 139 52000	17.58	51 140 47000	24.50
Steel				○		○		●	
Stainless steel								●	
Cast iron				●		●			
Non ferrous metals									
Heat resistant alloys		●							

XOHU

Designation	IC	D1	L	BS	S
	mm	mm	mm	mm	mm
XOHU 1204..	13.36	4.4	8.8	1.83	5.00



XOHU

XOHU

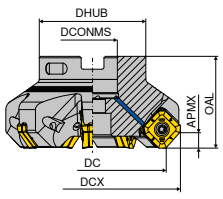
CERATIZIT \ Performance

ISO	RE mm	-M50 CTPP235
		 XOHU NEW Article no.
1204ABSR	0.8	51 141 12000 £ 21.76
Steel		●
Stainless steel		○
Cast iron		
Non ferrous metals		
Heat resistant alloys		

MaxiMill – A 271 Face mill

▲ 8 cutting edges per insert

CERATIZIT \ Performance

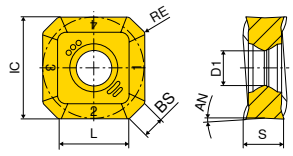


ISO designation	DC	OAL	APMX	DCX	DCONMS	DHUB	Insert	ZNF	Article no.	£
	mm	mm	mm	mm	mm	mm				
A271.50.R.04-17	50	40	8.4	66.1	22	43	SAKU 1706	4	50 767 050	180.78
A271.63.R.06-17	63	40	8.4	79.1	22	48	SAKU 1706	6	50 767 063	254.05
A271.80.R.07-17	80	50	8.4	96.1	27	58	SAKU 1706	7	50 767 080	290.68
A271.100.R.08-17	100	50	6.8	116.1	32	78	SAKU 1706	8	50 767 100	334.68
A271.125.R.10-17	125	63	8.4	141.1	40	88	SAKU 1706	10	50 767 125	385.91

Spare parts DC	TORX® blade		Key D		 Clamping screw	
	Article no.	£	Article no.	£	Article no.	£
50 - 125	80 950 037	3.68	80 950 114	7.21	70 950 302	3.16

SAKU

Designation	IC	D1	L	BS	S	AN
	mm	mm	mm	mm	mm	°
SAKU 1706..	17	5.8	11.85	3.7	6.35	3



SAKU

SAKU

CERATIZIT \ Performance

ISO	RE	-F50 CTCP220		-F50 CTPP225		-F50 CTCP230		-F50 CTPP235	
		-F50 DCX1220		-F50 DPX1225		-F50 DCX1230		-F50 DPX1235	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		 SAKU		 SAKU		 SAKU		 SAKU	
	mm	Article no.	£	Article no.	£	Article no.	£	Article no.	£
1706ABSR	0.8	51 004 270	19.86	51 004 070	19.86	51 004 020	19.86	51 004 120	19.86
Steel		●		●		●		●	
Stainless steel						○		○	
Cast iron									
Non ferrous metals									
Heat resistant alloys									

More inserts can be found on → **Page 78.**

24

Stock around the clock!

Tool Supply 24/7

If you install a Tool-O-Mat it means that we take on all the procurement and stocking costs for you. You have 100 % availability of all tools at all times and without expenditure.

Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

SAKU

CERATIZIT \ Performance

ISO	RE mm	-F50 CTPM225 / -F50 DPX2225 / DRAGONSKIN / SAKU		-F50 CTCM235 / -F50 DCX2235 / DRAGONSKIN / SAKU		-F50 CTPM240 / -F50 DPX2240 / DRAGONSKIN / SAKU		-F50 CTPM245 / -F50 DPX2245 / DRAGONSKIN / SAKU		-F50 CTC5240 / -F50 HCF5240 / DRAGONSKIN / SAKU	
		Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£
1706ABSR	0.8	51 004 220	19.86	51 004 320	19.86	51 004 420	19.86	51 004 470	24.44	50 306 520	24.44
Steel		○		○		○		●			
Stainless steel		●		●		●		●			
Cast iron											
Non ferrous metals											
Heat resistant alloys										●	

SAKU

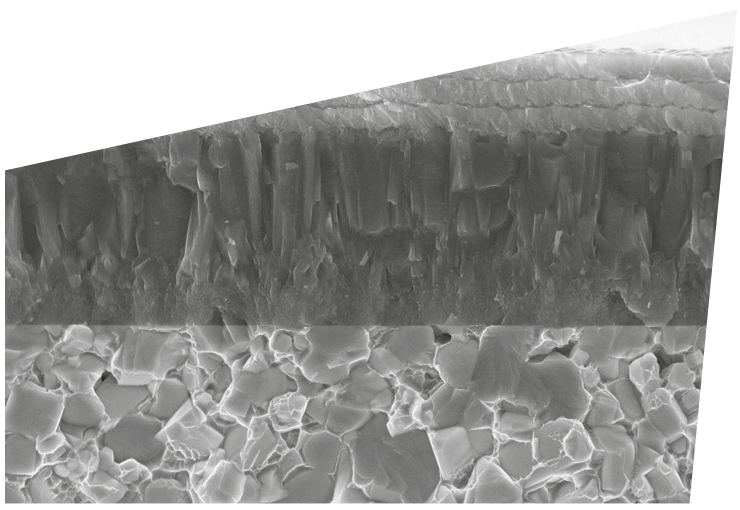
CERATIZIT \ Performance

ISO	RE mm	-M50 CTCP220 / -M50 DCX1220 / DRAGONSKIN / SAKU		-M50 CTPP225 / -M50 DPX1225 / DRAGONSKIN / SAKU		-M50 CTCP230 / -M50 DCX1230 / DRAGONSKIN / SAKU		-M50 CTPP235 / -M50 DPX1235 / DRAGONSKIN / SAKU	
		Article no.	£	Article no.	£	Article no.	£	Article no.	£
1706ABSR	0.8	51 005 270	19.86	51 005 070	19.86	51 005 020	19.86	51 005 120	19.86
Steel		●		●		●		●	
Stainless steel						○		○	
Cast iron									
Non ferrous metals									
Heat resistant alloys									

SAKU

CERATIZIT \ Performance

ISO	RE mm	-M50 CTPM225 / -M50 DPX2225 / DRAGONSKIN / SAKU		-M50 CTCM235 / -M50 DCX2235 / DRAGONSKIN / SAKU		-M50 CTPM240 / -M50 DPX2240 / DRAGONSKIN / SAKU		-M50 CTCK215 / -M50 DCX3215 / DRAGONSKIN / SAKU		-M50 CTPK220 / -M50 DPX3220 / DRAGONSKIN / SAKU		-R50 CTCK215 / -R50 DCX3215 / DRAGONSKIN / SAKU		-R50 CTPK220 / -R50 DPX3220 / DRAGONSKIN / SAKU	
		Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£
1706ABSR	0.8	51 005 220	19.86	51 005 320	19.86	51 005 420	19.86	51 005 520	19.86	51 005 620	19.86	51 058 520	19.86	51 058 620	19.86
Steel		○		○		○		○		○		○		○	
Stainless steel		●		●		●									
Cast iron								●		●		●		●	
Non ferrous metals															
Heat resistant alloys															



Dragonskin Coating

DRAGONSKIN

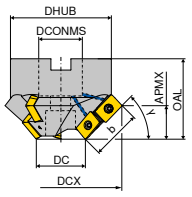
The coatings for the highest performance

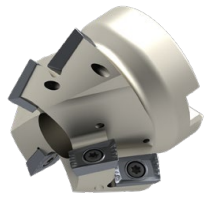
The product category Dragonskin is intended to help make tools easily recognizable and quick to find using CERATIZIT's high-performance coating technology. All products that are marked with the Dragonskin icon represent unmatchable performance, maximum tool life and maximum process reliability.

MaxiMill – Chamfer Cutter A 242

- ▲ Caution: Use only inserts with a corner radius of less than 1.6 mm
- ▲ ZEFP = number of inserts
- ▲ ZNP = tooth rows

CERATIZIT \ Performance





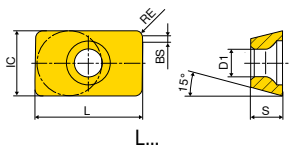
KAPR °	ZEFP	DCX ±0,3 mm	DC mm	b ±0,3 mm	OAL mm	APMX ±0,3 mm	DCONMS mm	DHUB mm	ZNP	Insert	ZNF	Article no.	£
15	6	92.2	35	29.6	50	7.6	27	62.5	2	LD.. 1504..	3	50 768 015	171.09
30	6	86.3	35	29.6	50	14.8	27	62.5	2	LD.. 1504..	3	50 768 030	171.09
45	6	76.9	35	29.6	50	20.9	27	62.5	2	LD.. 1504..	3	50 768 045	171.09
60	6	64.6	35	29.6	50	25.6	22	62.5	2	LD.. 1504..	3	50 768 060 1)	171.09
75	6	50.3	35	29.6	60	28.5	22	49.0	2	LD.. 1504..	3	50 768 075 1)	171.09

1) Version with Powerscrew

Spare parts KAPR	 Clamping key - T Article no. £		Key D Article no. £		 Power Screw Article no. £		 Clamping screw Article no. £		 clamping screw Article no. £	
15 - 45			6.74	80 950 113			2.42	70 950 304	3.88	83 950 125
60 - 75	3.35	80 397 050	6.74	80 950 113	13.24	70 950 154	2.42	70 950 304		

LDFT / LDFW

Designation	IC mm	D1 mm	L mm	BS mm	S mm
LDF. 1504PD..	9.52	4.4	15	1.2	4.76
LDFT 1504PD..	9.52	4.4	15	0.8	4.76



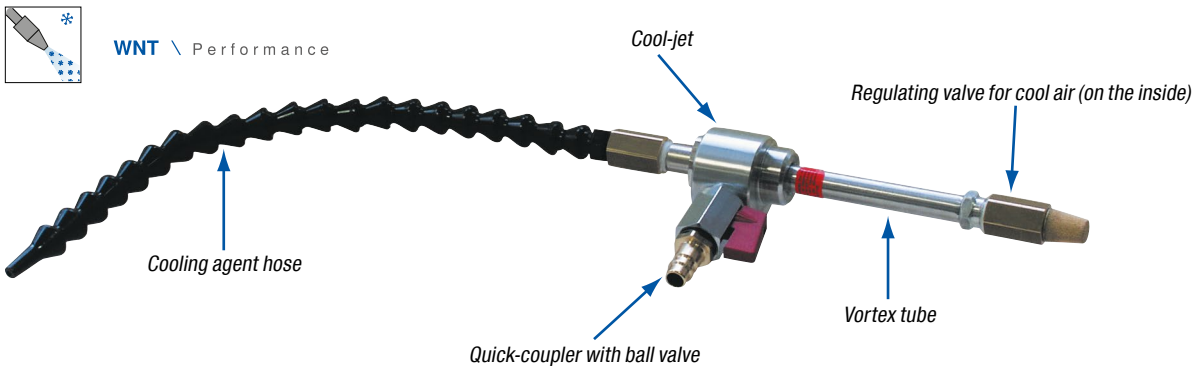
LDFT / LDFW

CERATIZIT \ Performance

ISO	-29 CTCP230 / -29 DCX1230 DRAGONSKIN  LDFT Article no.	£	-29 CTPP235 / -29 DPX1235 DRAGONSKIN  LDFT Article no.	£	-33 CTPM240 / -33 DPX2240 DRAGONSKIN  LDFT Article no.	£	CTCK215 / DCX3215 DRAGONSKIN  LDFW Article no.	£
1504PDSR	51 079 020	13.04	51 079 120	13.04	51 042 420	12.46	51 043 520	10.89
Steel	●		●		○		○	
Stainless steel	○		○		●			
Cast iron							●	
Non ferrous metals								
Heat resistant alloys								

Cool-jet

WNT \ Performance



Utilizable air temperature measured at the effective discharge of the vortex tube (not the nozzle end)

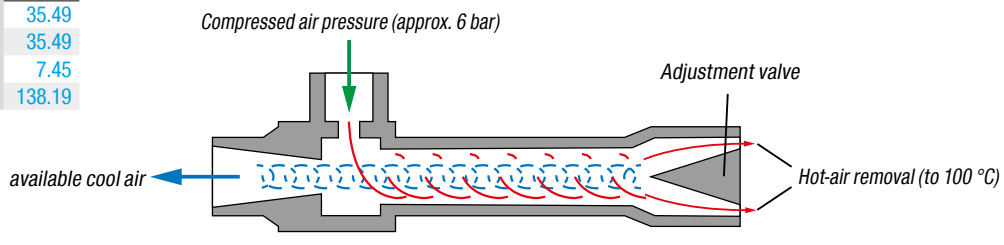
Entrance pressure				
	3 bar	–31 °C	up to	–6 °C
	4 bar	–35 °C	up to	–8 °C
	5 bar	–39 °C	up to	–10 °C
	6 bar	–42 °C	up to	–11 °C
	7 bar	–46 °C	up to	–13 °C

In order to operate the regulating valve, the silencer must be unscrewed – there is a burn danger! The valve of the hot air side can reach up to 100 °C: Before contact, allow cooling!

Air consumption at an inlet temperature of + 21 °C and an inlet pressure of 6.9 bar: 7,08 l / sec. (25.5 m³ / h)

Cool-jet	Article no.	£
3–7 bar air pressure, at -46 °C	81 900 100	662.85

Accessories	Article no.	£
Magnetic plate Ø 80 mm without clamping arm	81 900 101	35.49
Spare tube, length 300 mm	81 900 104	35.49
Jet silencer (air filter)	81 900 105	7.45
Complete set (with magnetic set and clamping arm), weight 0,4 kg	81 900 107	138.19



Speed Calculation $RPM = \frac{v_c \times 1000}{\pi \times D}$ v_c = (See Individual v_c Charts) π = 3.142 D = Diameter

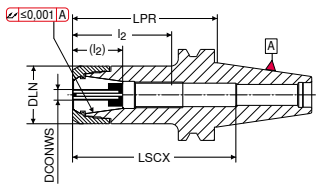
ER Precision Collet chuck

- for standard or sealed nuts
- maximum size collet to ISO tolerance field H10
- for clamping a roll key is required
- p_{max} = 80 bar

Scope of supply:

Holder **without** nut, **without** backstop

Centro-P WNT \ Performance



AD
G 2,5 n_{max} 25000

Adapter	DCONWS mm	LPR mm	DLN mm	LSCX mm	l_2 (l_2) mm	for collet	Article no.	£
BT 40	1 - 10	75	30	90	38 - 53 (29 - 39)	426E (ER16)	84 524 210	76.80
BT 40	1 - 10	90	30	120	30 - 50 (29 - 36)	426E (ER16)	84 524 310	91.01
BT 40	1 - 10	120	30	140	29 - 45 (29 - 35)	426E (ER16)	84 524 410	123.92
BT 40	1 - 10	150	30	180	29 - 45 (29 - 32)	426E (ER16)	84 524 510	133.60
BT 40	2 - 16	60	40	92	44 - 64 (36 - 46)	430E (ER25)	84 524 116	87.14
BT 40	2 - 16	75	40	100	42 - 59 (36 - 41)	430E (ER25)	84 524 216	76.80
BT 40	2 - 16	90	40	91	42 - 59 (36 - 41)	430E (ER25)	84 524 316	91.01
BT 40	2 - 16	120	40	91	40 - 65 (36 - 47)	430E (ER25)	84 524 416	133.60
BT 40	2 - 16	150	40	100	40 - 64 (36 - 45)	430E (ER25)	84 524 516	143.28
BT 40	2 - 16	200	40	150	40 - 64 (36 - 45)	430E (ER25)	84 524 616	164.58
BT 40	2 - 20	60	50	55	45 - 64 (42 - 46)	470E (ER32)	84 524 120	87.14
BT 40	2 - 20	75	50	100	42 - 76 (42 - 52)	470E (ER32)	84 524 220	76.80
BT 40	2 - 20	90	50	100	42 - 76 (42 - 52)	470E (ER32)	84 524 320	91.01
BT 40	2 - 20	120	50	110	42 - 71 (42 - 53)	470E (ER32)	84 524 420	133.60
BT 40	2 - 20	150	50	110	42 - 71 (42 - 53)	470E (ER32)	84 524 520	143.28

LSCX = clamping depth without back stop screw for shanks
l_2 = with back stop screw 1, dimension in brackets ( ) = with back stop screw 2
dimension LPR when using tightening nuts with seals 4 mm longer

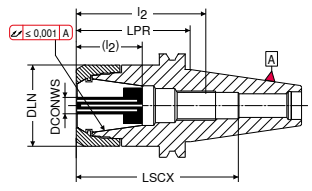
ER Precision Collet chuck

- for standard or sealed nuts
- maximum size collet to ISO tolerance field H10
- for clamping a roll key is required
- p_{max} = 80 bar

Scope of supply:

Holder **without** nut, **without** backstop

Centro-P WNT \ Performance



AD/B
G 2,5 n_{max} 25000

Adapter	DCONWS mm	LPR mm	DLN mm	LSCX mm	l_2 (l_2) mm	for collet	Article no.	£
SK 40	1 - 10	130	30	140	28 - 50 (14 - 34)	426E (ER16)	84 414 510	125.87
SK 40	1 - 10	160	30	200	28 - 45 (16 - 31)	426E (ER16)	84 414 910	138.92
SK 40	2 - 16	45	40	85	35 - 60 (20 - 42)	430E (ER25)	84 414 816	114.31
SK 40	2 - 16	130	40	140	38 - 67 (21 - 49)	430E (ER25)	84 414 516	136.80
SK 40	2 - 16	160	40	118	35 - 60 (20 - 42)	430E (ER25)	84 414 916	144.12
SK 40	2 - 20	130	50	114	50 - 74 (36 - 55)	470E (ER32)	84 414 620	136.80
SK 40	2 - 20	160	50	119	52 - 70 (32 - 52)	470E (ER32)	84 414 920	144.12
SK 50	2 - 20	100	50	150	53 - 81 (35 - 63)	470E (ER32)	84 414 520	234.14
SK 50	2 - 20	160	50	200	53 - 83 (35 - 65)	470E (ER32)	84 414 720	381.39

Your local Technical Sales Engineer carries a Demo Kit in his car - ASK FOR A DEMO

Roll key

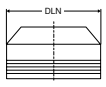
- Version CP = for Centro-P lock nuts
- Version STD = for standard lock nuts

WNT \ Performance

for lock nut	DLN mm	Article no.	£
426E / ER 16 CP	30	84 950 027	60.24
430E / ER 25 CP	40	84 950 054	70.61
470E / ER 32 CP + STD / OZ 462E CP	50	84 950 056	66.20

ER Standard lock nut for precision collet chuck

WNT \ Performance



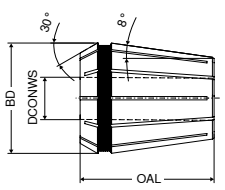
for seals

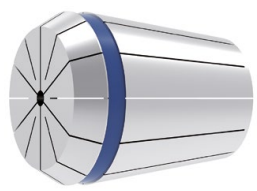
for collet	DCONWS mm	DLN mm	TQX Nm	Article no.	£
426E (ER16)	1 - 10	30	50	84 950 001	29.73
430E (ER25)	2 - 16	40	85	84 950 003	33.03
470E (ER32)	2 - 20	50	135	84 950 005	36.33

Precision ER collet for precision collet chuck

- DIN ISO 15488-B (old DIN 6499-B)
- 12 times slotted
- Double taper clamping
- Coloured ring as identification of precision collet
- ER08: 5 µm runout and repeatability

ER-B 20 µm WNT \ Performance





DCONWS mm	BD = 17 OAL = 27.5 426 E / ER16 Article no.	£	BD = 26 OAL = 34 430 E / ER25 Article no.	£	BD = 33 OAL = 40 470 E / ER32 Article no.	£
1.0	84 596 010	49.36				
1.1	84 596 011	88.28				
1.2	84 596 012	88.28				
1.4	84 596 014	88.28				
1.5	84 596 015	49.36				
1.6	84 596 016	88.28				
1.8	84 596 018	88.28				
2.0	84 596 020	42.16	84 597 020	43.64	84 598 020	44.64
2.2	84 596 022	78.36				
2.4	84 596 024	78.36				
2.5	84 596 025	42.16	84 597 025	43.64		
2.6	84 596 026	78.36				
2.8	84 596 028	78.36				
3.0	84 596 030	35.71	84 597 030	36.71	84 598 030	37.21
3.2	84 596 032	69.44				
3.4	84 596 034	61.48				
3.5	84 596 035	45.46	84 597 035	47.62		
3.6	84 596 036	69.44				
3.8	84 596 038	69.44				
4.0	84 596 040	35.71	84 597 040	36.71	84 598 040	37.21
4.5	84 596 045	45.46	84 597 045	47.62		
5.0	84 596 050	35.71	84 597 050	36.71	84 598 050	37.21
5.5	84 596 055	45.46	84 597 055	47.62		
5.6	84 596 056	69.44				
6.0	84 596 060	35.71	84 597 060	36.71	84 598 060	37.21
6.3	84 596 063	69.44				
6.5	84 596 065	45.46	84 597 065	47.62		

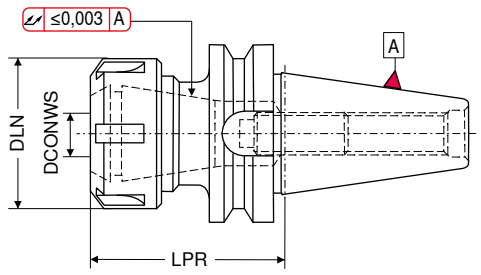
DCONWS mm	BD = 17 OAL = 27.5 426 E / ER16 Article no.	£	BD = 26 OAL = 34 430 E / ER25 Article no.	£	BD = 33 OAL = 40 470 E / ER32 Article no.	£
7.0	84 596 070	35.71	84 597 070	36.71	84 598 070	37.21
7.1	84 596 071	69.44				
7.5	84 596 075	45.46	84 597 075	47.62		
8.0	84 596 080	35.71	84 597 080	36.71	84 598 080	37.21
8.5	84 596 085	45.46	84 597 085	47.62		
9.0	84 596 090	35.71	84 597 090	36.71	84 598 090	37.21
9.5	84 596 095	45.46	84 597 095	47.62		
10.0	84 596 100	35.71	84 597 100	36.71	84 598 100	37.21
10.5			84 597 105	47.62		
11.0			84 597 110	36.71	84 598 110	37.21
11.5			84 597 115	47.62		
12.0			84 597 120	36.71	84 598 120	37.21
12.5			84 597 125	47.62		
13.0			84 597 130	36.71	84 598 130	37.21
13.5			84 597 135	47.62		
14.0			84 597 140	36.71	84 598 140	37.21
14.5			84 597 145	47.62		
15.0			84 597 150	36.71	84 598 150	37.21
15.5			84 597 155	47.62		
16.0			84 597 160	36.71	84 598 160	37.21
17.0					84 598 170	37.21
18.0					84 598 180	37.21
19.0					84 598 190	37.21
20.0					84 598 200	37.21

Clamping range covered: H10 corresponding to shank Ø DCONWS

ER-Collet chuck

Scope of supply:
Holder with lock nut and adjustable back stop

WNT \ Standard



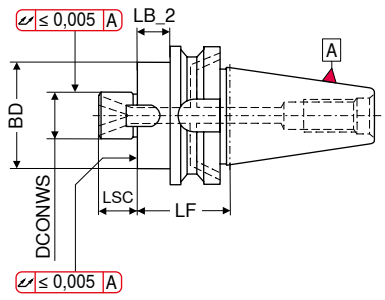
	Adapter	DCONWS	LPR	DLN	TQX	for collet	AD/B G 6,3 n_{max} 8000 Article no.	£	AD/B G 2,5 n_{max} 18000 Article no.	£
		mm	mm	mm	Nm					
short	BT 40	1 - 10	60	32	56	426E (ER16)	82 508 110	46.24	82 509 110	56.15
	BT 40	1 - 16	70	42	104	430E (ER25)	82 508 116	48.49	82 509 116	56.15
	BT 40	2 - 20	70	50	136	470E (ER32)	82 508 120	48.49	82 509 120	56.15
	BT 40	3 - 26	70	63	176	472E (ER40)	82 508 126	51.18	82 509 126	57.79
long	BT 40	1 - 10	120	32	56	426E (ER16)	82 508 410	52.86	82 509 410	62.76
	BT 40	1 - 16	120	42	104	430E (ER25)	82 508 416	52.86	82 509 416	62.76
	BT 40	2 - 20	120	50	136	470E (ER32)	82 508 420	52.86	82 509 420	62.76

Shell mill adapter

▲ With fixed drive dogs and enlarged contact face for milling cutters with transverse groove

Scope of supply:
Toolholder with retaining screw

WNT \ Standard



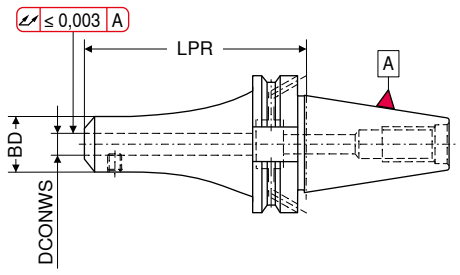
	Adapter	DCONWS	LB_2	LF	BD	LSC	AD/B G 6,3 n_{max} 8000 Article no.	£
		mm	mm	mm	mm	mm		
short	BT 40	16	25	52	38	17	82 514 116	60.02
	BT 40	22	25	52	48	19	82 514 122	65.31
	BT 40	27	25	52	58	21	82 514 127	66.06
	BT 40	32	23	50	78	24	82 514 132	69.70
	BT 40	40	23	50	88	27	82 514 140 [1]	75.74

1) with cross screw and 4 holes M12, Pitch Circle diameter = 66.7 mm, coolant outlet on the outer diameter of the spigot (DCONWS)!

Cylindrical shank adapter (Weldon)

▲ For shanks according to DIN 6535 HB / 1835 B with lateral clamping flat

WNT \ Standard



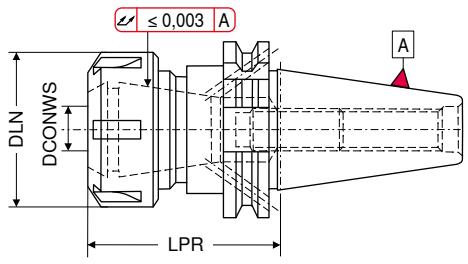
	Adapter	DCONWS $_{H4}$	LPR	BD	AD/B G 6,3 n_{max} 8000 Article no.	£	AD/B G 2,5 n_{max} 18000 Article no.	£	AD/Be G 6,3 n_{max} 8000 Article no.	£	AD/Be G 2,5 n_{max} 18000 Article no.	£
		mm	mm	mm								
short	BT 40	6	50	25	82 502 106	46.24	82 501 106	52.86	82 503 106	66.07	82 504 106	69.36
	BT 40	8	50	28	82 502 108	46.24	82 501 108	52.86	82 503 108	66.07	82 504 108	69.36
	BT 40	10	63	35	82 502 110	46.24	82 501 110	52.86	82 503 110	66.07	82 504 110	69.36
	BT 40	12	63	42	82 502 112	46.24	82 501 112	52.86	82 503 112	66.07	82 504 112	69.36
	BT 40	14	63	44	82 502 114	46.24	82 501 114	52.86	82 503 114	66.07	82 504 114	69.36
	BT 40	16	63	48	82 502 116	46.24	82 501 116	52.86	82 503 116	66.07	82 504 116	69.36
	BT 40	18	63	50	82 502 118	46.24	82 501 118	52.86	82 503 118	66.07	82 504 118	69.36
	BT 40	20	63	52	82 502 120	46.24	82 501 120	52.86	82 503 120	66.07	82 504 120	69.36
	BT 40	25	100	65	82 502 125	46.24	82 501 125	52.86	82 503 125	66.07	82 504 125	69.36
	BT 40	32	100	72	82 502 132	46.24	82 501 132	52.86	82 503 132	66.07		
	BT 40	40	120	90	82 502 140	46.24						
long	BT 40	6	100	25	82 502 506	49.54	82 501 506	56.15				
	BT 40	8	100	28	82 502 508	49.54	82 501 508	56.15				
	BT 40	10	100	35	82 502 510	49.54	82 501 510	56.15				
	BT 40	12	100	42	82 502 512	49.54	82 501 512	56.15				
	BT 40	14	100	44	82 502 514	49.54	82 501 514	56.15				
	BT 40	16	100	48	82 502 516	49.54	82 501 516	56.15				
	BT 40	18	100	50	82 502 518	49.54	82 501 518	56.15				
	BT 40	20	100	52	82 502 520	49.54	82 501 520	56.15				
extra-long	BT 40	6	160	25	82 502 606	52.86	82 501 606	59.46				
	BT 40	8	160	28	82 502 608	52.86	82 501 608	59.46				
	BT 40	10	160	35	82 502 610	52.86	82 501 610	59.46				
	BT 40	12	160	42	82 502 612	52.86	82 501 612	59.46				
	BT 40	14	160	44	82 502 614	52.86	82 501 614	59.46				
	BT 40	16	160	48	82 502 616	52.86	82 501 616	59.46				
	BT 40	18	160	50	82 502 618	52.86	82 501 618	59.46				
	BT 40	20	160	52	82 502 620	52.86	82 501 620	59.46				
	BT 40	25	160	65	82 502 625	52.86	82 501 625	59.46				

Spare parts can be found in → **Main catalogue, chapter 16.**

ER Collet chuck

Scope of supply:
Holder with lock nut and adjustable back stop

WNT \ Standard



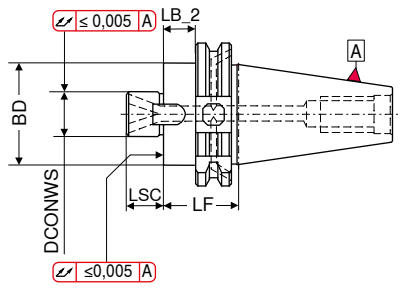
	Adapter	DCONWS	LPR	DLN	TQX	for collet	AD/B G 6,3 n_{max} 8000 Article no.	£	AD/B G 2,5 n_{max} 18000 Article no.	£
		mm	mm	mm	Nm					
short	SK 40	1 - 10	60	32	56	426E (ER16)	82 414 110	46.24	82 415 110	56.15
	SK 40	1 - 16	70	42	104	430E (ER25)	82 414 116	48.49	82 415 116	56.15
	SK 40	2 - 20	70	50	136	470E (ER32)	82 414 120	48.49	82 415 120	56.15
	SK 40	3 - 26	70	63	176	472E (ER40)	82 414 126	51.18	82 415 126	57.79
long	SK 40	1 - 10	120	32	56	426E (ER16)	82 414 410	52.86	82 415 410	62.76
	SK 40	1 - 16	120	42	104	430E (ER25)	82 414 416	52.86	82 415 416	62.76
	SK 40	2 - 20	120	50	136	470E (ER32)	82 414 420	52.86	82 415 420	62.76

Shell mill adapter

▲ Screwed drive dogs

Scope of supply:
Toolholder with retaining screw

WNT \ Standard



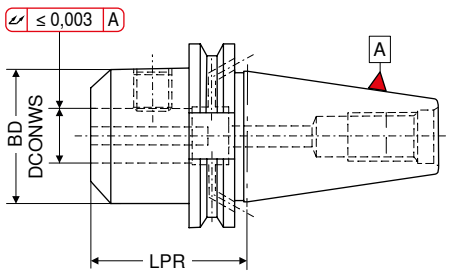
	Adapter	DCONWS	LB_2	LF	BD	LSC	AD/B G 6,3 n_{max} 8000 Article no.	£
		mm	mm	mm	mm	mm		
short	SK 40	16	25	44	38	17	82 428 116	60.02
	SK 40	22	25	44	48	19	82 428 122	65.31
	SK 40	27	36	55	58	21	82 428 127	66.06
	SK 40	32	31	50	78	24	82 428 132	69.70
	SK 40	40	31	50	88	27	82 428 140 [1]	75.74

1) with cross screw and 4 holes M12, Pitch Circle diameter = 66.7 mm, coolant outlet on the outer diameter of the spigot (DCONWS)!

Cylindrical shank adapter (Weldon)

▲ For shanks according to DIN 6535 HB / 1835 B with lateral clamping flat

WNT \ Standard



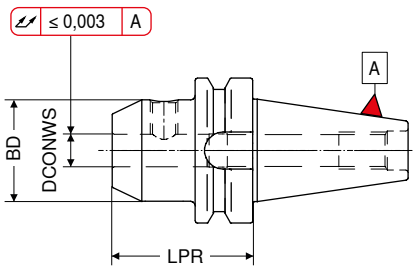
	Adapter	DCONWS $_{H4}$	LPR	BD	AD/B G 6,3 n_{max} 8000 Article no.	£	AD/B G 2,5 n_{max} 18000 Article no.	£	AD/Be G 6,3 n_{max} 8000 Article no.	£	AD/Be G 2,5 n_{max} 18000 Article no.	£
		mm	mm	mm								
short	SK 40	6	50	25	82 402 106	46.24	82 401 106	52.86	82 403 106	66.07	82 404 106	69.36
	SK 40	8	50	28	82 402 108	46.24	82 401 108	52.86	82 403 108	66.07	82 404 108	69.36
	SK 40	10	50	35	82 402 110	46.24	82 401 110	52.86	82 403 110	66.07	82 404 110	69.36
	SK 40	12	50	42	82 402 112	46.24	82 401 112	52.86	82 403 112	66.07	82 404 112	69.36
	SK 40	14	50	44	82 402 114	46.24	82 401 114	52.86	82 403 114	66.07	82 404 114	69.36
	SK 40	16	63	48	82 402 116	46.24	82 401 116	52.86	82 403 116	66.07	82 404 116	69.36
	SK 40	18	63	50	82 402 118	46.24	82 401 118	52.86	82 403 118	66.07	82 404 118	69.36
	SK 40	20	63	52	82 402 120	46.24	82 401 120	52.86	82 403 120	66.07	82 404 120	69.36
	SK 40	25	100	65	82 402 125	46.24	82 401 125	52.86	82 403 125	66.07	82 404 125	69.36
	SK 40	32	100	72	82 402 132	46.24	82 401 132	52.86	82 403 132	66.07		
	SK 40	40	120	90	82 402 140	46.24						
long	SK 40	6	100	25	82 402 506	49.54	82 401 506	56.15				
	SK 40	8	100	28	82 402 508	49.54	82 401 508	56.15				
	SK 40	10	100	35	82 402 510	49.54	82 401 510	56.15				
	SK 40	12	100	42	82 402 512	49.54	82 401 512	56.15				
	SK 40	14	100	44	82 402 514	49.54	82 401 514	56.15				
	SK 40	16	100	48	82 402 516	49.54	82 401 516	56.15				
	SK 40	18	100	50	82 402 518	49.54	82 401 518	56.15				
	SK 40	20	100	52	82 402 520	49.54	82 401 520	56.15				
extra-long	SK 40	6	160	25	82 402 606	52.86	82 401 606	59.46				
	SK 40	8	160	28	82 402 608	52.86	82 401 608	59.46				
	SK 40	10	160	35	82 402 610	52.86	82 401 610	59.46				
	SK 40	12	160	42	82 402 612	52.86	82 401 612	59.46				
	SK 40	14	160	44	82 402 614	52.86	82 401 614	59.46				
	SK 40	16	160	48	82 402 616	52.86	82 401 616	59.46				
	SK 40	18	160	50	82 402 618	52.86	82 401 618	59.46				
	SK 40	20	160	52	82 402 620	52.86	82 401 620	59.46				
	SK 40	25	160	65	82 402 625	52.86	82 401 625	59.46				

Spare parts can be found in → **Main catalogue, chapter 16.**

Cylindrical shank adapter (Weldon) – BT-FC

- with face contact
- for shanks according to DIN 6535 / 1835 B with lateral clamping flat

WNT \ Standard



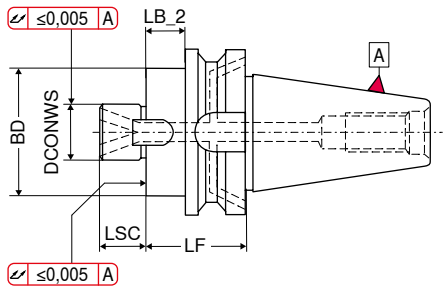
AD
G 2,5 n_{max} 25000

	Adapter	DCONWS $_{H4}$	LPR	BD	Article no.	
		mm	mm	mm		£
short	BT-FC 30	6	50	25	84 552 006	57.87
	BT-FC 30	8	50	28	84 552 008	57.87
	BT-FC 30	10	50	35	84 552 010	57.87
	BT-FC 30	12	50	42	84 552 012	57.87
	BT-FC 30	16	63	48	84 552 016	62.08
	BT-FC 30	20	63	52	84 552 020	62.08
	BT-FC 40	6	50	25	84 552 106	73.33
	BT-FC 40	8	50	28	84 552 108	70.95
	BT-FC 40	10	63	35	84 552 110	70.95
	BT-FC 40	12	63	42	84 552 112	70.95
	BT-FC 40	16	63	48	84 552 116	70.95
	BT-FC 40	20	63	52	84 552 120	70.95
	BT-FC 40	25	90	65	84 552 125	94.33
	BT-FC 40	32	100	72	84 552 132	94.33
	BT-FC 50	6	63	25	84 552 306	108.83
	BT-FC 50	8	63	28	84 552 308	105.62
	BT-FC 50	10	63	35	84 552 310	105.62
	BT-FC 50	12	80	42	84 552 312	105.62
	BT-FC 50	16	80	48	84 552 316	105.62
	BT-FC 50	20	80	52	84 552 320	105.62
	BT-FC 50	25	100	65	84 552 325	120.91
	BT-FC 50	32	105	72	84 552 332	120.91

Shell mill adapter – BT-FC

- with face contact
- with fixed drive dogs and enlarged contact face for milling cutters with transverse slot

WNT \ Standard



AD
G 6,3 n_{max} 15000

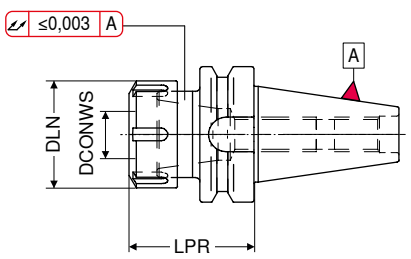
	Adapter	DCONWS	LB_2	LF	BD	LSC	Article no.	
		mm	mm	mm	mm	mm		£
short	BT-FC 30	16	18	39.0	40	17	84 562 016	63.69
	BT-FC 30	22	18	39.0	50	19	84 562 022	63.69
	BT-FC 30	27	18	39.0	60	21	84 562 027	63.69
	BT-FC 30	32	28	49.0	80	24	84 562 032	63.69
	BT-FC 40	16	8	34.0	40	17	84 562 116	76.60
	BT-FC 40	22	8	34.0	50	19	84 562 122	76.60
	BT-FC 40	27	8	34.0	60	21	84 562 127	76.60
	BT-FC 40	32	23	49.0	80	24	84 562 132	76.60
	BT-FC 40	40	23	49.0	89	27	84 562 140	76.60
	BT-FC 50	22	12	48.5	50	19	84 562 322	88.67
	BT-FC 50	27	12	48.5	60	21	84 562 327	88.67
	BT-FC 50	32	12	48.5	80	24	84 562 332	94.33
	BT-FC 50	40	17	53.5	89	27	84 562 340	94.33

ER Collet chuck – BT-FC

- with face contact

Scope of supply:
Toolholder including nut

WNT \ Standard



AD
G 2,5 n_{max} 20000

	Adapter	DCONWS	LPR	DLN	TQX	for collet	Article no.	
		mm	mm	mm	Nm			£
short	BT-FC 30	1 - 10	63	28	56	426E (ER16)	84 557 010	65.30
	BT-FC 30	1 - 16	60	42	104	430E (ER25)	84 557 016	65.30
	BT-FC 30	2 - 20	60	50	136	470E (ER32)	84 557 020	65.30
	BT-FC 40	1 - 10	63	28	56	426E (ER16)	84 557 110	82.25
	BT-FC 40	1 - 16	60	42	104	430E (ER25)	84 557 116	82.25
	BT-FC 40	2 - 20	60	50	136	470E (ER32)	84 557 120	82.25
	BT-FC 50	1 - 16	70	42	104	430E (ER25)	84 557 316	112.04
	BT-FC 50	2 - 20	70	50	136	470E (ER32)	84 557 320	112.04
long	BT-FC 50	1 - 10	100	28	56	426E (ER16)	84 557 310	112.04

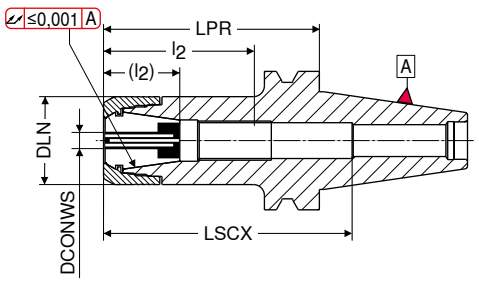
Spare parts can be found in → **Main catalogue, chapter 16.**

ER Precision Collet chuck – BT-FC

- with face contact
- for standard or sealed nuts
- maximum clamping range covered according to ISO tolerance field H10
- for clamping a roll key is required
- p_{max} = 80 bar

Scope of supply:
Holder **without** nut, **without** backstop

Centro-P **WNT** \ Performance



AD
G 2,5 n_{max} 25000

Adapter	DCONWS	LPR	BD	LSCX	l_2 (l_2)	for collet	Article no.	
	mm	mm	mm	mm	mm			£
BT-FC 30	1 - 10	75	30	97	28 - 45 (14 - 31)	426E (ER16)	84 525 002	133.22
BT-FC 30	2 - 16	75	40	72	38 - 56 (23 - 39)	430E (ER25)	84 525 012	135.12
BT-FC 30	2 - 20	75	45	84	42 - 62 (24 - 45)	470E (ER32)	84 525 022	135.12
BT-FC 40	1 - 10	75	30	90	38 - 53 (29 - 39)	426E (ER16)	84 525 102	148.44
BT-FC 40	2 - 16	75	40	100	42 - 59 (36 - 41)	430E (ER25)	84 525 112	150.34
BT-FC 40	2 - 20	75	50	100	42 - 76 (42 - 52)	470E (ER32)	84 525 122	150.34

LSCX = clamping depth without back stop screw for shanks
l_2 = with back stop screw 1, dimension in brackets ( ) = with back stop screw 2
dimension LPR when using tightening nuts with seals 4 mm longer

Speed Calculation

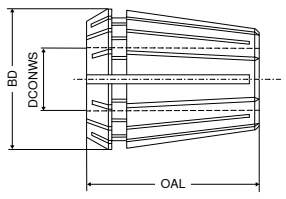
$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

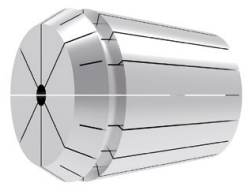
v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

ER precision collet

- ▲ DIN ISO 15488-B (old DIN 6499-B)
- ▲ Double taper collet
- ▲ 16 times slotted

ER-B 20 µm WNT \ Standard





DCONWS mm		BD = 17 OAL = 27.5 426 E / ER16 Article no.	£	BD = 21 OAL = 31.5 428 E / ER20 Article no.	£	BD = 26 OAL = 34 430 E / ER25 Article no.	£	BD = 33 OAL = 40 470 E / ER32 Article no.	£	BD = 41 OAL = 46 472 E / ER40 Article no.	£
1		82 673 01000	14.01	82 674 01000 [1]	13.69						
2		82 673 02000	14.01	82 674 02000 [1]	13.69	82 675 02000 [1]	14.12				
3		82 673 03000	11.50	82 674 03000	9.27	82 675 03000	9.75	82 676 03000	10.55	82 677 03000	13.33
4		82 673 04000	11.50	82 674 04000	9.27	82 675 04000	9.75	82 676 04000	10.55	82 677 04000	13.33
5		82 673 05000	11.50	82 674 05000	9.27	82 675 05000	9.75	82 676 05000	10.55	82 677 05000	13.33
6		82 673 06000	11.50	82 674 06000	9.27	82 675 06000	9.75	82 676 06000	10.55	82 677 06000	13.33
7		82 673 07000	11.50	82 674 07000	9.27	82 675 07000	9.75	82 676 07000	10.55	82 677 07000	13.33
8		82 673 08000	11.50	82 674 08000	9.27	82 675 08000	9.75	82 676 08000	10.55	82 677 08000	13.33
9		82 673 09000	11.50	82 674 09000	9.27	82 675 09000	9.75	82 676 09000	10.55	82 677 09000	13.33
10		82 673 10000	11.50	82 674 10000	9.27	82 675 10000	9.75	82 676 10000	10.55	82 677 10000	13.33
11				82 674 11000	9.27	82 675 11000	9.75	82 676 11000	10.55	82 677 11000	13.33
12				82 674 12000	9.27	82 675 12000	9.75	82 676 12000	10.55	82 677 12000	13.33
13				82 674 13000	9.27	82 675 13000	9.75	82 676 13000	10.55	82 677 13000	13.33
14						82 675 14000	9.75	82 676 14000	10.55	82 677 14000	13.33
15						82 675 15000	9.75	82 676 15000	10.55	82 677 15000	13.33
16						82 675 16000	9.75	82 676 16000	10.55	82 677 16000	13.33
17								82 676 17000	10.55	82 677 17000	13.33
18								82 676 18000	10.55	82 677 18000	13.33
19								82 676 19000	10.55	82 677 19000	13.33
20								82 676 20000	10.55	82 677 20000	13.33
21										82 677 21000	13.33
22										82 677 22000	13.33
23										82 677 23000	13.33
24										82 677 24000	13.33
25										82 677 25000	13.33
26										82 677 26000	13.33
	Set in a wooden box	82 673 99900	184.40	82 674 99900	184.40	82 675 99900	184.40	82 676 99900	197.32	82 677 99900	310.36

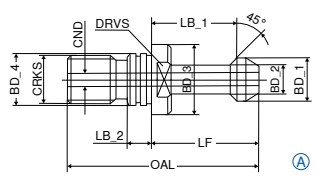
1) not included in the set

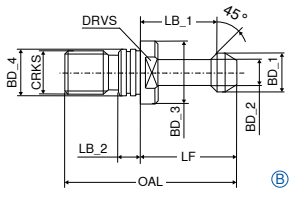
Pull stud for tool holders according to JIS B 6339

- ▲ MAS-BT 45° Form A and B

Scope of supply:
including O-Ring

WNT \ Standard





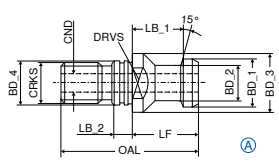
Adapter	BD_1 mm	BD_2 mm	BD_3 mm	BD_4 mm	CRKS	OAL mm	LF mm	LB_1 mm	LB_2 mm	CND mm	DRVS mm	TQX Nm	form	Article no.	£	Article no.	£
BT 30	11	7	16.5	12.5	M12	43	23	18	4.0	2.2	13	60	A			82 534 030	9.52
BT 30	11	7	16.5	12.5	M12	43	23	18	4.0		13	60	B	82 530 030	9.52		
BT 40	15	10	23.0	17.0	M16	60	35	28	5.5	4.0	19	90	A			82 534 040	9.52
BT 40	15	10	23.0	17.0	M16	60	35	28	5.5		19	90	B	82 530 040	8.16		
BT 50	23	17	38.0	25.0	M24	85	45	35	8.0	6.0	30	145	A			82 534 050	12.25
BT 50	23	17	38.0	25.0	M24	85	45	35	8.0		30	145	B	82 530 050	11.57		

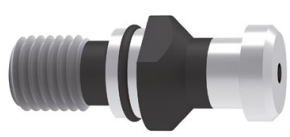
Pull studs for tool holders according to DIN 69871

- ▲ DIN 69872 form A and B
- ▲ For tools with or without axial coolant supply

Scope of supply:
including O-Ring

WNT \ Standard





Adapter	BD_1 mm	BD_2 mm	BD_3 mm	BD_4 mm	CRKS	OAL mm	LF mm	LB_1 mm	LB_2 mm	CND mm	DRVS mm	TQX Nm	form	Article no.	£
SK 30	13	9	17	13	M12	44	24	19	5	3.5	14	60	A	82 468 030	7.76
SK 40	19	14	23	17	M16	54	26	20	7	7.0	19	90	A	82 468 040	6.61
SK 50	28	21	36	25	M24	74	34	25	10	11.5	30	145	A	82 468 050	9.81

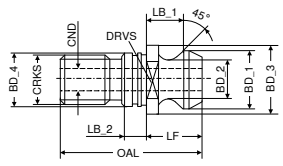
Pull studs for tool holders according to DIN 69871

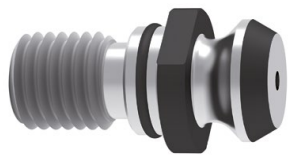
▲ Similar to ISO / DIS 7388 (ANSI-CAT only for SK 40) Form A

Scope of supply:

SK 50 including O-ring
SK 40 without O-ring groove

WNT \ Standard



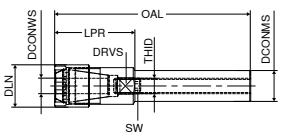


Adapter	BD_1	BD_2	BD_3	BD_4	CRKS	OAL	LF	LB_1	LB_2	CND	DRVS	TQX	Article no.	£
	mm	mm	mm	mm		mm	mm	mm	mm	mm	mm	Nm		
SK 40	18.95	12.95	22.5	17	M16	41.26	16.40	11.15	4.0	6.0	19	90	82 487 040	6.61
SK 50	29.10	19.60	37.0	25	M24	65.50	25.55	17.95	5.5	11.5	30	145	82 487 050	10.36

ER collet chuck with mini clamping nut

▲ with cylindrical shank

WNT \ Standard



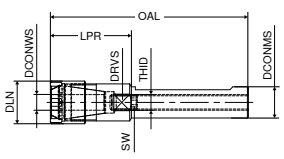
AD

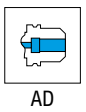
DCONMS h6	DCONWS	OAL	LPR	DLN	THID	DRVS	for collet	Article no.	£
mm	mm	mm	mm	mm		mm			
8	1 - 5	79	24	12		9	4004E (ER08)	83 453 081	67.96
12	1 - 5	155	18	12	M5	10	4004E (ER08)	83 453 122	143.74
16	1 - 7	182	22	16	M7,5x0,5	14	4008E (ER11)	83 453 163	141.22
16	1 - 10	117	37	22	M11x1	17	426E (ER16)	83 453 164	143.74
16	1 - 10	197	37	22	M11x1	17	426E (ER16)	83 453 165	141.22
20	1 - 10	166	25	22	M11x1	17	426E (ER16)	83 453 204	101.29
25	1 - 13	166	37	28	M14x1	22	428E (ER20)	83 453 254	117.18
25	1 - 16	190	40	35	M18x1	27	430E (ER25)	83 453 256	147.62

ER collet chuck with mini clamping nut

▲ with cylindrical shank and clamping flat

WNT \ Standard





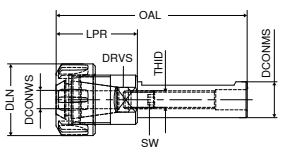
AD

DCONMS h6	DCONWS	OAL	LPR	DLN	THID	DRVS	for collet	Article no.	£
mm	mm	mm	mm	mm		mm			
20	1 - 10	166	25	22	M11x1	17	426E (ER16)	83 454 204	101.29
20	1 - 13	137	37	28	M11x1	22	428E (ER20)	83 454 206	72.83
20	1 - 16	146	46	35	M11x1	27	430E (ER25)	83 454 208	84.91
25	1 - 13	166	28	28	M14x1	22	428E (ER20)	83 454 254	117.18
25	1 - 16	190	40	35	M18x1	27	430E (ER25)	83 454 256	147.62

ER Collet Chuck

▲ with cylindrical shank and clamping flat

WNT \ Standard



AD

DCONMS h6	DCONWS	OAL	LPR	DLN	THID	DRVS	for collet	Article no.	£
mm	mm	mm	mm	mm		mm			
40	2 - 20	100		50	M22x1,5	36	470E (ER32)	83 455 401	86.28
40	2 - 20	160		50	M22x1,5	36	470E (ER32)	83 455 402	106.54
40	3 - 30	139	59	63	M28x1,5	40	472E (ER40)	83 455 405	98.92

Note: Spanner to be ordered separately.

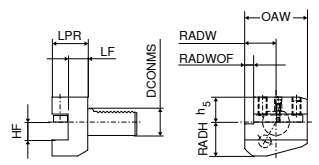
Speed Calculation

$$RPM = \frac{v_c \times 1000}{\pi \times D}$$

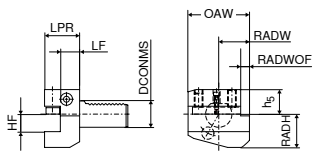
v_c = (See Individual v_c Charts)
π = 3.142
D = Diameter

Radial tool holders, short

WNT \ Performance



B2



B1

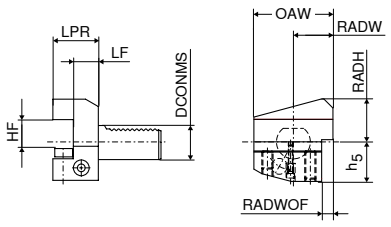
B2

B1

DCONMS h6 mm	HF 0/-0,1 mm	OAW mm	RADW mm	RADWOF mm	h5 mm	RADH mm	LF 0/+0,5 mm	LPR mm	Left-hand Article no.	£	Right-hand Article no.	£
16	12	42	23.0	5.0	20.0	22	13.0	24			82 185 160	97.15
20	16	55	30.0	7.0	25.0	30	16.0	30	82 189 200	82.93	82 185 200	88.53
20	16	55	30.0	7.0	25.0	30	26.0	40	82 189 201	108.10	82 185 201	102.15
30	20	70	35.0	10.0	28.0	38	18.5	40	82 189 300	89.81	82 185 300	81.42
30	20	70	35.0	10.0	28.0	38	42.0	60	82 189 301	142.00	82 185 301	134.76
40	25	85	42.5	12.5	32.5	48	18.5	44	82 189 400	91.00	82 185 400	83.09
50	32	100	50.0	16.0	35.0	60	30.0	55	82 189 500	141.10	82 185 500	138.78

Radial tool holders, overhead, short

WNT \ Performance

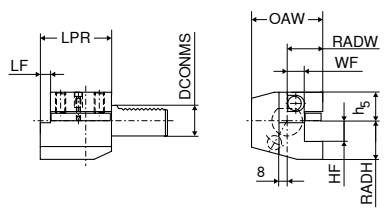


B3

DCONMS h6 mm	HF 0/-0,1 mm	OAW mm	RADW mm	RADWOF mm	h5 mm	RADH mm	LF 0/+0,5 mm	LPR mm	Right-hand Article no.	£
16	12	42	23.0	5.0	20.0	22	13.0	24	82 193 160	102.41
20	16	55	30.0	7.0	25.0	30	16.0	30	82 193 200	88.53
20	16	55	30.0	7.0	25.0	30	26.0	40	82 193 201	128.53
25	16	55	30.0	7.0	25.0	30	16.0	30	82 193 250	142.53
30	20	70	35.0	10.0	35.0	38	18.5	40	82 193 300	83.89
30	20	70	35.0	10.0	35.0	38	42.0	60	82 193 301	142.00
40	25	85	42.5	12.5	42.5	48	18.5	44	82 193 400	88.72
50	32	100	50.0	16.0	50.0	60	30.0	55	82 193 500	141.10

Axial tool holders

WNT \ Performance



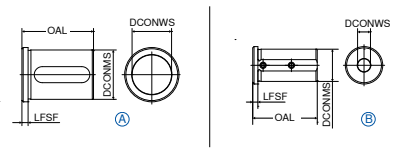
C1

DCONMS h6 mm	HF 0/-0,1 mm	OAW mm	RADW mm	WF 0/+0,3 mm	h5 mm	RADH mm	LPR mm	LF mm	Right-hand Article no.	£
20	16	52	27.0	13.0	25.0	30	55	7.0	82 211 200	122.04
30	20	70	35.0	17.0	28.0	38	70	10.0	82 211 300	94.44
40	25	85	42.5	20.5	32.5	48	85	12.5	82 211 400	109.86
50	32	100	50.0	25.5	35.0	60	100	16.0	82 211 500	160.19

Reduction sleeves for direct clamping

▲ For tools with cylindrical shank

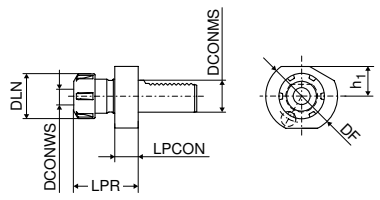
WNT \ Performance



DCONMS mm	DCONWS mm	OAL mm	LFSF mm	Fig.	Article no.	£
25	12	50	4	B	83 272 262	55.26
25	10	50	4	B	83 272 260	55.26
25	16	50	4	A	83 272 266	55.26
25	8	50	4	B	83 272 258	55.26
25	20	50	4	A	83 272 270	55.26
25	6	50	4	B	83 272 256	72.47
32	6	58	5	B	83 272 326	74.78
32	16	58	5	A	83 272 336	56.83
32	12	58	5	B	83 272 332	56.83
32	20	58	5	A	83 272 340	56.83
32	10	58	5	B	83 272 330	56.83
32	25	58	5	A	83 272 345	56.83
32	8	58	5	B	83 272 328	74.78
40	8	58	5	B	83 272 408	90.85
40	20	58	5	A	83 272 420	74.78
40	16	58	5	A	83 272 416	74.78
40	25	58	5	A	83 272 425	74.78
40	12	58	5	B	83 272 412	74.78
40	32	58	5	A	83 272 432	74.78
40	10	58	5	B	83 272 410	74.78
50	12	75	5	B	83 272 512	84.37
50	25	75	5	A	83 272 525	84.37
50	32	75	5	A	83 272 532	84.37
50	20	75	5	A	83 272 520	84.37
50	40	75	5	A	83 272 540	84.37
50	16	75	5	A	83 272 516	84.37

ER Collet chucks

WNT \ Performance



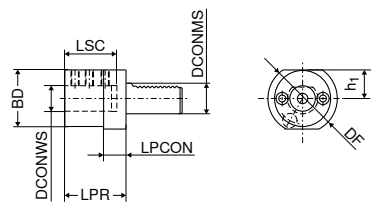
E4

DCONMS h6 mm	DCONWS mm	DF mm	DLN mm	h1 mm	LPR mm	LPCON mm	for collet	Article no.	£
16	1 - 10	40	28	18.0	45.5	14	426E (ER16)	82 286 160	140.07
16	1 - 13	40	34	18.0	44.0	14	428E (ER20)	82 286 161	138.61
20	1 - 16	50	42	23.0	57.0	18	430E (ER25)	82 286 202	114.10
20	2 - 20	50	50	23.0	62.0	18	470E (ER32)	82 286 203	119.29
30	1 - 16	68	42	28.0	57.0	22	430E (ER25)	82 286 300	112.62
30	2 - 20	68	50	28.0	75.0	22	470E (ER32)	82 286 301	112.73
40	1 - 16	83	42	32.5	63.0	22	430E (ER25)	82 286 400	122.12
40	2 - 20	83	50	32.5	75.0	22	470E (ER32)	82 286 401	122.12
40	3 - 26	83	63	32.5	75.0	22	472E (ER40)	82 286 402	119.93
50	2 - 20	94	50	35.0	75.0	30	470E (ER32)	82 286 500	177.85
50	3 - 26	94	63	35.0	63.0	30	472E (ER40)	82 286 501	177.85

Boring bar holder

▲ for turning tools with cylindrical shank
▲ Coolant supply either through the tool or via the ball-shaped spray nozzle

WNT \ Performance



E2

DCONMS h6 mm	DCONWS H7 mm	DF mm	BD mm	h1 mm	LPR mm	LPCON mm	LSC mm	Article no.	£
16	6	40	32	18.0	44	13	34	82 268 160 1)	120.15
16	8	40	32	18.0	44	13	34	82 268 161 1)	91.69
16	10	40	32	18.0	44	13	34	82 268 162 1)	91.69
16	12	40	40	18.0	44	13	34	82 268 163 1)	91.69
16	16	40	40	18.0	44	13	34	82 268 164 1)	91.69
20	8	50	40	23.0	50	18	41	82 268 200	85.25
20	10	50	40	23.0	50	18	41	82 268 201	85.25
20	12	50	40	23.0	50	18	41	82 268 202	85.25
20	16	50	40	23.0	50	18	41	82 268 203	85.25
20	20	50	50	23.0	50	18	41	82 268 204	85.25
20	25	50	50	23.0	60	18	51	82 268 205	85.25
25	8	58	40	25.0	50	18	41	82 268 250	139.01
25	10	58	40	25.0	50	18	41	82 268 251	139.01
25	12	58	40	25.0	50	18	41	82 268 252	139.01
25	16	58	40	25.0	50	18	41	82 268 253	139.01
25	20	58	58	25.0	50	18	41	82 268 254	139.01
25	25	58	58	25.0	60	18	51	82 268 255	139.01
30	8	68	55	28.0	60	22	51	82 268 300	83.09
30	10	68	55	28.0	60	22	51	82 268 301	83.09
30	12	68	55	28.0	60	22	51	82 268 302	83.09
30	16	68	55	28.0	60	22	51	82 268 303	83.09
30	20	68	55	28.0	60	22	51	82 268 304	83.09
30	25	68	55	28.0	60	22	51	82 268 305	83.09
30	32	68	68	28.0	75	22	61	82 268 306	83.09
40	8	83	55	32.5	75	22	61	82 268 400	84.70
40	10	83	55	32.5	75	22	61	82 268 401	84.70
40	12	83	55	32.5	75	22	61	82 268 402	84.70
40	16	83	55	32.5	75	22	61	82 268 403	84.70
40	20	83	55	32.5	75	22	61	82 268 404	84.70
40	25	83	55	32.5	75	22	61	82 268 405	84.70
40	32	83	83	32.5	75	22	61	82 268 406	84.70
40	40	83	83	32.5	90	22	76	82 268 407	84.70
50	12	98	68	35.0	90	30	76	82 268 500	122.01
50	16	98	68	35.0	90	30	76	82 268 501	122.01
50	20	98	68	35.0	90	30	76	82 268 502	122.01
50	25	98	68	35.0	90	30	76	82 268 503	116.97
50	32	98	68	35.0	90	30	76	82 268 504	116.97
50	40	98	98	35.0	90	30	76	82 268 505	116.97
50	50	98	98	35.0	100	30	86	82 268 506	116.97

1) Coolant supply through pipe joint

Tool Supply 24/7

Tool-O-Mat 840
up to 840 tools

Tool-O-Mat 80
up to 80 tools

Tool-O-Mat 60
up to 60 tools

Access to Cutting Tools 24/7
with full control

Itemised Reporting

Major cashflow benefits
you only pay for the tools you use

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you don't get left with old cutting tool technology

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only one consolidated invoice per month

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the ability to control high value items

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over 350 machines in operation in the UK & Ireland

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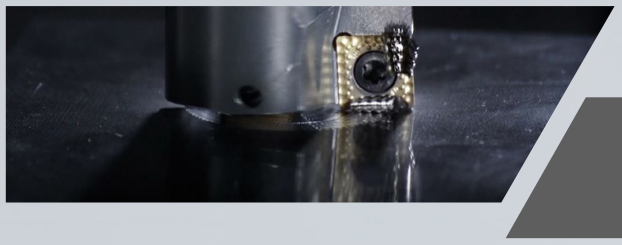
The product brand CERATIZIT stands for high-quality indexable insert tools. The products are characterized by their high quality and contain the DNA of many years of experience in the development and production of carbide tools.



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THE QUALITY LABEL FOR EFFICIENT BORE PRODUCTION

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