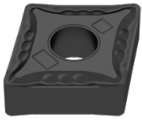


New products for machining technicians

NEW CTCM120 and CTCM130 for stainless turning



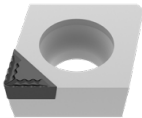
In addition to the all-rounder CTPM125 grade, the CTCM120 and CTCM130 stainless turning grades now provide a tougher and a more wear-resistant option for finer adjustment to the material to be machined. What's more, the stainless range offers geometric compatibility across all three grades.

NEW Standard line



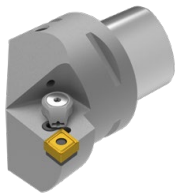
Attractively priced indexable inserts for steel machining – our ISO turning standard line not only impresses on price but also by providing the best levels of performance!

NEW CBN/PCD update



Various cutting edge finishes and chip breakers are being added to the CBN and PCD range to provide a specialist for every application.

NEW MaxiLock tool holders with PSC connection



Our MaxiLock tool holders with PSC connection provide the most stable conditions for your machining process and can be purchased with high-performance cooling to improve the service life of the tools and provide optimal chip control.

NEW Exchangeable head system



Our modular exchangeable head system provides a wide selection of exchangeable cutting heads for PSC and HSK-T base bodies.

You can also opt for the vibration-damped base holder, which will make your internal turning operations much easier.



Solid drilling and bore machining

- 1 HSS drilling
- 2 Solid carbide drilling
- 3 Indexable insert drills
- 4 Reaming and Countersinking
- 5 Spindle Tooling

Threading

- 6 Taps and thread formers
- 7 Circular and Thread Milling
- 8 Thread turning

Turning

- 9 Turning Tools
- 10 Multifunctional Tools – EcoCut and FreeTurn
- 11 Grooving Tools
- 12 Miniature turning tools

Milling

- 13 HSS Milling Cutters
- 14 Solid Carbide milling cutters
- 15 Milling tools with indexable inserts

Catalogue –
Clamping technology

- 16 Adaptors and Accessories
- 17 Workpiece clamping

- 18 Material examples and article no. Index

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CERATIZIT \ Performance

Premium quality tools for high performance.

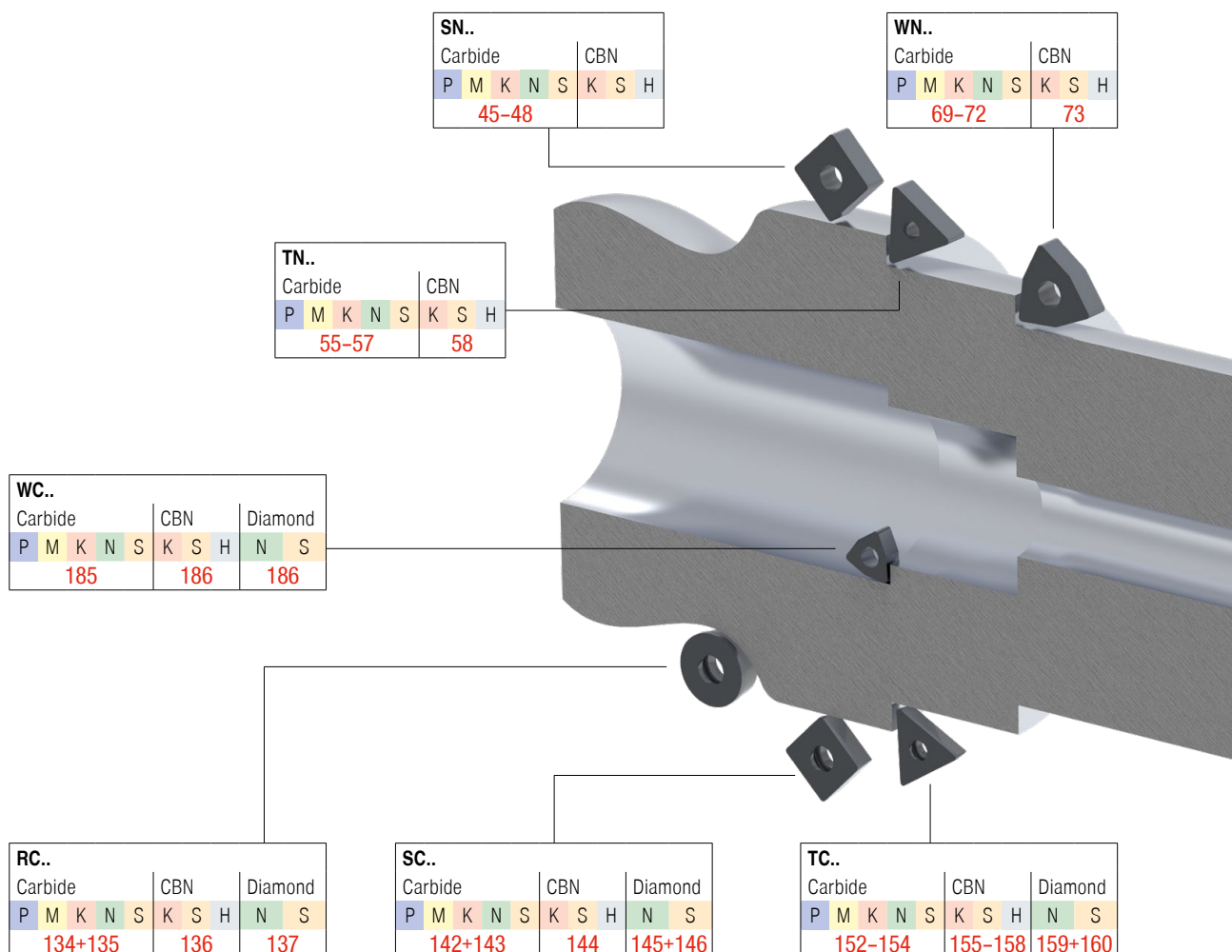
The premium quality tools from the **CERATIZIT Performance** product line have been designed for specific applications and are distinguished by their outstanding performance. If you make high demands on the performance of your production and want to achieve the very best results, we recommend the Premium tools in this product line.

CERATIZIT \ Standard

Quality tools for standard applications.

The quality tools of the **CERATIZIT Standard** product line are high quality, powerful and reliable and enjoy the highest trust of our customers worldwide. Tools from this product line are the first choice for many standard applications and guarantee optimal results.

Toolfinder – Application



Coding of the chip breakers

All new chip breakers are coded according to the following key:

-M50

Inserts – Basic Type	Application range	Material		Chip breaker width
	F = Fine	1 = Steel	5 = Heat Resistant alloys	1 = Narrow
0 N = Negative Inserts	M = Medium	2 = Stainless steel	6 = Hard	
5 P = Positive Inserts	R = Rough	3 = Cast Iron	7 = Universal	
		4 = Non Ferrous Metals		9 = Wide



Detailed information on the chip breakers can be found in the technical appendix → **pages 220–227**

Symbol explanation

CTCP125
Carbide Grade

F Fine Machining
M Medium Machining
R Rough Machining



Smooth cut
 Irregular cutting depth
 Interrupted cut



A detailed overview of grades can be found in the technical appendix on → **page 238**

9

CN..
Carbide CBN Diamond
P M K N S K S H N S
9–14 15–18 19

DN..
Carbide CBN Diamond
P M K N S K S H N S
27–31 32+33 34

VN..
Carbide CBN
P M K N S K S H
62–64 65

KN..
Carbide CBN
P M K N S K S H
↓

CC..
Carbide CBN Diamond
P M K N S K S H N S
78–82 83–89 90–94

VC..
Carbide CBN Diamond
P M K N S K S H N S
164–167 168–171 172–174

DC..
Carbide CBN Diamond
P M K N S K S H N S
105–109 110–117 118–122



This article can be found in our online shop at cuttingtools.ceratizit.com

Toolfinder – negative inserts



			Steel	Stainless steel	Cast iron	Non ferrous metals	Heat resistant	hardened materials	Non metal materials	Geometry						
			P	M	K	N	S	H	O	CN..	DN..	KN..	SN..	TN..	VN..	WN..
Main application: Steel and cast iron	Fine	-CF / -CF20		●	○	○				9	27			55		69
		-F40		●		○									62	
		-F50		●		○				9	27		45	55	62	69
		-TFQ		●	○	○				9+10	27+28					69
	Medium	-XU		●		○				10	28				62	70
		-FMS		●		○				14	31				64	72
		-M40		●		○									62	
		-M50		●	○	○				10	28+29		45	55	62	70
		-TMQ		●		○				10	29					70
		-MRS		●	○					14	31					72
	Rough	-M70 -11, -12		●	○	○				10+11	29		45+46	56		70
		.NMA		●	○					11	29		46+47	56		71
		-R28		●	○	○				11	29		47	56		
		-R58		●	○	○				11+12	29+30		47	56+57		
		-R88		●	○	○				12			48			
Main application: Stainless	Fine	-F30		○	●		○			13	30		48	57	62	71
		-M30		○	●		○			13	30		48	57	62+63	71
	Medium	-M42		○	●		●									
		-M60		○	●		○			13	30		48	57		71
Main application: Heat-resistant	Fine	-F32		●		○	●									
		-M34		●	●	○	●			13	30		48	57	63	71
	Medium	-M42		○	●	○	●									
		-M52		●		○	●									

This article can be found in our online shop at cuttingtools.ceratizit.com

Toolfinder – negative inserts



			Steel	Stainless steel	Cast iron	Non ferrous metals	Heat resistant	hardened materials	Non metal materials	Geometry						
			P	M	K	N	S	H	O							
Main application: Cast iron, sintered steels, heat resistant, hardened	Fine	CTBS05U			•											73
		CTBS10U			•		•			15+16						
		CTBS10C			•		•			15+16						
		CTBS20U			•		•			15+16	32					
		CTBS20C			•		•			15+16	32					73
		CTBH15U						•								
		CTBH15C						•		17	32					
		CTBH20U						•		17	32			58		
		CTBH20C	48–62 HRC					•		17	33			58	65	73
		CTBH21U	52–65 HRC					•								
	Rough	CTBH40U	54–65 HRC					•		18	33			58	65	
		CTBH40C	48–65 HRC					•		18	33			58	65	73
		CTBH41U	48–65 HRC					•		18						
Diamond		CTD PD20				•		•		19	34					
		CTD PS30				•		•		19						



With the PCBN grades CTB S10 and CTB S20, sintered steels can also be machined. You can find the cutting data on → **page 200–203**

Toolfinder – positive inserts



				Steel	Stainless steel	Cast iron	Non ferrous metals	Heat resistant	hardened materials	Non metal materials	Geometry										
				P	M	K	N	S	H	O											
Main application: Steel and cast iron	Fine	-CF05		●	○	○					78	105		142			152		164		
		-SF		●	○	○						78+79	105		142			152		164	185
	Medium	-CF55		●	○	○						78	105		142			152		164	
		-SMF		●	○	○						78+79	105	134	142			152+153		164+165	
		-FMS		●	○							82	109							167	
		-SM		●	○	●						79	105+106	134	142			153		165	
		-SMQ		●		○						79+80	106								
		-MRS		●	○							82	109							167	
		EN, EL, ER		●	○	●									142						
		Main application: Stainless	Fine	-F43		○	●		●												
-M81				○	●			○													
Medium	-M25			○	●			●			80	106					153		165		
	-M55			○	●			●			80	106		143			153		165		
Main application: Non-ferrous metals	Fine	-23P				○	●			○	80	107									
		-25P		●	●	○	●	●		○	80	107		143					166		
	Medium	-25Q		●	●	○	●	●		○	80	107							166		
		-27		●	●	○	●	●		○	80+81	107+108	135	143			154		166		
		-29				○	●			○	81	108							166		
Main application: Heat-resistant	Fine	-F05		●	●		●	●				108							166		
		-F23			●	○	○	●													

This article can be found in our online shop at cuttingtools.ceratizit.com

Toolfinder – positive inserts



			Steel	Stainless steel	Cast iron	Non ferrous metals	Heat resistant	hardened materials	Non metal materials	Geometry								
			P	M	K	N	S	H	O	CC..	DC..	RC..	SC..	SP..	TC..	TP..	VC..	WC..
Main application: Cast iron, sintered steels, heat resistant, hardened	Fine	CTBS10U			•		•			83	110	136	144		155+156		168+169	186
		CTBS10C			•		•				111+112							
		CTBS20U			•		•			84+85	111+112				155+156		168+169	
		CTBS20C			•		•			84+85	111+112				155+156		168+169	
		CTBH15U	< 32 HRC					•		86	111-113				155+156		168+169	186
		CTBH15C	< 32 HRC					•		86	113				157+158		168+169	
		CTBH21U	52-65 HRC					•		87	113-115						170	
		CTBH21C	52-65 HRC					•			114+115							
		CTBH20U						•		87	114+115				155+156		170	186
		CTBH20C	48-62 HRC					•		84-88	113-115				157+158		170	
	Rough	CTBH40U	54-65 HRC					•		88	114-117				157+158		171	186
		CTBH40C	48-65 HRC					•		89	116+117				157+158		171	
		CTBH41U	48-65 HRC					•									171	
		CTBH41C	48-65 HRC					•			116+117							
	Diamond	CTD PD20				•		•		90+91	118+120	137	145		159		172+173	186
		CTD PS30				•		•		92+93	119-121	137	145+146		159+160		173	
		CTD PU20				•		•		93	119-122		146		160		173+174	
		CTD CD10				•		•		94	122				160		174	
		CTD MD05				•		•		90	118						172	



With the PCBN grades CTB S10 and CTB S20, sintered steels can also be machined. You can find the cutting data on → **page 200-203**

Toolfinder – holders

Toolholders and Boring Bars for negative inserts



Geometry	Tool holder	Boring bars	HSK-T	PSC	Exchangeable head system	
					Exchangeable cutting heads	Basic holder
CN..	20-22	25+26	23	24	191	188-190
DN..	35+36	43+44	37-39	39-42	191+192	188-190
SN..	49-53	54	53			
TN..	59+60	61				
VN..	66		67	67+68		
WN..	74	76+77	75	75+77	192	188-190

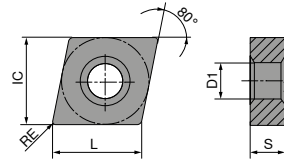
Toolholders and boring bars for positive inserts



Geometry	Tool holder	Boring bars	HSK-T	PSC	Exchangeable head system	
					Exchangeable cutting heads	Basic holder
CC..	95-97	100-104	98+104	99	193	188-190
DC..	123-125	129-133	126+133	127+128	193+194	188-190
RC..	138-140		141			
SC..	147-149	150+151				
TC..	161+162	163				
VC..	175-178	182-184	178-184	180+181		
WC..		187				

CNMG / CNMA / CNMM

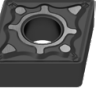
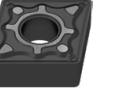
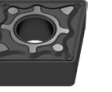
Designation	L mm	S mm	D1 mm	IC mm
CNMG 0903..	9,7	3,18	3,81	9,52
CNM. 1204..	12,9	4,76	5,16	12,70
CNM. 1606..	16,1	6,35	6,35	15,87
CNM. 1906..	19,3	6,35	7,94	19,05
CNMM 2509..	25,8	9,52	9,12	25,40



CNMG

		-CF TCM10		-CF20 CTEP110		-TFQ CTEP110		-F50 CTCP115		-F50 CTCP125		-F50 CTCP135		-TFQ CTCP115	
		DRAGONS SKIN		DRAGONS SKIN		DRAGONS SKIN		DRAGONS SKIN		DRAGONS SKIN		DRAGONS SKIN		DRAGONS SKIN	
		F		F		F		F		F		F		F	
		CERMET CNMG		CERMET CNMG		CERMET CNMG		CNMG		CNMG		CNMG		CNMG	
		70 101 ...		76 101 ...		76 110 ...		76 132 ...		76 132 ...		76 132 ...		76 110 ...	
ISO	RE mm	EUR 1A/78		EUR 1A/78		EUR 1A/78		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
090304EN	0,4							7,79 316		7,82 516		7,79 716			
090308EN	0,8							7,79 318		7,82 518		7,79 718			
120404EN	0,4	10,16 904		10,62 028		12,34 028		11,99 328		11,99 528		11,99 728		13,74 328	
120408EN	0,8	10,16 908		10,62 030		12,34 030		11,99 330		11,99 530		11,99 730		13,74 330	
120412EN	1,2					12,34 032		11,99 332		11,99 532		11,99 732		13,74 320	
P		●		●		●		●		●		●		●	
M		○		○		○		○		○		○		○	
K		○		○		○		○		○		○		○	
N															
S															
H															
O															

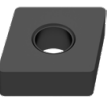
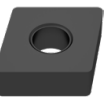
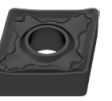
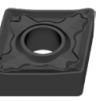
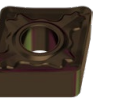
CNMG

		-TFQ CTCP125		-XU CTCP115		-XU CTCP125		-M50 CTCK110		-M50 CTCK120		-M50 CTCP115		-M50 CTCP125	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
															
		F		M		M		M		M		M		M	
		CNMG		CNMG		CNMG		CNMG		CNMG		CNMG		CNMG	
		76 110 ...		76 290 ...		76 290 ...		70 132 ...		70 132 ...		76 135 ...		76 135 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
120404EN	0,4	13,74	528	12,03	328	12,03	528	11,99	028	11,99	530	11,99	328	11,99	528
120408EN	0,8	13,74	530	12,03	330	12,03	530	11,99	030	11,99	530	11,99	330	11,99	530
120412EN	1,2	13,74	532	12,03	332	12,03	532	11,99	032	11,99	532	11,99	320	11,99	532
120416EN	1,6									11,99	532	11,99	334	11,99	534
160608EN	0,8											19,38	342	19,38	542
160612EN	1,2											19,38	344	19,38	544
160616EN	1,6											19,38	346	19,38	546
P			●		●		●		○		○		●		●
M															
K			○		○		○		●		●		○		○
N															
S															
H															
O															

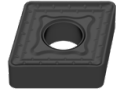
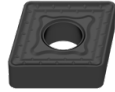
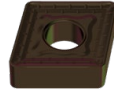
CNMG

		-M50 CTCP135		-TMQ CTCP115		-TMQ CTCP125		-M70 CTCK110		-M70 CTCK120		-M70 CTCP115		-M70 CTCP125	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
															
		M		M		M		M		M		M		M	
		CNMG		CNMG		CNMG		CNMG		CNMG		CNMG		CNMG	
		76 135 ...		76 196 ...		76 196 ...		70 119 ...		70 119 ...		76 119 ...		76 119 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
120404EN	0,4	11,99	728									11,99	330	11,99	530
120408EN	0,8	11,99	730	13,74	33000	13,74	530	11,99	030	11,99	530	11,99	330	11,99	530
120412EN	1,2	11,99	732	13,74	320	13,74	532	11,99	032	11,99	532	11,99	320	11,99	532
120416EN	1,6	11,99	734					11,99	034	11,99	534	11,99	334	11,99	534
160608EN	0,8	19,38	742					19,38	042	19,38	542	19,38	342	19,38	542
160612EN	1,2	19,38	744					19,38	044	19,38	544	19,38	344	19,38	544
160616EN	1,6	19,38	746					19,38	046	19,38	546	19,38	346	19,38	546
160624EN	2,4											19,38	348	19,38	548
190608EN	0,8											27,37	354	27,37	554
190612EN	1,2							27,37	056	27,37	556	27,37	356	27,37	556
190616EN	1,6							27,37	058	27,37	558	27,37	358	27,37	558
190624EN	2,4									27,37	560	27,37	360	27,37	560
P			●		●		●		○		○		●		●
M			○												
K					○		○		●		●		○		○
N															
S															
H															
O															

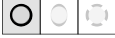
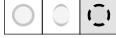
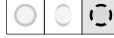
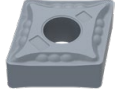
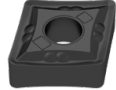
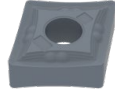
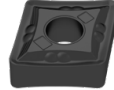
CNMG / CNMA / CNMM

		-M70 CTCP135		CTCK110		CTCK120		-R28 CTCP115		-R28 CTCP125		-R28 CTCP135		-R58 CTCP115	
		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin	
															
		M		R		R		R		R		R		R	
		CNMG		CNMA		CNMA		CNMM		CNMM		CNMM		CNMM	
		76 119 ...		70 100 ...		70 100 ...		76 114 ...		76 114 ...		76 114 ...		76 115 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
120404EN	0,4			11,99	028	11,99	528								
120408EN	0,8	11,99	730	11,99	030	11,99	530	12,21	330	12,21	530			12,21	330
120412EN	1,2	11,99	732	11,99	032	11,99	532	12,21	332	12,21	532	12,21	732	12,21	332
120416EN	1,6	11,99	734	11,99	034	11,99	534	12,21	334	12,21	534	12,21	734	12,21	334
160608EN	0,8	19,38	742	19,38	042	19,38	542								
160612EN	1,2	19,38	744	19,38	044	19,38	544	19,38	344	19,38	544	19,38	744	19,38	344
160616EN	1,6	19,38	746	19,38	046	19,38	546	19,38	346	19,38	546	19,38	746	19,38	346
160624EN	2,4	19,38	748											19,38	348
190608EN	0,8	27,37	754												
190612EN	1,2	27,37	756	27,37	056	27,37	556	27,37	356	27,37	556	27,37	756	27,37	356
190616EN	1,6	27,37	758	27,37	058	27,37	558	27,37	358	27,37	558	27,37	758	27,37	358
190624EN	2,4	27,37	760					27,37	360	27,37	560	27,37	760	27,37	360
250924EN	2,4							63,19	38400	63,19	58400	63,19	78400	63,19	384
P			●	○		○		●		●		●		●	
M			○									○			
K				●		●		○		○					○
N															
S															
H															
O															

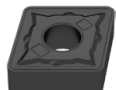
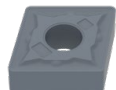
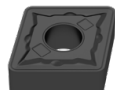
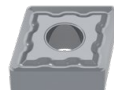
CNMM

		-R58 CTCP125		-R58 CTCP135		-R88 CTCP115		-R88 CTCP125		-R88 CTCP135	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
											
											
		R		R		R		R		R	
		CNMM		CNMM		CNMM		CNMM		CNMM	
		76 115 ...		76 115 ...		76 133 ...		76 133 ...		76 133 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
120408EN	0,8	12,21	530	12,21	730						
120412EN	1,2	12,21	532	12,21	732						
120416EN	1,6	12,21	534	12,21	734						
160612EN	1,2	19,38	544	19,38	744						
160616EN	1,6	19,38	546	19,38	746						
160624EN	2,4	19,38	548	19,38	748						
160624SN	2,4					19,38	348	19,38	548	19,38	748
190612EN	1,2	27,37	556	27,37	756						
190616EN	1,6	27,37	558	27,37	758						
190616SN	1,6					27,37	358	27,37	558	27,37	758
190624EN	2,4	27,37	524	27,37	760						
190624SN	2,4					27,37	360	27,37	560	27,37	760
250924EN	2,4	63,19	584	63,19	784						
250924SN	2,4					63,19	384	63,19	584	63,19	784
P			●		●		●		●		●
M					○						○
K			○				○		○		
N											
S											
H											
O											

CNMG

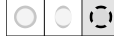
		NEW				NEW		NEW				NEW	
		-F30		-F30		-F30		-M30		-M30		-M30	
		CTCM120		CTPM125		CTCM130		CTCM120		CTPM125		CTCM130	
		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin	
													
													
		F		F		F		M		M		M	
		CNMG		CNMG		CNMG		CNMG		CNMG		CNMG	
		75 010 ...		75 010 ...		75 010 ...		75 011 ...		75 011 ...		75 011 ...	
ISO		EUR		EUR		EUR		EUR		EUR		EUR	
RE		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08	
120404EN	0,4	11,99	12800	11,99	280	11,99	32800	11,99	13000	11,99	230	11,99	33000
120408EN	0,8	11,99	13000	11,99	230	11,99	33000	11,99	13200	11,99	232	11,99	33200
120412EN	1,2							11,99	13400	11,99	234	11,99	33400
120416EN	1,6												
P			○		○		○		○		○		○
M			●		●		●		●		●		●
K													
N													
S							○						○
H													
O													

CNMG

		NEW				NEW		NEW	
		-M60		-M60		-M60		-M34	
		CTCM120		CTPM125		CTCM130		CTPX710	
		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin	
									
									
		M		M		M		M	
		CNMG		CNMG		CNMG		CNMG	
		75 012 ...		75 012 ...		75 012 ...		75 003 ...	
ISO		EUR		EUR		EUR		EUR	
RE		1A/08		1A/08		1A/08		1A/08	
120404EN	0,4							11,29	62800
120408EN	0,8	11,99	13000	11,99	230	11,99	33000	11,29	63000
120412EN	1,2	11,99	13200	11,99	232	11,99	33200	11,29	63200
120416EN	1,6	11,99	13400	11,99	234	11,99	33400	11,29	63400
P			○		○		○		●
M			●		●		●		●
K									
N									○
S							○		●
H									
O									

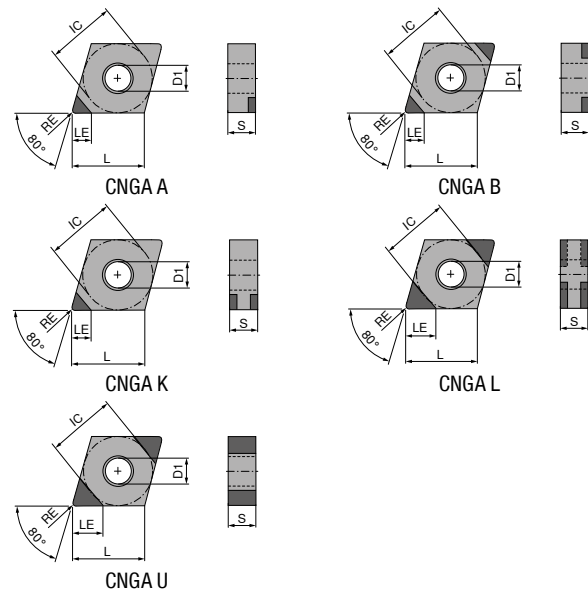
9

CNMG

		NEW		NEW		NEW		NEW		NEW	
		-FMS CT-P15		-FMS CT-P25		-MRS CT-P15		-MRS CT-P25		-MRS CT-P35	
											
											
		F		F		M		M		M	
		CNMG		CNMG		CNMG		CNMG		CNMG	
		75 302 ...		75 302 ...		75 303 ...		75 303 ...		75 303 ...	
ISO	RE mm	EUR 1S/1N		EUR 1S/1N		EUR 1S/1N		EUR 1S/1N		EUR 1S/1N	
120404EN	0,4	3,59	02809	3,59	12809						
120408EN	0,8	3,59	03009	3,59	13009	3,59	03009	3,59	13009	3,59	23009
120412EN	1,2	3,59	03209	3,59	13209	3,59	03209	3,59	13209	3,59	23209
120416EN	1,6					3,59	03409	3,59	13409	3,59	23409
160612EN	1,2					5,26	04409	5,26	14409	5,26	24409
160616EN	1,6					5,26	04609	5,26	14609	5,26	24609
190612EN	1,2					7,82	05609	7,82	15609	7,82	25609
190616EN	1,6					7,82	05809	7,82	15809	7,82	25809
P			●		●		●		●		●
M			○		○		○		○		○
K											
N											
S											
H											
O											

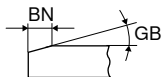
CNGA

Designation	L mm	S mm	D1 mm	IC mm
CNGA 1204..	12,9	4,76	5,13	12,7



CNGA

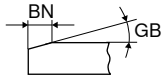
▲ TCE(NOI) = Design and number of equipped cutting edge corners



	NEW	NEW	NEW		
	CTBS10U	CTBS10C	CTBS20U	CTBS20C	CTBS20C
	F	F	F	F	F
	CBN	CBN	CBN	CBN	CBN
	CNGA	CNGA	CNGA	CNGA	CNGA
	71 406 ...	71 408 ...	71 406 ...	71 400 ...	71 401 ...
	EUR	EUR	EUR	EUR	EUR
	Y0	Y0	Y0	Y0	Y0
ISO	RE	BN	GB	TCE	LE
	mm	mm		(NOI)	mm
120402FN	0,2			A (1)	3,4
120402TN	0,2	0,12	20°	A (1)	3,4
120404SN	0,4	0,09	10°	L (4)	2,8
120404TN	0,4	0,09	15°	A (1)	3,1
120404TN	0,4	0,09	15°	L (4)	2,8
120404SN	0,4	0,09	15°	L (4)	2,8
120404SN	0,4	0,11	15°	K (2)	2,8
120404SN	0,4	0,11	15°	L (4)	2,8
120404SN	0,4	0,09	20°	L (4)	2,8
120404TN	0,4	0,12	20°	A (1)	3,1
120404SN	0,4	0,14	20°	K (2)	2,8
120404SN	0,4	0,14	20°	L (4)	2,8
120404TN	0,4	0,15	25°	L (4)	2,8
120404SN	0,4	0,18	30°	K (2)	2,8
120404FN	0,4			A (1)	3,1
120404SN	0,4	0,18	30°	L (4)	2,8
120408TN	0,8	0,09	10°	L (4)	2,5
120408SN	0,8	0,09	10°	L (4)	2,5
120408SN	0,8	0,09	15°	L (4)	2,5
120408TN	0,8	0,09	15°	L (4)	2,5
120408SN	0,8	0,11	15°	K (2)	2,5
P					
M					
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CNGA

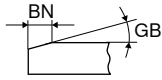
▲ TCE(NOI) = Design and number of equipped cutting edge corners



ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	71 406 ...		71 408 ...		71 406 ...		71 400 ...		71 401 ...	
						EUR	Y0	EUR	Y0	EUR	Y0	EUR	Y0	EUR	Y0
120408SN	0,8	0,11	15°	L (4)	2,5									61,52	16300
120408SN	0,8	0,09	20°	L (4)	2,5									61,52	154
120408TN	0,8	0,11	20°	L (4)	2,5										
120408TN	0,8	0,12	20°	A (1)	2,8	41,08	10500	74,70	80400						
120408SN	0,8	0,14	20°	K (2)	2,5							37,60	164		
120408SN	0,8	0,14	20°	L (4)	2,5									61,52	17200
120408TN	0,8	0,15	25°	L (4)	2,5			74,70	80500					61,52	18000
120408SN	0,8	0,16	25°	L (4)	2,5							37,60	184	61,52	184
120408SN	0,8	0,18	30°	K (2)	2,5									61,52	184
120408SN	0,8	0,18	30°	L (4)	2,5										
120408FN	0,8			A (1)	2,8	41,08	10400								
120412SN	1,2	0,09	10°	L (4)	2,2									61,52	126
120412TN	1,2	0,09	15°	L (4)	2,2			74,70	80600					61,52	136
120412SN	1,2	0,09	15°	L (4)	2,2										
120412SN	1,2	0,11	15°	K (2)	2,2							37,60	146	61,52	16400
120412SN	1,2	0,11	15°	L (4)	2,2									61,52	156
120412TN	1,2	0,12	20°	A (1)	2,5	41,08	10700								
120412SN	1,2	0,14	20°	K (2)	2,2							37,60	166	61,52	17300
120412SN	1,2	0,14	20°	L (4)	2,2										
120412TN	1,2	0,15	25°	L (4)	2,2			74,70	80700						
120412SN	1,2	0,18	30°	K (2)	2,2							37,60	186		
120412FN	1,2			A (1)	2,5	41,08	10600			41,08	20100				
120412SN	1,2	0,18	30°	L (4)	2,2									61,52	186
P															
M															
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CNGA

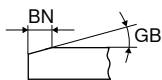
▲ TCE(NOI) = Design and number of equipped cutting edge corners



						CTBH15C	CTBH15C	NEW CTBH20U	CTBH20C	CTBH20C	NEW -Q CTBH20C
						F	F	F	F	F	F
						CBN CNGA	CBN CNGA	CBN CNGA	CBN CNGA	CBN CNGA	CBN CNGA
						71 003 ...	71 005 ...	71 406 ...	71 400 ...	71 401 ...	71 407 ...
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0
120402FN	0,2			A (1)	3,4			41,08 40000			
120402TN	0,2	0,12	20°	A (1)	3,4			41,08 40100			
120404TN	0,4	0,09	15°	K (2)	2,8				37,60 222		
120404TN	0,4	0,09	15°	L (4)	2,8					61,52 21200	
120404SN	0,4	0,11	15°	B (2)	3,0	71,93 32814					
120404SN	0,4	0,11	20°	K (2)	2,8				37,60 25800		
120404SN	0,4	0,11	20°	L (4)	2,8					61,52 242	
120404TN	0,4	0,12	20°	A (1)	3,1			41,08 40300			
120404TN	0,4	0,11	25°	K (2)	2,8				37,60 252		
120404FN	0,4			K (2)	2,8				37,60 212		
120404FN	0,4			A (1)	3,1			41,08 40200			
120404TN	0,4	0,11	25°	L (4)	2,8					61,52 25200	
120404SN	0,4	0,13	25°	L (4)	2,8					61,52 262	
120404SN	0,4	0,14	25°	B (2)	3,0	71,93 32829					
120404RN	0,4			B (2)	3,0	71,93 22800					
120404FN	0,4			L (4)	2,8					61,52 20200	
120408TN	0,8	0,09	15°	K (2)	2,5				37,60 224		
120408SN	0,8	0,11	15°	B (2)	2,7	71,93 33014					
120408TN	0,8	0,09	20°	K (2)	2,5				37,60 234		
120408SN	0,8	0,11	20°	K (2)	2,5				37,60 26000		
120408SN	0,8	0,11	20°	L (4)	2,5					61,52 244	
120408TN	0,8	0,12	20°	A (1)	2,8			41,08 40500			
120408TN	0,8	0,11	25°	K (2)	2,5				37,60 254		
120408TN	0,8	0,11	25°	L (4)	2,5					61,52 25300	
120408FN	0,8			L (4)	2,5					61,52 20300	
120408FN	0,8			A (1)	2,8			41,08 40400			
120408SN	0,8	0,13	25°	L (4)	2,5					61,52 264	
120408SN	0,8	0,14	25°	B (2)	2,7	71,93 33029					
120408SN	0,8	0,14	30°	L (4)	2,5					61,52 274	
120408RN	0,8			B (2)	2,7	71,93 23000					
120408FN	0,8			K (2)	2,5						41,50 30000
120412TN	1,2	0,09	15°	K (2)	2,2				37,60 226		
120412SN	1,2	0,11	15°	B (2)	2,4		71,93 33214				
120412SN	1,2	0,11	20°	K (2)	2,2				37,60 26200		
120412SN	1,2	0,11	20°	L (4)	2,2					61,52 246	
120412TN	1,2	0,11	25°	K (2)	2,2				37,60 256		
120412FN	1,2			K (2)	2,2				37,60 216		
120412TN	1,2	0,11	25°	L (4)	2,2					61,52 25400	
120412SN	1,2	0,13	25°	L (4)	2,2					61,52 266	
120412SN	1,2	0,14	25°	B (2)	2,4		71,93 33229				
120412RN	1,2			B (2)	2,4		71,93 23200				
P											
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CNGA

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



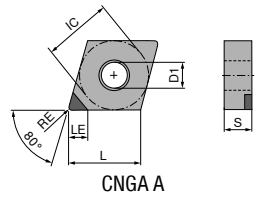
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	71 406 ...	71 400 ...	71 401 ...	71 407 ...	71 409 ...
120402FN	0,2			A (1)	3,4	EUR Y0 41,08 50000	EUR Y0			
120402TN	0,2	0,12	25°	A (1)	3,4	41,08 50100				
120404SN	0,4	0,09	20°	L (4)	2,8			61,52 332		
120404SN	0,4	0,11	20°	L (4)	2,8			61,52 34200		
120404SN	0,4	0,11	25°	K (2)	2,8		37,60 352			
120404SN	0,4	0,11	25°	L (4)	2,8			61,52 352		
120404TN	0,4	0,12	25°	A (1)	3,1	41,08 50300				
120404TN	0,4	0,08	30°	U (2)	2,8					135,50 70000
120404SN	0,4	0,14	30°	L (4)	2,8			61,52 372		
120404SN	0,4	0,14	35°	L (4)	2,8			61,52 38000		
120404FN	0,4			A (1)	3,1	41,08 50200				
120404SN	0,4	0,14	35°	K (2)	2,8		37,60 382			
120408SN	0,8	0,09	15°	L (4)	2,5			61,52 31200		
120408EN	0,8			L (4)	2,5			61,52 30200		
120408SN	0,8	0,09	20°	L (4)	2,5			61,52 334		
120408SN	0,8	0,11	20°	L (4)	2,5			61,52 34300		
120408SN	0,8	0,11	20°	K (2)	2,5		37,60 35800			
120408SN	0,8	0,11	25°	K (2)	2,5		37,60 354			
120408SN	0,8	0,11	25°	L (4)	2,5			61,52 354		
120408TN	0,8	0,12	25°	A (1)	2,8	41,08 50500		61,52 364		
120408SN	0,8	0,13	25°	L (4)	2,5		37,60 36200			
120408SN	0,8	0,13	25°	K (2)	2,5					135,50 70100
120408TN	0,8	0,08	30°	U (2)	2,6			61,52 374		
120408SN	0,8	0,14	30°	L (4)	2,5		37,60 38800	61,52 38100		
120408SN	0,8	0,14	30°	K (2)	2,5		37,60 314		41,50 60000	
120408SN	0,8	0,14	35°	L (4)	2,5			61,52 376		
120408EN	0,8			K (2)	2,5	41,08 50400				
120408FN	0,8			A (1)	2,8		37,60 384		74,70 60100	
120408SN	0,8	0,14	35°	K (2)	2,5					
120412SN	1,2	0,09	20°	L (4)	2,2			61,52 336		
120412SN	1,2	0,11	25°	K (2)	2,2		37,60 356			
120412SN	1,2	0,11	25°	L (4)	2,2			61,52 356		
120412TN	1,2	0,12	25°	A (1)	2,5	41,08 50700				
120412SN	1,2	0,13	25°	L (4)	2,2			61,52 366		
120412TN	1,2	0,08	30°	U (2)	2,4					135,50 70200
120412SN	1,2	0,14	30°	L (4)	2,2			61,52 376		
120412FN	1,2			A (1)	2,5	41,08 50600				
120412SN	1,2	0,14	35°	K (2)	2,2		37,60 386			
P										
M										
K										
N										
S										
H										
O										



For fast and efficient determination of the most appropriate edge preparation CNGA test inserts are available. → Page 218

CNGA

Designation	L mm	S mm	D1 mm	IC mm
CNGA 1204..	12,9	4,76	5,13	12,7



CNGA

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

ISO	RE mm	TCE (NOI)	LE mm
120404FN	0,4	A (1)	6,3
120408FN	0,8	A (1)	6,0
120412FN	1,2	A (1)	5,7

NEW

CTDPD20

F

DIAMOND

CNGA

71 127 ...

EUR

Y0

71,93 10001

71,93 10101

81,62 10201

NEW

CTDPS30

F

DIAMOND

CNGA

71 127 ...

EUR

Y0

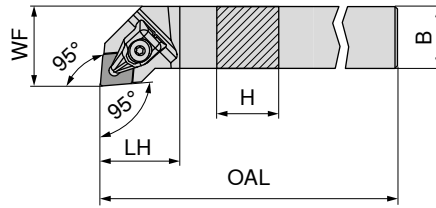
71,93 20001

71,93 20101

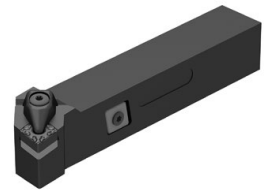
81,62 20201

P		
M		
K		
N	•	•
S		
H		
O	•	•

MaxiLock-D – DCLN 95° – Toolholder with top clamping



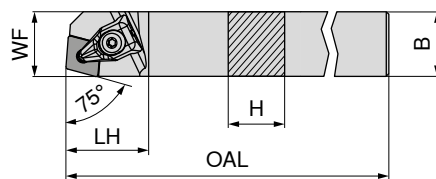
Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand		Right-hand	
								70 509 ...		70 508 ...	
								EUR 2A/24		EUR 2A/24	
DCLN R/L 1616 H09	16	16	100	23	20	2	CN.. 0903	78,62	516	78,62	516
DCLN R/L 2020 K09	20	20	125	24	25	2	CN.. 0903	87,59	520	87,59	520
DCLN R/L 2020 K12	20	20	125	32	25	4	CN.. 1204	87,59	620	87,59	620
DCLN R/L 2525 M12	25	25	150	32	32	4	CN.. 1204	90,61	625	90,61	625
DCLN R/L 3225 P12	32	25	170	32	32	4	CN.. 1204	97,20	632	97,20	632
DCLN R/L 2525 M16	25	25	150	38	32	6,5	CN.. 1606	90,61	725	90,61	725
DCLN R/L 3232 P16	32	32	170	36	40	6,5	CN.. 1606	122,40	732	122,40	732
DCLN R/L 3232 P19	32	32	170	42	40	6,5	CN.. 1906	122,40	832	122,40	832
DCLN R/L 4040 S19	40	40	250	42	50	6,5	CN.. 1906	152,10	940	152,10	940
DCLN R/L 4040 S25	40	40	250	60	50	6,5	CN.. 2509	152,10	440	152,10	440

										
	XPress type		Key D		Clamping screw		Carbide type C			
	70 950 ...		80 950 ...		70 950 ...		70 950 ...			
Spare parts for Article no.	EUR 2A/28		EUR Y7		EUR 2A/28		EUR 2A/28			
70 508 516 / 70 509 516	24,82	823	T09 - IP	11,58	126	M3x7 - IP	3,30	819	7,48	848
70 508 520 / 70 509 520	24,82	823	T09 - IP	11,58	126	M3x7 - IP	3,30	819	7,48	848
70 508 620 / 70 509 620	24,48	824	T15 - IP	12,25	128	M4,5x12 - IP	3,13	820	8,28	810
70 508 625 / 70 509 625	24,48	824	T15 - IP	12,25	128	M4,5x12 - IP	3,13	820	8,28	810
70 508 632 / 70 509 632	24,48	824	T15 - IP	12,25	128	M4,5x12 - IP	3,13	820	8,28	810
70 508 725 / 70 509 725	27,49	825	T20 - IP	12,92	129	M5x14 - IP	4,44	821	12,65	814
70 508 732 / 70 509 732	27,49	825	T20 - IP	12,92	129	M5x14 - IP	4,44	821	12,65	814
70 508 832 / 70 509 832	30,07	826	T20 - IP	12,92	129	M5x14 - IP	4,44	821	13,56	816
70 508 940 / 70 509 940	30,07	826	T20 - IP	12,92	129	M5x14 - IP	4,44	821	13,56	816
70 508 440 / 70 509 440	47,74	827	T25 - IP	14,94	130	M6x16 - IP	8,44	822	25,99	625

MaxiLock-D – DCBN 75° – Toolholder with top clamping



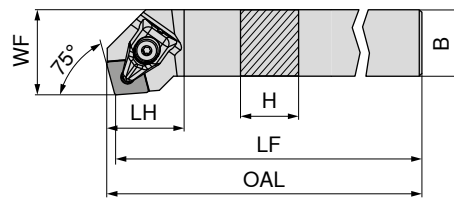
Illustrations show right-hand versions



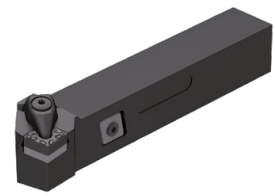
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand		Right-hand	
								70 501 ...		70 500 ...	
								EUR 2A/24		EUR 2A/24	
DCBN R/L 2525 M12	25	25	150	32	22	4	CN.. 1204	87,59	825	87,59	825

				
	XPRESS type	Key D	Clamping screw	Carbide type C
	70 950 ...	80 950 ...	70 950 ...	70 950 ...
Spare parts for Article no.	EUR 2A/28	EUR Y7	EUR 2A/28	EUR 2A/28
70 501 825 / 70 500 825	24,48 824	12,25 128	3,13 820	8,28 810

MaxiLock-D – DCKN 75° – Toolholder with top clamping



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LF mm	LH mm	WF mm	torque moment Nm	Insert
DCKN R/L 2525 M12	25	25	152,9	150	28,9	32	4	CN.. 1204

Left-hand	Right-hand
70 505 ...	70 504 ...
EUR 2A/24 87,59	EUR 2A/24 87,59
825	825

Spare parts
for Article no.

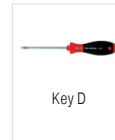
70 505 825 / 70 504 825



XPress type

70 950 ...EUR
2A/28
24,48

824



Key D

80 950 ...EUR
Y7
12,25

128



Clamping screw

70 950 ...EUR
2A/28
3,13

820

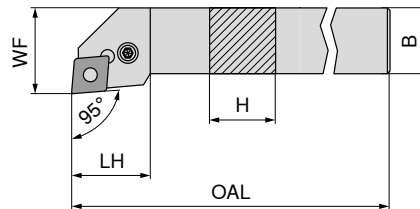


Carbide type C

70 950 ...EUR
2A/28
8,28

810

MaxiLock-N – PCLN 95° – Toolholder with lever clamping



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert
PCLN R/L 1616 H12	16	16	100	26,2	20	4	CN.. 1204
PCLN R/L 2020 K12	20	20	125	27,5	25	4	CN.. 1204
PCLN R/L 2525 M12	25	25	150	28,1	32	4	CN.. 1204
PCLN R/L 3225 P12	32	25	170	28,1	32	4	CN.. 1204
PCLN R/L 2525 M16	25	25	150	32,7	32	4	CN.. 1606
PCLN R/L 3232 P16	32	32	170	32,6	40	4	CN.. 1606
PCLN R/L 3232 P19	32	32	170	38,0	40	8	CN.. 1906
PCLN R/L 4040 S19	40	40	250	38,0	50	8	CN.. 1906
PCLN R/L 4040 S25	40	40	250	50,0	50	8	CN.. 2509

Left-hand	Right-hand
70 509 ...	70 508 ...
EUR 2A/24 78,62	EUR 2A/24 78,62
016	016
87,59	87,59
020	020
90,61	90,61
025	025
97,20	97,20
032	032
90,61	90,61
125	125
122,40	122,40
132	132
122,40	122,40
232	232
152,10	152,10
54000	54000
152,10	152,10
340	340

Spare parts
for Article no.

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



Key I

70 950 ...EUR
2A/28
2,57

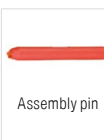
176



Shim

70 950 ...EUR
2A/28
1,85

198



Assembly pin

70 950 ...EUR
2A/28
1,28

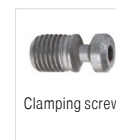
192



Lever

70 950 ...EUR
2A/28
13,22

187



Clamping screw

70 950 ...EUR
2A/28
3,68

209

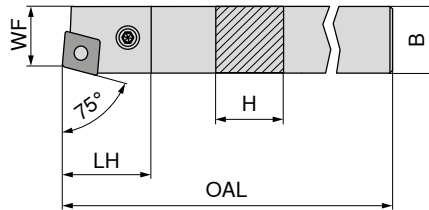


Carbide type C

70 950 ...EUR
2A/28
8,28

233

MaxiLock-N – PCBN 75° – Toolholder with lever clamping



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert
PCBN R/L 2525 M12	25	25	150	27,70	22	4	CN.. 1204
PCBN R/L 2525 M16	25	25	150	31,81	22	4	CN.. 1606
PCBN R/L 3232 P19	32	32	170	38,00	27	8	CN.. 1906

Left-hand		Right-hand	
70 501 ...		70 500 ...	
EUR 2A/24		EUR 2A/24	
87,59	025	87,59	025
87,59	12500	87,59	125
122,40	032	122,40	032

Spare parts
for Article no.

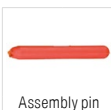
	SW3	SW3	SW3	SW3	SW3	SW3
70 500 025 / 70 501 025	2,57	176	1,85	198	1,28	192
70 500 125 / 70 501 12500	2,57	176	1,18	391	1,28	394
70 500 032 / 70 501 032	2,70	396	1,85	392	1,28	395



Key I



Shim



Assembly pin



Lever

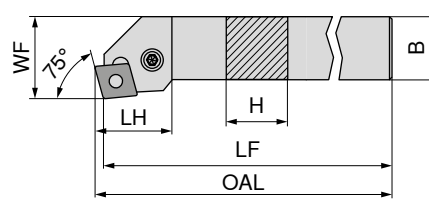


Clamping screw



Carbide type C

MaxiLock-N – PCKN 75° – Toolholder with lever clamping



Illustrations show right-hand versions

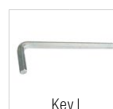


ISO designation	H mm	B mm	OAL mm	LF mm	LH mm	WF mm	torque moment Nm	Insert
PCKN R/L 2525 M12	25	25	153,07	150	31,4	32	4	CN.. 1204

Left-hand		Right-hand	
70 505 ...		70 504 ...	
EUR 2A/24		EUR 2A/24	
87,59	025	87,59	025

Spare parts
for Article no.

	SW3	SW3	SW3	SW3	SW3	SW3
70 505 025 / 70 504 025	2,57	176	1,85	198	1,28	192
					13,22	187
					3,68	209
					8,28	233



Key I



Shim



Assembly pin



Lever

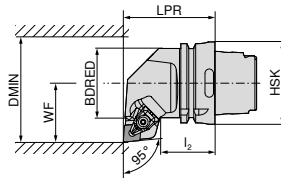


Clamping screw



Carbide type C

MaxiLock-D – DCLN 95° – Toolholder with top clamping



Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	l ₂ mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 504 ...		Right-hand 74 503 ...	
									EUR 2D/80		EUR 2D/80	
HSK T63 DCLN R/L 12	HSK-T 63	70	42	53	45	100	4	CN.. 1204	236,00	512	236,00	512
HSK T63 DCLN R/L 16	HSK-T 63	70	42	53	45	125	4	CN.. 1606	236,00	516	236,00	516
HSK T63 DCLN R/L 19	HSK-T 63	70	42	53	45	125	8	CN.. 1906	236,00	519	236,00	519
HSK T100 DCLN R/L 12	HSK-T 100	80	45	88	55	125	4	CN.. 1204	277,00	712	277,00	712
HSK T100 DCLN R/L 19	HSK-T 100	80	45	88	55	125	8	CN.. 1906	277,00	719	277,00	719

Spare parts
for Article no.

74 504 512 / 74 503 512	24,48	824	T15 - IP	12,25	128	M4,5x12 - IP	3,13	820	8,28	810
74 504 516 / 74 503 516	27,49	825	T20 - IP	12,92	129	M5x14 - IP	4,44	821	12,65	814
74 504 519 / 74 503 519	30,07	826	T20 - IP	12,92	129	M5x14 - IP	4,44	821	13,56	816
74 504 712 / 74 503 712	24,48	824	T15 - IP	12,25	128	M4,5x12 - IP	3,13	820	8,28	810
74 504 719 / 74 503 719	30,07	826	T20 - IP	12,92	129	M5x14 - IP	4,44	821	13,56	816



XPress type



Key D

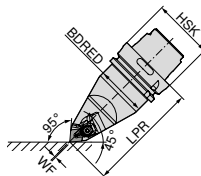


Clamping screw



Carbide type C

MaxiLock-D – DCMN 95° – Toolholder with top clamping



ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert	Neutral 74 506 ...	
							EUR 2D/80	
HSK T63 DCMN N 12	HSK-T 63	115	53	0	4	CN.. 1204	323,60	512
HSK T100 DCMN N 12	HSK-T 100	150	88	0	4	CN.. 1204	380,60	712

Spare parts
for Article no.

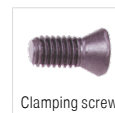
74 506 512	24,48	824	T15 - IP	12,25	128	M4,5x12 - IP	3,13	820	8,28	810
74 506 712	24,48	824	T15 - IP	12,25	128	M4,5x12 - IP	3,13	820	8,28	810



XPress type



Key D



Clamping screw

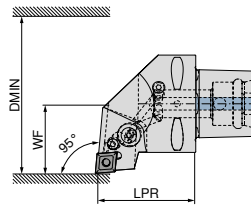


Carbide type C

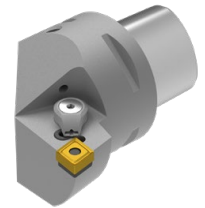
MaxiLock-N – PCLN 95° – Toolholder with lever clamping

Scope of supply:

without high-performance coolant set



Illustrations show right-hand versions



ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Direct cooling compatible	NEW Left-hand 84 657 ...		NEW Right-hand 84 656 ...	
								EUR Y8		EUR Y8	
PSC40 PCLN R/L 50050-12	PSC 40	50	27	50	5	CN.. 1204	DC	229,30	01295	229,30	01295
PSC50 PCLN R/L 65060-12	PSC 50	60	35	65	5	CN.. 1204	DC	252,50	01294	252,50	01294
PSC63 PCLN R/L 80065-12	PSC 63	65	45	80	5	CN.. 1204	DC	286,70	01293	286,70	01293



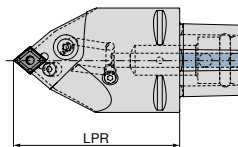
The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → Page 42.

				
	Shim	Elbow lever screw	Lever	Carbide type C
	84 950 ...	84 950 ...	84 950 ...	84 950 ...
Spare parts	EUR	EUR	EUR	EUR
Adapter	Y8	Y8	Y8	Y8
PSC 40	1,16 29200	M8X1/L17 SW3 4,55 28700	13,47 29000	13,38 27800
PSC 50	1,16 29200	M8X1/L17 SW3 4,55 28700	13,47 29000	13,38 27800
PSC 63	1,16 29200	M8X1/L17 SW3 4,55 28700	13,47 29000	13,38 27800

MaxiLock-N – PCMN 50° – Toolholder with lever clamping

Scope of supply:

without high-performance coolant set



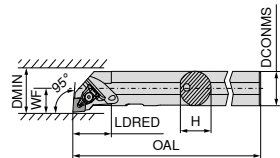
ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Direct cooling compatible	NEW Neutral 84 675 ...	
						EUR Y8	
PSC63 PCMN N 0100-12	PSC 63	100	5	CN.. 1204	DC	286,70	01293
PSC63 PCMN N 0130-12	PSC 63	130	5	CN.. 1204	DC	286,70	11293



The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → Page 42.

				
	Shim	Elbow lever screw	Lever	Carbide type C
	84 950 ...	84 950 ...	84 950 ...	84 950 ...
Spare parts	EUR	EUR	EUR	EUR
Adapter	Y8	Y8	Y8	Y8
PSC 63	1,16 29200	M8X1/L17 SW3 4,55 28700	13,47 29000	13,38 27800

MaxiLock-D – DCLN 95° – Boring bar with top clamping



Illustrations show right-hand versions

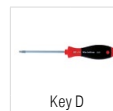


ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									70 557 ...		70 556 ...	
									EUR 2A/24		EUR 2A/24	
A20Q DCLN R/L 09	20	19	180	35	13	25	2	CN.. 0903	205,40	720	205,40	720
A25R DCLN R/L 12	25	24	200	36	17	32	4	CN.. 1204	228,90	825	228,90	825
A32S DCLN R/L 12	32	31	250	40	22	40	4	CN.. 1204	236,70	832	236,70	832
A40T DCLN R/L 12	40	39	300	45	27	50	4	CN.. 1204	263,70	840	263,70	840
A40U DCLN L 16	50	47	350	45	35	63	6,5	CN.. 1606	326,30	85000		



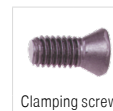
XPress type

70 950 ...

EUR
2A/28

Key D

80 950 ...

EUR
Y7

Clamping screw

70 950 ...

EUR
2A/28

Carbide type C

70 950 ...

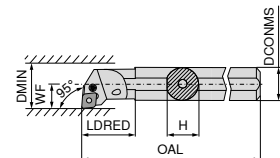
EUR
2A/28Spare parts
for Article no.

70 556 720 / 70 557 720	24,82	823	T09 - IP	11,58	126	M3x7 - IP	3,30	819		848
70 556 825 / 70 557 825	24,48	824	T15 - IP	12,25	128	M4,5x12 - IP	3,13	820		
70 556 832 / 70 557 832	24,48	824	T15 - IP	12,25	128	M4,5x12 - IP	3,13	820	8,28	810
70 556 840 / 70 557 840	24,48	824	T15 - IP	12,25	128	M4,5x12 - IP	3,13	820	8,28	810
70 557 85000	27,49	825	T20 - IP	12,92	129	M5x14 - IP	4,44	821	12,65	814

MaxiLock-N – PCLN 95° – Boring bar with lever clamping

▲ A... = with thro' coolant

▲ S... = without thro' coolant



Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									70 557 ...		70 556 ...	
									EUR 2A/24		EUR 2A/24	
A25R PCLN R/L 12	25	23	200	36,0	17	32	4	CN.. 1204	228,90	225	228,90	225
S25T PCLN R/L 12	25	23	300	22,0	17	32	4	CN.. 1204	228,90	025	228,90	025
A32S PCLN R/L 12	32	30	250	50,0	22	40	4	CN.. 1204	236,70	232	236,70	232
S32U PCLN R/L 12	32	30	350	24,1	22	40	4	CN.. 1204	236,70	032	236,70	032
A40T PCLN R/L 12	40	38	300	60,0	27	50	4	CN.. 1204	263,70	240	263,70	240
S40V PCLN R/L 12	40	38	400	24,1	27	50	4	CN.. 1204	263,70	040	263,70	04000 ¹⁾
S50W PCLN R/L 16	50	47	450	31,0	35	63	4	CN.. 1606	326,30	050	326,30	050

1) nickel-plated



Key I

70 950 ...

EUR
2A/28

Shim

70 950 ...

EUR
2A/28

Assembly pin

70 950 ...

EUR
2A/28

Lever

70 950 ...

EUR
2A/28

Clamping screw

70 950 ...

EUR
2A/28

Carbide type C

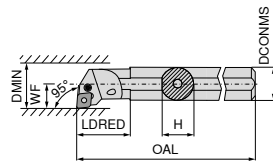
70 950 ...

EUR
2A/28Spare parts
for Article no.

70 556 225 / 70 557 225	SW3	2,57	176	1,85	198	1,28	192	13,22	187	4,49	205	8,28	233
70 556 025 / 70 557 025	SW3	2,57	176	1,85	198	1,28	192	13,22	187	4,49	205	8,28	233
70 556 232 / 70 557 232	SW3	2,57	176	1,85	198	1,28	192	13,22	187	4,49	205	8,28	233
70 556 032 / 70 557 032	SW3	2,57	176	1,85	198	1,28	192	13,22	187	4,49	205	8,28	233
70 556 240 / 70 557 240	SW3	2,57	176	1,85	198	1,28	192	13,22	187	3,68	209	8,28	233
70 556 04000 / 70 557 040	SW3	2,57	176	1,85	198	1,28	192	13,22	187	3,68	209	8,28	233
70 556 050 / 70 557 050	SW3	2,57	176	1,18	391	1,28	394	13,10	385	3,99	388	13,10	380

MaxiLock-N – PCLN 95° – Boring bar with lever clamping

▲ with carbide core



Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 559 ...		Right-hand 70 558 ...	
									EUR 2A		EUR 2A	
E-A25R PCLN R/L 12	25	23	200	40	17	31	4	CN.. 1204	745,10	025	745,10	025
E-A32S PCLN R/L 12	32	30	250	50	22	39	4	CN.. 1204	983,50	032	983,50	032
E-A40T PCLN R/L 12	40	38	300	60	27	48	4	CN.. 1204	1.174,00	040	1.174,00	040

Spare parts
for Article no.

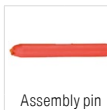
				70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	
				EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28	
70 558 025 / 70 559 025			SW3	2,57	176	1,85	198	1,28	192	13,22	187	4,49	205	8,28	233		
70 558 032 / 70 559 032			SW3	2,57	176	1,85	198	1,28	192	13,22	187	4,49	205	8,28	233		
70 558 040 / 70 559 040			SW3	2,57	176	1,85	198	1,28	192	13,22	187	3,68	209	8,28	233		



Key I



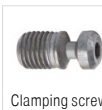
Shim



Assembly pin



Lever

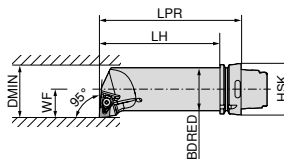


Clamping screw



Carbide type C

MaxiLock-D – DCLN 95° – Boring bar with top clamping



Illustrations show right-hand versions



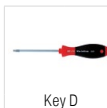
ISO designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 529 ...		Right-hand 74 528 ...	
									EUR 2D/80		EUR 2D/80	
HSK T63 50Q DCLN R/L 12	HSK-T 63	175	149	50	35	63	4	CN.. 1204	323,60	512	323,60	512

Spare parts
for Article no.

				70 950 ...		80 950 ...		70 950 ...		70 950 ...	
				EUR 2A/28		EUR Y7		EUR 2A/28		EUR 2A/28	
74 528 512 / 74 529 512				24,48	824	12,25	128	3,13	820	8,28	810



XPress type



Key D



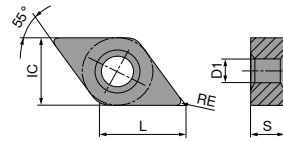
Clamping screw



Carbide type C

DNMG / DNMA / DNMM

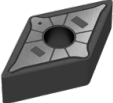
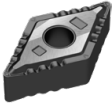
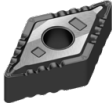
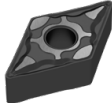
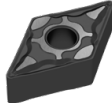
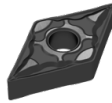
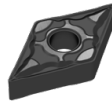
Designation	L mm	S mm	D1 mm	IC mm
DNMG 1104..	11,6	4,76	3,81	9,52
DNMG 1504..	15,5	4,76	5,16	12,70
DNM. 1506..	15,5	6,35	5,16	12,70



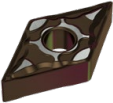
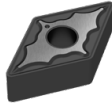
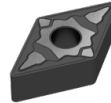
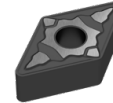
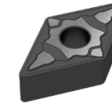
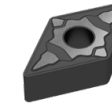
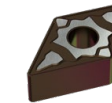
DNMG

		-CF TCM10		-CF20 CTEP110		-TFQ CTEP110		-F50 CTCP115		-F50 CTCP125		-F50 CTCP135		-TFQ CTCP115	
		DRAGONS SKIN		DRAGONS SKIN		DRAGONS SKIN		DRAGONS SKIN		DRAGONS SKIN		DRAGONS SKIN		DRAGONS SKIN	
		F		F		F		F		F		F		F	
		CERMET DNMG		CERMET DNMG		CERMET DNMG		DNMG		DNMG		DNMG		DNMG	
		70 155 ...		76 102 ...		76 153 ...		76 134 ...		76 134 ...		76 134 ...		76 153 ...	
ISO	RE mm	EUR 1A/78		EUR 1A/78		EUR 1A/78		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
110402EN	0,2							12,80	302	12,80	502	12,80	702		
110404EN	0,4	12,21	904	12,80	004			12,80	304	12,80	504	12,80	704		
110408EN	0,8			12,80	006			12,80	306	12,80	506	12,80	706		
110412EN	1,2							12,80	308	12,80	508	12,80	708		
150404EN	0,4							15,51	316	15,51	516	15,51	716		
150408EN	0,8							15,51	318	15,51	518	15,51	718		
150412EN	1,2							15,51	320	15,51	520	15,51	720		
150604EN	0,4	15,99	914	16,80	028	18,68	028	16,80	328	16,80	528	16,80	728	19,38	32800
150608EN	0,8			16,80	030	18,68	030	16,80	330	16,80	530	16,80	730	19,38	330
150612EN	1,2			16,80	032			16,80	332	16,80	532	16,80	732		
P			●		●		●		●		●		●		●
M			○		○		○		○		○		○		○
K			○		○		○		○		○		○		○
N															
S															
H															
O															

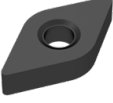
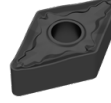
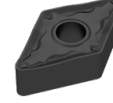
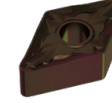
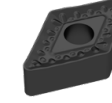
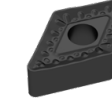
DNMG

		-TFQ CTCP125		-XU CTCP115		-XU CTCP125		-M50 CTCK110		-M50 CTCK120		-M50 CTCP115		-M50 CTCP125	
		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin	
															
															
		F		M		M		M		M		M		M	
		DNMG		DNMG		DNMG		DNMG		DNMG		DNMG		DNMG	
		76 153 ...		76 291 ...		76 291 ...		70 133 ...		70 133 ...		76 136 ...		76 136 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
110404EN	0,4											12,80	304	12,80	504
110408EN	0,8											12,80	306	12,80	506
110412EN	1,2											12,80	308	12,80	508
150404EN	0,4											15,51	316	15,51	514
150408EN	0,8							15,51	018	15,51	518	15,51	318	15,51	518
150412EN	1,2							15,51	020	15,51	520	15,51	320	15,51	516
150416EN	1,6											15,51	322	15,51	522
150604EN	0,4	19,38	528	16,80	328	16,80	528					16,80	328	16,80	528
150608EN	0,8	19,38	530	16,80	330	16,80	530	16,80	030	16,80	530	16,80	330	16,80	530
150612EN	1,2			16,80	332	16,80	532	16,80	032	16,80	532	16,80	332	16,80	532
150616EN	1,6											16,80	334	16,80	534
P			●		●		●		○		○		●		●
M															
K			○		○		○		●		●		○		○
N															
S															
H															
O															

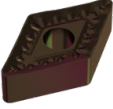
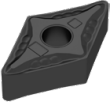
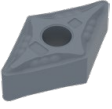
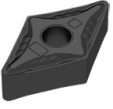
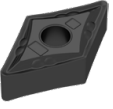
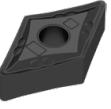
DNMG

		-M50 CTCP135		-TMQ CTCP125		-M70 CTCK110		-M70 CTCK120		-M70 CTCP115		-M70 CTCP125		-M70 CTCP135	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
															
		M		M		M		M		M		M		M	
		DNMG		DNMG		DNMG		DNMG		DNMG		DNMG		DNMG	
		76 136 ...		76 197 ...		70 263 ...		70 263 ...		76 263 ...		76 263 ...		76 263 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
110404EN	0,4	12,80	704												
110408EN	0,8	12,80	706							12,80	306	12,80	506	12,80	706
110412EN	1,2	12,80	708							12,80	308	12,80	508	12,80	708
150404EN	0,4	15,51	716												
150408EN	0,8	15,51	718			15,51	018	15,51	518	15,51	318	15,51	518	15,51	718
150412EN	1,2	15,51	720			15,51	020	15,51	520	15,51	320	15,51	520	15,51	720
150416EN	1,6	15,51	722							15,51	322	15,51	522	15,51	722
150604EN	0,4	16,80	728												
150608EN	0,8	16,80	730	19,38	530	16,80	030	16,80	530	16,80	330	16,80	530	16,80	730
150612EN	1,2	16,80	732	19,38	532	16,80	032	16,80	532	16,80	332	16,80	532	16,80	732
150616EN	1,6	16,80	734			16,80	034	16,80	534	16,80	334	16,80	534	16,80	734
P			●		●		○		○		●		●		●
M			○												○
K					○		●		●		○		○		
N															
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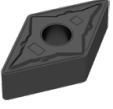
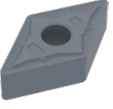
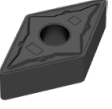
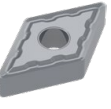
DNMA / DNMM

		CTCK110		CTCK120		-R28 CTCP115		-R28 CTCP125		-R28 CTCP135		-R58 CTCP115		-R58 CTCP125	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
															
		R		R		R		R		R		R		R	
		DNMA		DNMA		DNMM		DNMM		DNMM		DNMM		DNMM	
		70 156 ...		70 156 ...		76 165 ...		76 165 ...		76 165 ...		76 166 ...		76 166 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
150408EN	0,8	15,51	018	15,51	518										
150412EN	1,2	15,51	020	15,51	520										
150608EN	0,8	16,80	030	16,80	530										
150612EN	1,2	16,80	032	16,80	532	16,80	332	16,80	532	16,80	732	16,80	332	16,80	532
150616EN	1,6					16,80	334	16,80	534	16,80	734	16,80	334	16,80	534
P			○		○		●		●		●		●		●
M											○				
K			●		●		○		○				○		○
N															
S															
H															
O															

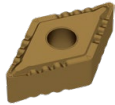
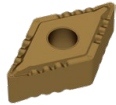
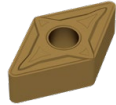
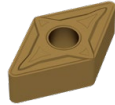
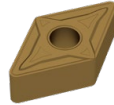
DNMM / DNMG

		NEW		NEW		NEW		NEW	
		-R58 CTCP135	-F30 CTCM120	-F30 CTPM125	-F30 CTCM130	-M30 CTCM120	-M30 CTPM125	-M30 CTCM130	
		DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin	
									
		R DNMM	F DNMG	F DNMG	F DNMG	M DNMG	M DNMG	M DNMG	
		76 166 ...	75 013 ...	75 013 ...	75 013 ...	75 014 ...	75 014 ...	75 014 ...	
ISO	RE mm	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08	
110404EN	0,4		12,80 10400	12,80 204	12,80 30400	12,80 10600	12,80 206	12,80 30600	
110408EN	0,8		12,80 10600	12,80 206	12,80 30600	12,80 10800	12,80 208	12,80 30800	
110412EN	1,2								
150604EN	0,4		16,80 12800	16,80 228	16,80 32800				
150608EN	0,8		16,80 13000	16,80 230	16,80 33000	16,80 13000	16,80 230	16,80 33000	
150612EN	1,2	16,80 732				16,80 13200	16,80 232	16,80 33200	
150616EN	1,6	16,80 734							
P		●	○	○	○	○	○	○	
M		○	●	●	●	●	●	●	
K									
N									
S					○			○	
H									
O									

DNMG

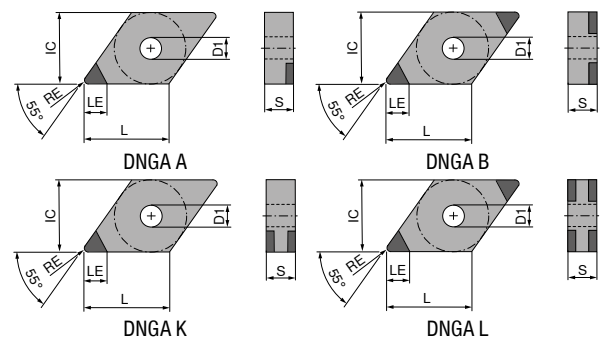
		NEW		NEW		NEW	
		-M60 CTCM120	-M60 CTPM125	-M60 CTCM130	-M34 CTPX710		
		DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin		
							
		M DNMG	M DNMG	M DNMG	M DNMG		
		75 015 ...	75 015 ...	75 015 ...	75 004 ...		
ISO	RE mm	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08		
150404EN	0,4				16,20 61600		
150408EN	0,8				16,20 61800		
150412EN	1,2				16,20 62000		
150608EN	0,8	16,80 13000	16,80 230	16,80 33000	17,75 63000		
150612EN	1,2	16,80 13200	16,80 232	16,80 33200	17,75 63200		
P		○	○	○	●		
M		●	●	●	●		
K							
N					○		
S				○	●		
H							
O							

DNMG

		NEW		NEW		NEW		NEW		NEW	
		-FMS CT-P15		-FMS CT-P25		-MRS CT-P15		-MRS CT-P25		-MRS CT-P35	
											
											
		F		F		M		M		M	
		DNMG		DNMG		DNMG		DNMG		DNMG	
		75 306 ...		75 306 ...		75 307 ...		75 307 ...		75 307 ...	
		EUR		EUR		EUR		EUR		EUR	
		1S/1N		1S/1N		1S/1N		1S/1N		1S/1N	
ISO	RE mm										
150404EN	0,4	4,62	01609	4,62	11609						
150408EN	0,8	4,62	01809	4,62	11809	4,62	01809	4,62	11809		
150604EN	0,4	4,85	02809	4,85	12809						
150608EN	0,8	4,85	03009	4,85	13009	4,85	03009	4,85	13009	4,85	23009
150612EN	1,2	4,85	03209	4,85	13209	4,85	03209	4,85	13209	4,85	23209
150616EN	1,6					4,85	03409	4,85	13409	4,85	23409
P			●		●		●		●		●
M			○		○		○		○		○
K											
N											
S											
H											
O											

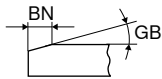
DNGA

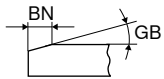
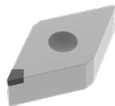
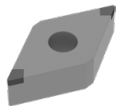
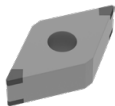
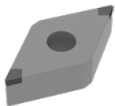
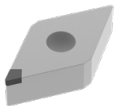
Designation	L mm	S mm	D1 mm	IC mm
DNGA 1504..	15,5	4,76	5,13	12,7
DNGA 1506..	15,5	6,35	5,16	12,7
DNGA 1506..	15,5	6,35	5,13	12,7



DNGA

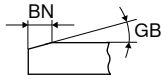
▲ TCE(NOI) = Design and number of equipped cutting edge corners



						NEW CTBS20U   F CBN DNGA 71 410 ... EUR Y0		NEW CTBS20C   F CBN DNGA 71 411 ... EUR Y0		CTBS20C   F CBN DNGA 71 403 ... EUR Y0		CTBH15C   F CBN DNGA 71 017 ... EUR Y0		NEW CTBH20U   F CBN DNGA 71 410 ... EUR Y0	
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm										
150604SN	0,4	0,09	10°	L (4)	2,8										
150604SN	0,4	0,09	15°	L (4)	2,8										
150604TN	0,4	0,09	15°	A (1)	3,5	41,08	20000			61,52	122				
150604SN	0,4	0,11	15°	B (2)	2,8					61,52	132				
150604SN	0,4	0,09	20°	L (4)	2,8							71,93	32814		
150404SN	0,4	0,09	20°	L (4)	2,8					61,52	152				
150604SN	0,4	0,09	20°	K (2)	2,8		41,50	20000		61,52	10200				
150604TN	0,4	0,12	20°	A (1)	3,5									41,08	40500
150404TN	0,4	0,12	20°	A (1)	3,5									41,08	40100
150604SN	0,4	0,14	25°	B (2)	2,8							71,93	32829		
150604FN	0,4			A (1)	3,5									41,08	40400
150604SN	0,4	0,18	30°	L (4)	2,8					61,52	182			41,08	40000
150404FN	0,4			A (1)	3,5										
150608SN	0,8	0,09	10°	L (4)	2,6					61,52	124				
150608SN	0,8	0,09	15°	L (4)	2,6					61,52	134				
150608TN	0,8	0,09	15°	A (1)	3,0	41,08	20100								
150608TN	0,8	0,09	15°	A (1)	5,0	73,04	20200								
150608SN	0,8	0,11	15°	K (2)	2,6			41,50	20100						
150608SN	0,8	0,11	15°	B (2)	2,6							71,93	33014		
150608SN	0,8	0,09	20°	L (4)	2,6					61,52	154				
150408SN	0,8	0,09	20°	L (4)	2,6					61,52	10300				
150608TN	0,8	0,12	20°	A (1)	3,0									41,08	40700
150408TN	0,8	0,12	20°	A (1)	3,0									41,08	40300
150608SN	0,8	0,14	25°	B (2)	2,6							71,93	33029		
150608SN	0,8	0,16	25°	K (2)	2,6		41,50	20200							
150608SN	0,8	0,18	30°	L (4)	2,6					61,52	184				
150608FN	0,8			A (1)	3,0									41,08	40600
150408FN	0,8			A (1)	3,0									41,08	40200
150612SN	1,2	0,11	15°	B (2)	2,8							71,93	33214		
150612SN	1,2	0,14	25°	B (2)	2,8							71,93	33229		
P															
M															
K															
N															
S															
H															
O															

DNGA

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

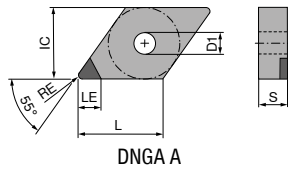


ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	71 402 ... EUR Y0	71 403 ... EUR Y0	71 410 ... EUR Y0	71 402 ... EUR Y0	71 403 ... EUR Y0
150604FN	0,4			A (1)	3,5					
150604TN	0,4	0,09	15°	K (2)	2,8	37,60				
150604SN	0,4	0,09	20°	K (2)	2,8				37,60	
150404SN	0,4	0,09	20°	L (4)	2,8					61,52
150604SN	0,4	0,09	20°	L (4)	2,8					61,52
150404SN	0,4	0,11	20°	L (4)	2,8					61,52
150604SN	0,4	0,11	20°	K (2)	2,8	37,60				
150604SN	0,4	0,11	20°	L (4)	2,8		61,52			
150604SN	0,4	0,11	25°	K (2)	2,8				37,60	
150404TN	0,4	0,11	25°	L (4)	2,8		61,52	20200		
150604TN	0,4	0,11	25°	L (4)	2,8		61,52	24800		
150404SN	0,4	0,11	25°	L (4)	2,8					61,52
150604TN	0,4	0,11	25°	K (2)	2,8	37,60				
150604SN	0,4	0,11	25°	L (4)	2,8					61,52
150404TN	0,4	0,12	25°	A (1)	3,5			41,08		
150604TN	0,4	0,12	25°	A (1)	3,5			41,08		
150604SN	0,4	0,13	25°	L (4)	2,8		61,52	262		
150404FN	0,4			A (1)	3,5			41,08		
150404SN	0,4	0,13	25°	L (4)	2,8		61,52	20300		
150604SN	0,4	0,14	30°	L (4)	2,8					61,52
150604SN	0,4	0,14	35°	K (2)	2,8				37,60	
150604FN	0,4			L (4)	2,8		61,52	29300		
150604FN	0,4			K (2)	2,8	37,60				
150604SN	0,4	0,14	35°	L (4)	2,8					61,52
150408FN	0,8			A (1)	3,0			41,08		
150608TN	0,8	0,09	15°	K (2)	2,6	37,60				
150608SN	0,8	0,09	20°	L (4)	2,6					61,52
150608SN	0,8	0,11	20°	K (2)	2,6	37,60			37,60	
150608SN	0,8	0,11	20°	L (4)	2,6		61,52	244		61,52
150408SN	0,8	0,11	20°	L (4)	2,6					61,52
150608SN	0,8	0,11	25°	K (2)	2,6				37,60	
150408TN	0,8	0,11	25°	L (4)	2,6		61,52	20500		
150608TN	0,8	0,11	25°	L (4)	2,6		61,52	24900		
150408SN	0,8	0,11	25°	L (4)	2,6					61,52
150608TN	0,8	0,11	25°	K (2)	2,6	37,60				
150608SN	0,8	0,11	25°	L (4)	2,6					61,52
150408TN	0,8	0,12	25°	A (1)	3,0			41,08		
150608FN	0,8			A (1)	3,0			41,08		
150608TN	0,8	0,12	25°	A (1)	3,0			41,08		
150608SN	0,8	0,13	25°	K (2)	2,6	37,60				
150608SN	0,8	0,13	25°	L (4)	2,6		61,52	264		61,52
150408SN	0,8	0,14	30°	L (4)	2,6					61,52
150608SN	0,8	0,14	30°	L (4)	2,6		61,52	274		61,52
150608SN	0,8	0,14	35°	K (2)	2,6				37,60	
150608FN	0,8			L (4)	2,6		61,52	29400		
150408FN	0,8			L (4)	2,6		61,52	20400		
150608FN	0,8			K (2)	2,6	37,60				
150608SN	0,8	0,14	35°	L (4)	2,6					61,52

P					
M					
K					
N					
S					
H					
O					

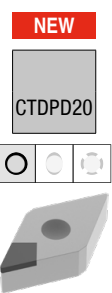
DNGA

Designation	L mm	S mm	D1 mm	IC mm
DNGA 1504..	15,5	4,76	5,13	12,7
DNGA 1506..	15,5	6,35	5,13	12,7



DNGA

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



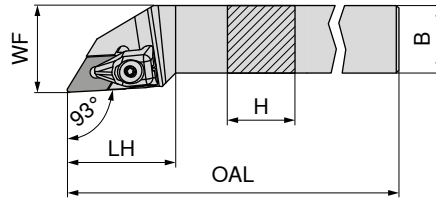
F
DIAMOND
DNGA

71 128 ...

ISO	RE mm	TCE (NOI)	LE mm	
150404FN	0,4	A (1)	6,4	
150408FN	0,8	A (1)	6,0	
150412FN	1,2	A (1)	5,6	
150604FN	0,4	A (1)	6,4	
150608FN	0,8	A (1)	6,0	
150612FN	1,2	A (1)	5,6	
P				
M				
K				
N				•
S				
H				
O				•

EUR	
Y0	
71,93	10001
71,93	10101
84,39	10201
71,93	10301
71,93	10401
84,39	10501

MaxiLock-D – DDJN 93° – Toolholder with top clamping



Illustrations show right-hand versions

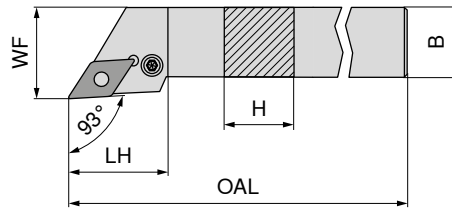


ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand		Right-hand	
								70 541 ...		70 540 ...	
								EUR 2A/24		EUR 2A/24	
DDJN R/L 1616 H11	16	16	100	33	20	2	DN.. 1104	78,62	816	78,62	816
DDJN R/L 2020 K11	20	20	125	33	25	2	DN.. 1104	87,59	820	87,59	820
DDJN R/L 2525 M11	25	25	150	33	32	2	DN.. 1104	90,61	825	90,61	825
DDJN R/L 2020 K15	20	20	125	40	25	4	DN.. 1504 / 1506	87,59	720	87,59	720
DDJN R/L 2525 M15	25	25	150	40	32	4	DN.. 1504 / 1506	90,61	725	90,61	725
DDJN R/L 3225 P15	32	25	170	40	32	4	DN.. 1504 / 1506	97,20	832	97,20	832

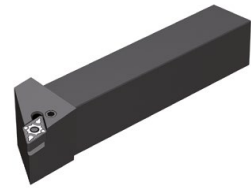
1 When using DN.. 1504 indexable inserts, use insert seat article no. 70 950 40000.

Spare parts for Article no.	XPress type		Key D		Clamping screw		Solid Carbide Seat D	
	70 950 ...		80 950 ...		70 950 ...		70 950 ...	
	EUR 2A/28		EUR Y7		EUR 2A/28		EUR 2A/28	
70 541 816 / 70 540 816	29,62	835	11,58	126	3,30	819	3,71	808
70 541 820 / 70 540 820	29,62	835	11,58	126	3,30	819	3,71	808
70 541 825 / 70 540 825	29,62	835	11,58	126	3,30	819	3,71	808
70 541 720 / 70 540 720	24,48	824	12,25	128	3,13	820	8,28	811
70 541 725 / 70 540 725	24,48	824	12,25	128	3,13	820	8,28	811
70 541 832 / 70 540 832	24,48	824	12,25	128	3,13	820	8,28	811

MaxiLock-N – PDJN 93° – Toolholder with lever clamping

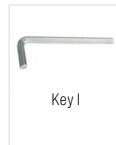


Illustrations show right-hand versions



								Left-hand		Right-hand	
								70 541 ...		70 540 ...	
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	EUR 2A/24		EUR 2A/24	
PDJN R/L 1616 H11	16	16	100	30,0	20	3	DN.. 1104	78,62	116	78,62	116
PDJN R/L 2020 K11	20	20	125	30,0	25	3	DN.. 1104	87,59	12000 ¹⁾	87,59	12000 ¹⁾
PDJN R/L 2525 M11	25	25	150	30,0	32	3	DN.. 1104	90,61	12500 ¹⁾	90,61	12500 ¹⁾
PDJN R/L 2020 K15	20	20	125	34,9	25	3,2	DN.. 1506	87,59	020	87,59	020
PDJN R/L 2525 M15	25	25	150	35,4	32	3,2	DN.. 1506	90,61	025	90,61	025
PDJN R/L 3225 P15	32	25	170	35,4	32	3,2	DN.. 1506	97,20	032	97,20	032
PDJN R/L 3232 P15	32	32	170	34,7	40	3,2	DN.. 1506	122,40	13200	122,40	13200

1) nickel-plated



Key I



Shim



Assembly pin



Lever



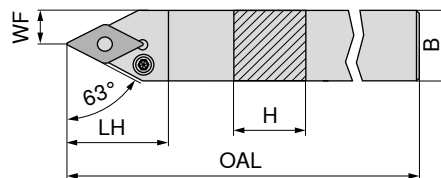
Clamping screw



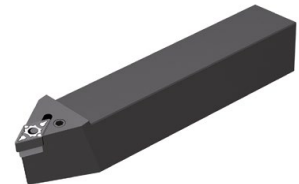
Solid Carbide

		70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	
Spare parts for Article no.		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28	
70 540 116 / 70 541 116	SW2,5	2,57	175	2,16	122	1,28	191	15,72	121	3,35	208	7,57	120
70 540 12000 / 70 541 12000	SW2,5	2,57	175	2,16	122	1,28	191	15,72	121	3,35	208	7,57	120
70 540 12500 / 70 541 12500	SW2,5	2,57	175	2,16	122	1,28	191	15,72	121	3,35	208	7,57	120
70 540 020 / 70 541 020	SW3	2,57	176	1,85	198	1,28	192	14,36	188	3,99	388	8,28	236
70 540 025 / 70 541 025	SW3	2,57	176	1,85	198	1,28	192	14,36	188	3,99	388	8,28	236
70 540 032 / 70 541 032	SW3	2,57	176	1,85	198	1,28	192	14,36	188	3,99	388	8,28	236
70 540 13200 / 70 541 13200	SW3	2,57	176	1,85	198	1,28	192	14,36	188	3,99	388		

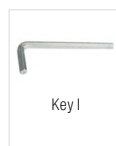
MaxiLock-N – PDNN 63° – Toolholder with lever clamping



Illustrations show right-hand versions



								Left-hand	Right-hand
								70 537 ...	70 536 ...
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	EUR 2A/24	EUR 2A/24
PDNN R/L 2525 M11	25	25	150	30,0	12,5	3	DN.. 1104	90,61	90,61
PDNN R/L 2525 M15	25	25	150	36,5	12,5	3,2	DN.. 1506	90,61	90,61



Key I



Shim



Assembly pin



Lever



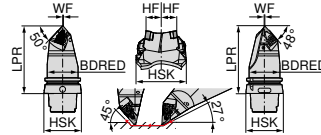
Clamping screw



Solid Carbide

		70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	
Spare parts for Article no.		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28	
70 537 125 / 70 536 125	SW2,5	2,57	175	2,16	122	1,28	191	15,72	121	3,35	208	7,57	120
70 537 025 / 70 536 025	SW3	2,57	176	1,85	198	1,28	192	14,36	188	3,99	388	8,28	236

MaxiLock-D – DCMN + DDMN – Toolholder with top clamping



Neutral

74 600 ...

ISO designation	Adapter	LPR mm	BDRED mm	WF mm	HF mm	torque moment Nm	Insert	EUR 2D/80	
HSK T63 DCMN L 12 + DDMN L 15	HSK-T 63	115	53	0,5	20	4	CN.. 1204 / DN.. 1506	610,70	501
HSK T100 DCMN L 12 + DDMN L 15	HSK-T 100	150	88	0,5	20	4	CN.. 1204 / DN.. 1506	697,40	701



Face turning maximum 78 mm



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...

Solid Carbide
Seat D

70 950 ...



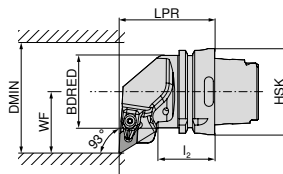
Carbide type C

70 950 ...

Spare parts
for Article no.

	EUR 2A/28		EUR Y7		EUR 2A/28		EUR 2A/28		EUR 2A/28
74 600 501	24,48	824	12,25	128	3,13	820	8,28	811	8,28
74 600 701	24,48	824	12,25	128	3,13	820	8,28	811	8,28

MaxiLock-D – DDUN 93° – Toolholder with top clamping



Illustrations show right-hand versions



Left-hand

74 516 ...

Right-hand

74 515 ...

ISO designation	Adapter	LPR mm	l ₂ mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	EUR 2D/80		EUR 2D/80	
HSK T63 DDUN R/L 15	HSK-T 63	70	42	53	45	125	4	DN.. 1506	236,00	515	236,00	515
HSK T100 DDUN R/L 15	HSK-T 100	80	45	88	55	125	4	DN.. 1506	277,00	715	277,00	715



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...

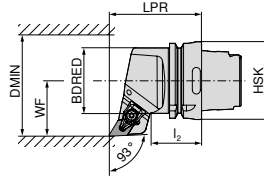
Solid Carbide
Seat D

70 950 ...

Spare parts
for Article no.

	EUR 2A/28		EUR Y7		EUR 2A/28		EUR 2A/28		EUR 2A/28
74 516 515 / 74 515 515	24,48	824	12,25	128	3,13	820	8,28	811	8,28
74 516 715 / 74 515 715	24,48	824	12,25	128	3,13	820	8,28	811	8,28

MaxiLock-D – DDJN 93° – Toolholder with top clamping



Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	I ₂ mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									74 512 ...		74 511 ...	
HSK T63 DDJN R/L 15	HSK-T 63	75	42	53	45	125	4	DN.. 1506	EUR 2D/80 236,00	515	EUR 2D/80 236,00	515
HSK T100 DDJN R/L 15	HSK-T 100	85	45	88	55	125	4	DN.. 1506	EUR 2D/80 277,00	715	EUR 2D/80 277,00	715

Spare parts
for Article no.

74 512 515 / 74 511 515	EUR 2A/28 24,48	824	T15 - IP	EUR Y7 12,25	128	M4,5x12 - IP	EUR 2A/28 3,13	820	EUR 2A/28 8,28	811
74 512 715 / 74 511 715	EUR 2A/28 24,48	824	T15 - IP	EUR Y7 12,25	128	M4,5x12 - IP	EUR 2A/28 3,13	820	EUR 2A/28 8,28	811



XPRESS type

70 950 ...

EUR
2A/28
24,48

824



Key D

80 950 ...

EUR
Y7
12,25

128



Clamping screw

70 950 ...

EUR
2A/28
3,13

820



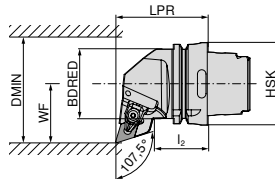
Solid Carbide
Seat D

70 950 ...

EUR
2A/28
8,28

811

MaxiLock-D – DDHN 107.5° – Toolholder with top clamping



Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	I ₂ mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									74 508 ...		74 507 ...	
HSK T63 DDHN R/L 15	HSK-T 63	70	42	53	45	125	4	DN.. 1506	EUR 2D/80 236,00	515	EUR 2D/80 236,00	515

Spare parts
for Article no.

74 508 515 / 74 507 515	EUR 2A/28 24,48	824	T15 - IP	EUR Y7 12,25	128	M4,5x12 - IP	EUR 2A/28 3,13	820	EUR 2A/28 8,28	811
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XPRESS type

70 950 ...

EUR
2A/28
24,48

824



Key D

80 950 ...

EUR
Y7
12,25

128



Clamping screw

70 950 ...

EUR
2A/28
3,13

820



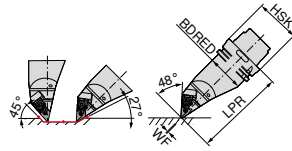
Solid Carbide
Seat D

70 950 ...

EUR
2A/28
8,28

811

MaxiLock-D – DDMN 48° – Toolholder with top clamping



Left-hand

74 519 ...

ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert	
HSK T63 DDMN L 15	HSK-T 63	130	53	0	4	DN.. 1506	
HSK T100 DDMN L 15	HSK-T 100	160	88	0	4	DN.. 1506	

EUR

2D/80

323,60

380,60

515

715



XPress type

70 950 ...

EUR

2A/28

24,48

824



Key D

80 950 ...

EUR

Y7

12,25

128



Clamping screw

70 950 ...

EUR

2A/28

3,13

820

Solid Carbide
Seat D

70 950 ...

EUR

2A/28

8,28

811

Spare parts
for Article no.

74 519 515

74 519 715

T15 - IP

T15 - IP

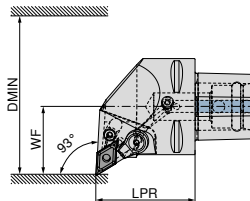
M4,5x12 - IP

M4,5x12 - IP

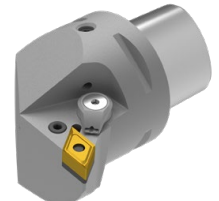
MaxiLock-N – PDUN 93° – Toolholder with lever clamping

Scope of supply:

without high-performance coolant set



Illustrations show right-hand versions



NEW

Left-hand

84 661 ...

EUR

Y8

229,30

252,50

286,70

01595

01594

01593

NEW

Right-hand

84 660 ...

EUR

Y8

229,30

252,50

286,70

01595

01594

01593

ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Direct cooling compatible	
PSC40 PDUN R/L 50050-15	PSC 40	50	27	50	5	DN.. 1506	DC	
PSC50 PDUN R/L 65060-15	PSC 50	60	35	65	5	DN.. 1506	DC	
PSC63 PDUN R/L 80065-15	PSC 63	65	45	80	5	DN.. 1506	DC	



The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → Page 42.



Shim

84 950 ...

EUR

Y8

1,16

29200



Elbow lever screw

84 950 ...

EUR

Y8

4,55

28700



Lever

84 950 ...

EUR

Y8

15,67

28900

Solid Carbide
Seat D

84 950 ...

EUR

Y8

24,61

27900

Spare parts
Adapter

PSC 40

PSC 50

PSC 63

M8X1/L17 SW3

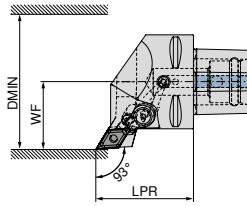
M8X1/L17 SW3

M8X1/L17 SW3

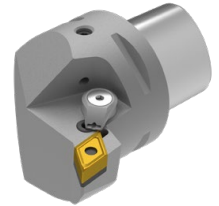
MaxiLock-N – PDJN 93° – Toolholder with lever clamping

Scope of supply:

without high-performance coolant set



Illustrations show right-hand versions



ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Direct cooling compatible	NEW Left-hand 84 665 ...		NEW Right-hand 84 664 ...	
								EUR Y8		EUR Y8	
PSC40 PDJN R/L 50050-15	PSC 40	50	27	50	5	DN.. 1506	DC	229,30	01595	229,30	01595
PSC50 PDJN R/L 65060-15	PSC 50	60	35	65	5	DN.. 1506	DC	252,50	01594	252,50	01594
PSC63 PDJN R/L 80065-15	PSC 63	65	45	80	5	DN.. 1506	DC	286,70	01593	286,70	01593



The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → Page 42.

Spare parts

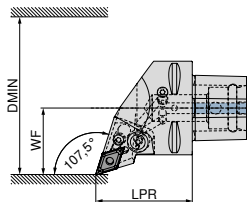
Adapter

Adapter	Shim	Elbow lever screw	Lever	Solid Carbide Seat D
PSC 40	84 950 ... EUR Y8 1,16 29200	84 950 ... EUR Y8 4,55 28700	84 950 ... EUR Y8 15,67 28900	84 950 ... EUR Y8 24,61 27900
PSC 50	84 950 ... EUR Y8 1,16 29200	84 950 ... EUR Y8 4,55 28700	84 950 ... EUR Y8 15,67 28900	84 950 ... EUR Y8 24,61 27900
PSC 63	84 950 ... EUR Y8 1,16 29200	84 950 ... EUR Y8 4,55 28700	84 950 ... EUR Y8 15,67 28900	84 950 ... EUR Y8 24,61 27900

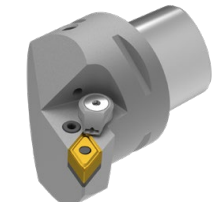
MaxiLock-N – PDHN 107,5° – Toolholder with lever clamping

Scope of supply:

without high-performance coolant set



Illustrations show right-hand versions



ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Direct cooling compatible	NEW Left-hand 84 669 ...		NEW Right-hand 84 668 ...	
								EUR Y8		EUR Y8	
PSC40 PDHN R/L 50050-15	PSC 40	50	27	50	5	DN.. 1506		229,30	01595	229,30	01595
PSC50 PDHN R/L 65060-15	PSC 50	60	35	65	5	DN.. 1506		252,50	01594	252,50	01594
PSC63 PDHN R/L 80065-15	PSC 63	65	45	80	5	DN.. 1506	DC	286,70	01593	286,70	01593



The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → Page 42.

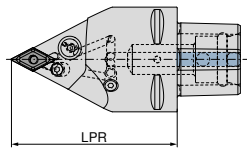
Spare parts

Adapter

Adapter	Shim	Elbow lever screw	Lever	Solid Carbide Seat D
PSC 40	84 950 ... EUR Y8 1,16 29200	84 950 ... EUR Y8 4,55 28700	84 950 ... EUR Y8 15,67 28900	84 950 ... EUR Y8 24,61 27900
PSC 50	84 950 ... EUR Y8 1,16 29200	84 950 ... EUR Y8 4,55 28700	84 950 ... EUR Y8 15,67 28900	84 950 ... EUR Y8 24,61 27900
PSC 63	84 950 ... EUR Y8 1,16 29200	84 950 ... EUR Y8 4,55 28700	84 950 ... EUR Y8 15,67 28900	84 950 ... EUR Y8 24,61 27900

MaxiLock-N – PDNN 62,5° – Toolholder with lever clamping

Scope of supply:
without high-performance coolant set



NEW
Neutral
84 676 ...
EUR Y8
286,70 01593
286,70 11593

ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Direct cooling compatible
PSC63 PDNN N 0100-15	PSC 63	100	5	DN.. 1506	DC
PSC63 PDNN N 0130-15	PSC 63	130	5	DN.. 1506	DC

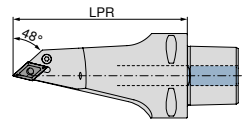
i The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page 42.**


Clamping screw
84 950 ...
EUR Y8
3,20 27600

Adapter
PSC 63

MaxiLock-N – PDMN 48° – Toolholder with lever clamping

Scope of supply:
without high-performance coolant set



NEW
Neutral
84 680 ...
EUR Y8
353,20 11593

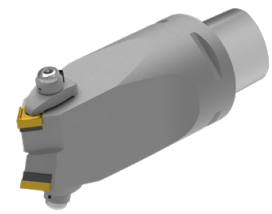
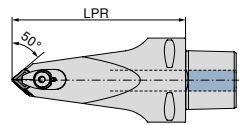
ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Direct cooling compatible
PSC63 PDMN L 0130-15	PSC 63	130	5	DN.. 1506	DC

i The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page 42.**


Clamping screw
84 950 ...
EUR Y8
3,20 27600

Adapter
PSC 63

Toolholder DCMN – DDMN 50°/48°



NEW
Neutral
84 683 ...
EUR
Y8
448,70 01293

ISO designation	Adapter	LPR mm	torque moment Nm	Insert
PSC63 DCMN-DDMN L 0130-12/15	PSC 63	130	10	CN.. 1204 / DN.. 1506

Spare parts
Adapter

PSC 63	M6X28 SW4	EUR Y8 20,47	28300	EUR Y8 24,25	28500	EUR Y8 7,81	28400	EUR Y8 4,83	27500	EUR Y8 24,61	27900	EUR Y8 13,38	27800
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 Clamping Screw	 Clamping claw	 Ring-shaped nozzle	 Clamping screw	 Solid Carbide Seat D	 Carbide type C
84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...

High-performance coolant set

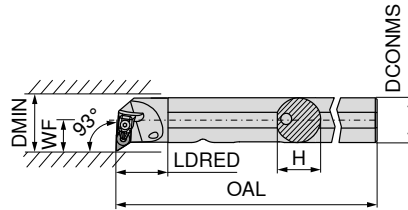
- ▲ Using the DC kit blocks the other coolant outlet so that all of the pressure is concentrated by the kit!
- ▲ Can be used up to 100 bar

Scope of supply:
Direct cooling nozzle and O-ring



Coolant set	84 950 ... EUR Y8 103,50	27400
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MaxiLock-D – DDUN 93° – Boring bar with top clamping



Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									70 569 ...		70 568 ...	
									EUR 2A/24		EUR 2A/24	
A25R DDUN R/L 11	25	24	200	30	17	32	2	DN.. 1104	228,90	725	228,90	725
A32S DDUN R/L 11	32	31	250	40	22	40	2	DN.. 1104	236,70	732	236,70	732
A40T DDUN R/L 15	40	39	300	45	27	50	4	DN.. 1506	263,70	840	263,70	840

Spare parts
for Article no.

70 568 725 / 70 569 725	EUR 2A/28	29,62	835	T09 - IP	EUR Y7	11,58	126	M3x7 - IP	EUR 2A/28	3,30	819	EUR 2A/28	3,71	808
70 568 732 / 70 569 732	EUR 2A/28	29,62	835	T09 - IP	EUR Y7	11,58	126	M3x7 - IP	EUR 2A/28	3,30	819	EUR 2A/28	3,71	808
70 568 840 / 70 569 840	EUR 2A/28	24,48	824	T15 - IP	EUR Y7	12,25	128	M4,5x12 - IP	EUR 2A/28	3,13	820	EUR 2A/28	8,28	811



XPress type

70 950 ...

EUR
2A/28

Key D

80 950 ...

EUR
Y7

Clamping screw

70 950 ...

EUR
2A/28Solid Carbide
Seat D

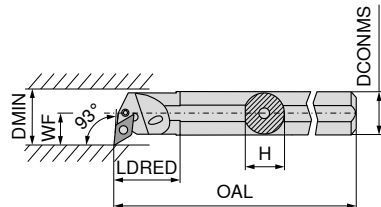
70 950 ...

EUR
2A/28

MaxiLock-N – PDUN 93° – Boring bar with lever clamping

▲ A... = with thro' coolant

▲ S... = without thro' coolant



Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									70 569 ...		70 568 ...	
									EUR 2A/24		EUR 2A/24	
A20Q PDUN R/L 11	20	18,5	180	36	16,0	28	3	DN.. 1104	205,40	12000 ¹⁾	205,40	12000 ¹⁾
A25R PDUN R/L 11	25	23,0	200	36	18,5	32	3	DN.. 1104	228,90	125	228,90	12500 ¹⁾
A32S PDUN R/L 11	32	30,0	250	36	22,0	40	3	DN.. 1104	236,70	13200 ¹⁾	236,70	132
A32S PDUN R/L 15	32	30,0	250	50	22,0	40	3,2	DN.. 1506	236,70	232	236,70	232
A40T PDUN R/L 15	40	38,0	300	60	27,0	50	3,2	DN.. 1506	263,70	240	263,70	240
S50W PDUN R/L 15	50	47,0	450	31	35,0	63	3,2	DN.. 1506	326,30	050	326,30	050

1) nickel-plated

Spare parts
for Article no.

70 568 12000 / 70 569 12000	EUR 2A/28	2,57	175	SW2,5	EUR 2A/28	2,16	122	EUR 2A/28	1,28	191	EUR 2A/28	15,72	125	EUR 2A/28	2,28	126	EUR 2A/28	3,35	208	EUR 2A/28	7,57	120
70 568 12500 / 70 569 125	EUR 2A/28	2,57	175	SW2,5	EUR 2A/28	2,16	122	EUR 2A/28	1,28	191	EUR 2A/28	15,72	121	EUR 2A/28	3,35	208	EUR 2A/28	7,57	120	EUR 2A/28	8,28	236
70 568 132 / 70 569 13200	EUR 2A/28	2,57	175	SW2,5	EUR 2A/28	2,16	122	EUR 2A/28	1,28	191	EUR 2A/28	15,72	121	EUR 2A/28	3,35	208	EUR 2A/28	7,57	120	EUR 2A/28	8,28	236
70 568 232 / 70 569 232	EUR 2A/28	2,57	176	SW3	EUR 2A/28	1,85	198	EUR 2A/28	1,28	192	EUR 2A/28	14,36	188	EUR 2A/28	3,68	209	EUR 2A/28	8,28	236	EUR 2A/28	8,28	236
70 568 240 / 70 569 240	EUR 2A/28	2,57	176	SW3	EUR 2A/28	1,85	198	EUR 2A/28	1,28	192	EUR 2A/28	14,36	188	EUR 2A/28	3,68	209	EUR 2A/28	8,28	236	EUR 2A/28	8,28	236
70 568 050 / 70 569 050	EUR 2A/28	2,57	176	SW3	EUR 2A/28	1,85	198	EUR 2A/28	1,28	192	EUR 2A/28	14,36	188	EUR 2A/28	3,99	388	EUR 2A/28	8,28	236	EUR 2A/28	8,28	236



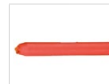
Key I

70 950 ...

EUR
2A/28

Shim

70 950 ...

EUR
2A/28

Assembly pin

70 950 ...

EUR
2A/28

Lever

70 950 ...

EUR
2A/28

Clamping screw

70 950 ...

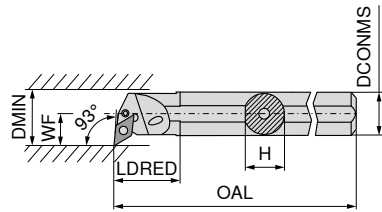
EUR
2A/28Solid Carbide
Seat D

70 950 ...

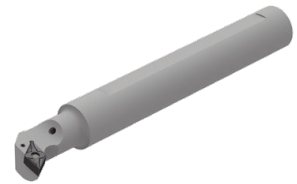
EUR
2A/28

MaxiLock-N – PDUN 93° – Boring bar with lever clamping

▲ with carbide core



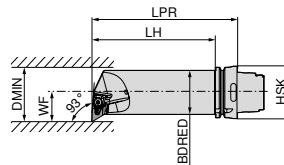
Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									70 563 ...		70 562 ...	
E-A25R PDUN R/L 11	25	23	200	40	17	31	3	DN.. 1104	EUR 2A		EUR 2A	
E-A32S PDUN R/L 15	32	30	250	50	22	39	3,2	DN.. 1506	745,10	025	745,10	025
E-A40T PDUN R/L 15	40	38	300	60	27	48	3,2	DN.. 1506	983,50	032	983,50	032
									1.174,00	040	1.174,00	040

Spare parts for Article no.	Key I		Shim		Assembly pin		Lever		Clamping screw		Solid Carbide Seat D	
	70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	
70 562 025 / 70 563 025	EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28	
70 562 032 / 70 563 032	2,57	175	2,16	122	1,28	191	15,72	121	3,35	208	7,57	120
70 562 040 / 70 563 040	2,57	176	1,85	198	1,28	192	14,36	188	3,99	388	8,28	236
	2,57	176	1,85	198	1,28	192	14,36	188	3,99	388	8,28	236

MaxiLock-D – DDUN 93° – Boring bar with top clamping



Illustrations show right-hand versions

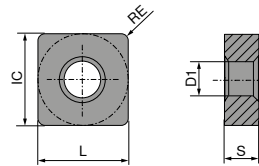


ISO designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									74 533 ...		74 532 ...	
HSK T63 50Q DDUN R/L 15	HSK-T 63	175	149	50	35	63	4	DN.. 1506	EUR 2D/80		EUR 2D/80	
									323,60	515	323,60	515

Spare parts for Article no.	XPress type		Key D		Clamping screw		Solid Carbide Seat D	
	70 950 ...		80 950 ...		70 950 ...		70 950 ...	
74 533 515 / 74 532 515	EUR 2A/28		EUR Y7		EUR 2A/28		EUR 2A/28	
	24,48	824	12,25	128	3,13	820	8,28	811

SNMG / SNMA / SNMM

Designation	L mm	S mm	D1 mm	IC mm
SNMG 0903..	9,52	3,18	3,81	9,52
SNM. 1204..	12,70	4,76	5,16	12,70
SNM. 1506..	15,87	6,35	6,35	15,87
SNM. 1906..	19,05	6,35	7,94	19,05
SNMM 2507..	25,40	7,94	9,12	25,40
SNMM 2509..	25,40	9,52	9,12	25,40



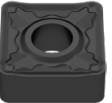
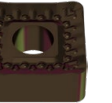
SNMG

		-F50 CTCP115		-F50 CTCP125		-F50 CTCP135		-M50 CTCP115		-M50 CTCP125		-M50 CTCP135		-M70 CTCK110	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		F SNMG		F SNMG		F SNMG		M SNMG		M SNMG		M SNMG		M SNMG	
		76 140 ...		76 140 ...		76 140 ...		76 137 ...		76 137 ...		76 137 ...		70 225 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
090308EN	0,8	7,79	306	7,79	506	7,79	706								
120404EN	0,4	12,21	316	12,21	516	12,21	716								
120408EN	0,8	12,21	318	12,21	518	12,21	718	12,21	318	12,21	518	12,21	718	12,21	018
120412EN	1,2	12,21	320	12,21	520	12,21	720	12,21	320	12,21	520	12,21	720	12,21	020
120416EN	1,6							12,21	322	12,21	522	12,21	722	12,21	022
150608EN	0,8							19,38	330	19,38	530	19,38	730		
150612EN	1,2							19,38	332	19,38	532	19,38	732	19,38	032
150616EN	1,6							19,38	334	19,38	534	19,38	734	19,38	034
190612EN	1,2													27,37	044
190616EN	1,6													27,37	046
P			●		●		●		●		●		●		○
M							○						○		
K			○		○				○		○				●
N															
S															
H															
O															

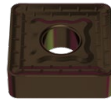
SNMG / SNMA

		-M70 CTCK120		-M70 CTCP115		-M70 CTCP125		-M70 CTCP135		CTCP125		CTCP135		CTCK110	
		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin	
															
															
		M		M		M		M		M		M		R	
		SNMG		SNMG		SNMG		SNMG		SNMG		SNMG		SNMA	
		70 225 ...		76 225 ...		76 225 ...		76 225 ...		76 116 ...		76 116 ...		70 114 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
090308EN	0,8									7,79	506	7,79	706		
120408EN	0,8	12,21	518	12,21	318	12,21	518	12,21	718					12,21	018
120412EN	1,2	12,21	520	12,21	320	12,21	520	12,21	720					12,21	020
120416EN	1,6	12,21	522	12,21	322	12,21	522	12,21	722					12,21	022
150612EN	1,2	19,38	532	19,38	332	19,38	532	19,38	732					19,38	032
150616EN	1,6	19,38	534	19,38	334	19,38	534	19,38	734					19,38	034
190612EN	1,2	27,37	544	27,37	344	27,37	544	27,37	744					27,37	044
190616EN	1,6	27,37	546	27,37	346	27,37	546	27,37	746					27,37	046
190624EN	2,4			27,37	348	27,37	548	27,37	748						
P			○	●		●		●		●		●		○	
M								○				○			
K		●		○		○				○				●	
N															
S															
H															
O															

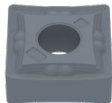
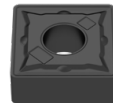
SNMA / SNMM

		CTCK120		-R28 CTCP115		-R28 CTCP125		-R28 CTCP135		-R58 CTCP115		-R58 CTCP125		-R58 CTCP135	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
															
		R		R		R		R		R		R		R	
		SNMA		SNMM		SNMM		SNMM		SNMM		SNMM		SNMM	
		70 114 ...		76 128 ...		76 128 ...		76 128 ...		76 129 ...		76 129 ...		76 129 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
120408EN	0,8	12,21	518							12,21	318	12,21	518	12,21	718
120412EN	1,2	12,21	520							12,21	320	12,21	520	12,21	720
120416EN	1,6	12,21	522												
150612EN	1,2	19,38	532	19,38	332	19,38	532	19,38	732	19,38	332	19,38	532	19,38	732
150616EN	1,6	19,38	534	19,38	334	19,38	534	19,38	734	19,38	334	19,38	534	19,38	734
190612EN	1,2	27,37	544							27,37	344	27,37	544	27,37	744
190616EN	1,6	27,37	546	27,37	346	27,37	546	27,37	746	27,37	346	27,37	546	27,37	746
190624EN	2,4									27,37	348	27,37	548	27,37	748
250724EN	2,4							53,80	760	53,80	360	53,80	560	53,80	760
250924EN	2,4			63,19	370	63,19	570	63,19	770	63,19	370	63,19	570	63,19	770
P			○		●		●		●		●		●		●
M									○						○
K			●		○		○				○		○		
N															
S															
H															
O															

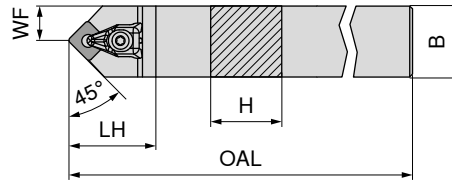
SNMM / SNMG

		-R88 CTCP115		-R88 CTCP125		-R88 CTCP135		NEW -F30 CTCM120		-F30 CTPM125		NEW -F30 CTCM130		NEW -M30 CTCM120	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
															
		R SNMM		R SNMM		R SNMM		F SNMG		F SNMG		F SNMG		M SNMG	
		76 130 ...		76 130 ...		76 130 ...		75 016 ...		75 016 ...		75 016 ...		75 017 ...	
ISO		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
RE mm															
120404EN	0,4							12,21	11600	12,21	216	12,21	31600		
120408EN	0,8							12,21	11800	12,21	218	12,21	31800	12,21	11800
120412EN	1,2													12,21	12000
190616SN	1,6	27,37	346	27,37	546	27,37	746								
190624SN	2,4	27,37	348	27,37	548	27,37	748								
250724SN	2,4	53,80	36000	53,80	56000	53,80	760								
250924SN	2,4	63,19	37000	63,19	57000	63,19	770								
P			●		●		●	○		○		○		○	
M							○	●		●		●		●	
K			○		○										
N															
S												○			
H															
O															

SNMG

		-M30 CTPM125		NEW -M30 CTCM130		NEW -M60 CTCM120		-M60 CTPM125		NEW -M60 CTCM130		NEW -M34 CTPX710	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
													
													
		M SNMG		M SNMG		M SNMG		M SNMG		M SNMG		M SNMG	
		75 017 ...		75 017 ...		75 018 ...		75 018 ...		75 018 ...		75 005 ...	
ISO		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
RE mm													
120408EN	0,8			12,21	31800	12,21	11800	12,21	218	12,21	31800	12,80	61800
120412EN	1,2			12,21	32000	12,21	12000	12,21	210	12,21	32000	12,80	62000
120416EN	1,6					12,21	12200	12,21	220	12,21	32200		
P			○		○		○		○		○		●
M			●		●		●		●		●		●
K													
N													○
S					○						○		●
H													
O													

MaxiLock-D – DSDN 45° – Toolholder with top clamping



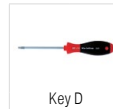
Neutral

70 516 ...

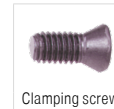
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert		
DSDN N 2020 K12	20	20	125	38	10,3	4	SN.. 1204	EUR 2A/24 87,59	620
DSDN N 2525 M12	25	25	150	38	12,5	4	SN.. 1204	EUR 2A/24 90,61	625



XPress type



Key D



Clamping screw



Solid Carbide support S

70 950 ...

80 950 ...

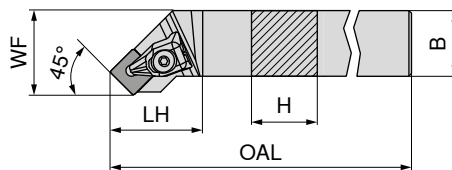
70 950 ...

70 950 ...

Spare parts
for Article no.

	EUR 2A/28 24,48	824		EUR Y7 12,25	128		EUR 2A/28 3,13	820		EUR 2A/28 8,28	813
70 516 620	24,48	824	T15 - IP	12,25	128	M4,5x12 - IP	3,13	820	8,28	813	
70 516 625	24,48	824	T15 - IP	12,25	128	M4,5x12 - IP	3,13	820	8,28	813	

MaxiLock-D – DSSN 45° – Toolholder with top clamping



Illustrations show right-hand versions



9

Left-hand

70 513 ...

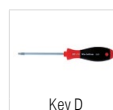
Right-hand

70 512 ...

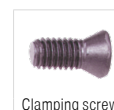
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert		
DSSN R/L 2020 K12	20	20	125	35	25	4	SN.. 1204	EUR 2A/24 87,59	620
DSSN R/L 2525 M12	25	25	150	35	32	4	SN.. 1204	EUR 2A/24 90,61	625
DSSN R/L 3225 P12	32	25	170	35	32	4	SN.. 1204	EUR 2A/24 97,20	632



XPress type



Key D



Clamping screw



Solid Carbide support S

70 950 ...

80 950 ...

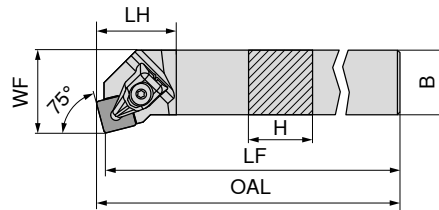
70 950 ...

70 950 ...

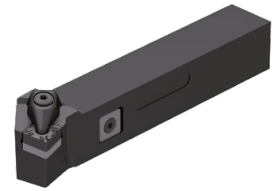
Spare parts
for Article no.

	EUR 2A/28 24,48	824		EUR Y7 12,25	128		EUR 2A/28 3,13	820		EUR 2A/28 8,28	813
70 512 620 / 70 513 620	24,48	824	T15 - IP	12,25	128	M4,5x12 - IP	3,13	820	8,28	813	
70 512 625 / 70 513 625	24,48	824	T15 - IP	12,25	128	M4,5x12 - IP	3,13	820	8,28	813	
70 512 632 / 70 513 632	24,48	824	T15 - IP	12,25	128	M4,5x12 - IP	3,13	820	8,28	813	

MaxiLock-D – DSKN 75° – Toolholder with top clamping



Illustrations show right-hand versions



									Left-hand		Right-hand	
									70 525 ...		70 524 ...	
ISO designation	H mm	B mm	OAL mm	LF mm	LH mm	WF mm	torque moment Nm	Insert	EUR 2A/24		EUR 2A/24	
DSKN R/L 2525 M12	25	25	153,3	150	28	32	4	SN.. 1204	90,61	625	90,61	625



XPress type



Key D



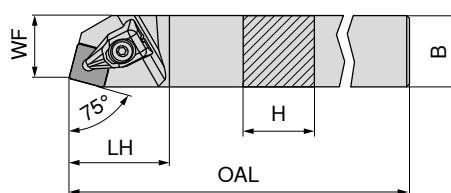
Clamping screw

Solid Carbide
support S

**Spare parts
for Article no.**

70 525 625 / 70 524 625	24,48	824	T15 - IP	12,25	128	M4,5x12 - IP	3,13	820	8,28	813
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MaxiLock-D – DSBN 75° – Toolholder with top clamping



Illustrations show right-hand versions



								Right-hand
								70 520 ...
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	EUR 2A/24
DSBN R 2020 K12	20	20	125	35	17	4	SN.. 1204	87,59
DSBN R 2525 M12	25	25	150	35	22	4	SN.. 1204	90,61
DSBN R 2525 M15	25	25	150	42	22	6,5	SN.. 1506	90,61
DSBN R 3232 P15	32	32	170	42	27	6,5	SN.. 1506	122,40
DSBN R 3232 P19	32	32	170	48	27	6,5	SN.. 1906	122,40
DSBN R 4040 S19	40	40	250	48	35	6,5	SN.. 1906	152,10
DSBN R 4040 S25	40	40	250	57	35	6,5	SN.. 2507 / SN.. 2509	152,10



When using SN.. 2509 indexable inserts, use insert seat article no. 70 950 40100.



XPress type



Key D

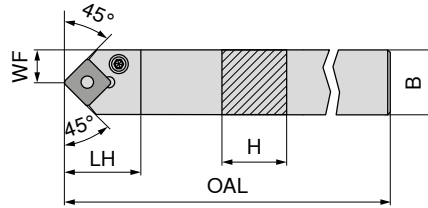


Clamping screw

Solid Carbide
support S

		70 950 ...		80 950 ...			70 950 ...			70 950 ...	
Spare parts for Article no.		EUR 2A/28			EUR Y7			EUR 2A/28		EUR 2A/28	
70 520 620		24,48	824	T15 - IP	12,25	128	M4,5x12 - IP	3,13	820	8,28	813
70 520 625		24,48	824	T15 - IP	12,25	128	M4,5x12 - IP	3,13	820	8,28	813
70 520 725		27,49	825	T20 - IP	12,92	129	M5x14 - IP	4,44	821	12,65	833
70 520 832		27,49	825	T20 - IP	12,92	129	M5x14 - IP	4,44	821	12,65	833
70 520 732		30,07	826	T20 - IP	12,92	129	M5x14 - IP	4,44	821	13,56	817
70 520 840		30,07	826	T20 - IP	12,92	129	M5x14 - IP	4,44	821	13,56	817
70 520 940		47,74	827	T25 - IP	14,94	130	M6x16 - IP	8,44	822	25,31	818

MaxiLock-N – PSDN 45° – Toolholder with lever clamping



Neutral

70 516 ...

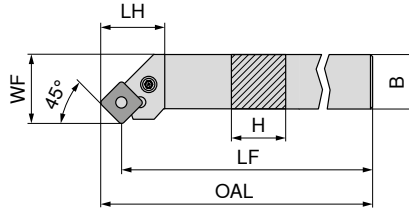
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	EUR 2A/24	
PSDN N 1616 H09	16	16	100	21,0	8,3	3	SNM. 0903	78,62	016
PSDN N 2020 K12	20	20	125	27,6	10,3	4	SNM. 1204	87,59	020
PSDN N 2525 M12	25	25	150	27,6	12,8	4	SNM. 1204	90,61	025
PSDN N 3225 P19	32	25	170	40,4	12,5	8	SNM. 1906	97,20	03200
PSDN N 4040 S25	40	40	250	48,8	20,0	8	SNM. 2507 / 2509	152,10	04000



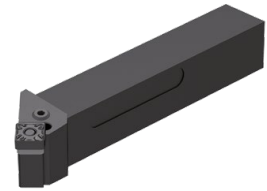
When using SN.. 2509 indexable inserts, use insert seat article no. 70 950 40200.

Spare parts for Article no.		Key I		Shim		Assembly pin		Lever		Clamping screw		Solid Carbide support S	
		70 950 ...	EUR 2A/28	70 950 ...	EUR 2A/28	70 950 ...	EUR 2A/28	70 950 ...	EUR 2A/28	70 950 ...	EUR 2A/28	70 950 ...	EUR 2A/28
70 516 016	SW2,5	2,57	175	1,85	197	1,28	191	13,10	185	3,35	208	6,42	229
70 516 020	SW3	2,57	176	1,85	198	1,28	192	13,22	187	3,68	209	6,42	230
70 516 025	SW3	2,57	176	1,85	198	1,28	192	13,22	187	3,68	209	6,42	230
70 516 03200	SW4	2,70	396	1,85	392	1,28	395	20,07	386	3,99	389	20,17	383
70 516 04000	SW5	3,86	265	1,18	621	1,98	623	27,12	620	2,39	622	41,49	27600

MaxiLock-N – PSSN 45° – Toolholder with lever clamping



Illustrations show right-hand versions

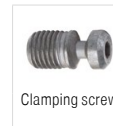
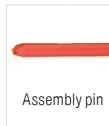
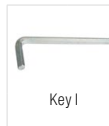


ISO designation	H mm	B mm	OAL mm	LF mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 513 ...		Right-hand 70 512 ...	
									EUR 2A/24		EUR 2A/24	
PSSN R/L 1616 H09	16	16	106,7	100	21,2	20	3	SNM. 0903	78,62	016	78,62	01600 ¹⁾
PSSN R/L 2020 K12	20	20	134,0	125	29,3	25	4	SNM. 1204	87,59	020	87,59	020
PSSN R/L 2525 M12	25	25	159,0	150	29,3	32	4	SNM. 1204	90,61	025	90,61	025
PSSN R/L 3225 P12	32	25	179,0	170	32,0	32	4	SNM. 1204	97,20	032	97,20	032
PSSN R 2525 M15	25	25	161,2	150	29,3	32	4	SNM. 1506			90,61	125
PSSN R 3232 P15	32	32	181,2	170	32,0	40	4	SNM. 1506			122,40	132
PSSN R/L 3232 P19	32	32	183,5	170	40,2	40	8	SNM. 1906	122,40	232	122,40	232
PSSN R 4040 S25	40	40	268,0	250	48,8	50	8	SNM. 2507 / 2509			149,30	04000

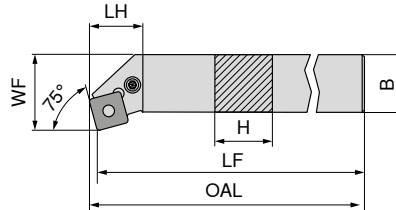
1) nickel-plated

When using SN.. 2509 indexable inserts, use insert seat article no. 70 950 40200.

Spare parts for Article no.		70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	
		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28	
70 512 01600 / 70 513 016	SW2,5	2,57	175	1,85	197	1,28	191	13,10	185	3,35	208	6,42	229
70 512 020 / 70 513 020	SW3	2,57	176	1,85	198	1,28	192	13,22	187	3,68	209	6,42	230
70 512 025 / 70 513 025	SW3	2,57	176	1,85	198	1,28	192	13,22	187	3,68	209	6,42	230
70 512 032 / 70 513 032	SW3	2,57	176	1,85	198	1,28	192	13,22	187	3,68	209	6,42	230
70 512 125	SW3	2,57	176	1,18	391	1,28	394	13,10	385	3,99	388	13,10	382
70 512 132	SW3	2,57	176	1,18	391	1,28	394	13,10	385	3,99	388	13,10	382
70 512 232 / 70 513 232	SW4	2,70	396	1,85	392	1,28	395	20,07	386	3,99	389	20,17	383
70 512 04000	SW5	3,86	265	1,18	621	1,98	623	27,12	620	2,39	622	41,49	27600



MaxiLock-N – PSKN 75° – Toolholder with lever clamping



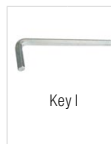
Illustrations show right-hand versions



ISO designation	H mm	LF mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 525 ...		Right-hand 70 524 ...	
									EUR 2A/24		EUR 2A/24	
PSKN R/L 1616 H09	16	100	16	102,5	18,7	20	3	SNM. 0903	78,62	016	78,62	016
PSKN R/L 2020 K12	20	125	20	128,3	22,7	25	4	SNM. 1204	87,59	020	87,59	020
PSKN R/L 2525 M12	25	150	25	153,3	22,7	32	4	SNM. 1204	90,61	025	90,61	025
PSKN R/L 3225 P12	32	170	25	173,1	24,1	32	4	SNM. 1204	97,20	03200	97,20	03200
PSKN R 4040 S19	40	250	40	254,6	38,3	50	8	SNM. 1906			152,10	04000

Spare parts
for Article no.

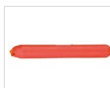
		70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
		EUR 2A/28	EUR 2A/28	EUR 2A/28	EUR 2A/28	EUR 2A/28	EUR 2A/28
70 524 016 / 70 525 016	SW2,5	2,57	1,85	1,28	13,10	3,35	6,42
70 524 020 / 70 525 020	SW3	2,57	1,85	1,28	13,22	3,68	6,42
70 524 025 / 70 525 025	SW3	2,57	1,85	1,28	13,22	3,68	6,42
70 524 03200 / 70 525 03200	SW3	2,57	1,85	1,28	13,22	3,68	6,42
70 524 04000	SW4	2,70	3,96	1,85	3,95	20,07	386



Key I



Shim



Assembly pin



Lever

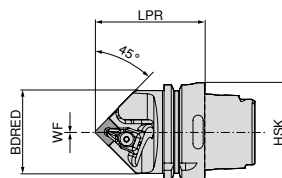


Clamping screw



Solid Carbide support S

MaxiLock-D – DSDN 45° – Toolholder with top clamping



ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert	Neutral 74 522 ...	
							EUR 2D/80	
HSK T63 DSDN N 12	HSK-T 63	70	53	0	4	SN.. 1204	236,00	512
HSK T63 DSDN N 15	HSK-T 63	75	53	0	4	SN.. 1506	236,00	515
HSK T100 DSDN N 12	HSK-T 100	80	88	0	4	SN.. 1204	277,00	712
HSK T100 DSDN N 19	HSK-T 100	85	88	0	8	SN.. 1906	277,00	719



XPress type



Key D



Clamping screw

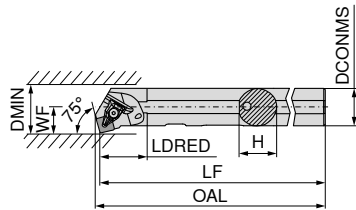


Solid Carbide support S

Spare parts
for Article no.

	70 950 ...	80 950 ...	70 950 ...	70 950 ...
	EUR 2A/28	EUR Y7	EUR 2A/28	EUR 2A/28
74 522 512	24,48	824	12,25	128
74 522 515	27,49	825	12,92	129
74 522 712	24,48	824	12,25	128
74 522 719	30,07	826	12,92	129

MaxiLock-D – DSKN 75° – Boring bar with top clamping



Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	LF mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
										70 561 ...		70 560 ...	
A32S DSKN R/L 12	32	31	250	254,2	40	22	40	4	SN.. 1204	EUR 2A/24 236,70	832	EUR 2A/24 236,70	832

Spare parts
for Article no.

70 561 832 / 70 560 832

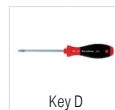


XPress type

70 950 ...

EUR
2A/28
24,48

824



Key D

80 950 ...

EUR
Y7
12,25

128



Clamping screw

70 950 ...

EUR
2A/28
3,13

820



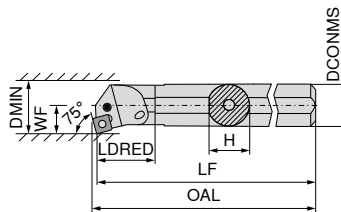
Solid Carbide
support S

70 950 ...

EUR
2A/28
8,28

813

MaxiLock-N – PSKN 75° – Boring bar with lever clamping



Illustrations show right-hand versions



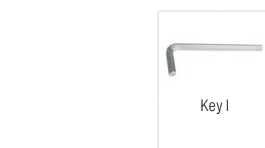
ISO designation	DCONMS mm	H mm	LF mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
										70 561 ...		70 560 ...	
A25R PSKN R/L 12	25	23	200	203	15,5	17	32	4	SNM. 1204	EUR 2A/24 228,90	225	EUR 2A/24 228,90	225
A32S PSKN R/L 12	32	30	250	253	16,0	22	40	4	SNM. 1204	EUR 2A/24 236,70	232	EUR 2A/24 236,70	232
A40T PSKN R/L 12	40	38	300	303	23,0	27	50	4	SNM. 1204	EUR 2A/24 263,70	240	EUR 2A/24 263,70	240

Spare parts
for Article no.

70 561 225 / 70 560 225

70 561 232 / 70 560 232

70 561 240 / 70 560 240



Key I

70 950 ...

EUR
2A/28
2,57

176

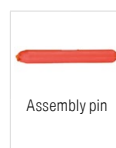


Shim

70 950 ...

EUR
2A/28
1,85

198



Assembly pin

70 950 ...

EUR
2A/28
1,28

192

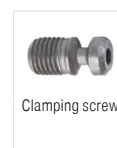


Lever

70 950 ...

EUR
2A/28
13,22

187



Clamping screw

70 950 ...

EUR
2A/28
4,49

205



Solid Carbide
support S

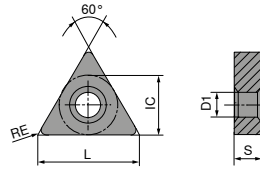
70 950 ...

EUR
2A/28
6,42

230

TNMG / TNMA / TNMM

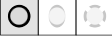
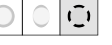
Designation	L mm	S mm	D1 mm	IC mm
TNMG 1103..	11,0	3,18	2,26	6,35
TNM. 1604..	16,5	4,76	3,81	9,52
TNM. 2204..	22,0	4,76	5,16	12,70



TNMG

		-CF20 CTCP110		-F50 CTCP115		-F50 CTCP125		-F50 CTCP135		-M50 CTCP115		-M50 CTCP125		-M50 CTCP135	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		F		F		F		F		M		M		M	
		CERMET TNMG		TNMG		TNMG		TNMG		TNMG		TNMG		TNMG	
		76 149 ...		76 146 ...		76 146 ...		76 146 ...		76 138 ...		76 138 ...		76 138 ...	
ISO	RE mm	EUR 1A/78		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
110304EN	0,4			6,76	304	6,76	504	6,76	704						
110308EN	0,8			6,76	306	6,76	506	6,76	706						
160404EN	0,4	10,62	016	10,71	316	10,71	516	10,71	716	10,71	316	10,71	516	10,71	716
160408EN	0,8	10,62	018	10,71	318	10,71	518	10,71	718	10,71	318	10,71	518	10,71	718
160412EN	1,2	10,62	020	10,71	320	10,71	520	10,71	720	10,71	320	10,71	520	10,71	720
220408EN	0,8									14,45	330	14,45	530	14,45	730
220412EN	1,2									14,45	332	14,45	532	14,45	732
P		●		●		●		●		●		●		●	
M		○						○						○	
K		○		○		○				○		○			
N															
S															
H															
Q															

TNMG

		-M70 CTCK110		-M70 CTCK120		-M70 CTCP115		-M70 CTCP125		-M70 CTCP135		CTCP125		CTCP135	
		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin	
															
															
		M TNMG		M TNMG		M TNMG		M TNMG		M TNMG		M TNMG		M TNMG	
		70 155 ...		70 155 ...		76 155 ...		76 155 ...		76 155 ...		76 142 ...		76 142 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
110302EN	0,2													6,76	702
160404ER	0,4											10,71	516	10,71	716
160408EL	0,8											10,71	518		
160408EN	0,8	10,71	018	10,71	518	10,71	318	10,71	518	10,71	718				
160408ER	0,8											10,71	517	10,71	717
160412EN	1,2	10,71	020	10,71	520	10,71	320	10,71	520	10,71	720				
220404EN	0,4							14,45	528						
220408EN	0,8	14,45	030	14,45	530	14,45	330	14,45	530	14,45	730				
220412EN	1,2	14,45	032	14,45	532	14,45	332	14,45	532	14,45	732				
220416EN	1,6	14,45	034	14,45	534	14,45	334	14,45	534	14,45	734				
P			○		○		●		●		●		●		●
M											○				○
K			●		●		○		○				○		
N															
S															
H															
O															

TNMA / TNMM

		CTCK110		CTCK120		-R28 CTCP115		-R28 CTCP125		-R28 CTCP135		-R58 CTCP115		-R58 CTCP125	
		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin	
															
															
		R TNMA		M TNMA		R TNMM		R TNMM		R TNMM		R TNMM		R TNMM	
		70 134 ...		70 134 ...		76 154 ...		76 154 ...		76 154 ...		76 152 ...		76 152 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
160408EN	0,8	10,71	018	10,71	518										
160412EN	1,2	10,71	020	10,71	520										
160416EN	1,6	10,71	022	10,71	522										
220408EN	0,8	14,45	030	14,45	530										
220412EN	1,2	14,45	032	14,45	532							14,45	332	14,45	532
220416EN	1,6	14,45	034	14,45	534	14,45	334	14,45	534	14,45	734				
P			○		○		●		●		●		●		●
M											○				
K			●		●		○		○				○		○
N															
S															
H															
O															

TNMM / TNMG

		NEW		NEW		NEW		NEW	
		-R58 CTCP135	-F30 CTCM120	-F30 CTPM125	-F30 CTCM130	-M30 CTCM120	-M30 CTPM125	-M30 CTCM130	
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	
									
		R TNMM	F TNMG	F TNMG	F TNMG	M TNMG	M TNMG	M TNMG	
		76 152 ...	75 019 ...	75 019 ...	75 019 ...	75 020 ...	75 020 ...	75 020 ...	
ISO	RE mm	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08	
160404EN	0,4		10,71	10,71	10,71	10,71	10,71	10,71	
160408EN	0,8		10,71	10,71	10,71	10,71	10,71	10,71	
160412EN	1,2					10,71	10,71	10,71	
220412EN	1,2	14,45							
P		•	○	○	○	○	○	○	
M		○	•	•	•	•	•	•	
K									
N									
S					○			○	
H									
O									

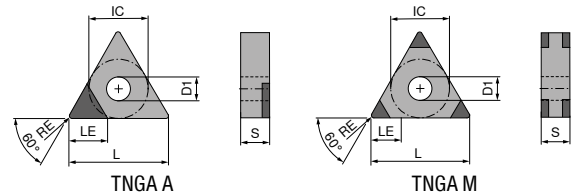
TNMG

		NEW		NEW		NEW	
		-M60 CTCM120	-M60 CTPM125	-M60 CTCM130	-M34 CTPX710		
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN		
							
		M TNMG	M TNMG	M TNMG	M TNMG		
		75 021 ...	75 021 ...	75 021 ...	75 006 ...		
ISO	RE mm	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08		
160408EN	0,8	10,71	10,71	10,71	10,62		
160412EN	1,2	10,71	10,71	10,71	10,71		
220404EN	0,4				15,28		
220408EN	0,8				15,28		
220416EN	1,6				15,28		
P		○	○	○	•		
M		•	•	•	•		
K							
N					○		
S					○		
H							
O							

9

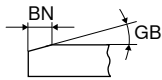
TNGA

Designation	L mm	S mm	D1 mm	IC mm
TNGA 1103..	11,0	3,18	2,26	6,35
TNGA 1604..	16,5	4,76	3,81	9,52



TNGA

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

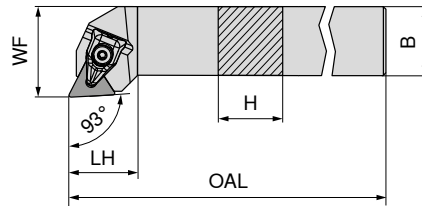


ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	CTBH20U		CTBH20C		CTBH40U		CTBH40C	
						F	CBN TNGA	F	CBN TNGA	F	CBN TNGA	F	CBN TNGA
110304TN	0,4	0,12	20°	A (1)	2,8	71 108 ...	EUR Y0 37,02	500		71 108 ...	EUR Y0 37,02	802 1)	
110308FN	0,8			A (1)	2,5								
110308TN	0,8	0,12	20°	A (1)	2,5	37,02	502			37,02	802 1)		
160404FN	0,4			A (1)	3,5	34,86	404 1)			34,86	804 1)		
160404TN	0,4	0,09	15°	M (6)	2,8			100,30	222			100,30	332
160404SN	0,4	0,09	20°	M (6)	2,8			100,30	242			100,30	342
160404SN	0,4	0,11	20°	M (6)	2,8								
160404TN	0,4	0,12	20°	A (1)	3,5	34,86	504					100,30	352
160404SN	0,4	0,11	25°	M (6)	2,8			100,30	252				
160404TN	0,4	0,11	25°	M (6)	2,8					34,86	904		
160404TN	0,4	0,12	25°	A (1)	3,5			100,30	212				
160404FN	0,4			M (6)	2,8			100,30	262				
160404SN	0,4	0,13	25°	M (6)	2,8							100,30	372
160404SN	0,4	0,14	30°	M (6)	2,8							100,30	382
160404SN	0,4	0,14	35°	M (6)	2,8								
160408TN	0,8	0,09	15°	M (6)	2,5			100,30	224			100,30	324
160408SN	0,8	0,09	15°	M (6)	2,5							100,30	334
160408SN	0,8	0,09	20°	M (6)	2,5								
160408TN	0,8	0,09	20°	M (6)	2,5			100,30	234			100,30	344
160408SN	0,8	0,11	20°	M (6)	2,5			100,30	244			100,30	354
160408TN	0,8	0,12	20°	A (1)	3,0	34,86	506						
160408SN	0,8	0,11	25°	M (6)	2,5			100,30	254				
160408TN	0,8	0,11	25°	M (6)	2,5					34,86	906		
160408TN	0,8	0,12	25°	A (1)	3,0			100,30	264			100,30	364
160408SN	0,8	0,13	25°	M (6)	2,5			100,30	27200			100,30	374
160408SN	0,8	0,14	30°	M (6)	2,5							100,30	384
160408SN	0,8	0,14	35°	M (6)	2,5								
160408FN	0,8			M (6)	2,5			100,30	214				
160408FN	0,8			A (1)	3,0	34,86	406 1)			34,86	80500		
160408EN	0,8			M (6)	2,5							100,30	314
160412TN	1,2	0,09	15°	M (6)	2,2			100,30	226			100,30	336
160412SN	1,2	0,09	20°	M (6)	2,2							100,30	346
160412SN	1,2	0,11	20°	M (6)	2,2			100,30	246			100,30	356
160412SN	1,2	0,11	25°	M (6)	2,2								
160412TN	1,2	0,11	25°	M (6)	2,2			100,30	256			100,30	366
160412SN	1,2	0,13	25°	M (6)	2,2			100,30	266			100,30	376
160412SN	1,2	0,14	30°	M (6)	2,2							100,30	386
160412SN	1,2	0,14	35°	M (6)	2,2								
160412FN	1,2			M (6)	2,2			100,30	216				

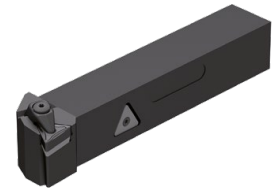
P				
M				
K				
N				
S				
H				
O				

1) Machining to 60 HRC

MaxiLock-D – DTJN 93° – Toolholder with top clamping



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 591 ...		Right-hand 70 590 ...	
								EUR 2A/24		EUR 2A/24	
DTJN R/L 2020 K16	20	20	125	23	25	2	TNM. 1604	87,59	820	87,59	820
DTJN R/L 2525 M16	25	25	150	24	32	2	TNM. 1604	90,61	825	90,61	825

Spare parts
for Article no.

70 590 820 / 70 591 820	EUR 2A/28 24,82	823	T09 - IP	EUR Y7 11,58	126	M3x7 - IP	EUR 2A/28 3,30	819	EUR 2A/28 7,29	847
70 590 825 / 70 591 825	EUR 2A/28 24,82	823	T09 - IP	EUR Y7 11,58	126	M3x7 - IP	EUR 2A/28 3,30	819	EUR 2A/28 7,29	847



XPress type

70 950 ...

EUR
2A/28
24,82

823



Key D

80 950 ...

EUR
Y7
11,58

126



Clamping screw

70 950 ...

EUR
2A/28
24,82

819

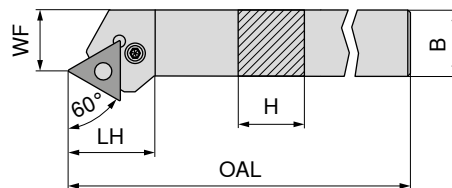
Solid Carbide
Seat T

70 950 ...

EUR
2A/28
7,29

847

MaxiLock-N – PTTN 60° – Toolholder with lever clamping



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 529 ...		Right-hand 70 528 ...	
								EUR 2A/24		EUR 2A/24	
PTTN R/L 2020 K16	20	20	125	25,9	17	3	TNM. 1604	87,59	020	87,59	020
PTTN R/L 2525 M22	25	25	150	32,7	22	4	TNM. 2204	90,61	025	90,61	025

Spare parts
for Article no.

70 529 020 / 70 528 020	EUR 2A/28 2,57	175	SW2,5	EUR 2A/28 1,85	197	EUR 2A/28 1,28	191	EUR 2A/28 13,10	185	EUR 2A/28 3,35	208	EUR 2A/28 7,29	225
70 529 025 / 70 528 025	EUR 2A/28 2,57	176	SW3	EUR 2A/28 1,85	198	EUR 2A/28 1,28	192	EUR 2A/28 13,22	187	EUR 2A/28 3,68	209	EUR 2A/28 10,43	226



Key I

70 950 ...

EUR
2A/28
2,57

175

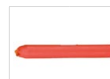


Shim

70 950 ...

EUR
2A/28
1,85

197



Assembly pin

70 950 ...

EUR
2A/28
1,28

191



Lever

70 950 ...

EUR
2A/28
13,10

185



Clamping screw

70 950 ...

EUR
2A/28
3,35

208

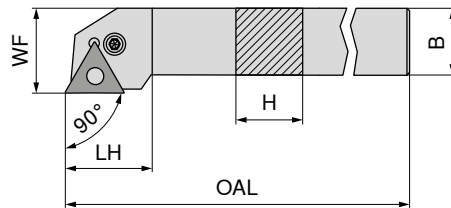
Solid Carbide
Seat T

70 950 ...

EUR
2A/28
7,29

225

MaxiLock-N – PTGN 90° – Toolholder with lever clamping



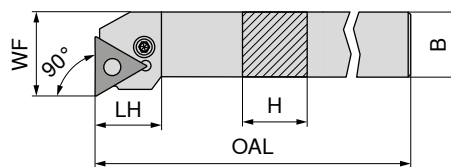
Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 533 ...		Right-hand 70 532 ...	
								EUR 2A/24		EUR 2A/24	
PTGN R/L 1616 H16	16	16	100	20	20	3	TNM. 1604	78,62	016	78,62	016
PTGN R/L 2020 K16	20	20	125	20	25	3	TNM. 1604	87,59	020	87,59	020
PTGN R/L 2525 M16	25	25	150	22	32	3	TNM. 1604	90,61	025	90,61	025
PTGN R/L 3225 P16	32	25	170	22	32	3	TNM. 1604	97,20	032	97,20	032
PTGN R/L 2525 M22	25	25	150	29	32	4	TNM. 2204	90,61	125	90,61	125
PTGN R/L 3232 P22	32	32	170	29	40	4	TNM. 2204	122,40	132	122,40	132

Spare parts for Article no.	70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	
	EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28	
70 532 016 / 70 533 016	2,57	175	1,85	197	1,28	191	13,10	185	3,35	208	7,29	225
70 532 020 / 70 533 020	2,57	175	1,85	197	1,28	191	13,10	185	3,35	208	7,29	225
70 532 025 / 70 533 025	2,57	175	1,85	197	1,28	191	13,10	185	3,35	208	7,29	225
70 532 032 / 70 533 032	2,57	175	1,85	197	1,28	191	13,10	185	3,35	208	7,29	225
70 532 125 / 70 533 125	2,57	176	1,85	198	1,28	192	13,22	187	3,68	209	10,43	226
70 532 132 / 70 533 132	2,57	176	1,85	198	1,28	192	13,22	187	3,68	209	10,43	226

MaxiLock-N – PTFN 90° – Toolholder with lever clamping



Illustrations show right-hand versions



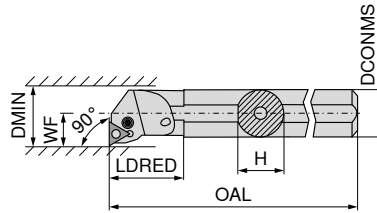
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 535 ...		Right-hand 70 534 ...	
								EUR 2A/24		EUR 2A/24	
PTFN R/L 1616 H16	16	16	100	19,7	20	3	TNM. 1604	78,62	016	78,62	016
PTFN R/L 2020 K16	20	20	125	20,2	25	3	TNM. 1604	87,59	020	87,59	020
PTFN R/L 2525 M16	25	25	150	20,2	32	3	TNM. 1604	90,61	025	90,61	025
PTFN R/L 2525 M22	25	25	150	25,2	32	4	TNM. 2204	90,61	125	90,61	125
PTFN R/L 3225 P22	32	25	170	25,2	32	4	TNM. 2204	97,20	132	97,20	132

Spare parts for Article no.	70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	
	EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28	
70 534 016 / 70 535 016	2,57	175	1,85	197	1,28	191	13,10	185	3,35	208	7,29	225
70 534 020 / 70 535 020	2,57	175	1,85	197	1,28	191	13,10	185	3,35	208	7,29	225
70 534 025 / 70 535 025	2,57	175	1,85	197	1,28	191	13,10	185	3,35	208	7,29	225
70 534 125 / 70 535 125	2,57	176	1,85	198	1,28	192	13,22	187	3,68	209	10,43	226
70 534 132 / 70 535 132	2,57	176	1,85	198	1,28	192	13,22	187	3,68	209	10,43	226

MaxiLock-N – PTFN 90° – Boring bar with lever clamping

▲ A... = with thro' coolant

▲ S... = without thro' coolant



Illustrations show right-hand versions

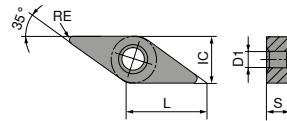


ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									70 565 ...		70 564 ...	
									EUR 2A/24		EUR 2A/24	
A16M PTFN R/L 11	16	15,0	150	14,0	11	20	2,2	TNM. 1103	152,10	216	152,10	216
A20Q PTFN R/L 11	20	18,5	180	14,0	13	25	2,2	TNM. 1103	205,40	220	205,40	220
A25R PTFN R/L 16	25	23,0	200	17,5	17	32	3	TNM. 1604	228,90	225	228,90	225
S25T PTFN R 16	25	23,0	300	17,5	17	32	3	TNM. 1604			228,90	02500
A32S PTFN R/L 16	32	30,0	250	18,0	22	40	3	TNM. 1604	236,70	232	236,70	232
A40T PTFN R/L 22	40	38,0	300	27,0	27	50	4	TNM. 2204	263,70	240	263,70	240
S50W PTFN R 22	50	47,0	450	35,0	35	63	4	TNM. 2204			326,30	050

Spare parts for Article no.	Key I		Shim		Assembly pin		Lever		Clamping screw		Solid Carbide Seat T	
	70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	
	EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28	
70 564 216 / 70 565 216	2,57	177					13,22	184	2,23	207		
70 564 220 / 70 565 220	2,57	177					13,22	184	2,23	207		
70 564 225 / 70 565 225	2,57	175	1,85	197	1,28	191	13,10	185	3,35	208	7,29	225
70 564 02500	2,57	175	1,85	197	1,28	191	13,10	185	3,35	208	7,29	225
70 564 232 / 70 565 232	2,57	175	1,85	197	1,28	191	13,10	185	3,35	208	7,29	225
70 564 240 / 70 565 240	2,57	176	1,85	198	1,28	192	13,22	187	3,68	209	10,43	226
70 564 050	2,57	176	1,85	198	1,28	192	13,22	187	3,68	209	10,43	226

VNMG

Designation	L mm	S mm	D1 mm	IC mm
VNMG 1604..	16,6	4,76	3,81	9,52



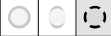
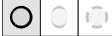
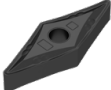
VNMG

		-F40 CTCP125	-F50 CTCP115	-F50 CTCP125	-F50 CTCP135	-XU CTCP115	-XU CTCP125	-M40 CTCP125
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F VNMG	F VNMG	F VNMG	F VNMG	M VNMG	M VNMG	M VNMG
		76 000 ...	76 156 ...	76 156 ...	76 156 ...	76 294 ...	76 294 ...	76 001 ...
ISO	RE mm	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08
160404EN	0,4	21,61	21,61	21,61	21,61	21,57	21,57	21,61
160408EN	0,8	21,61	21,61	21,61	21,61	21,57	21,57	21,61
P		•	•	•	•	•	•	•
M					○			
K		○	○	○		○	○	○
N								
S								
H								
O								

VNMG

		-M50 CTCK120	-M50 CTCP115	-M50 CTCP125	NEW -F30 CTCM120	-F30 CTPM125	NEW -F30 CTCM130	NEW -M30 CTCM120
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M VNMG	M VNMG	M VNMG	F VNMG	F VNMG	F VNMG	M VNMG
		70 131 ...	76 131 ...	76 131 ...	75 022 ...	75 022 ...	75 022 ...	75 023 ...
ISO	RE mm	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08
160404EN	0,4		21,61	21,61	21,61	21,61	21,61	
160408EN	0,8	21,61	21,61	21,61	21,61	21,61	21,61	21,61
160412EN	1,2	21,61	21,61	21,61				
P		○	•	•	○	○	○	○
M					•	•	•	•
K		•	○	○				
N								
S							○	
H								
O								

VNMG

		-M30 CTPM125		NEW -M30 CTCM130		NEW -M34 CTPX710	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
							
							
		M VNMG		M VNMG		M VNMG	
		75 023 ...		75 023 ...		75 009 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08	
160404EN	0,4					20,55 61600	
160408EN	0,8	21,61 218		21,61 31800		20,55 61800	
160412EN	1,2					20,55 62000	
P		○		○		●	
M		●		●		●	
K							
N						○	
S				○		●	
H							
O							

VNMG

ISO	RE mm				
160404EN	0,4				
160408EN	0,8				
P				●	●
M				○	○
K					
N					
S					
H					
O					

NEW

-FMS

CT-P15

○

○

○



F

VNMG

75 310 ...

EUR 1S/1N

4,57 01609

4,57 01809

NEW

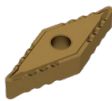
-FMS

CT-P25

○

○

○



F

VNMG

75 310 ...

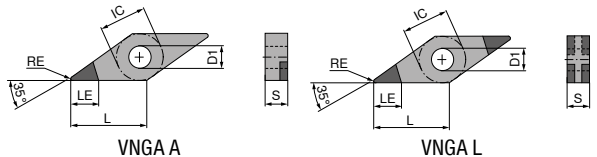
EUR 1S/1N

4,57 11609

4,57 11809

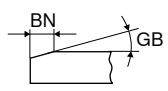
VNGA

Designation	L mm	S mm	D1 mm	IC mm
VNGA 1604..	16,6	4,76	3,81	9,52



VNGA

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

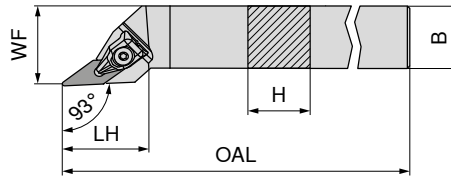


ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
160404FN	0,4			A (1)	5,0
160404SN	0,4	0,09	20°	L (4)	2,8
160404SN	0,4	0,11	20°	L (4)	2,8
160404TN	0,4	0,11	25°	L (4)	2,8
160404SN	0,4	0,11	25°	L (4)	2,8
160404TN	0,4	0,12	25°	A (1)	5,0
160404SN	0,4	0,13	25°	L (4)	2,8
160404SN	0,4	0,14	30°	L (4)	2,8
160404SN	0,4	0,14	35°	L (4)	2,8
160404FN	0,4			L (4)	2,8
160408SN	0,8	0,09	15°	L (4)	2,2
160408SN	0,8	0,11	20°	L (4)	2,2
160408SN	0,8	0,11	25°	L (4)	2,2
160408TN	0,8	0,11	25°	L (4)	2,2
160408TN	0,8	0,12	25°	A (1)	4,4
160408SN	0,8	0,13	25°	L (4)	2,2
160408SN	0,8	0,14	30°	L (4)	2,2
160408SN	0,8	0,14	35°	L (4)	2,2
160408FN	0,8			L (4)	2,2
160408FN	0,8			A (1)	4,4

NEW	NEW	NEW
CTBH20C	CTBH40U	CTBH40C
F	F	F
CBN	CBN	CBN
VNGA	VNGA	VNGA
71 413 ...	71 412 ...	71 413 ...
EUR	EUR	EUR
Y0	Y0	Y0
	59,34	60000
74,70		74,70
30100		60100
74,70		60100
	59,34	50100
		74,70
		74,70
		74,70
74,70		30000
		74,70
74,70		30400
		74,70
74,70		30500
	59,34	50300
74,70		74,70
		74,70
		74,70
74,70		30300
	59,34	50200

P
M
K
N
S
H
O

MaxiLock-D – DVJN 93° – Toolholder with top clamping



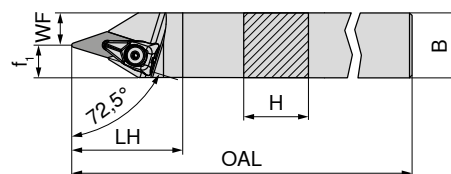
Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand		Right-hand	
								70 503 ...		70 502 ...	
DVJN R/L 2020 K16	20	20	125	39	25	2	VN.. 1604	EUR 2A/24 100,80	620	EUR 2A/24 100,80	620
DVJN R/L 2525 M16	25	25	150	39	32	2	VN.. 1604	106,90	725	106,90	725

Spare parts for Article no.	XPress type		Key D		Clamping screw		Solid Carbide Seat V	
	70 950 ...		80 950 ...		70 950 ...		70 950 ...	
70 502 620 / 70 503 620	EUR 2A/28 29,62	835	EUR Y7 11,58	126	EUR 2A/28 3,30	819	EUR 2A/28 5,87	806
70 502 725 / 70 503 725	29,62	835	11,58	126	3,30	819	5,87	806

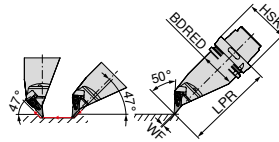
MaxiLock-D – DVVN 72.5° – Toolholder with top clamping



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	f ₁ mm	torque moment Nm	Insert	Neutral	
									70 506 ...	
DVVN N 2020 K16	20	20	125	43	7,5	12,5	2	VN.. 1604	EUR 2A/24 100,80	620
DVVN N 2525 M16	25	25	150	43	12,5	12,5	2	VN.. 1604	106,90	625

Spare parts for Article no.	XPress type		Key D		Clamping screw		Solid Carbide Seat V	
	70 950 ...		80 950 ...		70 950 ...		70 950 ...	
70 506 620	EUR 2A/28 29,62	835	EUR Y7 11,58	126	EUR 2A/28 3,30	819	EUR 2A/28 5,87	806
70 506 625	29,62	835	11,58	126	3,30	819	5,87	806

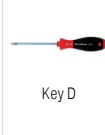
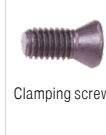
MaxiLock-D – DVMN 50° – Toolholder with top clamping



Left-hand

74 525 ...

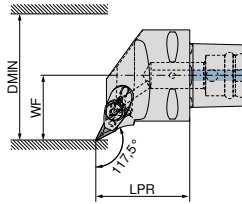
ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert	EUR 2D/80	
HSK T63 DVMN L 16	HSK-T 63	130	53	0	2	VN.. 1604	376,10	516
HSK T100 DVMN L 16	HSK-T 100	160	88	0	2	VN.. 1604	461,40	716

			
70 950 ...	80 950 ...	70 950 ...	70 950 ...
EUR 2A/28	EUR Y7	EUR 2A/28	EUR 2A/28
74 525 516	T09 - IP	M3x7 - IP	806
74 525 716	T09 - IP	M3x7 - IP	806

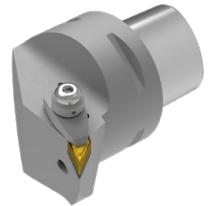
Spare parts
for Article no.

74 525 516	835	T09 - IP	126	M3x7 - IP	819	806
74 525 716	835	T09 - IP	126	M3x7 - IP	819	806

MaxiLock-D – DVPN 117,5° – Toolholder with top clamping



Illustrations show right-hand versions



NEW

Left-hand

84 673 ...

NEW

Right-hand

84 672 ...

ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert			EUR Y8		EUR Y8	
PSC40 DVPN R/L 50050-16	PSC 40	50	27	50	10	VN.. 1604			247,30	01695	247,30	01695
PSC50 DVPN R/L 65060-16	PSC 50	60	35	65	10	VN.. 1604			278,20	01694	278,20	01694
PSC63 DVPN R/L 80065-16	PSC 63	65	45	80	10	VN.. 1604			303,90	01693	303,90	01693



Clamping Screw



Clamping claw



Ring-shaped nozzle



Clamping screw



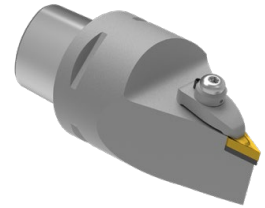
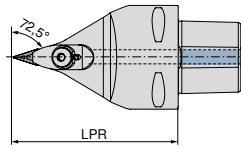
Solid Carbide Seat V

		84 950 ...		84 950 ...		84 950 ...		84 950 ...		84 950 ...	
Spare parts		EUR		EUR		EUR		EUR		EUR	
Adapter		Y8		Y8		Y8		Y8		Y8	
PSC 40	M6X28 SW4	20,47	28300	24,25	28500	7,81	28400	3,20	27600	24,61	28000
PSC 50	M6X28 SW4	20,47	28300	24,25	28500	7,81	28400	3,20	27600	24,61	28000
PSC 63	M6X28 SW4	20,47	28300	24,25	28500	7,81	28400	3,20	27600	24,61	28000

Spare parts
Adapter

PSC 40	M6X28 SW4	28300	24,25	28500	7,81	28400	3,20	27600	24,61	28000
PSC 50	M6X28 SW4	28300	24,25	28500	7,81	28400	3,20	27600	24,61	28000
PSC 63	M6X28 SW4	28300	24,25	28500	7,81	28400	3,20	27600	24,61	28000

MaxiLock-D – DVVN 72,5° – Toolholder with top clamping



NEW

Neutral

84 679 ...

EUR
Y8

ISO designation	Adapter	LPR mm	torque moment Nm	Insert
PSC63 DVVN N 0100-16	PSC 63	100	10	VN.. 1604
PSC63 DVVN N 0130-16	PSC 63	130	10	VN.. 1604

303,90 01693
303,90 11693

Clamping Screw

84 950 ...

EUR
Y8

20,47 28300



Clamping claw

84 950 ...

EUR
Y8

24,25 28500

Ring-shaped
nozzle

84 950 ...

EUR
Y8

7,81 28400



Clamping screw

84 950 ...

EUR
Y8

3,20 27600

Solid Carbide
Seat V

84 950 ...

EUR
Y8

24,61 28000

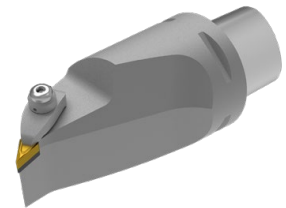
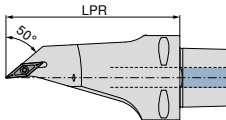
Spare parts

Adapter

PSC 63

M6X28 SW4

MaxiLock-D – DVMN 50° – Toolholder with top clamping



NEW

Neutral

84 682 ...

EUR
Y8

ISO designation	Adapter	LPR mm	torque moment Nm	Insert
PSC63 DVMN L 0130-16	PSC 63	130	10	VN.. 1604

353,20 01693



Clamping Screw

84 950 ...

EUR
Y8

20,47 28300



Clamping claw

84 950 ...

EUR
Y8

24,25 28600

Ring-shaped
nozzle

84 950 ...

EUR
Y8

7,81 28400



Clamping screw

84 950 ...

EUR
Y8

3,20 27600

Solid Carbide
Seat V

84 950 ...

EUR
Y8

24,61 28000

Spare parts

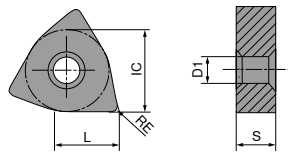
Adapter

PSC 63

M6X28 SW4

WNMG / WNMA

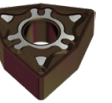
Designation	L mm	S mm	D1 mm	IC mm
WNMG 0604..	6,5	4,76	3,81	9,52
WNM. 0804..	8,6	4,76	5,16	12,70



WNMG

		-CF20 CTEP110		-TFQ CTEP110		-F50 CTCP115		-F50 CTCP125		-F50 CTCP135		-TFQ CTCP115		-TFQ CTCP125	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		F		F		F		F		F		F		F	
		CERMET WNMG		CERMET WNMG		WNMG		WNMG		WNMG		WNMG		WNMG	
		76 171 ...		76 177 ...		76 157 ...		76 157 ...		76 157 ...		76 177 ...		76 177 ...	
		EUR 1A/78		EUR 1A/78		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
ISO	RE mm														
060404EN	0,4	10,16	004			10,45	304	10,45	504	10,45	704	12,10	304	12,10	514
060408EN	0,8	10,16	006	12,10	006	10,45	306	10,45	506	10,45	706	12,10	306	12,10	506
080404EN	0,4			15,14	016	13,16	316	13,16	516	13,16	716				
080408EN	0,8	13,16	018	15,14	018	13,16	318	13,16	518	13,16	718	15,14	318	15,14	518
080412EN	1,2					13,16	320	13,16	520	13,16	720	15,14	320	15,14	520
P		●		●		●		●		●		●		●	
M		○		○						○					
K		○		○		○		○				○		○	
N															
S															
H															
O															

WNMG

		-XU CTCP115		-XU CTCP125		-M50 CTCK110		-M50 CTCK120		-M50 CTCP115		-M50 CTCP125		-M50 CTCP135	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
															
		M		M		M		M		M		M		M	
		WNMG		WNMG		WNMG		WNMG		WNMG		WNMG		WNMG	
		76 295 ...		76 295 ...		70 139 ...		70 139 ...		76 139 ...		76 139 ...		76 139 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
060404EN	0,4									10,45	304	10,45	504	10,45	704
060408EN	0,8									10,45	306	10,45	506	10,45	706
060412EN	1,2									10,45	308	10,45	508	10,45	708
080404EN	0,4	13,17	316	13,17	516					13,16	316	13,16	516	13,16	716
080408EN	0,8	13,17	318	13,17	518	13,16	018	13,16	518	13,16	318	13,16	518	13,16	718
080412EN	1,2	13,17	320	13,17	520	13,16	020	13,16	520	13,16	320	13,16	520	13,16	720
080416EN	1,6							13,16	522	13,16	322	13,16	522	13,16	722
P			•		•		○		○		•		•		•
M															○
K			○		○		•		•		○		○		
N															
S															
H															
O															

WNMG

		-TMQ CTCP115		-TMQ CTCP125		-M70 CTCK110		-M70 CTCK120		-M70 CTCP115		-M70 CTCP125		-M70 CTCP135	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
															
		M		M		M		M		M		M		M	
		WNMG		WNMG		WNMG		WNMG		WNMG		WNMG		WNMG	
		76 198 ...		76 198 ...		70 273 ...		70 273 ...		76 273 ...		76 273 ...		76 273 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
060408EN	0,8									10,45	306	10,45	506	10,45	706
060412EN	1,2									10,45	308	10,45	508	10,45	708
080408EN	0,8	15,14	31800	15,14	518	13,16	018	13,16	518	13,16	318	13,16	518	13,16	718
080412EN	1,2	15,14	320	15,14	520	13,16	020	13,16	520	13,16	320	13,16	520	13,16	720
080416EN	1,6					13,16	022	13,16	522	13,16	322	13,16	522	13,16	722
P			•		•		○		○		•		•		•
M															○
K			○		○		•		•		○		○		
N															
S															
H															
O															

WNMA / WNMG

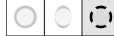
		CTCK110		CTCK120		NEW -F30 CTCM120		-F30 CTPM125		NEW -F30 CTCM130		NEW -M30 CTCM120		-M30 CTPM125	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
		R		R		F		F		F		M		M	
		WNMA		WNMA		WNMG		WNMG		WNMG		WNMG		WNMG	
		70 169 ...		70 169 ...		75 024 ...		75 024 ...		75 024 ...		75 025 ...		75 025 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
060404EN	0,4					10,45	10400	10,45	204	10,45	30400				
060408EN	0,8					10,45	10600	10,45	206	10,45	30600	10,45	10600	10,45	206
060412EN	1,2									10,45	30600	10,45	10800	10,45	208
080404EN	0,4					13,16	11600	13,16	216	13,16	31600				
080408EN	0,8	13,16	018	13,16	518	13,16	11800	13,16	218	13,16	31800	13,16	11800	13,16	218
080412EN	1,2	13,16	020	13,16	520							13,16	12000	13,16	220
080416EN	1,6	13,16	022	13,16	522										
P			○		○		○		○		○		○		○
M						●		●		●		●		●	
K			●		●										
N															
S											○				
H															
O															

9

WNMG

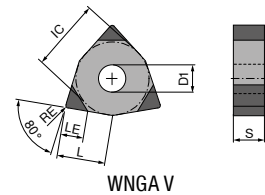
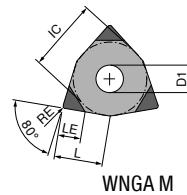
		NEW -M30 CTCM130		NEW -M60 CTCM120		-M60 CTPM125		NEW -M60 CTCM130		NEW -M34 CTPX710	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
											
		M		M		M		M		M	
		WNMG		WNMG		WNMG		WNMG		WNMG	
		75 025 ...		75 026 ...		75 026 ...		75 026 ...		75 008 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
060408EN	0,8	10,45	30600	10,45	10600	10,45	206	10,45	30600		
060412EN	1,2	10,45	30800	10,45	10800	10,45	208	10,45	30800		
080408EN	0,8	13,16	31800	13,16	11800	13,16	218	13,16	31800	13,74	61800
080412EN	1,2	13,16	32000	13,16	12000	13,16	220	13,16	32000	13,74	62000
P			○		○		○		○		●
M			●		●		●		●		●
K											
N											○
S			○						○		●
H											
O											

WNMG

		NEW		NEW		NEW		NEW		NEW	
		-FMS CT-P15		-FMS CT-P25		-MRS CT-P15		-MRS CT-P25		-MRS CT-P35	
											
											
		F		F		M		M		M	
		WNMG		WNMG		WNMG		WNMG		WNMG	
		75 311 ...		75 311 ...		75 312 ...		75 312 ...		75 312 ...	
		EUR		EUR		EUR		EUR		EUR	
		1S/1N		1S/1N		1S/1N		1S/1N		1S/1N	
		4,23 01609		4,23 11609		4,23 01809		4,23 11809		4,23 21809	
		4,23 01809		4,23 11809		4,23 02009		4,23 12009		4,23 22009	
		4,23 02009		4,23 12009		4,23 02009		4,23 12009		4,23 22009	
		P		M		K		N		S	
		H		O							

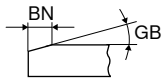
WNGA

Designation	L mm	S mm	D1 mm	IC mm
WNGA 0804..	8,5	4,76	5,13	12,7



WNGA

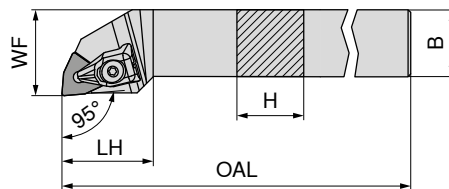
▲ TCE(NOI) = Design and number of equipped cutting edge corners



						NEW						NEW	
						CTBS05U	CTBS20C	CTBH20C	CTBH40C	CTBH40C		-Q	CTBH40C
						F	F	F	F	F		F	
						CBN	CBN	CBN	CBN	CBN		CBN	
						WNGA	WNGA	WNGA	WNGA	WNGA		WNGA	
						71 415 ...	71 405 ...	71 405 ...	71 405 ...	71 414 ...			
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0		EUR Y0	
080404FN	0,4			M (6)	2,8			87,49 20200					
080404SN	0,4	0,09	10°	M (6)	2,8		87,49 122						
080404TN	0,4	0,09	15°	M (6)	2,8			87,49 23200					
080404SN	0,4	0,09	15°	M (6)	2,8		87,49 132			87,49 332			
080404SN	0,4	0,09	20°	M (6)	2,8		87,49 152						
080404SN	0,4	0,11	20°	M (6)	2,8			87,49 242					
080404TN	0,4	0,11	25°	M (6)	2,8			87,49 25200		87,49 352			
080404SN	0,4	0,13	25°	M (6)	2,8			87,49 262		87,49 372			
080404SN	0,4	0,14	30°	M (6)	2,8								
080404TN	0,4	0,20	30°	V (3)	2,8	150,60 00100							
080404TN	0,4	0,20	30°	V (3)	4,5	175,00 00200							
080408SN	0,8	0,09	10°	M (6)	2,5		87,49 124						
080408TN	0,8	0,09	15°	M (6)	2,5			87,49 23300					
080408SN	0,8	0,09	15°	M (6)	2,5		87,49 134						
080408SN	0,8	0,09	20°	M (6)	2,5		87,49 154			87,49 334			
080408SN	0,8	0,11	20°	M (6)	2,5			87,49 244					
080408TN	0,8	0,11	25°	M (6)	2,5			87,49 25300		87,49 354			
080408SN	0,8	0,11	25°	M (6)	2,5					87,49 364		110,60 60100	
080408SN	0,8	0,13	25°	M (6)	2,5			87,49 264		87,49 376			
080408SN	0,8	0,16	25°	M (6)	2,5		87,49 174						
080408SN	0,8	0,14	30°	M (6)	2,5			87,49 274					
080408TN	0,8	0,20	30°	V (3)	2,6	150,60 00300							
080408TN	0,8	0,20	30°	V (3)	4,2	175,00 00400							
080408SN	0,8	0,14	35°	M (6)	2,5					87,49 38200			
080408EN	0,8			M (6)	2,5							110,60 60000	
080412SN	1,2	0,11	20°	M (6)	2,2					87,49 34200			
080412SN	1,2	0,11	25°	M (6)	2,2					87,49 35100			
080412SN	1,2	0,14	30°	M (6)	2,2					87,49 36100			
080412TN	1,2	0,20	30°	V (3)	2,4	150,60 00500							
080412TN	1,2	0,20	30°	V (3)	4,0	175,00 00600							
080412SN	1,2	0,14	35°	M (6)	2,2					87,49 38300			

P													
M													
K													
N													
S													
H													
O													

MaxiLock-D – DWLN 95° – Toolholder with top clamping



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 543 ...		Right-hand 70 542 ...	
								EUR 2A/24		EUR 2A/24	
DWLN R/L 1616 H06	16	16	100	25	20	2	WN.. 0604	78,62	716	78,62	716
DWLN R/L 2020 K06	20	20	125	27	25	2	WN.. 0604	87,59	720	87,59	720
DWLN R/L 2525 M06	25	25	150	27	32	2	WN.. 0604	90,61	725	90,61	725
DWLN R/L 2020 K08	20	20	125	34	25	4	WN.. 0804	87,59	620	87,59	620
DWLN R/L 2525 M08	25	25	150	34	32	4	WN.. 0804	90,61	625	90,61	625

Spare parts
for Article no.

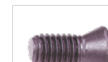
	70 950 ...		80 950 ...		70 950 ...		70 950 ...	
	EUR 2A/28		EUR Y7		EUR 2A/28		EUR 2A/28	
70 543 716 / 70 542 716	24,82	823	11,58	126	3,30	819	3,57	807
70 543 720 / 70 542 720	24,82	823	11,58	126	3,30	819	3,57	807
70 543 725 / 70 542 725	24,82	823	11,58	126	3,30	819	3,57	807
70 543 620 / 70 542 620	24,48	824	12,25	128	3,13	820	10,43	812
70 543 625 / 70 542 625	24,48	824	12,25	128	3,13	820	10,43	812



XPress type



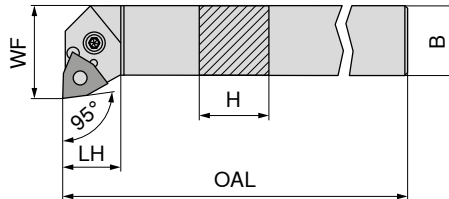
Key D



Clamping screw

Solid Carbide
Seat W

MaxiLock-N – PWLN 95° – Toolholder with lever clamping



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 543 ...		Right-hand 70 542 ...	
								EUR 2A/24		EUR 2A/24	
PWLN R/L 1616 H06	16	16	100	20	22,5	3	WNMG 0604	78,62	116	78,62	11600 ¹⁾
PWLN R/L 2020 K06	20	20	125	26	25,0	3	WNMG 0604	87,59	12000 ¹⁾	87,59	12000 ¹⁾
PWLN R/L 2525 M06	25	25	150	19	32,0	3	WNMG 0604	90,61	125	90,61	12500 ¹⁾
PWLN R/L 2020 K08	20	20	125	22	25,0	4	WNMG 0804	87,59	020	87,59	020
PWLN R/L 2525 M08	25	25	150	22	32,0	4	WNMG 0804	90,61	025	90,61	025
PWLN R/L 3225 P08	32	25	170	22	32,0	4	WNMG 0804	97,20	032	97,20	032

1) nickel-plated

Spare parts
for Article no.

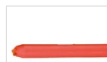
	70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	
	EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28	
70 542 11600 / 70 543 116	2,57	175	2,16	122	1,28	191	13,10	185	3,35	208	7,57	127
70 542 12000 / 70 543 12000	2,57	175	2,16	122	1,28	191	13,10	185	3,35	208	7,57	127
70 542 12500 / 70 543 125	2,57	175	2,16	122	1,28	191	13,10	185	3,35	208	7,57	127
70 542 020 / 70 543 020	2,57	176	1,85	198	1,28	192	13,22	187	3,68	209	9,16	235
70 542 025 / 70 543 025	2,57	176	1,85	198	1,28	192	13,22	187	3,68	209	9,16	235
70 542 032 / 70 543 032	2,57	176	1,85	198	1,28	192	13,22	187	3,68	209	9,16	235



Key I



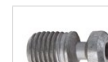
Shim



Assembly pin



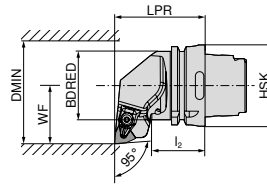
Lever



Clamping screw

Solid Carbide
Seat W

MaxiLock-D – DWLN 95° – Toolholder with top clamping



Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	I ₂ mm	BDRED mm	WF mm	DMIN mm	Insert	Left-hand		Right-hand	
								74 529 ...		74 528 ...	
HSK T63 DWLN R/L 08	HSK-T 63	70	42	53	45	125	WN.. 0804	EUR 2D/80		EUR 2D/80	
HSK T100 DWLN R/L 08	HSK-T 100	80	45	88	55	125	WN.. 0804	236,00	508	236,00	508
								277,00	708	277,00	708

Spare parts
for Article no.

74 528 508 / 74 529 508	EUR 2A/28	824	T15 - IP	EUR Y7	128	M4,5x12 - IP	EUR 2A/28	820	EUR 2A/28	812
74 528 708 / 74 529 708	24,48	824	T15 - IP	12,25	128	M4,5x12 - IP	3,13	820	10,43	812

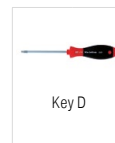


XPress type

70 950 ...

EUR
2A/28

24,48



Key D

80 950 ...

EUR
Y7

12,25



Clamping screw

70 950 ...

EUR
2A/28

3,13

Solid Carbide
Seat W

70 950 ...

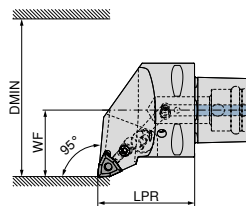
EUR
2A/28

10,43

MaxiLock-N – PWLN 95° – Toolholder with lever clamping

Scope of supply:

without high-performance coolant set



Illustrations show right-hand versions

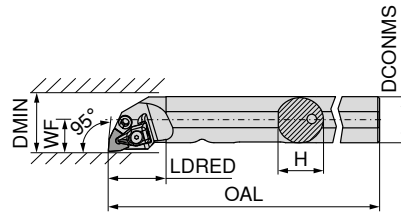


ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Direct cooling compatible	Left-hand		Right-hand	
								84 653 ...		84 652 ...	
PSC40 PWLN R/L 50050-08	PSC 40	50	27	50	5	WN.. 0804	DC	EUR Y8		EUR Y8	
PSC50 PWLN R/L 65060-08	PSC 50	60	35	65	5	WN.. 0804	DC	229,30	00895	229,30	00895
PSC63 PWLN R/L 80065-08	PSC 63	65	45	80	5	WN.. 0804	DC	252,50	00894	252,50	00894
								286,70	00893	286,70	00893

1 The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → Page 42.

Spare parts Adapter	Shim		Elbow lever screw		Lever		Solid Carbide Seat W	
	EUR Y8		EUR Y8		EUR Y8		EUR Y8	
PSC 40	1,16	29200	4,55	28700	15,67	28900	24,61	27700
PSC 50	1,16	29200	4,55	28700	15,67	28900	24,61	27700
PSC 63	1,16	29200	4,55	28700	15,67	28900	24,61	27700

MaxiLock-D – DWLN 95° – Boring bar with top clamping



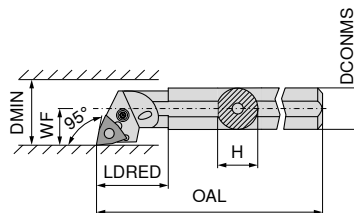
Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 573 ...		Right-hand 70 572 ...	
									EUR 2A/24		EUR 2A/24	
A25R DWLN R/L 06	25	24	200	32	17	32	2	WN.. 0604	228,90	725	228,90	725
A32S DWLN R/L 08	32	31	250	40	22	40	4	WN.. 0804	236,70	732	236,70	732
A40T DWLN R/L 08	40	39	300	45	27	50	4	WN.. 0804	263,70	64000	263,70	640

												
	XPress type		Key D		Clamping screw		Hydrant		Solid Carbide Seat W			
	70 950 ...		80 950 ...		70 950 ...		70 950 ...		70 950 ...			
Spare parts for Article no.	EUR 2A/28		EUR Y7		EUR 2A/28		EUR 2A/28		EUR 2A/28			
70 572 725 / 70 573 725	24,82	823	T09 - IP	11,58	126	M3x7 - IP	3,30	819	21,88	834	3,57	807
70 572 732 / 70 573 732	24,48	824	T15 - IP	12,25	128	M4,5x12 - IP	3,13	820	21,88	834	10,43	812
70 572 640 / 70 573 64000	24,48	824	T15 - IP	12,25	128	M4,5x12 - IP	3,13	820	21,88	834	10,43	812

MaxiLock-N – PWLN 95° – Boring bar with lever clamping



Illustrations show right-hand versions



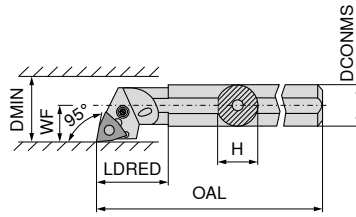
ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 573 ...		Right-hand 70 572 ...	
									EUR 2A/24		EUR 2A/24	
A16M PWLN R/L 06	16	15	150	20	11	20	3	WNMG 0604	185,90	11600 ¹⁾	185,90	11600 ¹⁾
A20Q PWLN R/L 06-1	20	19	180	30	13	25	3	WNMG 0604	205,40	12100 ¹⁾	205,40	12100 ¹⁾
A25R PWLN R/L 06	25	23	200	25	17	32	3	WNMG 0604	228,90	12500 ¹⁾	228,90	12500 ¹⁾
A32S PWLN R/L 06	32	30	250	50	22	40	3	WNMG 0604	236,70	132	236,70	132
A25R PWLN R/L 08	25	23	200	40	17	31	4	WNMG 0804	229,00	225	229,00	225
A32S PWLN R/L 08	32	30	250	50	22	40	4	WNMG 0804	236,70	032	236,70	032
A40T PWLN R/L 08	40	39	300	60	27	50	4	WNMG 0804	263,70	040	263,70	040

1) nickel-plated

Spare parts for Article no.	Key I		Shim		Assembly pin		Lever		Clamping screw		Solid Carbide Seat W	
	70 950 ...	EUR 2A/28	70 950 ...	EUR 2A/28	70 950 ...	EUR 2A/28	70 950 ...	EUR 2A/28	70 950 ...	EUR 2A/28	70 950 ...	EUR 2A/28
70 572 11600 / 70 573 11600	SW2	2,57	177				15,72	129	4,44	217		
70 572 12100 / 70 573 12100	SW2	2,57	177				15,72	129	4,44	217		
70 572 12500 / 70 573 12500	SW2,5	2,57	175	2,16	122	1,28	13,10	185	3,35	208	7,57	127
70 572 132 / 70 573 132	SW2,5	2,57	175	2,16	122	1,28	13,10	185	3,35	208	7,57	127
70 572 225 / 70 573 225	SW3	2,57	176				13,22	187	4,49	205		
70 572 032 / 70 573 032	SW3	2,57	176	1,85	198	1,28	13,22	187	3,68	209	9,16	235
70 572 040 / 70 573 040	SW3	2,57	176	1,85	198	1,28	13,22	187	3,68	209	9,16	235

MaxiLock-N – PWLN 95° – Boring bar with lever clamping

▲ with carbide core



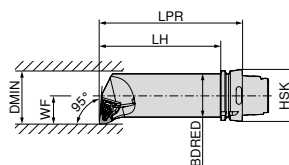
Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Right-hand 70 566 ...	
									EUR 2A	
E-A16M PWLN R 06	16	15	150	24	11	20	3	WNMG 0604	672,40	016
E-A20Q PWLN R 06	20	18	180	29	13	27	3	WNMG 0604	718,80	020
E-A25R PWLN R 06	25	23	200	40	17	31	3	WNMG 0604	745,10	025
E-A25R PWLN R 08	25	23	200	40	17	31	4	WNMG 0804	745,10	125
E-A32S PWLN R 08	32	30	250	50	22	39	4	WNMG 0804	983,50	032
E-A40T PWLN R 08	40	38	300	60	27	48	4	WNMG 0804	1.174,00	040

Spare parts for Article no.		70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	
		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28	
70 566 016	SW2	2,57	177					15,72	129	4,44	217		
70 566 020	SW2	2,57	177					15,72	129	4,44	217		
70 566 025	SW2,5	2,57	175	2,16	122	1,28	191	13,10	185	3,35	208	7,57	127
70 566 125	SW3	2,57	176					13,22	187	3,68	209		
70 566 032	SW3	2,57	176	1,85	198	1,28	192	13,22	187	3,68	209	9,16	235
70 566 040	SW3	2,57	176	1,85	198	1,28	192	13,22	187	3,68	209	9,16	235

MaxiLock-D – DWLN 95° – Boring bar with top clamping



Illustrations show right-hand versions

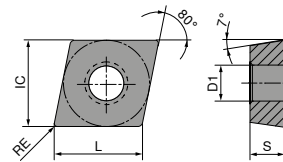


ISO designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 537 ...		Right-hand 74 536 ...	
									EUR 2D/80		EUR 2D/80	
HSK T63 50Q DWLN R/L 08	HSK-T 63	175	149	50	35	63	4	WN.. 0804	323,60	508	323,60	508

Spare parts for Article no.		70 950 ...		80 950 ...		70 950 ...		70 950 ...	
		EUR 2A/28		EUR Y7		EUR 2A/28		EUR 2A/28	
74 536 508 / 74 537 508	T15 - IP	24,48	824	12,25	128	3,13	820	10,43	812

CCGT / CCMT

Designation	L mm	S mm	D1 mm	IC mm
CC.T 0602..	6,4	2,38	2,8	6,35
CC.T 09T3..	9,7	3,97	4,4	9,52
CC.T 1204..	12,9	4,76	5,5	12,70



CCGT / CCMT

		-CF05 CTEP110		-CF55 CTEP110		-SF TCM10		-SMF TCM10		-SF TCM407		-SF CTCP125		-SF CTCP135	
		DRAGONSKIN		DRAGONSKIN								DRAGONSKIN		DRAGONSKIN	
		F		F		F		F		F		F		F	
		CERMET CCGT		CERMET CCMT		CERMET CCGT		CERMET CCMT		CERMET CCGT		CCGT		CCGT	
		76 247 ...		76 248 ...		70 251 ...		70 249 ...		70 251 ...		76 251 ...		76 251 ...	
ISO	RE mm	EUR 1A/78		EUR 1A/78		EUR 1A/78		EUR 1A/78		EUR 1A/78		EUR 1A/08		EUR 1A/08	
060202EN	0,2	14,55	002			14,10	900			14,10	850	14,55	502	14,55	702
060204EN	0,4	14,55	004	7,92	004	14,10	902	7,64	900	14,10	852				
09T302EN	0,2	15,51	014			14,55	904			14,55	854				
09T304EN	0,4	15,51	016	10,16	016	14,55	906	9,48	904						
09T308EN	0,8	15,51	018	10,16	018	14,55	908	9,48	906						
120404EN	0,4			14,34	028	18,21	910								
P		●		●		●		●		●		●		●	
M		○		○		○		○		○		○		○	
K		○		○		○		○		○		○		○	
N															
S															
H															
O															

CCMT / CCGT

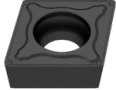
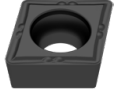
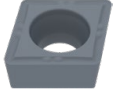
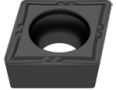
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		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		F		F		F		F		F		F		M	
		CCMT		CCMT		CCMT		CCMT		CCMT		CCMT		CCGT	
		76 253 ...		76 253 ...		76 253 ...		76 249 ...		76 249 ...		76 249 ...		76 250 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
060202EN	0,2													14,55	
060204EN	0,4	8,17		8,17		8,17				8,17		8,17			
060208EN	0,8									8,17		8,17			
09T304EN	0,4	10,19		10,19		10,19		10,19		10,19		10,19			
09T308EN	0,8	10,19		10,19				10,19		10,19		10,19			
120404EN	0,4			14,34						14,34					
120408EN	0,8			14,34				14,34				14,34			
P		●		●		●		●		●		●		●	
M						○						○			
K		○		○				○		○				○	
N															
S															
H															
O															

9

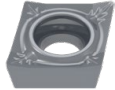
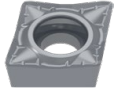
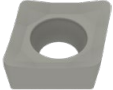
CCGT / CCMT

		-SM CTCP135		-SM CTCK110		-SM CTCK120		-SM CTCP115		-SM CTCP125		-SM CTCP135		-SMQ CTCP115	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		M		M		M		M		M		M		F	
		CCGT		CCMT		CCMT		CCMT		CCMT		CCMT		CCMT	
		76 250 ...		70 252 ...		70 252 ...		76 252 ...		76 252 ...		76 252 ...		76 194 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
060202EN	0,2	14,55													
060204EN	0,4			8,17		8,17		8,17		8,17		8,17			
060208EN	0,8			8,17		8,17		8,17		8,17		8,17			
09T304EN	0,4			10,19		10,19		10,19		10,19		10,19		11,46	
09T308EN	0,8			10,19		10,19		10,19		10,19		10,19		11,46	
09T312EN	1,2			10,19		10,19									
120404EN	0,4			14,34		14,34		14,34		14,34		14,34		16,10	
120408EN	0,8			14,34		14,34		14,34		14,34		14,34		16,10	
120412EN	1,2							14,34		14,34		14,34			
P		●		○		○		●		●		●		●	
M		○										○			
K				●		●		○		○				○	
N															
S															
H															
O															

CCMT

		NEW		NEW		NEW		NEW	
		-SMQ CTCP125	-M25 CTCM120	-M25 CTPM125	-M25 CTCM130	-M55 CTCM120	-M55 CTPM125	-M55 CTCM130	
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	
									
									
		F CCMT	F CCMT	F CCMT	F CCMT	M CCMT	M CCMT	M CCMT	
		76 194 ...	75 210 ...	75 210 ...	75 210 ...	75 211 ...	75 211 ...	75 211 ...	
ISO	RE mm	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08	EUR 1A/08	
060204EN	0,4		8,17 10400	8,17 204	8,17 30400	8,17 10400	8,17 204		
09T304EN	0,4	11,46 516	10,19 11600	10,19 216	10,19 31600	10,19 11600	10,19 216	10,19 31600	
09T308EN	0,8	11,46 518	10,19 11800	10,19 218	10,19 31800	10,19 11800	10,19 218	10,19 31800	
120404EN	0,4	16,10 528				14,34 12800	14,34 228	14,34 32800	
120408EN	0,8	16,10 530				14,34 13000	14,34 230	14,34 33000	
P		•	○	○	○	○	○	○	
M			•	•	•	•	•	•	
K		○							
N									
S					○			○	
H									
O									

CCGT

		NEW		NEW				
		-23P H216T	-25P H210T	-25P CTPX710	-25Q H210T	-25Q CTPX710	-27 H10T	-27 CWN15
								
								
		F CCGT	F CCGT	M CCGT	M CCGT	M CCGT	M CCGT	M CCGT
		70 255 ...	70 248 ...	70 248 ...	70 248 ...	70 248 ...	70 254 ...	70 254 ...
ISO	RE mm	EUR 1A/90	EUR 1A/90	EUR 1A/90	EUR 1A/90	EUR 1A/90	EUR 1A/90	EUR 1A
060202FN	0,2	11,46 652	11,46 636	13,63 70200			10,73 600	13,62 300
060204FN	0,4	11,46 654	11,46 638	13,63 70400	12,45 678	16,46 75400	10,73 602	13,62 302
09T302FN	0,2		11,99 639	13,98 71400			11,46 604	14,08 304
09T304FN	0,4	11,99 656	11,99 640	13,98 71600	13,16 680	17,25 76600	11,46 606	14,08 306
09T308FN	0,8	11,99 658	11,99 641	13,98 71800	13,16 681	17,25 76800	11,46 608	14,08 308
120402FN	0,2		13,98 643				13,39 610	16,34 310
120404FN	0,4		13,98 642	17,85 72800	15,51 682	19,40 77800	13,39 612	16,34 312
120408FN	0,8		13,98 644	17,85 73000	15,51 686	19,40 78000	13,39 614	16,34 314
P				●		●		
M				●		●		○
K		○	○		○		○	
N		●	●	●	●	●	●	●
S			○	●	○	●		
H								
O		○	○		○		○	

CCGT / CCMT

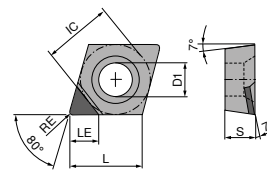
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		DRAGONSKIN			
					
					
		M		M	
		CCGT		CCMT	
		70 254 ...		70 245 ...	
ISO	RE mm	EUR 1A/90		EUR 1A/90	
060202FN	0,2	13,04	80200		
060204EN	0,4			8,25	60400
060204FN	0,4	13,04	80400		
09T302FN	0,2	13,39	81400		
09T304EN	0,4			8,79	61600
09T304FN	0,4	13,39	81600		
09T308EN	0,8			8,79	61800
09T308FN	0,8	13,39	81800		
120402FN	0,2	16,68	82600		
120404FN	0,4	16,68	82800		
120408FN	0,8	16,68	83000		
P			•		
M			•		
K			○		○
N			•		•
S			•		
H					
O			○		○

CCMT

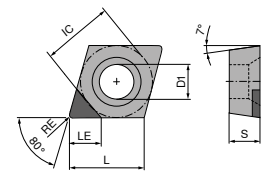
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		F		F		M		M	
		CCMT		CCMT		CCMT		CCMT	
		75 300 ...		75 300 ...		75 301 ...		75 301 ...	
ISO	RE mm	EUR 1S/1P		EUR 1S/1P		EUR 1S/1P		EUR 1S/1P	
09T304EN	0,4	2,61	01609	2,61	11609	2,61	01609	2,61	11609
09T308EN	0,8	2,61	01809	2,61	11809	2,61	01809	2,61	11809
120404EN	0,4	3,50	02809	3,50	12809	3,50	02809	3,50	12809
120408EN	0,8	3,50	03009	3,50	13009	3,50	03009	3,50	13009
120412EN	1,2					3,50	03209	3,50	13209
P			●		●		●		●
M			○		○		○		○
K									
N									
S									
H									
O									

CCGW / CCGT

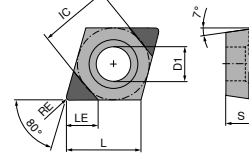
Designation	L mm	S mm	D1 mm	IC mm
CCG. 0602..	6,40	2,38	2,8	6,35
CCGW 0602..	6,45	2,38	2,8	6,35
CCG. 09T3..	9,70	3,97	4,4	9,52
CCGW 1204..	12,90	4,76	5,5	12,70



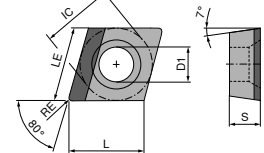
CCGT A



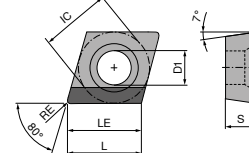
CCGW A



CCGW B



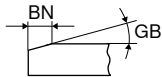
CCGW A L L



CCGW A RR

CCGW / CCGT

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

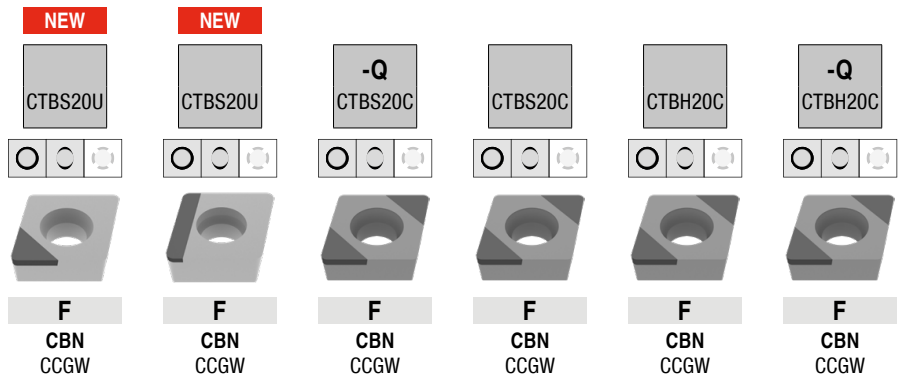
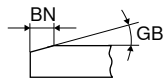


NEW				NEW				NEW	
CTBS10U		CTBS10U		CTBS10U		CTBS10U		CTBS10U	
F		F		F		F		F	
CBN		CBN		CBN		CBN		CBN	
CCGW		CCGW		CCGT		CCGW		CCGW	
71 419 ...		71 120 ...		71 124 ...		71 420 ...		71 420 ...	
EUR Y0		EUR Y0		EUR Y0		EUR Y0		EUR Y0	
		37,14 300		44,32 200					
		37,14 200							
		37,14 302		44,32 202					
		37,14 202							
		37,14 30300							
				44,32 25000					
		37,14 204							
		37,14 304		44,32 25200					
68,48 10000						95,86 10100			
68,48 10100								95,86 10000	
		37,14 206							
		37,14 306				95,86 10300			
								95,86 10200	
		37,14 208							
		37,14 308							
		37,14 310							
		37,14 210							

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CCGW

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

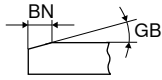


ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	71 418 ...	71 420 ...	71 162 ...	71 161 ...	71 161 ...	71 162 ...
						EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0
060202SN	0,2	0,09	10°	B (2)	3,4			59,35 120		59,35 230	59,35 230
060202SN	0,2	0,11	15°	B (2)	3,4			59,35 130			59,35 240
060202TN	0,2	0,12	15°	A (1)	3,4	41,08 20000					
060202SN	0,2	0,09	20°	B (2)	3,4					59,35 250	
060202TN	0,2	0,15	20°	B (2)	3,4			59,35 140			
060202SN	0,2	0,16	20°	B (2)	3,4			59,35 150	59,35 150		
060202TN	0,2	0,14	25°	B (2)	3,4					59,35 260	
060202SN	0,2	0,15	25°	B (2)	3,4					59,35 270	
060202EN	0,2			B (2)	3,4			59,35 110	59,35 110		59,35 220
060202TN	0,2	0,17	25°	B (2)	3,4			59,35 160	59,35 160		
060202FN	0,2			B (2)	3,4						59,35 210
060204SN	0,4	0,09	10°	B (2)	3,1			59,35 121	59,35 121	59,35 231	59,35 231
060204SN	0,4	0,11	15°	B (2)	3,1			59,35 131	59,35 131	59,35 241	59,35 241
060204TN	0,4	0,12	15°	A (1)	3,1	41,08 20200					
060204SN	0,4	0,09	20°	B (2)	3,1					59,35 251	59,35 251
060204TN	0,4	0,15	20°	B (2)	3,1			59,35 141	59,35 141		
060204SN	0,4	0,16	20°	B (2)	3,1			59,35 151	59,35 151		
060204TN	0,4	0,14	25°	B (2)	3,1					59,35 261	59,35 261
060204SN	0,4	0,15	25°	B (2)	3,1			59,35 161	59,35 161	59,35 271	
060204TN	0,4	0,17	25°	B (2)	3,1			59,35 171			
060204SN	0,4	0,18	25°	B (2)	3,1						
060204FN	0,4			A (1)	3,1	41,08 20100					
060204EN	0,4			B (2)	3,1					59,35 221	
060208EN	0,8			B (2)	2,8			59,35 112			
060208SN	0,8	0,09	10°	B (2)	2,8			59,35 122	59,35 122	59,35 232	
060208SN	0,8	0,11	15°	B (2)	2,8			59,35 132		59,35 252	
060208SN	0,8	0,09	20°	B (2)	2,8					59,35 262	
060208TN	0,8	0,15	20°	B (2)	2,8			59,35 142			
060208TN	0,8	0,14	25°	B (2)	2,8					59,35 262	
060208TN	0,8	0,17	25°	B (2)	2,8			59,35 162			
060208SN	0,8	0,18	25°	B (2)	2,8			59,35 172			
060208SN	0,8	0,18	30°	B (2)	2,8			59,35 182	59,35 182	59,35 282	
060208FN	0,8			B (2)	2,8					59,35 212	
09T302SN	0,2	0,09	10°	B (2)	3,4			59,35 123	59,35 123	59,35 233	
09T302SN	0,2	0,11	15°	B (2)	3,4			59,35 133	59,35 133	59,35 243	
09T302SN	0,2	0,09	20°	B (2)	3,4					59,35 253	
09T302SN	0,2	0,16	20°	B (2)	3,4			59,35 153			
09T302SN	0,2	0,15	25°	B (2)	3,4					59,35 273	
09T302EN	0,2			B (2)	3,4			59,35 113			
09T302TN	0,2	0,17	25°	B (2)	3,4			59,35 163			
09T302SN	0,2	0,18	25°	B (2)	3,4			59,35 173			
09T304SN	0,4	0,09	10°	B (2)	3,1			59,35 124	59,35 124	59,35 234	
09T304SN	0,4	0,11	15°	B (2)	3,1			59,35 134	59,35 134	59,35 244	
09T304TN	0,4	0,12	15°	A (1)	2,8	41,08 20400					
09T304SN	0,4	0,09	20°	B (2)	3,1					59,35 254	
09T304TN	0,4	0,15	20°	B (2)	3,1			59,35 144	59,35 144		
09T304SN	0,4	0,16	20°	B (2)	3,1			59,35 154	59,35 154		
09T304TN	0,4	0,14	25°	B (2)	3,1					59,35 264	
09T304SN	0,4	0,15	25°	B (2)	3,1					59,35 274	
09T304TN	0,4	0,17	25°	B (2)	3,1			59,35 164	59,35 164		
09T304SN	0,4	0,18	25°	B (2)	3,1			59,35 174	59,35 174		
09T304SN	0,4	0,18	30°	B (2)	3,1			59,35 184	59,35 184	59,35 284	

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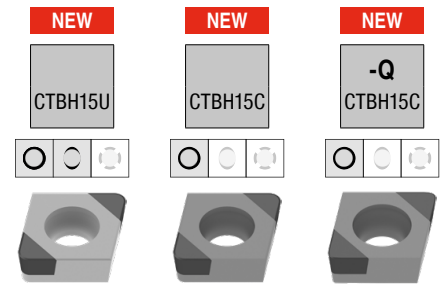
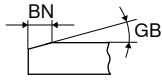
▲ TCE(NOI) = Design and number of equipped cutting edge corners



						NEW	NEW	-Q			-Q
						CTBS20U	CTBS20U	CTBS20C	CTBS20C	CTBH20C	CTBH20C
						F	F	F	F	F	F
						CBN	CBN	CBN	CBN	CBN	CBN
						CCGW	CCGW	CCGW	CCGW	CCGW	CCGW
						71 418 ...	71 420 ...	71 162 ...	71 161 ...	71 161 ...	71 162 ...
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0
09T304EN	0,4			B (2)	3,1				59,35	114	
09T304FN	0,4			A (1)	2,8	41,08					
09T308SN	0,8	0,09	10°	B (2)	2,8			59,35	125	59,35	235
09T308SN	0,8	0,11	15°	B (2)	2,8			59,35	135	59,35	245
09T308TLL	0,8	0,12	15°	A (1)	9,7		95,86				
09T308TN	0,8	0,12	15°	A (1)	2,5	41,08					
09T308SN	0,8	0,09	20°	B (2)	2,8						59,35
09T308TN	0,8	0,15	20°	B (2)	2,8			59,35	145	59,35	
09T308SN	0,8	0,16	20°	B (2)	2,8			59,35	155		
09T308TN	0,8	0,14	25°	B (2)	2,8					59,35	265
09T308SN	0,8	0,15	25°	B (2)	2,8					59,35	275
09T308TN	0,8	0,17	25°	B (2)	2,8			59,35	165	59,35	
09T308SN	0,8	0,18	25°	B (2)	2,8			59,35	175		
09T308FN	0,8			A (1)	2,5	41,08					
09T308EN	0,8			B (2)	2,8			59,35	115		59,35
09T308SN	0,8	0,18	30°	B (2)	2,8				59,35	185	
09T308FN	0,8			B (2)	2,8						59,35
120404FN	0,4			A (1)	3,1	41,08					
120404TN	0,4	0,12	15°	A (1)	3,1	41,08					
120408TN	0,8	0,12	15°	A (1)	2,8	41,08					
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▲ TCE(NOI) = Design and number of equipped cutting edge corners



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71 001 ...

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74,37 30214 71,93 30214
74,37 00200 71,93 00200

74,37 30414 71,93 30414
74,37 30429 71,93 30429
74,37 00400 71,93 00400

74,37 00600 71,93 00600
74,37 30614 71,93 30614
74,37 30629 71,93 30629

71,93 31414
71,93 31429

71,93 31614 71,93 31614
71,93 31629 71,93 31629

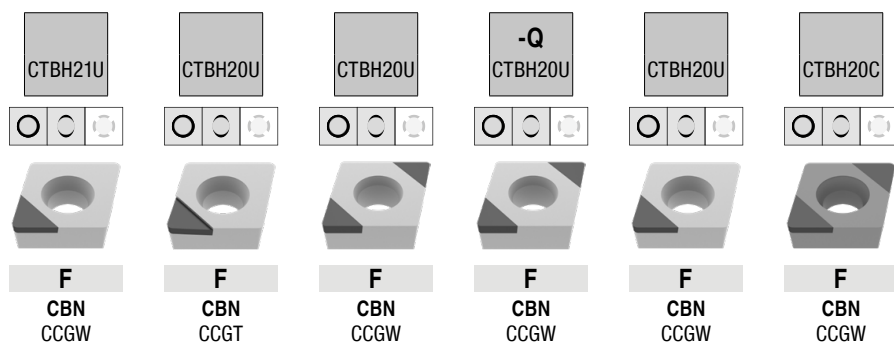
71,93 31814 71,93 31814
71,93 31829 71,93 31829

ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
060202SN	0,2	0,11	15°	B (2)	3,4
060202EN	0,2			B (2)	3,4
060204SN	0,4	0,11	15°	B (2)	3,1
060204SN	0,4	0,14	25°	B (2)	3,1
060204EN	0,4			B (2)	3,1
060208EN	0,8			B (2)	2,8
060208SN	0,8	0,11	15°	B (2)	2,8
060208SN	0,8	0,14	25°	B (2)	2,8
09T302SN	0,2	0,11	15°	B (2)	3,4
09T302SN	0,2	0,14	25°	B (2)	3,4
09T304SN	0,4	0,11	15°	B (2)	3,1
09T304SN	0,4	0,14	25°	B (2)	3,1
09T308SN	0,8	0,11	15°	B (2)	2,8
09T308SN	0,8	0,14	25°	B (2)	2,8

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CCGW / CCGT

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



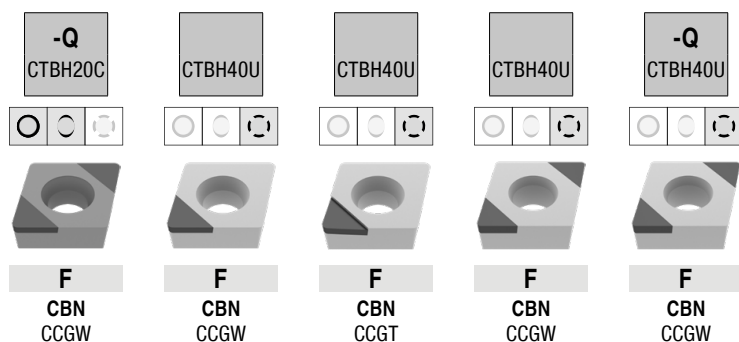
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	71 120 ... EUR Y0	71 124 ... EUR Y0	71 121 ... EUR Y0	71 123 ... EUR Y0	71 120 ... EUR Y0	71 161 ... EUR Y0
060202SN	0,2	0,09	10°	B (2)	3,4						59,35 230
060202SN	0,2	0,09	20°	B (2)	3,4						59,35 250
060202TN	0,2	0,12	20°	A (1)	3,4					37,14 500	59,35 260
060202TN	0,2	0,14	25°	B (2)	3,4						59,35 270
060202SN	0,2	0,15	25°	B (2)	3,4						59,35 270
060202FN	0,2			A (1)	3,4		44,32 400			37,14 400 1)	
060204SN	0,4	0,09	10°	B (2)	3,1						59,35 231
060204SN	0,4	0,11	15°	B (2)	3,1						59,35 241
060204SN	0,4	0,09	20°	B (2)	3,1						59,35 251
060204TN	0,4	0,12	20°	A (1)	3,1					37,14 502	59,35 261
060204TN	0,4	0,14	25°	B (2)	3,1						59,35 271
060204SN	0,4	0,15	25°	B (2)	3,1						59,35 271
060204FN	0,4			A (1)	3,1		44,32 402			37,14 402 1)	59,35 221
060204EN	0,4			B (2)	3,1						59,35 221
060208SN	0,8	0,09	10°	B (2)	2,8						59,35 232
060208SN	0,8	0,09	20°	B (2)	2,8						59,35 252
060208TN	0,8	0,14	25°	B (2)	2,8						59,35 262
060208SN	0,8	0,18	30°	B (2)	2,8						59,35 282
060208FN	0,8			B (2)	2,8						59,35 212
09T302SN	0,2	0,09	10°	B (2)	3,4						59,35 233
09T302SN	0,2	0,11	15°	B (2)	3,4						59,35 243
09T302SN	0,2	0,09	20°	B (2)	3,4						59,35 253
09T302TN	0,2	0,12	20°	B (2)	3,4			58,44 50100			59,35 273
09T302SN	0,2	0,15	25°	B (2)	3,4						59,35 273
09T304FN	0,4			A (1)	2,8					37,14 404 1)	59,35 234
09T304SN	0,4	0,09	10°	B (2)	3,1						59,35 244
09T304SN	0,4	0,11	15°	B (2)	3,1						59,35 254
09T304SN	0,4	0,09	20°	B (2)	3,1						59,35 254
09T304TN	0,4	0,12	20°	B (2)	3,1			58,44 502	58,67 502	37,14 504	59,35 264
09T304TN	0,4	0,12	20°	A (1)	2,8						59,35 274
09T304TN	0,4	0,14	25°	B (2)	3,1						59,35 274
09T304SN	0,4	0,15	25°	B (2)	3,1						59,35 274
09T304FN	0,4			B (2)	3,1		58,44 402 1)				59,35 284
09T304SN	0,4	0,18	30°	B (2)	3,1						59,35 284
09T304FN	0,4			A (1)	3,1	37,14 40500	44,32 45000				59,35 224
09T304EN	0,4			B (2)	3,1						59,35 224
09T308FN	0,8			A (1)	2,5					37,14 406 1)	59,35 235
09T308SN	0,8	0,09	10°	B (2)	2,8						59,35 245
09T308SN	0,8	0,11	15°	B (2)	2,8						59,35 245
09T308TN	0,8	0,12	20°	A (1)	2,5					37,14 506	59,35 265
09T308FN	0,8			B (2)	2,8		58,44 404 1)	58,67 404 1)	58,67 504		59,35 275
09T308TN	0,8	0,12	20°	B (2)	2,8		58,44 504	58,67 504			59,35 265
09T308TN	0,8	0,14	25°	B (2)	2,8						59,35 275
09T308SN	0,8	0,15	25°	B (2)	2,8						59,35 275
09T308FN	0,8			A (1)	2,8		44,32 45200				59,35 275
120404TN	0,4	0,12	20°	A (1)	3,1					37,14 508	
120408TN	0,8	0,12	20°	A (1)	2,8					37,14 510	

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1) Machining to 60 HRC

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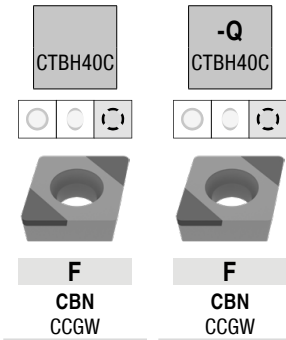
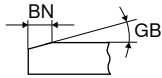
▲ TCE(NOI) = Design and number of equipped cutting edge corners



ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	71 162 ... EUR Y0	71 120 ... EUR Y0	71 124 ... EUR Y0	71 121 ... EUR Y0	71 123 ... EUR Y0
060202SN	0,2	0,09	10°	B (2)	3,4	59,35				
060202EN	0,2			B (2)	3,4	59,35				
060202FN	0,2			B (2)	3,4	59,35				
060202SN	0,2	0,11	15°	B (2)	3,4	59,35				
060202TN	0,2	0,12	25°	A (1)	3,4		37,14			
060202FN	0,2			A (1)	3,4		37,14	44,32		
060204SN	0,4	0,09	10°	B (2)	3,1	59,35				
060204SN	0,4	0,11	15°	B (2)	3,1	59,35				
060204SN	0,4	0,09	20°	B (2)	3,1	59,35				
060204TN	0,4	0,12	25°	A (1)	3,1		37,14			
060204TN	0,4	0,14	25°	B (2)	3,1	59,35				
060204FN	0,4			A (1)	3,1		37,14	44,32		
060208TN	0,8	0,12	25°	A (1)	2,8		37,14	90300		
09T302FN	0,2			B (2)	3,4				58,44	80100
09T304FN	0,4			A (1)	3,1			44,32		
09T304FN	0,4			A (1)	2,8		37,14			
09T304TN	0,4	0,12	25°	B (2)	3,1				58,44	902
09T304TN	0,4	0,12	25°	A (1)	2,8		37,14		58,44	802
09T304FN	0,4			B (2)	3,1				58,44	802
09T308FN	0,8			A (1)	2,5		37,14			
09T308SN	0,8	0,09	10°	B (2)	2,8	59,35				
09T308EN	0,8			B (2)	2,8	59,35				
09T308SN	0,8	0,11	15°	B (2)	2,8	59,35				
09T308SN	0,8	0,09	20°	B (2)	2,8	59,35				
09T308TN	0,8	0,12	25°	A (1)	2,5		37,14			
09T308TN	0,8	0,12	25°	B (2)	2,8				58,44	904
09T308TN	0,8	0,14	25°	B (2)	2,8	59,35			58,44	804
09T308FN	0,8			B (2)	2,8	59,35				
120404TN	0,4	0,12	25°	A (1)	3,1		37,14			
120404FN	0,4			A (1)	3,1		37,14			
120408TN	0,8	0,12	25°	A (1)	2,8		37,14	910		
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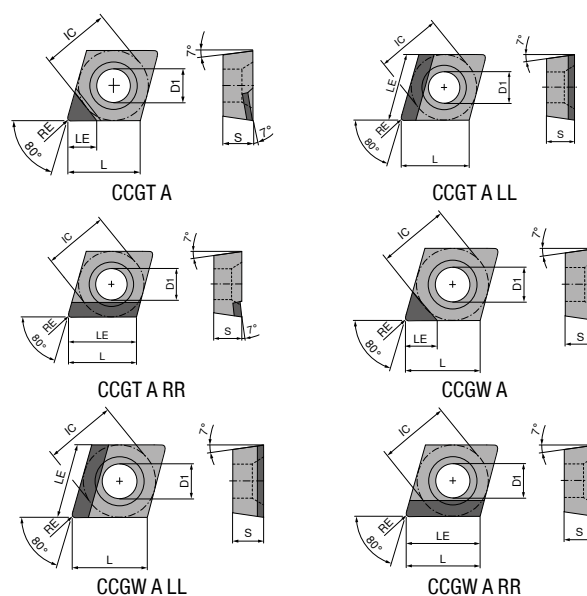
▲ TCE(NOI) = Design and number of equipped cutting edge corners



ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	71 161 ...	71 162 ...
060202TN	0,2	0,09	20°	B (2)	3,4	EUR Y0 59,35	320
060202SN	0,2	0,09	20°	B (2)	3,4	59,35	330
060202SN	0,2	0,09	25°	B (2)	3,4	59,35	350
060202TN	0,2	0,11	25°	B (2)	3,4	59,35	340
060202TN	0,2	0,14	30°	B (2)	3,4	59,35	360
060204SN	0,4	0,09	20°	B (2)	3,1	59,35	331
060204TN	0,4	0,09	20°	B (2)	3,1	59,35	32100
060204SN	0,4	0,09	25°	B (2)	3,1	59,35	351
060204TN	0,4	0,11	25°	B (2)	3,1	59,35	341
060204TN	0,4	0,14	30°	B (2)	3,1	59,35	361
060204SN	0,4	0,16	30°	B (2)	3,1	59,35	371
060204SN	0,4	0,17	35°	B (2)	3,1	59,35	381
060208TN	0,8	0,09	20°	B (2)	2,8	59,35	322
060208SN	0,8	0,09	25°	B (2)	2,8	59,35	352
060208TN	0,8	0,11	25°	B (2)	2,8	59,35	342
060208TN	0,8	0,14	30°	B (2)	2,8	59,35	362
060208SN	0,8	0,16	30°	B (2)	2,8	59,35	372
060208SN	0,8	0,17	35°	B (2)	2,8	59,35	382
09T302TN	0,2	0,09	20°	B (2)	3,4	59,35	323
09T302SN	0,2	0,09	25°	B (2)	3,4	59,35	353
09T302TN	0,2	0,11	25°	B (2)	3,4	59,35	343
09T302SN	0,2	0,16	30°	B (2)	3,4	59,35	373
09T302SN	0,2	0,17	35°	B (2)	3,4	59,35	383
09T304SN	0,4	0,09	20°	B (2)	3,1	59,35	334
09T304TN	0,4	0,09	20°	B (2)	3,1	59,35	324
09T304SN	0,4	0,09	25°	B (2)	3,1	59,35	354
09T304TN	0,4	0,11	25°	B (2)	3,1	59,35	344
09T304TN	0,4	0,14	30°	B (2)	3,1	59,35	364
09T304EN	0,4			B (2)	3,1	59,35	314
09T304SN	0,4	0,16	30°	B (2)	3,1	59,35	374
09T304SN	0,4	0,17	35°	B (2)	3,1	59,35	384
09T308SN	0,8	0,09	20°	B (2)	2,8	59,35	335
09T308TN	0,8	0,09	20°	B (2)	2,8	59,35	325
09T308SN	0,8	0,09	25°	B (2)	2,8	59,35	355
09T308TN	0,8	0,11	25°	B (2)	2,8	59,35	345
09T308TN	0,8	0,14	30°	B (2)	2,8	59,35	365
09T308SN	0,8	0,16	30°	B (2)	2,8	59,35	375
09T308SN	0,8	0,17	35°	B (2)	2,8	59,35	385
09T308EN	0,8			B (2)	2,8	59,35	315
P							
M							
K							
N							
S							
H							
O							

CCGW / CCGT

Designation	L mm	S mm	D1 mm	IC mm
CCG. 0602..	6,4	2,38	2,8	6,35
CCG. 0602..	6,5	2,38	2,8	6,35
CCG. 09T3..	9,7	3,97	4,4	9,52
CCG. 1204..	12,9	4,76	5,5	12,70



CCGW / CCGT

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

				CTDMD05		CTDPD20		CTDPD20		-Q CTDPD20		-Q CTDPD20		
														
														
				F		F		F		F		F		
				DIAMOND CCGW		DIAMOND CCGW		DIAMOND CCGT		DIAMOND CCGW		DIAMOND CCGT		
				71 120 ...		71 120 ...		71 124 ...		71 125 ...		71 126 ...		
ISO	RE mm	TCE (NOI)	LE mm	EUR Y0		EUR Y0		EUR Y0		EUR Y0		EUR Y0		
060201FN	0,1	A (1)	3,4		050									
060201FN	0,1	A (1)	3,5											
060202FN	0,2	A (1)	2,5	281,40				52,29	10100				66,31	101
060202FN	0,2	A (1)	3,3		052					66,31	102	66,31	102	
060202FN	0,2	A (1)	3,4				52,29	100	52,29	100				
060204FN	0,4	A (1)	2,5	281,40										
060204FN	0,4	A (1)	3,1		05300									
060204FN	0,4	A (1)	3,2				52,29	102	52,29	102	66,31	104	66,31	104
060208FN	0,8	A (1)	2,5	281,40										
060208FN	0,8	A (1)	3,0			52,29	10300	52,29	10300					
					054									
09T301FN	0,1	A (1)	4,5								67,56	111	67,56	111
09T302FN	0,2	A (1)	4,4								67,56	112	67,56	112
09T302FN	0,2	A (1)	4,5		056									
09T304FN	0,4	A (1)	2,5	284,90			53,43	10500	53,43	10500				
09T304FN	0,4	A (1)	4,2								67,56	114	67,56	114
09T304FN	0,4	A (1)	4,3			53,43	104	53,43	104					
09T308FN	0,8	A (1)	2,5	284,90										
09T308FN	0,8	A (1)	4,1			53,43	106	53,43	106					
					056									
120402FN	0,2	A (1)	4,4								68,70	122	68,70	122
120404FN	0,4	A (1)	4,2								68,70	124	68,70	124
120404FN	0,4	A (1)	4,3			54,63	108	54,63	108					
120408FN	0,8	A (1)	4,1			54,63	110	54,63	110					

P					
M					
K					
N					
S					
H					
O					

CCGW / CCGT

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

				NEW		NEW		NEW		NEW		NEW			
				CTDPD20		CTDPD20		-CB1 CTDPD20		-CB2 CTDPD20		-CB1 CTDPD20		-Q-CB2 CTDPD20	
															
															
				F		F		F		M		F		M	
				DIAMOND CCGW		DIAMOND CCGW		DIAMOND CCGT		DIAMOND CCGT		DIAMOND CCGT		DIAMOND CCGT	
				71 172 ...		71 172 ...		71 300 ...		71 168 ...		71 305 ...		71 169 ...	
ISO	RE mm	TCE (NOI)	LE mm	EUR Y0		EUR Y0		EUR Y0		EUR Y0		EUR Y0		EUR Y0	
060202FN	0,2	A (1)	3,40												
060204FN	0,4	A (1)	3,10												
060204FN	0,4	A (1)	3,20												
060204FRR	0,4	A (1)	6,45												
060204FLL	0,4	A (1)	6,45	85,76	10001										
060208FN	0,8	A (1)	3,00												
09T302FN	0,2	A (1)	4,40												
09T302FN	0,2	A (1)	4,50												
09T304FN	0,4	A (1)	4,20												
09T304FN	0,4	A (1)	4,30												
09T308FN	0,8	A (1)	4,10												
09T308FRR	0,8	A (1)	9,70												
09T308FLL	0,8	A (1)	9,70	91,30	10201										
09T312FLL	1,2	A (1)	9,70	91,30	10401										
120404FN	0,4	A (1)	4,20												
120404FN	0,4	A (1)	4,30												
120408FN	0,8	A (1)	4,10												
120412FRR	1,2	A (1)	12,90												
120412FLL	1,2	A (1)	12,90	101,00	10501										
P															
M															
K															
N															
S															
H															
Q															

CCGT / CCGW

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

				NEW		-Q		-Q		NEW		NEW		-CB2	
				CTDPS30		CTDPS30		CTDPS30		CTDPS30		CTDPS30		CTDPS30	
				F		F		F		F		F		M	
				DIAMOND		DIAMOND		DIAMOND		DIAMOND		DIAMOND		DIAMOND	
				CCGT		CCGW		CCGT		CCGT		CCGT		CCGT	
				71 166 ...		71 125 ...		71 126 ...		71 170 ...		71 170 ...		71 301 ...	
ISO	RE mm	TCE (NOI)	LE mm	EUR Y0		EUR Y0		EUR Y0		EUR Y0		EUR Y0		EUR Y0	
060201FN	0,1	A (1)	3,50	59,49	20001										
060202FN	0,2	A (1)	3,30			66,31	152	66,31	152						
060202FN	0,2	A (1)	3,40	59,49	20101									62,09	202
060204FN	0,4	A (1)	3,20											62,09	204
060204FRR	0,4	A (1)	6,45									85,76	20101		
060204FLL	0,4	A (1)	6,45							85,76	20001				
060208FN	0,8	A (1)	3,00											62,09	208
060208FRR	0,8	A (1)	6,45									85,76	20301		
060208FLL	0,8	A (1)	6,45							85,76	20201				
09T301FN	0,1	A (1)	4,50			67,56	16300								
09T302FN	0,2	A (1)	4,40			67,56	162	67,56	162						
09T302FN	0,2	A (1)	4,50	60,87	20201									67,10	212
09T304FN	0,4	A (1)	4,30											67,10	214
09T308FN	0,8	A (1)	4,10											67,10	218
09T308FRR	0,8	A (1)	9,70									91,30	20501		
09T308FLL	0,8	A (1)	9,70							91,30	20401				
120402FN	0,2	A (1)	4,40					68,70	172						
120404FN	0,4	A (1)	4,20					68,70	174						
120404FN	0,4	A (1)	4,30	60,87	20301									69,95	224
120408FN	0,8	A (1)	4,10											69,95	228
120412FRR	1,2	A (1)	12,90									101,00	20701		
120412FLL	1,2	A (1)	12,90							101,00	20601				
P															
M															
K															
N															
S															
H															
O															

CCGT / CCGW

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

				NEW		NEW	
				-Q-CB2 CTDPS30	CTDPU20	-CB3 CTDPU20	CTDPS30
				M	F	R	F
				DIAMOND CCGT	DIAMOND CCGW	DIAMOND CCGT	DIAMOND CCGW
				71 306 ...	71 171 ...	71 302 ...	71 171 ...
ISO	RE mm	TCE (NOI)	LE mm	EUR Y0	EUR Y0	EUR Y0	EUR Y0
060201FN	0,1	A (1)	3,5				58,09 20001
060202FN	0,2	A (1)	3,3	71,21 202			
060202FN	0,2	A (1)	3,4				58,09 20101
060204FN	0,4	A (1)	3,1	71,21 204			
060204FN	0,4	A (1)	3,2			62,09 204	58,09 20201
09T302FN	0,2	A (1)	4,4	72,00 212			
09T302FN	0,2	A (1)	4,5				60,87 20301
09T304FN	0,4	A (1)	4,2	72,00 214			
09T304FN	0,4	A (1)	4,3		62,26 30001 62,26 30101	67,10 214 67,10 218	60,87 20401
09T308FN	0,8	A (1)	4,1				
120402FN	0,2	A (1)	4,4	73,94 222			
120404FN	0,4	A (1)	4,2	73,94 224			
120404FN	0,4	A (1)	4,3				62,26 20501
P							
M							
K							
N							
S							
H							
O							

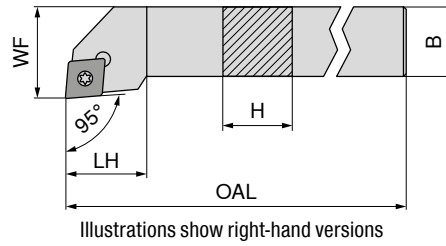
9

CCGW / CCGT

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

				NEW		NEW		NEW		NEW	
				CTDCD10		-CB1 CTDCD10		-Q-CB1 CTDCD10		-CB2 CTDCD10	
											
											
				F		F		F		M	
				DIAMOND		DIAMOND		DIAMOND		DIAMOND	
				CCGW		CCGT		CCGT		CCGT	
				71 171 ...		71 300 ...		71 167 ...		71 301 ...	
ISO	RE mm	TCE (NOI)	LE mm	EUR Y0		EUR Y0		EUR Y0		EUR Y0	
060202FN	0,2	A (1)	2,3								
060202FN	0,2	A (1)	2,4	67,79	40001	81,92	302	91,30	40001	81,92	30200
060204FN	0,4	A (1)	2,1								
060204FN	0,4	A (1)	2,2	67,79	40101	81,92	304	91,30	40101	81,92	304
060208FN	0,8	A (1)	2,0			81,92	30600				
09T302FN	0,2	A (1)	2,3								
09T302FN	0,2	A (1)	2,4	73,33	40201					84,53	31200
09T304FN	0,4	A (1)	2,1					92,70	40201		
09T304FN	0,4	A (1)	2,2	73,33	40301	84,53	314			84,53	314
09T308FN	0,8	A (1)	2,0	73,33	40401					84,53	31600
120404FN	0,4	A (1)	2,1					94,06	40301		
120404FN	0,4	A (1)	2,2							95,01	32600
120408FN	0,8	A (1)	2,0	78,86	40501					95,01	328
120408FN	0,8	A (1)	2,1								
P											
M											
K											
N											
S											
H											
O											

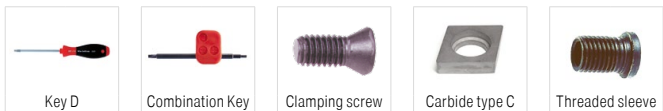
MaxiLock-S – SCLC 95° – Toolholder with screw clamping



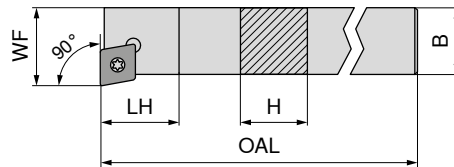
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 653 ...		Right-hand 70 652 ...	
								EUR 2A/24		EUR 2A/24	
SCLC R/L 0808 D06	8	8	60	9	10	1,2	CC.. 0602	63,97	008	63,97	008
SCLC R/L 1010 E06	10	10	70	9	12	1,2	CC.. 0602	67,82	010	67,82	010
SCLC R/L 1212 F09	12	12	80	15	16	3,2	CC.. 09T3	67,82	012	67,82	012
SCLC R/L 1616 H09	16	16	100	17	20	3,2	CC.. 09T3	84,00	016	84,00	016
SCLC R/L 2020 K09	20	20	125	17	25	3,2	CC.. 09T3	89,29	020	89,29	020
SCLC R/L 1616 H12	16	16	100	20	20	5	CC.. 1204	84,00	116	84,00	116
SCLC R/L 2020 K12	20	20	125	20	25	5	CC.. 1204	89,29	120	89,29	120
SCLC R/L 2525 M12	25	25	150	20	32	5	CC.. 1204	92,37	125	92,37	125
SCLC R/L 3225 P12	32	25	170	20	32	5	CC.. 1204	96,01	132	96,01	132

Spare parts
for Article no.

	80 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	
	EUR Y7		EUR 2A/28		EUR 2A		EUR 2A/28		EUR 2A/28	
70 653 008 / 70 652 008	8,03	110			2,43	112				
70 653 010 / 70 652 010	8,03	110			2,43	112				
70 653 012 / 70 652 012	9,56	113			3,30	113				
70 653 016 / 70 652 016			8,69	398	3,30	113	10,15	165	4,87	171
70 653 020 / 70 652 020			8,69	398	3,30	113	10,15	165	4,87	171
70 653 116 / 70 652 116			8,69	398	2,70	114	12,99	166	4,87	170
70 653 120 / 70 652 120			8,69	398	2,70	114	12,99	166	4,87	170
70 653 125 / 70 652 125			8,69	398	2,70	114	12,99	166	4,87	170
70 653 132 / 70 652 132			8,69	398	2,70	114	12,99	166	4,87	170



MaxiLock-S – SCFC 90° – Toolholder with screw clamping



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand		Right-hand	
								70 761 ...		70 760 ...	
SCFC R/L 0808 D06	8	8	60	10	10	1,2	CC.. 0602	EUR 2A/24 62,75	00800 ¹⁾	EUR 2A/24 62,75	008
SCFC R/L 1010 E06	10	10	70	10	12	1,2	CC.. 0602	67,82	010	67,82	010
SCFC R/L 1212 F09	12	12	80	13	16	3,2	CC.. 09T3	67,82	012	67,82	012
SCFC R/L 1616 H09	16	16	100	13	20	3,2	CC.. 09T3	84,00	016	84,00	016
SCFC R/L 2020 K12	20	20	125	17	25	5	CC.. 1204	87,59	02000 ¹⁾	89,29	020

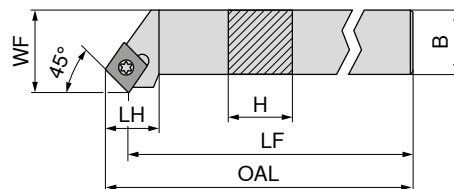
1) nickel-plated

Spare parts
for Article no.

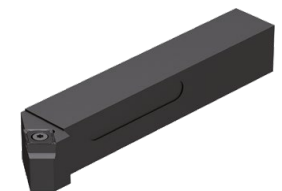
70 760 008 / 70 761 00800	EUR Y7 8,03	110
70 760 010 / 70 761 010	8,03	110
70 760 012 / 70 761 012	9,56	113
70 760 016 / 70 761 016		
70 760 020 / 70 761 02000		

Key D	Combination Key	Clamping screw	Carbide type C	Threaded sleeve
80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
EUR Y7 8,03	EUR 2A/28 2,43	EUR 2A 2,43	EUR 2A/28 2,43	EUR 2A/28 2,43
110		112		
		112		
		113		
	8,69	3,30	10,15	4,87
	398	113	165	171
	398	114	166	170

MaxiLock-S – SCSC 45° – Toolholder with screw clamping



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LF mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand		Right-hand	
									70 641 ...		70 640 ...	
SCSC R 1616 H12	16	16	109,1	100	20	20	5	CC.. 1204	EUR 2A/24 89,29	020	EUR 2A/24 84,00	016
SCSC R/L 2020 K12	20	20	134,1	125	20	25	5	CC.. 1204	92,37	025	89,29	020
SCSC R/L 2525 M12	25	25	159,1	150	20	32	5	CC.. 1204			92,37	025

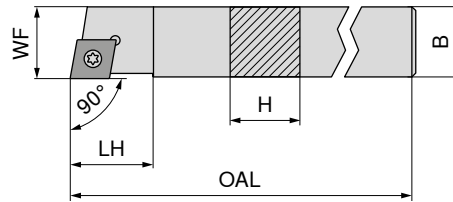
Spare parts
for Article no.

70 640 016	T15/SW	EUR 2A/28 8,69	398
70 641 020 / 70 640 020	T15/SW	8,69	398
70 641 025 / 70 640 025	T15/SW	8,69	398

Combination Key	Clamping screw	Carbide type C	Threaded sleeve
70 950 ...	70 950 ...	70 950 ...	70 950 ...
EUR 2A/28 8,69	EUR 2A/28 2,70	EUR 2A/28 12,99	EUR 2A/28 4,87
398	114	166	170
	114	166	170
	114	166	170

MaxiLock-S – SCAC 90° – Toolholder with screw clamping

▲ for sliding head lathes



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 757 ...		Right-hand 70 756 ...	
								EUR 2A/24		EUR 2A/24	
SCAC R/L 0808 K06	8	8	125	9	8	1,2	CC.. 0602	67,82	108	67,82	108
SCAC R/L 0808 D06	8	8	60	9	8	1,2	CC.. 0602	62,75	008	62,75	008
SCAC R/L 1010 M06	10	10	150	9	10	1,2	CC.. 0602	67,82	110	67,82	110
SCAC R/L 1010 E06	10	10	70	9	10	1,2	CC.. 0602	67,82	010	67,82	010
SCAC R/L 1212 M09	12	12	150	13	12	3,2	CC.. 09T3	75,86	112	75,86	112
SCAC R/L 1212 F09	12	12	80	13	12	3,2	CC.. 09T3	67,82	012	67,82	012
SCAC R/L 1414 M09	14	14	150	13	14	3,2	CC.. 09T3	74,42	114	74,42	114
SCAC R/L 1616 H09	16	16	100	13	16	3,2	CC.. 09T3	84,00	116	84,00	116
SCAC R/L 2020 K12	20	20	125	17	20	5	CC.. 1204	89,29	120	89,29	120

Spare parts for Article no.

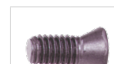
	80 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	
	EUR Y7		EUR 2A/28		EUR 2A		EUR 2A/28		EUR 2A/28	
70 756 108 / 70 757 108	8,03	110			2,43	112				
70 756 008 / 70 757 008	8,03	110			2,43	112				
70 756 110 / 70 757 110	8,03	110			2,43	112				
70 756 010 / 70 757 010	8,03	110			2,43	112				
70 756 112 / 70 757 112	9,56	113			3,30	113				
70 756 012 / 70 757 012	9,56	113			3,30	113				
70 756 114 / 70 757 114	9,56	113			3,30	113				
70 756 116 / 70 757 116			8,69	398	3,30	113	10,15	165	4,87	171
70 756 120 / 70 757 120			8,69	398	2,70	114	12,99	166	4,87	170



Key D



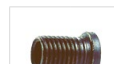
Combination Key



Clamping screw

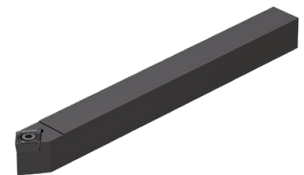
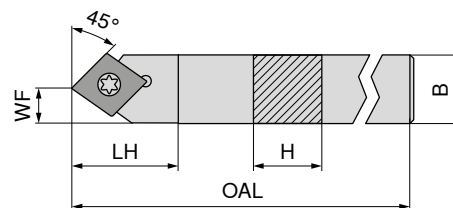


Carbide type C



Threaded sleeve

MaxiLock-S – SCDC 45° – Toolholder with screw clamping



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Neutral 70 752 ...	
								EUR 2A/24	
SCDC L 0808 K06	8	8	125	13	4	1,2	CC.. 0602	67,82	008
SCDC L 1010 M06	10	10	150	13	5	1,2	CC.. 0602	67,82	010
SCDC L 1212 M09	12	12	150	18	6	3,2	CC.. 09T3	75,86	012
SCDC L 1414 M09	14	14	150	18	7	3,2	CC.. 09T3	75,86	014

Spare parts for Article no.

	80 950 ...		70 950 ...	
	EUR Y7		EUR 2A	
70 752 008	8,03	110	2,43	112
70 752 010	8,03	110	2,43	112
70 752 012	9,56	113	3,30	113
70 752 014	9,56	113	3,30	113

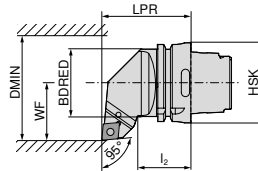


Key D



Clamping screw

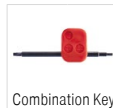
MaxiLock-S – SCLC 95° – Toolholder with screw clamping



Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	l ₂ mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									74 541 ...		74 540 ...	
HSK T63 SCLC R/L 12	HSK-T 63	70	42	53	45	100	5	CC.. 1204	EUR 2D/80 233,60	512	EUR 2D/80 233,60	512

Spare parts for Article no.	74 540 512 / 74 541 512	T15/SW	EUR 2A/28 8,69	398	M4,5x12	EUR 2A/28 2,70	114	EUR 2A/28 12,99	166	M4,5	EUR 2A/28 4,87	170



Combination Key



Clamping screw

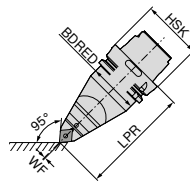


Carbide type C



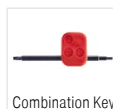
Threaded sleeve

MaxiLock-S – SCMC 50° – Toolholder with screw clamping

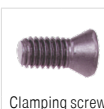


ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert	Neutral	
							74 542 ...	
HSK T63 SCMC N 12	HSK-T 63	115	53	0	5	CC.. 1204	EUR 2D/80 319,00	512

Spare parts for Article no.	74 542 512	T15/SW	EUR 2A/28 8,69	398	M4,5x12	EUR 2A/28 2,70	114	EUR 2A/28 12,99	166	M4,5	EUR 2A/28 4,87	170



Combination Key



Clamping screw



Carbide type C

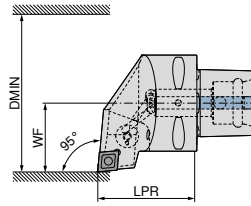


Threaded sleeve

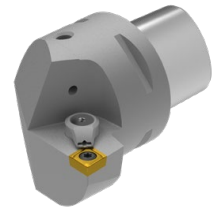
MaxiLock-S – SCLC 95° – Toolholder with screw clamping

Scope of supply:

without high-performance coolant set



Illustrations show right-hand versions



ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Direct cooling compatible	NEW Left-hand 84 655 ...		NEW Right-hand 84 654 ...	
								EUR Y8		EUR Y8	
PSC40 SCLC R/L 50050-12	PSC 40	50	27	50	5	CC.. 1204	DC	205,40	01295	205,40	01295
PSC50 SCLC R/L 65060-12	PSC 50	60	35	65	5	CC.. 1204	DC	235,40	01294	235,40	01294
PSC63 SCLC R/L 80065-12	PSC 63	65	45	80	5	CC.. 1204	DC	261,90	01293	261,90	01293



The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → Page 42.



Clamping screw

84 950 ...

EUR
Y8

4,83 27500

4,83 27500

4,83 27500

Adapter

PSC 40

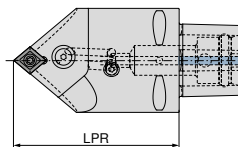
PSC 50

PSC 63

MaxiLock-S – SCMC 50° – Toolholder with screw clamping

Scope of supply:

without high-performance coolant set



NEW
Neutral

84 674 ...

EUR
Y8

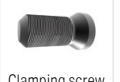
261,90 01293

261,90 11293

ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Direct cooling compatible	
PSC63 SCMC N 0100-12	PSC 63	100	5	CC.. 1204	DC	
PSC63 SCMC N 0130-12	PSC 63	130	5	CC.. 1204	DC	



The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → Page 42.



Clamping screw

84 950 ...

EUR
Y8

4,83 27500

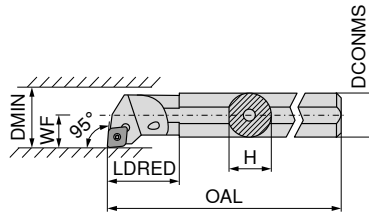
Adapter

PSC 63

MaxiLock-S – SCLC 95° – Boring bar with screw clamping

▲ A... = with thro' coolant

▲ S... = without thro' coolant



Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									70 717 ...		70 716 ...	
									EUR 2A/24		EUR 2A/24	
S08H SCLC R/L 06	8	7,2	100		5	11	1,2	CC.. 0602	101,40	008	101,40	008
A08F SCLC R/L 06	8	7,6	80	17	5	11	1,2	CC.. 0602	101,40	208	101,40	208
A10H SCLC R/L 06	10	9,5	100	19	7	13	1,2	CC.. 0602	101,40	210	101,40	210
S10K SCLC R/L 06	10	9,0	125		7	13	1,2	CC.. 0602	101,40	010	101,40	010
A12K SCLC R/L 06	12	11,5	125	22	9	16	1,2	CC.. 0602	101,40	212	101,40	212
S12Q SCLC R/L 06	12	11,0	180		9	16	1,2	CC.. 0602	101,40	012	101,40	012
A16M SCLC R/L 06	16	14,0	150	50	9	18	1,2	CC.. 0602	101,60	116	101,60	116
S16R SCLC R/L 09	16	14,5	200		11	20	3,2	CC.. 09T3	103,60	016	103,60	016
A16M SCLC R/L 09	16	15,0	150	29	11	20	3,2	CC.. 09T3	103,60	216	103,60	216
A20Q SCLC R/L 09	20	18,5	180	32	13	25	3,2	CC.. 09T3	129,20	220	129,20	220
S20S SCLC R/L 09	20	18,0	250		13	25	3,2	CC.. 09T3	129,20	020	129,20	020
S25T SCLC R/L 09	25	23,0	300		17	32	3,2	CC.. 09T3	148,50	025	148,50	025
A25R SCLC R/L 09	25	23,0	200	36	17	32	3,2	CC.. 09T3	148,50	225	148,50	225
A32S SCLC R/L 12	32	30,0	250	50	22	40	5	CC.. 1204	204,10	232	204,10	232
A40T SCLC R/L 12	40	38,0	300	60	27	50	5	CC.. 1204	245,10	240	245,10	240

Spare parts
for Article no.

	80 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	
	EUR Y7		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28	
70 716 008 / 70 717 008	8,03	110			2,70	116				
70 716 208 / 70 717 208	8,03	110			2,70	116				
70 716 210 / 70 717 210	8,03	110			2,70	116				
70 716 010 / 70 717 010	8,03	110			2,70	116				
70 716 212 / 70 717 212	8,03	110			2,70	116				
70 716 012 / 70 717 012	8,03	110			2,70	116				
70 716 116 / 70 717 116	8,03	110			2,70	116				
70 716 016 / 70 717 016	9,56	113			3,30	110				
70 716 216 / 70 717 216	9,56	113			3,30	110				
70 716 220 / 70 717 220	9,56	113			3,30	304				
70 716 020 / 70 717 020	9,56	113			3,30	110				
70 716 025 / 70 717 025	9,56	113			3,30	113				
70 716 225 / 70 717 225	9,56	113			3,30	304				
70 716 232 / 70 717 232			8,69	398	2,70	114	12,99	166	4,87	170
70 716 240 / 70 717 240			8,69	398	2,70	114	12,99	166	4,87	170



Key D



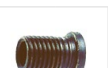
Combination Key



Clamping screw



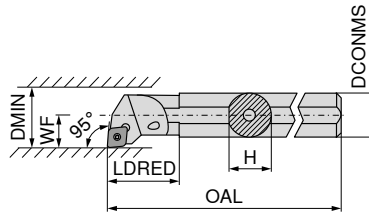
Carbide type C



Threaded sleeve

MaxiLock-S – SCLC 95° – Boring bar with screw clamping

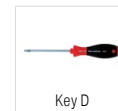
▲ with carbide core



Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 719 ...		Right-hand 70 718 ...	
									EUR 2A		EUR 2A	
E-A08F SCLC R/L 06	8	7,5	80	18	6	12	1,2	CC.. 0602	186,10	208	186,10	208
E-A10H SCLC R/L 06	10	9,0	100	25	7	14	1,2	CC.. 0602	186,10	210	186,10	210
E-A12K SCLC R/L 06	12	11,0	125	20	9	18	1,2	CC.. 0602	200,50	212	200,50	212
E-A16M SCLC R/L 09	16	15,0	150	28	11	22	3,2	CC.. 09T3	340,20	216	340,20	216
E-A20Q SCLC R/L 09	20	18,0	180	38	13	26	3,2	CC.. 09T3	420,60	220	420,60	220
E-A25R SCLC R/L 09	25	23,0	200	38	17	34	3,2	CC.. 09T3	533,90	225	533,90	225
E-A32S SCLC R/L 12	32	30,0	250	43	22	39	5	CC.. 1204	840,10	232	840,10	232

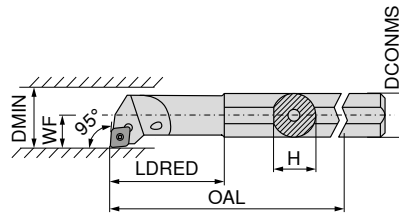


Spare parts for Article no.

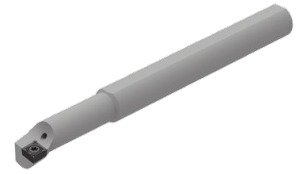
			80 950 ...		70 950 ...	
			EUR Y7		EUR 2A/28	
70 718 208 / 70 719 208	T08	8,03	110	M2,5x5	2,70	116
70 718 210 / 70 719 210	T08	8,03	110	M2,5x5	2,70	116
70 718 212 / 70 719 212	T08	8,03	110	M2,5x5	2,70	116
70 718 216 / 70 719 216	T15	9,56	113	M4x9,5	3,30	449
70 718 220 / 70 719 220	T15	9,56	113	M4x9,5	3,30	449
70 718 225 / 70 719 225	T15	9,56	113	M4x9,5	3,30	449
70 718 232 / 70 719 232	T15	9,56	113	M4x11	3,57	174

MaxiLock-S – SCLC 95° – Boring bar with screw clamping

▲ with carbide core



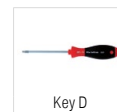
Illustrations show right-hand versions



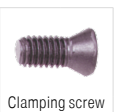
ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 719 ...		Right-hand 70 718 ...	
									EUR 2A		EUR 2A	
E-A0608F SCLC R/L 06	8	7,5	100	25	4	8	1,2	CC.. 0602	200,50	308	200,50	308
E-A0810H SCLC R/L 06	10	9,0	110	32	6	12	1,2	CC.. 0602	200,50	310	200,50	310
E-A1012K SCLC R/L 06	12	11,0	125	38	7	14	1,2	CC.. 0602	200,50	312	200,50	312
E-A1216M SCLC R/L 06	16	15,0	150	50	9	18	1,2	CC.. 0602	200,50	316	200,50	316

Spare parts
for Article no.

70 718 308 / 70 719 308	
70 718 310 / 70 719 310	
70 718 312 / 70 719 312	
70 718 316 / 70 719 316	



Key D



Clamping screw

80 950 ...

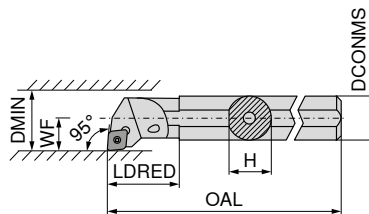
EUR Y7	
8,03	110
8,03	110
8,03	110
8,03	110

70 950 ...

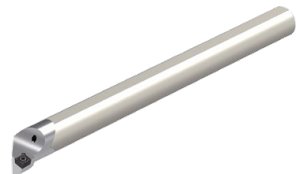
EUR 2A/28	
2,70	116
2,70	116
2,70	116
2,70	116

MaxiLock-S – SCLC 95° – Boring bar with screw clamping

▲ Type: Solid carbide



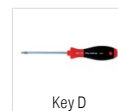
Illustrations show right-hand versions



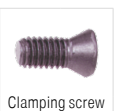
ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 719 ...		Right-hand 70 718 ...	
									EUR 2A/24		EUR 2A/24	
E08H SCLC R/L 06	8	7,6	100		6	11	1,2	CC.. 0602	230,60	008	230,60	008
E10K SCLC R/L 06	10	9,0	125	22	7	13	1,2	CC.. 0602	266,40	010	266,40	010
E12Q SCLC R/L 06	12	11,5	180	26	9	16	1,2	CC.. 0602	349,90	012	349,90	012
E16R SCLC R/L 09	16	15,0	200	34	11	20	3,2	CC.. 09T3	457,20	016	457,20	016
E20S SCLC R/L 09	20	18,5	250	38	13	25	3,2	CC.. 09T3	571,10	020	571,10	020
E25T SCLC R/L 09	25	23,0	300	43	17	32	3,2	CC.. 09T3	1.007,00	025	1.007,00	025

Spare parts
for Article no.

70 719 008 / 70 718 008	T08
70 719 010 / 70 718 010	T08
70 719 012 / 70 718 012	T08
70 719 016 / 70 718 016	T15
70 719 020 / 70 718 020	T15
70 719 025 / 70 718 025	T15



Key D



Clamping screw

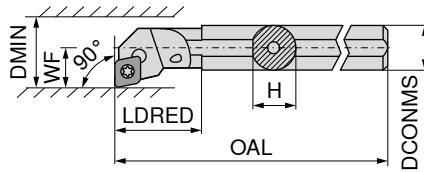
80 950 ...

EUR Y7	
8,03	110
8,03	110
8,03	110
9,56	113
9,56	113
9,56	113

70 950 ...

EUR 2A/28	
2,70	116
2,70	116
2,70	116
3,30	110
3,30	304
3,30	113

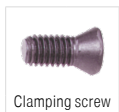
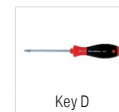
MaxiLock-S – SCFC 90° – Boring bar with screw clamping



Illustrations show right-hand versions

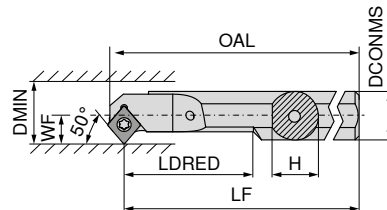


ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									70 793 ...		70 792 ...	
A08F SCFC R/L 06	8	7,6	80	17	5	11	1,2	CC.. 0602	EUR 2A/24 101,40	208	EUR 2A/24 101,40	208
A10H SCFC R/L 06	10	9,5	100	19	7	13	1,2	CC.. 0602	101,40	210	101,40	210
A12K SCFC R/L 06	12	11,5	125	22	9	16	1,2	CC.. 0602	101,40	212	101,40	212

Spare parts
for Article no.

Spare parts for Article no.			80 950 ...		70 950 ...	
			EUR Y7		EUR 2A/28	
70 792 208 / 70 793 208	T08	8,03	110	M2,5x5	2,70	116
70 792 210 / 70 793 210	T08	8,03	110	M2,5x5	2,70	116
70 792 212 / 70 793 212	T08	8,03	110	M2,5x5	2,70	116

MaxiLock-S – SCMC 50° – Boring bar with screw clamping



Illustrations show right-hand versions



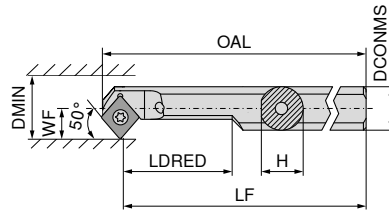
ISO designation	DCONMS mm	H mm	OAL mm	LF mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
										70 723 ...		70 722 ...	
A08H SCMC R/L 06	8	7	104,15	100	20	5,5	10,5	1,2	CC.. 0602	EUR 2A 99,47	208	EUR 2A 99,47	208
A10H SCMC R/L 06	10	9	114,15	110	26	6,0	11,0	1,2	CC.. 0602	99,47	210	99,47	210
A12K SCMC R/L 06	12	11	129,15	125	32	7,0	13,0	1,2	CC.. 0602	99,47	212	99,47	212
A16M SCMC R/L 06	16	14	154,15	150	40	9,0	16,0	1,2	CC.. 0602	101,60	216	101,60	216

Spare parts
for Article no.

Spare parts for Article no.			80 950 ...		70 950 ...	
			EUR Y7		EUR 2A/28	
70 723 208 / 70 722 208	T08	8,03	110	M2,5x5	2,70	116
70 723 210 / 70 722 210	T08	8,03	110	M2,5x5	2,70	116
70 723 212 / 70 722 212	T08	8,03	110	M2,5x5	2,70	116
70 723 216 / 70 722 216	T08	8,03	110	M2,5x5	2,70	116

MaxiLock-S – SCMC 50° – Boring bar with screw clamping

▲ with carbide core



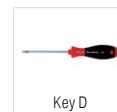
Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LF mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 707 ...		Right-hand 70 706 ...	
										EUR 2A		EUR 2A	
E-A0608H SCMC R/L 06	8	7,5	104,15	100	20	5,5	10,5	1,2	CC.. 0602	200,50	008	200,50	008
E-A0810H SCMC R/L 06	10	9,0	114,15	110	26	6,0	11,0	1,2	CC.. 0602	200,50	010	200,50	010
E-A1012K SCMC R/L 06	12	11,0	129,15	125	32	7,0	13,0	1,2	CC.. 0602	200,50	012	200,50	012
E-A1216M SCMC R/L 06	16	15,0	154,15	150	40	9,0	16,0	1,2	CC.. 0602	200,50	016	200,50	016

Spare parts
for Article no.

70 706 008 / 70 707 008
70 706 010 / 70 707 010
70 706 012 / 70 707 012
70 706 016 / 70 707 016



Key D



Clamping screw

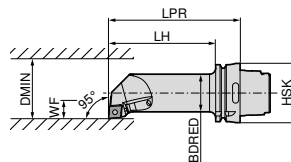
80 950 ...
EUR
Y7

8,03 110
8,03 110
8,03 110
8,03 110

70 950 ...
EUR
2A/28

2,70 116
2,70 116
2,70 116
2,70 116

MaxiLock-S – SCLC 95° – Boring bar with screw clamping



Illustrations show right-hand versions

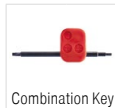


ISO designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 564 ...		Right-hand 74 563 ...	
									EUR 2D/80		EUR 2D/80	
HSK T63 40L SCLC R/L 12	HSK-T 63	140	114	40	27	50	5	CC.. 1204	321,40	512	321,40	512

Spare parts
for Article no.

74 563 512 / 74 564 512

70 950 ...		70 950 ...		70 950 ...		70 950 ...	
EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28	
8,69	398	2,70	114	12,99	166	4,87	170



Combination Key



Clamping screw



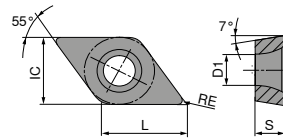
Carbide type C



Threaded sleeve

DCGT / DCMT / DCET

Designation	L mm	S mm	D1 mm	IC mm
DC.T 0702..	7,75	2,38	2,8	6,35
DC.T 11T3..	11,60	3,97	4,4	9,52



DCGT / DCMT

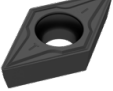
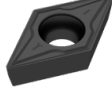
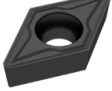
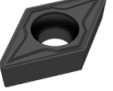
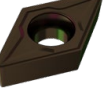
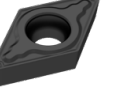
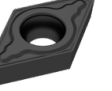
		-CF05 CTEP110		-CF55 CTEP110		-SF TCM10		-SMF TCM10		-SF TCM407		-SF CTCP125		-SF CTCP115	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		F		F		F		F		F		F		F	
		CERMET DCGT		CERMET DCMT		CERMET DCGT		CERMET DCMT		CERMET DCGT		DCGT		DCMT	
		76 245 ...		76 246 ...		70 257 ...		70 265 ...		70 257 ...		76 257 ...		76 259 ...	
		EUR 1A/78		EUR 1A/78		EUR 1A/78		EUR 1A/78		EUR 1A/78		EUR 1A/08		EUR 1A/08	
ISO	RE mm														
070201EN	0,1					898		898							
070202EN	0,2	14,55		8,26		14,10		7,64				14,55			
070204EN	0,4	14,55		8,26		14,10		7,64		14,10		502		8,17	
11T302EN	0,2	19,27				904				854					
11T304EN	0,4	19,27		11,46		906		10,73		856				11,48	
11T308EN	0,8	19,27		11,46		908		10,73		858				11,48	
P		●		●		●		●		●		●		●	
M		○		○		○		○		○		○		○	
K		○		○		○		○		○		○		○	
N															
S															
H															
O															

9

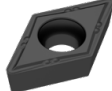
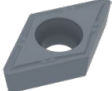
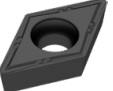
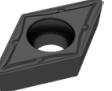
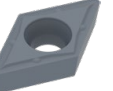
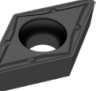
DCMT / DCGT

		-SF CTCP125		-SF CTCP135		-SMF CTCP115		-SMF CTCP125		-SMF CTCP135		-SM CTCP125		-SM CTCP135	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		F		F		F		F		F		M		M	
		DCMT		DCMT		DCMT		DCMT		DCMT		DCGT		DCGT	
		76 259 ...		76 259 ...		76 265 ...		76 265 ...		76 265 ...		76 256 ...		76 256 ...	
		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
ISO	RE mm														
070202EN	0,2							8,17		8,17		704			
070204EN	0,4	8,17		8,17				8,17		8,17		704		14,55	
070208EN	0,8									8,17		706			
11T304EN	0,4	11,48		11,48		316		11,48		11,48		716			
11T308EN	0,8	11,48		11,48		318		11,48		11,48		718			
P		●		●		●		●		●		●		●	
M				○								○			
K		○				○		○				○			
N															
S															
H															
O															

DCMT

		-SM CTCK110		-SM CTCK120		-SM CTCP115		-SM CTCP125		-SM CTCP135		-SMQ CTCP115		-SMQ CTCP125	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
															
		M DCMT		M DCMT		M DCMT		M DCMT		M DCMT		M DCMT		M DCMT	
		70 258 ...		70 258 ...		76 258 ...		76 258 ...		76 258 ...		76 195 ...		76 195 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
070204EN	0,4	8,17	004	8,17	554	8,17	304	8,17	504	8,17	704	9,31	304	9,31	504
070208EN	0,8	8,17	006	8,17	506	8,17	306	8,17	506	8,17	706				
11T304EL	0,4											12,80	31600	12,80	516
11T304EN	0,4	11,48	016	11,48	516	11,48	316	11,48	516	11,48	716	12,80	31500	12,80	515
11T304ER	0,4											12,80	31700	12,80	517
11T308EN	0,8	11,48	018	11,48	518	11,48	318	11,48	518	11,48	718	12,80	31800	12,80	518
11T312EN	1,2							11,48	520						
P			○		○		●		●		●		●		●
M											○				
K			●		●		○		○				○		○
N															
S															
H															
O															

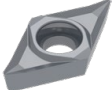
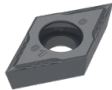
DCMT

		NEW -M25 CTCM120		-M25 CTPM125		NEW -M25 CTCM130		NEW -M55 CTCM120		-M55 CTPM125		NEW -M55 CTCM130	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
													
													
		F DCMT		F DCMT		F DCMT		M DCMT		M DCMT		M DCMT	
		75 213 ...		75 213 ...		75 213 ...		75 214 ...		75 214 ...		75 214 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
070202EN	0,2	8,17	10200	8,17	202	8,17	30200						
070204EN	0,4	8,17	10400	8,17	204	8,17	30400	8,17	10400	8,17	204	8,17	30400
070208EN	0,8							8,17	10600	8,17	206	8,17	30600
11T302EN	0,2	11,48	11400	11,48	214	11,48	31400						
11T304EN	0,4	11,48	11600	11,48	216	11,48	31600	11,48	11600	11,48	216	11,48	31600
11T308EN	0,8	11,48	11800	11,48	218	11,48	31800	11,48	11800	11,48	218	11,48	31800
P			○		○		○		○		○		○
M			●		●		●		●		●		●
K													
N													
S									○				○
H													
O													

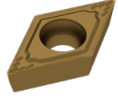
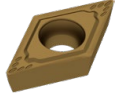
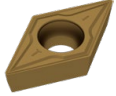
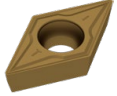
DCGT

		-23P H216T		-25P H210T		NEW -25P CTPX710		-25Q H210T		NEW -25Q CTPX710		-27 H10T		-27 CWN15	
		F		F		M		M		M		M		M	
		DCGT		DCGT		DCGT		DCGT		DCGT		DCGT		DCGT	
		70 261 ...		70 263 ...		70 263 ...		70 263 ...		70 263 ...		70 260 ...		70 260 ...	
ISO	RE mm	EUR 1A/90		EUR 1A/90		EUR 1A/90		EUR 1A/90		EUR 1A/90		EUR 1A/90		EUR 1A	
070202FN	0,2			10,32		12,34						9,75		12,48	
070204FN	0,4	10,32		10,32		12,34						9,75		12,48	
11T302FN	0,2			12,80		14,92						12,21		14,76	
11T304FL	0,4							13,98		17,82					
11T304FN	0,4	12,80		12,80		14,92		13,98		17,82		12,21		14,76	
11T304FR	0,4							13,98		17,82					
11T308FL	0,8							13,98							
11T308FN	0,8	12,80		12,80		14,92		13,98		17,82		12,21		14,76	
11T308FR	0,8							13,98							
P						●				●					
M						●				●				○	
K		○		○				○				○			
N		●		●		●		●		●		●		●	
S				○		●		○		●					
H															
O		○		○				○				○			

DCGT / DCMT / DCET

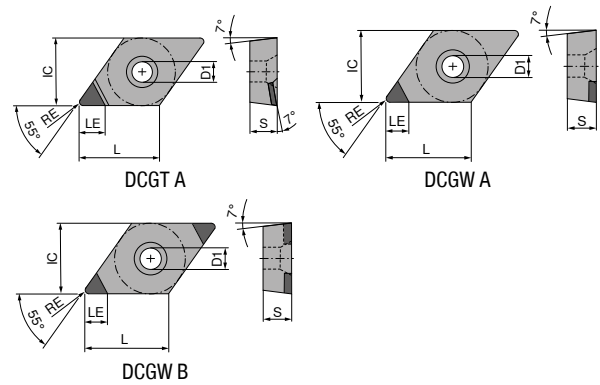
		NEW		NEW		NEW	
		-27 CTPX715		-29 H216T		-F05 CTPX710	
		DRAGONSKIN				DRAGONSKIN	
							
							
		M		M		F	
		DCGT		DCMT		DCET	
		70 260 ...		70 246 ...		76 254 ...	
ISO	RE mm	EUR 1A/90		EUR 1A/90		EUR 1H/17	
0702005FN	0,05					17,60	10200
070201FN	0,10					17,60	10400
0702015FN	0,15					17,60	10600
070202FN	0,20	11,85	80200			17,60	10800
070204FN	0,40	11,85	80400				
070204EN	0,40			7,48	60400		
11T3005FN	0,05					23,33	11400
11T301FN	0,10					23,33	11600
11T3015FN	0,15					23,33	11800
11T302FN	0,20	14,34	81400			23,33	12000
11T304EN	0,40			10,08	61600		
11T304FN	0,40	14,34	81600			23,33	12200
11T308EN	0,80			10,08	61800		
11T308FN	0,80	14,34	81800				
P		●		●		●	
M		●		●		●	
K		○		○			
N		●		●		●	
S		●				●	
H							
O		○		○			

DCMT

		NEW		NEW		NEW		NEW	
		-FMS CT-P15		-FMS CT-P25		-MRS CT-P15		-MRS CT-P25	
									
									
		F		F		M		M	
		DCMT		DCMT		DCMT		DCMT	
		75 304 ...		75 304 ...		75 305 ...		75 305 ...	
ISO		EUR 1S/1P		EUR 1S/1P		EUR 1S/1P		EUR 1S/1P	
RE									
070204EN	0,4	2,29	00409	2,29	10409	2,29	00409	2,29	10409
070208EN	0,8	2,29	00609	2,29	10609	2,29	00609	2,29	10609
11T304EN	0,4	2,88	01609	2,88	11609	2,88	01609	2,88	11609
11T308EN	0,8	2,88	01809	2,88	11809	2,88	01809	2,88	11809
P			●		●		●		●
M			○		○		○		○
K									
N									
S									
H									
O									

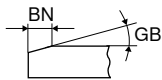
DCGW / DCGT

Designation	L mm	S mm	D1 mm	IC mm
DCG. 0702..	7,75	2,38	2,80	6,35
DCG. 11T3..	11,60	3,97	4,40	9,52
DCGW 0702..	7,75	2,38	2,38	6,35



DCGW / DCGT

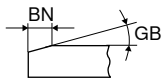
▲ TCE(NOI) = Design and number of equipped cutting edge corners



						CTBS10U		CTBS10U		CTBS10U		CTBS10U		CTBS10U	
						○		○		○		○		○	
						F		F		F		F		F	
						CBN		CBN		CBN		CBN		CBN	
						DCGW		DCGW		DCGT		DCGW		DCGW	
						71 130 ...		71 130 ...		71 134 ...		71 131 ...		71 131 ...	
						EUR		EUR		EUR		EUR		EUR	
						Y0		Y0		Y0		Y0		Y0	
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm										
070202TN	0,2	0,12	20°	A (1)	3,9	37,14	300	37,14	200	42,39	200				
070202FN	0,2			A (1)	3,9										
070204FN	0,4			A (1)	3,5			37,14	202	42,39	202				
070204TN	0,4	0,12	20°	A (1)	3,5	37,14	302								
070208FN	0,8			A (1)	3,0			37,14	204	42,39	204				
070208TN	0,8	0,12	20°	A (1)	3,0	37,14	304								
11T302FN	0,2			A (1)	3,9			37,14	206	42,39	206				
11T302TN	0,2	0,12	20°	B (2)	3,9							58,44	300		
11T302TN	0,2	0,12	20°	A (1)	3,9	37,14	306							58,44	200
11T302FN	0,2			B (2)	3,9										
11T304TN	0,4	0,12	20°	B (2)	3,5							58,44	302		
11T304FN	0,4			A (1)	3,5			37,14	208	42,39	208				
11T304TN	0,4	0,12	20°	A (1)	3,5	37,14	308							58,44	202
11T304FN	0,4			B (2)	3,5										
11T308TN	0,8	0,12	20°	B (2)	3,0							58,44	304		
11T308FN	0,8			A (1)	3,0			37,14	210	42,39	210				
11T308TN	0,8	0,12	20°	A (1)	3,0	37,14	310								
11T308FN	0,8			B (2)	3,0									58,44	204
P															
M															
K															
N															
S															
H															
O															

DCGW / DCGT

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

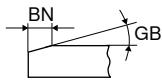


NEW						NEW						NEW						NEW						NEW											
CTBS10C						CTBS20U						CTBS20U						CTBS20U						CTBS20C						CTBH15U					
F						F						F						F						F						F					
CBN						CBN						CBN						CBN						CBN						CBN					
DCGW						DCGW						DCGT						DCGW						DCGW						DCGW					
71 424 ...						71 422 ...						71 421 ...						71 163 ...						71 163 ...						71 008 ...					
EUR						EUR						EUR						EUR						EUR						EUR					
Y0						Y0						Y0						Y0						Y0						Y0					
65,03 80100						41,08 20100																		59,35 120						74,37 30214					
																								59,35 130											
																								59,35 140											
																								59,35 150											
																								59,35 160											
65,03 80000						41,08 20000																								74,37 00200					
																								59,35 121											
65,03 80300						41,08 20200																		59,35 131						74,37 30414					
65,03 80400																								59,35 141											
																								59,35 151						74,37 30429					
																								59,35 161											
65,03 80200																								59,35 181						74,37 00400					
																								59,35 132											
																								59,35 142											
																								59,35 152											
																								59,35 162											
																								59,35 172											
																								59,35 112											
						41,08 20400																		59,35 133											
																								59,35 143											
																								59,35 153											
						41,08 20300																		59,35 163											
																								59,35 113											
																								59,35 124											
65,03 80600																		59,35 13400																	
						41,08 20500																													
65,03 80700																																			
65,03 80800																														59,35 144					
																														59,35 154					
																														59,35 164					
												50,22 20000																							
65,03 80500																														59,35 174					
																														59,35 184					

P											
M											
K											
N											
S											
H											
O											

DCGW / DCGT

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

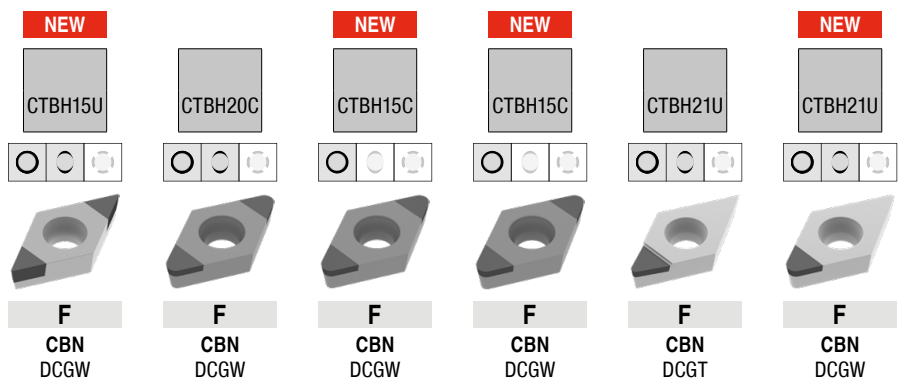
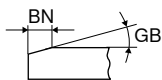


NEW	NEW	NEW	NEW		NEW
CTBS10C	CTBS20U	CTBS20U	CTBS20U	CTBS20C	CTBH15U
F	F	F	F	F	F
CBN DCGW	CBN DCGW	CBN DCGT	CBN DCGW	CBN DCGW	CBN DCGW
71 424 ...	71 422 ...	71 421 ...	71 163 ...	71 163 ...	71 008 ...

ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	EUR Y0		EUR Y0		EUR Y0		EUR Y0	
11T308SN	0,8	0,09	10°	B (2)	3,0	65,03	81000						
11T308TN	0,8	0,09	15°	B (2)	3,0	65,03	81100						
11T308SN	0,8	0,11	15°	B (2)	3,0					59,35	135		
11T308TN	0,8	0,12	15°	A (1)	3,0			41,08	20600				
11T308SN	0,8	0,14	15°	B (2)	3,0	65,03	81200						
11T308SN	0,8	0,14	20°	B (2)	3,0	65,03	81300						
11T308TN	0,8	0,15	20°	B (2)	3,0					59,35	145		
11T308SN	0,8	0,16	20°	B (2)	3,0					59,35	155		
11T308TN	0,8	0,17	25°	B (2)	3,0					59,35	165		
11T308SN	0,8	0,18	30°	B (2)	3,0					59,35	185		
11T308FN	0,8			A (1)	3,0			50,22	20100				
11T308EN	0,8			B (2)	3,0	65,03	80900			59,35	115		
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DCGW / DCGT

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

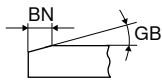


ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	71 012 ...	71 163 ...	71 007 ...	71 009 ...	71 134 ...	71 422 ...
						EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0
070202SN	0,2	0,09	10°	B (2)	3,9		59,35 230				
070202SN	0,2	0,11	15°	B (2)	3,9		59,35 240	71,93 30214			
070202EN	0,2			B (2)	3,9			71,93 00200			
070202SN	0,2	0,09	20°	B (2)	3,9		59,35 250				
070202FN	0,2			A (1)	3,9					42,39 400	
070202TN	0,2	0,13	25°	A (1)	3,9						47,16 40000
070202TN	0,2	0,14	25°	B (2)	3,9		59,35 260				
070204FN	0,4			B (2)	3,5		59,35 211				
070204SN	0,4	0,09	10°	B (2)	3,5		59,35 231				
070204SN	0,4	0,11	15°	B (2)	3,5		59,35 241	71,93 30414			
070204SN	0,4	0,09	20°	B (2)	3,5		59,35 251				
070204TN	0,4	0,13	25°	A (1)	3,5						47,16 40100
070204SN	0,4	0,14	25°	B (2)	3,5			71,93 30429			
070204TN	0,4	0,14	25°	B (2)	3,5		59,35 261				
070204EN	0,4			B (2)	3,5			71,93 00400			
070204SN	0,4	0,15	25°	B (2)	3,5		59,35 271				
070204FN	0,4			A (1)	3,5					42,39 402	
070208FN	0,8			B (2)	3,0		59,35 212				
070208SN	0,8	0,09	10°	B (2)	3,0		59,35 232				
070208SN	0,8	0,11	15°	B (2)	3,0	74,37 30614			71,93 30614		
070208SN	0,8	0,09	20°	B (2)	3,0		59,35 252				
070208SN	0,8	0,14	25°	B (2)	3,0	74,37 30629			71,93 30629		
070208TN	0,8	0,14	25°	B (2)	3,0		59,35 262				
070208EN	0,8			B (2)	3,0	74,37 00600	59,35 222		71,93 00600		
11T302RN	0,2			B (2)	3,9			71,93 21400			
11T302SN	0,2	0,09	15°	B (2)	3,9		59,35 233				
11T302SN	0,2	0,11	15°	B (2)	3,9		59,35 243	71,93 31414			
11T302SN	0,2	0,09	20°	B (2)	3,9		59,35 253				
11T302TN	0,2	0,14	25°	B (2)	3,9		59,35 263				
11T302SN	0,2	0,14	25°	B (2)	3,9			71,93 31429			
11T302SN	0,2	0,15	25°	B (2)	3,9		59,35 273				
11T302FN	0,2			A (1)	3,9					42,39 406	
11T304FN	0,4			B (2)	3,5		59,35 214				
11T304EN	0,4			B (2)	3,5		59,35 224				
11T304SN	0,4	0,09	10°	B (2)	3,5		59,35 234				
11T304SN	0,4	0,11	15°	B (2)	3,5		59,35 244	71,93 31614			
11T304SN	0,4	0,09	20°	B (2)	3,5		59,35 254				
11T304TN	0,4	0,14	25°	B (2)	3,5		59,35 264				
11T304RN	0,4			B (2)	3,5			71,93 21600			
11T304SN	0,4	0,14	25°	B (2)	3,5			71,93 31629			
11T304SN	0,4	0,15	25°	B (2)	3,5		59,35 274				
11T304SN	0,4	0,18	30°	B (2)	3,5		59,35 284				
11T304FN	0,4			A (1)	3,5					42,39 408	
11T308EN	0,8			B (2)	3,0		59,35 225				
11T308FN	0,8			B (2)	3,0		59,35 215				
11T308RN	0,8			B (2)	3,0						
11T308SN	0,8	0,11	15°	B (2)	3,0		59,35 245	71,93 21800			
11T308SN	0,8	0,09	20°	B (2)	3,0		59,35 255	71,93 31814			
11T308TN	0,8	0,14	25°	B (2)	3,0		59,35 265				
11T308SN	0,8	0,14	25°	B (2)	3,0						
11T308SN	0,8	0,18	30°	B (2)	3,0		59,35 285	71,93 31829			
11T308FN	0,8			A (1)	3,0					42,39 410	

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DCGW / DCGT

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



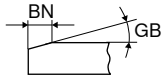
						NEW						NEW
						-Q	CTBH21U	CTBH20U	CTBH20U	CTBH40U	CTBH20C	CTBH21C
						F	F	F	F	F	F	F
						CBN	CBN	CBN	CBN	CBN	CBN	CBN
						DCGW	DCGW	DCGW	DCGT	DCGW	DCGW	DCGW
						71 423 ...	71 130 ...	71 131 ...	71 134 ...	71 163 ...	71 424 ...	
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0
070201EL	0,1			A (1)	3,0	57,84	40000					
070201ER	0,1			A (1)	3,0	57,84	40100					
070202SN	0,2	0,09	10°	B (2)	3,9					59,35	230	
070202SN	0,2	0,11	15°	B (2)	3,9					59,35	240	
070202SN	0,2	0,09	20°	B (2)	3,9					59,35	250	
070202TN	0,2	0,11	20°	B (2)	3,4							69,17 90100
070202TN	0,2	0,12	20°	B (2)	3,9			58,44	53000			
070202TN	0,2	0,12	20°	A (1)	3,9	37,14	500					
070202TN	0,2	0,14	25°	B (2)	3,9					59,35	260	
070202FN	0,2			A (1)	3,9	37,14	400 1)		42,39	800		
070202EN	0,2			B (2)	3,4							69,17 90000
070204SN	0,4	0,09	10°	B (2)	3,5					59,35	231	
070204SN	0,4	0,09	10°	B (2)	3,0							69,17 90300
070204SN	0,4	0,11	15°	B (2)	3,5					59,35	241	
070204SN	0,4	0,09	20°	B (2)	3,5					59,35	251	
070204TN	0,4	0,11	20°	B (2)	3,0							69,17 90400
070204TN	0,4	0,12	20°	B (2)	3,5			58,44	53200			
070204TN	0,4	0,12	20°	A (1)	3,5	37,14	502					
070204TN	0,4	0,14	25°	B (2)	3,5					59,35	261	
070204SN	0,4	0,15	25°	B (2)	3,5					59,35	271	
070204FN	0,4			B (2)	3,5					59,35	211	
070204FN	0,4			A (1)	3,5	37,14	402 1)		42,39	802		
070204EN	0,4			B (2)	3,0							69,17 90200
070208SN	0,8	0,09	10°	B (2)	3,0					59,35	232	
070208SN	0,8	0,09	20°	B (2)	3,0					59,35	252	
070208EN	0,8			B (2)	3,0					59,35	222	
070208FN	0,8			B (2)	3,0					59,35	212	
070208TN	0,8	0,11	20°	B (2)	2,6							69,17 90600
070208TN	0,8	0,12	20°	A (1)	3,0	37,14	504					
070208TN	0,8	0,14	25°	B (2)	3,0					59,35	262	
070208TN	0,8	0,15	35°	B (2)	2,6							69,17 90700
070208FN	0,8			A (1)	3,0	37,14	404 1)					69,17 90500
070208EN	0,8			B (2)	2,6							
11T302SN	0,2	0,09	15°	B (2)	3,9					59,35	233	
11T302SN	0,2	0,11	15°	B (2)	3,9					59,35	243	
11T302SN	0,2	0,09	20°	B (2)	3,9					59,35	253	
11T302TN	0,2	0,11	20°	B (2)	3,4							69,17 90900
11T302TN	0,2	0,12	20°	B (2)	3,9			58,44	500			
11T302TN	0,2	0,12	20°	A (1)	3,9	37,14	506					
11T302TN	0,2	0,14	25°	B (2)	3,9					59,35	263	
11T302FN	0,2			A (1)	3,9	37,14	406 1)		42,39	806		
11T302SN	0,2	0,15	25°	B (2)	3,9			58,44	400 1)			
11T302FN	0,2			B (2)	3,9							69,17 90800
11T302EN	0,2			B (2)	3,4							
11T304SN	0,4	0,09	10°	B (2)	3,5					59,35	234	
11T304SN	0,4	0,09	10°	B (2)	3,0							69,17 91000
11T304TN	0,4	0,09	15°	B (2)	3,0							69,17 91100
11T304SN	0,4	0,11	15°	B (2)	3,5					59,35	244	

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1) Machining to 60 HRC

DCGW / DCGT

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

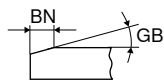


						NEW						NEW
						-Q	CTBH21U	CTBH20U	CTBH20U	CTBH40U	CTBH20C	CTBH21C
						F	F	F	F	F	F	F
						CBN	CBN	CBN	CBN	CBN	CBN	CBN
						DCGW	DCGW	DCGW	DCGT	DCGW	DCGW	DCGW
						71 423 ...	71 130 ...	71 131 ...	71 134 ...	71 163 ...	71 424 ...	
ISO	RE	BN	GB	TCE	LE	EUR	EUR	EUR	EUR	EUR	EUR	
mm	mm	mm		(NOI)	mm	Y0	Y0	Y0	Y0	Y0	Y0	
11T304SN	0,4	0,09	20°	B (2)	3,5					59,35	254	
11T304TN	0,4	0,11	20°	B (2)	3,0							69,17 91200
11T304TN	0,4	0,12	20°	B (2)	3,5			58,44	502			
11T304TN	0,4	0,12	20°	A (1)	3,5		37,14	508				
11T304TN	0,4	0,14	25°	B (2)	3,5					59,35	264	
11T304EN	0,4			B (2)	3,5					59,35	224	
11T304SN	0,4	0,14	25°	B (2)	3,0							69,17 91300
11T304SN	0,4	0,15	25°	B (2)	3,5					59,35	274	
11T304TN	0,4	0,15	30°	B (2)	3,0							69,17 91400
11T304SN	0,4	0,18	30°	B (2)	3,5					59,35	284	
11T304FN	0,4			A (1)	3,5		37,14	408 ¹⁾		42,39	808	
11T304FN	0,4			B (2)	3,5			58,44	402 ¹⁾	59,35	214	
11T308SN	0,8	0,11	15°	B (2)	3,0					59,35	245	
11T308SN	0,8	0,09	20°	B (2)	3,0					59,35	255	
11T308TN	0,8	0,11	20°	B (2)	2,6							69,17 91600
11T308TN	0,8	0,12	20°	B (2)	3,0			58,44	504			
11T308TN	0,8	0,12	20°	A (1)	3,0		37,14	510				
11T308TN	0,8	0,14	25°	B (2)	3,0					59,35	265	
11T308EN	0,8			B (2)	3,0					59,35	225	
11T308FN	0,8			B (2)	3,0			58,44	404 ¹⁾	59,35	215	
11T308TN	0,8	0,15	30°	B (2)	2,6							69,17 91700
11T308SN	0,8	0,18	30°	B (2)	3,0					59,35	285	
11T308FN	0,8			A (1)	3,0		37,14	410 ¹⁾		42,39	810	
11T308EN	0,8			B (2)	2,6							69,17 91500
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1) Machining to 60 HRC

DCGW

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



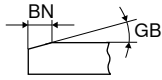
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	CTBH40U		CTBH40U		CTBH40C		CTBH41C	
						F	CBN DCGW	F	CBN DCGW	F	CBN DCGW	F	CBN DCGW
070202TN	0,2	0,09	10°	B (2)	3,4	71 130 ...	EUR Y0	71 131 ...	EUR Y0	71 163 ...	EUR Y0	71 424 ...	EUR Y0
070202TN	0,2	0,09	20°	B (2)	3,9								
070202SN	0,2	0,09	25°	B (2)	3,9					59,35	320		
070202TN	0,2	0,11	25°	B (2)	3,9					59,35	350		
070202TN	0,2	0,12	25°	B (2)	3,0					59,35	340		
070202TN	0,2	0,12	25°	A (1)	3,9	37,14	900	58,44	93000				
070202TN	0,2	0,14	30°	B (2)	3,9					59,35	360		
070202SN	0,2	0,16	30°	B (2)	3,9					59,35	370		
070202EN	0,2			B (2)	3,9					59,35	310		
070202SN	0,2	0,17	35°	B (2)	3,9					59,35	380		
070202FN	0,2			A (1)	3,9	37,14	800					69,17	00101
070202FN	0,2			B (2)	3,4							69,17	00401
070204TN	0,4	0,09	10°	B (2)	3,0								
070204SN	0,4	0,09	20°	B (2)	3,5					59,35	331		
070204SN	0,4	0,09	25°	B (2)	3,5					59,35	351		
070204TN	0,4	0,11	25°	B (2)	3,5					59,35	341		
070204TN	0,4	0,12	25°	B (2)	3,0			58,44	93200				
070204TN	0,4	0,12	25°	A (1)	3,5	37,14	902					69,17	00501
070204SN	0,4	0,14	25°	B (2)	3,0					59,35	361		
070204TN	0,4	0,14	30°	B (2)	3,5					59,35	371		
070204SN	0,4	0,16	30°	B (2)	3,5							69,17	00601
070204SN	0,4	0,15	35°	B (2)	3,0					59,35	381		
070204SN	0,4	0,17	35°	B (2)	3,5								
070204FN	0,4			A (1)	3,5	37,14	802					69,17	00301
070204FN	0,4			B (2)	3,0								
070208SN	0,8	0,09	20°	B (2)	3,0					59,35	332		
070208SN	0,8	0,13	20°	B (2)	2,6					59,35	352	69,17	00701
070208SN	0,8	0,09	25°	B (2)	3,0					59,35	342		
070208TN	0,8	0,11	25°	B (2)	3,0								
070208TN	0,8	0,12	25°	B (2)	3,0			58,44	93400				
070208TN	0,8	0,12	25°	A (1)	3,0	37,14	904						
070208TN	0,8	0,14	30°	B (2)	3,0					59,35	362		
070208SN	0,8	0,16	30°	B (2)	3,0					59,35	372		
070208SN	0,8	0,15	35°	B (2)	2,6							69,17	00801
070208SN	0,8	0,17	35°	B (2)	3,0					59,35	382		
070208FN	0,8			A (1)	3,0	37,14	804						
070208EN	0,8			B (2)	3,0					59,35	312		
11T302TN	0,2	0,09	20°	B (2)	3,9					59,35	323		
11T302SN	0,2	0,13	20°	B (2)	3,4							69,17	01001
11T302SN	0,2	0,09	25°	B (2)	3,9					59,35	353		
11T302TN	0,2	0,11	25°	B (2)	3,9					59,35	343		
11T302TN	0,2	0,12	25°	A (1)	3,9	37,14	906						
11T302TN	0,2	0,12	25°	B (2)	3,0			58,44	900				
11T302TN	0,2	0,14	30°	B (2)	3,9					59,35	363		
11T302SN	0,2	0,17	35°	B (2)	3,9					59,35	383		
11T302EN	0,2			B (2)	3,9					59,35	313		
11T302FN	0,2			B (2)	3,9			58,44	800 1)				
11T302FN	0,2			A (1)	3,9	37,14	806						
11T302FN	0,2			B (2)	3,4							69,17	00901

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1) Machining to 60 HRC

DCGW

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

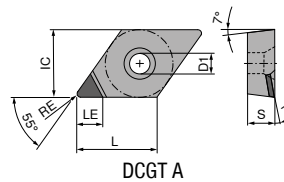


ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	CTBH40U		CTBH40U		CTBH40C		CTBH41C	
						F	CBN DCGW	F	CBN DCGW	F	CBN DCGW	F	CBN DCGW
						71 130 ...	EUR Y0	71 131 ...	EUR Y0	71 163 ...	EUR Y0	71 424 ...	EUR Y0
11T304SN	0,4	0,09	15°	B (2)	3,0								
11T304TN	0,4	0,09	20°	B (2)	3,5								
11T304SN	0,4	0,09	20°	B (2)	3,5					59,35	324		
11T304SN	0,4	0,13	20°	B (2)	3,0					59,35	334		
11T304SN	0,4	0,09	25°	B (2)	3,5					59,35	354	69,17	01301
11T304TN	0,4	0,11	25°	B (2)	3,5					59,35	344		
11T304TN	0,4	0,12	25°	B (2)	3,0								
11T304TN	0,4	0,12	25°	A (1)	3,5	37,14	908	58,44	902				
11T304SN	0,4	0,14	25°	B (2)	3,0							69,17	01401
11T304TN	0,4	0,14	30°	B (2)	3,5					59,35	364	69,17	01501
11T304SN	0,4	0,15	30°	B (2)	3,0								
11T304SN	0,4	0,16	30°	B (2)	3,5					59,35	374		
11T304SN	0,4	0,17	35°	B (2)	3,5					59,35	384		
11T304EN	0,4			B (2)	3,5					59,35	314		
11T304FN	0,4			B (2)	3,5			58,44	802 ¹⁾				
11T304FN	0,4			A (1)	3,5	37,14	808					69,17	01101
11T304FN	0,4			B (2)	3,0							69,17	01701
11T308TN	0,8	0,09	10°	B (2)	2,6								
11T308SN	0,8	0,09	20°	B (2)	3,0					59,35	335		
11T308TN	0,8	0,09	20°	B (2)	3,0					59,35	325		
11T308SN	0,8	0,09	25°	B (2)	3,0					59,35	355		
11T308TN	0,8	0,11	25°	B (2)	3,0					59,35	345		
11T308TN	0,8	0,12	25°	B (2)	3,0			58,44	904				
11T308TN	0,8	0,12	25°	A (1)	3,0	37,14	910						
11T308SN	0,8	0,14	25°	B (2)	2,6							69,17	01801
11T308TN	0,8	0,14	30°	B (2)	3,0					59,35	365	69,17	01901
11T308SN	0,8	0,15	30°	B (2)	2,6								
11T308SN	0,8	0,16	30°	B (2)	3,0					59,35	375		
11T308SN	0,8	0,17	35°	B (2)	3,0					59,35	385		
11T308FN	0,8			B (2)	3,0			58,44	804 ¹⁾				
11T308FN	0,8			B (2)	2,6							69,17	01601
P													
M													
K													
N													
S													
H													
O													

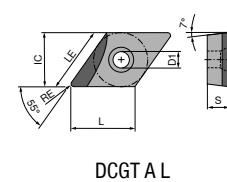
1) Machining to 60 HRC

DCGW / DCGT

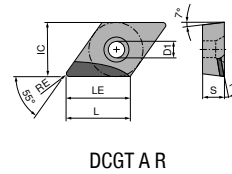
Designation	L mm	S mm	D1 mm	IC mm
DCG. 0702..	7,75	2,38	2,8	6,35
DCG. 11T3..	11,60	3,97	4,4	9,52



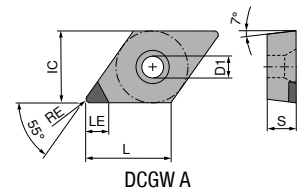
DCGT A



DCGT A L



DCGT A R



DCGW A

DCGW / DCGT

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

ISO	RE mm	TCE (NOI)	LE mm	CTDMD05		CTDMD05		NEW -Q CTDMD05		NEW -Q CTDMD05		CTDPD20		CTDPD20	
				EUR	Y0	EUR	Y0	EUR	Y0	EUR	Y0	EUR	Y0	EUR	Y0
070202FN	0,2	A (1)	2,5	280,30	00200	304,20	050								
070202FN	0,2	A (1)	3,7			304,20	052					52,29	100	52,29	100
070204FN	0,4	A (1)	2,5	280,30	00400	304,20									
070204FR	0,4	A (1)	2,5							469,20	50001				
070204FN	0,4	A (1)	3,4									52,29	102	52,29	102
070208FN	0,8	A (1)	2,5	280,30	00600	304,20	054					52,29	104	52,29	104
070208FN	0,8	A (1)	3,0												
11T302FN	0,2	A (1)	2,5			304,20	056								
11T302FN	0,2	A (1)	3,0	280,30	056										
11T302FN	0,2	A (1)	4,7									56,05	106	56,05	106
11T304FN	0,4	A (1)	2,5			304,20	058								
11T304FL	0,4	A (1)	3,0					444,80	50001						
11T304FN	0,4	A (1)	3,0	280,30	058										
11T304FN	0,4	A (1)	4,3									56,05	108	56,05	108
11T308FN	0,8	A (1)	2,5			304,20	060								
11T308FN	0,8	A (1)	4,0									56,05	110	56,05	110
11T312FN	1,2	A (1)	3,5									56,05	11200	56,05	11200
11T312FN	1,2	A (1)	3,6												
P															
M															
K															
N															
S															
H															
O															

DCGW / DCGT

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

				NEW		NEW		NEW		NEW		NEW		NEW	
				CTDPS30		CTDPS30		CTDPS30		CTDPS30		-CB1 CTDPU20		-CB2 CTDPU20	
				F		F		F		F		F		M	
				DIAMOND DCGW		DIAMOND DCGT		DIAMOND DCGT		DIAMOND DCGT		DIAMOND DCGT		DIAMOND DCGT	
				71 177 ...		71 173 ...		71 173 ...		71 173 ...		71 174 ...		71 175 ...	
ISO	RE mm	TCE (NOI)	LE mm	EUR Y0		EUR Y0		EUR Y0		EUR Y0		EUR Y0		EUR Y0	
070201FN	0,1	A (1)	3,8	59,49	20001			60,87	20001						
070202FN	0,2	A (1)	3,7	59,49	20101			60,87	20101			65,03	30001		
070204FN	0,4	A (1)	3,4	59,49	20201							65,03	30101	65,03	30001
070204FL	0,4	A (1)	5,5			85,76	20201								
070208FN	0,8	A (1)	3,0	59,49	20301										
11T301FN	0,1	A (1)	4,8	62,26	20401			63,63	20301						
11T302FN	0,2	A (1)	4,7	62,26	20501			63,63	20401						
11T304FN	0,4	A (1)	4,3	62,26	20601							67,79	30201	67,79	30101
11T304FL	0,4	A (1)	7,5			94,06	20501								
11T308FN	0,8	A (1)	4,0	62,26	20701							67,79	30301		
11T308FL	0,8	A (1)	7,0			94,06	20601								
11T308FR	0,8	A (1)	7,0					94,06	20701						
11T312FN	1,2	A (1)	3,6	62,26	20801										
11T312FL	1,2	A (1)	6,5			94,06	20801								
11T312FR	1,2	A (1)	6,5					94,06	20901						
P															
M															
K															
N															
S															
H															
O															

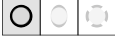
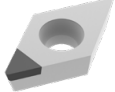
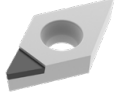
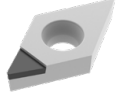
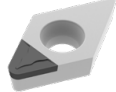
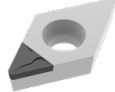
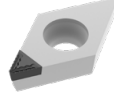
DCGT / DCGW

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

				CTDPD20	CTDPD20	-Q CTDPD20	-Q CTDPD20	-CB1 CTDPD20	-Q CTDPS30
				F	F	F	F	F	F
				DIAMOND	DIAMOND	DIAMOND	DIAMOND	DIAMOND	DIAMOND
				DCGT	DCGT	DCGT	DCGT	DCGT	DCGW
				71 136 ...	71 135 ...	71 144 ...	71 145 ...	71 310 ...	71 138 ...
ISO	RE mm	TCE (NOI)	LE mm	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0
070201FN	0,1	A (1)	3,8					64,60	10100
070202FN	0,2	A (1)	3,7					64,60	102
070204FL	0,4	A (1)	3,0				65,05		
070204FR	0,4	A (1)	3,0			65,05	104		
070204FN	0,4	A (1)	3,4					64,60	104
070204FRR	0,4	A (1)	5,5		72,68				
070204FLL	0,4	A (1)	5,5	72,68					
070208FN	0,8	A (1)	3,0					64,60	108
070208FRR	0,8	A (1)	5,0		72,68				
070208FLL	0,8	A (1)	5,0	72,68					
11T301FN	0,1	A (1)	4,8					68,70	11100
11T302FR	0,2	A (1)	4,0						68,70
11T302FN	0,2	A (1)	4,7					68,70	112
11T304FL	0,4	A (1)	4,0				68,70		
11T304FR	0,4	A (1)	4,0			68,70	114		68,70
11T304FN	0,4	A (1)	4,3					68,70	114
11T304FRR	0,4	A (1)	7,5		78,50				
11T304FLL	0,4	A (1)	7,5	78,50					
11T308FN	0,8	A (1)	4,0					68,70	118
11T308FRR	0,8	A (1)	7,0		78,50				
11T308FLL	0,8	A (1)	7,0	78,50					
P									
M									
K									
N				•	•	•	•	•	•
S									
H									
O				•	•	•	•	•	•

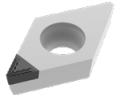
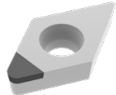
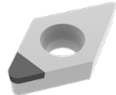
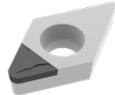
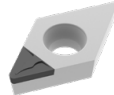
DCGW / DCGT

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

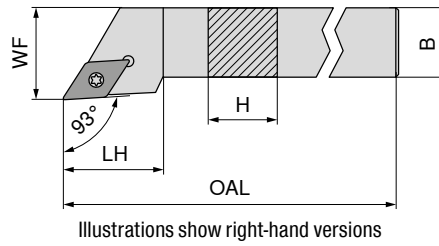
				-Q CTDPS30		-Q CTDPS30		-Q CTDPS30		-CB1 CTDPS30		-CB2 CTDPS30		-CB3 CTDPU20	
															
															
				F DIAMOND DCGW		F DIAMOND DCGT		F DIAMOND DCGT		F DIAMOND DCGT		M DIAMOND DCGT		R DIAMOND DCGT	
				71 139 ...		71 144 ...		71 145 ...		71 310 ...		71 311 ...		71 312 ...	
ISO	RE mm	TCE (NOI)	LE mm	EUR Y0		EUR Y0		EUR Y0		EUR Y0		EUR Y0		EUR Y0	
070201FL	0,1	A (1)	3,0					65,05	151						
070201FR	0,1	A (1)	3,0			65,05	15000								
070201FN	0,1	A (1)	3,8							64,60	20100				
070202FL	0,2	A (1)	3,0					65,05	152						
070202FR	0,2	A (1)	3,0			65,05	152								
070202FN	0,2	A (1)	3,7							64,60	202	64,60	202		
070204FN	0,4	A (1)	3,4							64,60	204	64,60	204	64,60	204
070208FN	0,8	A (1)	3,0									71,21	208		
11T301FL	0,1	A (1)	4,0					68,70	161						
11T301FR	0,1	A (1)	4,0			68,70	161								
11T301FN	0,1	A (1)	4,8							68,70	21100	68,70	21100		
11T302FL	0,2	A (1)	4,0					68,70	162						
11T302FR	0,2	A (1)	4,0			68,70	162								
11T302FN	0,2	A (1)	4,7							68,70	212	68,70	212		
11T304FL	0,4	A (1)	4,0	68,70	164										
11T304FN	0,4	A (1)	4,3							68,70	214	68,70	214	68,70	214
11T308FN	0,8	A (1)	4,0							76,43	218	76,43	218	76,43	218
P															
M															
K															
N															
S															
H															
O															

DCGT / DCGW

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

				-CB3 CTDPU20		NEW CTDPU20		NEW CTDCD10		-CB1 CTDCD10		-CB2 CTDCD10	
													
													
				R DIAMOND DCGT		F DIAMOND DCGW		F DIAMOND DCGW		F DIAMOND DCGT		M DIAMOND DCGT	
				71 312 ...		71 177 ...		71 177 ...		71 310 ...		71 311 ...	
ISO	RE mm	TCE (NOI)	LE mm	EUR Y0		EUR Y0		EUR Y0		EUR Y0		EUR Y0	
070202FN	0,2	A (1)	2,6					62,26	40001	83,17	302	83,17	30200
070204FN	0,4	A (1)	2,3					63,63	40101	83,17	304	83,17	304
070204FN	0,4	A (1)	3,4	64,60	204	59,49	30001						
070208FN	0,8	A (1)	2,0			59,49	30101	67,79	40201			89,89	308
070208FN	0,8	A (1)	3,0										
11T302FN	0,2	A (1)	2,6					65,03	40301	84,53	31200	84,53	31200
11T304FN	0,4	A (1)	2,3					66,39	40401	84,53	314	84,53	314
11T304FN	0,4	A (1)	4,3	68,70	214	60,87	30201						
11T308FN	0,8	A (1)	2,0					70,56	40501	91,14	318	91,14	318
11T308FN	0,8	A (1)	4,0	76,43	218	60,87	30301						
P													
M													
K													
N													
S													
H													
O													

MaxiLock-S – SDJC 93° – Toolholder with screw clamping



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 685 ...		Right-hand 70 684 ...	
								EUR 2A/24		EUR 2A/24	
SDJC R/L 0808 D07	8	8	60	13,0	10	1,2	DC.. 0702	63,97	008	63,97	008
SDJC R/L 1010 E07	10	10	70	13,0	12	1,2	DC.. 0702	67,82	010	67,82	010
SDJC R/L 1212 F07	12	12	80	14,5	16	1,2	DC.. 0702	67,82	012	67,82	012
SDJC R/L 1616 H11	16	16	100	20,0	20	3,2	DC.. 11T3	84,00	016	84,00	016
SDJC R/L 2020 K11	20	20	125	20,5	25	3,2	DC.. 11T3	89,29	020	89,29	020
SDJC R/L 2525 M11	25	25	150	21,5	32	3,2	DC.. 11T3	92,37	025	92,37	025
SDJC R/L 3225 P11	32	25	170	21,5	32	3,2	DC.. 11T3	96,01	032	96,01	032

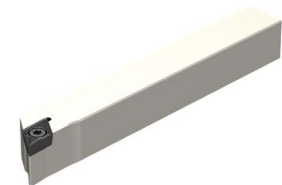
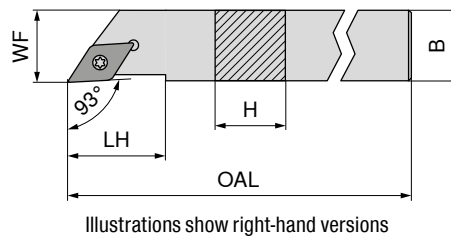
Spare parts
Insert

DC.. 0702	EUR Y7	8,03	110	EUR 2A/28	8,69	398	EUR 2A	2,43	112	EUR 2A/28	7,86	106	EUR 2A/28	4,87	171
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	Key D	80 950 ...		Combination Key	70 950 ...		Clamping screw	70 950 ...		Solid Carbide Seat D	70 950 ...		Threaded sleeve	70 950 ...
		EUR Y7			EUR 2A/28			EUR 2A		EUR 2A/28			EUR 2A/28	
		8,03			8,69			2,43		7,86			4,87	

MaxiLock-S – SDJC 93° – Toolholder with screw clamping

▲ for sliding head lathes



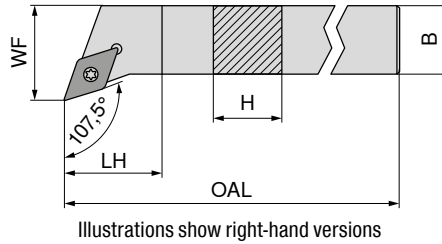
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 685 ...		Right-hand 70 684 ...	
								EUR X0		EUR X0	
SDJC R/L 0808 H07	8	8	100	13,0	8	1,2	DC.. 0702	80,78	108	80,78	108
SDJC R/L 1010 H07	10	10	100	13,0	10	1,2	DC.. 0702	80,78	110	80,78	110
SDJC R/L 1212 H07	12	12	100	14,5	12	1,2	DC.. 0702	90,72	112	90,72	112
SDJC R/L 1616 K07	16	16	125	33,0	16	1,2	DC.. 0702	100,30	116	100,30	116
SDJC R/L 1212 H11	12	12	100	22,0	12	3,2	DC.. 11T3	90,72	212	90,72	212
SDJC R/L 1616 K11	16	16	125	33,0	16	3,2	DC.. 11T3	100,30	216	100,30	216

Spare parts
Insert

DC.. 0702	T08	EUR Y7	8,03	110	EUR 2A	4,94	002
DC.. 11T3	T15	EUR Y7	9,56	113	EUR 2A	4,94	006

	Key D	80 950 ...		Clamping screw	72 950 ...
		EUR Y7			EUR 2A
		8,03			4,94

MaxiLock-S – SDHC 107.5° – Toolholder with screw clamping



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 689 ...		Right-hand 70 688 ...	
								EUR 2A/24		EUR 2A/24	
SDHC R/L 1010 E07	10	10	70	5,5	12	1,2	DC.. 0702	67,82	010	67,82	010
SDHC R/L 1212 F07	12	12	80	12,0	16	1,2	DC.. 0702	67,82	012	67,82	012
SDHC R/L 1616 H11	16	16	100	10,4	20	3,2	DC.. 11T3	84,00	016	84,00	016
SDHC R/L 2020 K11	20	20	125	14,0	32	3,2	DC.. 11T3	89,29	020	89,29	020
SDHC R/L 2525 M11	25	25	150	20,0	32	3,2	DC.. 11T3	92,37	025	92,37	025

Spare parts for Article no.

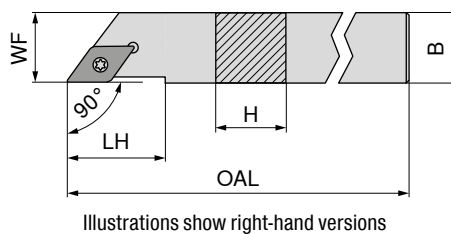
	EUR Y7		EUR 2A/28		EUR 2A		EUR 2A/28		EUR 2A/28	
70 689 010 / 70 688 010	8,03	110			2,43	112				
70 689 012 / 70 688 012	8,03	110			2,43	112				
70 689 016 / 70 688 016			8,69	398	3,30	113	7,86	106	4,87	171
70 689 020 / 70 688 020			8,69	398	3,30	113	7,86	106	4,87	171
70 689 025 / 70 688 025			8,69	398	3,30	113	7,86	106	4,87	171



80 950 ...	EUR Y7		70 950 ...	EUR 2A/28		70 950 ...	EUR 2A		70 950 ...	EUR 2A/28		70 950 ...	EUR 2A/28	

MaxiLock-S – SDAC 90° – Toolholder with screw clamping

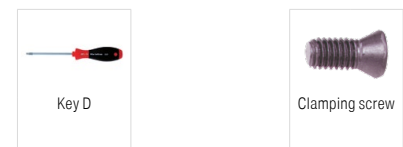
▲ for sliding head lathes



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 789 ...		Right-hand 70 788 ...	
								EUR 2A/24		EUR 2A/24	
SDAC R/L 0808 K07	8	8	125	14	8	1,2	DC.. 0702	67,82	008	67,82	008
SDAC R/L 1010 M07	10	10	150	14	10	1,2	DC.. 0702	67,82	010	67,82	010
SDAC R/L 1212 M07	12	12	150	14	12	1,2	DC.. 0702	75,86	012	75,86	012
SDAC R/L 1212 M11	12	12	150	21	12	3,2	DC.. 11T3	75,86	11200	75,86	11200
SDAC R/L 1414 M11	14	14	150	21	14	3,2	DC.. 11T3	75,86	014	75,86	014

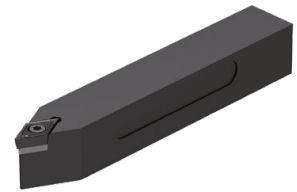
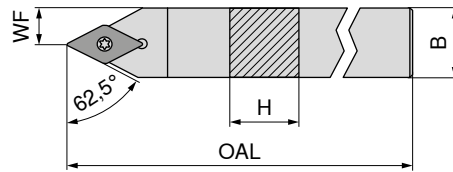
Spare parts for Article no.

	EUR Y7		EUR 2A	
70 788 008 / 70 789 008	8,03	110	2,43	112
70 788 010 / 70 789 010	8,03	110	2,43	112
70 788 012 / 70 789 012	8,03	110	2,43	112
70 788 11200 / 70 789 11200	9,56	113	3,30	113
70 788 014 / 70 789 014	9,56	113	3,30	113



80 950 ...	EUR Y7		70 950 ...	EUR 2A	

MaxiLock-S – SDNC 62.5° – Toolholder with screw clamping



Neutral

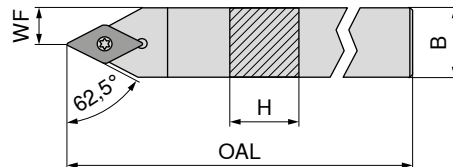
70 680 ...

ISO designation	H mm	B mm	OAL mm	WF mm	torque moment Nm	Insert	EUR 2A/24	
SDNC N 0808 D07	8	8	60	4,0	1,2	DC.. 0702	63,97	008
SDNC N 1010 E07	10	10	70	5,0	1,2	DC.. 0702	67,82	010
SDNC N 1212 F07	12	12	80	6,0	1,2	DC.. 0702	67,82	012
SDNC N 1616 H11	16	16	100	8,0	3,2	DC.. 11T3	84,00	016
SDNC N 2020 K11	20	20	125	10,0	3,2	DC.. 11T3	89,29	020
SDNC N 2525 M11	25	25	150	12,5	3,2	DC.. 11T3	92,37	025

Spare parts
for Article no.

	Key D	Combination Key	Clamping screw	Solid Carbide Seat D	Threaded sleeve
	80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
	EUR Y7	EUR 2A/28	EUR 2A	EUR 2A/28	EUR 2A/28
70 680 008	8,03 110		2,43 112		
70 680 010	8,03 110		2,43 112		
70 680 012	8,03 110		2,43 112		
70 680 016		8,69 398	3,30 113	7,86 106	4,87 171
70 680 020		8,69 398	3,30 113	7,86 106	4,87 171
70 680 025		8,69 398	3,30 113	7,86 106	4,87 171

MaxiLock-S – SDNC 62.5° – Toolholder with screw clamping



Neutral

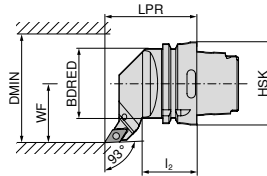
70 784 ...

ISO designation	H mm	B mm	OAL mm	WF mm	torque moment Nm	Insert	EUR 2A/24	
SDNC N 0808 K07	8	8	125	4	1,2	DC.. 0702	63,97	008
SDNC N 1010 M07	10	10	150	5	1,2	DC.. 0702	67,82	010
SDNC N 1212 M07	12	12	150	6	1,2	DC.. 0702	75,86	012
SDNC N 1212 M11	12	12	150	6	3,2	DC.. 11T3	75,86	11200
SDNC N 1414 M11	14	14	150	7	3,2	DC.. 11T3	75,86	014

Spare parts
for Article no.

	Key D	Clamping screw
	80 950 ...	70 950 ...
	EUR Y7	EUR 2A
70 784 008	T08 8,03 110	M2,5x6 2,43 112
70 784 010	T08 8,03 110	M2,5x6 2,43 112
70 784 012	T08 8,03 110	M2,5x6 2,43 112
70 784 11200	T15 9,56 113	M3,5x11 3,30 113
70 784 014	T15 9,56 113	M3,5x11 3,30 113

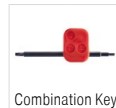
MaxiLock-S – SDJC 93° – Toolholder with screw clamping



Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	I ₂ mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									74 544 ...		74 543 ...	
HSK T63 SDJC R/L 11	HSK-T 63	70	42	53	45	100	3.2	DC.. 11T3	EUR 2D/80 233,60	511	EUR 2D/80 233,60	511

Spare parts for Article no.	74 543 511 / 74 544 511	T15/SW	EUR 2A/28 8,69	398	M3,5x11	EUR 2A/28 3,30	113	EUR 2A/28 7,86	106	M3,5	EUR 2A/28 4,87	171



Combination Key



Clamping screw

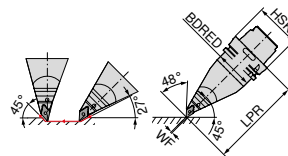


Solid Carbide
Seat D



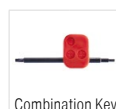
Threaded sleeve

MaxiLock-S – SDMC 48° – Toolholder with screw clamping

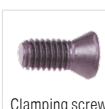


ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert	Left-hand	
							74 546 ...	
HSK T63 SDMC L 11	HSK-T 63	130	53	0	3.2	DC.. 11T3	EUR 2D/80 319,00	511

Spare parts for Article no.	74 546 511	T15/SW	EUR 2A/28 8,69	398	M3,5x11	EUR 2A/28 3,30	113	EUR 2A/28 7,86	106	M3,5	EUR 2A/28 4,87	171



Combination Key



Clamping screw

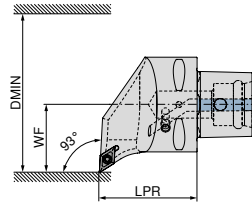


Solid Carbide
Seat D

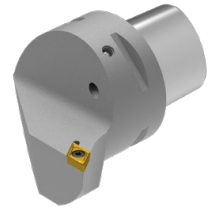


Threaded sleeve

MaxiLock-S – SDUC 93° – Toolholder with screw clamping



Illustrations show right-hand versions



ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	NEW Left-hand 84 659 ...		NEW Right-hand 84 658 ...	
							EUR Y8		EUR Y8	
PSC40 SDUC R/L 50050-11	PSC 40	50	27	50	3	DC.. 11T3	205,40	01195	205,40	01195
PSC50 SDUC R/L 65060-11	PSC 50	60	35	65	3	DC.. 11T3	235,40	01194	235,40	01194
PSC63 SDUC R/L 80065-11	PSC 63	65	45	80	3	DC.. 11T3	261,90	01193	261,90	01193

Adapter

PSC 40

PSC 50

PSC 63



Clamping screw

84 950 ...

EUR
Y8

3,20 27600

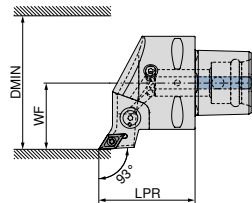
3,20 27600

3,20 27600

MaxiLock-S – SDJC 93° – Toolholder with screw clamping

Scope of supply:

without high-performance coolant set



Illustrations show right-hand versions



ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Direct cooling compatible	NEW Left-hand 84 663 ...		NEW Right-hand 84 662 ...	
								EUR Y8		EUR Y8	
PSC40 SDJC R/L 50050-11	PSC 40	50	27	50	3	DC.. 11T3	DC	205,40	01195	205,40	01195
PSC50 SDJC R/L 65060-11	PSC 50	60	35	65	3	DC.. 11T3	DC	235,40	01194	235,40	01194
PSC63 SDJC R/L 80065-11	PSC 63	65	45	80	3	DC.. 11T3	DC	261,90	01193	261,90	01193



The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → Page 42.



Clamping screw

84 950 ...

EUR
Y8

3,20 27600

3,20 27600

3,20 27600

Adapter

PSC 40

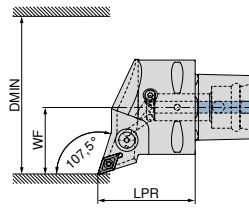
PSC 50

PSC 63

MaxiLock-S – SDHC 107.5° – Toolholder with screw clamping

Scope of supply:

without high-performance coolant set



Illustrations show right-hand versions



ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Direct cooling compatible	NEW Left-hand 84 667 ...		NEW Right-hand 84 666 ...	
								EUR Y8		EUR Y8	
PSC40 SDHC R/L 50050-11	PSC 40	50	27	50	3	DC.. 11T3	DC	205,40	01195	205,40	01195
PSC50 SDHC R/L 65060-11	PSC 50	60	35	65	3	DC.. 11T3	DC	235,40	01194	235,40	01194
PSC63 SDHC R/L 80065-11	PSC 63	65	45	80	3	DC.. 11T3	DC	261,90	01193	261,90	01193



The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → Page 42.



Clamping screw

84 950 ...

EUR
Y8

3,20 27600
3,20 27600
3,20 27600

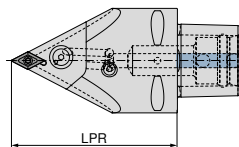
Adapter

PSC 40
PSC 50
PSC 63

MaxiLock-S – SDNC 62.5° – Toolholder with screw clamping

Scope of supply:

without high-performance coolant set



NEW
Neutral

84 677 ...

EUR
Y8

261,90 01193
261,90 11193

ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Direct cooling compatible	
PSC63 SDNC N 0100-11	PSC 63	100	3	DC.. 11T3	DC	261,90 01193
PSC63 SDNC N 0130-11	PSC 63	130	3	DC.. 11T3	DC	261,90 11193



The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → Page 42.



Clamping Screw



Clamping claw



Ring-shaped
nozzle



Clamping screw



Carbide seat

84 950 ...

EUR
Y8

20,47 28300

84 950 ...

EUR
Y8

24,25 28600

84 950 ...

EUR
Y8

7,81 28400

84 950 ...

EUR
Y8

4,83 27500

84 950 ...

EUR
Y8

24,61 27900

Adapter

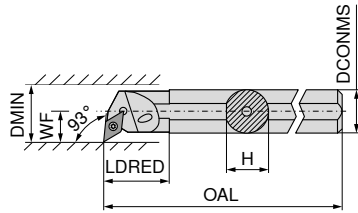
PSC 63

M6X28 SW4

MaxiLock-S – SDUC 93° – Boring bar with screw clamping

▲ A... = with thro' coolant

▲ S... = without thro' coolant



Illustrations show right-hand versions



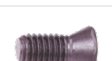
ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									70 737 ...		70 736 ...	
									EUR 2A/24		EUR 2A/24	
S12Q SDUC R/L 07	12	11,0	180		9	17	1,2	DC.. 0702	101,40	012	101,40	012
A12K SDUC R/L 07	12	11,5	125	22	9	16	1,2	DC.. 0702	101,40	212	101,40	212
A16M SDUC R/L 07	16	15,0	150	29	11	20	1,2	DC.. 0702	103,60	216	103,60	216
S16R SDUC R/L 07	16	15,0	200		11	21	1,2	DC.. 0702	103,60	016	103,60	016
A20Q SDUC R/L 07	20	18,5	180	32	13	25	1,2	DC.. 0702	129,20	220	129,20	220
S20S SDUC R 07	20	18,0	250		13	25	1,2	DC.. 0702			129,20	020
S20S SDUC R 11	20	18,0	250		13	25	3,2	DC.. 11T3			129,20	120
A20Q SDUC R/L 11	20	18,5	180	32	13	25	3,2	DC.. 11T3	129,20	320	129,20	320
A25R SDUC R/L 11	25	23,0	200	36	17	32	3,2	DC.. 11T3	148,50	325	148,50	325
S25T SDUC R/L 11	25	23,0	300		17	32	3,2	DC.. 11T3	148,50	125	148,50	125
A32S SDUC R/L 11	32	30,0	250	50	22	40	3,2	DC.. 11T3	204,10	332	204,10	332
S32U SDUC R 11	32	30,0	350		22	40	3,2	DC.. 11T3			204,10	132
A40T SDUC R/L 11	40	38,0	300	60	27	50	3,2	DC.. 11T3	245,10	340	245,10	340



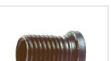
Key D



Combination Key



Clamping screw

Solid Carbide
Seat D

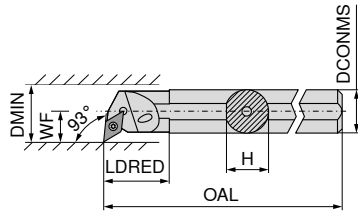
Threaded sleeve

Spare parts
for Article no.

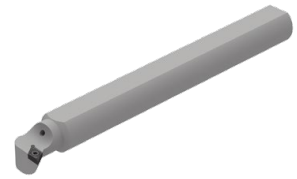
	80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
	EUR Y7	EUR 2A/28	EUR 2A	EUR 2A/28	EUR 2A/28
70 736 012 / 70 737 012	8,03 110		2,43 112		
70 736 212 / 70 737 212	8,03 110		2,43 112		
70 736 216 / 70 737 216	8,03 110		2,43 112		
70 736 016 / 70 737 016	8,03 110		2,43 112		
70 736 220 / 70 737 220	8,03 110		2,43 112		
70 736 020	8,03 110		2,43 112		
70 736 120	9,56 113		3,30 110		
70 736 320 / 70 737 320	9,56 113		3,30 110		
70 736 325 / 70 737 325	9,56 113		3,30 113		
70 736 125 / 70 737 125		8,69 398	3,30 113	7,86 106	4,87 171
70 736 332 / 70 737 332		8,69 398	3,30 113	7,86 106	4,87 171
70 736 132		8,69 398	3,30 113	7,86 106	4,87 171
70 736 340 / 70 737 340		8,69 398	3,30 113	7,86 106	4,87 171

MaxiLock-S – SDUC 93° – Boring bar with screw clamping

▲ with carbide core



Illustrations show right-hand versions

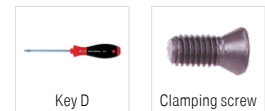


ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert
E-A10H SDUC R/L 07	10	9	100	28	8	13	1,2	DC.. 0702
E-A12K SDUC R/L 07	12	11	125	18	9	18	1,2	DC.. 0702
E-A16M SDUC R/L 07	16	15	150	30	11	22	1,2	DC.. 0702
E-A20Q SDUC R/L 07	20	18	180	38	13	26	1,2	DC.. 0702
E-A20Q SDUC R/L 11	20	18	180	38	13	26	3,2	DC.. 11T3
E-A25R SDUC R/L 11	25	23	200	38	17	34	3,2	DC.. 11T3
E-A32S SDUC R/L 11	32	30	250	43	22	39	3,2	DC.. 11T3

Left-hand		Right-hand	
70 739 ...		70 738 ...	
EUR		EUR	
2A		2A	
188,40	210	188,40	210
188,40	212	188,40	212
299,50	216	299,50	216
375,50	220	375,50	220
397,50	320	397,50	320
572,60	225	572,60	225
840,10	232	840,10	232

Spare parts for Article no.

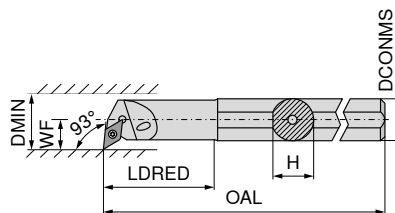
70 738 210 / 70 739 210
70 738 212 / 70 739 212
70 738 216 / 70 739 216
70 738 220 / 70 739 220
70 738 320 / 70 739 320
70 738 225 / 70 739 225
70 738 232 / 70 739 232



80 950 ...		70 950 ...	
EUR		EUR	
Y7		2A	
8,03	110	2,43	112
8,03	110	2,43	112
8,03	110	2,43	112
8,03	110	2,43	112
9,56	113	3,30	449
9,56	113	3,30	449
9,56	113	3,30	449

MaxiLock-S – SDUC 93° – Boring bar with screw clamping

▲ with carbide core



Illustrations show right-hand versions

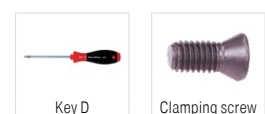


ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert
E-A0810H SDUC R/L 07	10	9	100	22	7	12,5	1,2	DC.. 0702
E-A1012K SDUC R/L 07	12	11	125	28	9	15,5	1,2	DC.. 0702
E-A1216M SDUC R/L 07	16	15	150	36	11	19,5	1,2	DC.. 0702

Left-hand		Right-hand	
70 739 ...		70 738 ...	
EUR		EUR	
2A		2A	
234,60	410	234,60	410
234,60	412	234,60	412
234,60	416	234,60	416

Spare parts for Article no.

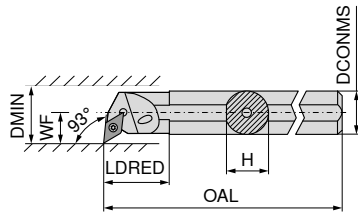
70 738 410 / 70 739 410
70 738 412 / 70 739 412
70 738 416 / 70 739 416



80 950 ...		70 950 ...	
EUR		EUR	
Y7		2A	
8,03	110	2,43	112
8,03	110	2,43	112
8,03	110	2,43	112

MaxiLock-S – SDUC 93° – Boring bar with screw clamping

▲ Type: Solid carbide



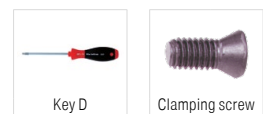
Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 739 ...		Right-hand 70 738 ...	
									EUR 2A/24		EUR 2A/24	
E12Q SDUC R/L 07	12	11,5	180	26	9	16	1,2	DC.. 0702	349,90	012	349,90	012
E16R SDUC R/L 07	16	15,0	200	34	11	20	1,2	DC.. 0702	457,20	016	457,20	016
E20S SDUC R/L 11	20	18,5	250	38	13	25	3,2	DC.. 11T3	571,10	120	571,10	120
E25T SDUC R/L 11	25	23,0	300	43	17	32	3,2	DC.. 11T3	1.007,00	125	1.007,00	125

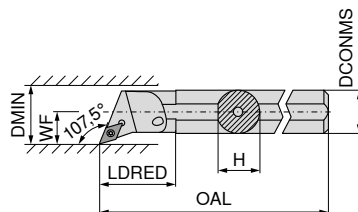
Spare parts
for Article no.

70 739 012 / 70 738 012
70 739 016 / 70 738 016
70 739 120 / 70 738 120
70 739 125 / 70 738 125



80 950 ...		70 950 ...	
EUR Y7		EUR 2A	
8,03	110	2,43	112
8,03	110	2,43	112
9,56	113	3,30	304
9,56	113	3,30	113

MaxiLock-S – SDQC 107.5° – Boring bar with screw clamping



Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 741 ...		Right-hand 70 740 ...	
									EUR 2A		EUR 2A	
A10H SDQC R/L 07	10	9,0	100	22	7	12,5	1,2	DC.. 0702	99,47	210	99,47	210
A12K SDQC R/L 07	12	11,5	125	22	9	16,0	1,2	DC.. 0702	101,40	212	101,40	212
A16M SDQC R/L 07	16	15,0	150	29	11	20,0	1,2	DC.. 0702	103,60	216	103,60	216
A20Q SDQC R/L 07	20	18,5	180	32	13	25,0	1,2	DC.. 0702	129,20	220	129,20	220
A25R SDQC R/L 11	25	23,0	200	36	17	32,0	3,2	DC.. 11T3	148,50	225	148,50	225
A32S SDQC R/L 11	32	30,0	250	50	22	40,0	3,2	DC.. 11T3	204,10	232	204,10	232
A40T SDQC R/L 11	40	38,0	300	60	27	50,0	3,2	DC.. 11T3	245,10	240	245,10	240

Spare parts
for Article no.

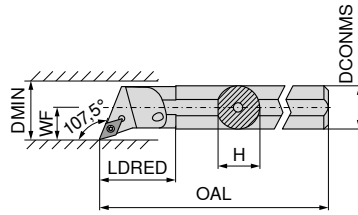
70 740 210 / 70 741 210
70 740 212 / 70 741 212
70 740 216 / 70 741 216
70 740 220 / 70 741 220
70 740 225 / 70 741 225
70 740 232 / 70 741 232
70 740 240 / 70 741 240



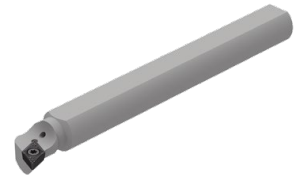
80 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	
EUR Y7		EUR 2A/28		EUR 2A		EUR 2A/28		EUR 2A/28	
8,03	110			2,43	112				
8,03	110			2,43	112				
8,03	110			2,43	112				
8,03	110			2,43	112				
		8,69	398	3,30	113	7,86	106	4,87	171
		8,69	398	3,30	113	7,86	106	4,87	171
		8,69	398	3,30	113	7,86	106	4,87	171

MaxiLock-S – SDQC 107.5° – Boring bar with screw clamping

▲ with carbide core



Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 751 ...		Right-hand 70 750 ...	
									EUR 2A		EUR 2A	
E-A12K SDQC R/L 07	12	11	125	24	9	18	1,2	DC.. 0702	188,40	012	188,40	012
E-A16M SDQC R/L 07	16	15	150	30	11	22	1,2	DC.. 0702	321,50	016	321,50	016
E-A20Q SDQC R/L 07	20	18	180	38	13	26	1,2	DC.. 0702	375,50	020	375,50	020
E-A20Q SDQC R/L 11	20	18	180	38	13	26	3,2	DC.. 11T3	397,50	120	397,50	120
E-A25R SDQC R/L 11	25	23	200	38	17	34	3,2	DC.. 11T3	635,40	025	635,40	025
E-A32S SDQC R/L 11	32	30	250	43	22	39	3,2	DC.. 11T3	840,10	032	840,10	032

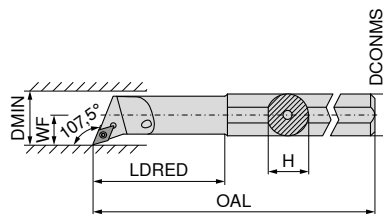
Spare parts for Article no.

70 750 012 / 70 751 012
70 750 016 / 70 751 016
70 750 020 / 70 751 020
70 750 120 / 70 751 120
70 750 025 / 70 751 025
70 750 032 / 70 751 032

Key D		Clamping screw	
80 950 ...		70 950 ...	
EUR Y7		EUR 2A	
8,03	110	2,43	112
8,03	110	2,43	112
8,03	110	2,43	112
9,56	113	3,30	449
9,56	113	3,30	449
9,56	113	3,30	449

MaxiLock-S – SDQC 107.5° – Boring bar with screw clamping

▲ with carbide core



Illustrations show right-hand versions



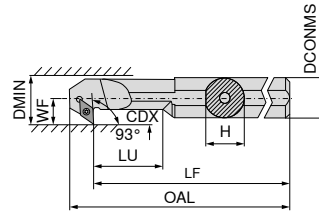
ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 751 ...		Right-hand 70 750 ...	
									EUR 2A		EUR 2A	
E-A0810H SDQC R/L 07	10	9	100	22	7	12,5	1,2	DC.. 0702	234,60	210	234,60	210
E-A1012K SDQC R/L 07	12	11	125	28	9	15,5	1,2	DC.. 0702	234,60	212	234,60	212
E-A1216M SDQC R/L 07	16	15	150	36	11	19,5	1,2	DC.. 0702	234,60	216	234,60	216

Spare parts for Article no.

70 750 210 / 70 751 210
70 750 212 / 70 751 212
70 750 216 / 70 751 216

Key D		Clamping screw	
80 950 ...		70 950 ...	
EUR Y7		EUR 2A	
8,03	110	2,43	112
8,03	110	2,43	112
8,03	110	2,43	112

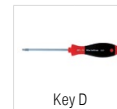
MaxiLock-S – SDXC 93° – Boring bar with screw clamping



Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	LF mm	OAL mm	LU mm	WF mm	DMIN mm	CDX mm	torque moment Nm	Insert	Left-hand 70 733 ...		Right-hand 70 732 ...	
											EUR 2A/24		EUR 2A/24	
A12K SDXC R/L 07	12	11,5	125	137,0	24	9	16	4,5	1,2	DC.. 0702	101,40	212	101,40	212
A16M SDXC R/L 07	16	15,0	150	162,0	36	11	20	4,5	1,2	DC.. 0702	103,60	216	103,60	216
A20Q SDXC R/L 11	20	18,5	180	196,5	40	13	25	6,5	3,2	DC.. 11T3	129,20	220	129,20	220
A25R SDXC R/L 11	25	23,0	200	216,8	50	17	32	9,5	3,2	DC.. 11T3	148,50	225	148,50	225



Key D



Clamping screw

Spare parts
for Article no.

70 733 212 / 70 732 212
70 733 216 / 70 732 216
70 733 220 / 70 732 220
70 733 225 / 70 732 225

80 950 ...

EUR
Y7

8,03

8,03

9,56

9,56

110

110

113

113

70 950 ...

EUR
2A

2,43

2,43

3,30

3,30

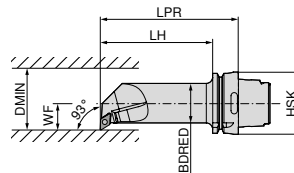
112

112

304

304

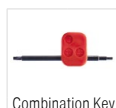
MaxiLock-S – SDUC 93° – Boring bar with screw clamping



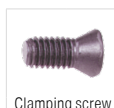
Illustrations show right-hand versions



ISO designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 566 ...		Right-hand 74 565 ...	
									EUR 2D/80		EUR 2D/80	
HSK T63 40L SDUC R/L 11	HSK-T 63	140	114	40	27	50	3.2	DC.. 11T3	321,40	511	321,40	511



Combination Key



Clamping screw

Solid Carbide
Seat D

Threaded sleeve

Spare parts
for Article no.

74 565 511 / 74 566 511

70 950 ...

EUR
2A/28

8,69

398

70 950 ...

EUR
2A/28

3,30

113

70 950 ...

EUR
2A/28

7,86

106

70 950 ...

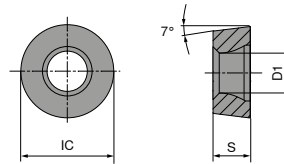
EUR
2A/28

4,87

171

RCMT / RCGT

Designation	S mm	D1 mm	IC mm
RCGT 0602..	2,38	2,8	6
RCGT 0803..	3,18	3,4	8
RC.T 1003..	3,18	4,0	10
RCMT 1204..	4,76	4,9	12
RCMT 1606..	6,35	5,3	16
RCMT 2006..	6,35	6,5	20
RCMT 2507..	7,94	7,2	25



RCMT / RCGT

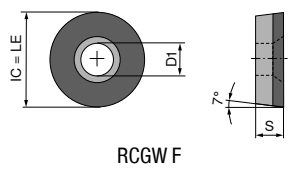
		-SMF CTCK110		-SM CTCP115		-SM CTCP125		-SM CTCP125		-SM CTCP135		-SM CTCP135	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		F RCMT		M RCMT		M RCGT		M RCMT		M RCGT		M RCMT	
		70 188 ...		76 264 ...		76 262 ...		76 264 ...		76 262 ...		76 264 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
0602M0EN	3,0					8,47 502				8,47 702			
0803M0EN	4,0					9,44 512				9,44 712			
1003M0SN	5,0							8,17 514				8,17 714	
1204M0SN	6,0			9,68 328				9,68 526				9,68 726	
1606M0EN	8,0	19,04 038											
1606M0SN	8,0			19,04 340				19,04 538				19,04 738	
2006M0SN	10,0					26,20 550						26,20 750	
2507M0SN	12,5			42,19 36200				42,19 562				42,19 762	
P		○		●		●		●		●		●	
M										○		○	
K		●		○		○		○					
N													
S													
H													
O													

RCGT

		-27 H10T		-27 CWN15		NEW -27 CTPX715	
							
							
		M RCGT		M RCGT		M RCGT	
		70 266 ...		70 266 ...		70 266 ...	
ISO	RE mm	EUR 1A/90		EUR 1A		EUR 1A/90	
0602M0FN	3	6,33	600	8,43	300		
0803M0FN	4	7,07	602	8,43	302	8,26	80200
1003M0FN	5	7,07	604			8,26	80400
P							●
M					○		●
K			○				○
N			●		●		●
S							●
H							
O			○				○

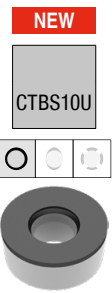
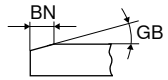
RCGW

Designation	S mm	D1 mm	IC mm
RCGW 1204..	4,76	4,4	12



RCGW

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



F
CBN
RCGW

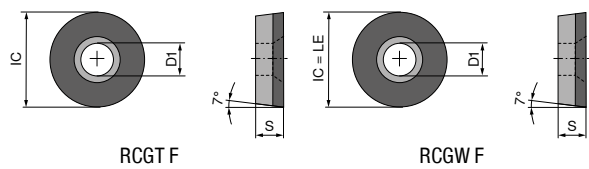
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm
1204M0TN	6	0,12	20°	F	12

71 425 ...
EUR
Y0
235,90 10000

P	
M	
K	●
N	
S	●
H	
O	

RCGW / RCGT

Designation	S mm	D1 mm	IC mm
RCG. 0602..	2,38	2,8	6
RCGW 0803..	3,18	3,4	8
RCGW 1003..	3,97	4,4	10
RCGT 10T3..	3,97	4,4	10
RCGW 1204..	4,76	4,4	12

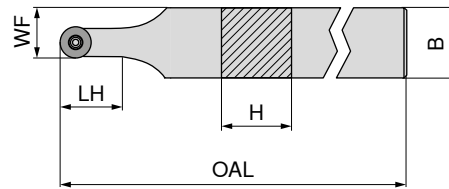


RCGW / RCGT

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

ISO	RE mm	TCE (NOI)	LE mm	NEW		NEW		NEW		NEW	
				CTDPD20	-CB1 CTDPD20	CTDPS30	-CB1 CTDPS30	CTDPS30	-CB1 CTDPS30	CTDPS30	-CB2 CTDPS30
				F	F	F	F	F	F	F	M
				DIAMOND RCGW	DIAMOND RCGT	DIAMOND RCGW	DIAMOND RCGT	DIAMOND RCGW	DIAMOND RCGT	DIAMOND RCGW	DIAMOND RCGT
				71 179 ...	71 315 ...	71 179 ...	71 315 ...	71 179 ...	71 315 ...	71 316 ...	
				EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0	
0602M0FN	3	F	6	112,70	10001	112,70	20001	112,70	202	157,20	202
0803M0FN	4	F	8	146,10	10101	146,10	20101				
1003M0FN	6	F	10	188,70	10201						
10T3M0FN	5	F	10		206,20	104		206,20	204	206,20	204
1204M0FN	6	F	12	238,90	10301						
P											
M											
K											
N											
S											
H											
O											

MaxiLock-S – SRDC 0° – Toolholder with screw clamping



Neutral

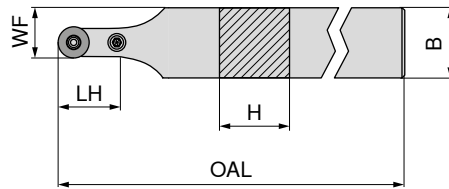
70 708 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	EUR 2A/24	
SRDC N 1212 F06	12	12	80	12,4	9,0	1,2	RC.. 0602 M0	77,28	012
SRDC N 1616 H06	16	16	100	12,4	11,0	1,2	RC.. 0602 M0	80,15	016
SRDC N 2020 K06	20	20	125	12,4	13,0	1,2	RC.. 0602 M0	89,29	020
SRDC N 2525 M06	25	25	150	12,4	15,5	1,2	RC.. 0602 M0	92,37	025
SRDC N 1616 H08	16	16	100	16,4	12,0	1,8	RC.. 0803 M0	80,15	116
SRDC N 2020 K08	20	20	125	16,4	14,0	1,8	RC.. 0803 M0	89,29	120
SRDC N 2525 M08	25	25	150	16,4	16,5	1,8	RC.. 0803 M0	92,37	125
SRDC N 1616 H10	16	16	100	20,3	13,0	3,2	RC.. 1003 M0	80,15	216
SRDC N 2020 K10	20	20	125	20,3	15,0	3,2	RC.. 1003 M0	89,29	220
SRDC N 2525 M10	25	25	150	20,3	17,5	3,2	RC.. 1003 M0	92,37	225

Spare parts
for Article no.

	Key D	Combination Key	Clamping screw	Solid carbide support R	Threaded sleeve
	80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
	EUR Y7	EUR 2A/28	EUR 2A	EUR 2A/28	EUR 2A/28
70 708 012	8,03	110	2,43	112	
70 708 016	8,03	110	2,43	112	
70 708 020	8,03	110	2,43	112	
70 708 025	8,03	110	2,43	112	
70 708 116	8,03	110	2,70	115	
70 708 120	8,03	110	2,70	115	
70 708 125	8,03	110	2,70	115	
70 708 216		8,69 398	3,30 113	12,99 117	4,87 171
70 708 220		8,69 398	3,30 113	12,99 117	4,87 171
70 708 225		8,69 398	3,30 113	12,99 117	4,87 171

MaxiLock-N – PRDC 0° – Toolholder with lever clamping



Neutral

70 544 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert
PRDC N 2525 M12	25	25	150	24	18,5	3	RCMT 1204
PRDC N 3225 P12	32	25	170	24	18,5	3	RCMT 1204
PRDC N 3225 P16	32	25	170	28	20,5	4	RCMT 1606

EUR
2A/24

92,37

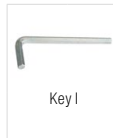
025

97,20

032

97,20

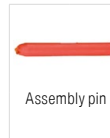
132



Key I



Shim



Assembly pin



Lever



Clamping screw

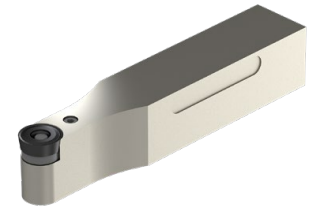
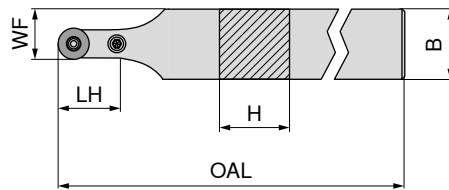


Solid carbide support R

Spare parts
for Article no.

	70 544 025	70 544 032	70 544 132	SW2,5	SW2,5	SW3	EUR 2A/28	EUR 2A/28	EUR 2A/28	EUR 2A/28	EUR 2A/28	EUR 2A/28	EUR 2A/28	EUR 2A/28	EUR 2A/28	EUR 2A/28
				175	175	176	2,57	1,85	1,28	16,30	178	3,35	208	7,44	215	215
							2,57	1,85	1,28	16,30	178	3,35	208	7,44	215	215
							2,57	1,44	1,28	16,86	387	3,68	390	13,22	384	384

MaxiLock-N – PRDC 0° – Toolholder with lever clamping



Neutral

70 545 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert
PRDC N 3225 P20	32	32	170	32	26,0	5	RCMT 2006
PRDC N 4040 S25	40	40	250	42	32,5	6	RCMT 2507

EUR
2A/24

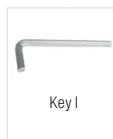
120,00

23200¹⁾

149,30

40400¹⁾

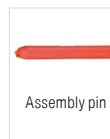
1) nickel-plated



Key I



Shim



Assembly pin



Lever



Clamping screw

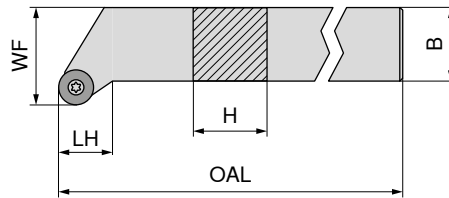


Solid carbide support R

Spare parts
for Article no.

	70 545 23200	70 545 40400	SW2,5	SW2,5	SW3	EUR 2A/28	EUR 2A/28	EUR 2A/28	EUR 2A/28	EUR 2A/28	EUR 2A/28	EUR 2A/28	EUR 2A/28	EUR 2A/28	EUR 2A/28	EUR 2A/28
			177	391	392	2,57	1,18	1,28	15,99	28100	3,61	28500	17,89	27400	27400	27400
						2,70	1,85	1,28	19,69	28400	7,85	28600	33,55	27500	27500	27500

MaxiLock-S – SRGC – Toolholder with screw clamping



Illustrations show right-hand versions



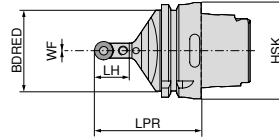
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 713 ...		Right-hand 70 712 ...	
								EUR 2A/24		EUR 2A/24	
SRGC R/L 1212 F06	12	12	80	10,0	16	1,2	RC.. 0602 M0	75,81	012	75,81	012
SRGC R 1616 H06	16	16	100	10,0	20	1,2	RC.. 0602 M0			80,15	016
SRGC R/L 2020 K06	20	20	125	11,5	25	1,2	RC.. 0602 M0	89,29	020	89,29	020
SRGC R/L 2525 M06	25	25	150	15,0	32	1,2	RC.. 0602 M0	92,37	025	92,37	025
SRGC R/L 1616 H08	16	16	100	11,0	20	1,8	RC.. 0803 M0	78,62	11600 ¹⁾	80,15	116
SRGC R 2020 K08	20	20	125	13,0	25	1,8	RC.. 0803 M0			89,29	120
SRGC R/L 2525 M08	25	25	150	16,0	32	1,8	RC.. 0803 M0	92,37	125	92,37	125
SRGC R/L 1616 H10	16	16	100	12,0	20	3,2	RC.. 1003 M0	78,62	216	78,62	216
SRGC R/L 2020 K10	20	20	125	13,5	25	3,2	RC.. 1003 M0	89,29	220	89,29	220
SRGC R/L 2525 M10	25	25	150	17,0	32	3,2	RC.. 1003 M0	92,37	225	92,37	225

1) nickel-plated

Spare parts for Article no.			Clamping screw		Solid carbide support R		Threaded sleeve	
			EUR 2A		EUR 2A/28		EUR 2A/28	
70 712 012 / 70 713 012	M2,5x6	2,43	112					
70 712 016	M2,5x6	2,43	112					
70 712 020 / 70 713 020	M2,5x6	2,43	112					
70 712 025 / 70 713 025	M2,5x6	2,43	112					
70 712 116 / 70 713 11600	M3x7,3	2,70	115					
70 712 120	M3x7,3	2,70	115					
70 712 125 / 70 713 125	M3x7,3	2,70	115					
70 712 216 / 70 713 216	M3,5x11	3,30	113	12,99	117	M3,5	4,87	171
70 712 220 / 70 713 220	M3,5x11	3,30	113	12,99	117	M3,5	4,87	171
70 712 225 / 70 713 225	M3,5x11	3,30	113	12,99	117	M3,5	4,87	171

Spare parts for Article no.			Key D		Combination Key	
			EUR Y7		EUR 2A/28	
70 712 012 / 70 713 012	T08	8,03	110			
70 712 016	T08	8,03	110			
70 712 020 / 70 713 020	T08	8,03	110			
70 712 025 / 70 713 025	T08	8,03	110			
70 712 116 / 70 713 11600	T08	8,03	110			
70 712 120	T08	8,03	110			
70 712 125 / 70 713 125	T08	8,03	110			
70 712 216 / 70 713 216				T15/SW	8,69	398
70 712 220 / 70 713 220				T15/SW	8,69	398
70 712 225 / 70 713 225				T15/SW	8,69	398

MaxiLock-N – PRDC 0° – Toolholder with lever clamping



Neutral

74 548 ...

ISO designation	Adapter	LPR mm	BORED mm	WF mm	torque moment Nm	Insert	EUR 2D/80	
HSK T63 PRDC N 12	HSK-T 63	70	53	0	3	RC.. 1204 M0	236,00	512
HSK T100 PRDC N 12	HSK-T 100	80	88	0	3	RC.. 1204 M0	268,90	712
HSK T100 PRDC N 16	HSK-T 100	80	88	0	4	RC.. 1606 M0	268,90	716

Spare parts
for Article no.

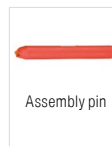
			70 950 ...	EUR 2A/28		70 950 ...	EUR 2A/28		70 950 ...	EUR 2A/28		70 950 ...	EUR 2A/28		70 950 ...	EUR 2A/28		70 950 ...	EUR 2A/28	
74 548 512		SW2,5		2,57	175		1,85	197		1,28	191		16,30	178		3,35	208		7,44	215
74 548 712		SW2,5		2,57	175		1,85	197		1,28	191		16,30	178		3,35	208		7,44	215
74 548 716		SW3		2,57	176		1,44	196		1,28	192		16,86	387		3,68	390		13,22	384



Key I



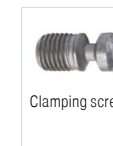
Shim



Assembly pin



Lever

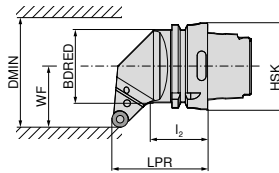


Clamping screw



Solid carbide support R

MaxiLock-N – PRSC – Toolholder with lever clamping



Illustrations show right-hand versions



Left-hand

74 552 ...

Right-hand

74 551 ...

ISO designation	Adapter	LPR mm	I ₂ mm	BORED mm	WF mm	DMIN mm	torque moment Nm	Insert	EUR 2D/80		EUR 2D/80	
HSK T63 PRSC R/L 12	HSK-T 63	70	44	53	45	100	3	RC.. 1204 M0	236,00	512	236,00	512
HSK T100 PRSC R/L 12	HSK-T 100	80	57	88	55	106	3	RC.. 1204 M0	268,90	712	268,90	712
HSK T100 PRSC R/L 16	HSK-T 100	80	55	88	55	125	4	RC.. 1606 M0	268,90	716	268,90	716

Spare parts
for Article no.

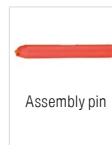
			70 950 ...	EUR 2A/28		70 950 ...	EUR 2A/28		70 950 ...	EUR 2A/28		70 950 ...	EUR 2A/28		70 950 ...	EUR 2A/28		70 950 ...	EUR 2A/28	
74 551 512 / 74 552 512		SW2,5		2,57	175		1,85	197		1,28	191		16,30	178		3,35	208		7,44	215
74 551 712 / 74 552 712		SW2,5		2,57	175		1,85	197		1,28	191		16,30	178		3,35	208		7,44	215
74 551 716 / 74 552 716		SW3		2,57	176		1,44	196		1,28	192		16,86	387		3,68	390		13,22	384



Key I



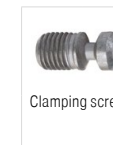
Shim



Assembly pin



Lever



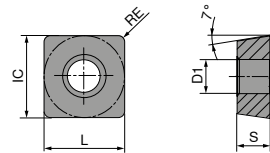
Clamping screw



Solid carbide support R

SCGT / SCMT / SCMX

Designation	L mm	S mm	D1 mm	IC mm
SC.T 09T3..	9,52	3,97	4,4	9,52
SC.. 1204..	12,70	4,76	5,5	12,70



SCGT / SCMT

		-CF05 CTEP110		-CF55 CTEP110		-SF TCM10		-SF TCM407		-SF CTCP125		-SMF CTCP115		-SMF CTCP135	
		DRAGONSKIN		DRAGONSKIN						DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		F		F		F		F		F		F		F	
		CERMET SCGT		CERMET SCMT		CERMET SCGT		CERMET SCGT		SCMT		SCMT		SCMT	
		76 261 ...		76 260 ...		70 271 ...		70 271 ...		76 269 ...		76 267 ...		76 267 ...	
ISO	RE mm	EUR 1A/78		EUR 1A/78		EUR 1A/78		EUR 1A/78		EUR 1A/08		EUR 1A/08		EUR 1A/08	
09T304EN	0,4	15,86	004	10,16	004	14,55	902	14,55	852	10,19	504	10,19	304		
09T308EN	0,8	15,86	006	10,16	006	14,55	904	14,55		10,19	506	10,19	306		
120408EN	0,8									14,34	518			14,34	718
P			●		●		●		●		●		●		●
M			○		○		○		○		○		○		○
K			○		○		○		○		○		○		
N															
S															
H															
O															

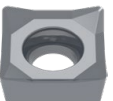
SCMT / SCMX

		-SM CTCK110		-SM CTCK120		-SM CTCP115		-SM CTCP125		-SM CTCP135		CTCP135	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		M		M		M		M		M		M	
		SCMT		SCMT		SCMT		SCMT		SCMT		SCMX	
		70 268 ...		70 268 ...		76 268 ...		76 268 ...		76 268 ...		76 182 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
09T304EN	0,4	10,19	004	10,19	504	10,19	304	10,19	504	10,19	704		
09T308EN	0,8	10,19	006	10,19	506	10,19	306	10,19	506	10,19	706		
120408EN	0,8	14,34	018	14,34	518	14,34	318	14,34	518	14,34	718	13,04	718
120412EN	1,2	14,34	020	14,34	520			14,34	520				
P			○		○		●		●		●		●
M											○		○
K			●		●		○		○				
N													
S													
H													
O													

SCMT

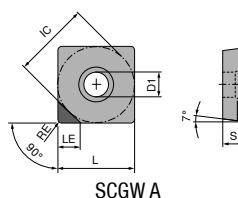
				NEW				NEW	
				-M55 CTCM120		-M55 CTPM125		-M55 CTCM130	
				DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
									
									
				M SCMT		M SCMT		M SCMT	
				75 216 ...		75 216 ...		75 216 ...	
ISO	RE mm			EUR 1A/08		EUR 1A/08		EUR 1A/08	
09T308EN	0,8			10,19		10,19		10,19	
120408EN	0,8			14,34		14,34		14,34	
				10600		206		30600	
				11800		218		31800	
P				○		○		○	
M				●		●		●	
K									
N									
S								○	
H									
O									

SCGT

				NEW		NEW			
				-25P H210T		-25P CTPX710		-27 CTPX715	
						DRAGONSKIN		DRAGONSKIN	
									
									
				F SCGT		M SCGT		M SCGT	
				70 283 ...		70 283 ...		70 270 ...	
ISO	RE mm			EUR 1A/90		EUR 1A/90		EUR 1A/90	
09T304FN	0,4								
09T308FN	0,8								
120408FN	0,8			13,98		16,57		13,39	
				634		71600		604	
								602	
								300	
								302	
								304	
P				●		●			
M				●		●		○	
K				○		○		○	
N				●		●		●	
S				○		●		●	
H									
O				○		○		○	

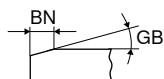
SCGW

Designation	L mm	S mm	D1 mm	IC mm
SCGW 09T3..	9,52	3,97	4,4	9,52
SCGW 1204..	12,70	4,76	5,5	12,70



SCGW

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



NEW

CTBS10U



F

CBN
SCGW

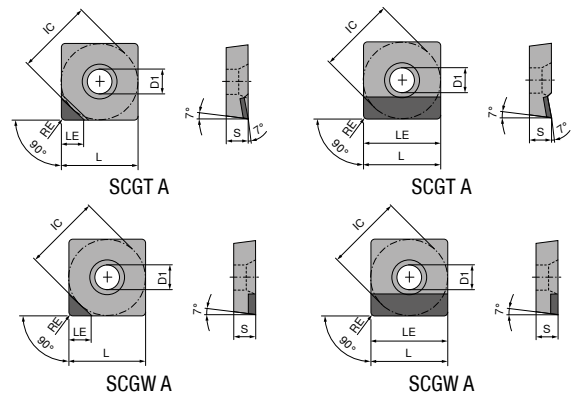
71 426 ...

ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	EUR Y0	
09T304TN	0,4	0,12	20°	A (1)	3,5	41,08	10100
09T304FN	0,4			A (1)	3,5	41,08	10000
09T308FN	0,8			A (1)	3,4	41,08	10200
09T308TN	0,8	0,12	20°	A (1)	3,4	41,08	10300
120404FN	0,4			A (1)	3,5	41,08	10400
120404TN	0,4	0,12	20°	A (1)	3,5	41,08	10500
120408FN	0,8			A (1)	3,4	41,08	10600
120408TN	0,8	0,12	20°	A (1)	3,4	41,08	10700

P	
M	
K	•
N	
S	•
H	
O	

SCGW / SCGT

Designation	L mm	S mm	D1 mm	IC mm
SCG. 09T3..	9,52	3,97	4,4	9,52
SCG. 1204..	12,70	4,76	5,5	12,70



SCGW / SCGT

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

				NEW		NEW		-CB1		NEW		NEW	
				CTDPD20		CTDPD20		CTDPD20		CTDPS30		CTDPS30	
				F		F		F		F		F	
				DIAMOND		DIAMOND		DIAMOND		DIAMOND		DIAMOND	
				SCGW		SCGW		SCGT		SCGW		SCGT	
				71 182 ...		71 183 ...		71 320 ...		71 182 ...		71 180 ...	
ISO	RE mm	TCE (NOI)	LE mm	EUR	Y0	EUR	Y0	EUR	Y0	EUR	Y0	EUR	Y0
09T304FN	0,4	A (1)	9,52			91,30	10001						
09T304FN	0,4	A (1)	4,40	60,87	10001			76,43	114	60,87	20601	60,87	20001
09T308FN	0,8	A (1)	4,30	60,87	10101			76,43	118			60,87	20101
09T308FN	0,8	A (1)	9,52			91,30	10101						
09T312FN	1,2	A (1)	4,20	60,87	10201							60,87	20201
120404FN	0,4	A (1)	12,70			101,00	10201						
120404FN	0,4	A (1)	4,40	62,26	10301								
120408FN	0,8	A (1)	4,30	62,26	10401								
120408FN	0,8	A (1)	12,70			101,00	10301						
120412FN	1,2	A (1)	12,70			101,00	10401						
120412FN	1,2	A (1)	4,20	62,26	10501								
P													
M													
K													
N													
S													
H													
O													

SCGT

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

ISO	RE mm	TCE (NOI)	LE mm						
09T304FN	0,4	A (1)	4,4						
09T308FN	0,8	A (1)	9,5						
09T308FN	0,8	A (1)	4,3						
120408FN	0,8	A (1)	12,7						
120412FN	1,2	A (1)	12,0						
P									
M									
K									
N									
S									
H									
O									

NEW

CTDPS30

F

DIAMOND SCGT

71 181 ...

EUR Y0

NEW

-CB2 CTDPS30

M

DIAMOND SCGT

71 321 ...

EUR Y0

-CB3 CTDPU20

R

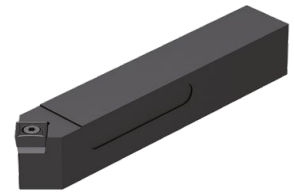
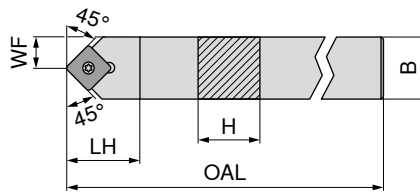
DIAMOND SCGT

71 322 ...

EUR Y0

20001	214	214
20101	218	218
20201		

MaxiLock-S – SSDC 45° – Toolholder with screw clamping



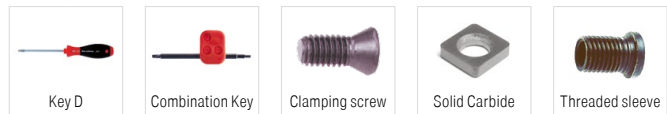
Neutral

70 656 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	EUR 2A/24	
SSDC N 1212 F09	12	12	80	16	6,0	3,2	SC.. 09T3..	67,82	012
SSDC N 1616 H09	16	16	100	20	8,0	3,2	SC.. 09T3..	84,00	016
SSDC N 2020 K09	20	20	125	20	10,0	3,2	SC.. 09T3..	89,29	020
SSDC N 1616 H12	16	16	100	25	8,0	5	SC.. 1204..	84,00	116
SSDC N 2020 K12	20	20	125	25	10,0	5	SC.. 1204..	89,29	120
SSDC N 2525 M12	25	25	150	25	12,5	5	SC.. 1204..	92,37	125

Spare parts
for Article no.

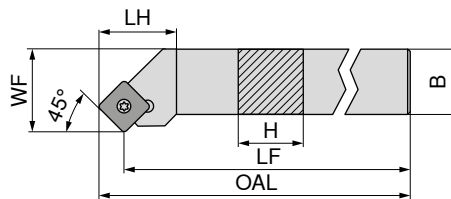
	EUR Y7	113	EUR 2A/28	398	EUR 2A/28	113	EUR 2A/28	167	EUR 2A/28	171
70 656 012	9,56				3,30	113				
70 656 016			8,69	398	3,30	113	10,15	167	4,87	171
70 656 020			8,69	398	3,30	113	10,15	167	4,87	171
70 656 116			8,69	398	2,70	114	12,99	168	4,87	170
70 656 120			8,69	398	2,70	114	12,99	168	4,87	170
70 656 125			8,69	398	2,70	114	12,99	168	4,87	170



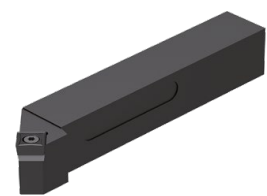
80 950 ... 70 950 ... 70 950 ... 70 950 ... 70 950 ...

EUR Y7 EUR 2A/28 EUR 2A/28 EUR 2A/28 EUR 2A/28

MaxiLock-S – SSSC 45° – Toolholder with screw clamping



Illustrations show right-hand versions



Left-hand

Right-hand

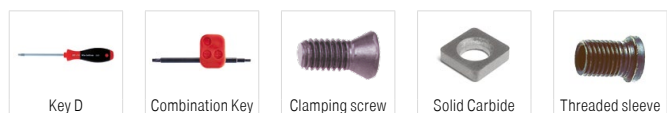
70 661 ...

70 660 ...

ISO designation	H mm	B mm	LF mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	EUR 2A/24		EUR 2A/24	
SSSC R/L 1212 F09	12	12	80	86,40	18	16	3,2	SC.. 09T3..	67,82	012	67,82	012
SSSC R/L 1616 H09	16	16	100	106,40	20	20	3,2	SC.. 09T3..	84,00	016	84,00	016
SSSC R/L 2020 K09	20	20	125	131,40	20	25	3,2	SC.. 09T3..	89,29	020	89,29	020
SSSC R/L 1616 H12	16	16	100	108,63	25	20	5	SC.. 1204..	84,00	116	84,00	116
SSSC R/L 2020 K12	20	20	125	133,63	25	25	5	SC.. 1204..	89,29	120	89,29	120
SSSC R/L 2525 M12	25	25	150	158,63	25	32	5	SC.. 1204..	92,37	125	92,37	125
SSSC R 3225 P12	32	25	170	178,63	25	32	5	SC.. 1204..			96,01	132

Spare parts
for Article no.

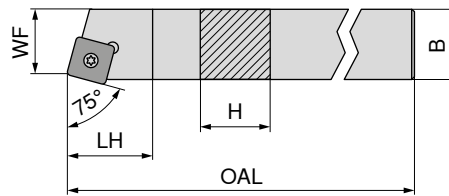
	EUR Y7	113	EUR 2A/28	398	EUR 2A/28	113	EUR 2A/28	167	EUR 2A/28	171
70 661 012 / 70 660 012	9,56				3,30	113				
70 661 016 / 70 660 016			8,69	398	3,30	113	10,15	167	4,87	171
70 661 020 / 70 660 020			8,69	398	3,30	113	10,15	167	4,87	171
70 661 116 / 70 660 116			8,69	398	2,70	114	12,99	168	4,87	170
70 661 120 / 70 660 120			8,69	398	2,70	114	12,99	168	4,87	170
70 661 125 / 70 660 125			8,69	398	2,70	114	12,99	168	4,87	170
70 660 132			8,69	398	2,70	114	12,99	168	4,87	170



80 950 ... 70 950 ... 70 950 ... 70 950 ... 70 950 ...

EUR Y7 EUR 2A/28 EUR 2A/28 EUR 2A/28 EUR 2A/28

MaxiLock-S – SSBC 75° – Toolholder with screw clamping



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand		Right-hand	
								70 665 ...		70 664 ...	
SSBC R/L 1616 H09	16	16	100	20	13	3,2	SC.. 09T3..	EUR 2A/24 84,00	016	EUR 2A/24 84,00	016
SSBC R 2020 K09	20	20	125	20	17	3,2	SC.. 09T3..			EUR 2A/24 89,29	020
SSBC R/L 2020 K12	20	20	125	20	17	5	SC.. 1204..	87,59	12000 ¹⁾	EUR 2A/24 89,29	120
SSBC R/L 2525 M12	25	25	150	20	22	5	SC.. 1204..	92,37	125	EUR 2A/24 92,37	125

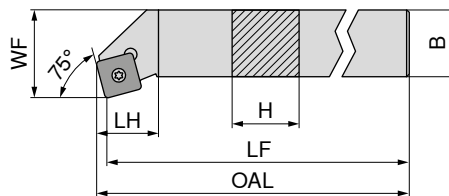
1) nickel-plated

Spare parts
for Article no.

	80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
	EUR Y7	EUR 2A/28	EUR 2A/28	EUR 2A/28	EUR 2A/28
70 664 016 / 70 665 016	9,56 113	8,69 398	3,30 113	10,15 167	4,87 171
70 664 020	9,56 113	8,69 398	3,30 113	10,15 167	4,87 171
70 664 120 / 70 665 12000	9,56 113	8,69 398	2,70 114	12,99 168	4,87 170
70 664 125 / 70 665 125	9,56 113	8,69 398	2,70 114	12,99 168	4,87 170



MaxiLock-S – SSKC 75° – Toolholder with screw clamping



Illustrations show right-hand versions

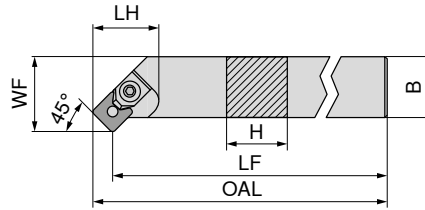


ISO designation	H mm	B mm	LF mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand		Right-hand	
									70 669 ...		70 668 ...	
SSKC R/L 1616 H09	16	16	100	102,3	22	20	3,2	SC.. 09T3..	EUR 2A/24 84,00	016	EUR 2A/24 84,00	016
SSKC R/L 2020 K09	20	20	125	127,3	22	25	3,2	SC.. 09T3..	89,29	020	EUR 2A/24 89,29	020
SSKC R 2020 K12	20	20	125	127,3	23	25	5	SC.. 1204..			EUR 2A/24 89,29	120
SSKC R 2525 M12	25	25	150	153,3	23	32	5	SC.. 1204..			EUR 2A/24 92,37	125

Spare parts
for Article no.

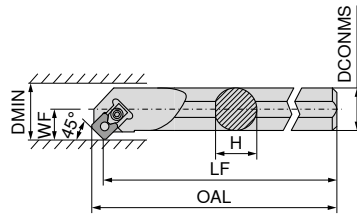
	80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
	EUR Y7	EUR 2A/28	EUR 2A/28	EUR 2A/28	EUR 2A/28
70 668 016 / 70 669 016	9,56 113	8,69 398	3,30 113	10,15 167	4,87 171
70 668 020 / 70 669 020	9,56 113	8,69 398	3,30 113	10,15 167	4,87 171
70 668 120	9,56 113	8,69 398	2,70 114	12,99 168	4,87 170
70 668 125	9,56 113	8,69 398	2,70 114	12,99 168	4,87 170





							
			Key D	Dowel pin	Clamping Element	Wedge	Solid Carbide support S
			80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
			EUR Y7	EUR 2A/28	EUR 2A/28	EUR 2A/28	EUR 2A/28
Spare parts for Article no.							
70 588 020 / 70 589 020	T20	114	10,25	4,29 153	12,55 159	7,86 150	12,76 140
70 588 025 / 70 589 025	T20	114	10,25	4,29 153	12,55 159	7,86 150	12,76 140
70 588 032 / 70 589 032	T20	114	10,25	4,29 153	12,55 159	7,86 150	12,76 140

MaxiLock-P – MSSC 45° – Boring bar with top clamping



Illustrations show right-hand versions



									Left-hand		Right-hand	
									70 625 ...		70 624 ...	
ISO designation	DCONMS mm	H mm	LF mm	OAL mm	WF mm	DMIN mm	torque moment Nm	Insert	EUR 2A/24		EUR 2A/24	
S32S MSSC R/L 12	32	30	250	258	22	40	5	SCMX 1204	232,80	032	232,80	032



Key D



Dowel pin

Clamping
Element

Wedge

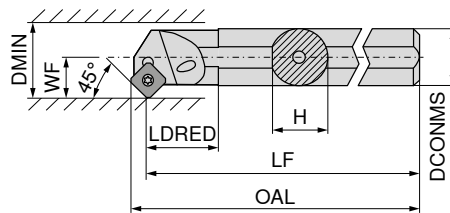
Solid Carbide
support S

Spare parts		EUR		EUR		EUR		EUR		EUR		
for Article no.		Y7		2A/28		2A/28		2A/28		2A/28		
70 625 032 / 70 624 032		T20	10,25	114	5,28	155	12,55	163	7,86	150	12,76	147

MaxiLock-S – SSSC 45° – Boring bar with screw clamping

▲ A... = with thro' coolant

▲ S... = without thro' coolant



Illustrations show right-hand versions



										Left-hand		Right-hand	
										70 721 ...		70 720 ...	
ISO designation	DCONMS mm	H mm	LF mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	EUR 2A/24		EUR 2A/24	
S16R SSSC R 09	16	15,00	200	206,0	13,97	11	20	3,2	SC.. 09T3..			103,60	016
A16M SSSC R/L 09	16	15,25	150	156,0	29,00	11	20	3,2	SC.. 09T3..	103,60	216	103,60	216
A20Q SSSC R/L 09	20	19,00	180	186,0	32,00	13	25	3,2	SC.. 09T3..	129,20	220	129,20	220
A25R SSSC R/L 09	25	24,50	200	206,0	36,00	17	32	3,2	SC.. 09T3..	148,50	225	148,50	225
A32S SSSC R/L 12	32	31,00	250	258,3	50,00	22	40	5	SC.. 1204..	204,10	232	204,10	232
A40T SSSC R/L 12	40	39,00	300	308,1	60,00	27	50	5	SC.. 1204..	245,10	240	245,10	240



Key D



Combination Key



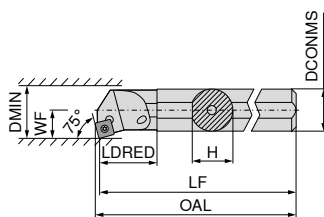
Clamping screw

Solid Carbide
support S

Threaded sleeve

		80 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	
Spare parts		EUR		EUR		EUR		EUR		EUR	
for Article no.		Y7		2A/28		2A/28		2A/28		2A/28	
70 720 016		9,56	113			3,30	110				
70 720 216 / 70 721 216		9,56	113			3,30	110				
70 720 220 / 70 721 220		9,56	113			3,30	304				
70 720 225 / 70 721 225		9,56	113			3,30	304				
70 720 232 / 70 721 232				8,69	398	2,70	114	12,99	168	4,87	170
70 720 240 / 70 721 240				8,69	398	2,70	114	12,99	168	4,87	170

MaxiLock-S – SSKC 75° – Boring bar with screw clamping



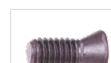
Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	LF mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 725 ...		Right-hand 70 724 ...	
										EUR 2A/24		EUR 2A/24	
A16M SSKC R/L 09	16	15,0	150	152,4	29	11	20	3,2	SC.. 09T3..	103,60	216	103,60	216
A20Q SSKC R/L 09	20	18,5	180	182,4	32	13	25	3,2	SC.. 09T3..	129,20	220	129,20	220
A25R SSKC R/L 09	25	23,0	200	202,4	36	17	32	3,2	SC.. 09T3..	148,50	225	148,50	225



Key D



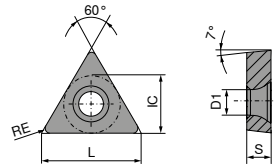
Clamping screw

Spare parts
for Article no.

70 724 216 / 70 725 216	T15	9,56	113	M3,5x7,2	3,30	110
70 724 220 / 70 725 220	T15	9,56	113	M3,5x8,6	3,30	304
70 724 225 / 70 725 225	T15	9,56	113	M3,5x8,6	3,30	304

TCGT / TCMT

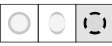
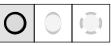
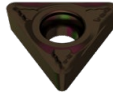
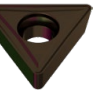
Designation	L mm	S mm	D1 mm	IC mm
TCMT 0902..	9,6	2,38	2,50	5,56
TC.T 1102..	11,0	2,38	2,80	6,35
TC.T 16T3..	16,5	3,97	4,40	9,52
TCMT 2204..	22,0	4,76	5,16	12,70



TCGT / TCMT

		-CF05 CTEP110		-CF55 CTEP110		-SF TCM10		-SMF TCM10		-SF CTCP125		-SMF CTCP115	
		DRAGONSKIN		DRAGONSKIN						DRAGONSKIN		DRAGONSKIN	
		F CERMET TCGT		F CERMET TCMT		F CERMET TCGT		F CERMET TCMT		F TCMT		F TCMT	
		76 272 ...		76 266 ...		70 273 ...		70 284 ...		76 275 ...		76 284 ...	
ISO	RE mm	EUR 1A/78		EUR 1A/78		EUR 1A/78		EUR 1A/78		EUR 1A/08		EUR 1A/08	
110202EN	0,2	14,22	014			13,16	900			8,02	516		
110204EN	0,4	14,22	016	8,11	016	13,16	902	7,64	902	8,02	518	8,02	318
110208EN	0,8	14,22	018							8,02	518		
16T304EN	0,4	18,02	028			16,68	906			11,59	528	11,59	328
16T308EN	0,8			11,24	030					11,59	530	11,59	330
P			●	●		●		●		●		●	
M			○	○		○		○					
K			○	○		○		○		○		○	
N													
S													
H													
O													

TCMT / TCGT

		-SMF CTCP135		-SM CTCP135		-SM CTCK110		-SM CTCK120		-SM CTCP115		-SM CTCP125		-SM CTCP135	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
															
		F TCMT		M TCGT		M TCMT		M TCMT		M TCMT		M TCMT		M TCMT	
		76 284 ...		76 270 ...		70 274 ...		70 274 ...		76 274 ...		76 274 ...		76 274 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
090204EN	0,4											8,02	504	8,02	704
110202EN	0,2			14,22	714										
110204EN	0,4					8,02	016	8,02	516	8,02	316	8,02	516	8,02	716
110208EN	0,8	8,02	718			8,02	018	8,02	518	8,02	318			8,02	718
16T304EN	0,4					11,59	028	11,59	528	11,59	328	11,59	528	11,59	728
16T308EN	0,8					11,59	030	11,59	530	11,59	330	11,59	530	11,59	730
16T312EN	1,2					11,59	032	11,59	532						
220408EN	0,8											16,68	542	16,68	742
P			●		●		○		○		●		●		●
M			○		○										○
K							●		●		○		○		
N															
S															
H															
O															

9

TCMT

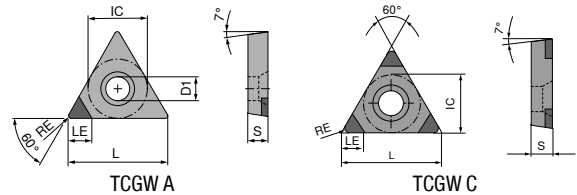
		NEW -M25 CTCM120		-M25 CTPM125		NEW -M25 CTCM130		NEW -M55 CTCM120		-M55 CTPM125		NEW -M55 CTCM130	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
													
													
		F TCMT		F TCMT		F TCMT		M TCMT		M TCMT		M TCMT	
		75 217 ...		75 217 ...		75 217 ...		75 218 ...		75 218 ...		75 218 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
090204EN	0,4							8,02	10400	8,02	204	8,02	30400
110204EN	0,4	8,02	11600	8,02	216	8,02	31600	8,02	11600	8,02	216	8,02	31600
16T304EN	0,4	11,03	12800	11,59	228	11,59	32800						
16T308EN	0,8	11,03	13000	11,59	230	11,59	33000	11,59	13000	11,59	230	11,59	33000
P			○		○		○		○		○		○
M			●		●		●		●		●		●
K													
N													
S							○						○
H													
O													

TCGT

		-27 H10T		-27 CWN15		NEW -27 CTPX715	
							
							
		M		M		M	
		TCGT		TCGT		TCGT	
		70 276 ...		70 276 ...		70 276 ...	
ISO	RE mm	EUR 1A/90		EUR 1A		EUR 1A/90	
110202FN	0,2	11,46	600	14,08	300		
110204FN	0,4	11,46	602	14,08	302	21,46	81600
16T302FN	0,2	13,50	604	16,68	304		
16T304FN	0,4	13,50	606	16,68	306		
16T308FN	0,8	13,50	608	16,68	308	21,46	83000
P							●
M					○		●
K			○				○
N			●		●		●
S							●
H							
O			○				○

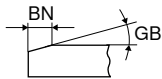
TCGW

Designation	L mm	S mm	D1 mm	IC mm
TCGW 0902..	9,6	2,38	2,5	5,56
TCGW 1102..	11,0	2,38	2,8	6,35
TCGW 16T3..	16,5	3,97	4,4	9,52



TCGW

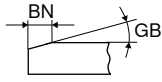
▲ TCE(NOI) = Design and number of equipped cutting edge corners



						CTBS10U		NEW CTBH15U		NEW CTBH15U		CTBH20U		NEW CTBS20U		CTBS20C	
						F		F		F		F		F		F	
						CBN		CBN		CBN		CBN		CBN		CBN	
						TCGW		TCGW		TCGW		TCGW		TCGW		TCGW	
						71 140 ...		71 028 ...		71 029 ...		71 140 ...		71 427 ...		71 164 ...	
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	EUR		EUR		EUR		EUR		EUR		EUR	
090202SN	0,2	0,09	10°	C (3)	2,6											69,71	120
090202SN	0,2	0,11	15°	C (3)	2,6					85,47	30214	37,14	500			69,71	130
090202TN	0,2	0,12	20°	A (1)	3,8	37,14	300									69,71	140
090202TN	0,2	0,15	20°	C (3)	2,6											69,71	150
090202SN	0,2	0,16	20°	C (3)	2,6							37,14	400				
090202FN	0,2			A (1)	3,8					85,47	00200						
090202EN	0,2			C (3)	2,6												
090204SN	0,4	0,09	10°	C (3)	2,2											69,71	121
090204SN	0,4	0,11	15°	C (3)	2,2			85,47	30414							69,71	131
090204TN	0,4	0,12	15°	A (1)	3,5							37,14	502	41,08	20000		
090204TN	0,4	0,12	20°	A (1)	3,5	37,14	302									69,71	151
090204SN	0,4	0,16	20°	C (3)	2,2											69,71	161
090204TN	0,4	0,17	25°	C (3)	2,2							37,14	402				
090204FN	0,4			A (1)	3,5	37,14	202			85,47	00400					69,71	111
090204EN	0,4			C (3)	2,2												
090208SN	0,8	0,09	10°	C (3)	1,8											69,71	122
090208SN	0,8	0,11	15°	C (3)	1,8			85,47	30614			37,14	504			69,71	132
090208TN	0,8	0,12	20°	A (1)	3,0											69,71	142
090208TN	0,8	0,15	20°	C (3)	1,8					85,47	00600					69,71	162
090208EN	0,8			C (3)	1,8												
090208TN	0,8	0,17	25°	C (3)	1,8												
110202SN	0,2	0,09	10°	C (3)	2,9											69,71	123
110202SN	0,2	0,11	15°	C (3)	2,9							37,14	506			69,71	133
110202TN	0,2	0,12	20°	A (1)	3,8	37,14	306									69,71	143
110202TN	0,2	0,15	20°	C (3)	2,9							37,14	406			69,71	153
110202SN	0,2	0,16	20°	C (3)	2,9												
110202FN	0,2			A (1)	3,8	37,14	206										
110204SN	0,4	0,09	10°	C (3)	2,5											69,71	124
110204SN	0,4	0,11	15°	C (3)	2,5							37,14	508			69,71	134
110204TN	0,4	0,12	20°	A (1)	3,5	37,14	308									69,71	144
110204TN	0,4	0,15	20°	C (3)	2,5											69,71	154
110204SN	0,4	0,16	20°	C (3)	2,5											69,71	164
110204TN	0,4	0,17	25°	C (3)	2,5							37,14	40700				
110204FN	0,4			A (1)	3,5	37,14	208										
110204EN	0,4			C (3)	2,5											69,71	114
P																	
M																	
K																	
N																	
S																	
H																	
O																	

TCGW

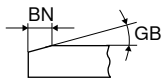
▲ TCE(NOI) = Design and number of equipped cutting edge corners



						CTBS10U		NEW CTBH15U		NEW CTBH15U		CTBH20U		NEW CTBS20U		CTBS20C	
						F		F		F		F		F		F	
						CBN TCGW		CBN TCGW		CBN TCGW		CBN TCGW		CBN TCGW		CBN TCGW	
						71 140 ...		71 028 ...		71 029 ...		71 140 ...		71 427 ...		71 164 ...	
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	EUR Y0		EUR Y0		EUR Y0		EUR Y0		EUR Y0		EUR Y0	
110208SN	0,8	0,09	10°	C (3)	2,1											69,71	125
110208SN	0,8	0,11	15°	C (3)	2,1											69,71	135
110208TN	0,8	0,12	20°	A (1)	3,0	37,14	310					37,14	510			69,71	145
110208TN	0,8	0,15	20°	C (3)	2,1											69,71	165
110208TN	0,8	0,17	25°	C (3)	2,1											69,71	165
110208FN	0,8			A (1)	3,0	37,14	210					37,14	410				
16T304SN	0,4	0,09	10°	C (3)	3,2											69,71	126
16T304SN	0,4	0,11	15°	C (3)	3,2											69,71	136
16T308SN	0,8	0,09	10°	C (3)	2,7											69,71	127
16T308SN	0,8	0,11	15°	C (3)	2,7											69,71	137
16T308SN	0,8	0,16	20°	C (3)	2,7											69,71	157
16T308TN	0,8	0,17	25°	C (3)	2,7											69,71	167
16T308EN	0,8			C (3)	2,7											69,71	117
P																	
M																	
K																	
N																	
S																	
H																	
O																	

TCGW

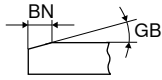
▲ TCE(NOI) = Design and number of equipped cutting edge corners



						NEW		NEW						
						CTBH15C	CTBH15C	CTBH20C	CTBH40U	CTBH40C				
						F	F	F	F	F				
						CBN	CBN	CBN	CBN	CBN				
						TCGW	TCGW	TCGW	TCGW	TCGW				
						71 027 ...	71 034 ...	71 164 ...	71 140 ...	71 164 ...				
ISO	RE	BN	GB	TCE	LE	EUR	EUR	EUR	EUR	EUR				
mm	mm	mm		(NOI)	mm	Y0	Y0	Y0	Y0	Y0				
090202SN	0,2	0,11	15°	C (3)	2,6		83,44 30214							
090202SN	0,2	0,09	20°	C (3)	2,6			69,71 250			69,71 330			
090202TN	0,2	0,09	20°	C (3)	2,6						69,71 320			
090202TN	0,2	0,11	25°	C (3)	2,6						69,71 340			
090202TN	0,2	0,12	25°	A (1)	3,8				37,14 900					
090202FN	0,2			A (1)	3,8				37,14 80100					
090202FN	0,2			C (3)	2,6			69,71 210						
090202EN	0,2			C (3)	2,6		83,44 00200	69,71 220						
090204SN	0,4	0,11	15°	C (3)	2,2	83,44 30414		69,71 241						
090204TN	0,4	0,09	20°	C (3)	2,2						69,71 321			
090204SN	0,4	0,09	25°	C (3)	2,2						69,71 351			
090204TN	0,4	0,11	25°	C (3)	2,2						69,71 341			
090204TN	0,4	0,12	25°	A (1)	3,5				37,14 902					
090204EN	0,4			C (3)	2,2	83,44 00400		69,71 221						
090204FN	0,4			A (1)	3,5				37,14 802					
090204TN	0,4	0,14	25°	C (3)	2,2			69,71 261						
090204SN	0,4	0,15	25°	C (3)	2,2			69,71 271						
090204TN	0,4	0,14	30°	C (3)	2,2						69,71 361			
090204SN	0,4	0,16	30°	C (3)	2,2						69,71 371			
090208SN	0,8	0,09	10°	C (3)	1,8			69,71 232						
090208SN	0,8	0,11	15°	C (3)	1,8	83,44 30614		69,71 242						
090208SN	0,8	0,09	20°	C (3)	1,8			69,71 252						
090208TN	0,8	0,14	20°	C (3)	1,8						69,71 362			
090208SN	0,8	0,09	25°	C (3)	1,8						69,71 352			
090208TN	0,8	0,11	25°	C (3)	1,8						69,71 342			
090208TN	0,8	0,12	25°	A (1)	3,0				37,14 904					
090208EN	0,8			C (3)	1,8	83,44 00600					69,71 312			
110202FN	0,2			A (1)	3,8				37,14 806					
110202SN	0,2	0,11	15°	C (3)	2,9		83,44 31414	69,71 253			69,71 333			
110202SN	0,2	0,09	20°	C (3)	2,9						69,71 323			
110202TN	0,2	0,11	25°	C (3)	2,9						69,71 343			
110202TN	0,2	0,12	25°	A (1)	3,8				37,14 906					
110202EN	0,2			C (3)	2,9			69,71 223						
110202FN	0,2			C (3)	2,9			69,71 213						
110202SN	0,2	0,14	25°	C (3)	2,9		83,44 31429				69,71 363			
110202TN	0,2	0,14	30°	C (3)	2,9									
110204FN	0,4			A (1)	3,5				37,14 808					
110204SN	0,4	0,09	10°	C (3)	2,5			69,71 234						
110204SN	0,4	0,11	15°	C (3)	2,5		83,44 31614	69,71 244						
110204TN	0,4	0,09	20°	C (3)	2,5						69,71 324			
110204SN	0,4	0,09	25°	C (3)	2,5						69,71 354			
110204TN	0,4	0,11	25°	C (3)	2,5						69,71 344			
110204TN	0,4	0,12	25°	A (1)	3,5				37,14 908					
110204EN	0,4			C (3)	2,5			69,71 224						
110204TN	0,4	0,14	25°	C (3)	2,5			69,71 264						
110204FN	0,4			C (3)	2,5			69,71 214						
P														
M														
K														
N														
S														
H														
O														

TCGW

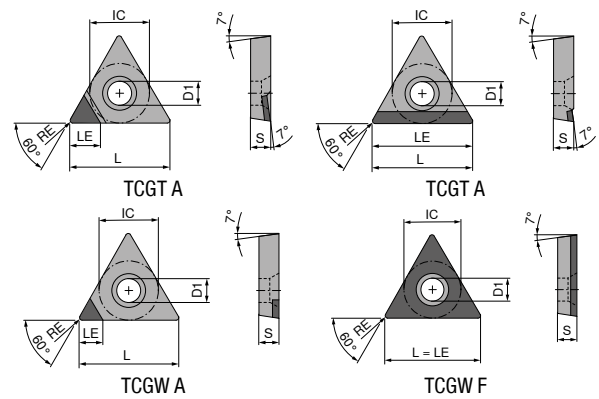
▲ TCE(NOI) = Design and number of equipped cutting edge corners



ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	NEW		NEW							
						CTBH15C	CTBH15C	CTBH15C	CTBH15C	CTBH20C	CTBH40U	CTBH40C	CTBH40C	CTBH40C	CTBH40C
						F	F	F	F	F	F	F	F	F	F
						CBN	CBN	CBN	CBN	CBN	CBN	CBN	CBN	CBN	CBN
						TCGW	TCGW	TCGW	TCGW	TCGW	TCGW	TCGW	TCGW	TCGW	TCGW
						71 027 ...	71 034 ...	71 164 ...	71 140 ...	71 164 ...					
						EUR	EUR	EUR	EUR	EUR					
						Y0	Y0	Y0	Y0	Y0					
110204SN	0,4	0,14	25°	C (3)	2,5		83,44	31629		69,71	274			69,71	364
110204SN	0,4	0,15	25°	C (3)	2,5									69,71	374
110204TN	0,4	0,14	30°	C (3)	2,5										
110204SN	0,4	0,16	30°	C (3)	2,5										
110208SN	0,8	0,09	10°	C (3)	2,1					69,71	235				
110208SN	0,8	0,11	15°	C (3)	2,1	83,44	31814			69,71	245				
110208SN	0,8	0,09	20°	C (3)	2,1					69,71	255				
110208TN	0,8	0,09	20°	C (3)	2,1									69,71	325
110208SN	0,8	0,09	25°	C (3)	2,1									69,71	355
110208TN	0,8	0,12	25°	A (1)	3,0						37,14	910			
110208EN	0,8			C (3)	2,1									69,71	315
110208TN	0,8	0,14	25°	C (3)	2,1					69,71	265				
110208SN	0,8	0,14	25°	C (3)	2,1	83,44	31829							69,71	365
110208TN	0,8	0,14	30°	C (3)	2,1									69,71	375
110208SN	0,8	0,16	30°	C (3)	2,1										
16T304SN	0,4	0,09	20°	C (3)	3,2					69,71	256			69,71	336
16T304SN	0,4	0,09	25°	C (3)	3,2									69,71	356
16T304TN	0,4	0,11	25°	C (3)	3,2									69,71	346
16T304SN	0,4	0,15	25°	C (3)	3,2					69,71	276				
16T304TN	0,4	0,14	30°	C (3)	3,2									69,71	366
16T304SN	0,4	0,17	35°	C (3)	3,2									69,71	386
16T304FN	0,4			C (3)	3,2					69,71	216				
16T304EN	0,4			C (3)	3,2					69,71	226				
16T308SN	0,8	0,11	15°	C (3)	2,7					69,71	247				
16T308SN	0,8	0,09	20°	C (3)	2,7									69,71	337
16T308SN	0,8	0,09	25°	C (3)	2,7									69,71	357
16T308TN	0,8	0,11	25°	C (3)	2,7									69,71	347
16T308TN	0,8	0,14	25°	C (3)	2,7					69,71	267				
16T308SN	0,8	0,15	25°	C (3)	2,7					69,71	277				
16T308TN	0,8	0,14	30°	C (3)	2,7									69,71	367
16T308SN	0,8	0,16	30°	C (3)	2,7									69,71	377
16T308SN	0,8	0,18	30°	C (3)	2,7					69,71	287				
16T308EN	0,8			C (3)	2,7					69,71	227			69,71	317
P															
M															
K															
N															
S															
H															
O															

TCGW / TCGT

Designation	L mm	S mm	D1 mm	IC mm
TCG. 0902..	9,6	2,38	2,5	5,56
TCG. 1102..	11,0	2,38	2,8	6,35
TCG. 16T3..	16,5	3,97	4,4	9,52



TCGW / TCGT

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

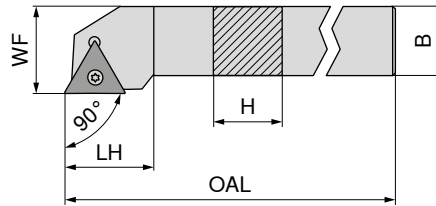
				NEW	NEW		NEW		NEW
				CTDPD20	CTDPD20	CTDPD20	CTDPD20	-CB1 CTDPD20	CTDPS30
				F	F	F	F	F	F
				DIAMOND TCGW	DIAMOND TCGW	DIAMOND TCGW	DIAMOND TCGT	DIAMOND TCGT	DIAMOND TCGT
				71 188 ...	71 187 ...	71 140 ...	71 184 ...	71 325 ...	71 184 ...
ISO	RE mm	TCE (NOI)	LE mm	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0
090202FN	0,2	A (1)	3,7			56,05	100	62,09	112
090204FN	0,4	A (1)	3,4			56,05	102	62,09	114
090208FN	0,8	A (1)	3,0			56,05	104	53,97	10001
090208FN	0,8	A (1)	9,6	81,62	10001				
110202FN	0,2	A (1)	3,7			51,15	106	56,73	10101
110202FN	0,2	F	11,0		184,20	10001		64,60	122
110204FN	0,4	A (1)	3,4			51,15	108	56,73	10201
110204FN	0,4	F	11,0		184,20	10101		64,60	124
110204FN	0,4	A (1)	11,0	85,76	10101				
110208FN	0,8	A (1)	3,0			51,15	110	56,73	10301
110208FN	0,8	A (1)	11,0	85,76	10201				
16T304FN	0,4	A (1)	4,6			56,05	112	62,26	10401
16T304FN	0,4	A (1)	16,5	113,40	10301			67,33	134
16T308FN	0,8	A (1)	4,2			56,05	114	62,26	10501
16T308FN	0,8	A (1)	16,5	113,40	10401			67,33	13600
16T312FN	1,2	A (1)	3,8			56,05	11600		
P									
M									
K									
N				•	•	•	•	•	•
S									
H									
O				•	•	•	•	•	•

TCGW / TCGT

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

				NEW	NEW		NEW		NEW
				CTDPS30	CTDPS30	-CB2 CTDPS30	CTDPU20	-CB3 CTDPU20	CTDCD10
									
									
				F	F	M	F	R	F
				DIAMOND TCGW	DIAMOND TCGT	DIAMOND TCGT	DIAMOND TCGW	DIAMOND TCGT	DIAMOND TCGW
				71 186 ...	71 185 ...	71 326 ...	71 188 ...	71 327 ...	71 186 ...
ISO	RE mm	TCE (NOI)	LE mm	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0
090202FN	0,2	A (1)	3,7	53,97	20001	62,09	212		
090204FN	0,4	A (1)	3,4			62,09	214		
090204FN	0,4	A (1)	9,6		81,62	20001			
110202FN	0,2	A (1)	2,6						71,93
110202FN	0,2	A (1)	3,7	56,73	20101	64,60	222		
110204FN	0,4	A (1)	2,3						71,93
110204FN	0,4	A (1)	3,4	56,73	20201	64,60	224	64,60	224
110204FN	0,4	A (1)	11,0		85,76	20101		80,23	30001
110208FN	0,8	A (1)	2,0		85,76	20201			
110208FN	0,8	A (1)	11,0						71,93
16T304FN	0,4	A (1)	2,3						
16T304FN	0,4	A (1)	4,6			67,33	234		77,46
16T304FN	0,4	A (1)	16,5		113,40	20301			
16T308FN	0,8	A (1)	2,0						77,46
16T308FN	0,8	A (1)	4,2					68,57	238
16T308FN	0,8	A (1)	16,5		113,40	20401			
P									
M									
K									
N									
S									
H									
O									

MaxiLock-S – STGC 90° – Toolholder with screw clamping



Illustrations show right-hand versions



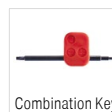
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 677 ...		Right-hand 70 676 ...	
								EUR 2A/24		EUR 2A/24	
STGC R/L 1010 E09	10	10	70	12	12	1	TC.. 0902	66,53	010	67,82	010
STGC R/L 1212 F11	12	12	80	15	16	1,2	TC.. 1102	67,82	012	67,82	012
STGC R/L 1616 H16	16	16	100	22	20	3,2	TC.. 16T3	84,00	016	84,00	016
STGC R/L 2020 K16	20	20	125	22	25	3,2	TC.. 16T3	89,29	020	89,29	020
STGC R/L 2525 M16	25	25	150	22	32	3,2	TC.. 16T3	92,37	025	92,37	025

Spare parts for Article no.

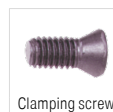
	EUR Y7		EUR 2A/28		EUR 2A/28		EUR 2A/28		EUR 2A/28	
70 676 010 / 70 677 010	8,03	109			2,70	111				
70 676 012 / 70 677 012	8,03	110			2,43	112				
70 676 016 / 70 677 016			8,69	398	3,30	113	8,15	169	4,87	171
70 676 020 / 70 677 020			8,69	398	3,30	113	8,15	169	4,87	171
70 676 025 / 70 677 025			8,69	398	3,30	113	8,15	169	4,87	171



Key D



Combination Key



Clamping screw



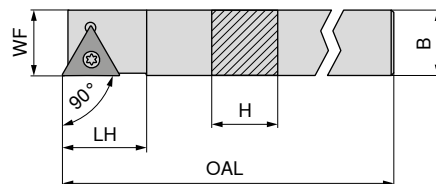
Solid Carbide
Seat T



Threaded sleeve

MaxiLock-S – STAC 90° – Toolholder with screw clamping

▲ for sliding head lathes



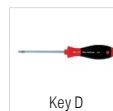
Illustrations show right-hand versions



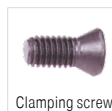
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 769 ...		Right-hand 70 768 ...	
								EUR 2A/24		EUR 2A/24	
STAC R/L 1010 K09	10	10	125	12	10	1	TC.. 0902	66,53	010	66,53	010
STAC R/L 1212 K11	12	12	125	15	12	1,2	TC.. 1102	75,86	012	75,86	012
STAC R 1414 K11	14	14	125	15	14	1,2	TC.. 1102			75,86	014

Spare parts for Article no.

70 769 010 / 70 768 010	T07	8,03	109	M2,2x5	2,70	111
70 769 012 / 70 768 012	T08	8,03	110	M2,5x6	2,43	112
70 768 014	T08	8,03	110	M2,5x6	2,43	112

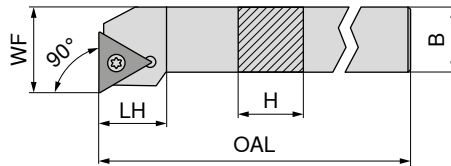


Key D



Clamping screw

MaxiLock-S – STFC 90° – Toolholder with screw clamping



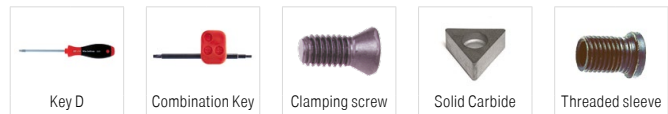
Illustrations show right-hand versions



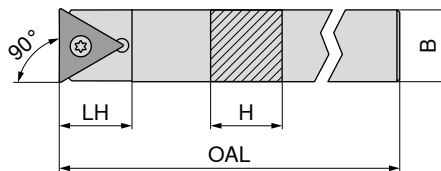
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 673 ...		Right-hand 70 672 ...	
								EUR 2A/24		EUR 2A/24	
STFC R/L 1212 F11	12	12	80	15	16	1,2	TC.. 1102	67,82	012	67,82	012
STFC R/L 1616 H16	16	16	100	20	20	3,2	TC.. 16T3	84,00	016	84,00	016
STFC R/L 2020 K16	20	20	125	20	25	3,2	TC.. 16T3	89,29	020	89,29	020
STFC R/L 2525 M16	25	25	150	20	32	3,2	TC.. 16T3	92,37	025	92,37	025

Spare parts
for Article no.

	80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 673 012 / 70 672 012	EUR Y7 8,03	EUR 2A/28 110	EUR 2A 2,43	EUR 2A/28 112	EUR 2A/28 112
70 673 016 / 70 672 016		8,69 398	3,30 113	8,15 169	4,87 171
70 673 020 / 70 672 020		8,69 398	3,30 113	8,15 169	4,87 171
70 673 025 / 70 672 025		8,69 398	3,30 113	8,15 169	4,87 171



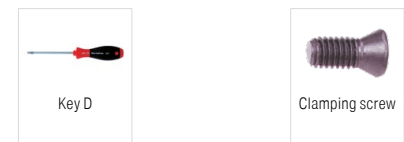
MaxiLock-S – STCC 90° – Toolholder with screw clamping



ISO designation	H mm	B mm	OAL mm	LH mm	torque moment Nm	Insert	Neutral 70 782 ...	
							EUR 2A/24	
STCC N 0808 K09	8	8	125	11	1	TC.. 0902	63,97	008
STCC N 1010 K11	10	10	125	15	1,2	TC.. 1102	67,82	010
STCC N 1212 K11	12	12	125	15	1,2	TC.. 1102	75,86	012
STCC N 1414 K11	14	14	125	21	1,2	TC.. 1102	75,86	014
STCC N 1616 K11	16	16	125	24	1,2	TC.. 1102	84,00	016

Spare parts
for Article no.

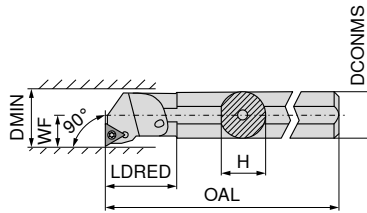
	80 950 ...	70 950 ...
70 782 008	EUR Y7 8,03	EUR 2A/28 110
70 782 010	8,03 109	M2,2x5 2,70 111
70 782 012	8,03 110	M2,5x6 2,43 112
70 782 014	8,03 110	M2,5x6 2,43 112
70 782 016	8,03 110	M2,5x6 2,43 112



MaxiLock-S – STFC 90° – Boring bar with screw clamping

▲ A... = with thro' coolant

▲ S... = without thro' coolant



Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									70 729 ...		70 728 ...	
									EUR 2A/24		EUR 2A/24	
A10H STFC R/L 09	10	9,5	100	19	7	13	1	TC.. 0902	101,40	210	101,40	210
A12K STFC R/L 11	12	11,5	125	22	9	16	1,2	TC.. 1102	101,40	212	101,40	212
A16M STFC R/L 11	16	15,0	150	29	11	20	1,2	TC.. 1102	103,60	216	103,60	216
S16R STFC R 11	16	15,0	200		11	21	1,2	TC.. 1102			103,60	016
A20Q STFC R/L 11	20	18,5	180	32	13	25	1,2	TC.. 1102	129,20	220	129,20	220
S20S STFC R 11	20	18,0	250		13	25	1,2	TC.. 1102			129,20	020
A25R STFC R/L 16	25	24,0	200	36	17	32	3,2	TC.. 16T3	148,50	225	148,50	225
A32S STFC R/L 16	32	31,0	250	50	22	40	3,2	TC.. 16T3	204,10	232	204,10	232
A40T STFC R/L 16	40	39,0	300	60	27	50	3,2	TC.. 16T3	245,10	240	245,10	240

Spare parts
for Article no.

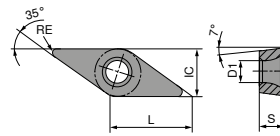
		70 950 ...		70 950 ...		70 950 ...	
		EUR 2A/28		EUR 2A/28		EUR 2A/28	
70 729 210 / 70 728 210	M2,2x5	2,70	111				
70 729 212 / 70 728 212	M2,5x6	2,43	112				
70 729 216 / 70 728 216	M2,5x6	2,43	112				
70 728 016	M2,5x6	2,43	112				
70 729 220 / 70 728 220	M2,5x6	2,43	112				
70 728 020	M2,5x6	2,43	112				
70 729 225 / 70 728 225	M3,5x11	3,30	113	8,15	169	M3,5	4,87 171
70 729 232 / 70 728 232	M3,5x11	3,30	113	8,15	169	M3,5	4,87 171
70 729 240 / 70 728 240	M3,5x11	3,30	113	8,15	169	M3,5	4,87 171

Spare parts
for Article no.

		80 950 ...		70 950 ...	
		EUR Y7		EUR 2A/28	
70 729 210 / 70 728 210	T07	8,03	109		
70 729 212 / 70 728 212	T08	8,03	110		
70 729 216 / 70 728 216	T08	8,03	110		
70 728 016	T08	8,03	110		
70 729 220 / 70 728 220	T08	8,03	110		
70 728 020	T08	8,03	110		
70 729 225 / 70 728 225				T15/SW	8,69 398
70 729 232 / 70 728 232				T15/SW	8,69 398
70 729 240 / 70 728 240				T15/SW	8,69 398

VC GT / VC MT / VC ET

Designation	L mm	S mm	D1 mm	IC mm
VCET 1103..	11,1	3,18	2,8	6,35
VC.T 1103..	11,1	3,18	2,9	6,35
VC.T 1604..	16,6	4,76	4,4	9,52
VC GT 2205..	22,1	5,56	5,5	12,70



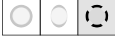
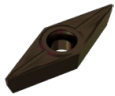
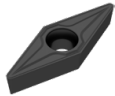
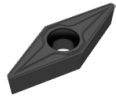
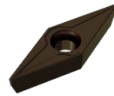
VC GT / VC MT

		-CF05 CTEP110		-CF55 CTEP110		-SF TCM10		-SF TCM407		-SMF TCM10		-SF CTCP115		-SF CTCP115	
		DRAGONSKIN		DRAGONSKIN								DRAGONSKIN		DRAGONSKIN	
		F		F		F		F		F		F		F	
		CERMET		CERMET		CERMET		CERMET		CERMET		VCMT		VC GT	
		76 276 ...		76 292 ...		70 277 ...		70 277 ...		70 288 ...		76 279 ...		76 277 ...	
ISO	RE mm	EUR 1A/78		EUR 1A/78		EUR 1A/78		EUR 1A/78		EUR 1A/78		EUR 1A/08		EUR 1A/08	
110301EN	0,1					16,10	892	16,10	844					16,80	314
110302EN	0,2	17,64	014			16,10	894	16,10	846					16,80	316
110304EN	0,4	17,64	016	13,69	016	16,10	896	16,10		12,93	896			16,80	318
110308EN	0,8														
160404EN	0,4	21,03	028	16,80	028	20,33	900	20,33	850	15,99	900	16,80	328		
160408EN	0,8	21,03	030	16,80	030	20,33	902			15,99	902	16,80	330		
P			●		●		●		●		●		●		●
M			○		○		○		○		○		○		○
K			○		○		○		○		○		○		○
N															
S															
H															
O															

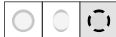
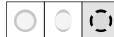
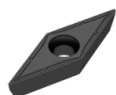
VC GT / VC MT

		-SF CTCP125		-SF CTCP125		-SF CTCP135		-SF CTCP135		-SMF CTCP115		-SMF CTCP125		-SMF CTCP135	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		F		F		F		F		F		F		F	
		VC GT		VC MT		VC GT		VC MT		VC MT		VC MT		VC GT	
		76 277 ...		76 279 ...		76 277 ...		76 279 ...		76 288 ...		76 288 ...		76 285 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
110302EN	0,2	16,80	514			16,80	714							16,80	714
110304EN	0,4	16,80	516			16,80	716			14,45	316	14,45	516		
110308EN	0,8	16,80	518			16,80	718								
160404EN	0,4			16,80	528			16,80	728	16,80	328	16,80	528		
160408EN	0,8			16,80	530					16,80	330	16,80	530		
P			●		●		●		●		●		●		●
M			○		○		○		○		○		○		○
K			○		○		○		○		○		○		○
N															
S															
H															
O															

VCMT

		-SMF CTCP135		-SM CTCK110		-SM CTCK120		-SM CTCP115		-SM CTCP125		-SM CTCP135	
		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin	
													
													
		F VCMT		M VCMT		M VCMT		M VCMT		M VCMT		M VCMT	
		76 288 ...		70 278 ...		70 278 ...		76 278 ...		76 278 ...		76 278 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
110304EN	0,4	14,45		716									
160404EN	0,4	16,80		728		16,80 028		16,80 328		16,80 528		16,80 728	
160406EN	0,6					16,80 528		16,80 329		16,80 528		16,80 728	
160408EN	0,8	16,80		730		16,80 030		16,80 330		16,80 530		16,80 730	
160412EN	1,2			16,80 032		16,80 532		16,80 33200		16,80 53200		16,80 732	
P		●		○		○		●		●		●	
M		○										○	
K				●		●		○		○			
N													
S													
H													
O													

VCMT

		NEW -M25 CTCM120		-M25 CTPM125		NEW -M25 CTCM130		NEW -M55 CTCM120		-M55 CTPM125		NEW -M55 CTCM130	
		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin	
													
													
		F VCMT		F VCMT		F VCMT		M VCMT		M VCMT		M VCMT	
		75 219 ...		75 219 ...		75 219 ...		75 220 ...		75 220 ...		75 220 ...	
ISO	RE mm	EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08		EUR 1A/08	
160404EN	0,4	16,80 12800		16,80 228		16,80 32800		16,80 12800		16,80 228		16,80 32800	
160408EN	0,8	16,80 13000		16,80 23000		16,80 33000		16,80 13000		16,80 230		16,80 33000	
P		○		○		○		○		○		○	
M		●		●		●		●		●		●	
K													
N													
S						○						○	
H													
O													

9

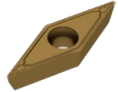
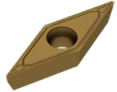
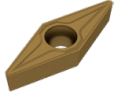
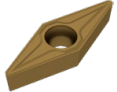
VCGT / VCMT

		-25P H210T		NEW -25P CTPX710		-25Q H210T		-27 H10T		-27 CWN15		NEW -27 CTPX715		NEW -29 H216T	
				 DRAGONSKIN								 DRAGONSKIN			
		F VCGT		M VCGT		M VCGT		M VCGT		M VCGT		M VCGT		M VCMT	
		70 282 ...		70 282 ...		70 282 ...		70 280 ...		70 280 ...		70 280 ...		70 247 ...	
ISO	RE mm	EUR 1A/90		EUR 1A/90		EUR 1A/90		EUR 1A/90		EUR 1A		EUR 1A/90		EUR 1A/90	
110302FN	0,2	15,86	638	18,21	71400			15,14	606	17,82	306	17,75	81400		
110304FL	0,4					17,64	670								
110304FN	0,4	15,86	640	18,21	71600	17,64	680	15,14	608	17,82	308	17,75	81600		
110304FR	0,4														
110308FN	0,8							15,14	610	17,82	310				
160404EN	0,4													14,22	62800
160404FN	0,4	19,38	642	22,56	72800			18,45	612	21,00	312	21,50	82800		
160408EN	0,8													14,22	63000
160408FN	0,8	19,38	644	22,56	73000			18,45	614	21,00	314	21,50	83000		
160412EN	1,2													14,22	63200
160412FN	1,2	19,38	646	22,56	73200			18,45	616	21,00	316				
220530FN	3,0	26,20	648	30,07	75000			25,03	618						
P				•										•	
M				•						○				•	
K			○			○		○				○		○	
N			•	•		•		•		•		•		•	
S			○	•		○						•			
H															
O			○			○		○				○		○	

VCET

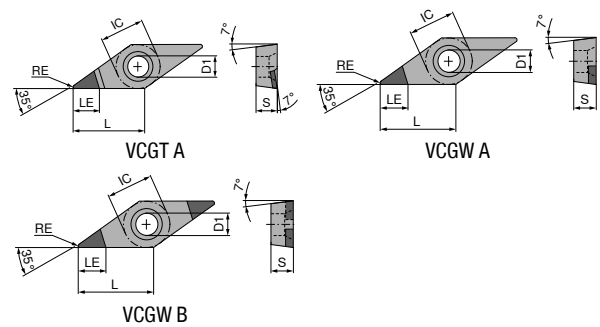
		NEW -F05 CTPX710	
		 DRAGONSKIN	
		F VCET	
		76 255 ...	
ISO	RE mm	EUR 1H/17	
1103005FN	0,05	24,45	11400
1103015FN	0,15	24,45	11800
110301FN	0,10	24,45	11600
110302FN	0,20	24,45	12000
110304FN	0,40	24,45	12200
P			•
M			•
K			
N			•
S			•
H			
O			

VCMT

		NEW		NEW		NEW		NEW	
		-FMS CT-P15		-FMS CT-P25		-MRS CT-P15		-MRS CT-P25	
									
									
		F VCMT		F VCMT		M VCMT		M VCMT	
		75 308 ...		75 308 ...		75 309 ...		75 309 ...	
ISO	RE mm	EUR 1S/1P		EUR 1S/1P		EUR 1S/1P		EUR 1S/1P	
110304EN	0,4	4,42	01609	4,42	11609				
160404EN	0,4	4,47	02809	4,47	12809	4,47	02809	4,47	12809
160408EN	0,8	4,47	03009	4,47	13009	4,47	03009	4,47	13009
P			●		●		●		●
M			○		○		○		○
K									
N									
S									
H									
O									

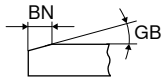
VCGW / VCGT

Designation	L mm	S mm	D1 mm	IC mm
VCG. 1103..	11,1	3,18	2,9	6,35
VCG. 1604..	16,6	4,76	4,4	9,52
VCGW 0702..	6,9	2,38	2,2	3,97



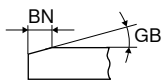
VCGW

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



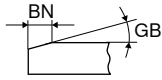
						NEW		NEW		NEW	
						CTBS10U	CTBS20U	CTBS20C	CTBH15U	CTBH15C	
						F	F	F	F	F	
						CBN	CBN	CBN	CBN	CBN	
						VCGW	VCGW	VCGW	VCGW	VCGW	
						71 160 ...	71 429 ...	71 165 ...	71 036 ...	71 035 ...	
ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0	
110302SN	0,2	0,11	15°	B (2)	3,4				74,37	32014	71,93 32014
110302TN	0,2	0,12	15°	A (1)	4,7						
110302FN	0,2			A (1)	4,7	43,86	54,78 20000				
110302TN	0,2	0,12	20°	A (1)	4,7	43,86					
110302SN	0,2	0,14	25°	B (2)	3,4				74,37	32029	71,93 32029
110302EN	0,2			B (2)	3,4				74,37	02000	71,93 02000
110304SN	0,4	0,09	10°	B (2)	3,1			59,35			
110304SN	0,4	0,11	15°	B (2)	3,1			59,35			
110304TN	0,4	0,12	20°	A (1)	4,5	43,86			74,37	32214	71,93 32214
110304TN	0,4	0,15	20°	B (2)	3,1			59,35			
110304SN	0,4	0,16	20°	B (2)	3,1			59,35			
110304SN	0,4	0,14	25°	B (2)	3,1						71,93 32229
110304SN	0,4	0,18	25°	B (2)	3,1			59,35			
110304FN	0,4			A (1)	4,5	43,86					
110304EN	0,4			B (2)	3,1				74,37	02200	71,93 02200
110308SN	0,8	0,09	10°	B (2)	2,5			59,35			
110308SN	0,8	0,11	15°	B (2)	2,5			59,35			
110308TN	0,8	0,12	20°	A (1)	4,2	43,86			74,37	32414	71,93 32414
110308SN	0,8	0,16	20°	B (2)	2,5			59,35			
110308SN	0,8	0,14	25°	B (2)	3,1				74,37	32229	
110308SN	0,8	0,14	25°	B (2)	2,5				74,37	32429	71,93 32429
110308TN	0,8	0,17	25°	B (2)	2,5			59,35			
110308SN	0,8	0,18	25°	B (2)	2,5			59,35			
110308FN	0,8			A (1)	4,2	43,86					
110308EN	0,8			B (2)	2,5			59,35	74,37	02400	71,93 02400
160402SN	0,2	0,11	15°	B (2)	3,4				74,37	33614	71,93 33614
160402TN	0,2	0,12	20°	A (1)	5,3	49,21					
160404SN	0,2	0,14	25°	B (2)	3,4				74,37	33629	
160402FN	0,2			B (2)	3,4						71,93 23600
160402SN	0,2	0,14	25°	A (1)	5,3	49,21					71,93 33629
160402SN	0,2			B (2)	3,4						
160404SN	0,4	0,09	10°	B (2)	3,1			59,35			
160404SN	0,4	0,11	15°	B (2)	3,1			59,35	74,37	33814	71,93 33814
P											
M											
K							•	•	•		
N											
S							•	•	•		
H										•	•
O											

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

9

VCGW / VCGT

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

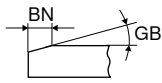


ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	CTBH20U		CTBH21U		NEW CTBH21U		NEW CTBH21U		CTBH20C	
						F	CBN VCGW	F	CBN VCGW	F	CBN VCGW	F	CBN VCGT	F	CBN VCGW
						71 160 ...	EUR Y0	71 160 ...	EUR Y0	71 430 ...	EUR Y0	71 428 ...	EUR Y0	71 165 ...	EUR Y0
070202TN	0,2	0,13	25°	A (1)	3,5				43,86	55000					
070204FN	0,4			A (1)	3,2				43,86	45000					
110302TN	0,2	0,12	20°	A (1)	4,7	43,86	500				71,51	40100			
110302TN	0,2	0,13	25°	B (2)	3,5										
110302FN	0,2			A (1)	4,7	43,86	400 1)				71,51	40000			
110302FN	0,2			B (2)	3,5										
110304FN	0,4			A (1)	3,2										
110304SN	0,4	0,09	20°	B (2)	3,1							54,78	40000	59,35	251
110304TN	0,4	0,12	20°	A (1)	4,5	43,86	502								
110304TN	0,4	0,13	25°	B (2)	3,2					71,51	40300			59,35	261
110304TN	0,4	0,14	25°	B (2)	3,1									59,35	271
110304SN	0,4	0,15	25°	B (2)	3,1									59,35	221
110304FN	0,4			B (2)	3,2					71,51	40200			59,35	211
110304EN	0,4			B (2)	3,1									59,35	221
110304FN	0,4			A (1)	4,5	43,86	402 1)							59,35	211
110304FN	0,4			B (2)	3,1									59,35	211
110308SN	0,8	0,11	15°	B (2)	2,5									59,35	242
110308SN	0,8	0,09	20°	B (2)	2,5									59,35	252
110308TN	0,8	0,12	20°	A (1)	4,2	43,86	504							59,35	262
110308TN	0,8	0,14	25°	B (2)	2,5									59,35	272
110308SN	0,8	0,15	25°	B (2)	2,5									59,35	282
110308SN	0,8	0,18	30°	B (2)	2,5									59,35	282
110308FN	0,8			A (1)	4,2	43,86	404 1)							59,35	222
110308EN	0,8			B (2)	2,5									59,35	222
160402FN	0,2			A (1)	3,5				49,21	43000		54,78	40100		
160402TN	0,2	0,12	20°	A (1)	5,3	49,21	505								
160402TN	0,2	0,13	25°	A (1)	3,5				49,21	52000					
160402TN	0,2	0,13	25°	B (2)	3,5					71,51	40400				
160402FN	0,2			A (1)	5,3	49,21	405 1)								
160404SN	0,4	0,11	15°	B (2)	3,1									59,35	24400
160404SN	0,4	0,09	20°	B (2)	3,1									59,35	255
160404TN	0,4	0,12	20°	A (1)	5,0	49,21	506								
160404TN	0,4	0,13	25°	B (2)	3,2					71,51	40600				
160404FN	0,4			B (2)	3,2					71,51	40500				
160404TN	0,4	0,13	25°	A (1)	3,2				49,21	52200					
160404TN	0,4	0,14	25°	B (2)	3,1									59,35	265
160404FN	0,4			A (1)	3,2				49,21	41200				59,35	225
160404EN	0,4			B (2)	3,1									59,35	215
160404FN	0,4			A (1)	5,0	49,21	406 1)							59,35	215
160404FN	0,4			B (2)	3,1									59,35	215
160408SN	0,8	0,11	15°	B (2)	2,5									59,35	246
160408SN	0,8	0,09	20°	B (2)	2,5									59,35	256
160408TN	0,8	0,12	20°	A (1)	4,4	49,21	508								
160408TN	0,8	0,13	25°	B (2)	2,8					71,51	40800			59,35	266
160408TN	0,8	0,14	25°	B (2)	2,5									59,35	276
160408SN	0,8	0,15	25°	B (2)	2,5									59,35	286
160408SN	0,8	0,18	30°	B (2)	2,5									59,35	286
160408FN	0,8			A (1)	4,4	49,21	408 1)							59,35	226
160408FN	0,8			B (2)	2,8					71,51	40700			59,35	226
160408EN	0,8			B (2)	2,5									59,35	226
160412TN	1,2	0,12	20°	A (1)	3,9	49,21	510								
P															
M															
K															
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1) Machining to 60 HRC

VCGW

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

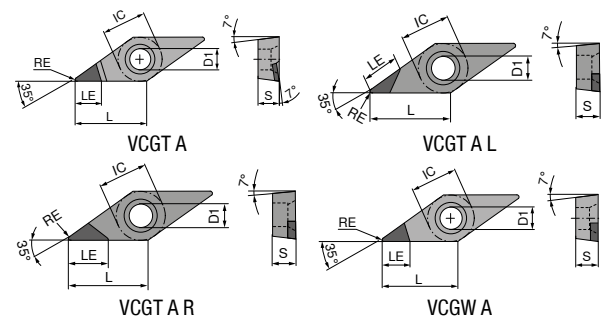


ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm	CTBH40U	CTBH40C	CTBH41U	CTBH41U
070202FN	0,2			A (1)	3,5				
070204FN	0,4			A (1)	3,2				
110302FN	0,2			A (1)	4,7				
110302TN	0,2	0,12	25°	A (1)	4,7				
110302FN	0,2			B (2)	3,5				
110304SN	0,4	0,09	20°	B (2)	3,1				
110304SN	0,4	0,09	25°	B (2)	3,1				
110304TN	0,4	0,11	25°	B (2)	3,1				
110304TN	0,4	0,12	25°	A (1)	4,5				
110304TN	0,4	0,14	30°	B (2)	3,1				
110304SN	0,4	0,17	35°	B (2)	3,1				
110304FN	0,4			A (1)	4,5				
110304FN	0,4			B (2)	3,2				
110308SN	0,8	0,09	20°	B (2)	2,5				
110308SN	0,8	0,09	25°	B (2)	2,5				
110308TN	0,8	0,11	25°	B (2)	2,5				
110308TN	0,8	0,14	30°	B (2)	2,5				
110308SN	0,8	0,16	30°	B (2)	2,5				
110308SN	0,8	0,17	35°	B (2)	2,5				
110308FN	0,8			A (1)	4,2				
110308EN	0,8			B (2)	2,5				
160402FN	0,2			A (1)	5,3				
160402FN	0,2			A (1)	3,5				
160402TN	0,2	0,12	25°	A (1)	5,3				
160402FN	0,2			B (2)	3,5				
160404SN	0,4	0,09	20°	B (2)	3,1				
160404SN	0,4	0,09	25°	B (2)	3,1				
160404TN	0,4	0,11	25°	B (2)	3,1				
160404TN	0,4	0,12	25°	A (1)	5,0				
160404TN	0,4	0,08	30°	A (1)	3,2				
160404TN	0,4	0,14	30°	B (2)	3,1				
160404SN	0,4	0,17	35°	B (2)	3,1				
160404FN	0,4			A (1)	3,2				
160404FN	0,4			A (1)	5,0				
160404FN	0,4			B (2)	3,2				
160408SN	0,8	0,09	20°	B (2)	2,5				
160408SN	0,8	0,09	25°	B (2)	2,5				
160408TN	0,8	0,11	25°	B (2)	2,5				
160408TN	0,8	0,12	25°	A (1)	4,4				
160408TN	0,8	0,14	30°	B (2)	2,5				
160408SN	0,8	0,16	30°	B (2)	2,5				
160408SN	0,8	0,17	35°	B (2)	2,5				
160408EN	0,8			B (2)	2,5				
160408FN	0,8			A (1)	4,4				
160408FN	0,8			A (1)	2,8				
160408FN	0,8			B (2)	2,8				
160412TN	1,2	0,12	25°	A (1)	3,9				

P				
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O				

VCGT / VCGW

Designation	L mm	S mm	D1 mm	IC mm
VCG. 0702..	6,9	2,38	2,2	3,97
VCG. 1103..	11,1	3,18	2,9	6,35
VCG. 1103..	11,1	3,18	2,8	6,35
VCG. 1303..	13,3	3,18	3,4	7,94
VCG. 1604..	16,6	4,76	4,4	9,52



VCGT / VCGW

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

				NEW													
				CTDMD05		CTDMD05		CTDPD20		CTDPD20		CTDPD20		CTDPD20		CTDPD20	
				O		O		O		O		O		O		O	
				F		F		F		F		F		F		F	
				DIAMOND		DIAMOND		DIAMOND		DIAMOND		DIAMOND		DIAMOND		DIAMOND	
				VCGT		VCGW		VCGW		VCGT		VCGT		VCGT		VCGT	
				71 189 ...		71 160 ...		71 160 ...		71 062 ...		71 063 ...		71 064 ...			
ISO	RE mm	TCE (NOI)	LE mm	EUR		EUR		EUR		EUR		EUR		EUR		EUR	
070202FN	0,2	A (1)		533,40	50001												
070204FN	0,4	A (1)		533,40	50101												
110301FN	0,1	A (1)	5,4							61,29	10100						
110302FN	0,2	A (1)	3,0			354,30	050										
110302FN	0,2	A (1)	4,6	553,30	50201			59,14	100	61,29	100						
110304FN	0,4	A (1)	3,0			354,30	052										
110304FN	0,4	A (1)	3,9	553,30	50301			59,14	102	61,29	102						
110304FN	0,4	A (1)	6,5									78,50	102				
110304FL	0,4	A (1)	6,5													78,50	102
110308FN	0,8	A (1)	3,3					61,29	104	61,29	104						
110308FR	0,8	A (1)	6,0									78,50	104				
110308FL	0,8	A (1)	6,0													78,50	104
160401FN	0,1	A (1)	6,0							67,10	10700						
160402FN	0,2	A (1)	5,9					63,68	105	67,10	105						
160402FN	0,2	A (1)		553,30	50401												
160404FN	0,4	A (1)	5,5					64,82	106	67,10	106						
160404FR	0,4	A (1)	7,5									84,18	106				
160404FN	0,4	A (1)		553,30	50501												
160404FL	0,4	A (1)	7,5													84,18	106
160408FN	0,8	A (1)	5,0			516,80	07800	67,10	108	67,10	108						
160408FR	0,8	A (1)	7,0									84,18	108				
160408FN	0,8	A (1)		628,60	50601												
160408FL	0,8	A (1)	7,0													84,18	108
160412FN	1,2	A (1)	4,5					72,68	110	77,13	110						
160412FR	1,2	A (1)	7,0									89,67	110				
160412FL	1,2	A (1)	7,0													89,67	110
P																	
M																	
K																	
N																	
S																	
H																	
O																	

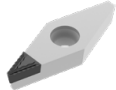
VCGT / VCGW

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

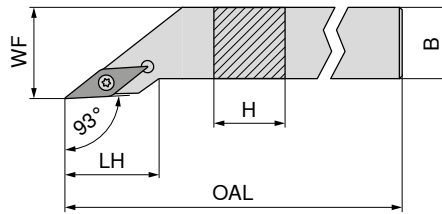
				-CB1 CTDPD20  F DIAMOND VCGT 71 330 ...	NEW CTDPS30  F DIAMOND VCGW 71 191 ...	NEW CTDPS30  F DIAMOND VCGT 71 189 ...	-CB1 CTDPS30  F DIAMOND VCGT 71 330 ...	-CB2 CTDPS30  M DIAMOND VCGT 71 331 ...	NEW CTDPU20  F DIAMOND VCGW 71 191 ...	
ISO	RE mm	TCE (NOI)	LE mm	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0	EUR Y0
070201FN	0,1	A (1)	3,8							
070202FN	0,2	A (1)	3,6		63,63 20001	63,63 20001				
070204FN	0,4	A (1)	3,2		63,63 20101					
110301FN	0,1	A (1)	5,4	87,15 11000	71,93 20201	71,93 20101				
110302FN	0,2	A (1)	4,6	87,15 112	71,93 20301	71,93 20201	87,15 21200	84,53 212		
110304FN	0,4	A (1)	3,9	87,15 114	71,93 20401	71,93 20301	87,15 214	87,15 214		
110308FN	0,8	A (1)	3,3					87,15 21800		
130302FN	0,2	A (1)	5,9		74,70 20501	74,70 20401				
160401FN	0,1	A (1)	6,0		74,70 20601	74,70 20501				
160402FN	0,2	A (1)	5,9	91,14 13200		74,70 20601		91,14 23200		
160404FN	0,4	A (1)	5,5	91,14 134	74,70 20701	74,70 20701	91,14 234	91,14 234		77,46 30001
160408FN	0,8	A (1)	5,0	100,30 138	74,70 20801		100,30 238	100,30 238		
160412FN	1,2	A (1)	4,5	100,30 14000	83,00 20901		100,30 24000	110,80 242		
P										
M										
K										
N										
S										
H										
O										

VCGT / VCGW

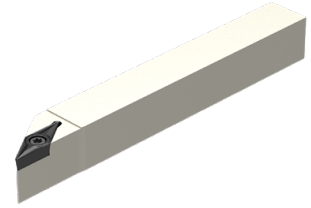
▲ TCE(NOI) = Design and number of equipped cutting edge corners

				NEW		NEW		NEW		NEW	
				-CB2 CTDPU20		-CB3 CTDPU20		CTDCD10		-CB1 CTDCD10	
											
											
				M DIAMOND VCGT		R DIAMOND VCGT		F DIAMOND VCGW		F DIAMOND VCGT	
				71 190 ...		71 332 ...		71 191 ...		71 330 ...	
ISO	RE mm	TCE (NOI)	LE mm	EUR Y0		EUR Y0		EUR Y0		EUR Y0	
110301FN	0,1	A (1)	3,0								
110302FN	0,2	A (1)	3,0								
110304FN	0,4	A (1)	3,0								
110304FN	0,4	A (1)	3,9			87,15	214				
110308FN	0,8	A (1)	3,0								
160402FN	0,2	A (1)	3,0								
160404FN	0,4	A (1)	3,0								
160404FN	0,4	A (1)	5,5	99,60	30001	91,14	234				
160408FN	0,8	A (1)	3,0								
160412FN	1,2	A (1)	3,0								
P											
M											
K											
N											
S											
H											
O											

MaxiLock-S – SVJC 93° – Toolholder with screw clamping



Illustrations show right-hand versions



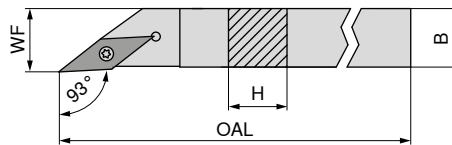
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 697 ...		Right-hand 70 696 ...	
								EUR 2A/24		EUR 2A/24	
SVJC R/L 1212 F11	12	12	80	21,5	16	1,2	VC.. 1103	83,23	012	83,23	012
SVJC R/L 1616 H11	16	16	100	21,5	20	1,2	VC.. 1103	92,37	016	92,37	016
SVJC R/L 2020 K11	20	20	125	23,0	25	1,2	VC.. 1103	106,00	020	106,00	020
SVJC R/L 2525 M11	25	25	150	25,5	32	1,2	VC.. 1103	113,60	025	113,60	025
SVJC R/L 2020 K16	20	20	125	29,5	25	3,2	VC.. 1604	106,00	120	106,00	120
SVJC R/L 2525 M16	25	25	150	32,5	32	3,2	VC.. 1604	113,60	125	113,60	125
SVJC R/L 3225 P16	32	25	170	32,5	32	3,2	VC.. 1604	122,50	132	122,50	132

Spare parts
Insert

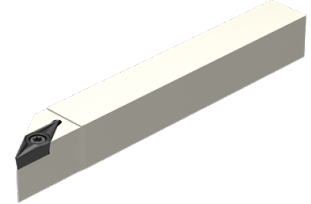
Insert	EUR Y7		EUR 2A/28		EUR 2A		EUR 2A/28		EUR 2A/28	
VC.. 1103	8,03	110			2,43	112				
VC.. 1604			8,69	398	3,30	113	10,56	107	4,87	171

	Key D		Combination Key		Clamping screw		Solid Carbide Seat V		Threaded sleeve
80 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	
EUR Y7		EUR 2A/28		EUR 2A		EUR 2A/28		EUR 2A/28	

MaxiLock-S – SVJC 93° – Toolholder with screw clamping



Illustrations show right-hand versions



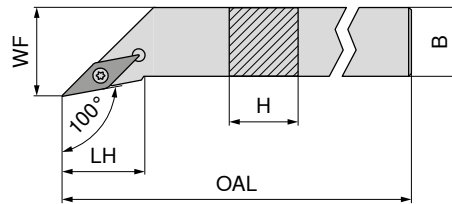
ISO designation	H mm	B mm	OAL mm	WF mm	torque moment Nm	Insert	Left-hand 70 697 ...		Right-hand 70 696 ...	
							EUR X0		EUR X0	
SVJC R/L 0808 H11	8	8	100	8	1,2	VC.. 1103	87,05	008	87,05	008
SVJC R/L 1010 H11	10	10	100	10	1,2	VC.. 1103	87,05	010	87,05	010
SVJC R/L 1212 H11	12	12	100	12	1,2	VC.. 1103	100,20	112	100,20	112
SVJC R/L 1616 K11	16	16	125	16	1,2	VC.. 1103	109,10	116	109,10	116

Spare parts
Insert

Insert	EUR Y7		EUR 2A	
VC.. 1103	8,03	110	2,43	112

	Key D		Clamping screw
80 950 ...		70 950 ...	
EUR Y7		EUR 2A	

MaxiLock-S – SVZC 100° – Toolholder with screw clamping



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand		Right-hand	
								70 701 ...		70 700 ...	
SVZC R/L 2525 M16	25	25	150	28,5	32	3,2	VC.. 1604	EUR 2A/24 113,60	025	EUR 2A/24 113,60	025

Spare parts for Article no.	70 950 ...		70 950 ...		70 950 ...		70 950 ...	
	EUR 2A/28 8,69	398	EUR 2A/28 3,30	113	EUR 2A/28 10,56	107	EUR 2A/28 4,87	171
70 701 025 / 70 700 025	T15/SW		M3,5x11		M3,5			

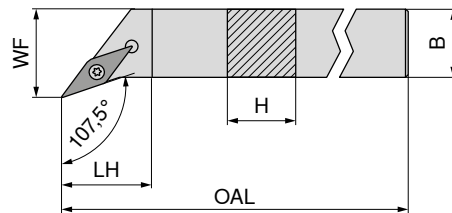
Combination Key

Clamping screw

Solid Carbide
Seat V

Threaded sleeve

MaxiLock-S – SVHC 107.5° – Toolholder with screw clamping



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand		Right-hand	
								70 705 ...		70 704 ...	
SVHC R/L 1212 F11	12	12	80	11,4	16	1,2	VC.. 1103	EUR 2A/24 83,23	012	EUR 2A/24 83,23	012
SVHC R/L 1616 H11	16	16	100	11,4	20	1,2	VC.. 1103	EUR 2A/24 92,37	016	EUR 2A/24 92,37	016
SVHC R/L 2020 K11	20	20	125	14,6	25	1,2	VC.. 1103	EUR 2A/24 106,00	020	EUR 2A/24 106,00	020
SVHC R/L 2525 M11	25	25	150	20,9	32	1,2	VC.. 1103	EUR 2A/24 113,60	025	EUR 2A/24 113,60	025
SVHC R/L 2020 K16	20	20	125	13,2	25	3,2	VC.. 1604	EUR 2A/24 106,00	120	EUR 2A/24 106,00	120
SVHC R/L 2525 M16	25	25	150	19,6	32	3,2	VC.. 1604	EUR 2A/24 113,60	125	EUR 2A/24 113,60	125
SVHC R/L 3225 P16	32	25	170	19,6	32	3,2	VC.. 1604	EUR 2A/24 122,50	132	EUR 2A/24 122,50	132
SVHC R/L 2525 M22	25	25	150	19,6	32	5	VC.. 2205	EUR 2A/24 113,60	225	EUR 2A/24 113,60	225
SVHC R/L 3225 P22	32	25	170	19,6	32	5	VC.. 2205	EUR 2A/24 122,50	232	EUR 2A/24 122,50	232

Spare parts for Article no.	80 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	
	EUR Y7 8,03	110	EUR 2A/28 8,69	398	EUR 2A 3,30	113	EUR 2A/28 10,56	107	EUR 2A/28 4,87	171
70 704 012 / 70 705 012	8,03	110			2,43	112				
70 704 016 / 70 705 016	8,03	110			2,43	112				
70 704 020 / 70 705 020	8,03	110			2,43	112				
70 704 025 / 70 705 025	8,03	110			2,43	112				
70 704 120 / 70 705 120			8,69	398	3,30	113	10,56	107	4,87	171
70 704 125 / 70 705 125			8,69	398	3,30	113	10,56	107	4,87	171
70 704 132 / 70 705 132			8,69	398	3,30	113	10,56	107	4,87	171
70 704 225 / 70 705 225			8,69	398	2,70	114	14,02	109	4,87	170
70 704 232 / 70 705 232			8,69	398	2,70	114	14,02	109	4,87	170

Key D

Combination Key

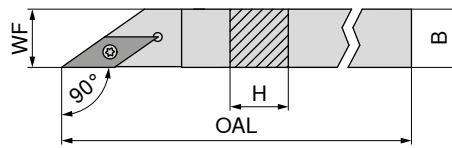
Clamping screw

Solid Carbide
Seat V

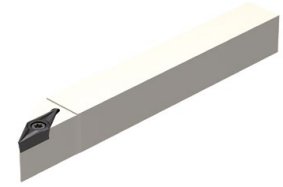
Threaded sleeve

MaxiLock-S – SVAC 90° – Toolholder with screw clamping

▲ for sliding head lathes



Illustrations show right-hand versions

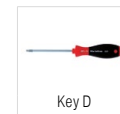


ISO designation	H mm	B mm	OAL mm	WF mm	torque moment Nm	Insert
SVAC R/L 0808 H11	8	8	100	8	1,2	VC.. 1103
SVAC R/L 1010 H11	10	10	100	10	1,2	VC.. 1103
SVAC R/L 1212 H11	12	12	100	12	1,2	VC.. 1103

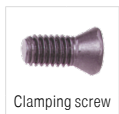
Left-hand		Right-hand	
70 695 ...		70 694 ...	
EUR		EUR	
X0		X0	
87,05	008	87,05	008
87,05	010	87,05	010
100,20	012	100,20	012

Spare parts for Article no.

70 694 008 / 70 695 008	T08	8,03	110	M2,5x6	2,43	112
70 694 010 / 70 695 010	T08	8,03	110	M2,5x6	2,43	112
70 694 012 / 70 695 012	T08	8,03	110	M2,5x6	2,43	112



Key D



Clamping screw

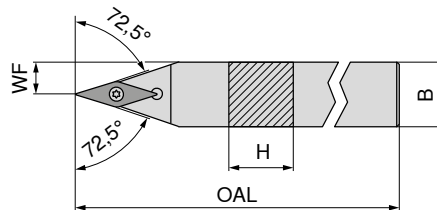
80 950 ...

EUR	
Y7	
8,03	110
8,03	110
8,03	110

70 950 ...

EUR	
2A	
2,43	112
2,43	112
2,43	112

MaxiLock-S – SVVC 72.5° – Toolholder with screw clamping



ISO designation	H mm	B mm	OAL mm	WF mm	torque moment Nm	Insert
SVVC N 1212 F11	12	12	80	6,0	1,2	VC.. 1103
SVVC N 1616 H11	16	16	100	8,0	1,2	VC.. 1103
SVVC N 2020 K11	20	20	125	10,0	1,2	VC.. 1103
SVVC N 2525 M11	25	25	150	12,5	1,2	VC.. 1103
SVVC N 2020 K16	20	20	125	10,0	3,2	VC.. 1604
SVVC N 2525 M16	25	25	150	12,5	3,2	VC.. 1604
SVVC N 3225 P16	32	25	170	12,5	3,2	VC.. 1604

Neutral
70 692 ...

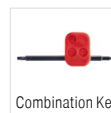
EUR		EUR		EUR		EUR		EUR	
2A/24		2A/28		2A		2A/28		2A/28	
83,23	012			2,43	112				
92,37	016			2,43	112				
106,00	020			2,43	112				
113,60	025			2,43	112				
106,00	120			3,30	113	10,56	107	4,87	171
113,60	125			3,30	113	10,56	107	4,87	171
122,50	132			3,30	113	10,56	107	4,87	171

Spare parts for Article no.

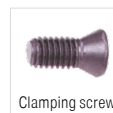
70 692 012	8,03	110							
70 692 016	8,03	110							
70 692 020	8,03	110							
70 692 025	8,03	110							
70 692 120			8,69	398	3,30	113	10,56	107	4,87
70 692 125			8,69	398	3,30	113	10,56	107	4,87
70 692 132			8,69	398	3,30	113	10,56	107	4,87



Key D



Combination Key



Clamping screw



Solid Carbide
Seat V



Threaded sleeve

80 950 ...

EUR	
Y7	
8,03	110
8,03	110
8,03	110
8,03	110

70 950 ...

EUR	
2A/28	
8,69	398
8,69	398
8,69	398

70 950 ...

EUR	
2A	
2,43	112
2,43	112
2,43	112
2,43	112

70 950 ...

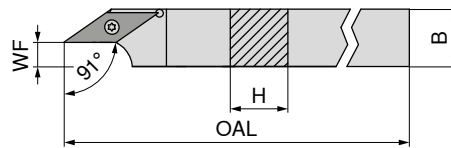
EUR	
2A/28	
10,56	107
10,56	107
10,56	107

70 950 ...

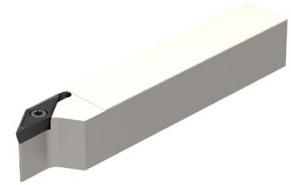
EUR	
2A/28	
4,87	171
4,87	171
4,87	171

MaxiLock-S – SVXC 91° – Toolholder with screw clamping

▲ for sliding head lathes



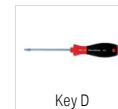
Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	WF mm	torque moment Nm	Insert	Left-hand 70 691 ...		Right-hand 70 690 ...	
							EUR X0		EUR X0	
SVXC R/L 1010 H11	10	10	100	3,4	1,2	VC.. 1103	87,05	010	87,05	010
SVXC R/L 1212 H11	12	12	100	5,4	1,2	VC.. 1103	100,20	012	100,20	012
SVXC R/L 1616 K11	16	16	125	8,9	1,2	VC.. 1103	109,10	016	109,10	016
SVXC R/L 2020 K16	20	20	125	10,4	3,2	VC.. 1604	125,30	020	125,30	020

Spare parts for Article no.

70 691 010 / 70 690 010	T08	8,03	110	M2,5x6	2,43	112
70 691 012 / 70 690 012	T08	8,03	110	M2,5x6	2,43	112
70 691 016 / 70 690 016	T08	8,03	110	M2,5x6	2,43	112
70 691 020 / 70 690 020	T15	9,56	113	M3,5x11	3,30	113

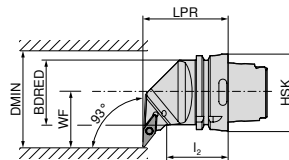


Key D



Clamping screw

MaxiLock-S – SVUC 93° – Toolholder with screw clamping



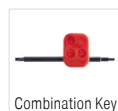
Illustrations show right-hand versions



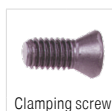
ISO designation	Adapter	LPR mm	I ₂ mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 557 ...		Right-hand 74 558 ...	
									EUR 2D/80		EUR 2D/80	
HSK T63 SVUC R/L 16	HSK-T 63	70	42	53	45	100	3.2	VC.. 1604	280,30	516	280,30	516

Spare parts for Article no.

74 558 516 / 74 557 516	T15/SW	8,69	398	M3,5x11	3,30	113	10,56	107	M3,5	4,87	171
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Combination Key



Clamping screw

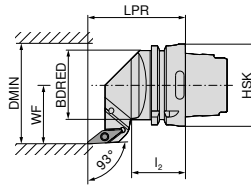


Solid Carbide
Seat V



Threaded sleeve

MaxiLock-S – SVJC 93° – Toolholder with screw clamping



Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	I ₂ mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									74 556 ...		74 555 ...	
HSK T63 SVJC R/L 16	HSK-T 63	75	42	53	45	100	3.2	VC.. 1604	EUR 2D/80 280,30	516	EUR 2D/80 280,30	516
									70 950 ...		70 950 ...	
									EUR 2A/28 8,69	398	EUR 2A/28 3,30	113
									EUR 2A/28 10,56	107	EUR 2A/28 4,87	171

Spare parts
for Article no.

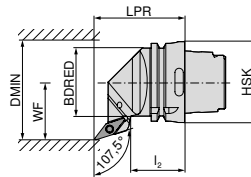
74 555 516 / 74 556 516

T15/SW

M3,5x11

M3,5

MaxiLock-S – SVHC 107.5° – Toolholder with screw clamping



Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	I ₂ mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									74 554 ...		74 553 ...	
HSK T63 SVHC R/L 16	HSK-T 63	70	42	53	45	100	3.2	VC.. 1604	EUR 2D/80 280,30	516	EUR 2D/80 280,30	516
									70 950 ...		70 950 ...	
									EUR 2A/28 8,69	398	EUR 2A/28 3,30	113
									EUR 2A/28 10,56	107	EUR 2A/28 4,87	171

Spare parts
for Article no.

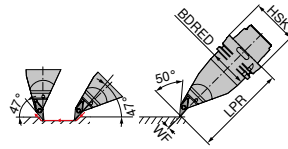
74 553 516 / 74 554 516

T15/SW

M3,5x11

M3,5

MaxiLock-S – SVMC 50° – Toolholder with screw clamping



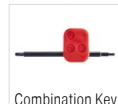
Left-hand

74 560 ...

ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert	
HSK T63 SVMC L 16	HSK-T 63	130	53	0	3.2	VC.. 1604	

EUR
2D/80
376,10

516



Combination Key



Clamping screw

Solid Carbide
Seat V

Threaded sleeve

Spare parts
for Article no.

74 560 516

70 950 ...
EUR 2A/28 8,69
398

T15/SW

70 950 ...
EUR 2A/28 3,30
113

M3,5x11

70 950 ...
EUR 2A/28 10,56
107

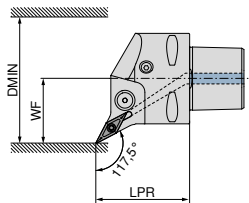
M3,5

70 950 ...
EUR 2A/28 4,87
171

MaxiLock-S – SVPC 117,5° – Toolholder with screw clamping

Scope of supply:

without high-performance coolant set



Illustrations show right-hand versions



NEW

Left-hand

84 671 ...

NEW

Right-hand

84 670 ...

ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Direct cooling compatible	
PSC40 SVPC R/L 50050-16	PSC 40	50	27	50	3	VC.. 1604	DC	
PSC50 SVPC R/L 65060-16	PSC 50	60	35	65	3	VC.. 1604	DC	
PSC63 SVPC R/L 80065-16	PSC 63	65	45	80	3	VC.. 1604	DC	

EUR
Y8

205,40 01695
235,40 01694
261,90 01693

EUR
Y8

205,40 01695
235,40 01694
261,90 01693



The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → Page 42.



Clamping screw

84 950 ...

EUR
Y8

3,20 27600
3,20 27600
3,20 27600

Spare parts

Adapter

PSC 40

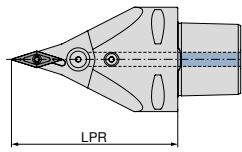
PSC 50

PSC 63

MaxiLock-S – SVVC 72.5° – Toolholder with screw clamping

Scope of supply:

without high-performance coolant set



NEW
Neutral

84 678 ...

ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Direct cooling compatible	EUR Y8	
PSC63 SVVC N 0100-16	PSC 63	100	3	VC.. 1604	DC	261,90	01693
PSC63 SVVC N 0130-16	PSC 63	130	3	VC.. 1604	DC	261,90	11693



The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page 42.**



Clamping screw

84 950 ...

EUR
Y8

3,20 27600

Spare parts

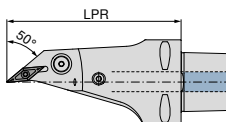
Adapter

PSC 63

MaxiLock-S – SVMC 50° – Toolholder with screw clamping

Scope of supply:

without high-performance coolant set



NEW
Neutral

84 681 ...

ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Direct cooling compatible	EUR Y8	
PSC63 SVMC L 0130-16	PSC 63	130	3	VC.. 1604	DC	353,20	11693



The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page 42.**



Clamping screw

84 950 ...

EUR
Y8

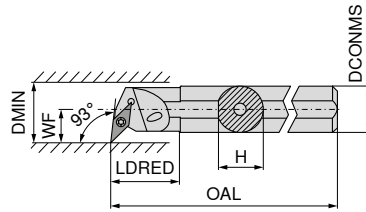
3,20 27600

Spare parts

Adapter

PSC 63

MaxiLock-S – SVUC 93° – Boring bar with screw clamping



Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 745 ...		Right-hand 70 744 ...	
									EUR 2A/24		EUR 2A/24	
A16M SVUC R/L 11	16	15,0	150	29	11	20	1,2	VC.. 1103	132,20	216	132,20	216
A20Q SVUC R/L 11	20	18,5	180	32	13	25	1,2	VC.. 1103	152,40	220	152,40	220
A25R SVUC R/L 11	25	23,0	200	36	17	32	1,2	VC.. 1103	186,70	225	186,70	225
A32S SVUC R/L 16	32	30,0	250	50	22	40	3,2	VC.. 1604	224,00	232	224,00	232
A40T SVUC R/L 16	40	38,0	300	60	27	50	3,2	VC.. 1604	259,90	240	259,90	240

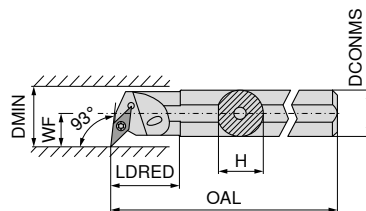
Spare parts for Article no.

	EUR Y7		EUR 2A/28		EUR 2A		EUR 2A/28		EUR 2A/28	
70 744 216 / 70 745 216	8,03	110			2,43	112				
70 744 220 / 70 745 220	8,03	110			2,43	112				
70 744 225 / 70 745 225	8,03	110			2,43	112				
70 744 232 / 70 745 232			8,69	398	3,30	113	10,56	107	4,87	171
70 744 240 / 70 745 240			8,69	398	3,30	113	10,56	107	4,87	171

	Key D		Combination Key		Clamping screw		Solid Carbide Seat V		Threaded sleeve
80 950 ...	EUR Y7	70 950 ...	EUR 2A/28	70 950 ...	EUR 2A	70 950 ...	EUR 2A/28	70 950 ...	EUR 2A/28

MaxiLock-S – SVUC 93° – Boring bar with screw clamping

▲ with carbide core



Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Right-hand 70 746 ...	
									EUR 2A	
E-A16M SVUC R 11	16	15	150	16,5	11	21	1,2	VC.. 1103	342,40	216
E-A20Q SVUC R 11	20	18	180	20,5	13	25	1,2	VC.. 1103	487,70	220
E-A25R SVUC R 11	25	23	200	25,5	17	31	1,2	VC.. 1103	827,90	225
E-A25R SVUC R 16	25	23	200	25,5	17	31	3,2	VC.. 1604	827,90	325
E-A32S SVUC R 16	32	30	250	32,5	22	39	3,2	VC.. 1604	892,90	232

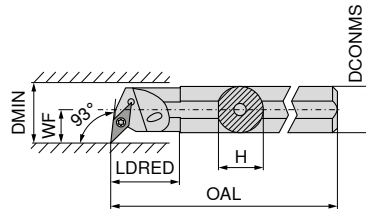
Spare parts for Article no.

	EUR Y7		EUR 2A	
70 746 216	8,03	110	2,43	112
70 746 220	8,03	110	2,43	112
70 746 225	8,03	110	2,43	112
70 746 325	9,56	113	3,30	449
70 746 232	9,56	113	3,30	449

	Key D		Clamping screw
80 950 ...	EUR Y7	70 950 ...	EUR 2A

MaxiLock-S – SVUC 93° – Boring bar with screw clamping

▲ Type: Solid carbide



Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 747 ...		Right-hand 70 746 ...	
									EUR 2A/24		EUR 2A/24	
E16R SVUC R/L 11	16	15,0	200	34	11	20	1,2	VC.. 1103	506,20	016	506,20	016
E20S SVUC R/L 11	20	18,5	250	38	13	25	1,2	VC.. 1103	600,40	020	600,40	020

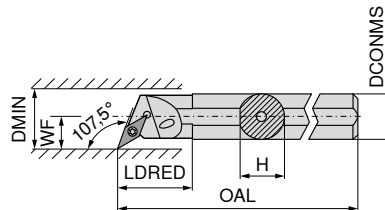
Spare parts for Article no.

70 746 016 / 70 747 016	T08	8,03	110	M2,5x6	2,43	112
70 746 020 / 70 747 020	T08	8,03	110	M2,5x6	2,43	112

Key D

Clamping screw

MaxiLock-S – SVQC 107.5° – Boring bar with screw clamping



Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 749 ...		Right-hand 70 748 ...	
									EUR 2A/24		EUR 2A/24	
A16M SVQC R/L 11	16	15,0	150	29	11	20	1,2	VC.. 1103	132,20	216	132,20	216
A20Q SVQC R/L 11	20	18,5	180	32	13	25	1,2	VC.. 1103	152,40	220	152,40	220
A25R SVQC R/L 11	25	23,0	200	36	17	32	1,2	VC.. 1103	186,70	225	186,70	225
A32S SVQC R/L 16	32	30,0	250	50	22	40	3,2	VC.. 1604	224,00	232	224,00	232
A40T SVQC R/L 16	40	38,0	300	60	27	50	3,2	VC.. 1604	259,90	240	259,90	240

Spare parts for Article no.

70 748 216 / 70 749 216	8,03	110		2,43	112					
70 748 220 / 70 749 220	8,03	110		2,43	112					
70 748 225 / 70 749 225	8,03	110		2,43	112					
70 748 232 / 70 749 232			8,69	398	3,30	113	10,56	107	4,87	171
70 748 240 / 70 749 240			8,69	398	3,30	113	10,56	107	4,87	171

Key D

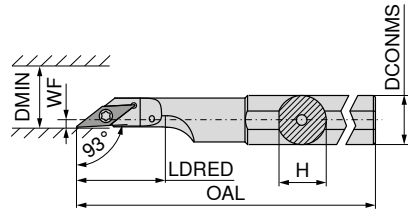
Combination Key

Clamping screw

Solid Carbide
Seat V

Threaded sleeve

MaxiLock-S – SVJC 93° – Boring bar with screw clamping



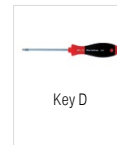
Illustrations show right-hand versions



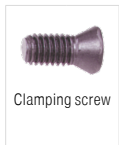
ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 727 ...		Right-hand 70 726 ...	
									EUR 2A		EUR 2A	
A16M SVJC R/L 11	16	15	150	30	2	22	1,2	VC.. 1103	117,70	216	117,70	216
A20M SVJC R/L 11	20	19	150	38	2	25	1,2	VC.. 1103	117,70	220	117,70	220
A25M SVJC R/L 16	25	24	150	44	2	28	3,2	VC.. 1604	117,70	225	117,70	225

Spare parts
for Article no.

70 727 216 / 70 726 216
70 727 220 / 70 726 220
70 727 225 / 70 726 225



Key D



Clamping screw

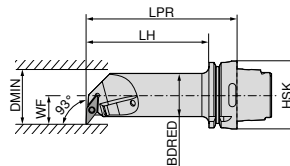
80 950 ...

EUR Y7	
8,03	110
8,03	110
9,56	113

70 950 ...

EUR 2A	
2,43	112
2,43	112
3,57	174

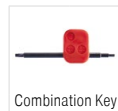
MaxiLock-S – SVUC 93° – Boring bar with screw clamping



Illustrations show right-hand versions



ISO designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 568 ...		Right-hand 74 567 ...	
									EUR 2D/80		EUR 2D/80	
HSK T63 40L SVUC R/L 16	HSK-T 63	140	114	40	27	50	3,2	VC.. 1604	373,70	516	373,70	516



Combination Key



Clamping screw



Solid Carbide
Seat V



Threaded sleeve

70 950 ...

EUR 2A/28	
8,69	398

70 950 ...

EUR 2A/28	
3,30	113

70 950 ...

EUR 2A/28	
10,56	107

70 950 ...

EUR 2A/28	
4,87	171

Spare parts
for Article no.

74 567 516 / 74 568 516

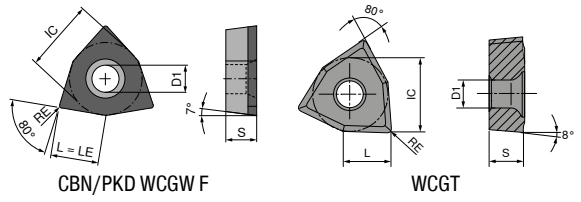
T15/SW

M3,5x11

M3,5

WCGT / WCGW

Designation	L mm	S mm	D1 mm	IC mm
WCGW 0201..	2,70	1,58	2,3	3,97
WCGT 0201..	2,71	1,59	2,1	3,97

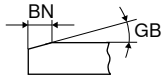


WCGT

		-SF TCM10		-SF CTPP430		-SF H216T	
		DRAGONSKIN					
		F		F		F	
		CERMET WCGT		WCGT		WCGT	
		70 287 ...		70 287 ...		70 287 ...	
		EUR 1A/78		EUR 1A/08		EUR 1A/08	
ISO	RE mm						
020102EN	0,2	17,04	900	18,34	450	14,01	600
020104EN	0,4	17,04	902	18,34	452	14,01	602
P		●		●			
M		○		●			
K		○		○		○	
N				○		○	●
S				○			
H							
O							○

WCGW

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



ISO	RE mm	BN mm	GB	TCE (NOI)	LE mm				
020102EN	0,2			F	2,7				
020102SN	0,2	0,11	15°	F	2,7				
020102TN	0,2	0,12	20°	F	2,7				
020102TN	0,2	0,12	25°	F	2,7				
020102FN	0,2			F	2,7	136,70	200		
020104SN	0,4	0,11	15°	F	2,7				
020104TN	0,4	0,12	20°	F	2,7				
020104FN	0,4			F	2,7				
020104EN	0,4			F	2,7				
020104TN	0,4	0,12	25°	F	2,7				

1) Machining to 60 HRC

WCGW

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

ISO	RE mm	TCE (NOI)	LE mm						
020102FN	0,2	F	2,7						
020104FN	0,4	F	2,7						

CTDPD20



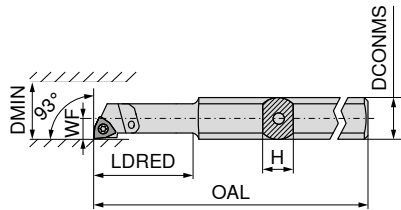
F

DIAMOND
WCGW

71 154 ...

EUR
Y0135,70 100
135,70 102

MaxiLock-S – SWUC 93° – Boring bar with screw clamping



Illustrations show right-hand versions



ISO designation	H mm	OAL mm	LDRED mm	WF mm	DCONMS mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									70 731 ...		70 730 ...	
A0508H SWUC R/L 02	7	100	24	2,9	8	5,8	0,4	WC.. 0201..	EUR 2A		EUR 2A	
A0608H SWUC R/L 02	7	100	24	3,9	8	7,8	0,4	WC.. 0201..	145,30	005	145,30	005
									145,30	006	145,30	006

Spare parts
for Article no.

70 731 005 / 70 730 005	T06	EUR Y7	8,69	108	M1,8x3,4	EUR 2A/28	3,86	334
70 731 006 / 70 730 006	T06	EUR Y7	8,69	108	M1,8x3,4	EUR 2A/28	3,86	334

Key D

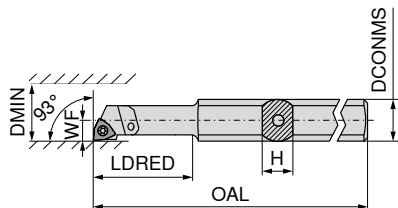
Clamping screw

80 950 ...

70 950 ...

MaxiLock-S – SWUC 93° – Boring bar with screw clamping

▲ with carbide core



Illustrations show right-hand versions



ISO designation	H mm	OAL mm	LDRED mm	WF mm	DCONMS mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									70 743 ...		70 742 ...	
E-A0508H SWUC R/L 02	7	100	24	2,9	8	5,8	0,4	WC.. 0201..	EUR 2A		EUR 2A	
E-A0608H SWUC R/L 02	7	100	24	3,9	8	7,8	0,4	WC.. 0201..	161,80	005	161,80	005
SET							0,4	WC.. 0201..	161,80	006	161,80	006
									321,50	999	321,50	999

Set includes boring bars 70 743 005 and 70 743 006 or 70 742 005 and 70 742 006

Key D

Clamping screw

80 950 ...

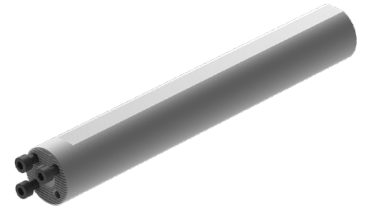
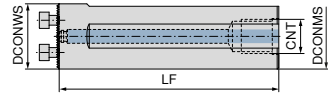
70 950 ...

Spare parts
for Article no.

70 743 005 / 70 742 005	T06	EUR Y7	8,69	108	M1,8x3,4	EUR 2A/28	3,86	334
70 743 006 / 70 742 006	T06	EUR Y7	8,69	108	M1,8x3,4	EUR 2A/28	3,86	334

Base holders for the exchangeable head system – cylindrical

- ▲ Connection thread for thro' coolant
- ▲ 3 clamping flats



NEW



84 194 ...

EUR

Y8

255,40 02599

271,80 03299

331,80 04099

DCONWS mm	LF mm	DCONMS mm	CNT
25	200	25	1/4
32	218	32	3/8
40	283	40	1/2



Clamping Screw

84 950 ...

EUR

Y8

M4X12 (SW3) 1,74 30000

M5X14 (SW4) 1,74 29900

M6X16 (SW5) 1,74 29800

Spare parts
for Article no.

84 194 02599

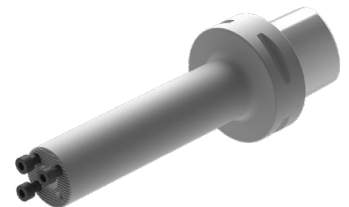
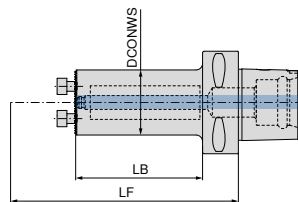
84 194 03299

84 194 04099

Base holders for the exchangeable head system – vibration-damped

Scope of supply:

Includes clamping screws



NEW



right / left

84 195 ...

EUR

Y8

910,10 02593

1.006,00 03293

1.102,00 04093

Adapter	LF mm	LB mm	DCONWS mm
PSC 63	150	93	25
PSC 63	185	128	32
PSC 63	225	163	40



Clamping Screw

84 950 ...

EUR

Y8

M4X12 (SW3) 1,74 30000

M5X14 (SW4) 1,74 29900

M6X16 (SW5) 1,74 29800

Spare parts
for Article no.

84 195 02593

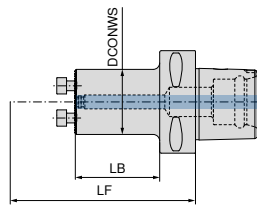
84 195 03293

84 195 04093

Base holders for the exchangeable head system

Scope of supply:

Includes clamping screws



NEW



right / left

84 192 ...

Adapter	LF mm	LB mm	DCONWS mm	EUR Y8	
PSC 40	90	35	25	263,50	02595
PSC 40	110	55	32	263,50	03295
PSC 40	120		40	263,50	04095
PSC 50	90	35	25	296,40	02594
PSC 50	110	55	32	296,40	03294
PSC 50	140	80	40	296,40	04094
PSC 63	100	43	25	323,30	02593
PSC 63	125	68	32	323,30	03293
PSC 63	140	78	40	323,30	04093
PSC 63	160	68	32	323,30	13293
PSC 63	180	118	40	323,30	14093



Clamping Screw

84 950 ...

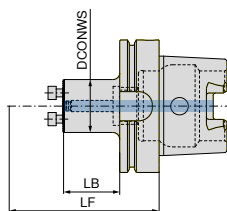
Spare parts for Article no.

	EUR Y8	
84 192 02595	1,74	30000 M4X12 (SW3)
84 192 03295	1,74	29900 M5X14 (SW4)
84 192 04095	1,74	29800 M6X16 (SW5)
84 192 02594	1,74	30000 M4X12 (SW3)
84 192 03294	1,74	29900 M5X14 (SW4)
84 192 04094	1,74	29800 M6X16 (SW5)
84 192 02593	1,74	30000 M4X12 (SW3)
84 192 03293	1,74	29900 M5X14 (SW4)
84 192 04093	1,74	29800 M6X16 (SW5)
84 192 13293	1,74	29900 M5X14 (SW4)
84 192 14093	1,74	29800 M6X16 (SW5)

Base holders for the exchangeable head system

Scope of supply:

Includes clamping screws



NEW



right / left

84 193 ...

Adapter	LF mm	LB mm	DCONWS mm		
HSK-T 40	90	35	25		
HSK-T 40	110	55	25		
HSK-T 40	115	60	32		
HSK-T 40	120		40		
HSK-T 63	105	35	25		
HSK-T 63	125	64	32		
HSK-T 63	140	74	40		
HSK-T 63	160	99	32		
HSK-T 63	180	114	40		
HSK-T 100	180	111	40		

EUR
Y8

263,50 02539
263,50 12539
263,50 03239
263,50 04039

323,30 02537
323,30 03237
323,30 04037
323,30 13237
323,30 14037

426,70 04035



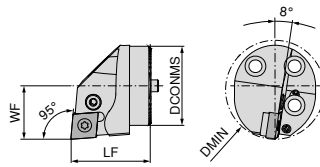
Clamping Screw

84 950 ...

Spare parts for Article no.

84 193 02539	M4X12 (SW3)	1,74	30000
84 193 12539	M4X12 (SW3)	1,74	30000
84 193 03239	M5X14 (SW4)	1,74	29900
84 193 04039	M6X16 (SW5)	1,74	29800
84 193 02537	M4X12 (SW3)	1,74	30000
84 193 03237	M5X14 (SW4)	1,74	29900
84 193 04037	M6X16 (SW5)	1,74	29800
84 193 13237	M5X14 (SW4)	1,74	29900
84 193 14037	M6X16 (SW5)	1,74	29800
84 193 04035	M6X16 (SW5)	1,74	29800

Exchangeable cutting head PCLN 95°



Illustrations show right-hand versions



DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert	NEW Left-hand		NEW Right-hand	
						84 159 ...	EUR Y8	84 160 ...	EUR Y8
25	35	32	17	10	CN.. 1204	200,30	02500	200,30	02500
32	35	40	22	10	CN.. 1204	206,00	03200	206,00	03200
40	40	50	27	10	CN.. 1204	208,90	04000	208,90	04000

Spare parts
for Article no.

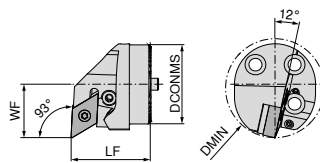
84 160 02500 / 84 159 02500	1,16	29200	M8X1/L17 SW3	4,55	28700	13,47	29000	13,38	27800
84 160 03200 / 84 159 03200	1,16	29200	M8X1/L17 SW3	4,55	28700	13,47	29000	13,38	27800
84 160 04000 / 84 159 04000	1,16	29200	M8X1/L17 SW3	4,55	28700	13,47	29000	13,38	27800



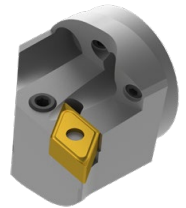
84 950 ... 84 950 ... 84 950 ... 84 950 ...

EUR Y8	EUR Y8	EUR Y8	EUR Y8
1,16	29200	4,55	28700
1,16	29200	4,55	28700
1,16	29200	4,55	28700

Exchangeable cutting head PDUN 93°



Illustrations show right-hand versions



DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert	NEW Left-hand		NEW Right-hand	
						84 161 ...	EUR Y8	84 162 ...	EUR Y8
25	35	32	17	5	DN.. 1104	200,30	02500	200,30	02500
32	35	40	22	5	DN.. 1104	206,00	03200	206,00	03200
32	35	40	22	5	DN.. 1506	206,00	13200	206,00	13200
40	40	50	27	5	DN.. 1104	208,90	04000	208,90	04000
40	40	50	27	5	DN.. 1506	208,90	14000	208,90	14000

Spare parts
for Article no.

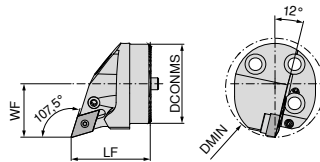
84 162 02500 / 84 161 02500	1,16	29300	M6/ L14 SW2,5	4,55	28800	15,38	29100	24,61	28100
84 162 03200 / 84 161 03200	1,16	29300	M6/ L14 SW2,5	4,55	28800	15,38	29100	24,61	28100
84 162 13200 / 84 161 13200	1,16	29200	M8X1/L17 SW3	4,55	28700	15,67	28900	24,61	27900
84 162 04000 / 84 161 04000	1,16	29300	M6/ L14 SW2,5	4,55	28800	15,38	29100	24,61	28100
84 162 14000 / 84 161 14000	1,16	29200	M8X1/L17 SW3	4,55	28700	15,67	28900	24,61	27900



84 950 ... 84 950 ... 84 950 ... 84 950 ...

EUR Y8	EUR Y8	EUR Y8	EUR Y8
1,16	29300	4,55	28800
1,16	29300	4,55	28800
1,16	29200	4,55	28700
1,16	29300	4,55	28800
1,16	29200	4,55	28700

Exchangeable cutting head PDQN 107.5°



Illustrations show right-hand versions



DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert
25	35	32	17	5	DN.. 1104
32	35	40	22	5	DN.. 1104
40	40	50	27	5	DN.. 1104

NEW Left-hand		NEW Right-hand	
84 163 ...		84 164 ...	
EUR		EUR	
Y8		Y8	
200,30	02500	200,30	02500
206,00	03200	206,00	03200
208,90	04000	208,90	04000

Spare parts
for Article no.

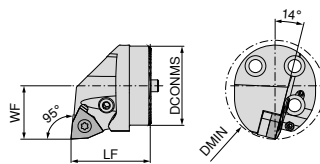
84 163 02500 / 84 164 02500	1,16	29300	M6/ L14 SW2,5	4,55	28800	15,38	29100	24,61	28100
84 163 03200 / 84 164 03200	1,16	29300	M6/ L14 SW2,5	4,55	28800	15,38	29100	24,61	28100
84 163 04000 / 84 164 04000	1,16	29300	M6/ L14 SW2,5	4,55	28800	15,38	29100	24,61	28100



84 950 ...	84 950 ...	84 950 ...	84 950 ...
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EUR		EUR		EUR		EUR	
Y8		Y8		Y8		Y8	
1,16	29300	4,55	28800	15,38	29100	24,61	28100
1,16	29300	4,55	28800	15,38	29100	24,61	28100
1,16	29300	4,55	28800	15,38	29100	24,61	28100

Exchangeable cutting head PWLN 95°



Illustrations show right-hand versions



DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert
32	35	40	22	5	WN.. 0804
40	40	50	27	5	WN.. 0804

NEW Left-hand		NEW Right-hand	
84 165 ...		84 166 ...	
EUR		EUR	
Y8		Y8	
206,00	03200	206,00	03200
208,90	04000	208,90	04000

Spare parts
for Article no.

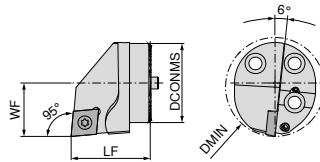
84 166 03200 / 84 165 03200	1,16	29200	M8X1/L17 SW3	4,55	28700	15,67	28900	24,61	27700
84 166 04000 / 84 165 04000	1,16	29200	M8X1/L17 SW3	4,55	28700	15,67	28900	24,61	27700



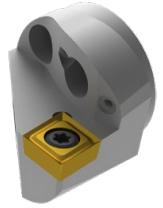
84 950 ...	84 950 ...	84 950 ...	84 950 ...
------------	------------	------------	------------

EUR		EUR		EUR		EUR	
Y8		Y8		Y8		Y8	
1,16	29200	4,55	28700	15,67	28900	24,61	27700
1,16	29200	4,55	28700	15,67	28900	24,61	27700

Exchangeable cutting head SCLC 95°



Illustrations show right-hand versions



DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert
25	35	32	17	5	CC.. 1204
32	35	40	22	5	CC.. 1204
40	40	50	27	5	CC.. 1204

NEW
Left-hand

84 147 ...

EUR
Y8

163,60	02500
166,60	03200
169,30	04000

NEW
Right-hand

84 148 ...

EUR
Y8

163,60	02500
166,60	03200
169,30	04000

Spare parts
for Article no.

84 148 02500 / 84 147 02500
84 148 03200 / 84 147 03200
84 148 04000 / 84 147 04000



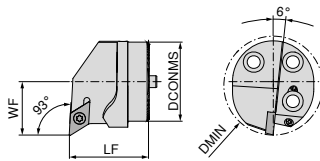
Clamping screw

84 950 ...

EUR
Y8

4,83	27500
4,83	27500
4,83	27500

Exchangeable cutting head SDUC 93°



Illustrations show right-hand versions

NEW
Left-hand

84 143 ...

EUR
Y8

163,60	02500
166,60	03200
169,30	04000

NEW
Right-hand

84 144 ...

EUR
Y8

163,60	02500
166,60	03200
169,30	04000

DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert
25	35	32	17	3	DC.. 11T3
32	35	40	22	3	DC.. 11T3
40	40	50	27	3	DC.. 11T3

Spare parts
for Article no.

84 144 02500 / 84 143 02500
84 144 03200 / 84 143 03200
84 144 04000 / 84 143 04000



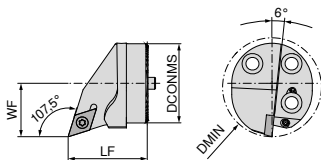
Clamping screw

84 950 ...

EUR
Y8

3,20	27600
3,20	27600
3,20	27600

Exchangeable cutting head SDQC 107.5°



Illustrations show right-hand versions



DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert
25	35	32	17	3	DC.. 11T3
32	35	40	22	3	DC.. 11T3
40	40	50	27	3	DC.. 11T3

NEW Left-hand		NEW Right-hand	
84 145 ...		84 146 ...	
EUR		EUR	
Y8		Y8	
163,60	02500	163,60	02500
166,60	03200	166,60	03200
169,30	04000	169,30	04000

Spare parts
for Article no.

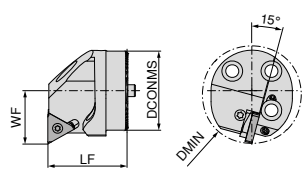
84 146 02500 / 84 145 02500
84 146 03200 / 84 145 03200
84 146 04000 / 84 145 04000



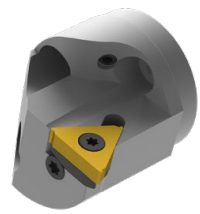
Clamping screw

84 950 ...	
EUR	
Y8	
3,20	27600
3,20	27600
3,20	27600

Exchangeable cutting head for internal thread



Illustrations show right-hand versions

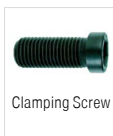


DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert
25	35	32	17	2	16 ..
32	35	40	22	2	16 ..
40	40	50	27	2	16 ..

NEW Left-hand		NEW Right-hand	
84 167 ...		84 168 ...	
EUR		EUR	
Y8		Y8	
217,30	02500	217,30	02500
226,60	03200	226,60	03200
238,50	04000	238,50	04000

 Suitable internal thread inserts can be found in → **Chapter 8 – Thread Turning, pages 6-30**

Spare parts
for Article no.

		 Shim		 Clamping Screw		 Clamping screw	
		84 950 ...		84 950 ...		84 950 ...	
		EUR		EUR		EUR	
		Y8		Y8		Y8	
84 168 02500	29,00 29500	UNC5x7,3	5,75 29700	5,75 29400			
84 167 02500	29,00 29600	UNC5x7,3	5,75 29700	5,75 29400			
84 168 03200	29,00 29500	UNC5x7,3	5,75 29700	5,75 29400			
84 167 03200	29,00 29600	UNC5x7,3	5,75 29700	5,75 29400			
84 168 04000	29,00 29500	UNC5x7,3	5,75 29700	5,75 29400			
84 167 04000	29,00 29600	UNC5x7,3	5,75 29700	5,75 29400			

Material examples for cutting data tables

	Material sub-group	Index	Composition / Structure / Heat treatment		Tensile strength N/mm ² / HB / HRC	Material number	Material designation	Material number	Material designation
P	Unalloyed steel	P.1.1	< 0,15 % C	Annealed	420 N/mm ² / 125 HB	1.0401	C15	1.1141	Ck15
		P.1.2	< 0,45 % C	Annealed	640 N/mm ² / 190 HB	1.1191	C45E	1.0718	9SMnPb28
		P.1.3		Tempered	840 N/mm ² / 250 HB	1.1191	C45E	1.0535	C55
		P.1.4	< 0,75 % C	Annealed	910 N/mm ² / 270 HB	1.1223	C60R	1.0535	C55
		P.1.5		Tempered	1010 N/mm ² / 300 HB	1.1223	C60R	1.0727	45S20
	Low-alloy steel	P.2.1		Annealed	610 N/mm ² / 180 HB	1.7131	16MnCr5	1.6587	17CrNiMo6
		P.2.2		Tempered	930 N/mm ² / 275 HB	1.7131	16MnCr5	1.6587	17CrNiMo6
		P.2.3		Tempered	1010 N/mm ² / 300 HB	1.7225	42CrMo4	1.3505	100Cr6
		P.2.4		Tempered	1200 N/mm ² / 375 HB	1.7225	42CrMo4	1.3505	100Cr6
	High-alloy steel and high-alloy tool steel	P.3.1		Annealed	680 N/mm ² / 200 HB	1.4021	X20Cr13	1.4034	X46Cr13
		P.3.2		Hardened and tempered	1100 N/mm ² / 300 HB	1.2343	X38CrMoV5-1	1.4034	X46Cr13
		P.3.3		Hardened and tempered	1300 N/mm ² / 400 HB	1.2343	X38CrMoV5-1	1.4034	X46Cr13
	Stainless steel	P.4.1	Ferritic / martensitic	Annealed	680 N/mm ² / 200 HB	1.4016	X6Cr17	1.2316	X36CrMo16
		P.4.2	Martensitic	Tempered	1010 N/mm ² / 300 HB	1.4112	X90CrMoV18	1.2316	X36CrMo16
M	Stainless steel	M.1.1	Austenitic / austenitic-ferritic	Quenched	610 N/mm ² / 180 HB	1.4301	X5CrNi18-10	1.4571	X6CrNiMoTi17-12-2
		M.2.1	Austenitic	Tempered	300 HB	1.4841	X15CrNiSi25-21	1.4539	X1NiCrMoCu25-20-5
		M.3.1	Austenitic / ferritic (Duplex)		780 N/mm ² / 230 HB	1.4462	X2CrNiMoN22-5-3	1.4501	X2CrNiMoCuWN25-7-4
K	Grey cast iron	K.1.1	Pearlitic / ferritic		350 N/mm ² / 180 HB	0.6010	GG-10	0.6025	GG-25
		K.1.2	Pearlitic (martensitic)		500 N/mm ² / 260 HB	0.6030	GG-30	0.6045	GG-45
	Spherulitic graphite cast iron	K.2.1	Ferritic		540 N/mm ² / 160 HB	0.7040	GGG-40	0.7060	GGG-60
		K.2.2	Pearlitic		845 N/mm ² / 250 HB	0.7070	GGG-70	0.7080	GGG-80
	Malleable iron	K.3.1	Ferritic		440 N/mm ² / 130 HB	0.8035	GTW-35-04	0.8045	GTW-45
		K.3.2	Pearlitic		780 N/mm ² / 230 HB	0.8165	GTS-65-02	0.8170	GTS-70-02
N	Aluminium wrought alloy	N.1.1	Non-hardenable		60 HB	3.0255	Al99,5	3.3315	AlMg1
		N.1.2	Hardenable	Age-hardened	340 N/mm ² / 100 HB	3.1355	AlCuMg2	3.2315	AlMgSi1
	Cast aluminium alloy	N.2.1	≤ 12 % Si, non-hardenable		250 N/mm ² / 75 HB	3.2581	G-AlSi12	3.2163	G-AlSi9Cu3
		N.2.2	≤ 12 % Si, hardenable	Age-hardened	300 N/mm ² / 90 HB	3.2134	G-AlSi5Cu1Mg	3.2373	G-AlSi9Mg
		N.2.3	> 12 % Si, non-hardenable		440 N/mm ² / 130 HB		G-AlSi17Cu4Mg		G-AlSi18CuNiMg
	Copper and copper alloys (bronze/brass)	N.3.1	Free-machining alloys, PB > 1 %		375 N/mm ² / 110 HB	2.0380	CuZn39Pb2 (Ms58)	2.0410	CuZn44Pb2
		N.3.2	CuZn, CuSnZn		300 N/mm ² / 90 HB	2.0331	CuZn15	2.4070	CuZn28Sn1As
		N.3.3	CuSn, lead-free copper and electrolytic copper		340 N/mm ² / 100 HB	2.0060	E-Cu57	2.0590	CuZn40Fe
	Magnesium alloys	N.4.1	Magnesium and magnesium alloys		70 HB	3.5612	MgAl6Zn	3.5312	MgAl3Zn
S	Heat-resistant alloys	S.1.1	Fe - basis	Annealed	680 N/mm ² / 200 HB	1.4864	X12NiCrSi 36-16	1.4865	G-X40NiCrSi38-18
		S.1.2		Age-hardened	950 N/mm ² / 280 HB	1.4980	X6NiCrTiMoVB25-15-2	1.4876	X10NiCrAlTi32-20
		S.2.1	Ni or Co basis	Annealed	840 N/mm ² / 250 HB	2.4631	NiCr20TiAl (Nimonic80A)	3.4856	NiCr22Mo9Nb
		S.2.2		Age-hardened	1180 N/mm ² / 350 HB	2.4668	NiCr19Nb5Mo3 (Inconel 718)	2.4955	NiFe25Cr20NbTi
		S.2.3		Cast	1080 N/mm ² / 320 HB	2.4765	CoCr20W15Ni	1.3401	G-X120Mn12
	Titanium alloys	S.3.1	Pure titanium		400 N/mm ²	3.7025	Ti99,8	3.7034	Ti99,7
		S.3.2	Alpha + beta alloys	Age-hardened	1050 N/mm ² / 320 HB	3.7165	TiAl6V4	Ti-6246	Ti-6Al-2Sn-4Zr-6Mo
		S.3.3	Beta alloys		1400 N/mm ² / 410 HB	Ti555.3	Ti-5Al-5V-5Mo-3Cr	R56410	Ti-10V-2Fe-3Al
H	Hardened steel	H.1.1		Hardened and tempered	46-55 HRC				
		H.1.2		Hardened and tempered	56-60 HRC				
		H.1.3		Hardened and tempered	61-65 HRC				
		H.1.4		Hardened and tempered	66-70 HRC				
	Chilled iron	H.2.1		Cast	400 HB				
	Hardened cast iron	H.3.1		Hardened and tempered	55 HRC				
O	Non-metal materials	O.1.1	Plastics, duroplastic		≤ 150 N/mm ²				
		O.1.2	Plastics, thermoplastic		≤ 100 N/mm ²				
		O.2.1	Aramid fibre-reinforced		≤ 1000 N/mm ²				
		O.2.2	Glass/carbon-fibre reinforced		≤ 1000 N/mm ²				
		O.3.1	Graphite						

* Tensile strength

Cutting data standard values

			DRAGONSKIN												H210T	H10T/ H216T	CWN15
	TCM407	TCM10	CTEP110	CTCP115	CTCP125	CTCP135	CTCK110	CTCK120	CTPM125	CTCM120	CTCM130	CTPX710 -M34	CTPX710 -25P/-25Q	CTPX715 -27			
Index	v _c in m/min																
P.1.1	379	309	463	370	295	210	395	328	203	229	184	325	340	275			
P.1.2	328	266	404	315	250	175	344	281	171	200	152	286	300	236			
P.1.3	280	227	348	270	210	145	297	238	142	173	123	250	260	200			
P.1.4	265	213	330	250	200	135	281	223	132	164	113	238	250	188			
P.1.5	241	193	302	230	180	120	258	202	118	150	98	220	235	170			
P.2.1	336	273	413	325	260	180	352	288	176	204	157	292	300	242			
P.2.2	261	210	325	250	195	130	278	220	130	161	110	235	250	185			
P.2.3	241	193	302	230	180	120	258	202	118	150	98	220	235	170			
P.2.4	182	144	233	170	130	85	199	148	81	116	61	175	190	125			
P.3.1	281	219	344	200	170	150	273	220	142	159	124	140	150	138			
P.3.2	224	167	278	140	105	95	225	176	97	116	81	85	95	81			
P.3.3	167	114	213	85	40	35	178	131	51	73	38	30	35	24			
P.4.1	281	219	344	200	170	155			142	159	124	140	155	138			
P.4.2	253	193	311	170	135	125			119	138	103	113	130	109			
M.1.1	281	219	344			155			142	159	124	140	150	138			100
M.2.1						95			97	116	81	85	90	81			55
M.3.1						135			128	146	111	124	130	120			85
K.1.1			410	255	170		400	275						200	170	140	
K.1.2			310	235	160		310	265						160	130	115	
K.2.1	355	260	440	270	180		320	290						190	180	150	
K.2.2	315	215	350	205	160		275	230						150	130	110	
K.3.1	325	300	415	250	200		310	275						210	190	170	
K.3.2	250	205	250	210	160		265	230						180	160	140	
N.1.1												1840	1840	1750	1650	1400	1650
N.1.2												1600	1600	1500	1350	1100	1400
N.2.1												1250	1250	1200	1200	950	1250
N.2.2												1250	1250	1200	1100	950	1200
N.2.3												750	750	700	600	500	750
N.3.1												650	650	625	525	425	600
N.3.2												630	630	600	500	400	570
N.3.3												500	500	475	375	275	460
N.4.1												340	340	325	275	225	280
S.1.1											35	100	110	40	43		
S.1.2											26	80	85	30	33		
S.2.1											20	63	75	30	33		
S.2.2											20	40	45	24	25		
S.2.3											18	38	43	20	20		
S.3.1											110	95	100	110	110		
S.3.2											63	55	60	70	70		
S.3.3											45	40	45	50	50		
H.1.1																	
H.1.2																	
H.1.3																	
H.1.4																	
H.2.1																	
H.3.1																	
O.1.1														140	160	130	
O.1.2																	
O.2.1														150	140	105	
O.2.2																	
O.3.1																	



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approx. **±20%** according to the usage conditions.

Cutting data standard values

	CT-P15	CT-P25	CT-P35
Index	v_c in m/min		
P.1.1	290	235	165
P.1.2	250	200	140
P.1.3	215	170	115
P.1.4	200	160	110
P.1.5	185	145	100
P.2.1	260	210	145
P.2.2	200	155	105
P.2.3	185	145	95
P.2.4	135	105	65
P.3.1	160	135	120
P.3.2	115	85	75
P.3.3	65	34	26
P.4.1	160	135	120
P.4.2	140	110	100
M.1.1	150	130	120
M.2.1	125	105	75
M.3.1	140	120	110
K.1.1			
K.1.2			
K.2.1			
K.2.2			
K.3.1			
K.3.2			
N.1.1			
N.1.2			
N.2.1			
N.2.2			
N.2.3			
N.3.1			
N.3.2			
N.3.3			
N.4.1			
S.1.1			
S.1.2			
S.2.1			
S.2.2			
S.2.3			
S.3.1			
S.3.2			
S.3.3			
H.1.1			
H.1.2			
H.1.3			
H.1.4			
H.2.1			
H.3.1			
O.1.1			
O.1.2			
O.2.1			
O.2.2			
O.3.1			



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approx. $\pm 20\%$ according to the usage conditions.

Machinability of non-ferrous metals with carbide indexable inserts

	Material group	Material examples		Machinability of aluminium alloys	Comments
				*	
N	Pure aluminium	non hardenable	Al 99,5 W7	5	▲ Snarl chips
			Al 99,5 F13	4	▲ Possibly bad surface
			Al 99 W8	5	▲ Excessive built-up edge
			Al 99 F14	4	▲ Long tool life
	Aluminium wrought alloys	non hardenable			▲ Use coolant emulsion
			Al Mn W10	5	▲ Snarl, continuous or fragmented chip ▲ Large feed rates necessary for good swarf control ▲ Built-up edge ▲ Long tool life ▲ Emulsion coolant is advantageous
			Al Mn F16	4	
			Al Mg 1 W10	5	
			Al Mg 1 F19	4	
			Al Mg 3 W18	4	
			Al Mg 3 F25	3	
			Al Mg 5 W25	4	
			AL Mg 5 F28	2	
			Al Mg 4,5 Mn W27	4	
			Al Mg 4,5 Mn G35	3	
		hardenable	Al Mg Si 0,5 W	4	▲ Good swarf control with higher feed rates
			Al Mg Si 0,5 F13-25	3	
			Al Mg Si 1 W	4	
			Al Mg Si 1 F21-30	3	
			Al Mg Si Pb F20-28	2	▲ Very good swarf control
			Al Cu Si Pb F28-37	1	▲ No built up edge
			Al Cu Mg Pb F34-37	1	▲ Very good surface quality
			Al Cu Mg 1 W	3	▲ Good swarf control ▲ Good surface quality ▲ Little built-up edge
			Al Cu Mg 1 F33-40	2	
			Al Cu Mg 2 W	3	
			Al Cu Mg 2 F40-47	2	
			Al Cu Si Mn W	3	
			Al Cu Si Mn F43-46	2	
			Al Zn Mg Cu 1,5 F50-52	2	
	Cast Aluminium Alloys	non hardenable	Al Sn 6 Cu	1	▲ Good swarf control ▲ Built-up edge ▲ Higher Si content results in lower tool life
			G-Al Si 12	3	
			G-Al Si 10 Mg	3	
			G-Al Si 5 Mg	2	
			G-Al Si 7 Mg (9 Mg)	2	▲ High wear of the carbide
			G-Al Si Cu 3	2	
			G-Al Si 6 Cu 4	2	
			G-Al Mg 3 (Mg 5)	2	▲ Good swarf control ▲ Good surface quality ▲ Long tool life
			G-Al Mg 9	2	
			G-Al Mg 10	2	
			G-Al Mg 3 Si (5 Si)	2	
			G-Al Cu 4 Ti (Mg)	2	
			G-Al Si 12 Cu Mg Ni	2	
	Copper wrought alloys		Cu Ag		
			Cu As		
			Cu Cd		
			Cu Cd Sn		
			Cu Mg		
			Cu Mn		
		brass	Cu Zn Al		
		bronze	Cu Sn		
			Cu Sn Zn		
			Cu Ni		
			Cu Ni Fe		
			Cu Al		
O	Non metal materials	Duroplastics			
		Fibre-reinforced plastics			
		hard rubber			

* 1 = good machinability, 5 = bad machinability

Cutting data values for CBN inserts

Index	Material	Strength N/mm ² / HB / HRC	CTB S05U					
			EN			F / TN-F		
			EN			TN-D		
			v_c	f	a_p	v_c	f	a_p
	Sintered steels (< HV300)							
	general sintered steel (> HV300)							
	high density sintered steel (> HV600)							
K.1.1	Grey cast iron	350 N/mm ² / 180 HB	900-1600	0,02-0,25	0,15-4,5	900-1600	0,02-0,25	0,15-4,5
K.1.2		500 N/mm ² / 260 HB	900-1600	0,02-0,25	0,15-4,5	900-1600	0,02-0,25	0,15-4,5
K.2.1	Spherulitic graphite cast iron	540 N/mm ² / 160 HB	1000-1750	0,02-0,25	0,15-4,5	1000-1750	0,02-0,25	0,15-4,5
K.2.2		845 N/mm ² / 250 HB	1000-1750	0,02-0,25	0,15-4,5	1000-1750	0,02-0,25	0,15-4,5
K.3.1	Malleable iron	440 N/mm ² / 130 HB	1000-1750	0,02-0,25	0,15-4,5	1000-1750	0,02-0,25	0,15-4,5
K.3.2		780 N/mm ² / 220 HB	1000-1750	0,02-0,25	0,15-4,5	1000-1750	0,02-0,25	0,15-4,5
S.1.1		680 N/mm ² / 200 HB						
S.1.2		950 N/mm ² / 280 HB						
S.2.1	Heat-resistant alloys	840 N/mm ² / 250 HB						
S.2.2		1180 N/mm ² / 350 HB						
S.2.3		1080 N/mm ² / 320 HB						
S.3.1		400 N/mm ²						
S.3.2	Titanium alloys	1050 N/mm ² / 320 HB						
S.3.3		1400 N/mm ² / 410 HB						

* Tensile strength

Index	Material	Strength N/mm ² / HB / HRC	CTB S10U / CTB S10C					
			EN			F / FN		
			EN / FN			TN-D		
			v_c	f	a_p	v_c	f	a_p
	Sintered steels (< HV300)		250-750	0,02-0,25	0,02-0,4	210-550	0,08-0,35	0,1-0,4
	general sintered steel (> HV300)		200-700	0,02-0,25	0,02-0,4	150-400	0,08-0,35	0,1-0,4
	high density sintered steel (> HV600)		150-350	0,02-0,25	0,02-0,4	100-220	0,08-0,35	0,1-0,4
K.1.1	Grey cast iron	350 N/mm ² / 180 HB	900-1600	0,02-0,25	0,05-0,25	700-1200	0,08-0,35	0,08-0,4
K.1.2		500 N/mm ² / 260 HB	900-1600	0,02-0,25	0,05-0,25	700-1200	0,08-0,35	0,08-0,4
K.2.1	Spherulitic graphite cast iron	540 N/mm ² / 160 HB	1000-1750	0,02-0,25	0,02-0,25	800-1250	0,08-0,35	0,08-0,4
K.2.2		845 N/mm ² / 250 HB	1000-1750	0,02-0,25	0,02-0,25	800-1250	0,08-0,35	0,08-0,4
K.3.1	Malleable iron	440 N/mm ² / 130 HB	1000-1750	0,02-0,25	0,02-0,25	800-1250	0,08-0,35	0,08-0,4
K.3.2		780 N/mm ² / 220 HB	1000-1750	0,02-0,25	0,02-0,25	800-1250	0,08-0,35	0,08-0,4
S.1.1		680 N/mm ² / 200 HB	300-700	0,02-0,25	0,02-0,4	250-400	0,08-0,35	0,08-0,4
S.1.2		950 N/mm ² / 280 HB	300-700	0,02-0,25	0,02-0,4	250-400	0,08-0,35	0,08-0,4
S.2.1	Heat-resistant alloys	840 N/mm ² / 250 HB	300-700	0,02-0,25	0,02-0,4	250-400	0,08-0,35	0,08-0,4
S.2.2		1180 N/mm ² / 350 HB	300-700	0,02-0,25	0,02-0,4	250-400	0,08-0,35	0,08-0,4
S.2.3		1080 N/mm ² / 320 HB	300-700	0,02-0,25	0,02-0,4	250-400	0,08-0,35	0,08-0,4
S.3.1		400 N/mm ²						
S.3.2	Titanium alloys	1050 N/mm ² / 320 HB						
S.3.3		1400 N/mm ² / 410 HB						

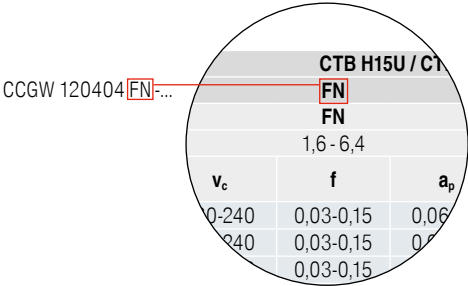
* Tensile strength



* Note chamfer width: The wider the chamfer, the more stable the cutting edge.

The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approx. $\pm 20\%$ according to the usage conditions.

CTB S10C								
TN-B			TN-C			TN-D / TN-E		
SN-B			SN-C / TN-C			TN-D / SN-D		
v _c	f	a _p	v _c	f	a _p	v _c	f	a _p
200-400	0,05-0,4	0,06-0,4	150-350	0,06-0,5	0,08-0,5	150-300	0,1-0,35	0,1-0,4
350-550	0,05-0,4	0,06-0,4	300-500	0,06-0,5	0,08-0,5	250-450	0,1-0,35	0,1-0,4
300-500	0,05-0,4	0,06-0,4	200-400	0,06-0,5	0,08-0,5	200-400	0,1-0,35	0,1-0,4
750-1200	0,05-0,4	0,06-0,4	800-1300	0,06-0,5	0,08-0,5	600-1100	0,1-0,35	0,1-0,4
750-1200	0,05-0,4	0,06-0,4	800-1300	0,06-0,5	0,08-0,5	600-1100	0,1-0,35	0,1-0,4
750-1200	0,05-0,4	0,06-0,4	800-1300	0,06-0,5	0,08-0,5	600-1100	0,1-0,35	0,1-0,4
750-1200	0,05-0,4	0,06-0,4	800-1300	0,06-0,5	0,08-0,5	600-1100	0,1-0,35	0,1-0,4
750-1200	0,05-0,4	0,06-0,4	800-1300	0,06-0,5	0,08-0,5	600-1100	0,1-0,35	0,1-0,4
750-1200	0,05-0,4	0,06-0,4	800-1300	0,06-0,5	0,08-0,5	600-1100	0,1-0,35	0,1-0,4
400-600	0,05-0,4	0,06-0,4	300-500	0,06-0,5	0,08-0,5	250-450	0,1-0,35	0,1-0,4
400-600	0,05-0,4	0,06-0,4	300-500	0,06-0,5	0,08-0,5	250-450	0,1-0,35	0,1-0,4
400-600	0,05-0,4	0,06-0,4	300-500	0,06-0,5	0,08-0,5	250-450	0,1-0,35	0,1-0,4
400-600	0,05-0,4	0,06-0,4	300-500	0,06-0,5	0,08-0,5	250-450	0,1-0,35	0,1-0,4
400-600	0,05-0,4	0,06-0,4	300-500	0,06-0,5	0,08-0,5	250-450	0,1-0,35	0,1-0,4



Cutting data values for CBN inserts

Index	Material	Strength N/mm ² / HB / HRC	CTB S20C / CTB S20U					
			EN / FN			SN-B		
			EN / FN			SN-B		
			v_c	f	a_p	v_c	f	a_p
	Sintered steels (< HV300)		250-750	0,02-0,25	0,02-0,4	250-700	0,04-0,25	0,03-0,4
	general sintered steel (> HV300)		200-700	0,02-0,25	0,02-0,4	200-700	0,04-0,25	0,03-0,4
	high density sintered steel (> HV600)		150-350	0,02-0,25	0,02-0,4	150-350	0,04-0,25	0,03-0,4
K.1.1	Grey cast iron	350 N/mm ² / 180 HB	800-1450	0,02-0,25	0,05-0,25	700-1400	0,04-0,25	0,05-0,25
K.1.2		500 N/mm ² / 260 HB	800-1450	0,02-0,25	0,05-0,25	700-1400	0,04-0,25	0,05-0,25
K.2.1	Spherulitic graphite cast iron	540 N/mm ² / 160 HB	900-1600	0,02-0,25	0,05-0,25	800-1600	0,04-0,25	0,05-0,25
K.2.2		845 N/mm ² / 250 HB	900-1600	0,02-0,25	0,05-0,25	800-1600	0,04-0,25	0,05-0,25
K.3.1	Malleable iron	440 N/mm ² / 130 HB	900-1600	0,02-0,25	0,05-0,25	800-1600	0,04-0,25	0,05-0,25
K.3.2		780 N/mm ² / 220 HB	900-1600	0,02-0,25	0,05-0,25	800-1600	0,04-0,25	0,05-0,25
S.1.1	Heat-resistant alloys	680 N/mm ² / 200 HB	200-600	0,02-0,25	0,02-0,4	200-550	0,04-0,25	0,03-0,4
S.1.2		950 N/mm ² / 280 HB	200-600	0,02-0,25	0,02-0,4	200-550	0,04-0,25	0,03-0,4
S.2.1		840 N/mm ² / 250 HB	200-600	0,02-0,25	0,02-0,4	200-550	0,04-0,25	0,03-0,4
S.2.2		1180 N/mm ² / 350 HB	200-600	0,02-0,25	0,02-0,4	200-550	0,04-0,25	0,03-0,4
S.2.3		1080 N/mm ² / 320 HB	200-600	0,02-0,25	0,02-0,4	200-550	0,04-0,25	0,03-0,4
S.3.1		400 N/mm ²						
S.3.2	Titanium alloys	1050 N/mm ² / 320 HB						
S.3.3		1400 N/mm ² / 410 HB						

* Tensile strength

Index	Material	Strength N/mm ² / HB / HRC	CTB S20C / CTB S20U					
			TN-E			SN-E		
			TN-E			SN-E		
			v_c	f	a_p	v_c	f	a_p
	Sintered steels (< HV300)		210-550	0,08-0,35	0,1-0,4	200-520	0,1-0,35	0,1-0,4
	general sintered steel (> HV300)		150-400	0,08-0,35	0,1-0,4	130-350	0,1-0,35	0,1-0,4
	high density sintered steel (> HV600)		100-220	0,08-0,35	0,1-0,4	100-200	0,1-0,35	0,1-0,4
K.1.1	Grey cast iron	350 N/mm ² / 180 HB	550-1000	0,08-0,35	0,08-0,4	550-950	0,1-0,35	0,1-0,4
K.1.2		500 N/mm ² / 260 HB	550-1000	0,08-0,35	0,08-0,4	550-950	0,1-0,35	0,1-0,4
K.2.1	Spherulitic graphite cast iron	540 N/mm ² / 160 HB	700-1200	0,08-0,35	0,08-0,4	700-1100	0,1-0,35	0,1-0,4
K.2.2		845 N/mm ² / 250 HB	700-1200	0,08-0,35	0,08-0,4	700-1100	0,1-0,35	0,1-0,4
K.3.1	Malleable iron	440 N/mm ² / 130 HB	700-1200	0,08-0,35	0,08-0,4	700-1100	0,1-0,35	0,1-0,4
K.3.2		780 N/mm ² / 220 HB	700-1200	0,08-0,35	0,08-0,4	700-1100	0,1-0,35	0,1-0,4
S.1.1	Heat-resistant alloys	680 N/mm ² / 200 HB	150-350	0,08-0,35	0,08-0,4	150-320	0,1-0,35	0,1-0,4
S.1.2		950 N/mm ² / 280 HB	150-350	0,08-0,35	0,08-0,4	150-320	0,1-0,35	0,1-0,4
S.2.1		840 N/mm ² / 250 HB	150-350	0,08-0,35	0,08-0,4	150-320	0,1-0,35	0,1-0,4
S.2.2		1180 N/mm ² / 350 HB	150-350	0,08-0,35	0,08-0,4	150-320	0,1-0,35	0,1-0,4
S.2.3		1080 N/mm ² / 320 HB	150-350	0,08-0,35	0,08-0,4	150-320	0,1-0,35	0,1-0,4
S.3.1		400 N/mm ²						
S.3.2	Titanium alloys	1050 N/mm ² / 320 HB						
S.3.3		1400 N/mm ² / 410 HB						

* Tensile strength

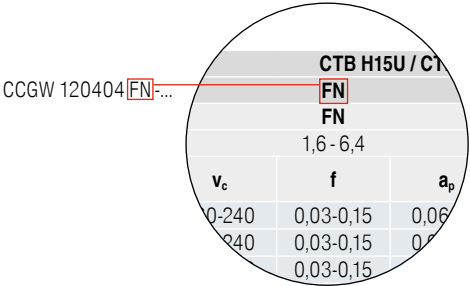


* Note chamfer width: The wider the chamfer, the more stable the cutting edge.

The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approx. $\pm 20\%$ according to the usage conditions.

CTB S20C / CTB S20U								
SN-C / TN-C			SN-C / TN-C			SN-D		
TN-D			TN-D			SN-D		
v _c	f	a _p	v _c	f	a _p	v _c	f	a _p
250-650	0,05-0,25	0,06-0,4	250-600	0,05-0,35	0,06-0,4	220-580	0,06-0,35	0,08-0,4
200-600	0,05-0,25	0,06-0,4	180-550	0,05-0,35	0,06-0,4	170-510	0,06-0,35	0,08-0,4
150-350	0,05-0,25	0,06-0,4	130-300	0,05-0,35	0,06-0,4	120-250	0,06-0,35	0,08-0,4
650-1300	0,05-0,25	0,06-0,4	650-1100	0,05-0,35	0,06-0,4	600-1000	0,06-0,35	0,08-0,5
650-1300	0,05-0,25	0,06-0,4	650-1100	0,05-0,35	0,06-0,4	600-1000	0,06-0,35	0,08-0,5
780-1400	0,05-0,25	0,06-0,4	750-1300	0,05-0,35	0,06-0,4	700-1250	0,06-0,35	0,08-0,5
780-1400	0,05-0,25	0,06-0,4	750-1300	0,05-0,35	0,06-0,4	700-1250	0,06-0,35	0,08-0,5
780-1400	0,05-0,25	0,06-0,4	750-1300	0,05-0,35	0,06-0,4	700-1250	0,06-0,35	0,08-0,5
200-550	0,05-0,25	0,06-0,4	180-500	0,05-0,4	0,06-0,4	180-450	0,06-0,5	0,08-0,5
200-550	0,05-0,25	0,06-0,4	180-500	0,05-0,4	0,06-0,4	180-450	0,06-0,5	0,08-0,5
200-550	0,05-0,25	0,06-0,4	180-500	0,05-0,4	0,06-0,4	180-450	0,06-0,5	0,08-0,5
200-550	0,05-0,25	0,06-0,4	180-500	0,05-0,4	0,06-0,4	180-450	0,06-0,5	0,08-0,5
200-550	0,05-0,25	0,06-0,4	180-500	0,05-0,4	0,06-0,4	180-450	0,06-0,5	0,08-0,5

CTB S20C / CTB S20U		
SN-F		
SN-F		
v _c	f	a _p
180-480	0,12-0,35	0,12-0,4
80-250	0,12-0,35	0,12-0,4
80-150	0,12-0,35	0,12-0,4
500-850	0,12-0,35	0,12-0,4
500-850	0,12-0,35	0,12-0,4
650-1000	0,12-0,35	0,12-0,4
650-1000	0,12-0,35	0,12-0,4
650-1000	0,12-0,35	0,12-0,4
650-1000	0,12-0,35	0,12-0,4
130-300	0,12-0,35	0,12-0,4
130-300	0,12-0,35	0,12-0,4
130-300	0,12-0,35	0,12-0,4
130-300	0,12-0,35	0,12-0,4
130-300	0,12-0,35	0,12-0,4



Cutting data values for CBN inserts

Index	Material	Strength	Cutting edges code negative insert* Cutting edges code positive insert* Ra (theo.)	CTB H15U / CTB H15C					
				FN			EN		
				FN			EN		
				1,6-6,4			1,0-3,2		
				v_c	f	a_p	v_c	f	a_p
H.1.1	Hardened steel	46-55 HRC	x	160-240	0,03-0,15	0,06-0,3	160-240	0,03-0,15	0,06-0,3
H.1.2		56-60 HRC	x	160-240	0,03-0,15	0,06-0,3	160-240	0,03-0,15	0,06-0,3
H.1.3		61-65 HRC	x	160-240	0,03-0,15	0,06-0,3	160-240	0,03-0,15	0,06-0,3
H.1.4		66-70 HRC	x	160-240	0,03-0,15	0,06-0,3	160-240	0,03-0,15	0,06-0,3
H.2.1	Chilled iron	400 HB	x	160-240	0,03-0,15	0,06-0,3	160-240	0,03-0,15	0,06-0,3
H.3.1	Hardened cast iron	55 HRC							

Index	Material	Strength	Cutting edges code negative insert* Cutting edges code positive insert* Ra (theo.)	CTB H21U / CTB H20C / CTB H21C					
				FN			TN-C		
				EN / FN			TN-C		
				1,6-6,4			1,0-4,5		
				v_c	f	a_p	v_c	f	a_p
H.1.1	Hardened steel	46-55 HRC	x	300-380	0,04-0,25	0,05-0,5	280-350	0,04-0,15	0,05-0,5
H.1.2		56-60 HRC	x	300-380	0,04-0,25	0,05-0,5	280-350	0,04-0,15	0,05-0,5
H.1.3		61-65 HRC	x	300-380	0,04-0,25	0,05-0,5	280-350	0,04-0,15	0,05-0,5
H.1.4		66-70 HRC	x	300-380	0,04-0,25	0,05-0,5	280-350	0,04-0,15	0,05-0,5
H.2.1	Chilled iron	400 HB	x	300-380	0,04-0,25	0,05-0,5	280-350	0,04-0,15	0,05-0,5
H.3.1	Hardened cast iron	55 HRC							

Index	Material	Strength	Cutting edges code negative insert* Cutting edges code positive insert* Ra (theo.)	CTB H21U / CTB H20C / CTB H21C					
				TN-E / SN-E			SN-F		
				TN-E			TN-F / SN-E		
				0,35-1,6			0,2-0,8		
				v_c	f	a_p	v_c	f	a_p
H.1.1	Hardened steel	46-55 HRC	x	210-260	0,05-0,15	0,1-0,5	180-230	0,06-0,20	0,1-0,5
H.1.2		56-60 HRC	x	210-260	0,05-0,15	0,1-0,5	180-230	0,06-0,20	0,1-0,5
H.1.3		61-65 HRC	x	210-260	0,05-0,15	0,1-0,5	180-230	0,06-0,20	0,1-0,5
H.1.4		66-70 HRC	x	210-260	0,05-0,15	0,1-0,5	180-230	0,06-0,20	0,1-0,5
H.2.1	Chilled iron	400 HB	x	210-260	0,05-0,15	0,1-0,5	180-230	0,06-0,20	0,1-0,5
H.3.1	Hardened cast iron	55 HRC							

Index	Material	Strength	Cutting edges code negative insert* Cutting edges code positive insert* Ra (theo.)	CTB H40U / CTB H40C / CTB H41U / CTB H41C					
				FN / EN			SN-B / TN-B		
				FN / EN			SN-B / TN-B		
				1,0-3,2			1,6-3,2		
				v_c	f	a_p	v_c	f	a_p
H.1.1	Hardened steel	46-55 HRC	x	190-250	0,03-0,15	0,03-0,5	180-250	0,03-0,2	0,05-0,7
H.1.2		56-60 HRC	x	190-250	0,03-0,15	0,03-0,5	180-250	0,03-0,2	0,05-0,7
H.1.3		61-65 HRC	x	190-250	0,03-0,15	0,03-0,5	180-250	0,03-0,2	0,05-0,7
H.1.4		66-70 HRC	x	190-250	0,03-0,15	0,03-0,5	180-250	0,03-0,2	0,05-0,7
H.2.1	Chilled iron	400 HB	x	190-250	0,03-0,15	0,03-0,5	180-250	0,03-0,2	0,05-0,7
H.3.1	Hardened cast iron	55 HRC							

Index	Material	Strength	Cutting edges code negative insert* Cutting edges code positive insert* Ra (theo.)	CTB H40U / CTB H40C / CTB H41U / CTB H41C					
				EN-T / SN-E			TN-E / SN-E		
				EN-T / TN-E / SN-E			TN-F		
				0,5-1,6			0,4-1,0		
				v_c	f	a_p	v_c	f	a_p
H.1.1	Hardened steel	46-55 HRC	x	140-200	0,05-0,15	0,08-0,5	180-230	0,05-0,25	0,1-0,5
H.1.2		56-60 HRC	x	140-200	0,05-0,15	0,08-0,5	180-230	0,05-0,25	0,1-0,5
H.1.3		61-65 HRC	x	140-200	0,05-0,15	0,08-0,5	180-230	0,05-0,25	0,1-0,5
H.1.4		66-70 HRC	x	140-200	0,05-0,15	0,08-0,5	180-230	0,05-0,25	0,1-0,5
H.2.1	Chilled iron	400 HB	x	140-200	0,05-0,15	0,08-0,5	180-230	0,05-0,25	0,1-0,5
H.3.1	Hardened cast iron	55 HRC							



* Note chamfer width: The wider the chamfer, the more stable the cutting edge.



The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approx. $\pm 20\%$ according to the usage conditions.

CTB H15U / CTB H15C								
SN-C			SN-E			RN (Rounded chamfer)		
SN-C			SN-E			RN (Rounded chamfer)		
0,5-1,6			0,1-0,8			0,1-0,8		
v_c	f	a_p	v_c	f	a_p	v_c	f	a_p
140-200	0,06-0,2	0,08-0,3	120-180	0,06-0,25	0,1-0,4	130-210	0,06-0,2	0,08-0,3
140-200	0,06-0,2	0,08-0,3	120-180	0,06-0,25	0,1-0,4	130-210	0,06-0,2	0,08-0,3
140-200	0,06-0,2	0,08-0,3	120-180	0,06-0,25	0,1-0,4	130-210	0,06-0,2	0,08-0,3
140-200	0,06-0,2	0,08-0,3	120-180	0,06-0,25	0,1-0,4	130-210	0,06-0,2	0,08-0,3
140-200	0,06-0,2	0,08-0,3	120-180	0,06-0,25	0,1-0,4	130-210	0,06-0,2	0,08-0,3

CTB H21U / CTB H20C / CTB H21C								
TN-D			TN-D / SN-D			TN-E		
SN-B			TN-D / SN-C			SN-D		
0,8-3,0			0,5-2,0			0,35-2,5		
v_c	f	a_p	v_c	f	a_p	v_c	f	a_p
270-330	0,06-0,25	0,05-0,5	250-320	0,06-0,25	0,08-1,0	220-290	0,05-0,15	0,08-0,5
270-330	0,06-0,25	0,05-0,5	250-320	0,06-0,25	0,08-1,0	220-290	0,05-0,15	0,08-0,5
270-330	0,06-0,25	0,05-0,5	250-320	0,06-0,25	0,08-1,0	220-290	0,05-0,15	0,08-0,5
270-330	0,06-0,25	0,05-0,5	250-320	0,06-0,25	0,08-1,0	220-290	0,05-0,15	0,08-0,5
270-330	0,06-0,25	0,05-0,5	250-320	0,06-0,25	0,08-1,0	220-290	0,05-0,15	0,08-0,5

CTB H21U / CTB H20C / CTB H21C		
SN-G		
TN-G / SN-F		
0,1-0,5		
v_c	f	a_p
160-200	0,05-0,12	0,1-0,5
160-200	0,05-0,12	0,1-0,5
160-200	0,05-0,12	0,1-0,5
160-200	0,05-0,12	0,1-0,5
160-200	0,05-0,12	0,1-0,5

CTB H40U / CTB H40C / CTB H41U / CTB H41C								
SN-C			SN-D			TN-D		
SN-C / TN-D			SN-D			TN-D		
0,8-3,0			0,8-2,0			0,5-1,6		
v_c	f	a_p	v_c	f	a_p	v_c	f	a_p
180-240	0,04-0,15	0,03-0,5	160-220	0,04-0,15	0,03-0,5	150-210	0,04-0,25	0,08-0,5
180-240	0,04-0,15	0,03-0,5	160-220	0,04-0,15	0,03-0,5	150-210	0,04-0,25	0,08-0,5
180-240	0,04-0,15	0,03-0,5	160-220	0,04-0,15	0,03-0,5	150-210	0,04-0,25	0,08-0,5
180-240	0,04-0,15	0,03-0,5	160-220	0,04-0,15	0,03-0,5	150-210	0,04-0,25	0,08-0,5
180-240	0,04-0,15	0,03-0,5	160-220	0,04-0,15	0,03-0,5	150-210	0,04-0,25	0,08-0,5

CTB H40U / CTB H40C / CTB H41U / CTB H41C					
TN-F / SN-F			SN-G		
SN-F			SN-G		
0,2-0,8			0,1-0,5		
v_c	f	a_p	v_c	f	a_p
130-200	0,04-0,15	0,1-0,5	120-190	0,04-0,12	0,1-0,5
130-200	0,04-0,15	0,1-0,5	120-190	0,04-0,12	0,1-0,5
130-200	0,04-0,15	0,1-0,5	120-190	0,04-0,12	0,1-0,5
130-200	0,04-0,15	0,1-0,5	120-190	0,04-0,12	0,1-0,5
130-200	0,04-0,15	0,1-0,5	120-190	0,04-0,12	0,1-0,5

CTB H15U / CTB H15C		
FN		
FN		
1,6 - 6,4		
v_c	f	a_p
130-240	0,03-0,15	0,06-0,3
130-240	0,03-0,15	0,06-0,3
130-240	0,03-0,15	0,06-0,3

CCGW 120404 FN...

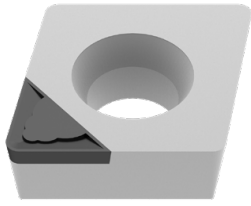
Cutting data standard values for diamond cutting materials CTD PD20 / PS30 / PU20 / CD10 / MD05

Index			Material group	a _p = 0,04–0,4 mm		a _p = 0,4–1,0 mm		a _p = 0,4–2,5 mm	
				Surface roughness R _z in µm		Surface roughness R _z in µm		Surface roughness R _z in µm	
				2,5–5,0	5,0–10	2,5–5,0	5,0–10	2,5–5,0	5,0–10
				CTD ...	CTD ...	CTD ...	CTD ...	CTD ...	CTD ...
N.1.1 N.1.2	Aluminium wrought alloys without Si f=0.05–0.5 mm/rev.		Tool Material v _c in m/min	PD20 / PU20 / CD10 / MD05 400–2500	PD20 / PU20 / CD10 / MD05 400–2500	PD20 / PU20 / CD10 / MD05 400–2000	PD20 / PU20 / CD10 / MD05 400–2000	PD20 / PU20 / CD10 / MD05 400–1600	PD20 / PU20 / CD10 / MD05 400–1600
			Tool Material v _c in m/min	PD20 / CD10 400–2500		PD20 / CD10 400–2000		PD20 / CD10 400–1600	
			Tool Material v _c in m/min	PD20 / PU20 400–2500	PD20 / PU20 400–2500	PD20 / PU20 400–2000	PD20 / PU20 400–2000	PD20 / PU20 400–1600	PD20 / PU20 400–1600
N.2.1	Cast Aluminium Alloys Si≤12 % – hardened or Si=12–20% – non hardened f=0.05–0,5 mm/rev.		Tool Material v _c in m/min	PS30 / PU20 / CD10 / MD05 600–2000	PS30 / PU20 / CD10 / MD05 600–2200	PS30 / PU20 / CD10 / MD05 600–1800	PS30 / PU20 / CD10 / MD05 600–2000	PS30 / PU20 / CD10 / MD05 600–1500	PS30 / PU20 / CD10 / MD05 600–1800
			Tool Material v _c in m/min	PD20 / PU20 / CD10 400–2000	PD20 / PU20 / CD10 400–2200	PD20 / PU20 / CD10 400–1800	PS30 / PU20 / CD10 600–2000	PS30 / PU20 / CD10 400–1500	PS30 / PU20 / CD10 400–1800
			Tool Material v _c in m/min	PS30 600–2000	PS30 600–2200	PS30 600–1800	PS30 600–2000	PS30 600–1500	
N.2.2 N.2.3	Aluminium cast alloys Si=12–20 % f=0.05–0.5 mm/rev.		Tool Material v _c in m/min	PU20 / CD10 / MD05 800–1200	PU20 / CD10 / MD05 400–1800	PU20 / CD10 / MD05 700–1000	PU20 / CD10 / MD05 400–1500	PU20 / CD10 / MD05 600–900	PU20 / CD10 / MD05 400–1200
			Tool Material v _c in m/min	PU20 / CD10 600–1800		PU20 / CD10 600–1500		PU20 / CD10 600–1200	
			Tool Material v _c in m/min		PU20 600–1800		PU20 600–1500		
N.3.1 N.3.2 N.3.3	Copper and copper wrought alloys f=0.05–0.5 mm/rev.		Tool Material v _c in m/min	PD20 / PU20 / CD10 / MD05 400–1800	PD20 / PU20 / CD10 / MD05 300–1600	PD20 / PU20 / CD10 / MD05 400–1600	PS30 / PU20 / CD10 / MD05 300–1600	PD20 / PU20 / CD10 / MD05 400–1400	PD20 / PU20 / CD10 / MD05 400–1500
			Tool Material v _c in m/min	PU20 / CD10 300–1500	PD20 / PU20 / CD10 300–1500	PD20 / PU20 / CD10 400–1600	PS30 / PU20 / CD10 300–1500	PD20 / PU20 / CD10 400–1500	PD20 / PU20 / CD10 300–1400
			Tool Material v _c in m/min		PD20 / PU20 300–1800		PS30 / PU20 300–1700	PD20 / PU20 300–1600	PS30 / PU20 200–1300
O.1.1 O.1.2	Plastic materials without reinforcement (acrylic glass) f=0.05–0.7 mm/rev.		Tool Material v _c in m/min		PD20 / CD10 / MD05 400–1200		PD20 / CD10 / MD05 300–1000		PS30 / CD10 / MD05 200–1000
			Tool Material v _c in m/min	PD20 / CD10 300–1200		PD20 / CD10 200–1000		PS30 / CD10 200–900	
			Tool Material v _c in m/min		PD20 / CD10 400–1200		PD20 / CD10 300–1000		PD20 / CD10 200–1000
O.2.1 O.2.2	Plastic materials with reinforcement (glass-fibre, carbon-fibre reinforced) f=0.05–0.7 mm/rev.		Tool Material v _c in m/min	PS30 / PU20 / CD10 / MD05 500–1000		PS30 / PU20 / CD10 / MD05 400–900	PS30 / PU20 / CD10 / MD05 300–900	PS30 / PU20 / CD10 / MD05 300–800	PS30 / PU20 / CD10 / MD05 200–1200
			Tool Material v _c in m/min	PS30 / PU20 / CD10 400–900		PS30 / PU20 / CD10 300–800	PS30 / PU20 / CD10 200–900	PS30 / PU20 / CD10 200–800	PS30 / PU20 / CD10 200–1400
			Tool Material v _c in m/min	PU20 500–1000		PU20 400–800	PU20 300–1000	PU20 300–800	
O.3.1	Graphite		Tool Material v _c in m/min	PD20 / PS30 / PU20 / CD10 100–3000		PD20 / PS30 / PU20 / CD10 100–3000		PD20 / PS30 / PU20 / CD10 100–3000	

 Smooth cut Irregular cutting depth Interrupted cut

Cutting data standard values for the CB chip breaker geometries

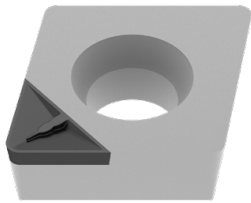
-CB1



3D-Chip Breaker -CB1				
Corner Radius	a_p in mm		f_z in mm/rev.	
	min.	max.	min.	max.
0,1 mm	0,05	0,30	0,02	0,05
0,2 mm	0,06	0,40	0,03	0,08
0,4 mm	0,10	0,80	0,04	0,15
0,8 mm	0,15	1,00	0,08	0,20
1,2 mm	0,30	1,50	0,12	0,25

- ▲ Finish and Superfinish
- ▲ Extremely sharp cutting edge geometry
- ▲ Depth of Cut a_p : 0.05–1.5 mm
- ▲ Smallest cutting pressure for highest accuracies
- ▲ For machining of thin-walled and unstable workpieces

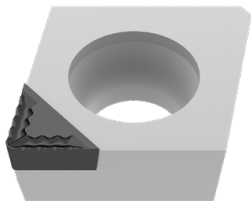
-CB2



3D-Chip Breaker -CB2				
Corner Radius	a_p in mm		f_z in mm/rev.	
	min.	max.	min.	max.
0,2 mm	0,50	0,80	0,08	0,12
0,4 mm	0,60	1,50	0,08	0,20
0,8 mm	0,70	1,50	0,15	0,30
1,2 mm	0,80	2,00	0,20	0,40

- ▲ Semi-finish and Finish machining
- ▲ Negative edge preparation
- ▲ Cutting Depth a_p : 0.5–2.0 mm
- ▲ High surface quality and tight tolerances
- ▲ Machining of solid workpieces under stable conditions

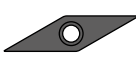
-CB3



3D-Chip Breaker -CB3				
Corner Radius	a_p in mm		f_z in mm/rev.	
	min.	max.	min.	max.
0,4 mm	1,00	3,00	0,10	0,20
0,8 mm	1,00	3,00	0,15	0,35

- ▲ Medium and rough machining
- ▲ Highly aggressive chip breaker
- ▲ Cutting depth a_p : 1.0–3.0 mm
- ▲ Stable component conditions necessary
- ▲ Cooling must be ensured

Cutting data standard values for negative inserts

	Designation	-CF20 (Cermet)						-F50					
		f			a _p			f			a _p		
		min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.
		mm/rev.			mm			mm/rev.			mm		
	CN.. 090304							0,06	0,15	0,25	0,2	0,5	1,5
	CN.. 090308							0,10	0,20	0,30	0,4	1,0	2,0
	CN.. 120404	0,05	0,15	0,25	0,3	0,5	1,5	0,06	0,15	0,25	0,2	0,6	1,5
	CN.. 120408	0,07	0,15	0,25	0,3	0,5	1,5	0,10	0,20	0,30	0,4	1,0	2,0
	CN.. 120412							0,14	0,25	0,35	0,6	1,4	2,6
	CN.. 120416												
	CN.. 160608												
	CN.. 160612												
	CN.. 160616												
	CN.. 160624												
	CN.. 190608												
	CN.. 190612												
	CN.. 190616												
	CN.. 190624												
	CN.. 250924												
	DN.. 110402							0,04	0,10	0,20	0,1	0,4	2,3
	DN.. 110404	0,05	0,15	0,25	0,3	0,5	1,5	0,06	0,15	0,25	0,2	0,6	1,5
	DN.. 110408	0,07	0,15	0,25	0,3	0,5	1,5	0,10	0,20	0,30	0,4	1,0	2,0
	DN.. 110412							0,14	0,25	0,35	0,6	1,4	2,6
	DN.. 150404							0,06	0,15	0,25	0,2	0,6	1,5
	DN.. 150408							0,10	0,20	0,30	0,4	1,0	2,0
	DN.. 150412							0,14	0,25	0,35	0,6	1,4	2,6
	DN.. 150416												
	DN.. 150604	0,05	0,15	0,25	0,3	0,5	1,5	0,06	0,15	0,25	0,2	0,6	1,5
	DN.. 150608	0,07	0,15	0,25	0,3	0,5	1,5	0,10	0,20	0,30	0,4	1,0	2,0
	DN.. 150612	0,10	0,20	0,30	0,5	0,7	1,5	0,14	0,25	0,35	0,6	1,4	2,6
	DN.. 150616												
	SN.. 090308							0,10	0,20	0,30	0,4	1,0	2,0
	SN.. 120404							0,06	0,15	0,25	0,2	0,6	1,5
	SN.. 120408							0,10	0,20	0,30	0,4	1,0	2,0
	SN.. 120412							0,14	0,25	0,35	0,6	1,4	2,6
	SN.. 120416												
	SN.. 150608												
	SN.. 150612												
	SN.. 150616												
	SN.. 190612												
	SN.. 190616												
	SN.. 190624												
	SN.. 250724												
	SN.. 250924												
	TN.. 110304							0,06	0,15	0,25	0,2	0,6	1,5
	TN.. 110308							0,10	0,20	0,30	0,4	1,0	2,0
	TN.. 160404	0,05	0,15	0,25	0,3	0,5	1,5	0,06	0,15	0,25	0,2	0,6	1,5
	TN.. 160408	0,07	0,15	0,25	0,3	0,5	1,5	0,10	0,20	0,30	0,4	1,0	2,0
	TN.. 160412	0,10	0,20	0,30	0,5	0,7	1,5	0,14	0,25	0,35	0,6	1,4	2,6
	TN.. 220404												
	TN.. 220408												
	TN.. 220412												
	TN.. 220416												
	VN.. 160404							0,06	0,15	0,25	0,2	0,6	1,5
	VN.. 160408							0,10	0,20	0,30	0,4	1,0	2,0
	VN.. 160412												
	WN.. 060404	0,05	0,15	0,25	0,3	0,5	1,5	0,06	0,15	0,25	0,2	0,6	1,5
	WN.. 060408	0,07	0,15	0,25	0,3	0,5	1,5	0,10	0,20	0,30	0,4	1,0	2,0
	WN.. 060412												
	WN.. 080404							0,06	0,15	0,25	0,2	0,6	1,5
	WN.. 080408	0,07	0,15	0,25	0,3	0,5	1,5	0,10	0,20	0,30	0,4	1,0	2,0
	WN.. 080412							0,14	0,25	0,35	0,6	1,4	2,6
	WN.. 080416												

Sharp
←
→
 Stable

Designation	-TFQ						-XU						-M50					
	f			a _p			f			a _p			f			a _p		
	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.
	mm/rev.			mm			mm/rev.			mm			mm/rev.			mm		
CN.. 090304																		
CN.. 090308																		
CN.. 120404	0,10	0,15	0,35	0,4	1,0	3,0	0,08	0,15	0,25	0,3	1,5	2,5	0,10	0,20	0,30	0,4	2,0	5,0
CN.. 120408	0,10	0,25	0,50	0,5	1,5	4,0	0,13	0,25	0,35	0,6	2,0	3,0	0,15	0,25	0,40	0,6	2,0	5,0
CN.. 120412	0,15	0,30	0,70	0,8	2,0	5,0	0,15	0,30	0,45	0,9	2,0	3,5	0,20	0,30	0,50	1,0	2,0	5,0
CN.. 120416													0,25	0,40	0,60	1,4	2,0	5,0
CN.. 160608													0,15	0,25	0,40	0,6	3,0	8,0
CN.. 160612													0,20	0,30	0,50	1,0	3,0	8,0
CN.. 160616													0,25	0,40	0,60	1,4	3,0	8,0
CN.. 160624																		
CN.. 190608																		
CN.. 190612																		
CN.. 190616																		
CN.. 190624																		
CN.. 250924																		
DN.. 110402																		
DN.. 110404													0,10	0,20	0,30	0,4	1,5	4,0
DN.. 110408													0,15	0,25	0,40	0,6	1,5	4,0
DN.. 110412													0,20	0,30	0,50	1,0	1,5	4,0
DN.. 150404													0,10	0,20	0,30	0,4	2,0	5,0
DN.. 150408													0,15	0,25	0,40	0,6	2,0	5,0
DN.. 150412													0,20	0,30	0,50	1,0	2,0	5,0
DN.. 150416													0,25	0,40	0,60	1,4	2,0	5,0
DN.. 150604	0,10	0,15	0,30	0,4	1,0	3,0	0,08	0,15	0,25	0,3	1,5	2,5	0,10	0,20	0,30	0,4	2,0	5,0
DN.. 150608	0,10	0,25	0,40	0,5	1,5	4,0	0,13	0,25	0,35	0,6	2,0	3,0	0,15	0,25	0,40	0,6	2,0	5,0
DN.. 150612							0,15	0,25	0,40	0,9	2,0	3,5	0,20	0,30	0,50	1,0	2,0	5,0
DN.. 150616													0,25	0,40	0,60	1,4	2,0	5,0
SN.. 090308																		
SN.. 120404																		
SN.. 120408													0,15	0,25	0,40	0,6	2,0	5,0
SN.. 120412													0,20	0,30	0,50	1,0	2,0	5,0
SN.. 120416													0,25	0,40	0,60	1,4	2,0	5,0
SN.. 150608													0,15	0,25	0,40	0,6	3,0	8,0
SN.. 150612													0,20	0,30	0,50	1,0	3,0	8,0
SN.. 150616													0,25	0,40	0,60	1,4	3,0	8,0
SN.. 190612																		
SN.. 190616																		
SN.. 190624																		
SN.. 250724																		
SN.. 250924																		
TN.. 110304																		
TN.. 110308																		
TN.. 160404													0,10	0,20	0,30	0,4	2,0	5,0
TN.. 160408													0,15	0,25	0,40	0,6	2,0	5,0
TN.. 160412													0,20	0,30	0,50	1,0	2,0	5,0
TN.. 220404																		
TN.. 220408													0,15	0,25	0,40	0,6	3,0	8,0
TN.. 220412													0,20	0,30	0,50	1,0	3,0	8,0
TN.. 220416																		
VN.. 160404							0,08	0,15	0,20	0,3	1,0	1,8	0,10	0,20	0,30	0,4	1,0	4,0
VN.. 160408							0,13	0,20	0,30	0,6	1,5	2,5	0,15	0,25	0,40	0,6	1,0	4,0
VN.. 160412													0,20	0,30	0,50	1,0	1,0	4,0
WN.. 060404	0,10	0,18	0,35	0,4	0,8	3,0							0,10	0,20	0,30	0,4	1,0	3,0
WN.. 060408	0,10	0,20	0,50	0,5	1,5	3,0							0,15	0,25	0,40	0,6	1,0	3,0
WN.. 060412													0,20	0,30	0,50	1,0	1,0	3,0
WN.. 080404							0,08	0,15	0,25	0,3	1,5	2,5	0,10	0,20	0,30	0,4	1,5	4,0
WN.. 080408	0,10	0,25	0,50	0,5	1,5	4,0	0,13	0,22	0,35	0,6	2,0	3,0	0,15	0,25	0,40	0,6	1,5	4,0
WN.. 080412	0,15	0,30	0,70	0,8	2,0	5,0	0,15	0,25	0,45	0,9	2,0	3,5	0,20	0,30	0,50	1,0	1,5	4,0
WN.. 080416													0,25	0,40	0,60	1,4	1,5	4,0

Sharp stable



Information on the cutting data of chip breakers not included in this overview, can be found on → **Page 220–227**

Cutting data standard values for negative inserts

Designation	-TMQ						-M70					
	f			a _p			f			a _p		
	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.
	mm/rev.			mm			mm/rev.			mm		
CN.. 090304												
CN.. 090308												
CN.. 120404												
CN.. 120408	0,20	0,40	0,65	0,8	3,0	5,0	0,20	0,30	0,45	0,8	3,0	6,0
CN.. 120412	0,25	0,50	0,85	1,0	3,0	6,0	0,25	0,40	0,60	1,2	3,0	6,0
CN.. 120416							0,30	0,45	0,70	1,6	3,0	6,0
CN.. 160608							0,20	0,30	0,45	0,8	4,0	8,0
CN.. 160612							0,25	0,40	0,60	1,2	4,0	8,0
CN.. 160616							0,30	0,45	0,70	1,6	4,0	8,0
CN.. 160624							0,40	0,70	1,20	2,4	4,0	8,0
CN.. 190608							0,20	0,30	0,45	0,8	4,5	9,0
CN.. 190612							0,25	0,40	0,60	1,2	4,5	9,0
CN.. 190616							0,30	0,45	0,70	1,6	4,5	9,0
CN.. 190624							0,40	0,70	1,20	2,4	4,5	9,0
CN.. 250924							0,40	0,70	1,20	2,4	6,0	13,0
DN.. 110402												
DN.. 110404												
DN.. 110408							0,20	0,25	0,45	0,8	2,0	5,0
DN.. 110412							0,25	0,35	0,60	1,2	2,0	5,0
DN.. 150404												
DN.. 150408							0,20	0,25	0,45	0,8	2,5	6,0
DN.. 150412							0,25	0,35	0,60	1,2	2,5	6,0
DN.. 150416							0,30	0,40	0,70	1,6	2,5	6,0
DN.. 150604												
DN.. 150608	0,15	0,30	0,50	0,8	2,5	5,0	0,20	0,25	0,45	0,8	2,5	6,0
DN.. 150612	0,20	0,40	0,60	1,0	3,0	5,0	0,25	0,35	0,60	1,2	2,5	6,0
DN.. 150616							0,30	0,40	0,70	1,6	2,5	6,0
SN.. 090308												
SN.. 120404												
SN.. 120408							0,20	0,30	0,50	0,8	3,0	6,0
SN.. 120412							0,25	0,40	0,65	1,2	3,0	6,0
SN.. 120416							0,30	0,45	0,70	1,6	3,0	6,0
SN.. 150608												
SN.. 150612							0,25	0,40	0,65	1,2	4,0	8,0
SN.. 150616							0,30	0,45	0,75	1,6	4,0	8,0
SN.. 190612							0,25	0,40	0,65	1,2	4,5	9,0
SN.. 190616							0,30	0,45	0,75	1,6	4,5	9,0
SN.. 190624							0,40	0,70	1,20	2,4	4,5	9,0
SN.. 250724												
SN.. 250924							0,40	0,70	1,20	2,4	6,0	13,0
TN.. 110304												
TN.. 110308												
TN.. 160404												
TN.. 160408							0,20	0,25	0,45	0,8	2,5	6,0
TN.. 160412							0,25	0,35	0,60	1,2	2,5	6,0
TN.. 220404							0,15	0,20	0,30	0,4	3,0	7,0
TN.. 220408							0,20	0,25	0,45	0,8	3,0	7,0
TN.. 220412							0,25	0,35	0,60	1,2	3,0	7,0
TN.. 220416							0,30	0,40	0,70	1,6	3,0	7,0
VN.. 160404												
VN.. 160408												
VN.. 160412												
WN.. 060404												
WN.. 060408							0,20	0,30	0,45	0,8	2,0	4,0
WN.. 060412							0,25	0,40	0,60	1,2	2,0	4,0
WN.. 080404												
WN.. 080408	0,20	0,30	0,65	0,8	3,0	5,0	0,20	0,30	0,45	0,8	2,5	5,0
WN.. 080412	0,25	0,40	0,85	1,0	3,0	6,0	0,25	0,40	0,60	1,2	2,5	5,0
WN.. 080416							0,30	0,45	0,70	1,6	2,5	5,0

Sharp stable



The data shows reference values. An adjustment to the actual conditions may be required.

Designation	-R28						-R58						-R88					
	f			a _p			f			a _p			f			a _p		
	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.
	mm/rev.			mm			mm/rev.			mm			mm/rev.			mm		
CN.. 090304																		
CN.. 090308																		
CN.. 120404																		
CN.. 120408	0,25	0,35	0,55	0,8	3,0	7,0	0,25	0,45	0,70	1,0	3,0	7,0						
CN.. 120412	0,30	0,45	0,70	1,0	3,0	7,0	0,30	0,55	0,85	1,5	3,0	7,0						
CN.. 120416	0,30	0,60	0,90	1,5	3,0	7,0	0,35	0,65	1,00	2,0	3,0	7,0						
CN.. 160608																		
CN.. 160612	0,30	0,45	0,70	1,0	4,0	9,0	0,30	0,55	0,85	1,5	4,0	9,0						
CN.. 160616	0,35	0,60	0,90	1,5	4,0	9,0	0,35	0,65	1,00	2,0	4,0	9,0						
CN.. 160624							0,40	0,75	1,20	2,5	4,0	9,0	0,40	0,70	1,20	2,0	5,0	9,0
CN.. 190608																		
CN.. 190612	0,30	0,45	0,70	1,0	5,5	12,0	0,35	0,55	0,85	1,5	5,5	12,0						
CN.. 190616	0,35	0,60	0,90	1,5	5,5	12,0	0,40	0,65	1,00	2,0	5,5	12,0	0,40	0,70	1,00	2,0	5,0	12,0
CN.. 190624	0,35	0,65	1,00	2,0	5,5	12,0	0,40	0,75	1,20	2,5	5,5	12,0	0,40	0,70	1,20	2,0	5,0	12,0
CN.. 250924							0,45	0,80	1,30	2,5	8,0	16,0	0,60	1,00	1,50	3,5	10,0	18,0
DN.. 110402																		
DN.. 110404																		
DN.. 110408																		
DN.. 110412																		
DN.. 150404																		
DN.. 150408																		
DN.. 150412																		
DN.. 150416																		
DN.. 150604																		
DN.. 150608																		
DN.. 150612	0,25	0,45	0,70	1,0	2,5	6,0	0,30	0,50	0,80	1,5	2,5	6,0						
DN.. 150616	0,30	0,60	0,85	1,5	2,5	6,0	0,35	0,60	0,90	2,0	2,5	6,0						
SN.. 090308																		
SN.. 120404																		
SN.. 120408							0,25	0,45	0,70	1,0	3,0	7,0						
SN.. 120412							0,30	0,55	0,85	1,5	3,0	7,0						
SN.. 120416																		
SN.. 150608																		
SN.. 150612	0,30	0,35	0,70	1,0	4,0	9,0	0,30	0,55	0,85	1,5	4,0	9,0						
SN.. 150616	0,35	0,60	0,90	1,5	4,0	9,0	0,35	0,65	1,00	2,0	4,0	9,0						
SN.. 190612							0,35	0,55	0,85	1,5	5,5	12,0						
SN.. 190616	0,35	0,60	0,90	1,5	5,5	12,0	0,40	0,65	1,00	2,0	5,5	12,0	0,40	0,70	1,00	2,0	5,0	12,0
SN.. 190624							0,40	0,75	1,20	2,0	5,5	12,0	0,40	0,70	1,20	2,0	5,0	12,0
SN.. 250724	0,35	0,65	1,00	2,0	7,0	16,0	0,45	0,80	1,30	2,5	8,0	16,0	0,60	1,00	1,50	3,5	10,0	18,0
SN.. 250924	0,35	0,65	1,00	2,0	7,0	16,0	0,45	0,80	1,30	2,5	8,0	16,0	0,60	1,00	1,50	3,5	10,0	18,0
TN.. 110304																		
TN.. 110308																		
TN.. 160404																		
TN.. 160408																		
TN.. 160412																		
TN.. 220404																		
TN.. 220408																		
TN.. 220412							0,30	0,50	0,80	1,5	3,0	7,0						
TN.. 220416	0,30	0,55	0,85	1,5	3,0	7,0												
VN.. 160404																		
VN.. 160408																		
VN.. 160412																		
WN.. 060404																		
WN.. 060408																		
WN.. 060412																		
WN.. 080404																		
WN.. 080408																		
WN.. 080412																		
WN.. 080416																		

Sharp stable



Information on the cutting data of chip breakers not included in this overview, can be found on → **Page 220–227**

Cutting data standard values for negative inserts

Designation	-F30						-M30					
	f			a _p			f			a _p		
	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.
	mm/rev.			mm			mm/rev.			mm		
CN.. 090304												
CN.. 090308												
CN.. 120404	0,05	0,15	0,25	0,4	1,0	2,0						
CN.. 120408	0,10	0,22	0,35	0,8	1,5	2,5	0,15	0,25	0,40	1,0	2,0	4,5
CN.. 120412							0,20	0,30	0,50	1,2	2,5	5,0
CN.. 120416							0,25	0,35	0,55	1,6	2,5	5,0
CN.. 160608												
CN.. 160612												
CN.. 160616												
CN.. 160624												
CN.. 190608												
CN.. 190612												
CN.. 190616												
CN.. 190624												
CN.. 250924												
DN.. 110402												
DN.. 110404	0,05	0,15	0,25	0,4	1,0	2,0						
DN.. 110408	0,10	0,20	0,35	0,8	1,5	2,5	0,15	0,25	0,40	1,0	2,0	4,5
DN.. 110412							0,20	0,30	0,50	1,2	2,0	4,5
DN.. 150404												
DN.. 150408												
DN.. 150412												
DN.. 150416												
DN.. 150604	0,05	0,15	0,25	0,4	1,0	2,0						
DN.. 150608	0,10	0,20	0,35	0,8	1,5	2,5	0,15	0,25	0,40	1,0	2,0	5,5
DN.. 150612							0,20	0,30	0,50	1,2	2,0	5,5
DN.. 150616												
SN.. 090308												
SN.. 120404	0,10	0,15	0,30	0,4	1,0	2,0						
SN.. 120408	0,15	0,20	0,40	0,8	1,5	2,5	0,20	0,25	0,45	1,0	2,0	4,5
SN.. 120412	0,15	0,20	0,40	1,2	1,8	2,5	0,25	0,30	0,50	1,2	2,0	5,0
SN.. 120416												
SN.. 150608												
SN.. 150612												
SN.. 150616												
SN.. 190612												
SN.. 190616												
SN.. 190624												
SN.. 250724												
SN.. 250924												
TN.. 110304												
TN.. 110308												
TN.. 160404	0,05	0,15	0,25	0,4	1,0	2,0						
TN.. 160408	0,10	0,15	0,35	0,8	1,5	2,5	0,15	0,25	0,40	1,0	2,0	4,5
TN.. 160412							0,20	0,30	0,50	1,2	2,0	4,5
TN.. 220404												
TN.. 220408												
TN.. 220412												
TN.. 220416												
VN.. 160404	0,08	0,10	0,20	0,4	1,0	2,0						
VN.. 160408	0,10	0,15	0,30	0,8	1,5	2,5	0,15	0,25	0,40	1,0	1,5	4,0
VN.. 160412												
WN.. 060404	0,05	0,15	0,25	0,4	1,0	2,0						
WN.. 060408	0,10	0,20	0,30	0,8	1,5	2,5	0,15	0,25	0,40	1,0	1,5	3,5
WN.. 060412							0,20	0,30	0,45	1,2	1,5	4,0
WN.. 080404	0,05	0,15	0,25	0,4	1,0	2,0						
WN.. 080408	0,10	0,20	0,35	0,8	1,5	2,5	0,15	0,25	0,40	1,0	2,0	4,5
WN.. 080412							0,20	0,30	0,50	1,2	2,0	5,0
WN.. 080416												

Sharp → stable



The data shows reference values. An adjustment to the actual conditions may be required.

Designation	-M60						-M34					
	f			a _p			f			a _p		
	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.
	mm/rev.			mm			mm/rev.			mm		
CN.. 090304												
CN.. 090308												
CN.. 120404							0,08	0,12	0,18	1,0	1,5	3,0
CN.. 120408	0,25	0,30	0,50	1,5	2,5	6,0	0,10	0,15	0,35	1,0	1,8	3,5
CN.. 120412	0,30	0,35	0,55	2,0	3,0	6,0	0,13	0,20	0,40	1,5	2,0	4,0
CN.. 120416	0,30	0,40	0,60	2,0	3,0	6,0	0,15	0,25	0,45	2,0	3,0	4,5
CN.. 160608												
CN.. 160612	0,30	0,35	0,55	2,0	3,0	8,0						
CN.. 160616												
CN.. 160624												
CN.. 190608												
CN.. 190612												
CN.. 190616												
CN.. 190624												
CN.. 250924												
DN.. 110402												
DN.. 110404												
DN.. 110408												
DN.. 110412												
DN.. 150404							0,08	0,12	0,18	0,8	1,2	2,5
DN.. 150408							0,10	0,15	0,30	1,0	1,8	3,5
DN.. 150412							0,13	0,20	0,38	1,5	2,0	4,0
DN.. 150416												
DN.. 150604												
DN.. 150608	0,25	0,30	0,45	1,5	2,5	6,0	0,10	0,15	0,30	1,0	1,8	3,5
DN.. 150612	0,30	0,40	0,55	1,5	2,5	6,0	0,13	0,20	0,38	1,5	2,0	4,0
DN.. 150616												
SN.. 090308												
SN.. 120404												
SN.. 120408	0,30	0,35	0,50	1,5	2,0	6,0	0,15	0,25	0,40	1,0	2,0	4,0
SN.. 120412	0,30	0,40	0,55	2,0	2,5	6,0	0,15	0,25	0,45	1,5	2,5	4,5
SN.. 120416	0,30	0,40	0,60	2,0	2,5	6,0						
SN.. 150608												
SN.. 150612												
SN.. 150616												
SN.. 190612												
SN.. 190616												
SN.. 190624												
SN.. 250724												
SN.. 250924												
TN.. 110304												
TN.. 110308												
TN.. 160404												
TN.. 160408	0,25	0,25	0,45	1,5	2,5	5,0	0,10	0,15	0,35	1,0	2,0	4,0
TN.. 160412	0,30	0,30	0,55	2,0	2,5	5,5						
TN.. 220404							0,10	0,15	0,35	1,0	2,0	4,0
TN.. 220408							0,13	0,20	0,40	1,5	2,5	4,0
TN.. 220412												
TN.. 220416							0,15	0,25	0,45	2,0	2,5	4,5
VN.. 160404							0,07	0,10	0,18	0,8	1,2	2,0
VN.. 160408							0,10	0,15	0,20	1,0	1,5	2,5
VN.. 160412							0,13	0,18	0,25	1,5	1,8	3,0
WN.. 060404												
WN.. 060408	0,25	0,30	0,45	1,5	2,0	4,0						
WN.. 060412	0,30	0,35	0,50	2,0	2,5	4,5						
WN.. 080404												
WN.. 080408	0,25	0,30	0,50	1,5	2,0	5,0	0,10	0,15	0,35	1,0	2,0	4,0
WN.. 080412	0,30	0,35	0,55	2,0	2,5	5,5	0,13	0,20	0,40	1,5	2,0	4,0
WN.. 080416												

Sharp
←
→
 Stable



Information on the cutting data of chip breakers not included in this overview, can be found on → **Page 220–227**

Cutting data values for positive inserts

	Designation	-CF05						-SF					
		f			a _p			f			a _p		
		min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.
		mm/rev.			mm			mm/rev.			mm		
	CC.. 060200							0,02	0,035	0,05	0,1	0,4	1,5
	CC.. 060201							0,02	0,035	0,05	0,2	0,4	1,5
	CC.. 060202	0,03	0,08	0,12	0,1	0,3	1,3	0,03	0,1	0,15	0,2	0,4	1,5
	CC.. 060204	0,05	0,10	0,12	0,1	0,3	1,3	0,05	0,1	0,2	0,2	0,6	1,5
	CC.. 060208							0,05	0,125	0,2	0,2	1	1,5
	CC.. 09T300							0,02	0,035	0,05	0,2	0,75	2
	CC.. 09T301							0,02	0,035	0,05	0,2	0,75	2
	CC.. 09T302	0,03	0,08	0,12	0,1	0,3	1,3	0,05	0,075	0,1	0,2	0,75	2
	CC.. 09T304	0,05	0,10	0,22	0,2	0,4	1,3	0,05	0,12	0,2	0,2	0,75	2
	CC.. 09T308	0,06	0,13	0,25	0,2	0,4	1,3	0,05	0,125	0,25	0,4	1	2
	CC.. 09T312												
	CC.. 120402							0,05	0,075	0,1	0,2	0,8	2,5
	CC.. 120404							0,05	0,12	0,2	0,2	1	2,5
	CC.. 120408							0,08	0,15	0,25	0,4	1	2,5
	CC.. 120412							0,08	0,15	0,25	0,4	1,5	2,5
	DC.. 0702005												
	DC.. 070201												
	DC.. 0702015												
	DC.. 070202	0,03	0,08	0,12	0,1	0,3	1,3	0,03	0,1	0,15	0,1	0,4	1,5
	DC.. 070204	0,05	0,10	0,22	0,2	0,4	1,3	0,05	0,12	0,2	0,2	0,6	1,5
	DC.. 070208												
	DC.. 11T3005												
	DC.. 11T301												
	DC.. 11T3015												
	DC.. 11T302	0,03	0,08	0,12	0,1	0,3	1,3						
	DC.. 11T304	0,05	0,10	0,22	0,2	0,4	1,3	0,05	0,12	0,2	0,2	0,7	2
	DC.. 11T308	0,06	0,13	0,25	0,2	0,4	1,3	0,08	0,15	0,25	0,4	1	2
	DC.. 11T312												
	RC.. 0602M0												
	RC.. 0803M0												
	RC.. 1003M0												
	RC.. 1204M0												
	RC.. 1606M0												
	RC.. 2006M0												
	RC.. 2507M0												
	SC.. 09T304	0,05	0,10	0,22	0,2	0,4	1,3	0,05	0,12	0,2	0,2	0,7	2
	SC.. 09T308	0,06	0,13	0,25	0,2	0,4	1,3	0,08	0,15	0,25	0,4	1	2
	SC.. 120408							0,08	0,15	0,25	0,4	1	2,5
	SC.. 120412												
	TC.. 090204												
	TC.. 110202	0,03	0,08	0,12	0,1	0,3	1,3						
	TC.. 110204	0,05	0,10	0,22	0,2	0,4	1,3	0,05	0,12	0,2	0,2	0,7	2
	TC.. 110208	0,06	0,13	0,25	0,2	0,4	1,3	0,08	0,15	0,25	0,4	1	2
	TC.. 16T302												
	TC.. 16T304	0,05	0,10	0,22	0,2	0,4	1,3	0,05	0,12	0,2	0,2	0,8	2,5
	TC.. 16T308							0,08	0,15	0,25	0,4	1	2,5
	TC.. 16T312												
	TC.. 220408												
	VC.. 1103005												
	VC.. 110301												
	VC.. 1103015												
	VC.. 110302	0,03	0,06	0,12	0,1	0,3	1,3	0,02	0,08	0,15	0,1	0,4	1,5
	VC.. 110304	0,05	0,08	0,22	0,2	0,4	1,3	0,05	0,1	0,2	0,2	0,6	1,5
	VC.. 110308							0,08	0,12	0,22	0,4	1	1,5
	VC.. 160402												
	VC.. 160404	0,05	0,08	0,22	0,2	0,4	1,3	0,05	0,1	0,2	0,2	0,7	2
	VC.. 160408	0,06	0,10	0,22	0,2	0,4	1,3	0,08	0,12	0,22	0,4	1	2
	VC.. 160412												
	VC.. 220530												
	WC.. 020102							0,02	0,075	0,1	0,1	0,4	1
	WC.. 020104							0,02	0,1	0,2	0,1	0,6	1,5

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The data shows reference values. An adjustment to the actual conditions may be required.

Designation	-CF55						-SMF						-SM					
	f			a _p			f			a _p			f			a _p		
	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.
	mm/rev.			mm			mm/rev.			mm			mm/rev.			mm		
CC.. 060200																		
CC.. 060201																		
CC.. 060202													0,04	0,12	0,2	0,2	0,6	2,5
CC.. 060204	0,05	0,12	0,22	0,2	0,5	1,3	0,07	0,15	0,25	0,3	0,7	2	0,08	0,17	0,3	0,4	0,8	2,5
CC.. 060208							0,1	0,17	0,27	0,6	1	2	0,12	0,2	0,35	0,8	1	2,5
CC.. 09T300																		
CC.. 09T301																		
CC.. 09T302																		
CC.. 09T304	0,05	0,12	0,22	0,2	0,5	1,3	0,07	0,15	0,25	0,3	0,8	2,5	0,08	0,17	0,3	0,4	1	3
CC.. 09T308	0,06	0,15	0,25	0,2	0,5	1,3	0,1	0,17	0,27	0,6	1	2,5	0,12	0,2	0,35	0,8	1,2	3
CC.. 09T312													0,15	0,22	0,4	1,2	1,5	3
CC.. 120402																		
CC.. 120404	0,05	0,12	0,22	0,2	0,5	1,3	0,07	0,15	0,25	0,3	1	3	0,08	0,17	0,3	0,4	1,2	3,5
CC.. 120408							0,1	0,17	0,27	0,6	1,2	3	0,12	0,2	0,35	0,8	1,5	3,5
CC.. 120412													0,15	0,22	0,4	1,2	2	3,5
DC.. 0702005																		
DC.. 070201																		
DC.. 0702015																		
DC.. 070202	0,03	0,10	0,12	0,1	0,4	1,3							0,04	0,12	0,2	0,2	0,6	2,5
DC.. 070204	0,05	0,12	0,22	0,2	0,5	1,3	0,07	0,15	0,25	0,3	0,7	2	0,08	0,17	0,3	0,4	0,8	2,5
DC.. 070208							0,1	0,17	0,27	0,6	1	2	0,12	0,2	0,3	0,8	1	2,5
DC.. 11T3005																		
DC.. 11T301																		
DC.. 11T3015																		
DC.. 11T302																		
DC.. 11T304	0,05	0,12	0,22	0,2	0,5	1,3	0,07	0,15	0,25	0,3	0,8	2,5	0,8	0,17	0,3	0,4	1	3
DC.. 11T308	0,06	0,15	0,25	0,2	0,5	1,3	0,1	0,17	0,27	0,6	1,2	2,5	0,12	0,2	0,35	0,8	1,2	3
DC.. 11T312													0,15	0,22	0,4	1,2	1,7	3
RC.. 0602M0													0,2	0,3	0,5	0,2	0,5	1,5
RC.. 0803M0													0,2	0,3	0,6	0,2	0,6	2
RC.. 1003M0													0,25	0,4	0,7	0,2	0,7	2,5
RC.. 1204M0													0,3	0,5	0,8	0,2	0,8	3
RC.. 1606M0							0,15	0,3	0,6	0,25	2	3,5	0,4	0,6	1	0,3	1	3,5
RC.. 2006M0													0,5	0,8	1,2	0,4	1,2	4
RC.. 2507M0													0,6	0,9	1,4	0,6	2	5
SC.. 09T304	0,05	0,12	0,22	0,2	0,5	1,3	0,07	0,15	0,25	0,3	0,8	2,5	0,08	0,17	0,3	0,4	1	3
SC.. 09T308	0,06	0,15	0,25	0,2	0,5	1,3	0,1	0,17	0,27	0,6	1	2,5	0,12	0,2	0,35	0,8	1,2	3
SC.. 120408							0,1	0,17	0,27	0,6	1,2	3	0,12	0,2	0,35	0,8	1,5	3,5
SC.. 120412													0,15	0,22	0,4	1,2	2	3,5
TC.. 090204													0,08	0,12	0,2	0,4	0,8	2
TC.. 110202													0,08	0,1	0,2	0,4	0,6	3
TC.. 110204	0,05	0,12	0,22	0,2	0,5	1,3							0,12	0,2	0,35	0,8	1,2	3
TC.. 110208							0,1	0,17	0,27	0,6	1	2,5	0,12	0,2	0,35	0,8	1,2	3
TC.. 16T302																		
TC.. 16T304							0,07	0,15	0,25	0,3	1	3	0,08	0,17	0,3	0,4	1,2	3,5
TC.. 16T308	0,06	0,15	0,25	0,2	0,5	1,3	0,1	0,17	0,27	0,6	1,2	3	0,12	0,2	0,35	0,8	1,5	3,5
TC.. 16T312													0,15	0,22	0,4	1,2	1,7	3,5
TC.. 220408													0,12	0,2	0,35	0,8	2,5	6
VC.. 1103005																		
VC.. 110301																		
VC.. 1103015																		
VC.. 110302							0,05	0,1	0,18	0,2	0,5	2						
VC.. 110304	0,05	0,10	0,22	0,2	0,5	1,3	0,07	0,15	0,23	0,3	0,7	2						
VC.. 110308																		
VC.. 160402																		
VC.. 160404	0,05	0,10	0,22	0,2	0,5	1,3	0,07	0,15	0,23	0,3	0,8	2,5	0,08	0,17	0,25	0,4	1	3
VC.. 160408	0,06	0,12	0,22	0,2	0,5	1,3	0,1	0,17	0,27	0,6	1	2,5	0,12	0,2	0,3	0,8	1,2	3
VC.. 160412													0,15	0,22	0,32	1,2	1,5	3
VC.. 220530																		
WC.. 020102																		
WC.. 020104																		

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Information on the cutting data of chip breakers not included in this overview, can be found on → **Page 220–227**

Cutting data values for positive inserts

	Designation	-SMQ						-M25					
		f			a _p			f			a _p		
		min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.
		mm/rev.			mm			mm/rev.			mm		
	CC.. 060200												
	CC.. 060201												
	CC.. 060202												
	CC.. 060204							0,06	0,13	0,20	0,2	1,1	2,0
	CC.. 060208												
	CC.. 09T300												
	CC.. 09T301												
	CC.. 09T302												
	CC.. 09T304	0,10	0,25	0,4	0,4	2	4	0,06	0,14	0,22	0,2	1,2	2,2
	CC.. 09T308	0,15	0,30	0,5	0,8	2	4	0,10	0,20	0,30	0,4	1,8	3,2
	CC.. 09T312												
	CC.. 120402												
	CC.. 120404	0,10	0,25	0,4	0,4	2	4						
	CC.. 120408	0,15	0,30	0,5	0,8	2	4						
	CC.. 120412												
	DC.. 0702005												
	DC.. 070201												
	DC.. 0702015												
	DC.. 070202							0,04	0,09	0,13	0,1	0,9	1,6
	DC.. 070204	0,10	0,18	0,25	0,4	1,5	3	0,06	0,12	0,18	0,2	1,1	2,0
	DC.. 070208												
	DC.. 11T3005												
	DC.. 11T301												
	DC.. 11T3015												
	DC.. 11T302							0,04	0,10	0,16	0,1	1,1	2,0
	DC.. 11T304	0,10	0,25	0,4	0,4	2	4	0,06	0,14	0,22	0,2	1,2	2,2
	DC.. 11T308	0,15	0,30	0,5	0,8	2	4	0,10	0,20	0,30	0,4	1,8	3,2
	DC.. 11T312												
	RC.. 0602M0												
	RC.. 0803M0												
	RC.. 1003M0												
	RC.. 1204M0												
	RC.. 1606M0												
	RC.. 2006M0												
	RC.. 2507M0												
	SC.. 09T304												
	SC.. 09T308												
	SC.. 120408												
	SC.. 120412												
	TC.. 090204												
	TC.. 110202												
	TC.. 110204							0,06	0,13	0,20	0,2	1,2	2,2
	TC.. 110208												
	TC.. 16T302												
	TC.. 16T304							0,06	0,14	0,22	0,2	1,6	3,0
	TC.. 16T308							0,10	0,20	0,30	0,4	1,9	3,4
	TC.. 16T312												
	TC.. 220408												
	VC.. 1103005												
	VC.. 110301												
	VC.. 1103015												
	VC.. 110302												
	VC.. 110304												
	VC.. 110308												
	VC.. 160402												
	VC.. 160404							0,06	0,13	0,20	0,2	1,2	2,2
	VC.. 160408							0,10	0,15	0,25	0,4	1,4	3,0
	VC.. 160412												
	VC.. 220530												
	WC.. 020102												
	WC.. 020104												

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Designation	-M55						-F05					
	f			a _p			f			a _p		
	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.
	mm/rev.			mm			mm/rev.			mm		
CC.. 060200												
CC.. 060201												
CC.. 060202												
CC.. 060204	0,06	0,13	0,20	0,4	1,5	2,6						
CC.. 060208												
CC.. 09T300												
CC.. 09T301												
CC.. 09T302												
CC.. 09T304	0,08	0,16	0,24	0,4	1,7	3,0						
CC.. 09T308	0,12	0,24	0,35	0,8	2,4	4,0						
CC.. 09T312												
CC.. 120402												
CC.. 120404	0,08	0,18	0,28	0,4	2,2	4,0						
CC.. 120408	0,12	0,26	0,40	0,8	2,8	4,8						
CC.. 120412												
DC.. 0702005							0,02	0,025	0,04	0,1	1	2
DC.. 070201							0,02	0,03	0,05	0,1	1	2
DC.. 0702015							0,02	0,04	0,075	0,1	1	2
DC.. 070202							0,02	0,05	0,1	0,1	1	2
DC.. 070204	0,06	0,14	0,22	0,4	1,3	2,2						
DC.. 070208	0,08	0,16	0,24	0,8	1,6	2,4						
DC.. 11T3005							0,02	0,025	0,04	0,1	1,25	2,5
DC.. 11T301							0,02	0,03	0,05	0,1	1,25	2,5
DC.. 11T3015							0,02	0,04	0,075	0,1	1,25	2,5
DC.. 11T302							0,02	0,075	0,1	0,1	1,25	2,5
DC.. 11T304	0,08	0,16	0,24	0,4	1,7	3,0	0,02	0,1	0,25	0,1	1,25	2,5
DC.. 11T308	0,12	0,24	0,35	0,8	2,4	4,0						
DC.. 11T312												
RC.. 0602M0												
RC.. 0803M0												
RC.. 1003M0												
RC.. 1204M0												
RC.. 1606M0												
RC.. 2006M0												
RC.. 2507M0												
SC.. 09T304	0,12	0,24	0,35	0,8	2,4	4,0						
SC.. 09T308	0,12	0,26	0,40	0,8	2,8	4,8						
SC.. 120408												
SC.. 120412												
TC.. 090204	0,06	0,12	0,18	0,4	1,3	2,2						
TC.. 110202												
TC.. 110204	0,06	0,14	0,22	0,4	1,4	2,4						
TC.. 110208												
TC.. 16T302												
TC.. 16T304												
TC.. 16T308	0,12	0,24	0,35	0,8	2,6	4,4						
TC.. 16T312												
TC.. 220408												
VC.. 1103005							0,02	0,025	0,04	0,1	1,25	2,5
VC.. 110301							0,02	0,03	0,05	0,1	1,25	2,5
VC.. 1103015							0,02	0,04	0,075	0,1	1,25	2,5
VC.. 110302							0,02	0,075	0,1	0,1	1,25	2,5
VC.. 110304							0,02	0,15	0,25	0,1	1,25	2,5
VC.. 110308												
VC.. 160402												
VC.. 160404	0,08	0,14	0,20	0,4	1,7	3,0						
VC.. 160408	0,12	0,21	0,30	0,8	2,1	3,4						
VC.. 160412												
VC.. 220530												
WC.. 020102												
WC.. 020104												

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Information on the cutting data of chip breakers not included in this overview, can be found on → **Page 220–227**

Application range of CBN grades

Cutting material grade						Material suitability / ISO hardness			
	Cutting material designation	Properties		Application range	Interrupted cut	Cast iron	Sintered steels	Heat resistant	hardened
PCBN content	Main binder								
High PCBN content	CTB S05U	90 %		Chilled iron (NiHard), grey cast iron	Smooth to strongly interrupted cut	05	05		
	CTB S10C	95 %		Grey cast iron (GG252), sintered steels, super alloys	Smooth to medium interrupted cut	10	10	10	
	CTB S10U	95 %		Grey cast iron, sintered steels, super alloys		10	10	10	
	CTB S20C	90 %		Spheroidal graphite cast iron, sintered steels, super alloys		20	20	20	
Low PCBN content	CTB H15C	40 %	TiN	Tempered steels from 32 HRC	Smooth cut				15
	CTB H15U	40 %	TiN					15	
	CTB H20C	65 %	TiCN	48–62 HRC	Smooth to slightly interrupted cut				20
	CTB H21C	65 %	TiCN	52–65 HRC					20
	CTB H21U	65 %	TiCN	52–65 HRC					20
	CTB H40C	55 %	TiN	48–65 HRC	Interrupted cut				40
	CTB H40U	65 %	TiN	54–65 HRC					40
	CTB H41C	65 %	TiN	48–65 HRC	Strongly interrupted cut				40
	CTB H41U	65 %	TiN	54–65 HRC					40

CBN – The Next Generation

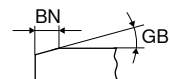
The ‚Sandwich‘ Technology

The singular system (patent), to apply CBN segments on a tungsten carbide base in a single process reduces the edge price significantly and opens up the possibility for the development of different CBN grades.

Specialized edge preparations! To achieve the highest efficiency for each application, the new CBN sandwich inserts are available with up to 8 edge preparations.

CBN Test Insert

The type CNGA test insert was specifically used, in order to identify the **quickest and most effective** type. The insert is manufactured with four edge preparations for trial. The cutting edge with highest performance gives the correct chamfer style.



Article no.	Designation	Chamfers (BN x GB)				Price / €
71 499 ...		Cutting edge 1	Cutting edge 2	Cutting edge 3	Cutting edge 4	
290	CNGA 120408XN_L2 CTBS20C	009B (0,09 mm x 10°)	011C (0,11 mm x 15°)	014D (0,14 mm x 20°)	018F (0,18 mm x 30°)	31,56
292	CNGA 120408XN_L2 CTBH20C	009D (0,09 mm x 20°)	011E (0,11 mm x 25°)	014F (0,14 mm x 30°)	018F (0,18 mm x 30°)	31,56
294	CNGA 120408XN_L2 CTBH40C	009D (0,09 mm x 20°)	011E (0,11 mm x 25°)	013E (0,13 mm x 25°)	014F (0,14 mm x 30°)	31,56

Diamond as a cutting material



Ensures

- ▲ Optimal surface quality
- ▲ burr-free workpieces
- ▲ high service lives
- ▲ lowest cutting forces
- ▲ High Process Security

Complete programme of roughing, finishing and wiper inserts for machining aluminium, non ferrous metals, plastics, ...

The cutting materials

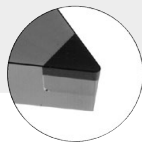
	CTD CD10 (CVD)	CTD PD20 (PKD)	CTD PU20 (PKD)	CTD PS30 (PKD)
	Fine grain Size (N10)	Fine grain grade (N20)	Coarse grain grade (N20)	Coarse grain Size (N30)
Properties	▲ perfect sharp edges ▲ no cutting pressure ▲ very close tolerances ▲ highest abrasion resistance with highest toughness ▲ very high heat conductivity	▲ high sharpness ▲ lower cutting pressure than PDC-S ▲ close tolerance ▲ lower abrasion resistance with increased toughness	▲ Very sharp cutting edge ▲ Reduced cutting pressure ▲ Tight tolerances ▲ Very high level of wear resistance and toughness	▲ high sharpness ▲ lower cutting pressure ▲ close tolerance ▲ lower abrasion resistance than with the PDC, with increased toughness
Material	suitable for superfinishing and semi-finishing of all non ferrous metals and NE-composite materials with small to high levels of abrasiveness	suitable for fine machining of all NE-materials with low abrasiveness	suitable for finishing to roughing non-ferrous metals and non-ferrous materials with highly abrasive alloying element. High chip removal on fibre-reinforced plastics such as CFRP and GFRP.	suitable for fine machining of all NE-materials and non-ferrous metals with low to very high levels of abrasiveness

9

Cutting Geometries

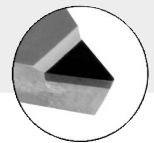
Neutral rake angle:

- ▲ higher cutting force
- ▲ higher temperature
- ▲ improved surface quality
- ▲ for stable workpieces



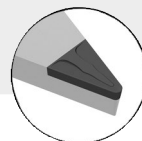
Positive rake angle:

- ▲ Lower cutting force
- ▲ Lower temperature
- ▲ reduction in surface quality
- ▲ for unstable workpieces
- ▲ improved accuracy



CB chip breaker geometries:

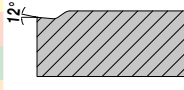
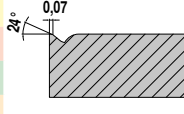
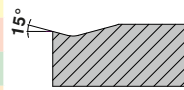
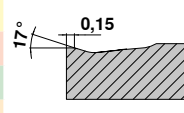
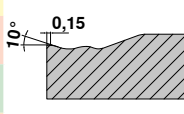
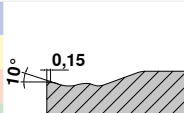
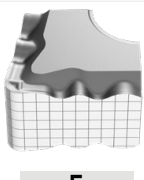
- ▲ Reliable chip control
- ▲ Ideal for low-alloy aluminium
- ▲ For F | M | R applications



Notes on diamond usage

- ▲ Coolant is not generally needed, however it facilitates chip removal
- ▲ Note the chemical reaction to carbide-forming elements (PCD)
- ▲ Note the thermal interaction and critical temperature:
PCD: 600 °C, CVD: 700 °C
Depending on the material, use cooling.

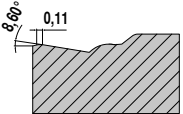
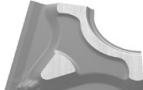
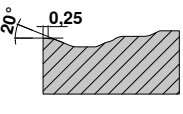
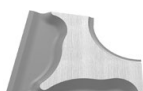
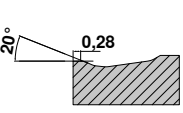
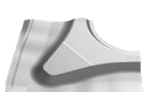
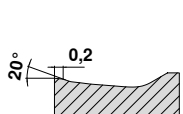
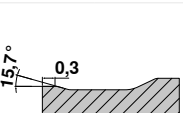
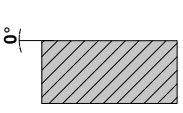
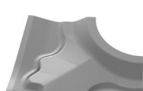
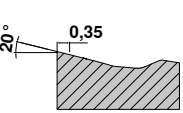
Standard chip breakers / application notes

Negative	Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration		Geometry
					a_p mm	f mm	
Main application steel and cast iron, secondary application stainless steels	-CF / -CF20					0,30-1,50	0,07-0,25
	- Fine finishing - Sharp cutting edge for low cutting forces - Good chip control even at small depths of cut 	CTEP110 / TCM10					
		CTEP110 / TCM10			CN.. DN.. TN.. WN..		
		CTEP110 / TCM10					
Main application steel and cast iron, secondary application stainless steels	-F40					0,50-2,00	0,10-0,30
	- Fine turning chip breaker for machining steels - Good chip control - Ideal for copy turning work 	CTCP125	CTCP125				
		CTCP125	CTCP125		VN..		
Main application steel and cast iron, secondary application stainless steels	-F50					0,10-2,60	0,06-0,35
	- Fine turning chip breaker for fine machining - Steel and stainless steels - Excellent chip control - High surface quality 	CTCP115 / CTCP125	CTCP115 / CTCP125 / CTCP135	CTCP135			
			CTCP135	CTCP135	CN.. DN.. SN.. TN.. VN.. WN..		
Main application steel and cast iron, secondary application stainless steels	-TFQ					0,50-5,00	0,10-0,60
	- Wiper geometry - Finishing to medium machining - Very high feedrate - High surface quality 	CTEP110 / CTCP115	CTCP115 / CTCP125				
		CTEP110			CN.. DN.. WN..		
		CTEP110 / CTCP115	CTCP115 / CTCP125				
Main application steel and cast iron, secondary application stainless steels	-XU					0,40-4,50	0,12-0,40
	- Finishing to light roughing - Universal chip breaker - Copy turning - Excellent chip formation - Low cutting forces 	CTCP115 / CTCP125	CTCP115 / CTCP125	CTCP125			
		CTCP115	CTCP115 / CTCP125		CN.. DN.. VN.. WN..		
Main application steel and cast iron, secondary application stainless steels	-FMS					0,40-3,00	0,10-0,30
	- Finishing to medium machining - very good chip control - universal chip breaker - low cutting forces 	CT-P15 / CT-P25	CT-P15 / CT-P25	CT-P25			
		CT-P15 / CT-P25	CT-P25		CN.. DN.. VN.. WN..		
		CT-P15 / CT-P25	CT-P15 / CT-P25				

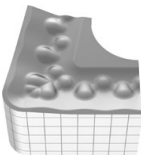
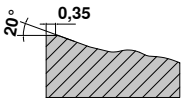
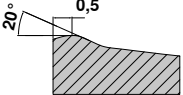
Standard chip breakers / application notes

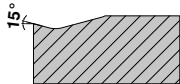
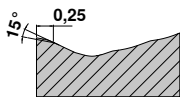
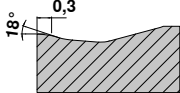
Main application steel and cast iron, secondary application stainless steels

Negative

	Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration		Geometry	
					a_p mm	f mm		
-M40 ▲ Stable geometry ▲ Medium feed rates ▲ Can be used for any application ▲ Good chip control	 M	CTCP125	CTCP125		 8,60° 0,11	0,50–3,00	0,50–3,00	VN..
		CTCP125	CTCP125					
-M50 ▲ Medium machining ▲ First choice for steel machining ▲ Universal application ▲ Wide range of applications	 M	CTCP115 / CTCP125 / CTCK110 / CTCK120	CTCP115 / CTCP125	CTCP125 / CTCP135	 20° 0,25	0,50–5,00	0,12–0,40	CN.. DN.. SN.. TN.. VN.. WN..
		CTCP115	CTCP125	CTCP135				
		CTCP115 / CTCP125 / CTCK110 / CTCK120	CTCP115 / CTCP125 / CTCK110 / CTCK120	CTCP125 / CTCK120				
-TMQ ▲ Wiper geometry ▲ Light to medium rough machining ▲ Very high feedrate ▲ High surface quality	 M	CTCP115	CTCP125		 20° 0,28	0,80–6,00	0,20–0,85	CN.. DN.. WN..
		CTCP125	CTCP125					
		CTCP125	CTCP125					
-MRS ▲ medium to rough machining ▲ well suited for components with cast crust or forged skin ▲ works well with interrupted cuts	 M R	CT-P15 / CT-P25 / CT-P35	CT-P15 / CT-P25 / CT-P35	CT-P25 / CT-P35	 20° 0,2	0,50–4,50	0,20–0,60	CN.. DN.. WN..
		CT-P15 / CT-P25	CT-P25 / CT-P35	CT-P35				
-M70 ▲ Light to medium rough machining ▲ Cast crust and forging skin ▲ Stable cutting edge ▲ Interrupted cut ▲ Raw materials and forgings	 M R	CTCK110 / CTCK120 / CTCP115	CTCP115 / CTCP125	CTCP125 / CTCP135	 15,7° 0,3	1,50–4,50	0,20–0,80	CN.. DN.. SN.. TN.. WN..
		CTCP115	CTCP125	CTCP135				
		CTCK110 / CTCK120 / CTCP115 / CTCP125	CTCK120 / CTCP125	CTCP125 / CTCK120				
.NMA ▲ Rough machining ▲ Stable cutting edge ▲ For short-chipping materials ▲ First choice for grey cast iron	 R	CTCK110	CTCK110 / CTCK120	CTCK120	 0°	1,50–4,50	0,20–0,80	CN.. DN.. SN.. TN.. WN..
-R28 ▲ Single sided roughing geometry ▲ Longitudinal, face and copy turning ▲ Varying depths of cut ▲ Steels with low tensile strength (800 N / mm²) ▲ Good chip control	 R	CTCP115 / CTCP125	CTCP115 / CTCP135 / CTCP125	CTCP135	 20° 0,35	1,00–12,00	0,25–0,80	CN.. DN.. SN..
		CTCP115 / CTCP125	CTCP125 / CTCP135	CTCP135				
		CTCP115	CTCP125	CTCP135				

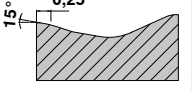
Standard chip breakers / application notes

Negative		Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration		Geometry	
						a_p mm	f mm		
Main application steel and cast iron, secondary application stainless steels	-R58	 R	CTCP115 / CTCP125	CTCP115 / CTCP135 / CTCP125	CTCP135		1,50-12,00	0,30-1,20	CN.. DN.. SN.. TN..
	▲ Single sided roughing geometry		CTCP115 / CTCP125	CTCP125 / CTCP135	CTCP135				
	▲ Longitudinal and face turning		CTCP115	CTCP115 / CTCP125	CTCP125				
	▲ Light interrupted cut								
	▲ Low cutting forces								
	▲ Unstable machines								
	-R88	 R	CTCP115 / CTCP125	CTCP115 / CTCP125 / CTCP135	CTCP135		3,50-16,00	0,50-1,50	SN..
	▲ Single sided roughing geometry		CTCP115 / CTCP125	CTCP115 / CTCP125	CTCP135				
	▲ Longitudinal and face turning		CTCP115	CTCP115 / CTCP125	CTCP125				
	▲ High feedrate								
	▲ Large depths of cut								
	▲ Heavily interrupted cut								

Main application stainless steels, secondary application steel and super alloys	Negative												
	-F30 ▲ Finishing of stainless steels ▲ Continous cut ▲ High surface quality ▲ Good swarf control			F	CTCM120 / CTPM125 CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130 CTCM120 / CTPM125 / CTCM130	CTCM130 CTCM130		15°	0,08-2,5	0,10-0,35	CN.. DN.. SN.. TN.. VN.. WN..	
	-M30 ▲ Option for stainless steel machining ▲ Good swarf control ▲ Little edg build up ▲ Low cutting forces ▲ Little built-up edge ▲ Applicable on unstable machines			F M	CTCM120 / CTPM125 CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130 CTCM120 / CTPM125 / CTCM130	CTCM130 CTCM130		15°	0,25	1,00-4,50	0,15-0,40	CN.. DN.. SN.. TN.. VN.. WN..
	-M60 ▲ Light to medium roughing ▲ Stable cutting edge ▲ Interrupted cut ▲ Forged skin and cast crust			M R	CTCM120 / CTPM125 CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130 CTCM120 / CTPM125 / CTCM130	CTCM130 CTCM130		18°	0,3	1,50-6,00	0,25-0,50	CN.. DN.. SN.. TN.. WN..

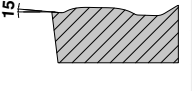
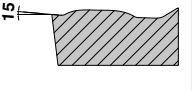
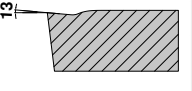
Standard chip breakers / application notes

Negative

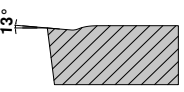
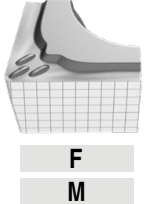
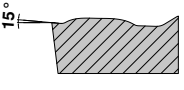
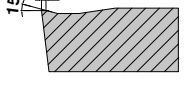
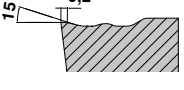
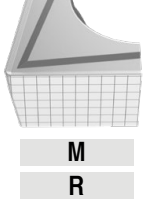
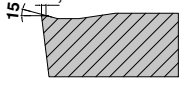
Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration		Geometry
				a_p mm	f mm	
						CN.. DN.. SN.. VN.. WN..
-M34		CTPX710	CTPX710			
▲ First choice for superalloys		CTPX710	CTPX710			
▲ Light cutting geometry		CTPX710	CTPX710			
▲ Little built-up edge		CTPX710	CTPX710			
▲ Low cutting forces		CTPX710	CTPX710			
M				0,80-3,0	0,10-0,30	

Main application super alloys,
secondary application stainless steels

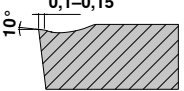
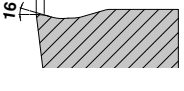
Positive

Main application steel and cast iron, secondary application stainless steels and super alloys	-CF05		CTEP110 / TCM407	TCM10 / TCM407			CC.. DC.. SC.. TC.. VC..
	▲ Fine finishing		CTEP110				
	▲ For all common steel materials, stainless steels and GGG		CTEP110	TCM10 / TCM407			
	▲ Good swarf control						
	▲ High surface quality						
	F					0,20-1,30 0,06-0,25	
	-SF		CTCP115	CTCP125	CTCP125 / CTCP135		CC.. DC.. SC.. TC.. VC.. WC..
	▲ Finishing / contour turning						
	▲ Good swarf control			CTCP125	CTCP125		
	▲ High surface quality						
	▲ Low cutting forces						
	F					0,05-2,50 0,05-0,25	
	-CF55		CTEP110	TCM10 / CTEP110			CC.. DC.. SC.. TC.. VC..
	▲ Finishing to medium machining		CTEP110	CTEP110			
	▲ Suitable for general and stainless steels		CTEP110	CTEP110			
	▲ Low cutting forces						
	▲ Good swarf control						
	▲ High surface quality						
	F					0,20-1,30 0,06-0,25	
	M						

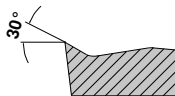
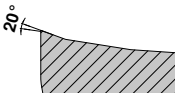
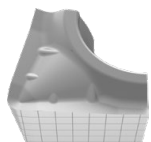
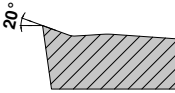
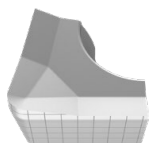
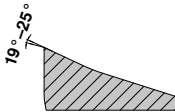
Standard chip breakers / application notes

	Positive	Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration		Geometry
						a_p mm	f mm	
Main application steel and cast iron, secondary application stainless steels and super alloys	-SMF		CTEP110 / CTCP115 CTEP110 CTEP110	TCM10 / CTCP125 / CTCP115 CTCP135	CTCP135 CTCP135		0,20-1,30 0,06-0,25	CC.. DC.. SC.. TC.. VC..
	-FMS		CT-P15 / CT-P25 CT-P15 / CT-P25	CT-P15 / CT-P25 CT-P15 / CT-P25	CT-P25		0,10-2,00 0,05-0,20	CC.. DC.. VC..
	-SM		CTCP115 / CTCP125 CTCP115 / CTCK110 / CTCK120	CTCP125 / CTCP135 / CTCP115 CTCP135 CTCP125 / CTCK110 / CTCK120	CTCP125 / CTCP135 CTCP135 CTCK120		0,05-5,00 0,15-0,45	CC.. DC.. SC.. TC.. VC..
	-SMQ		CTCP115 CTCP125 / CTCP115	CTCP125 CTCP125	CTCP125 CTCP125		1,00-4,00 0,15-0,45	CC.. DC..
	-MRS		CT-P15 / CT-P25 CT-P15 / CT-P25	CT-P15 / CT-P25 CT-P15 / CT-P25	CT-P25		0,15-3,50 0,15-0,35	CC.. DC.. VC..
		M R						

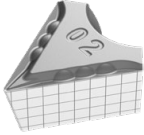
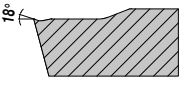
Positive

-M25		CTCM120 / CTPM125 CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130 CTCM120 / CTPM125 / CTCM130	CTCM130 CTCM130		0,40-3,20 0,10-0,30	CC.. DC.. TC.. VC..
-M55		CTCM120 / CTPM125 CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130 CTCM120 / CTPM125 / CTCM130	CTCM130 CTCM130		0,40-4,80 0,06-0,35	CC.. DC.. SC.. TC.. VC..
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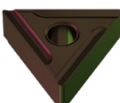
Standard chip breakers / application notes

Positive		Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration		Geometry	
						a_p mm	f mm		
Main application non-ferrous metals, secondary application stainless steels, steels, super alloys, cast iron	-23P	 F					0,2-4,0	0,05-0,3	CC.. DC..
	▲ Low adhesion		H216T	H216T	H216T				
	▲ Good chip control with soft aluminium alloys		H216T	H216T	H216T				
	-25P	 F M	CTPX710	CTPX710			0,50-4,50	0,05-0,60	CC.. DC.. SC.. VC..
	▲ Sharp cutting edge		CTPX710	CTPX710					
	▲ Good swarf control on soft aluminium alloys		CTPX710 / H216T	CTPX710 / H216T	CTPX710 / H216T				
	▲ Low adhesion		CTPX710	CTPX710					
	-25Q	 M	CTPX710	CTPX710			0,05-6,50	0,05-0,60	CC.. DC.. VC..
	▲ Wiper geometry		CTPX710	CTPX710					
	▲ High feed rates		H210T	H210T					
	▲ High surface quality		H210T / CTPX710	H210T / CTPX710	H210T / CTPX710				
	▲ Good swarf control on soft aluminium alloys		H210T / CTPX710	H210T / CTPX710					
	▲ Low adhesion								
	-27	 M R	CTPX715	CTPX715			1,00-10,00	0,10-0,75	CC.. DC.. RC.. SC.. TC.. VC..
	▲ The universal Alu geometry		CTPX715	CTPX715					
	▲ Sharp cutting edge		CTPX715 / H216T	CTPX715 / H216T					
	▲ Extremely positive rake angle		CTPX715 / H216T	CTPX715 / H216T	CTPX715 / H216T				
▲ Low adhesion	CTPX715		CTPX715						
▲ High feed rates									
		CTPX715 / H216T	CTPX715 / H216T	CTPX715 / H216T					

Standard chip breakers / application notes

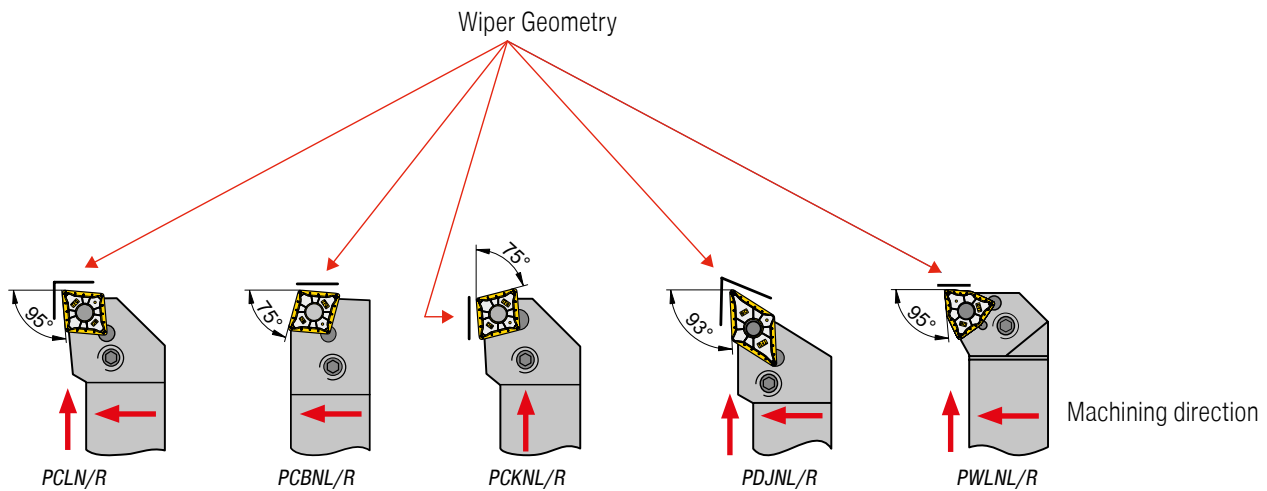
Positive	Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration		Geometry
					a_p mm	f mm	
Main application super alloys and stainless steels, secondary application steels and non-ferrous metals	-F05 ▲ Maximum tolerance class ▲ Outstanding chip control, even with the smallest cutting depths ▲ Very low cutting forces  F	CTPX710	CTPX710				DC.. VC..
		CTPX710	CTPX710				
		CTPX710	CTPX710				
		CTPX710	CTPX710				
		CTPX710	CTPX710				
		CTPX710	CTPX710		0,10-2,50	0,02-0,25	

Supplementary chip breakers / application notes

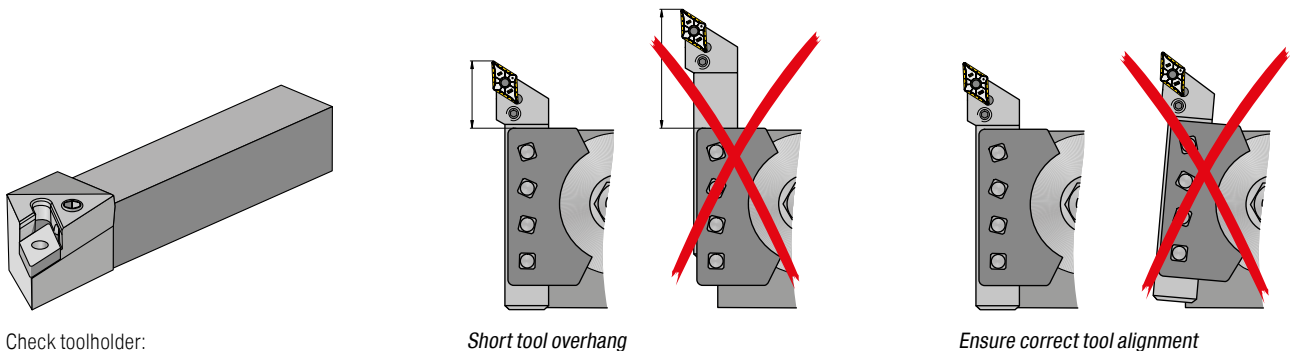
	Model	Smooth cut 	Irregular cutting depth 	Interrupted cut 
-EN ▲ Universal chip breaker for general steels	 M	CTCP115	CTCP125	CTCP135
		CTCP125	CTCP135	CTCP135
		CTCK110	CTCK120	CTCP125
-ER EL ▲ A problem solver for unstable conditions ▲ Can be used on less powerful machines ▲ Can be used for general steels and on stainless materials as a secondary application	 M		CTCP125	CTCP135

Masterfinish – wiper geometry – notes

Through the use of indexable inserts with wiper edge (-TFQ; -TMQ; -SMQ; -25Q) high quality surfaces can be produced economically.



All turning inserts with wiper cutting edge are clamped in standard ISO tool holders.



Feed rate guide values for surface finish quality

Roughness range R_z in μm	$R_{t\text{max}}$	Corresponds to R_a	Roughness index	ISO 1302	Corner radius r_e in mm and feed rate f in mm/rev.			
					$r_e = 0,4$	$r_e = 0,8$	$r_e = 1,2$	$r_e = 1,6$
63-100	$\sqrt{R_{t100}}$	12,5-25	N11	$\frac{25}{\nabla}$		0,51	0,69	0,88
40-63	$\sqrt{R_{t63}}$	6,3-25	N10	$\frac{12,5}{\nabla}$	0,27	0,43	0,56	0,68
31,5-40	$\sqrt{R_{t40}}$	4,9-6,3	N9	$\frac{6,3}{\nabla}$	0,25	0,37	0,49	0,57
25-31,5	$\sqrt{R_{t31,5}}$	4,0-4,9			0,22	0,32	0,41	0,47
16-25	$\sqrt{R_{t25}}$	2,5-4,0	N8	$\frac{3,2}{\nabla}$	0,20	0,28	0,36	0,39
10-16	$\sqrt{R_{t16}}$	1,6-2,5			0,15	0,22	0,29	0,31
6,3-10	$\sqrt{R_{t10}}$	1,0-1,6	N7	$\frac{1,6}{\nabla}$	0,10	0,13	0,18	0,20

Masterfinish – wiper geometry – functional principle

Relationship of feed rate to surface roughness

Improved Surface Quality

With the same feed rate an insert with wiper cutting edge reaches a roughness value R_t which is many times better than a conventional insert.



Shorter machining time

To achieve the same R_t -value as with a standard insert, double the feed rate can be applied for the insert with wiper cutting edge (**= shorter production time per component!**)



9

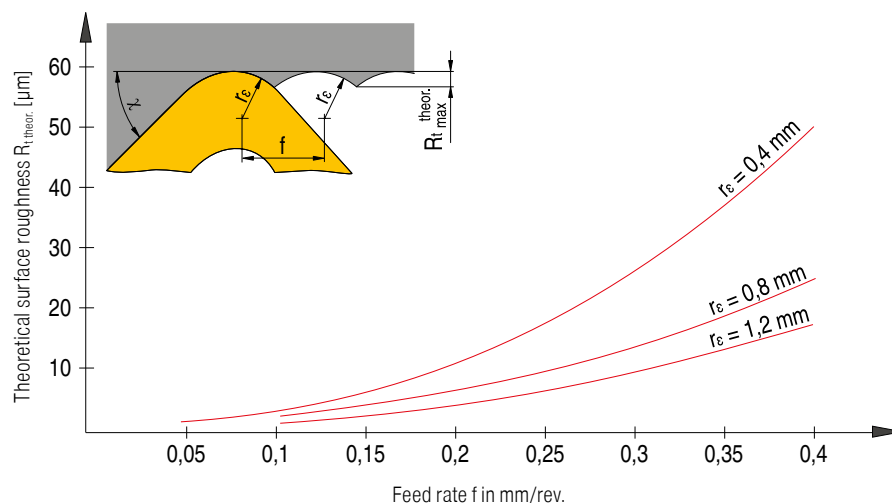
Theoretical Surface Quality

The maximum theoretical surface roughness with turning $R_{t_{theor.}}$ is the combination of feed rate and corner radius:

or approximately:

$$R_{t_{theor.}} = \left(r_\epsilon - \sqrt{r_\epsilon^2 - \frac{f^2}{4}} \right) \cdot 1000$$

$$R_{t_{theor.}} = \frac{125 \cdot f^2}{r_\epsilon} \quad [\mu\text{m}]$$



ISO designation system for inserts

Indexable inserts – metric

C N M G 12 04 08 E N - M50

1 2 3 4 5 6 7 8 9 13

Indexable inserts – inch

C N M G 4 3 2 E N - M50

1 2 3 4 5 6 7 8 9 13

Indexable inserts, CBN,
ceramic – metric

C N G A 12 04 08 S N - 020D - B 3 - Q

1 2 3 4 5 6 7 8 9 10 11 12 13

Indexable inserts, CBN,
ceramic – inch

C N G A 4 3 2 S N - 020D - B 3 - Q

1 2 3 4 5 6 7 8 9 10 11 12 13

1			
Insert shape			
V	35°	Included angle	
D	55°		
E	75°		
C	80°		
M	86°	Included angle	
K	55°		
B	82°		
A	85°		
L	90°	Other shapes	
P	108°		
H	120°		
O	135°		
R	-		
S	90°		
T	60°		
W	80°		

2			
Clearance angle			
		α	
A	3°	F	25°
B	5°	G	30°
C	7°	N	0°
D	15°	P	11°
E	20°		
O Clearance angles not included within the standard for which particular information is necessary.			

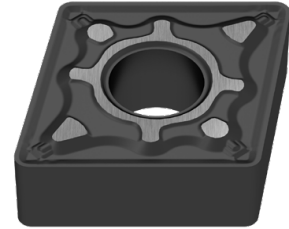
3						
Tolerances						
	IC±		BS		S	
	mm	inch	mm	inch	mm	inch
A	0,025	.0010	0,005	.0002	0,025	.001
F	0,013	.0005	0,005	.0002	0,025	.001
C	0,025	.0010	0,013	.0005	0,025	.001
H	0,013	.0005	0,013	.0005	0,025	.001
E	0,025	.0010	0,025	.0010	0,025	.001
G	0,025	.0010	0,025	.0010	0,13	.005
J	0,05-0,15*	.002-.006*	0,005	.0002	0,025	.001
K	0,05-0,15*	.002-.006*	0,013	.0005	0,025	.001
L	0,05-0,15*	.002-.006*	0,025	.0010	0,025	.001
M	0,05-0,15*	.002-.006*	0,05-0,20*	.003-.008*	0,13	.005
N	0,05-0,15*	.002-.006*	0,05-0,20*	.003-.008*	0,025	.001
U	0,08-0,25*	.003-.010*	0,13-0,38*	.005-.015*	0,13	.005
* Depends on insert size						

6				
Insert thickness				
		Code		
mm	inch	mm	inch	
1,59	1/16	01	1	
2,38	3/32	02		
3,18	1/8	03	2	
3,97	5/32	T3		
4,76	3/16	04	3	
5,56	7/32	05		
6,35	1/4	06	4	
7,94	5/16	07	5	
9,52	3/8	09	6	

7				
Corner radius				
		Code		
mm	inch	mm	inch	
≤ 0,05	.0015	00	X0	
0,1	.004	01	0	
0,2	.008	02	.5	
0,4	1/64	04	1	
0,8	1/32	08	2	
1,2	3/64	12	3	
1,6	1/16	16	4	
2,0	5/64	20	5	
2,4	3/32	24	6	
2,8	7/64	28	7	
3,2	1/8	32	8	

8	
Cutting edge	
F	Sharp
E	rounded
T	chamfered
S	Chamfered and honed
K	Double-chamfered
P	Double-chamfered and honed
R	Round chamfer

9	
Direction of cut	
R	
L	
N	
CBN and PCD segment orientation	



4

Characteristics

N	
R	
F	
A	
M, P	
G, P	
W	
T	
Q	
U	
B	
H	
C	
J	
X	Special version

inch

Change at inscribed circle
IK < 1/4"

IK > 1/4"	IK < 1/4"
N / R / F	E
A / M / G	D
X	X

5

Cutting length

Type	ISO	ANSI	L		d	
			mm	inch	mm	inch
	06	2	6,4	.250	6,35	.250
	09	3	9,7	.382	9,525	.375
	12	4	12,9	.508	12,70	.500
	16	5	16,1	.634	15,875	.625
	19	6	19,3	.760	19,05	.750
	25	8	25,8	1.016	25,4	1.000
	32	12	35,24	1.269	31,75	1.250
	06	2	6,35	.250	6,35	.250
	09	3	9,525	.375	9,525	.375
	12	4	12,7	.500	12,7	.500
	15	5	15,875	.625	15,875	.625
	19	6	19,05	.750	19,05	.750
	25	8	25,4	1.000	25,4	1.000
	31	10	31,75	1.250	31,75	1.250
	07	2	7,7	.303	6,35	.250
	11	3	11,6	.457	9,525	.375
	15	4	15,5	.610	12,70	.500
	11	2	11,1	.437	6,35	.250
	16	3	16,6	.653	9,525	.375
	22	4	22,10	.870	12,70	.500

* inch version

Type	ISO	ANSI	L		d	
			mm	inch	mm	inch
	06	1.2	6,9	.272	3,97	.156
	09	1.8	9,6	.378	5,56	.219
	11	2	11,0	.433	6,35	.250
	16	3	16,5	.650	9,525	.375
	22	4	22,	.079	12,70	.039
	27	5	27,5	1.083	15,875	.625
	33	6	33,0	1.299	19,05	.750
	06	3	6,5	.256	9,525	.375
	08	4	8,7	.331	12,70	.039
	10	5	10,9	.429	15,875	.625
	06	2	6,35	.250	6,35	.250
	08	-	8,0	.315	8,0	.315
	09	3	9,52	.375	9,52	.375
	10	-	10,0	.394	10,0	.394
	12*	-	12,0	.472	12,0	.472
	12	4	12,7	.488	12,70	.488
	15	5	15,875	.625	15,875	.625
	16	-	16,0	.630	16,0	.630
	19	6	19,05	.750	19,05	.750
	25	8	25,0	.984	25,0	.984
	25*	-	25,4	1.000	25,4	1.000
	31	10	31,75	1.250	31,75	1.250
	32	-	32,0	1.260	32,0	1.260

9

10

Chamfer type



	mm	inch		
015	0,15	.006	A	05°
020	0,20	.008	B	10°
025	0,25	.010	C	15°
050	0,50	.020	D	20°
075	0,75	.030	E	25°
100	1,00	.040	F	30°
			G	35°

1) Two letters are assigned for double-chamfered cutting edges
e.g. BE =
chamfer angle 1 (y_1) = 10°
chamfer angle 2 (y_2) = 25°

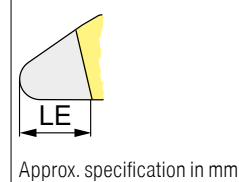
11

Number of cutting edges

Single sided		Complete insert thickness	
A		T	
B		U	
C		V	
D		W	
G		X	
H		Y	
Double sided		Entire clamping flat	
K		S	
L		F	
M		E	
N			
P			
Q			

12

Segment length



13

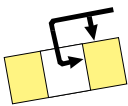
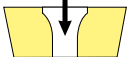
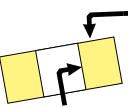
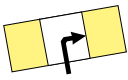
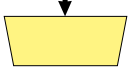
Chip breaker
designations

You can find a comprehensive chip
breaker overview on
→ page 220-227

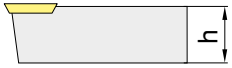
ISO designation system for tool holders

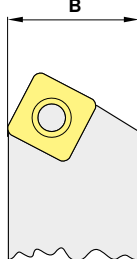
P	C	L	N	R	20	20	K	12	-	T
1	2	3	4	5	6	7	8	9	10	
UT50	-	P	C	L	N	R			-12	
0	1	2	3	4	5	6	7	8	9	10
HSK-T63	-	D	C	L	N	R			-12	
0	1	2	3	4	5	6	7	8	9	10

0
System/size
UT = UTS according to ISO 26622 UT40 = UTS 40 mm UT50 = UTS 50 mm UT63 = UTS 63 mm
HSK-T according to ISO 12164 HSK-T63 = 63 mm HSK-T100 = 100 mm

1
Tool holder
D  Retained from above and via bore S  Retained via centre screw
M  Retained from above and via bore P  Retained via the bore
C  Retained from above X Special version

2	
Insert shape	
V 35°	Included angle
D 55°	
E 75°	
C 80°	
M 86°	
K 55°	Included angle
B 82°	
A 85°	
L 90°	
P 108°	
H 120°	
O 135°	
R -	
S 90°	
T 60°	
W 80°	
Other shapes	

6
Shank height


7
Shank width


8

Tool length

OAL			OAL		
mm	inch		mm	inch	
32	4.000	A	160	4.500	N
40	4.500	B	170	5.500	P
50	5.000	C	180	-	Q
60	6.000	D	200	6.000	R
70	7.000	E	250	7.000	S
80	8.000	F	300	8.000	T
90	5.500	G	350	5.500	U
100	5.625	H	400	3.500	V
110	5.300	J	450	3.500	W
125	14.000	K	500	3.750	Y
140	6.800	L	Special version		X
150	4.400	M			



3

Style

90°

A

75°

B

90°

C

45°

D

60°

E

90°

F

90°

G

107,5°

H

93°

J

75°

K

95°

L

50°

M

63°

N

117,5°

P

75°

R

45°

S

60°

T

93°

U

72,5°

V

60°

W

85°

Y

4

Clearance angle

α	α
A 3°	F 25°
B 5°	G 30°
C 7°	N 0°
D 15°	P 11°
E 20°	

O Clearance angles not included within the standard for which particular information is necessary.

5

Direction of cut

R

L

N

9

Cutting length

R

H

L

O

S

T

P

VDECM

W

ABK

10

Manufacturer specification

T = Toggle
Special length (mm)
Insert thickness (deviating from standard)
Special version (X...)
Machine manufacturer (specific)

ISO designation system for boring bars

A 25 R			P C L N R					12		
1	2	3	4	5	6	7	8	9	10	
UT40 -			25 G -			P C L N R -			12	
0	1	2	3	4	5	6	7	8	9	10
HSK-T63 -			50 Q -			D C L N R -			12	
0	1	2	3	4	5	6	7	8	9	10

0

System/size

UT = UTS

according to ISO 26622

UT40 = UTS 40 mm

UT50 = UTS 50 mm

UT63 = UTS 63 mm

HSK-T

according to ISO 12164

HSK-T63 = 63 mm

HSK-T100 = 100 mm

1

Shank type

S Steel shank	E As C with coolant hole
A Steel shank with coolant hole	F As C with antivibration system
B Steel shank with antivibration system	G As C with coolant hole and antivibration system
D Steel shank with coolant hole and antivibration system	H Heavy metal
C Carbide shank with steel head	J Heavy metal with coolant hole

5

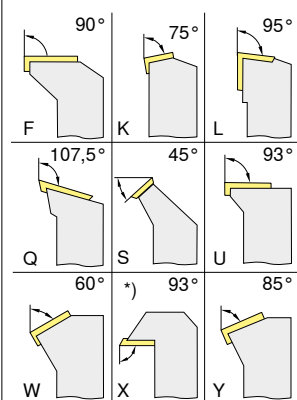
Insert shape

V 35°	Included angle
D 55°	
E 75°	
C 80°	
M 86°	
K 55°	Included angle
B 82°	
A 85°	
L 90°	
P 108°	
H 120°	
O 135°	
R -	
S 90°	
T 60°	
W 80°	

Other shapes

6

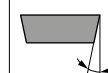
Style



*) CERATIZIT factory standard

7

Clearance angle



A 3°	F 25°
B 5°	G 30°
C 7°	N 0°
D 15°	P 11°
E 20°	

O Clearance angles not included within the standard for which particular information is necessary.



2

Shank type & size

DCONMS mm	DCONMS inch
08	
10	
12	
16	
20	
25	
32	
40	
50	
60	

A two-digit figure indicating the boring bar diameter in 1/16 of an inch.

3

Tool length

OAL		
mm	inch	
80	3	F
100	3,5	H
110	4	J
125	4,5	K
140	5	L
150	5,5	M
160	6	N
170	6,5	P
180	6,75	Q
200	7	R
250	8	S
300	10	T
350	12	U
400	14	V
450	16	W
500	18	Y
	20	
Special version		X

4

Clamping method

D Retained from above and via bore	S Retained via centre screw
M Retained from above and via bore	P Retained via the bore
C Retained from above	X Special version

8

Direction of cut

R

L

9

Cutting length

10

Manufacturer specification

T = Toggle
Special length (mm)
Insert thickness (deviating from standard)
Special version (X..)
Machine manufacturer (specific)

Types of wear

Wear on clearance face



Abrasion on flank: normal wear after a certain machining time

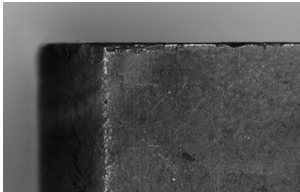
Cause

- ▲ Too high cutting speed
- ▲ Carbide grade with too low wear resistance
- ▲ Feed rate not adapted

Remedy

- ▲ Reduce cutting speed
- ▲ Use grade with higher wear resistance
- ▲ Adapt feed rate to cutting speed and cutting depth

Edge chipping



Through excessive mechanical stress at the cutting edge fracture and chipping can occur.

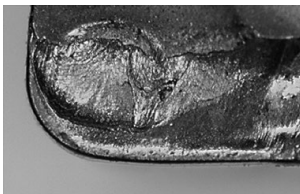
Cause

- ▲ Grade with too high wear resistance
- ▲ Vibration
- ▲ Too high cutting speed and / or feed rate
- ▲ Interrupted cut
- ▲ Swarf damage

Remedy

- ▲ Use tougher grade
- ▲ Use negative cutting edge geometry with chip groove
- ▲ Improve stability (tool, work piece)

Cratering



The hot chip which is being evacuated causes cratering at the rake face of the cutting edge.

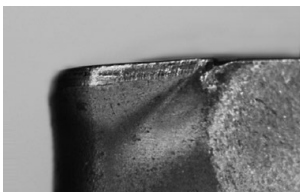
Cause

- ▲ Too high cutting speed and / or feed rate
- ▲ Rake angle too shallow
- ▲ Grade with insufficient wear resistance
- ▲ Insufficient coolant supply

Remedy

- ▲ Reduce cutting speed and / or feed rate
- ▲ Use grade with higher wear resistance
- ▲ Increase coolant quantity and / or pressure, optimise coolant supply
- ▲ Use grade which is more resistant to cratering

Plastic deformation



High machining temperature and simultaneous mechanical stress can lead to plastic deformation.

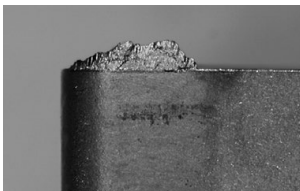
Cause

- ▲ Too high machining temperature resulting in softening of substrate
- ▲ Damage of coating
- ▲ Grade with insufficient wear resistance
- ▲ Insufficient coolant supply

Remedy

- ▲ Reduce cutting speed
- ▲ Use grade with higher wear resistance
- ▲ Provide cooling

Built-up edge



Built-up material / edges occur when the chip is not evacuated properly due to insufficient cutting temperature.

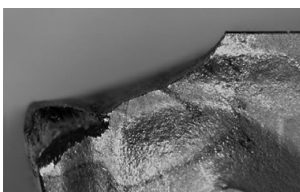
Cause

- ▲ Insufficient cutting speed
- ▲ Rake angle too shallow
- ▲ Wrong cutting material
- ▲ Lack of cooling / lubrication

Remedy

- ▲ Increase cutting speed
- ▲ Increase rake angle
- ▲ Apply TiN coating
- ▲ Use emulsion with higher concentration

Insert breakage



Excessive stress of the insert causes breakage.

Cause

- ▲ Excessive stress of cutting material
- ▲ Lack of stability
- ▲ Clearance angle too small

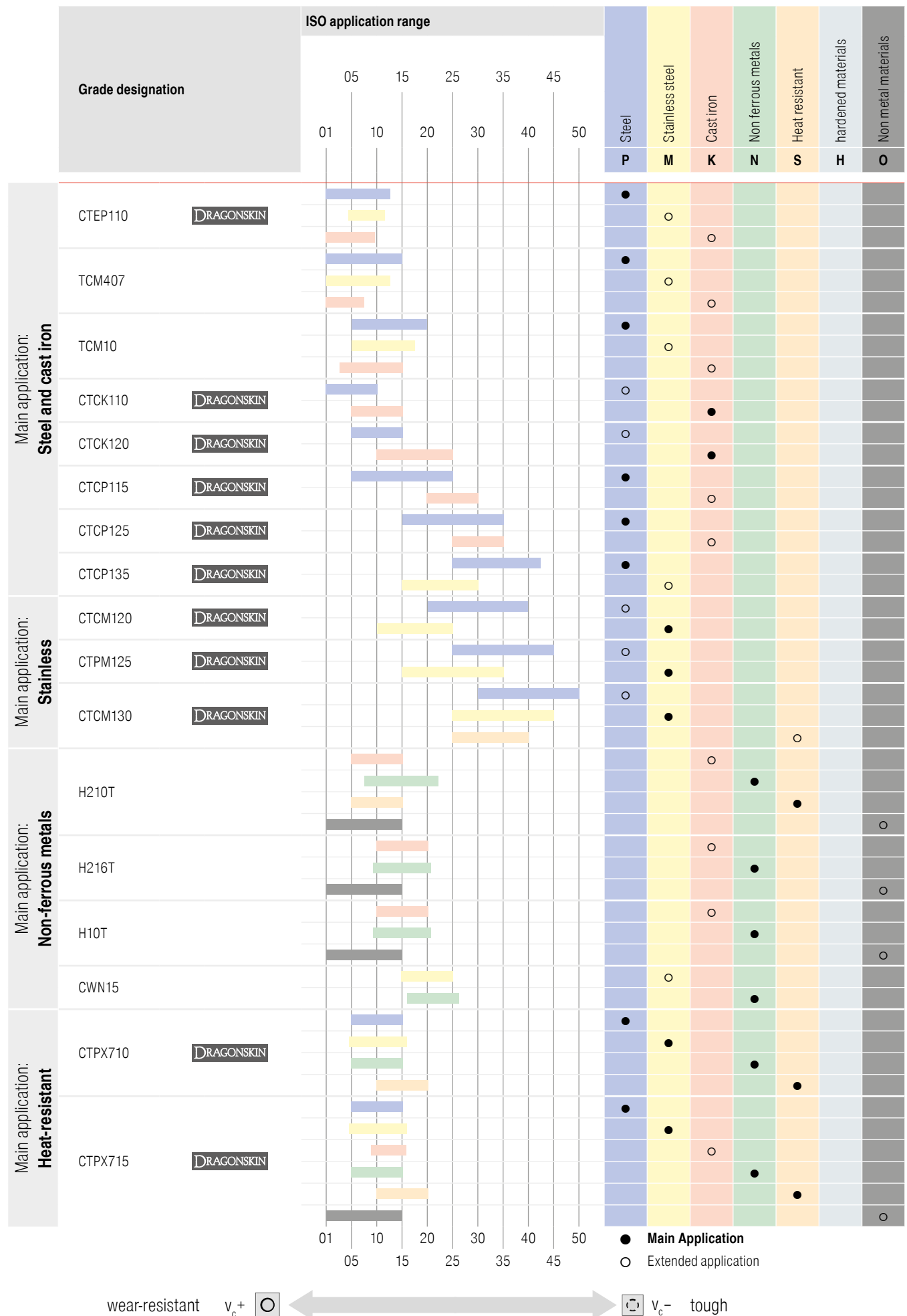
Remedy

- ▲ Use tougher grade
- ▲ Use protective edge chamfer
- ▲ Increase edge hone
- ▲ Use geometry with higher stability

Recommendation for Optimum Results

Type of problem																
Type of wear						Work piece problems				Swarf control						
Wear on clearance face	Cratering	Edge chipping	Plastic deformation	Insert breakage	Built-up edge	Vibration	Formation of pips and burrs	Chattered surface	Surface quality	Chip too long (snarl chip)	Chip too short (fragmented chip)					
⬇	⬇		⬇		⬇	⬇			⬆	⬇		Cutting speed	Cutting data	Remedy measures		
⌚		⬇	⬇	⬇		⬆		⬇	⬇	⬆	⬇				Feed rate	
⬇	⬇	⬇	⬇				⬇	⬇	⬇							Feed rate at centre
		⬆	⌚		⬇	⌚	⬇	⬇	⬇	⬇	⬆	Chip groove	Insert selection			
⬆		⬆	⬆	⬆		⬇	⬇	⬇	⬆						Corner radius	
⬆	⬆	⬇	⬆	⬇												Tool Material
		⌚		⌚		⌚		⌚	⌚			Tool clamping	General criteria			
		⌚		⌚		⌚		⌚	⌚						Work piece clamping	
		⌚		⌚		⌚			⬇							Overhang
⌚		⌚				⌚	⌚		⌚			Tip height				
●	⌚		●		●		●		●	●			Cooling lubricant			
⬆	⬆		⬆		⬆	⬆			⬆	⬆						
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Grades Overview



Grade description

TCM407	▲ Cermet, uncoated ▲ ISO P10 M05 K05 ▲ The uncoated cermet grade for super-fine finishing steel materials	CTCM130	▲ Carbide, TiCN-Al₂O₃-coated ▲ ISO P25 M30 ▲ Robust turning grade for austenitic stainless steel with interrupted cuts
CTEP110	▲ Cermet, TiCN-Al₂O₃-coated ▲ ISO P10 M10 K05 ▲ The cermet grade with reserves of toughness for finish machining at high cutting speeds	CTPM125	▲ ISO P35 M25 ▲ The universal carbide grade with maximum toughness, without affecting the necessary hot hardness and wear resistance for stainless machining
TCM10	▲ Cermet, uncoated ▲ ISO P15 M10 K10 ▲ The uncoated cermet grade for finish machining stainless and hardened steel ▲ Particularly wear resistant thanks to high heat resistance	CTCK110	▲ Carbide, TiCN-Al₂O₃-coated ▲ ISO P05 K10 ▲ The wear-resistant grade for machining cast iron materials at high cutting speeds in a continuous cut
CTCP115	▲ Carbide, TiCN-Al₂O₃-coated ▲ ISO P15 K25 ▲ The wear-resistant high-performance grade for stable conditions and a continuous cut	CTCK120	▲ Carbide, TiCN-Al₂O₃-coated ▲ ISO P10 K20 ▲ The grade for cast iron machining, with high toughness reserves for difficult conditions and interrupted cuts
CTCP125	▲ Carbide, TiCN-Al₂O₃-coated ▲ ISO P25 K30 ▲ The first choice for universal machining of steels	H10T	▲ Carbide, uncoated ▲ ISO K15 N15 O10 ▲ The uncoated carbide grade for machining aluminium and other non-ferrous metals
CTCP135	▲ Carbide, TiCN-Al₂O₃-coated ▲ ISO P35 M25 ▲ The tough alternative for heavily interrupted cut and unstable conditions	H210T	▲ Carbide, uncoated ▲ ISO N10 S10 K10 O10 ▲ The wear-resistant carbide grade for machining aluminium and other non-ferrous metals
CT-P15	▲ Carbide, coated ▲ ISO P15 M10 ▲ Wear-resistant standard steel grade for smooth cut	H216T	▲ Carbide, uncoated ▲ ISO K15 N15 O10 ▲ The uncoated carbide grade for machining aluminium and other non-ferrous metals ▲ Also highly suitable for HSC machining
CT-P25	▲ Carbide, coated ▲ ISO P25 M20 ▲ Standard steel grade for universal steel machining	CWN15	▲ Carbide, TiN-coated ▲ ISO M15 K15 ▲ Special carbide grade for abrasive aluminium alloys
CT-P35	▲ Carbide, coated ▲ ISO P35 M25 ▲ Tough standard steel grade for interrupted cutting	CTPX710	▲ Carbide, AlTiN-coated ▲ ISO P10 M10 K10 N10 S15 ▲ Universal multi-material grade from the X7 line for highest machining requirements
CTCM120	▲ Carbide, TiCN-Al₂O₃-coated ▲ ISO P15 M20 ▲ Wear-resistant turning grade for austenitic stainless steel; top performance for smooth cuts	CTPX715	▲ Carbide, AlTiN-coated ▲ ISO P10 M10 K10 N10 S15 O10 ▲ Universal multi-material grade from the X7 line for highest machining requirements

Grade description

C T C **P** **1** **2** **5** (Example)

Main application – material

- | | |
|-----|------------------------------|
| 1 P | Steel |
| 2 M | Stainless steel |
| 3 K | Cast iron |
| 4 N | Light and non ferrous metals |
| 5 S | Super alloys, titanium |
| 6 H | Hard materials |
| 7 X | Universal application |

Application

- | | |
|---|-------------------|
| 1 | Turning |
| 2 | Milling |
| 3 | Grooving |
| 4 | Drilling |
| 5 | Thread turning |
| 6 | Others |
| 7 | Several processes |

Degree of hardness

- | | |
|-----|--------|
| 05 | ISO 05 |
| 10 | ISO 10 |
| 15 | ISO 15 |
| ... | |