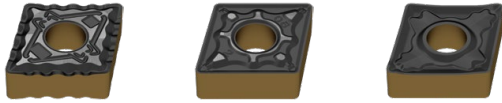


New products for machining technicians

NEW

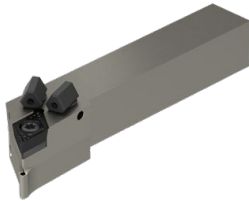
Steel machining with the new ISO-P grades



Thanks to a CVD multilayer coating with the latest Dragonskin coating technology, the indexable inserts are ideally suited to versatile steel machining. In combination with a balanced carbide base substrate, the new grades in the ISO-P category boast a wide application area with improved wear resistance. Depending on the cutting conditions, the perfect cutting material can be selected from three grades.

NEW

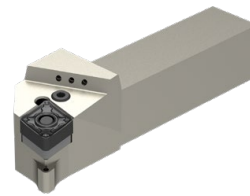
Tool holder with square shank – MaxiLock-S DC for positive indexable inserts



The new MaxiLock-S DC tool holders improve both your process security and the service life of the tool cutting edges with targeted cooling. Suitable for a wide range of positive indexable inserts.

NEW

Tool holder with square shank – MaxiLock-N DC for negative indexable inserts



Improve your machining process with precision cooling on the tool cutting edge. The cooling has a particularly efficient effect on the flank of the tool. Suitable for a wide range of negative indexable inserts using toggle clamps.



Suitable adapters for our square rotating- and grooving holders can be found in **Chapter 16 Adapters and accessories**. Available for machine interfaces VDI and BMT.

New: Adapters with HSK-T machine interface → **Chapter 16, pages 194+195**

NEW

-M23 chip breaker

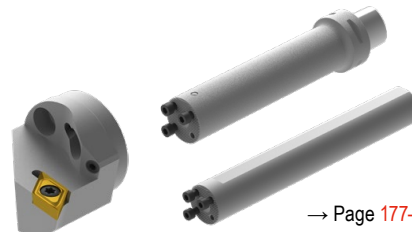


→ Page 125

Soft cutting geometry with excellent Chip breaking behavior at low cutting depths for steel machining. Available for positive round inserts in the ISO-P carbide grades.

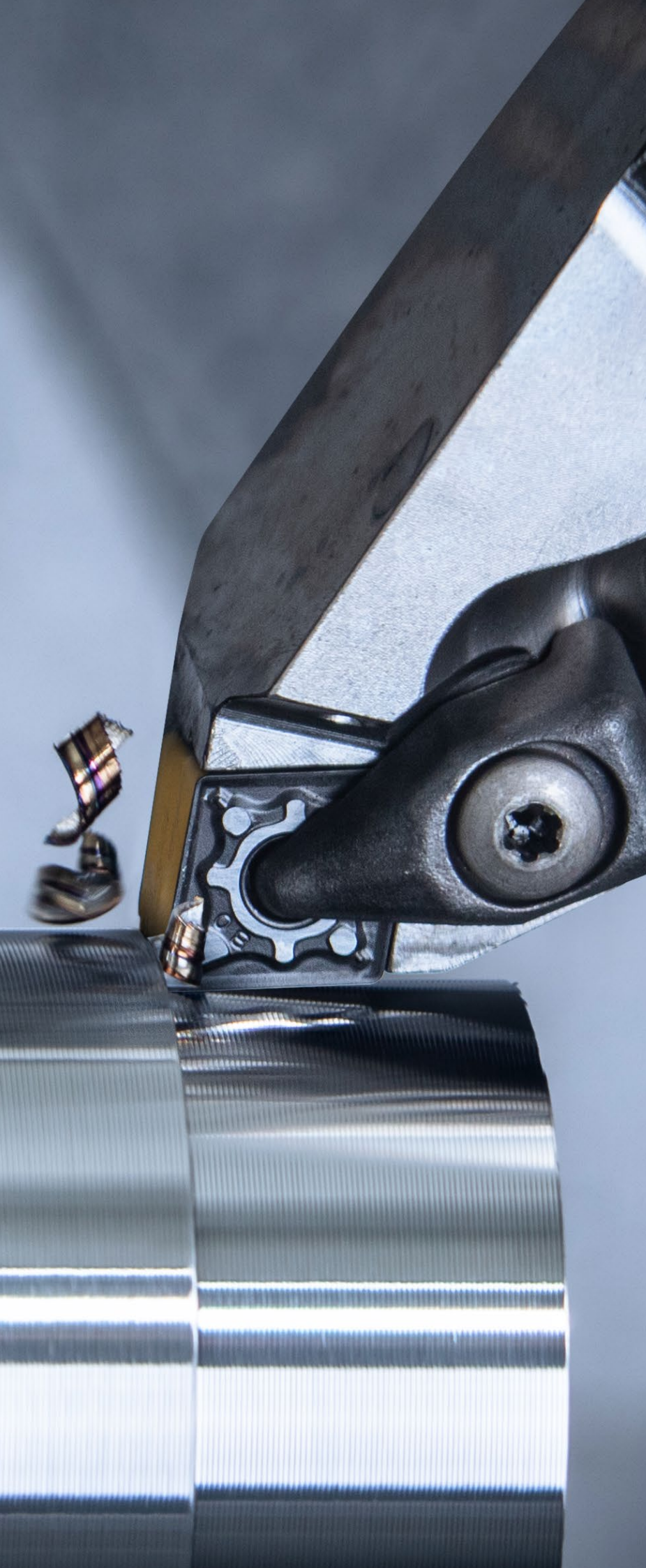
NEW

MaxiChange – Exchangeable head system



→ Page 177-192

The new actively vibration-dampened basic holder for demanding internal turning operations. Available with the Machine interface PSC, HSK-T and cylindrical shank.



Solid drilling and bore machining

- 1 HSS drilling
- 2 Solid carbide drilling
- 3 Indexable insert drilling
- 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

Clamping technology

- 16 Adaptors and Accessories
- 17 Workpiece clamping

- 18 Material examples and article no. Index

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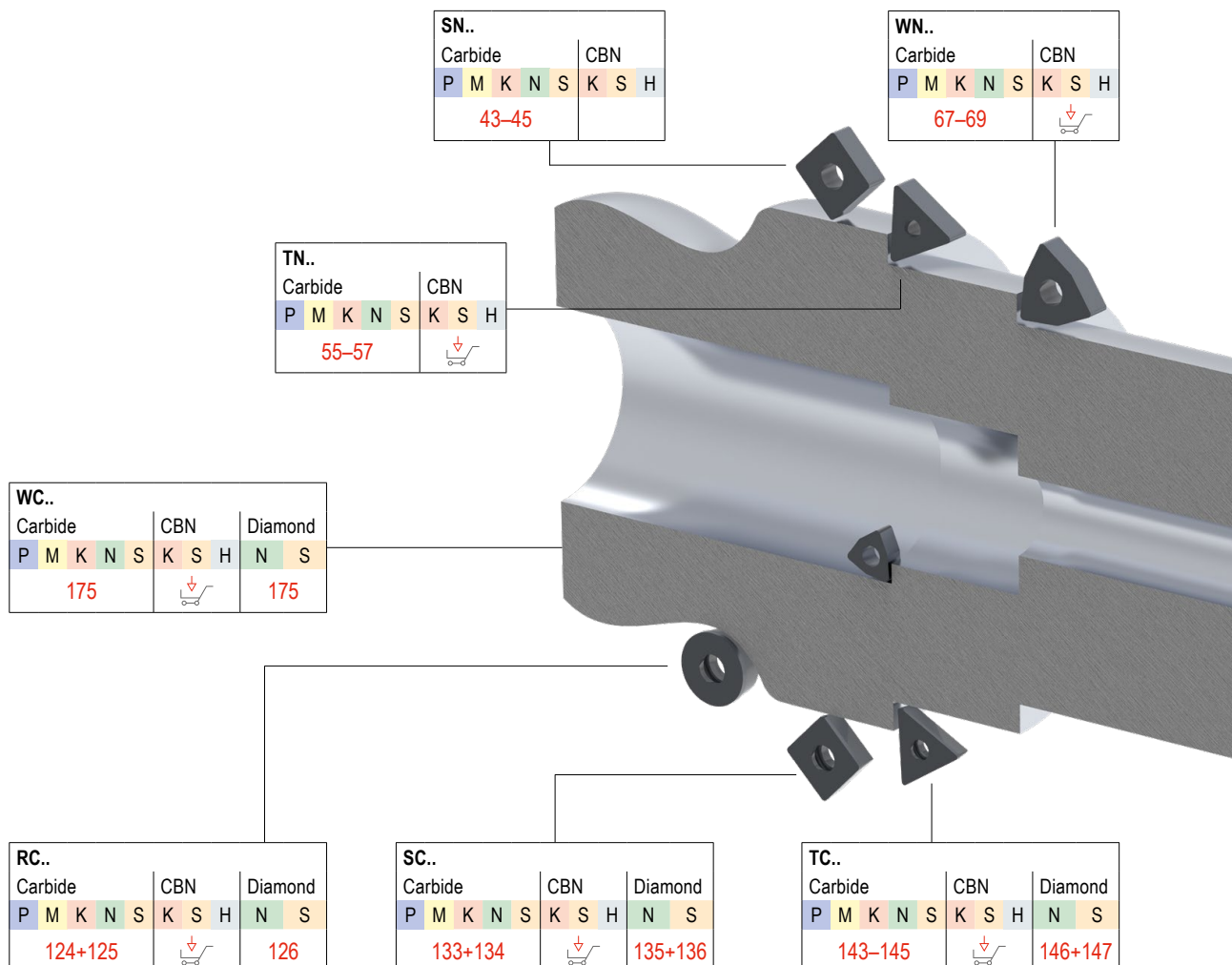
Symbol explanation	5
Toolfinder – Application	4+5
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CERATIZIT \ Performance

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.

Toolfinder – Application



Symbol explanation

CTCP125-P Carbide Grade		Smooth cut		Int. coolant supply
F Fine Machining		Irregular cutting depth		DirectCooling
M Medium Machining		Interrupted cut		
R Rough Machining				

A detailed overview of grades can be found in the technical appendix on → page 228



Hard turning with PCBN indexable inserts



<https://cts.ceratizit.com/en/pcbn-indexable-inserts>



The tool selection for Sliding head machines



cts.ceratizit.com/en/sliding-head-turning

CN..		
Carbide	CBN	Diamond
P M K N S	K S H	N S
12-16		17

DN..		
Carbide	CBN	Diamond
P M K N S	K S H	N S
26-29		30

VN..		
Carbide	CBN	
P M K N S	K S H	
62+63		

KN..		
Carbide		
P M K N S		

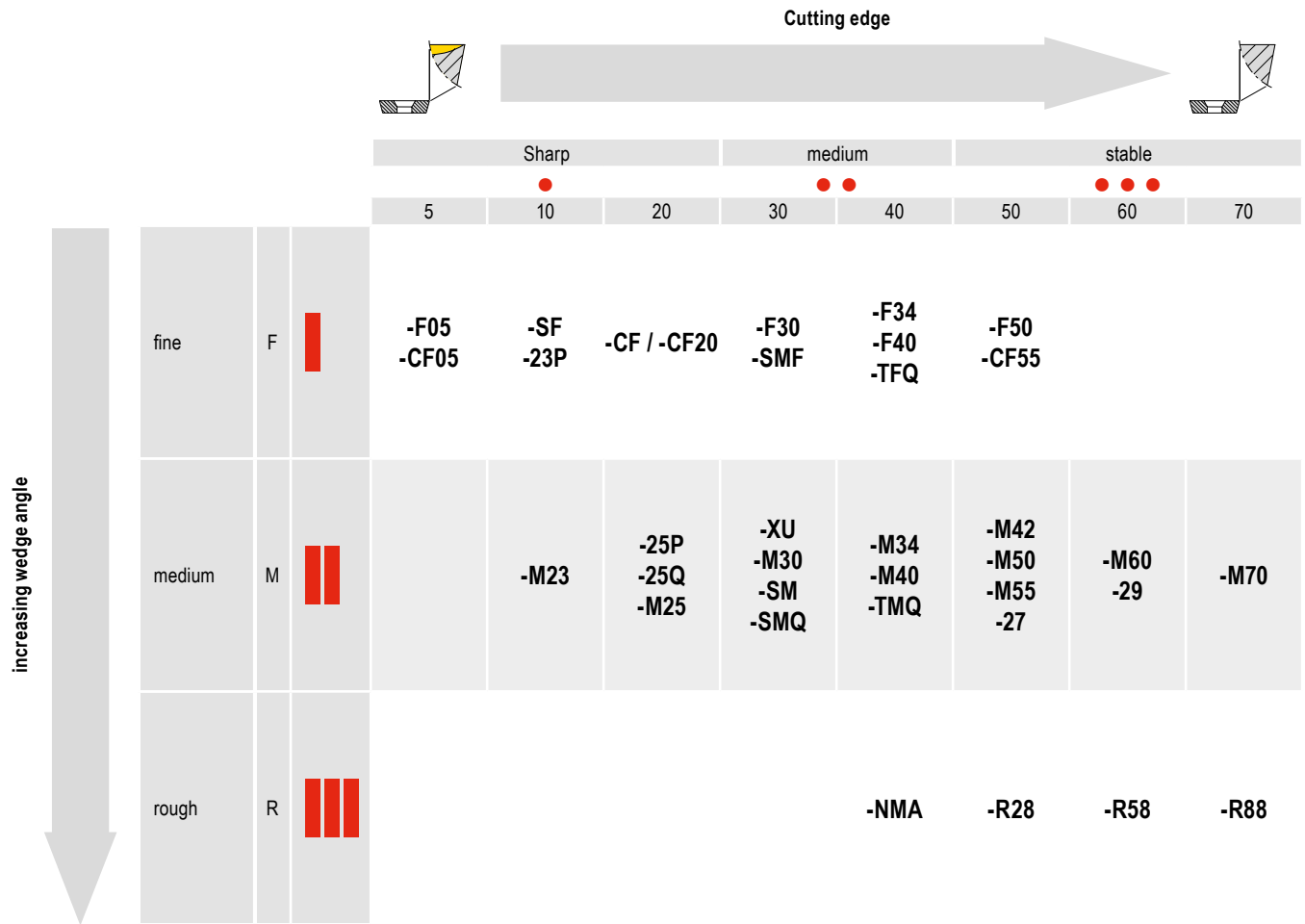
CC..		
Carbide	CBN	Diamond
P M K N S	K S H	N S
76-79		80-84

VC..		
Carbide	CBN	Diamond
P M K N S	K S H	N S
153-155		157-159

DC..		
Carbide	CBN	Diamond
P M K N S	K S H	N S
99-102		104-108

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

Chip Breakers Overview



Grade description

CT CERATIZIT

C **T** **C** **P** **1** **2** **5** **-P** (Example)

CT CERATIZIT

P Performance

Degree of hardness

Application

Main application – material

Coating

W Uncoated carbide	S Mixed ceramic	P Steel	1 Turning	05 ISO 05	↑ ↓
C CVD-coated carbide	K Whisker ceramic	M Stainless steel	2 Milling	10 ISO 10	
P PVD-coated carbide	I SiAlON	K Cast iron	3 Grooving	15 ISO 15	
T Cermet, uncoated	D PDC	N Non-ferrous metals	4 Drilling	20 ISO 20	
E Cermet, coated	B PcBN	S Heat-resistant	5 Thread turning	25 ISO 25	
N Silicon nitride, uncoated	H HSS sintered	H Tempered steel	6 Others	30 ISO 30	
M Silicon nitride, coated		O Non-metal materials	7 Several processes	35 ISO 35	
		X Universal application		40 ISO 40	

Toolfinder – negative inserts



			Steel	Stainless steel	Cast iron	Non-ferrous metals	Heat-resistant	Tempered steel	Non-metal materials	Geometry							
			P	M	K	N	S	H	O								
Main application: Steel and cast iron	Fine	Sharp	-CF / -CF20	●	○	○				12	26			55		67	
		-F40	●	○											62		
		-F50	●	○						12	26			43	55	62	67
		-TFQ	●	○						12+13	27						67
	Medium	-XU	●	○						13	27					62	68
		-M40	●	○											62		
		-M50	●	○						13	27			43	55	62	68
		-TMQ	●	○						13	27						68
		-M70 -11, -12	●	○						13+14	28			44	56		68
		.NMA	●	○						14	28			44	56		69
	Rough	-R28	●	○						14	28			45	56		
		-R58	●	○						14+15	28+29			45	56+57		
-R88		●	○						15				45				
Main application: Stainless	Fine	Sharp	-F30	○	●		○			15	29		46	57	62	69	
		-M30	○	●		○				15	29		46	57	62+63	69	
		-42	○	●		○				15							
	Medium	-M42	○	●		●				16	29		46	57		69	
		-M60	○	●		○				16	29		45	57		69	
		-M70	○	●		○				13-15	28+29		46	57		69	
Main application: Heat-resistant	Fine	Sharp	-F32	○	●		○	●									
		-F34	○	●		○	●			16						70	
	Medium	-M34	●	●		○	●			16	29		45	57	63	70	
		-M42	○	●		○	●			16	29						
		-M52	○	●		○	●										
Main application: Non-ferrous metals	Diamond		FN , FL, FR			●		●		17	30						

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	Tempered steel	Non-metal materials	Geometry									
			P	M	K	N	S	H	O	CC..	DC..	RC..	SC..	SP..	TC..	TP..	VC..	WC..	
Main application: Steel and cast iron	Sharp	Fine	-CF05	●	○	○				76	99		133			143		153	
			-SF	●	○	○				76-78	99-101		133			143		153+154	175
		Medium	-CF55	●	○	○				76	99		133			143		153	
			-M23	●	○							125							
	-SMF		●	○	○				76-78	99+105	124	133			143		153+154		
	-SM		●	○	●				77+78	100	124+125	133			143		154		
	stable	-SMQ	●	○					77+78	101									
		-EN, -EL, -ER	●	○	●									↓		↓			
Main application: Stainless	Sharp	Fine	-F43	○	●		○			78	101				144				
			-M81	○	●		○			↓	↓						↓		
	Medium	-M25	○	●		●			78	101		134			144		154		
		-M55	○	●		●			78	101		133+134			144+145		154+155		
Main application: Non-ferrous metals	Sharp	Fine	-23P		○	●		○		78	102								
			-25P	●	●	○	●	●	○	78	102	125	134					155	
		Medium	-25Q	●	●	○	●	●	○	79	102							155	
			-27	●	●	○	●	●	○	79	102	125	134			145		156	
			-29	●	○	○	●		○	79	103							156	
	Diamond	-FN, -FL, -FR				●		●		80-84	104-108	126	135+136			146+147		157-159	175
		CB1				●		●		81+84	105-108	126	135			146		158+159	
		CB2				●		●		81+84	105 107+108	126	136			147		158+159	
CB3				●		●		83	107		136			147		159			
Main application: Heat-resistant	Sharp	Fine	-F05	●	●	●	●			79	103							156	
			-F23	●	○	○	●			↓	↓							↓	



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

Toolfinder – holders

Toolholders and boring bars for negative inserts



Geometry	Tool holder	Boring bars	HSK-T	PSC
CN..	18-21	24+25	22	23
DN..	31-34	41+42	34-36	37-40
SN..	47-52	54	52	
TN..	58-60	61		
VN..	64		65	65+66
WN..	71+72	74+75	73	73

Toolholders and boring bars for positive inserts



Geometry	Tool holder	Boring bars	HSK-T	PSC
CC..	85-91	94-98	92	93
DC..	109-115	119-123	116	117+118
RC..	127-131		132	
SC..	137-141	142		
TC..	148-151	152		
VC..	160-168	172-174	168-170	170+171
WC..		176		

MaxiChange – Overview of the product range

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

Exchangeable heads

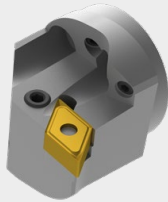
For negative inserts

PCLN 95°



187

PDUN 93°



187

PDQN 107,5°



188

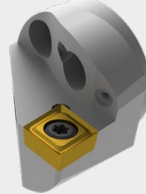
PWLN 95°



188

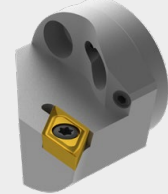
For positive inserts

SCLC 95°



189

SDUC 93°



189

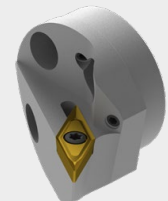
NEW

SDQC 107,5°



190

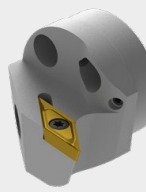
SVPC 117,5°



190

NEW

SVUC 93°



191

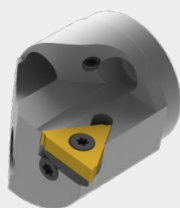
NEW

SVQC 107,5°



191

For internal thread



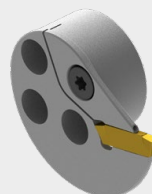
192

→ Chapter 11 – Grooving tools

For radial grooving

NEW

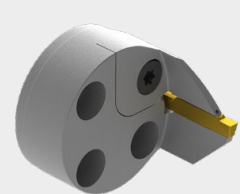
GX 16



For axial grooving


NEW

GX 24

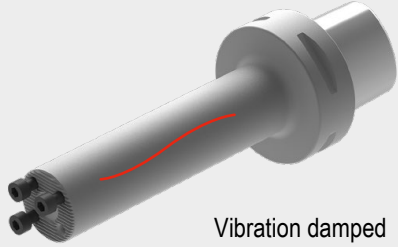


Tool holder

PSC

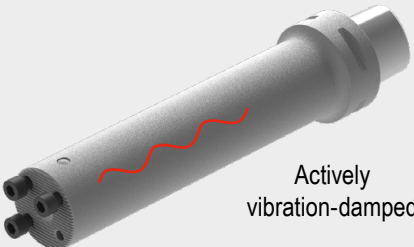


177



Vibration damped

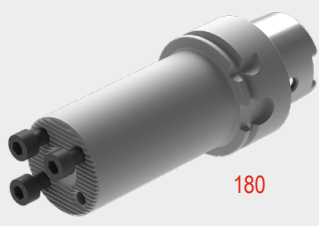
178



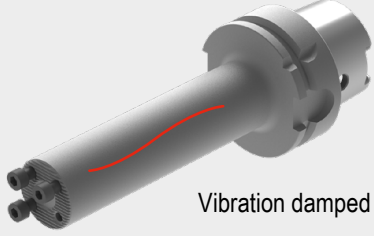
Actively vibration-damped

179

HSK-T

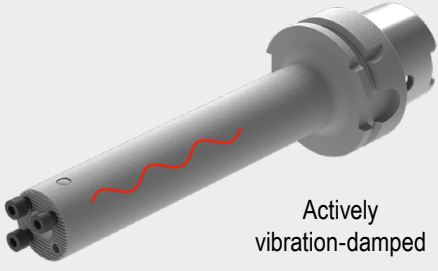


180



Vibration damped

181



Actively vibration-damped

182

Cylindrical shank



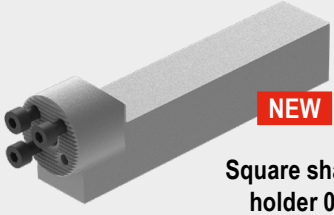
183



NEW

Actively vibration-damped


184



NEW

Square shank holder 0°

185



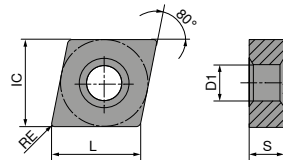
NEW

Square shank holder 90°

186

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		NEW -F50 CTCP115-P		NEW -F50 CTCP125-P		NEW -F50 CTCP135-P		NEW -TFQ CTCP115-P	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		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														
090304EN	0,4							31601		51601		71601			
090308EN	0,8							31801		51801		71801			
120404EN	0,4	904		028		028		32801		52801		72801		32801	
120408EN	0,8	908		030		030		33001		53001		73001		33001	
120412EN	1,2					032		33201		53201		73201		32001	
P		●		●		●		●		●		●		●	
M		○		○		○		○		○		○		○	
K		○		○		○		○		○		○		○	
N															
S															
H															
O															

CNMG

		NEW	NEW	NEW		NEW	NEW	
		-TFQ CTCP125-P	-XU CTCP115-P	-XU CTCP125-P	-M50 CTCK110	-M50 CTCK120	-M50 CTCP115-P	-M50 CTCP125-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F CNMG	M CNMG	M CNMG	M CNMG	M CNMG	M CNMG	M CNMG
		76 110 ...	76 290 ...	76 290 ...	70 132 ...	70 132 ...	76 135 ...	76 135 ...
ISO	RE mm							
120404EN	0,4	52801	32801	52801	028		32801	52801
120408EN	0,8	53001	33001	53001	030	530	33001	53001
120412EN	1,2	53201	33201	53201	032	532	32001	53201
120416EN	1,6						33401	53401
160608EN	0,8						34201	54201
160612EN	1,2						34401	54401
160616EN	1,6						34601	54601
P		●	●	●	○	○	●	●
M								
K		○	○	○	●	●	○	○
N								
S								
H								
O								

9

CNMG

		NEW	NEW	NEW		NEW	NEW	
		-M50 CTCP135-P	-TMQ CTCP115-P	-TMQ CTCP125-P	-M70 CTCK110	-M70 CTCK120	-M70 CTCP115-P	-M70 CTCP125-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M CNMG	M CNMG	M CNMG	M CNMG	M CNMG	M CNMG	M CNMG
		76 135 ...	76 196 ...	76 196 ...	70 119 ...	70 119 ...	76 119 ...	76 119 ...
ISO	RE mm							
120404EN	0,4	72801					33001	53001
120408EN	0,8	73001	33001	53001	030	530	32001	53201
120412EN	1,2	73201	32001	53201	032	532	33401	53401
120416EN	1,6	73401			034	534		
160608EN	0,8	74201			042	542	34201	54201
160612EN	1,2	74401			044	544	34401	54401
160616EN	1,6	74601			046	546	34601	54601
160624EN	2,4						34801	54801
190608EN	0,8						35401	55401
190612EN	1,2				056	556	35601	55601
190616EN	1,6				058	558	35801	55801
190624EN	2,4						36001	56001
P		●	●	●	○	○	●	●
M		○						
K			○	○	●	●	○	○
N								
S								
H								
O								

CNMG / CNMA / CNMM

		NEW				NEW		NEW		NEW	
		-M70		CTCK110		CTCK120		-R28		-R28	
		CTCP135-P		CTCP115-P		CTCP125-P		CTCP135-P		CTCP115-P	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		M		R		R		R		R	
		CNMG		CNMA		CNMA		CNMM		CNMM	
		76 119 ...		70 100 ...		70 100 ...		76 114 ...		76 114 ...	
ISO	RE mm										
120404EN	0,4				028		528				
120408EN	0,8	73001			030		530	33001	53001		33001
120412EN	1,2	73201			032		532	33201	53201	73201	33201
120416EN	1,6	73401			034		534	33401	53401	73401	33401
160608EN	0,8	74201			042		542				
160612EN	1,2	74401			044		544	34401	54401	74401	34401
160616EN	1,6	74601			046		546	34601	54601	74601	34601
160624EN	2,4	74801									34801
190608EN	0,8	75401									
190612EN	1,2	75601			056		556	35601	55601	75601	35601
190616EN	1,6	75801			058		558	35801	55801	75801	35801
190624EN	2,4	76001						36001	56001	76001	36001
250924EN	2,4							38401	58401	78401	38401
P		●	○	○	●	●	●	●	●	●	●
M		○								○	
K			●	●	○	○	○	○	○		○
N											
S											
H											
O											

CNMM



		NEW -R58 CTCP125-P	NEW -R58 CTCP135-P	NEW -R88 CTCP115-P	NEW -R88 CTCP125-P	NEW -R88 CTCP135-P
		R CNMM	R CNMM	R CNMM	R CNMM	R CNMM
		76 115 ...	76 115 ...	76 133 ...	76 133 ...	76 133 ...
ISO	RE mm	53001	73001			
120408EN	0,8	53201	73201			
120412EN	1,2	53401	73401			
120416EN	1,6					
160612EN	1,2	54401	74401			
160616EN	1,6	54601	74601			
160624EN	2,4	54801	74801			
160624SN	2,4			34801	54801	74801
190612EN	1,2	55601	75601			
190616EN	1,6	55801	75801			
190616SN	1,6			35801	55801	75801
190624EN	2,4	52401	76001			
190624SN	2,4			36001	56001	76001
250924EN	2,4	58401	78401			
250924SN	2,4			38401	58401	78401
P		●	●	●	●	●
M			○			○
K		○		○	○	○
N						
S						
H						
O						

9

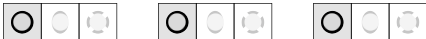
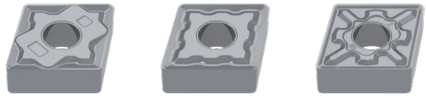
CNMG

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

CNMG

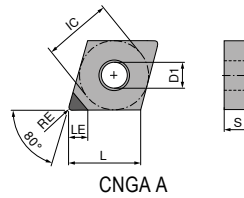
		NEW	NEW				NEW
		-42 CTCM130	-M42 CTCM130	-M60 CTCM120	-M60 CTPM125	-M60 CTCM130	-M70 CTCM130
		DRAGONSKIN					
							
							
		M CNMG					
		75 030 ...	75 029 ...	75 012 ...	75 012 ...	75 012 ...	75 037 ...
ISO	RE mm						
120404EN	0,4		32800				
120408EN	0,8	33000	33000	13000	230	33000	33000
120412EN	1,2		33200	13200	232	33200	33200
120416EN	1,6			13400	234	33400	
160612EN	1,2			14400	24400	34400	34400
190612EN	1,2						35600
190616EN	1,6						35800
P		○	○	○	○	○	○
M		●	●	●	●	●	●
K							
N							
S		○	○			○	○
H							
O							

CNMG

		NEW		NEW
		-F34 CTPX710	-M34 CTPX710	-M42 CTPX710
		DRAGONSKIN		
				
				
		F CNMG	M CNMG	M CNMG
		75 299 ...	75 003 ...	75 007 ...
ISO	RE mm			
120404EN	0,4		62800	62800
120408EN	0,8		63000	63000
120412EN	1,2		63200	63200
120416EN	1,6		63400	
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

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

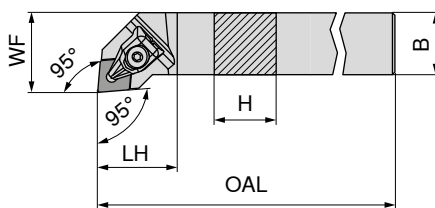
CTDPD20	CTDPS30
F	F
DIAMOND CNGA	DIAMOND CNGA
71 127 ...	71 127 ...
10001	20001
10101	20101
10201	20201

P		
M		
K		
N	•	•
S		
H		
O	•	•

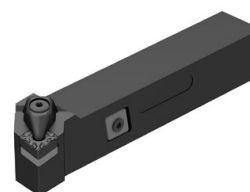
MaxiLock-D – DCLN 95° – Toolholder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Left-hand **70 509 ...** Right-hand **70 508 ...**

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert		
DCLN R/L 1616 H09	16	16	100	23	20	2	CN.. 0903		
DCLN R/L 2020 K09	20	20	125	24	25	2	CN.. 0903	516	516
DCLN R/L 2020 K12	20	20	125	32	25	4	CN.. 1204	520	520
DCLN R/L 2525 M12	25	25	150	32	32	4	CN.. 1204	620	620
DCLN R/L 3225 P12	32	25	170	32	32	4	CN.. 1204	625	625
DCLN R/L 3225 M16	32	25	170	32	32	4	CN.. 1204	632	632
DCLN R/L 2525 M16	25	25	150	38	32	6,5	CN.. 1606	725	725
DCLN R/L 3232 P16	32	32	170	36	40	6,5	CN.. 1606	732	732
DCLN R/L 3232 P19	32	32	170	42	40	6,5	CN.. 1906	832	832
DCLN R/L 4040 S19	40	40	250	42	50	6,5	CN.. 1906	940	940
DCLN R/L 4040 S25	40	40	250	60	50	6,5	CN.. 2509	440	440



XPRESS type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Carbide type C

70 950 ...

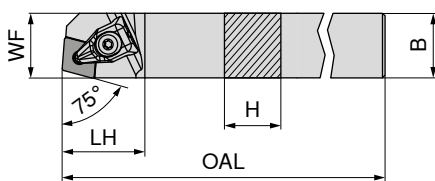
Spare parts for Article no.

70 508 516 / 70 509 516	823	T09 - IP	126	M3x7 - IP	819	848
70 508 520 / 70 509 520	823	T09 - IP	126	M3x7 - IP	819	848
70 508 620 / 70 509 620	824	T15 - IP	128	M4,5x12 - IP	820	810
70 508 625 / 70 509 625	824	T15 - IP	128	M4,5x12 - IP	820	810
70 508 632 / 70 509 632	824	T15 - IP	128	M4,5x12 - IP	820	810
70 508 725 / 70 509 725	825	T20 - IP	129	M5x14 - IP	821	814
70 508 732 / 70 509 732	825	T20 - IP	129	M5x14 - IP	821	814
70 508 832 / 70 509 832	826	T20 - IP	129	M5x14 - IP	821	816
70 508 940 / 70 509 940	826	T20 - IP	129	M5x14 - IP	821	816
70 508 440 / 70 509 440	827	T25 - IP	122	M6x16 - IP	822	625

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

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Left-hand **70 501 ...** Right-hand **70 500 ...**

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert		
DCBN R/L 2525 M12	25	25	150	32	22	4	CN.. 1204	825	825



XPRESS type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Carbide type C

70 950 ...

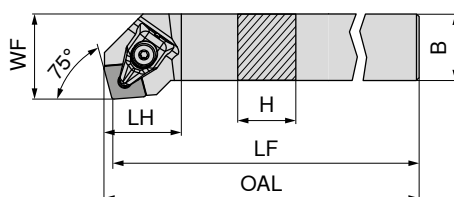
Spare parts for Article no.

70 501 825 / 70 500 825	824	T15 - IP	128	M4,5x12 - IP	820	810
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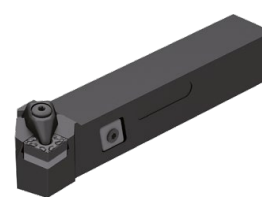
MaxiLock-D – DCKN 75° – Toolholder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



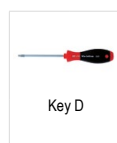
Left-hand **70 505 ...** Right-hand **70 504 ...**

ISO designation	H mm	B mm	OAL mm	LF mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand	Right-hand
DCKN R/L 2525 M12	25	25	152,9	150	28,9	32	4	CN.. 1204	825	825



70 950 ...

824



Key D

80 950 ...

128



Clamping screw

70 950 ...

820



Carbide type C

70 950 ...

810

Spare parts
for Article no.

70 505 825 / 70 504 825

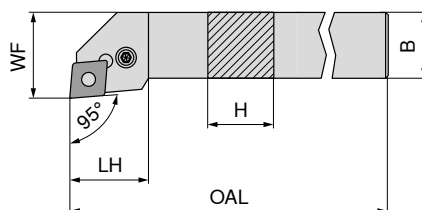
T15 - IP

M4,5x12 - IP

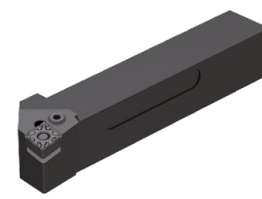
MaxiLock-N – PCLN 95° – Toolholder with lever clamping

Scope of supply:

Tool holder with allen key

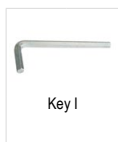


Illustrations show right-hand versions



Left-hand **70 509 ...** Right-hand **70 508 ...**

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand	Right-hand
PCLN R/L 1616 H12	16	16	100	26,2	20	4	CN.. 1204	016	016
PCLN R/L 2020 K12	20	20	125	27,5	25	4	CN.. 1204	020	020
PCLN R/L 2525 M12	25	25	150	28,1	32	4	CN.. 1204	025	025
PCLN R/L 3225 P12	32	25	170	28,1	32	4	CN.. 1204	032	032
PCLN R/L 2525 M16	25	25	150	32,7	32	4	CN.. 1606	125	125
PCLN R/L 3232 P16	32	32	170	32,6	40	4	CN.. 1606	132	132
PCLN R/L 3232 P19	32	32	170	38,0	40	8	CN.. 1906	232	232
PCLN R/L 4040 S19	40	40	250	38,0	50	8	CN.. 1906	54000	54000
PCLN R/L 4040 S25	40	40	250	50,0	50	8	CN.. 2509	340	340



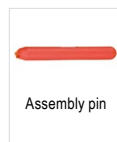
Key I

70 950 ...



Shim

70 950 ...



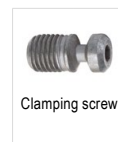
Assembly pin

70 950 ...



Lever

70 950 ...



Clamping screw

70 950 ...



Carbide type C

70 950 ...

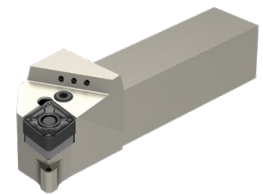
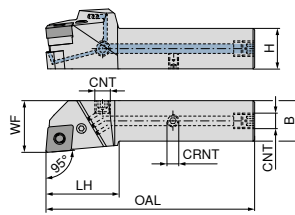
Spare parts
for Article no.

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

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

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions

NEW Left-hand 70 592 ...
NEW Right-hand 70 592 ...

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



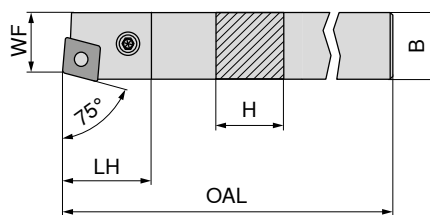
Spare parts
for Article no.

70 592 02000 / 70 592 02001	176	198	192	294	187	209	233	86700
70 592 02500 / 70 592 02501	176	198	192	294	187	209	233	86700
70 592 03200 / 70 592 03201	176	198	192	294	187	209	233	86700
70 592 12500 / 70 592 12501	176	391	394	294	385	388	380	86700
70 592 13200 / 70 592 13201	176	391	394	294	385	388	380	86700
70 592 23200 / 70 592 23201	396	392	395	294	386	389	381	86700
70 592 04000 / 70 592 04001	396	392	395	294	386	389	381	86700
70 592 14000 / 70 592 14001	265	621	623	294	620	622	624	86700

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

Scope of supply:

Tool holder with allen key

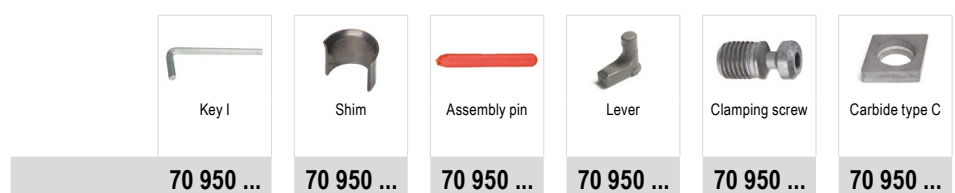


Illustrations show right-hand versions



Left-hand 70 501 ...
Right-hand 70 500 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	70 501 ...	70 500 ...
PCBN R/L 2525 M12	25	25	150	27,70	22	4	CN.. 1204	025	025
PCBN R/L 2525 M16	25	25	150	31,81	22	4	CN.. 1606	12500	125
PCBN R/L 3232 P19	32	32	170	38,00	27	8	CN.. 1906	032	032



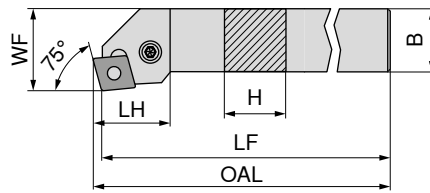
Spare parts
for Article no.

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

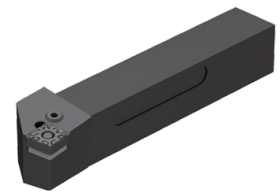
MaxiLock-N – PCKN 75° – Toolholder with lever clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left-hand	Right-hand
70 505 ...	70 504 ...
025	025

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

**Spare parts
for Article no.**

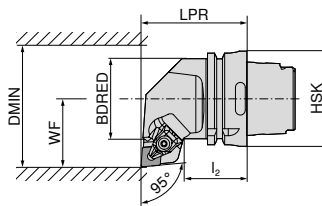
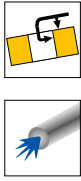
70 505 025 / 70 504 025

Key I	Shim	Assembly pin	Lever	Clamping screw	Carbide type C
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
SW3	176	198	192	187	209
				209	233

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

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

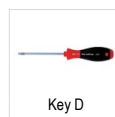


ISO designation	Adapter	LPR mm	l ₂ mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand	Right-hand
									74 504 ...	74 503 ...
HSK T63 DCLN R/L 12	HSK-T 63	70	42	53	45	100	4	CN.. 1204	512	512
HSK T63 DCLN R/L 16	HSK-T 63	70	42	53	45	125	4	CN.. 1606	516	516
HSK T63 DCLN R/L 19	HSK-T 63	70	42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



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Carbide type C

70 950 ...

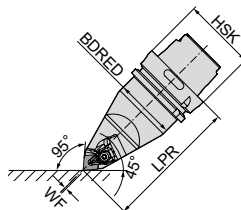
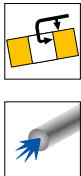
**Spare parts
for Article no.**

74 504 512 / 74 503 512	824	T15 - IP	128	M4,5x12 - IP	820	810
74 504 516 / 74 503 516	825	T20 - IP	129	M5x14 - IP	821	814
74 504 519 / 74 503 519	826	T20 - IP	129	M5x14 - IP	821	816
74 504 712 / 74 503 712	824	T15 - IP	128	M4,5x12 - IP	820	810
74 504 719 / 74 503 719	826	T20 - IP	129	M5x14 - IP	821	816

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

Scope of supply:

Tool holder with Torx key



Neutral

74 506 ...

ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert	
HSK T63 DCMN N 12	HSK-T 63	115	53	0	4	CN.. 1204	512
HSK T100 DCMN N 12	HSK-T 100	150	88	0	4	CN.. 1204	712



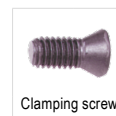
XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Carbide type C

70 950 ...

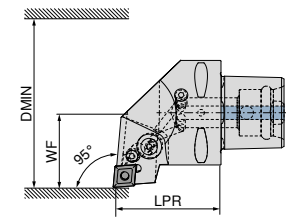
**Spare parts
for Article no.**

74 506 512	824	T15 - IP	128	M4,5x12 - IP	820	810
74 506 712	824	T15 - IP	128	M4,5x12 - IP	820	810

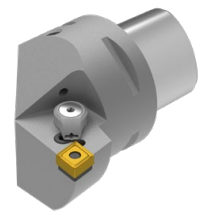
MaxiLock-N – PCLN 95° – Toolholder with lever clamping

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	Left-hand	Right-hand
								84 657 ...	84 656 ...
PSC40 PCLN R/L 50050-12	PSC 40	50	27	50	5	CN.. 1204	DC	01295	01295
PSC50 PCLN R/L 65060-12	PSC 50	60	35	65	5	CN.. 1204	DC	01294	01294
PSC63 PCLN R/L 80065-12	PSC 63	65	45	80	5	CN.. 1204	DC	01293	01293

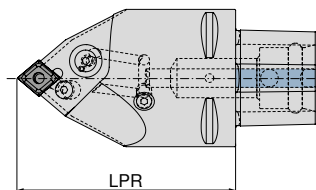
The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra → **Page 40.**

Spare parts for Article no.	Shim	Elbow lever screw	Lever	Carbide type C	
					84 950 ...
84 656 01295 / 84 657 01295	29200	M8X1/L17 SW3	28700	29000	27800
84 656 01294 / 84 657 01294	29200	M8X1/L17 SW3	28700	29000	27800
84 656 01293 / 84 657 01293	29200	M8X1/L17 SW3	28700	29000	27800

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	Neutral
						84 675 ...
PSC63 PCMN N 0100-12	PSC 63	100	5	CN.. 1204	DC	01293
PSC63 PCMN N 0130-12	PSC 63	130	5	CN.. 1204	DC	11293

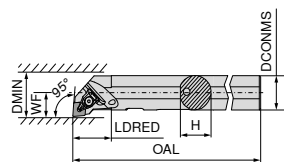
The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra → **Page 40.**

Spare parts for Article no.	Shim	Elbow lever screw	Lever	Carbide type C	
					84 950 ...
84 675 01293	29200	M8X1/L17 SW3	28700	29000	27800
84 675 11293	29200	M8X1/L17 SW3	28700	29000	27800

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

Scope of supply:

Boring bar with Torx key



Illustrations show right-hand versions

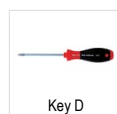


ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									70 557 ...	70 556 ...	70 557 ...	70 556 ...
A20Q DCLN R/L 09	20	19	180	35	13	25	2	CN.. 0903	720		720	
A25R DCLN R/L 12	25	24	200	36	17	32	4	CN.. 1204	825		825	
A32S DCLN R/L 12	32	31	250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



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Carbide type C

70 950 ...

Spare parts for Article no.

70 556 720 / 70 557 720	823	T09 - IP	126	M3x7 - IP	819	848
70 556 825 / 70 557 825	824	T15 - IP	128	M4,5x12 - IP	820	
70 556 832 / 70 557 832	824	T15 - IP	128	M4,5x12 - IP	820	810
70 556 840 / 70 557 840	824	T15 - IP	128	M4,5x12 - IP	820	810
70 557 85000	825	T20 - IP	129	M5x14 - IP	821	814

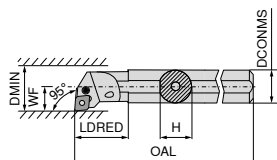
MaxiLock-N – PCLN 95° – Boring bar with lever clamping

▲ A... = with thro' coolant

▲ S... = without thro' coolant

Scope of supply:

Boring bar with Allen key

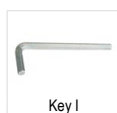


Illustrations show right-hand versions



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 ...	70 557 ...	70 556 ...
A25R PCLN R/L 12	25	23	200	36,0	17	32	4	CN.. 1204	225		225	
S25T PCLN R/L 12	25	23	300	22,0	17	32	4	CN.. 1204	025		025	
A32S PCLN R/L 12	32	30	250	50,0	22	40	4	CN.. 1204	232		232	
S32U PCLN R/L 12	32	30	350	24,1	22	40	4	CN.. 1204	032		032	
A40T PCLN R/L 12	40	38	300	60,0	27	50	4	CN.. 1204	240		240	
S40V PCLN R/L 12	40	38	400	24,1	27	50	4	CN.. 1204	040		04000 ¹⁾	
S50W PCLN R/L 16	50	47	450	31,0	35	63	4	CN.. 1606	050		050	

1) nickel-plated



Key I

70 950 ...



Shim

70 950 ...



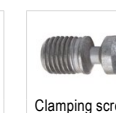
Assembly pin

70 950 ...



Lever

70 950 ...



Clamping screw

70 950 ...



Carbide type C

70 950 ...

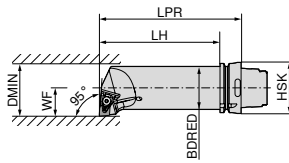
Spare parts for Article no.

70 556 225 / 70 557 225	SW3	176	198	192	187	205	233
70 556 025 / 70 557 025	SW3	176	198	192	187	205	233
70 556 232 / 70 557 232	SW3	176	198	192	187	205	233
70 556 032 / 70 557 032	SW3	176	198	192	187	205	233
70 556 240 / 70 557 240	SW3	176	198	192	187	209	233
70 556 04000 / 70 557 040	SW3	176	198	192	187	209	233
70 556 050 / 70 557 050	SW3	176	391	394	385	388	380

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

Scope of supply:

Boring bar with Torx key



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 ...
HSK T63 50Q DCLN R/L 12	HSK-T 63	175	149	50	35	63	4	CN.. 1204	512	512

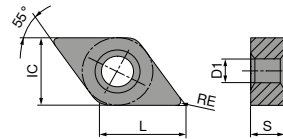
**Spare parts
for Article no.**

74 528 512 / 74 529 512

XPress type	Key D	Clamping screw	Carbide type C
70 950 ...	80 950 ...	70 950 ...	70 950 ...
824	T15 - IP	128	M4,5x12 - IP
		820	810

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

ISO	RE mm	-CF TCM10		-CF20 CTEP110		-TFQ CTEP110		NEW -F50 CTCP115-P		NEW -F50 CTCP125-P		NEW -F50 CTCP135-P	
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN				
		F	F	F	F	F	F	F	F	F	F	F	F
		CERMET DNMG	CERMET DNMG	CERMET DNMG	CERMET DNMG	CERMET DNMG	DNMG	DNMG	DNMG	DNMG	DNMG	DNMG	DNMG
		70 155 ...	76 102 ...	76 153 ...	76 134 ...	76 134 ...	76 134 ...	76 134 ...	76 134 ...	76 134 ...	76 134 ...	76 134 ...	76 134 ...
110402EN	0,2				30201	50201	70201						
110404EN	0,4	904	004		30401	50401	70401						
110408EN	0,8		006		30601	50601	70601						
110412EN	1,2				30801	50801	70801						
150404EN	0,4				31601	51601	71601						
150408EN	0,8				31801	51801	71801						
150412EN	1,2				32001	52001	72001						
150604EN	0,4	914	028	028	32801	52801	72801						
150608EN	0,8		030	030	33001	53001	73001						
150612EN	1,2		032		33201	53201	73201						
P		●	●	●	●	●	●	●	●	●	●	●	●
M		○	○	○	○	○	○	○	○	○	○	○	○
K		○	○	○	○	○	○	○	○	○	○	○	○
N													
S													
H													
O													

DNMG

		NEW		NEW		NEW		NEW		NEW			
		-TFQ		-TFQ		-TFQ		-TFQ		-XU		-M50	
		CTCP115-P		CTCP125-P		CTCP115-P		CTCP125-P		CTCP115-P		CTCP125-P	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		F		F		M		M		M		M	
		DNMG		DNMG		DNMG		DNMG		DNMG		DNMG	
		76 153 ...		76 153 ...		76 169 ...		76 169 ...		76 291 ...		76 291 ...	
ISO	RE												
	mm												
150408EN	0,8											018	
150412EN	1,2											020	
150604EN	0,4	32801		52801				32801		52801			
150608EN	0,8	33001		53001				33001		53001			030
150612EN	1,2				33201		53201	33201		53201			032
P			●		●		●		●		●		○
M													
K			○		○		○		○		○		●
N													
S													
H													
O													

DNMG

		NEW		NEW		NEW		NEW		NEW	
		-M50		-M50		-M50		-M50		-TMQ	
		CTCK120		CTCP115-P		CTCP125-P		CTCP135-P		CTCP125-P	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		M		M		M		M		M	
		DNMG		DNMG		DNMG		DNMG		DNMG	
		70 133 ...		76 136 ...		76 136 ...		76 136 ...		76 168 ...	
ISO	RE										
	mm										
110404EN	0,4			30401		50401		70401			
110408EN	0,8			30601		50601		70601			
110412EN	1,2			30801		50801		70801			
150404EN	0,4			31601		51401		71601			
150408EN	0,8		518	31801		51801		71801			
150412EN	1,2		520	32001		51601		72001			
150416EN	1,6			32201		52201		72201			
150604EN	0,4			32801		52801		72801			
150608EN	0,8		530	33001		53001		73001		33001	53001
150612EN	1,2		532	33201		53201		73201		33201	53201
150616EN	1,6			33401		53401		73401			
P			○		●		●		●		●
M									○		
K			●		○		○		○		○
N											
S											
H											
O											

DNMG

ISO		RE mm	-M70 CTCK110		-M70 CTCK120		NEW -M70 CTCP115-P		NEW -M70 CTCP125-P		NEW -M70 CTCP135-P	
			DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
			M DNMG		M DNMG		M DNMG		M DNMG		M DNMG	
			70 263 ...		70 263 ...		76 263 ...		76 263 ...		76 263 ...	
110408EN	0,8							30601	50601	70601		
110412EN	1,2						30801	50801	70801			
150408EN	0,8		018	518	31801	51801	71801					
150412EN	1,2		020	520	32001	52001	72001					
150416EN	1,6				32201	52201	72201					
150608EN	0,8		030	530	33001	53001	73001					
150612EN	1,2		032	532	33201	53201	73201					
150616EN	1,6		034	534	33401	53401	73401					
P			○	○	●	●	●					
M										○		
K			●	●	○	○						
N												
S												
H												
O												

DNMA / DNMM

ISO		RE mm	CTCK110	CTCK120	NEW -R28 CTCP115-P	NEW -R28 CTCP125-P	NEW -R28 CTCP135-P	NEW -R58 CTCP115-P	NEW -R58 CTCP125-P
			DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
			R DNMA	R DNMA	R DNMM	R DNMM	R DNMM	R DNMM	R DNMM
			70 156 ...	70 156 ...	76 165 ...	76 165 ...	76 165 ...	76 166 ...	76 166 ...
150408EN	0,8		018	518					
150412EN	1,2		020	520					
150608EN	0,8		030	530					
150612EN	1,2		032	532	33201	53201	73201	33201	53201
150616EN	1,6				33401	53401	73401	33401	53401
P			○	○	●	●	●	●	●
M							○		
K			●	●	○	○		○	○
N									
S									
H									
O									

DNMM / DNMG

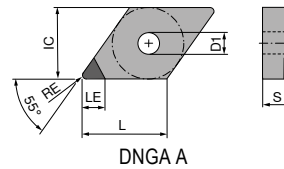
		NEW						
		-R58 CTCP135-P	-F30 CTCM120	-F30 CTPM125	-F30 CTCM130	-M30 CTCM120	-M30 CTPM125	-M30 CTCM130
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		R	F	F	F	M	M	M
		DNMM	DNMG	DNMG	DNMG	DNMG	DNMG	DNMG
		76 166 ...	75 013 ...	75 013 ...	75 013 ...	75 014 ...	75 014 ...	75 014 ...
ISO	RE mm							
110404EN	0,4		10400	204	30400			
110408EN	0,8		10600	206	30600	10600	206	30600
110412EN	1,2					10800	208	30800
150404EN	0,4		11600		31600			31800
150408EN	0,8		11800		31800	11800		31800
150412EN	1,2					12000		32000
150604EN	0,4		12800	228	32800			33000
150608EN	0,8		13000	230	33000	13000	230	33000
150612EN	1,2	73201				13200	232	33200
150616EN	1,6	73401						
P		●	○	○	○	○	○	○
M		○	●	●	●	●	●	●
K								
N								
S					○			○
H								
O								

DNMG

		NEW						
		-M42 CTCM130	-M60 CTCM120	-M60 CTPM125	-M60 CTCM130	-M70 CTCM130	-M34 CTPX710	-M42 CTPX710
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M	M	M	M	M	M	M
		DNMG	DNMG	DNMG	DNMG	DNMG	DNMG	DNMG
		75 027 ...	75 015 ...	75 015 ...	75 015 ...	75 038 ...	75 004 ...	75 027 ...
ISO	RE mm							
110404EN	0,4	30400						
110408EN	0,8	30600				30600		
150404EN	0,4	31600					61600	
150408EN	0,8	31800	11800		31800		61800	
150412EN	1,2		12000		32000		62000	
150604EN	0,4	32800						63000
150608EN	0,8	33000	13000	230	33000		63000	63000
150612EN	1,2		13200	232	33200		63200	
P		○	○	○	○	○	●	●
M		●	●	●	●	●	●	●
K								
N							○	○
S		○			○	○	●	●
H								
O								

DNGA

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



DNGA

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

CTDPD20

F
DIAMOND
DNGA

71 128 ...

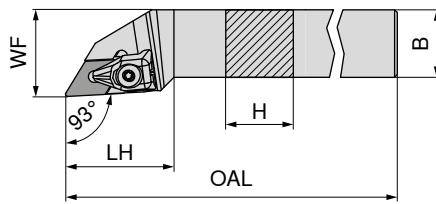
ISO	RE mm	TCE (NOI)	LE mm	
150404FN	0,4	A (1)	6,4	10001
150408FN	0,8	A (1)	6,0	10101
150412FN	1,2	A (1)	5,6	10201
150604FN	0,4	A (1)	6,4	10301
150608FN	0,8	A (1)	6,0	10401
150612FN	1,2	A (1)	5,6	10501

P
M
K
N
S
H
O

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

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Left-hand **70 541 ...** Right-hand **70 540 ...**

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand	Right-hand
DDJN R/L 1616 H11	16	16	100	33	20	2	DN.. 1104	816	816
DDJN R/L 2020 K11	20	20	125	33	25	2	DN.. 1104	820	820
DDJN R/L 2525 M11	25	25	150	33	32	2	DN.. 1104	825	825
DDJN R/L 2020 K15	20	20	125	40	25	4	DN.. 1504 / 1506	720	720
DDJN R/L 2525 M15	25	25	150	40	32	4	DN.. 1504 / 1506	725	725
DDJN R/L 3225 P15	32	25	170	40	32	4	DN.. 1504 / 1506	832	832

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



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Solid Carbide Seat D

70 950 ...

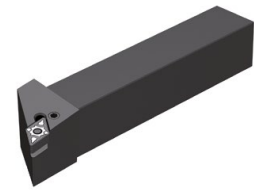
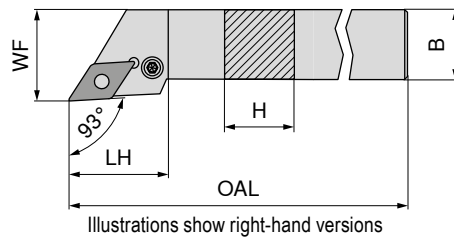
Spare parts for Article no.

70 541 816 / 70 540 816	835	T09 - IP	126	M3x7 - IP	819	808
70 541 820 / 70 540 820	835	T09 - IP	126	M3x7 - IP	819	808
70 541 825 / 70 540 825	835	T09 - IP	126	M3x7 - IP	819	808
70 541 720 / 70 540 720	824	T15 - IP	128	M4,5x12 - IP	820	811
70 541 725 / 70 540 725	824	T15 - IP	128	M4,5x12 - IP	820	811
70 541 832 / 70 540 832	824	T15 - IP	128	M4,5x12 - IP	820	811

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

Scope of supply:

Tool holder with allen key



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert
PDJN R/L 1616 H11	16	16	100	30,0	20	3	DN.. 1104
PDJN R/L 2020 K11	20	20	125	30,0	25	3	DN.. 1104
PDJN R/L 2525 M11	25	25	150	30,0	32	3	DN.. 1104
PDJN R/L 2020 K15	20	20	125	34,9	25	3,2	DN.. 1506
PDJN R/L 2525 M15	25	25	150	35,4	32	3,2	DN.. 1506
PDJN R/L 3225 P15	32	25	170	35,4	32	3,2	DN.. 1506
PDJN R/L 3232 P15	32	32	170	34,7	40	3,2	DN.. 1506

Left-hand 70 541 ...	Right-hand 70 540 ...
116	116
12000 ¹⁾	12000 ¹⁾
12500 ¹⁾	12500 ¹⁾
020	020
025	025
032	032
13200	13200

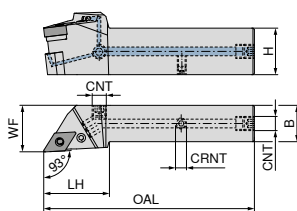
1) nickel-plated

Spare parts for Article 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 ...
70 540 116 / 70 541 116						
70 540 12000 / 70 541 12000						
70 540 12500 / 70 541 12500						
70 540 020 / 70 541 020						
70 540 025 / 70 541 025						
70 540 032 / 70 541 032						
70 540 13200 / 70 541 13200						

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

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions

NEW Left-hand **70 593 ...**
NEW Right-hand **70 593 ...**

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

Key I	Shim	Assembly pin	Coolant screw plug	Lever	Clamping screw	Solid Carbide Seat D	Grubscrew
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...

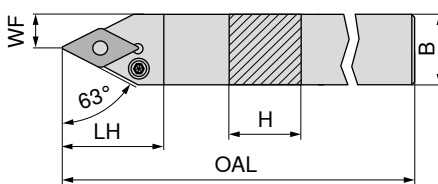
Spare parts for Article no.

70 593 02001 / 70 593 02000	175	122	191	294	121	208	120	86700
70 593 02501 / 70 593 02500	175	122	191	294	121	208	120	86700
70 593 12001 / 70 593 12000	176	198	192	294	188	209	236	86700
70 593 12501 / 70 593 12500	176	198	192	294	188	209	236	86700
70 593 03201 / 70 593 03200	176	198	192	294	188	209	236	86700
70 593 13201 / 70 593 13200	176	198	192	294	188	209	236	86700

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

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left-hand **70 537 ...**
Right-hand **70 536 ...**

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	70 537 ...	70 536 ...
PDNN R/L 2525 M11	25	25	150	30,0	12,5	3	DN.. 1104	125	125
PDNN R/L 2525 M15	25	25	150	36,5	12,5	3,2	DN.. 1506	025	025

Key I	Shim	Assembly pin	Lever	Clamping screw	Solid Carbide Seat D
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...

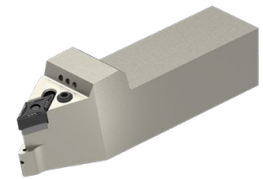
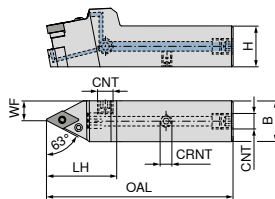
Spare parts for Article no.

70 537 125 / 70 536 125	SW2,5	175	122	191	121	208	120
70 537 025 / 70 536 025	SW3	176	198	192	188	388	236

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

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions

NEW Left-hand **70 594 ...**
NEW Right-hand **70 594 ...**

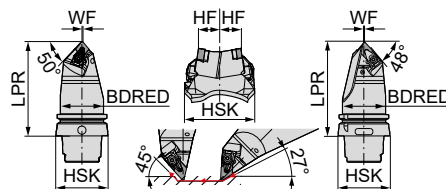
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	70 594 ...	70 594 ...
PDNN R/L 2525 X11-T DC	25	25	114	45	12,5	M6	G1/8"	3	DN.. 1104	02500	02501
PDNN R/L 2525 X15-T DC	25	25	119	50	12,5	M6	G1/8"	3,2	DN.. 1506	12500	12501

Spare parts for Article no.	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...							
70 594 02501 / 70 594 02500		175		122		191		294		121		208		120		86700
70 594 12501 / 70 594 12500		176		198		192		294		188		209		236		86700

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

Scope of supply:

Tool holder with Torx key



Neutral **74 600 ...**

ISO designation	Adapter	LPR mm	BDRED mm	WF mm	HF mm	torque moment Nm	Insert	74 600 ...
HSK T63 DCMN L 12 + DDMN L 15	HSK-T 63	115	53	0,5	20	4	CN.. 1204 / DN.. 1506	501
HSK T100 DCMN L 12 + DDMN L 15	HSK-T 100	150	88	0,5	20	4	CN.. 1204 / DN.. 1506	701

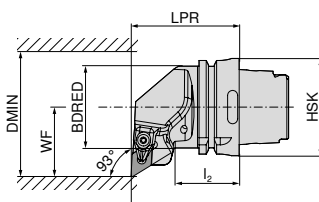
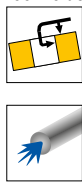
1 Face turning maximum 78 mm

Spare parts for Article no.	74 600 501	74 600 701
XPRESS type	824	824
Key D	T15 - IP	T15 - IP
Clamping screw	128	128
Solid Carbide Seat D	M4,5x12 - IP	M4,5x12 - IP
Carbide type C	820	820
	811	811
	810	810

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

Scope of supply:

Tool holder with Torx key







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	Left-hand	Right-hand
HSK T63 DDUN R/L 15	HSK-T 63	70	42	53	45	125	4	DN.. 1506	515	515
HSK T100 DDUN R/L 15	HSK-T 100	80	45	88	55	125	4	DN.. 1506	715	715

 XPress type 70 950 ...	 Key D 80 950 ...	 Clamping screw 70 950 ...	 Solid Carbide Seat D 70 950 ...
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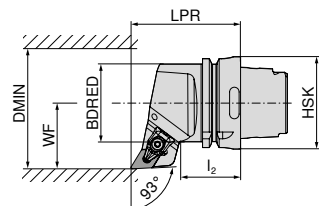
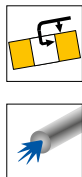
Spare parts for Article no.

74 516 515 / 74 515 515	824	T15 - IP	128	M4,5x12 - IP	820	811
74 516 715 / 74 515 715	824	T15 - IP	128	M4,5x12 - IP	820	811

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

Scope of supply:

Tool holder with Torx key







Illustrations show right-hand versions



Left-hand **74 512 ...**
Right-hand **74 511 ...**

ISO designation	Adapter	LPR mm	l ₂ mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand	Right-hand
HSK T63 DDJN R/L 15	HSK-T 63	75	42	53	45	125	4	DN.. 1506	515	515
HSK T100 DDJN R/L 15	HSK-T 100	85	45	88	55	125	4	DN.. 1506	715	715

 XPress type 70 950 ...	 Key D 80 950 ...	 Clamping screw 70 950 ...	 Solid Carbide Seat D 70 950 ...
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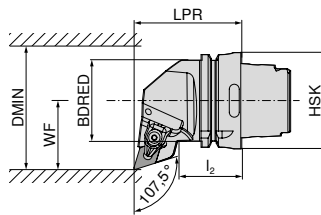
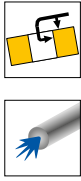
Spare parts for Article no.

74 512 515 / 74 511 515	824	T15 - IP	128	M4,5x12 - IP	820	811
74 512 715 / 74 511 715	824	T15 - IP	128	M4,5x12 - IP	820	811

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

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

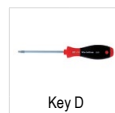


ISO designation	Adapter	LPR mm	l ₂ mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 508 ...	Right-hand 74 507 ...
HSK T63 DDHN R/L 15	HSK-T 63	70	42	53	45	125	4	DN.. 1506	515	515



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Solid Carbide Seat D

70 950 ...

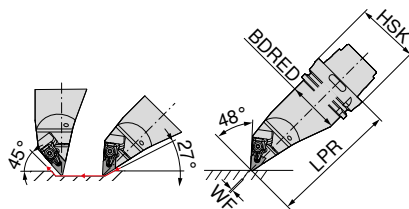
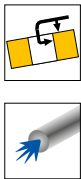
**Spare parts
for Article no.**

74 508 515 / 74 507 515	824	T15 - IP	128	M4,5x12 - IP	820	811
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MaxiLock-D – DDMN 48° – Toolholder with top clamping

Scope of supply:

Tool holder with Torx key



ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert	Left-hand 74 519 ...
HSK T63 DDMN L 15	HSK-T 63	130	53	0	4	DN.. 1506	515
HSK T100 DDMN L 15	HSK-T 100	160	88	0	4	DN.. 1506	715



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Solid Carbide Seat D

70 950 ...

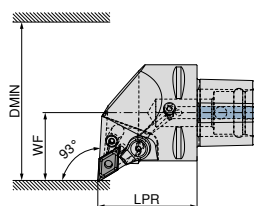
**Spare parts
for Article no.**

74 519 515	824	128	820	811
74 519 715	824	128	820	811

MaxiLock-N – PDUN 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	Left-hand	Right-hand
								84 661 ...	84 660 ...
PSC40 PDUN R/L 50050-15	PSC 40	50	27	50	5	DN.. 1504 / 1506	DC	01595	01595
PSC50 PDUN R/L 65060-15	PSC 50	60	35	65	5	DN.. 1504 / 1506	DC	01594	01594
PSC63 PDUN R/L 80065-15	PSC 63	65	45	80	5	DN.. 1504 / 1506	DC	01593	01593

Shim	Elbow lever screw	Lever	Solid Carbide Seat D
84 950 ...	84 950 ...	84 950 ...	84 950 ...
29200	28700	28900	27900

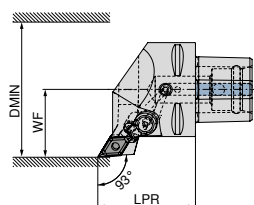
Spare parts

84 660 01593 / 84 661 01595

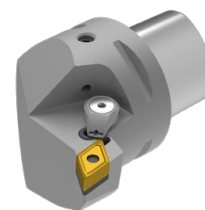
MaxiLock-N – PDJN 93° – Toolholder with lever clamping

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	Left-hand	Right-hand
								84 665 ...	84 664 ...
PSC40 PDJN R/L 50050-15	PSC 40	50	27	50	5	DN.. 1504 / 1506	DC	01595	01595
PSC50 PDJN R/L 65060-15	PSC 50	60	35	65	5	DN.. 1504 / 1506	DC	01594	01594
PSC63 PDJN R/L 80065-15	PSC 63	65	45	80	5	DN.. 1504 / 1506	DC	01593	01593

Shim	Elbow lever screw	Lever	Solid Carbide Seat D
84 950 ...	84 950 ...	84 950 ...	84 950 ...
29200	28700	28900	27900

Spare parts

Adapter

PSC 40
PSC 50
PSC 63

29200 M8X1/L17 SW3 28700 28900 27900
29200 M8X1/L17 SW3 28700 28900 27900
29200 M8X1/L17 SW3 28700 28900 27900



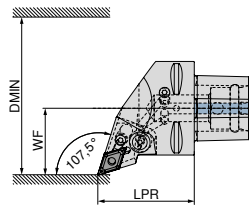
The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → Page 40.

When using DN1504.. inserts Shim item no. 84 950 28200

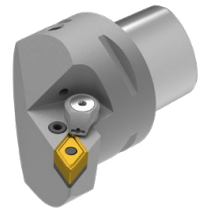
MaxiLock-N – PDHN 107,5° – Toolholder with lever clamping

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	Left-hand	Right-hand
								84 669 ...	84 668 ...
PSC40 PDHN R/L 50050-15	PSC 40	50	27	50	5	DN.. 1504 / 1506	DC	01595	01595
PSC50 PDHN R/L 65060-15	PSC 50	60	35	65	5	DN.. 1504 / 1506	DC	01594	01594
PSC63 PDHN R/L 80065-15	PSC 63	65	45	80	5	DN.. 1504 / 1506	DC	01593	01593

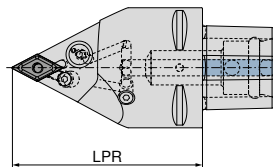
Shim	Elbow lever screw	Lever	Solid Carbide Seat D
84 950 ...	84 950 ...	84 950 ...	84 950 ...
84 668 01595 / 84 669 01595	29200	28700	28900
84 668 01594 / 84 669 01594	29200	28700	28900
84 668 01593 / 84 669 01593	29200	28700	28900

**Spare parts
for Article no.**

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

Scope of supply:


without high-performance coolant set



ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Direct cooling compatible	Neutral
						84 676 ...
PSC63 PDNN N 0100-15	PSC 63	100	5	DN.. 1504 / 1506	DC	01593
PSC63 PDNN N 0130-15	PSC 63	130	5	DN.. 1504 / 1506	DC	11593

Shim	Elbow lever screw	Lever	Solid Carbide Seat D
84 950 ...	84 950 ...	84 950 ...	84 950 ...
84 676 01593	29200	28700	28900
84 676 11593	29200	28700	28900

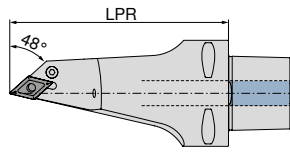
**Spare parts
for Article no.**

 The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra → **Page 40**.
When using DN1504.. inserts Shim item no. **84 950 28200**

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





Scope of supply:

without high-performance coolant set




Neutral
84 680 ...

ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Direct cooling compatible	
PSC63 PDMN L 0130-15	PSC 63	130	5	DN.. 1504 / 1506	DC	11593

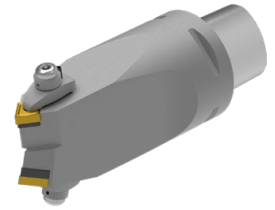
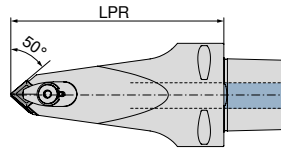
			
Shim	Elbow lever screw	Lever	Solid Carbide Seat D
84 950 ...	84 950 ...	84 950 ...	84 950 ...
29200	28700	28900	27900

Spare parts for Article no.

84 680 11593







 The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra → **Page 40**.
When using DN1504.. inserts Shim item no. **84 950 28200**

Toolholder DCMN – DDMN 50°/48°



Neutral
84 683 ...

ISO designation	Adapter	LPR mm	torque moment Nm	Insert	
PSC63 DCMN-DDMN L 0130-12/15	PSC 63	130	10	CN.. 1204 / DN.. 1506	01293

					
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 ...
28300	28500	28400	27500	27900	27800

Spare parts
for Article no.
84 683 01293

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



84 950 ...

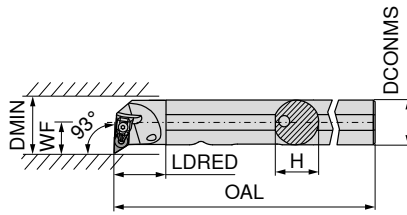
Coolant set

27400

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

Scope of supply:

Boring bar with Torx key



Illustrations show right-hand versions



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

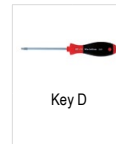
Left-hand 70 569 ...	Right-hand 70 568 ...
725	725
732	732
840	840

**Spare parts
for Article no.**

70 568 725 / 70 569 725	835	T09 - IP	126	M3x7 - IP	819	808
70 568 732 / 70 569 732	835	T09 - IP	126	M3x7 - IP	819	808
70 568 840 / 70 569 840	824	T15 - IP	128	M4,5x12 - IP	820	811



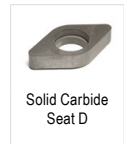
70 950 ...



80 950 ...



70 950 ...



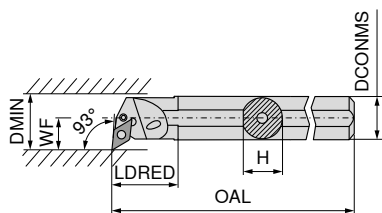
70 950 ...

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

▲ A... = with thro' coolant
▲ S... = without thro' coolant

Scope of supply:

Boring bar with Allen key



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 ...
A20Q PDUN R/L 11	20	18,5	180	36	16,0	28	3	DN.. 1104	12000 ¹⁾	12000 ¹⁾
A25R PDUN R/L 11	25	23,0	200	36	18,5	32	3	DN.. 1104	125	12500 ¹⁾
A32S PDUN R/L 11	32	30,0	250	36	22,0	40	3	DN.. 1104	13200 ¹⁾	132
A32S PDUN R/L 15	32	30,0	250	50	22,0	40	3,2	DN.. 1506	232	232
A40T PDUN R/L 15	40	38,0	300	60	27,0	50	3,2	DN.. 1506	240	240
S50W PDUN R/L 15	50	47,0	450	31	35,0	63	3,2	DN.. 1506	050	050

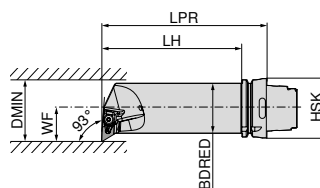
1) nickel-plated

Spare parts for Article no.	Key I	Shim	Assembly pin	Lever	Clamping screw	Solid Carbide Seat D
70 568 12000 / 70 569 12000		SW2,5	175		125	126
70 568 12500 / 70 569 125		SW2,5	175	122	121	208
70 568 132 / 70 569 13200		SW2,5	175	122	121	208
70 568 232 / 70 569 232		SW3	176	198	192	209
70 568 240 / 70 569 240		SW3	176	198	192	209
70 568 050 / 70 569 050		SW3	176	198	188	388

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

Scope of supply:

Boring bar with Torx key



Illustrations show right-hand versions

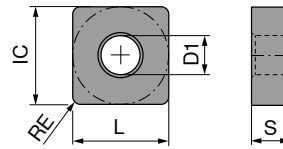


ISO designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand	Right-hand
									74 533 ...	74 532 ...
HSK T63 50Q DDUN R/L 15	HSK-T 63	175	149	50	35	63	4	DN.. 1506	515	515

Spare parts for Article no.	XPress type	Key D	Clamping screw	Solid Carbide Seat D		
					70 950 ...	80 950 ...
74 533 515 / 74 532 515	824	T15 - IP	128	M4,5x12 - IP	820	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

ISO	RE mm	NEW -F50		NEW -F50		NEW -F50		NEW -M50		NEW -M50		NEW -M50	
		CTCP115-P	CTCP125-P	CTCP135-P	CTCP115-P	CTCP125-P	CTCP135-P	CTCP115-P	CTCP125-P	CTCP135-P	CTCP115-P	CTCP125-P	CTCP135-P
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		F		F		F		M		M		M	
		SNMG		SNMG		SNMG		SNMG		SNMG		SNMG	
		76 140 ...		76 140 ...		76 140 ...		76 137 ...		76 137 ...		76 137 ...	
090308EN	0,8	30601	50601	70601									
120404EN	0,4	31601	51601	71601									
120408EN	0,8	31801	51801	71801			31801	51801	71801				
120412EN	1,2	32001	52001	72001			32001	52001	72001				
120416EN	1,6						32201	52201	72201				
150608EN	0,8						33001	53001	73001				
150612EN	1,2						33201	53201	73201				
150616EN	1,6						33401	53401	73401				
P		●	●	●	●	●	●	●	●	●	●	●	●
M													
K		○	○	○	○	○	○	○	○	○	○	○	○
N													
S													
H													
O													

9

SNMG / SNMA

		NEW		NEW		NEW		NEW			
		-M70	-M70	-M70	-M70	-M70	-M70	-M70	-M70	CTCK110	
		CTCK110	CTCP115-P	CTCP125-P	CTCP135-P	CTCP125-P	CTCP125-P	CTCK120	CTCK110		
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN		
		M	M	M	M	R	M	M	R		
		SNMG	SNMG	SNMG	SNMG	SNMG	SNMG	SNMG	SNMA		
		70 225 ...	76 225 ...	76 225 ...	76 225 ...	76 188 ...	70 225 ...	70 114 ...			
ISO	RE mm										
120408EN	0,8	018	31801	51801	71801		518	018			
120412EN	1,2	020	32001	52001	72001		520	020			
120416EN	1,6	022	32201	52201	72201		522	022			
150612EN	1,2	032	33201	53201	73201		532	032			
150616EN	1,6	034	33401	53401	73401		534	034			
190612EN	1,2	044	34401	54401	74401		544	044			
190616EN	1,6	046	34601	54601	74601		546	046			
190624EN	2,4		34801	54801	74801						
250924EN	2,4					57001					
P		○	●	●	●	●	○	○			
M					○						
K		●	○	○		○	●	●			
N											
S											
H											
O											

SNMA / SNMM

			NEW	NEW	NEW	NEW	NEW	NEW
		CTCK120	-R28 CTCP115-P	-R28 CTCP125-P	-R28 CTCP135-P	-R58 CTCP115-P	-R58 CTCP125-P	-R58 CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		R SNMA	R SNMM	R SNMM	R SNMM	R SNMM	R SNMM	R SNMM
		70 114 ...	76 128 ...	76 128 ...	76 128 ...	76 129 ...	76 129 ...	76 129 ...
ISO	RE mm							
120408EN	0,8	518						
120412EN	1,2	520						
120416EN	1,6	522						
150612EN	1,2	532	33201	53201	73201	33201	53201	73201
150616EN	1,6	534	33401	53401	73401	33401	53401	73401
190612EN	1,2	544				34401	54401	74401
190616EN	1,6	546	34601	54601	74601	34601	54601	74601
190624EN	2,4					34801	54801	74801
250724EN	2,4				76001	36001	56001	76001
250924EN	2,4		37001	57001	77001	37001	57001	77001
P		○	●	●	●	●	●	●
M					○			○
K		●	○	○		○	○	
N								
S								
H								
O								

9

SNMM

			NEW	NEW	NEW	NEW	NEW	NEW
			-R88 CTCP115-P	-R88 CTCP115-P	-R88 CTCP125-P	-R88 CTCP125-P	-R88 CTCP135-P	-R88 CTCP135-P
			DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
			R SNMM	R SNMM	R SNMM	R SNMM	R SNMM	R SNMM
			76 130 ...	76 325 ...	76 130 ...	76 326 ...	76 130 ...	76 327 ...
ISO	RE mm							
190616SN	1,6		34601		54601		74601	
190624SN	2,4		34801		54801		74801	
250724SN	2,4		36001		56001		76001	
250732SN	3,2			36101		56101		76101
250924SN	2,4		37001		57001		77001	
250932SN	3,2			37201		57201		77201
P			●	●	●	●	●	●
M							○	○
K			○	○	○	○		
N								
S								
H								
O								

SNMG

ISO	RE mm	-F30 CTCM120	-F30 CTPM125	-F30 CTCM130	-M30 CTCM120	-M30 CTPM125	-M30 CTPM125	-M30 CTCM130
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F SNMG	F SNMG	F SNMG	M SNMG	M SNMG	M SNMG	M SNMG
		75 016 ...	75 016 ...	75 016 ...	75 017 ...	75 017 ...	75 016 ...	75 017 ...
120404EN	0,4	11600	216	31600				
120408EN	0,8	11800	218	31800	11800	218		31800
120412EN	1,2				12000		220	32000
P		○	○	○	○	○	○	○
M		●	●	●	●	●	●	●
K								
N								
S				○				○
H								
O								

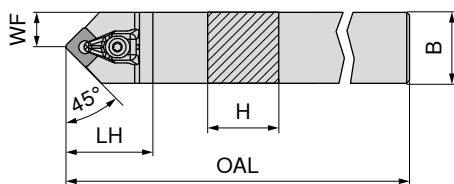
SNMG

ISO	RE mm	NEW -M42 CTCM130	-M60 CTCM120	-M60 CTPM125	-M60 CTCM130	NEW -M70 CTCM130	-M34 CTPX710
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M SNMG	M SNMG	M SNMG	M SNMG	M SNMG	M SNMG
		75 034 ...	75 018 ...	75 018 ...	75 018 ...	75 039 ...	75 005 ...
120408EN	0,8	31800	11800	218	31800	31800	61800
120412EN	1,2	32000	12000	210	32000	32000	62000
120416EN	1,6		12200	220	32200		
190616EN	1,6					34600	
P		○	○	○	○	○	●
M		●	●	●	●	●	●
K							
N							○
S			○			○	●
H							
O							

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

Scope of supply:

Tool holder with Torx key



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	620
DSDN N 2525 M12	25	25	150	38	12,5	4	SN.. 1204	625



XPRESS type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Solid Carbide support S

70 950 ...

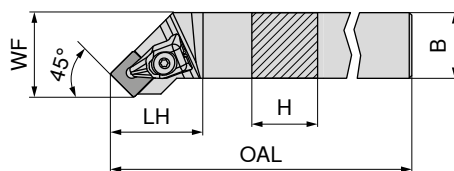
Spare parts for Article no.

70 516 620	824	T15 - IP	128	M4,5x12 - IP	820	813
70 516 625	824	T15 - IP	128	M4,5x12 - IP	820	813

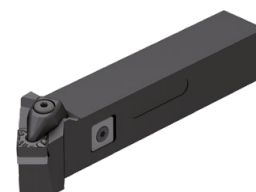
MaxiLock-D – DSSN 45° – Toolholder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Left-hand

Right-hand

70 513 ...

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	620	620
DSSN R/L 2525 M12	25	25	150	35	32	4	SN.. 1204	625	625
DSSN R/L 3225 P12	32	25	170	35	32	4	SN.. 1204	632	632



XPRESS type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Solid Carbide support S

70 950 ...

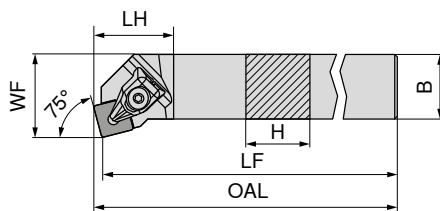
Spare parts for Article no.

70 512 620 / 70 513 620	824	T15 - IP	128	M4,5x12 - IP	820	813
70 512 625 / 70 513 625	824	T15 - IP	128	M4,5x12 - IP	820	813
70 512 632 / 70 513 632	824	T15 - IP	128	M4,5x12 - IP	820	813

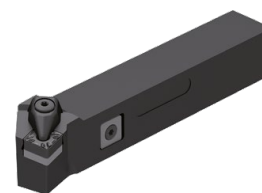
MaxiLock-D – DSKN 75° – Toolholder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Left-hand	Right-hand
70 525 ...	70 524 ...
625	625

ISO designation	H mm	B mm	OAL mm	LF mm	LH mm	WF mm	torque moment Nm	Insert
DSKN R/L 2525 M12	25	25	153,3	150	28	32	4	SN.. 1204

XPress type	Key D	Clamping screw	Solid Carbide support S
70 950 ...	80 950 ...	70 950 ...	70 950 ...
824	T15 - IP	128	M4,5x12 - IP
		820	813

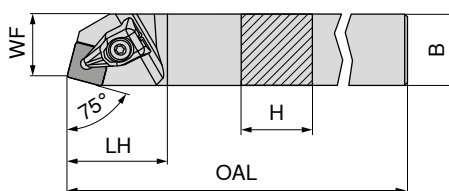
Spare parts for Article no.

70 525 625 / 70 524 625

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

Scope of supply:

Tool holder with Torx key



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
DSBN R 2020 K12	20	20	125	35	17	4	SN.. 1204
DSBN R 2525 M12	25	25	150	35	22	4	SN.. 1204
DSBN R 2525 M15	25	25	150	42	22	6,5	SN.. 1506
DSBN R 3232 P15	32	32	170	42	27	6,5	SN.. 1506
DSBN R 3232 P19	32	32	170	48	27	6,5	SN.. 1906
DSBN R 4040 S19	40	40	250	48	35	6,5	SN.. 1906
DSBN R 4040 S25	40	40	250	57	35	6,5	SN.. 2507 / SN.. 2509

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 ...
824	T15 - IP	128	M4,5x12 - IP
		820	813
		820	813
		821	833
		821	833
		821	817
		821	817
		822	818

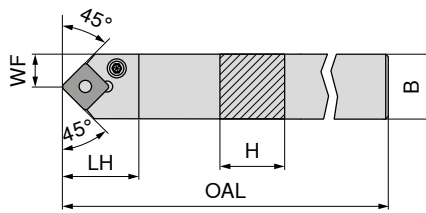
Spare parts for Article no.

70 520 620
70 520 625
70 520 725
70 520 832
70 520 732
70 520 840
70 520 940

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

Scope of supply:

Tool holder with allen key



Neutral
70 516 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	
PSDN N 2020 K12	20	20	125	27,6	10,3	4	SNM. 1204	020
PSDN N 2525 M12	25	25	150	27,6	12,8	4	SNM. 1204	025
PSDN N 3225 P19	32	25	170	40,4	12,5	8	SNM. 1906	03200
PSDN N 4040 S25	40	40	250	48,8	20,0	8	SNM. 2507 / 2509	04000

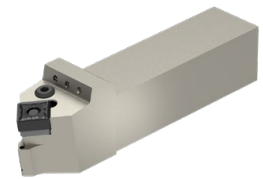
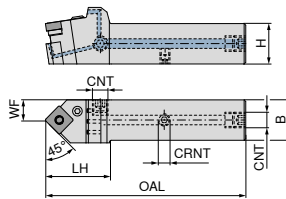
When using SN.. 2509 indexable inserts, use insert seat article no. 70 950 40200.

Spare parts for Article no.	Key I	Shim	Assembly pin	Lever	Clamping screw	Solid Carbide support S	70 950 ...						
							176	198	192	187	209	230	
70 516 020	SW3						176	198	192	187	209	230	
70 516 025	SW3						176	198	192	187	209	230	
70 516 03200	SW4						396	392	395	386	389	383	
70 516 04000	SW5						265	621	623	620	622	27600	

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

Scope of supply:

Tool holder with allen key



NEW
Neutral
70 596 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	
PSDN N 2020 X12-T DC	20	20	109	40	11,5	M6	G1/8"	4	SNM. 1204	02000
PSDN N 2525 X12-T DC	25	25	124	40	13,3	M6	G1/8"	4	SNM. 1204	02500
PSDN N 2525 X15-T DC	25	25	134	50	13,7	M6	G1/8"	4	SNM. 1506	12500
PSDN N 3225 X15-T DC	32	25	150	50	13,7	M6	G1/8"	4	SNM. 1506	03200
PSDN N 3225 X19-T DC	32	25	152	52	13,7	M6	G1/8"	8	SNM. 1906	13200
PSDN N 4040 X25-T DC	40	40	190	65	22,4	M6	G1/8"	8	SNM. 2507 / 2509	04000

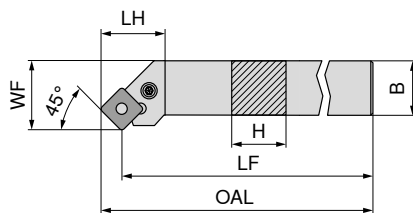
When using SN.. 2509 indexable inserts, use insert seat article no. 70 950 40200.

Spare parts for Article no.									
	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	
70 596 02000		176	198	192	294	187	209	230	86700
70 596 02500		176	198	192	294	187	209	230	86700
70 596 12500		176	391	394	294	385	388	382	86700
70 596 03200		176	391	394	294	385	388	382	86700
70 596 13200		396	392	395	294	386	389	383	86700
70 596 04000		265	621	623	294	620	622	27600	86700

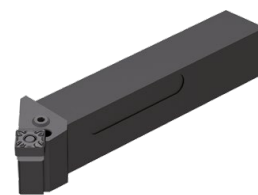
MaxiLock-N – PSSN 45° – Toolholder with lever clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions

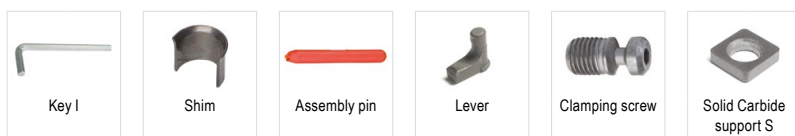


Left-hand	Right-hand
70 513 ...	70 512 ...
016	01600 ¹⁾
020	020
025	025
032	032
	125
	132
	232
232	
	04000

ISO designation	H mm	B mm	OAL mm	LF mm	LH mm	WF mm	torque moment Nm	Insert
PSSN R/L 1616 H09	16	16	106,7	100	23,6	20	3	SNM. 0903
PSSN R/L 2020 K12	20	20	134,0	125	27,3	25	4	SNM. 1204
PSSN R/L 2525 M12	25	25	159,0	150	29,3	32	4	SNM. 1204
PSSN R/L 3225 P12	32	25	179,0	170	29,3	32	4	SNM. 1204
PSSN R 2525 M15	25	25	161,2	150	32,5	32	4	SNM. 1506
PSSN R 3232 P15	32	32	181,2	170	38,9	40	4	SNM. 1506
PSSN R 3232 P19	32	32	183,5	170	41,2	40	8	SNM. 1906
PSSN L 3232 P19	32	32	183,5	170	40,2	40	8	SNM. 1906
PSSN R 4040 S25	40	40	268,0	250	50,8	50	8	SNM. 2507 / 2509

1) nickel-plated

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

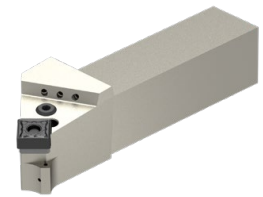
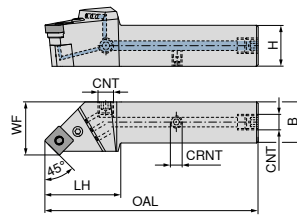


Spare parts for Article no.	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 512 01600 / 70 513 016	SW2,5	175	197	191	185	229
70 512 020 / 70 513 020	SW3	176	198	192	187	230
70 512 025 / 70 513 025	SW3	176	198	192	187	230
70 512 032 / 70 513 032	SW3	176	198	192	187	230
70 512 125	SW3	176	391	394	385	382
70 512 132	SW3	176	391	394	385	382
70 512 232	SW4	396	392	395	386	383
70 513 232	SW4	396	392	395	386	383
70 512 04000	SW5	265	621	623	620	27600

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

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions

	NEW	NEW
	Left-hand	Right-hand
	70 597 ...	70 597 ...
PSSN R/L 2020 X12-T DC	02000	02001
PSSN R/L 2525 X12-T DC	02500	02501
PSSN R/L 3225 X12-T DC	03200	03201
PSSN R 2525 X15-T DC		12501
PSSN R 3232 X15-T DC		13201
PSSN R/L 3232 X19-T DC	13200	23201
PSSN R 4040 X25-T DC		04001

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert
PSSN R/L 2020 X12-T DC	20	20	111,9	42,9	25	M6	G1/8"	4	SNM. 1204
PSSN R/L 2525 X12-T DC	25	25	129,9	45,9	32	M6	G1/8"	4	SNM. 1204
PSSN R/L 3225 X12-T DC	32	25	145,9	45,9	32	M6	G1/8"	4	SNM. 1204
PSSN R 2525 X15-T DC	25	25	131,5	47,5	32	M6	G1/8"	4	SNM. 1506
PSSN R 3232 X15-T DC	32	32	145,9	45,9	40	M6	G1/8"	4	SNM. 1506
PSSN R/L 3232 X19-T DC	32	32	151,8	51,8	40	M6	G1/8"	8	SNM. 1906
PSSN R 4040 X25-T DC	40	40	189,6	64,6	50	M6	G1/8"	8	SNM. 2507 / 2509

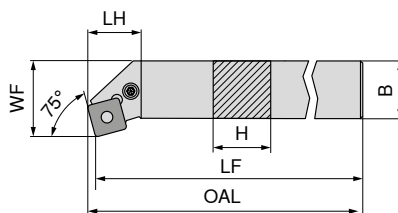
When using SN.. 2509 indexable inserts, use insert seat article no. 70 950 40200.

Spare parts for Article no.	Key I	Shim	Assembly pin	Coolant screw plug	Lever	Clamping screw	Solid Carbide support S	Grubscrew
	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 597 02001 / 70 597 02000	176	198	192	294	187	209	230	86700
70 597 02501 / 70 597 02500	176	198	192	294	187	209	230	86700
70 597 03201 / 70 597 03200	176	198	192	294	187	209	230	86700
70 597 12501	176	391	394	294	385	388	382	86700
70 597 13201	176	391	394	294	385	388	382	86700
70 597 23201 / 70 597 13200	396	392	395	294	386	389	383	86700
70 597 04001	265	621	623	294	620	622	27600	86700

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

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left-hand	Right-hand
70 525 ...	70 524 ...
016	016
020	020
025	025
03200	03200
	04000

ISO designation	H mm	LF mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert
PSKN R/L 1616 H09	16	100	16	102,5	18,7	20	3	SNM. 0903
PSKN R/L 2020 K12	20	125	20	128,3	24,1	25	4	SNM. 1204
PSKN R/L 2525 M12	25	150	25	153,3	24,1	32	4	SNM. 1204
PSKN R/L 3225 P12	32	170	25	173,1	24,1	32	4	SNM. 1204
PSKN R 4040 S19	40	250	40	254,6	38,3	50	8	SNM. 1906

Key I	Shim	Assembly pin	Lever	Clamping screw	Solid Carbide support S
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...

Spare parts

for Article no.

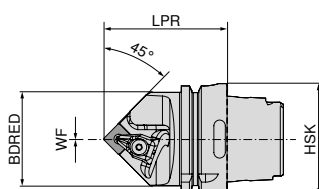
70 524 016 / 70 525 016	SW2,5	175	197	191	185	208	229
70 524 020 / 70 525 020	SW3	176	198	192	187	209	230
70 524 025 / 70 525 025	SW3	176	198	192	187	209	230
70 524 03200 / 70 525 03200	SW3	176	198	192	187	209	230
70 524 04000	SW4	396	392	395	386	389	383

9

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

Scope of supply:

Tool holder with Torx key



Neutral
74 522 ...

ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert	
HSK T63 DSDN N 12	HSK-T 63	70	53	0	4	SN.. 1204	512
HSK T63 DSDN N 15	HSK-T 63	75	53	0	4	SN.. 1506	515
HSK T100 DSDN N 12	HSK-T 100	80	88	0	4	SN.. 1204	712
HSK T100 DSDN N 19	HSK-T 100	85	88	0	8	SN.. 1906	719

XPress type	Key D	Clamping screw	Solid Carbide support S
70 950 ...	80 950 ...	70 950 ...	70 950 ...

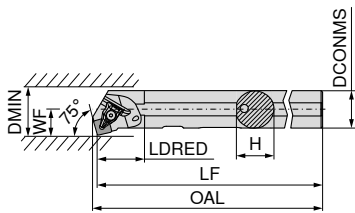
Spare parts
for Article no.

74 522 512	824	T15 - IP	128	M4,5x12 - IP	820	813
74 522 515	825	T20 - IP	129	M5x14 - IP	821	833
74 522 712	824	T15 - IP	128	M4,5x12 - IP	820	813
74 522 719	826	T20 - IP	129	M5x14 - IP	821	817

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

Scope of supply:

Boring bar with Torx key



Illustrations show right-hand versions

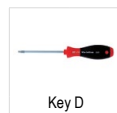


ISO designation	DCONMS mm	H mm	LF mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 561 ...	Right-hand 70 560 ...
A32S DSKN R/L 12	32	31	250	254,2	40	22	40	4	SN.. 1204	832	832



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Solid Carbide support S

70 950 ...

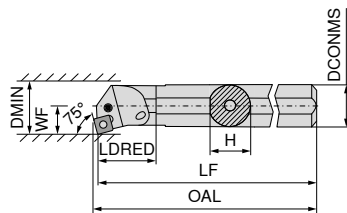
**Spare parts
for Article no.**

70 560 832 / 70 561 832	824	T15 - IP	128	M4,5x12 - IP	820	813
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MaxiLock-N – PSKN 75° – Boring bar with lever clamping

Scope of supply:

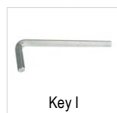
Boring bar with Allen key



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 70 561 ...	Right-hand 70 560 ...
A25R PSKN R/L 12	25	23	200	203	36	17	32	4	SNM. 1204	225	225
A32S PSKN R/L 12	32	30	250	253	50	22	40	4	SNM. 1204	232	232
A40T PSKN R/L 12	40	38	300	303	60	27	50	4	SNM. 1204	240	240



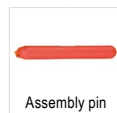
Key I

70 950 ...



Shim

70 950 ...



Assembly pin

70 950 ...



Lever

70 950 ...



Clamping screw

70 950 ...



Solid Carbide support S

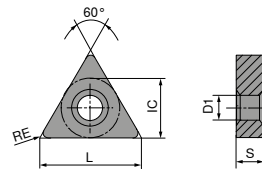
70 950 ...

**Spare parts
for Article no.**

70 561 225 / 70 560 225	SW3	176	198	192	187	205	230
70 561 232 / 70 560 232	SW3	176	198	192	187	205	230
70 561 240 / 70 560 240	SW3	176	198	192	187	209	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

		NEW		NEW		NEW		NEW		NEW	
		-CF20 CTEP110	-F50 CTCP115-P	-F50 CTCP125-P	-F50 CTCP135-P	-M50 CTCP115-P	-M50 CTCP125-P	-M50 CTCP135-P			
		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										
110304EN	0,4			30401	50401	70401					
110308EN	0,8			30601	50601	70601					
160404EN	0,4	016	31601	51601	71601	31601	51601	71601			
160408EN	0,8	018	31801	51801	71801	31801	51801	71801			
160412EN	1,2	020	32001	52001	72001	32001	52001	72001			
220408EN	0,8					33001	53001	73001			
220412EN	1,2					33201	53201	73201			
P		●	●	●	●	●	●	●			
M		○			○			○			
K		○	○	○		○	○				
N		[Green bar]									
S		[Orange bar]									
H		[Grey bar]									
O		[Dark Grey bar]									

9

TNMG

				NEW		NEW		NEW		NEW	
		-M70 CTCK110	-M70 CTCK120	-M70 CTCP115-P	-M70 CTCP125-P	-M70 CTCP135-P	CTCP125-P	CTCP135-P	CTCP125-P	CTCP135-P	CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M TNMG	M TNMG	M TNMG	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 ...	76 142 ...	76 142 ...	76 142 ...
ISO	RE mm										
160404ER	0,4										
160408EL	0,8										
160408EN	0,8	018	518	31801	51801	71801		51601		71601	
160408ER	0,8							51801			
160412EN	1,2	020	520	32001	52001	72001		51701		71801	
220404EN	0,4										
220408EN	0,8	030	530	33001	53001	73001					
220412EN	1,2	032	532	33201	53201	73201					
220416EN	1,6	034	534	33401	53401	73401					
P		○	○	●	●	●	●	●	●	●	●
M						○				○	
K		●	●	○	○			○			
N											
S											
H											
O											

TNMA / TNMM

				NEW		NEW		NEW		NEW	
		CTCK110	CTCK120	-R28 CTCP115-P	-R28 CTCP125-P	-R28 CTCP135-P	-R58 CTCP115-P	-R58 CTCP125-P	-R58 CTCP115-P	-R58 CTCP125-P	-R58 CTCP125-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		R TNMA	M TNMA	R TNMM	R TNMM	R TNMM	R TNMM	R TNMM	R TNMM	R TNMM	R TNMM
		70 134 ...	70 134 ...	76 154 ...	76 154 ...	76 154 ...	76 152 ...	76 152 ...	76 152 ...	76 152 ...	76 152 ...
ISO	RE mm										
160408EN	0,8	018	518								
160412EN	1,2	020	520								
160416EN	1,6	022	522								
220408EN	0,8	030	530								
220412EN	1,2	032	532								
220416EN	1,6	034	534	33401	53401	73401		33201		53201	
P		○	○	●	●	●	●	●	●	●	●
M						○				○	
K		●	●	○	○			○			○
N											
S											
H											
O											

TNMM / TNMG

		NEW						
		-R58 CTCP135-P	-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							
160404EN	0,4		11600	216	31600			
160408EN	0,8		11800	218	31800	11800	218	31800
160412EN	1,2					12000	220	32000
220412EN	1,2	73201						
P		●	○	○	○	○	○	○
M		○	●	●	●	●	●	●
K								
N								
S					○			○
H								
O								

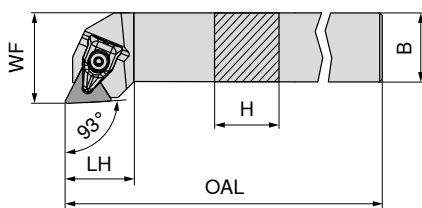
TNMG

		NEW				NEW	
		-M42 CTCM130	-M60 CTCM120	-M60 CTPM125	-M60 CTCM130	-M70 CTCM130	-M34 CTPX710
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M TNMG	M TNMG	M TNMG	M TNMG	M TNMG	M TNMG
		75 035 ...	75 021 ...	75 021 ...	75 021 ...	75 040 ...	75 006 ...
ISO	RE mm						
160404EN	0,4		31600				
160408EN	0,8		31800	11800	218	31800	61800
160412EN	1,2			12000	220	32000	
220404EN	0,4						62800
220408EN	0,8						63000
220412EN	1,2					33200	
220416EN	1,6						63400
P			○	○	○	○	●
M		●	●	●	●	●	●
K							
N							○
S			○			○	●
H							
O							

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

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



	Left-hand	Right-hand
70 591 ...		70 590 ...
	820	820
	825	825

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert
DTJN R/L 2020 K16	20	20	125	23	25	2	TNM. 1604
DTJN R/L 2525 M16	25	25	150	24	32	2	TNM. 1604



XPRESS type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Solid Carbide Seat T

70 950 ...

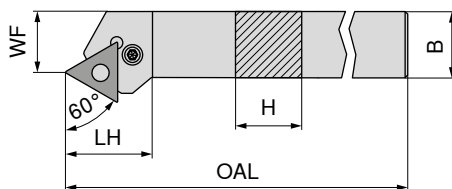
Spare parts for Article no.

70 590 820 / 70 591 820	823	T09 - IP	126	M3x7 - IP	819	847
70 590 825 / 70 591 825	823	T09 - IP	126	M3x7 - IP	819	847

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

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



	Left-hand	Right-hand
70 529 ...		70 528 ...
	020	020
	025	025

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert
PTTN R/L 2020 K16	20	20	125	25,9	17	3	TNM. 1604
PTTN R/L 2525 M22	25	25	150	32,7	22	4	TNM. 2204



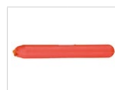
Key I

70 950 ...



Shim

70 950 ...



Assembly pin

70 950 ...



Lever

70 950 ...



Clamping screw

70 950 ...



Solid Carbide Seat T

70 950 ...

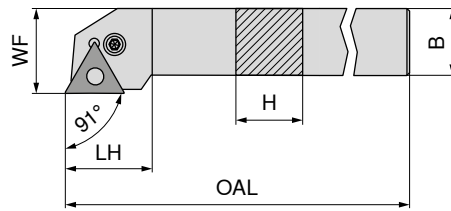
Spare parts for Article no.

70 529 020 / 70 528 020	175	SW2,5	191	185	208	225
70 529 025 / 70 528 025	176	SW3	198	187	209	226

MaxiLock-N – PTGN 91° – Toolholder with lever clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



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

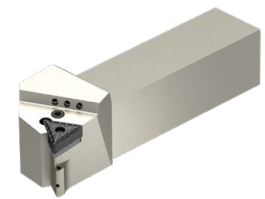
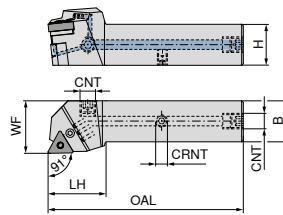
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert
PTGN R/L 1616 H16	16	16	100	20	20	3	TNM. 1604
PTGN R/L 2020 K16	20	20	125	20	25	3	TNM. 1604
PTGN R/L 2525 M16	25	25	150	22	32	3	TNM. 1604
PTGN R/L 3225 P16	32	25	170	22	32	3	TNM. 1604
PTGN R/L 2525 M22	25	25	150	29	32	4	TNM. 2204
PTGN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

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 ...		
70 532 016 / 70 533 016		SW2,5	175	197	191	185	208	225
70 532 020 / 70 533 020		SW2,5	175	197	191	185	208	225
70 532 025 / 70 533 025		SW2,5	175	197	191	185	208	225
70 532 032 / 70 533 032		SW2,5	175	197	191	185	208	225
70 532 125 / 70 533 125		SW3	176	198	192	187	209	226
70 532 132 / 70 533 132		SW3	176	198	192	187	209	226

MaxiLock-N – PTGN 91° DC – Toolholder with lever clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions

NEW Left-hand **70 598 ...**
NEW Right-hand **70 598 ...**

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	70 598 ...	70 598 ...
PTGN R/L 2020 X16-T DC	20	20	101	32	25	M6	G1/8"	3	TNM. 1604	02000	02001
PTGN R/L 2525 X16-T DC	25	25	119	35	32	M6	G1/8"	3	TNM. 1604	02500	02501
PTGN R/L 3225 X16-T DC	32	25	136	36	32	M6	G1/8"	3	TNM. 1604	03200	03201
PTGN R/L 2525 X22-T DC	25	25	122	38	32	M6	G1/8"	4	TNM. 2204	12500	12501
PTGN R/L 3232 X22-T DC	32	32	138	38	40	M6	G1/8"	4	TNM. 2204	13200	13201

Key I	Shim	Assembly pin	Coolant screw plug	Lever	Clamping screw	Solid Carbide Seat T	Grubscrew
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...

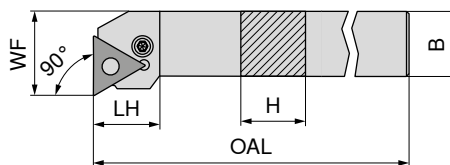
Spare parts for Article no.

70 598 02001 / 70 598 02000	175	197	192	294	185	208	225	86700
70 598 02501	175	197	192	294	185	208	225	86700
70 598 02500	175	197	191	294	185	208	225	86700
70 598 03201 / 70 598 03200	175	197	192	294	185	208	225	86700
70 598 12501 / 70 598 12500	176	198	192	294	187	209	226	86700
70 598 13201 / 70 598 13200	176	198	192	294	187	209	226	86700

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

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions

Left-hand **70 535 ...**
Right-hand **70 534 ...**

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	70 535 ...	70 534 ...
PTFN R/L 1616 H16	16	16	100	19,7	20	3	TNM. 1604	016	016
PTFN R/L 2020 K16	20	20	125	20,2	25	3	TNM. 1604	020	020
PTFN R/L 2525 M16	25	25	150	20,2	32	3	TNM. 1604	025	025
PTFN R/L 2525 M22	25	25	150	25,2	32	4	TNM. 2204	125	125
PTFN R/L 3225 P22	32	25	170	25,2	32	4	TNM. 2204	132	132

Key I	Shim	Assembly pin	Lever	Clamping screw	Solid Carbide Seat T
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...

Spare parts for Article no.

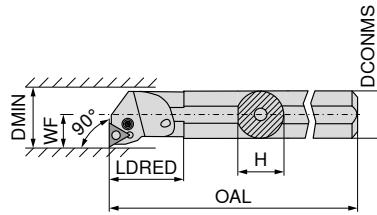
70 534 016 / 70 535 016	SW2,5	175	197	191	185	208	225
70 534 020 / 70 535 020	SW2,5	175	197	191	185	208	225
70 534 025 / 70 535 025	SW2,5	175	197	191	185	208	225
70 534 125 / 70 535 125	SW3	176	198	192	187	209	226
70 534 132 / 70 535 132	SW3	176	198	192	187	209	226

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

- ▲ A... = with thro' coolant
- ▲ S... = without thro' coolant

Scope of supply:

Boring bar with Allen key



Illustrations show right-hand versions



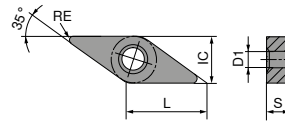
ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									70 565 ...		70 564 ...	
S25T PTFN R 16	25	23	300	36	17	32	3	TNM. 1604				02500
A25R PTFN R/L 16	25	23	200	36	17	32	3	TNM. 1604	225			225
A32S PTFN R/L 16	32	30	250	50	22	40	3	TNM. 1604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

**Spare parts
for Article 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 ...
70 564 02500	175	197	191	185	208	225
70 564 225 / 70 565 225	175	197	191	185	208	225
70 564 232 / 70 565 232	175	197	191	185	208	225
70 564 240 / 70 565 240	176	198	192	187	209	226
70 564 050	176	198	192	187	209	226

VNMG

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



VNMG

ISO	RE mm	NEW -F40 CTCP125-P DRAGONSKIN	NEW -F50 CTCP115-P DRAGONSKIN	NEW -F50 CTCP125-P DRAGONSKIN	NEW -F50 CTCP135-P DRAGONSKIN	NEW -XU CTCP115-P DRAGONSKIN	NEW -XU CTCP125-P DRAGONSKIN	NEW -M40 CTCP125-P DRAGONSKIN
		F VNMG 76 000 ...	F VNMG 76 156 ...	F VNMG 76 156 ...	F VNMG 76 156 ...	M VNMG 76 294 ...	M VNMG 76 294 ...	M VNMG 76 001 ...
160404EN	0,4	51601	31601	51601	71601	31601	51601	51601
160408EN	0,8	51801	31801	51801	71801	31801	51801	51801
P		●	●	●	●	●	●	●
M					○			
K		○	○	○		○	○	○
N								
S								
H								
O								

VNMG

ISO	RE mm	NEW -M50 CTCK110 DRAGONSKIN	NEW -M50 CTCK120 DRAGONSKIN	NEW -M50 CTCP115-P DRAGONSKIN	NEW -M50 CTCP125-P DRAGONSKIN	-F30 CTCM120 DRAGONSKIN	-F30 CTPM125 DRAGONSKIN	-F30 CTCM130 DRAGONSKIN
		M VNMG 70 190 ...	M VNMG 70 131 ...	M VNMG 76 131 ...	M VNMG 76 131 ...	F VNMG 75 022 ...	F VNMG 75 022 ...	F VNMG 75 022 ...
160404EN	0,4			31601	51601	11600	216	31600
160408EN	0,8		518	31801	51801	11800	218	31800
160412EN	1,2	01200	520	32001	52001			
P		○	○	●	●	○	○	○
M						●	●	●
K		●	●	○	○			
N								
S								○
H								
O								

VNMG

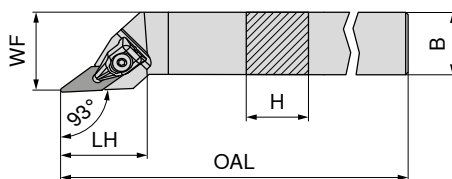
-M30 CTCM120	-M30 CTPM125	-M30 CTCM130	-M34 CTPX710
DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
M VNMG	M VNMG	M VNMG	M VNMG
75 023 ...	75 023 ...	75 023 ...	75 009 ...
11800	218	31800	61600 61800 62000

ISO	RE mm				
160404EN	0,4				
160408EN	0,8				
160412EN	1,2				
P			○	○	○
M		●	●	●	●
K					
N					○
S				○	●
H					
O					

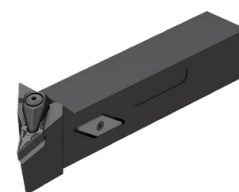
MaxiLock-D – DVJN 93° – Toolholder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Left-hand **70 503 ...** Right-hand **70 502 ...**

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand	Right-hand
DVJN R/L 2020 K16	20	20	125	39	25	2	VN.. 1604	620	620
DVJN R/L 2525 M16	25	25	150	39	32	2	VN.. 1604	725	725

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

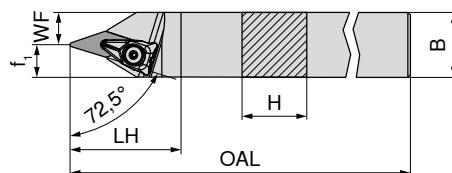
Spare parts for Article no.

70 502 620 / 70 503 620	835	T09 - IP	126	M3x7 - IP	819	806
70 502 725 / 70 503 725	835	T09 - IP	126	M3x7 - IP	819	806

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

Scope of supply:

Tool holder with Torx key



Neutral **70 506 ...**

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	f ₁ mm	torque moment Nm	Insert	Neutral
DVVN N 2020 K16	20	20	125	43	7,5	12,5	2	VN.. 1604	620
DVVN N 2525 M16	25	25	150	43	12,5	12,5	2	VN.. 1604	625

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

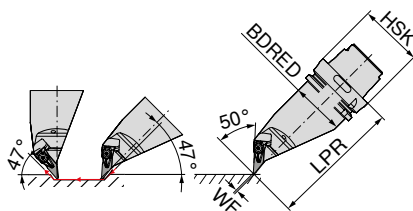
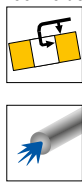
Spare parts for Article no.

70 506 620	835	T09 - IP	126	M3x7 - IP	819	806
70 506 625	835	T09 - IP	126	M3x7 - IP	819	806

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

Scope of supply:

Tool holder with Torx key

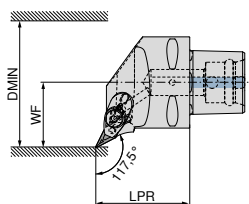
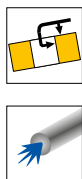


Left-hand
74 525 ...

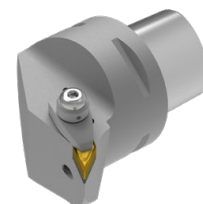
ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert	
HSK T63 DVMN L 16	HSK-T 63	130	53	0	2	VN.. 1604	516
HSK T100 DVMN L 16	HSK-T 100	160	88	0	2	VN.. 1604	716

Spare parts for Article no.	XPress type 70 950 ...	Key D 80 950 ...	Clamping screw 70 950 ...	Solid Carbide Seat V 70 950 ...		
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

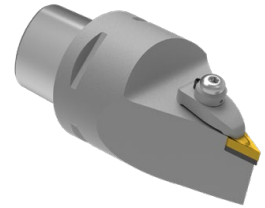
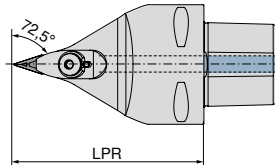


Left-hand **84 673 ...** Right-hand **84 672 ...**

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






Spare parts for Article no.	Clamping Screw 84 950 ...	Clamping claw 84 950 ...	Ring-shaped nozzle 84 950 ...	Clamping screw 84 950 ...	Solid Carbide Seat V 84 950 ...	
84 672 01695 / 84 673 01695	M6X28 SW4	28300	28500	28400	27600	28000
84 672 01694 / 84 673 01694	M6X28 SW4	28300	28500	28400	27600	28000
84 672 01693 / 84 673 01693	M6X28 SW4	28300	28500	28400	27600	28000

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



Neutral
84 679 ...

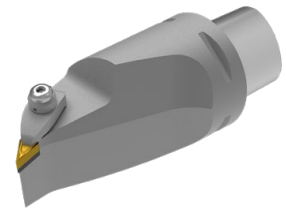
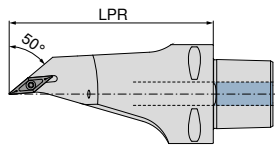
ISO designation	Adapter	LPR mm	torque moment Nm	Insert	
PSC63 DVVN N 0100-16	PSC 63	100	10	VN.. 1604	01693
PSC63 DVVN N 0130-16	PSC 63	130	10	VN.. 1604	11693

				
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 for Article no.






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

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



Neutral
84 682 ...

ISO designation	Adapter	LPR mm	torque moment Nm	Insert	
PSC63 DVMN L 0130-16	PSC 63	130	10	VN.. 1604	01693

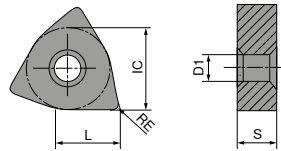
				
Clamping Screw	Clamping claw	Ring-shaped nozzle	Clamping screw	Solid Carbide Seat V
84 950 ...	84 950 ...	84 950 ...	84 950 ...	84 950 ...

Spare parts for Article no.

84 682 01693	M6X28 SW4	28300	28600	28400	27600	28000
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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

		NEW		NEW		NEW		NEW		NEW	
		-CF20 CTEP110	-TFQ CTEP110	-F50 CTCP115-P	-F50 CTCP125-P	-F50 CTCP135-P	-TFQ CTCP115-P	-TFQ CTCP125-P			
		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 ...			
ISO	RE mm										
060404EN	0,4	004		30401	50401	70401	30401	51401			
060408EN	0,8	006	006	30601	50601	70601	30601	50601			
080404EN	0,4		016	31601	51601	71601					
080408EN	0,8	018	018	31801	51801	71801	31801	51801			
080412EN	1,2			32001	52001	72001	32001	52001			
P		●	●	●	●	●	●	●			
M		○	○			○					
K		○	○	○	○		○	○			
N											
S											
H											
O											

WNMG

		NEW		NEW		NEW		NEW		NEW	
		-XU	-XU	-M50	-M50	-M50	-M50	-M50	-M50	-M50	-M50
		CTCP115-P	CTCP125-P	CTCK110	CTCK120	CTCP115-P	CTCP125-P	CTCP115-P	CTCP125-P	CTCP115-P	CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M	M	M	M	M	M	M	M	M	M
		WNMG	WNMG	WNMG	WNMG	WNMG	WNMG	WNMG	WNMG	WNMG	WNMG
		76 295 ...	76 295 ...	70 139 ...	70 139 ...	76 139 ...	76 139 ...	76 139 ...	76 139 ...	76 139 ...	76 139 ...
ISO	RE mm										
060404EN	0,4					30401		50401			70401
060408EN	0,8					30601		50601			70601
060412EN	1,2					30801		50801			70801
080404EN	0,4	31601	51601			31601		51601			71601
080408EN	0,8	31801	51801	018	518	31801		51801			71801
080412EN	1,2	32001	52001	020	520	32001		52001			72001
080416EN	1,6					32201		52201			72201
P		●	●	○	○	●	●	●	●	●	●
M											○
K		○	○	●	●	○	○	○	○	○	○
N											
S											
H											
O											

WNMG

		NEW		NEW		NEW		NEW		NEW	
		-TMQ	-TMQ	-M70	-M70	-M70	-M70	-M70	-M70	-M70	-M70
		CTCP115-P	CTCP125-P	CTCK110	CTCK120	CTCP115-P	CTCP125-P	CTCP115-P	CTCP125-P	CTCP115-P	CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M	M	M	M	M	M	M	M	M	M
		WNMG	WNMG	WNMG	WNMG	WNMG	WNMG	WNMG	WNMG	WNMG	WNMG
		76 198 ...	76 198 ...	70 273 ...	70 273 ...	76 273 ...	76 273 ...	76 273 ...	76 273 ...	76 273 ...	76 273 ...
ISO	RE mm										
060408EN	0,8					30601		50601			70601
060412EN	1,2					30801		50801			70801
080408EN	0,8	31801	51801	018	518	31801		51801			71801
080412EN	1,2	32001	52001	020	520	32001		52001			72001
080416EN	1,6			022	522	32201		52201			72201
P		●	●	○	○	●	●	●	●	●	●
M											○
K		○	○	●	●	○	○	○	○	○	○
N											
S											
H											
O											

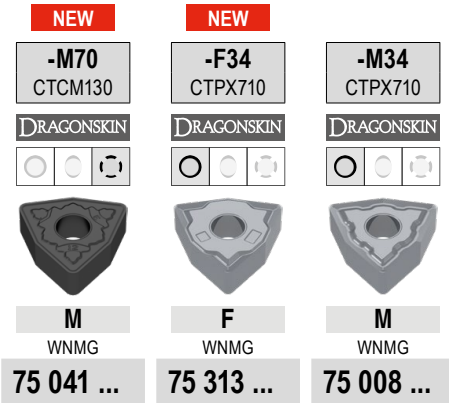
WNMA / WNMG

ISO	RE mm	CTCK110 DRAGONSKIN	CTCK120 DRAGONSKIN	-F30 CTCM120 DRAGONSKIN	-F30 CTPM125 DRAGONSKIN	-F30 CTCM130 DRAGONSKIN
060404EN	0,4	70 169 ...	70 169 ...	75 024 ...	75 024 ...	75 024 ...
060408EN	0,8			10400	204	30400
080404EN	0,4			10600	206	30600
080408EN	0,8	018	518	11600	216	31600
080412EN	1,2	020	520	11800	218	31800
080416EN	1,6	022	522			
P		○	○	○	○	○
M				●	●	●
K		●	●			
N						
S						○
H						
O						

WNMG

ISO	RE mm	-M30 CTCM120 DRAGONSKIN	-M30 CTPM125 DRAGONSKIN	-M30 CTCM130 DRAGONSKIN	NEW -M42 CTCM130 DRAGONSKIN	-M60 CTCM120 DRAGONSKIN	-M60 CTPM125 DRAGONSKIN	-M60 CTCM130 DRAGONSKIN
060404EN	0,4	75 025 ...	75 025 ...	75 025 ...	75 036 ...	75 026 ...	75 026 ...	75 026 ...
060408EN	0,8	10600	206	30600	30400	10600	206	30600
060412EN	1,2	10800	208	30800	30600	10800	208	30800
080404EN	0,4				31600			
080408EN	0,8	11800	218	31800	31800	11800	218	31800
080412EN	1,2	12000	220	32000	32000	12000	220	32000
P		○	○	○	○	○	○	○
M		●	●	●	●	●	●	●
K								
N								
S				○	○			○
H								
O								

WNMG

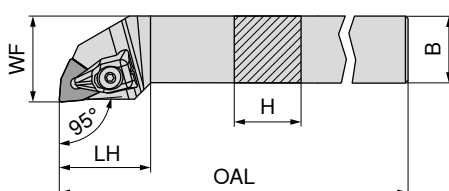


ISO	RE mm	75 041 ...	75 313 ...	75 008 ...
060408EN	0,8	30600		
080408EN	0,8	31800	61800	61800
080412EN	1,2	32000		62000
P		○	●	●
M		●	●	●
K				
N			○	○
S		○	●	●
H				
O				

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

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



	Left-hand 70 543 ...	Right-hand 70 542 ...
	716	716
	720	720
	725	725
	620	620
	625	625

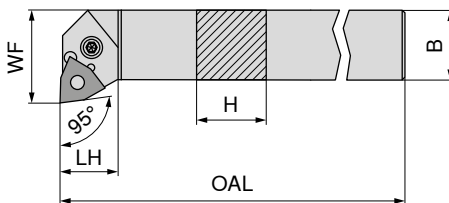
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert		
DWLN R/L 1616 H06	16	16	100	25	20	2	WN.. 0604		
DWLN R/L 2020 K06	20	20	125	27	25	2	WN.. 0604		
DWLN R/L 2525 M06	25	25	150	27	32	2	WN.. 0604		
DWLN R/L 2020 K08	20	20	125	34	25	4	WN.. 0804		
DWLN R/L 2525 M08	25	25	150	34	32	4	WN..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

	XPress type 70 950 ...	Key D 80 950 ...	Clamping screw 70 950 ...	Solid Carbide Seat W 70 950 ...		
Spare parts for Article no.						
70 543 716 / 70 542 716	823	T09 - IP	126	M3x7 - IP	819	807
70 543 720 / 70 542 720	823	T09 - IP	126	M3x7 - IP	819	807
70 543 725 / 70 542 725	823	T09 - IP	126	M3x7 - IP	819	807
70 543 620 / 70 542 620	824	T15 - IP	128	M4,5x12 - IP	820	812
70 543 625 / 70 542 625	824	T15 - IP	128	M4,5x12 - IP	820	812

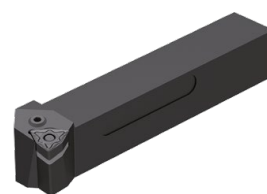
MaxiLock-N – PWLN 95° – Toolholder with lever clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



	Left-hand 70 543 ...	Right-hand 70 542 ...
	116	11600 ¹⁾
	12000 ¹⁾	12000 ¹⁾
	125	12500 ¹⁾
	020	020
	025	025
	032	032

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert		
PWLN R/L 1616 H06	16	16	100	20	22,5	3	WNNMG 0604		
PWLN R/L 2020 K06	20	20	125	26	25,0	3	WNNMG 0604		
PWLN R/L 2525 M06	25	25	150	19	32,0	3	WNNMG 0604		
PWLN R/L 2020 K08	20	20	125	22	25,0	4	WNNMG 0804		
PWLN R/L 2525 M08	25	25	150	22	32,0	4	WNNMG 0804		
PWLN R/L 3225 P08	32	25	170	22	32,0	4	WNNMG 0804		

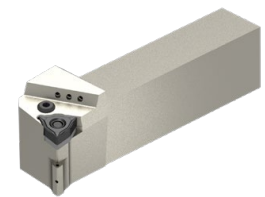
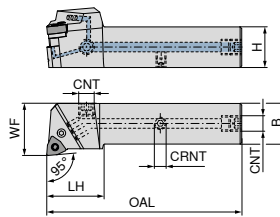
1) nickel-plated

	Key I 70 950 ...	Shim 70 950 ...	Assembly pin 70 950 ...	Lever 70 950 ...	Clamping screw 70 950 ...	Solid Carbide Seat W 70 950 ...
Spare parts for Article no.						
70 542 11600 / 70 543 116		SW2,5				
70 542 12000 / 70 543 12000		SW2,5				
70 542 12500 / 70 543 125		SW2,5				
70 542 020 / 70 543 020		SW3				
70 542 025 / 70 543 025		SW3				
70 542 032 / 70 543 032		SW3				

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

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions

NEW Left-hand **70 599 ...**
NEW Right-hand **70 599 ...**

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	70 599 ...	70 599 ...
PWLN R/L 2020 X06-T DC	20	20	104	35	25	M6	G1/8"	3	WNMG 0604	02000	02001
PWLN R/L 2525 X06-T DC	25	25	120	35	32	M6	G1/8"	3	WNMG 0604	02500	02501
PWLN R/L 2020 X08-T DC	20	20	104	35	25	M6	G1/8"	4	WNMG 0804	12000	12001
PWLN R/L 2525 X08-T DC	25	25	120	35	32	M6	G1/8"	4	WNMG 0804	12500	12501
PWLN R/L 3225 X08-T DC	32	25	135	35	32	M6	G1/8"	4	WNMG 0804	03200	03201

**Spare parts
for Article no.**

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

**Spare parts
for Article no.**

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

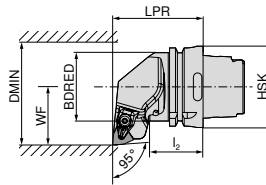
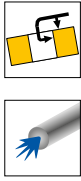
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...

70 950 ...	70 950 ...	70 950 ...

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

Scope of supply:

Tool holder with Torx key



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	42,00	52,6	45	125	WN.. 0804			508	508
HSK T100 DWLN R 08	HSK-T 100	80	45,00	87,6	55	125	WN.. 0804			708	708
HSK T100 DWLN L 08	HSK-T 100	80	53,96	87,6	55	125	WN.. 0804			708	



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Solid Carbide Seat W

70 950 ...

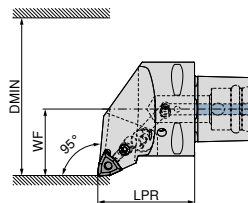
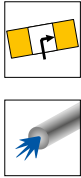
Spare parts for Article no.

74 528 508 / 74 529 508	824	T15 - IP	128	M4,5x12 - IP	820	812
74 528 708 / 74 529 708	824	T15 - IP	128	M4,5x12 - IP	820	812

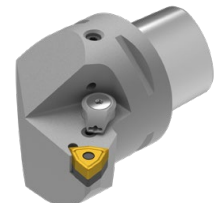
MaxiLock-N – PWLN 95° – Toolholder with lever clamping

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	00895	00895	00895	00895
PSC50 PWLN R/L 65060-08	PSC 50	60	35	65	5	WN.. 0804	DC	00894	00894	00894	00894
PSC63 PWLN R/L 80065-08	PSC 63	65	45	80	5	WN.. 0804	DC	00893	00893	00893	00893



The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → Page 40.



Shim

84 950 ...



Elbow lever screw

84 950 ...



Lever

84 950 ...



Solid Carbide Seat W

84 950 ...

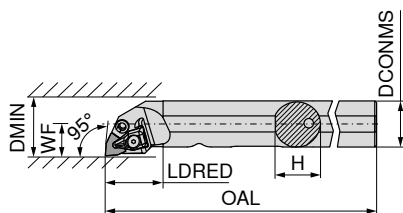
Spare parts for Article no.

84 652 00895 / 84 653 00895	29200	M8X1/L17 SW3	28700	28900	27700
84 652 00894 / 84 653 00894	29200	M8X1/L17 SW3	28700	28900	27700
84 652 00893 / 84 653 00893	29200	M8X1/L17 SW3	28700	28900	27700

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

Scope of supply:

Boring bar with Torx key



Illustrations show right-hand versions



	Left-hand 70 573 ...	Right-hand 70 572 ...
	725	725
	732	732
	64000	640

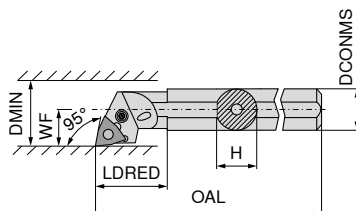
ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment	Insert
	mm	mm	mm	mm	mm	mm	Nm	
A25R DWLN R/L 06	25	24	200	32	17	32	2	WN.. 0604
A32S DWLN R/L 08	32	31	250	40	22	44	4	WN.. 0804
A40T DWLN R/L 08	40	39	300	45	27	50	4	WN.. 0804

Part	70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...
XPress type					
Key D					
Clamping screw					
Hydrant					
Solid Carbide Seat W					
Spare parts for Article no.					
70 572 725 / 70 573 725	823	T09 - IP	126	M3x7 - IP	819
70 572 732 / 70 573 732	824	T15 - IP	128	M4,5x12 - IP	834
70 572 640 / 70 573 64000	824	T15 - IP	128	M4,5x12 - IP	834

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

Scope of supply:

Boring bar with Allen key



Illustrations show right-hand versions



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

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

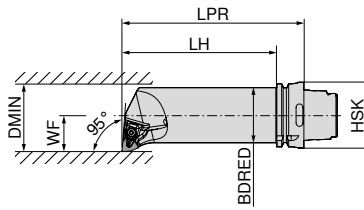
1) nickel-plated

Part	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
Key I						
Shim						
Assembly pin						
Lever						
Clamping screw						
Solid Carbide Seat W						
Spare parts for Article no.						
70 572 11600 / 70 573 11600		177			129	217
70 572 12100 / 70 573 12100		177			129	217
70 572 12500 / 70 573 12500		175	122	191	185	208
70 572 132 / 70 573 132		175	122	191	185	208
70 572 225 / 70 573 225		176			187	205
70 572 032 / 70 573 032		176	198	192	187	209
70 572 040 / 70 573 040		176	198	192	187	209

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

Scope of supply:

Boring bar with Torx key



Illustrations show right-hand versions



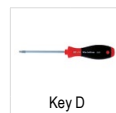
Left-hand	Right-hand
74 537 ...	74 536 ...
508	508

ISO designation	Adapter	LPR	LH	BDRED	WF	DMIN	torque moment	Insert
		mm	mm	mm	mm	mm	Nm	
HSK T63 50Q DWLN R/L 08	HSK-T 63	175	149	50	35	63	4	WN.. 0804



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Solid Carbide Seat W

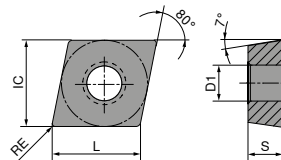
70 950 ...

Spare parts
for Article no.

74 536 508 / 74 537 508	824	T15 - IP	128	M4,5x12 - IP	820	812
-------------------------	------------	----------	------------	--------------	------------	------------

CCGT / CCMT / CCET

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

ISO	RE mm	-CF05 CTEP110		-CF55 CTEP110		-SF TCM407		-SF TCM10		-SMF TCM10		NEW -SF CTCP125-P		NEW -SF CTCP135-P	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		F		F		F		F		F		F		F	
		CERMET CCGT		CERMET CCMT		CERMET CCGT		CERMET CCGT		CERMET CCMT		CERMET CCGT		CERMET CCGT	
		76 247 ...		76 248 ...		70 251 ...		70 251 ...		70 249 ...		76 251 ...		76 251 ...	
060202EN	0,2		002			850		900				50201			70201
060204EN	0,4		004		004	852		902		900					
09T302EN	0,2		014			854		904							
09T304EN	0,4		016		016			906		904					
09T308EN	0,8		018		018			908		906					
120404EN	0,4				028			910							
P			●		●			●		●			●		●
M			○		○			○		○			○		○
K			○		○			○		○			○		
N															
S															
H															
O															

CCMT / CCGT

		NEW	NEW	NEW	NEW	NEW	NEW	NEW
		-SF	-SF	-SF	-SMF	-SMF	-SMF	-SM
		CTCP115-P	CTCP125-P	CTCP135-P	CTCP115-P	CTCP125-P	CTCP135-P	CTCP125-P
		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							
060202EN	0,2							50201
060204EN	0,4	30401	50401	70401		50401	70401	
060208EN	0,8					50601		
09T304EN	0,4	31601	51601	71601	31601	51601	71601	
09T308EN	0,8	31801	51801		31801	51801		
120404EN	0,4		52801			52801		
120408EN	0,8		53001		33001		73001	
P		●	●	●	●	●	●	●
M				○			○	
K		○	○		○	○		○
N								
S								
H								
O								

9

CCGT / CCMT

		NEW			NEW	NEW	NEW	NEW
		-SM	-SM	-SM	-SM	-SM	-SM	-SMQ
		CTCP135-P	CTCK110	CTCK120	CTCP115-P	CTCP125-P	CTCP135-P	CTCP115-P
		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							
060202EN	0,2	70201						
060204EN	0,4		004	554	30401	50401	70401	
060208EN	0,8		006	506	30601		70601	
09T304EN	0,4		016	516	31601	51601	71601	31601
09T308EN	0,8		018	518	31801	51801	71801	31801
09T312EN	1,2		020	520				
120404EN	0,4		028	528	32801	52801	72801	32801
120408EN	0,8		030	530	33001	53001	73001	33001
120412EN	1,2					53201		
P		●	○	○	●	●	●	●
M		○					○	
K			●	●	○	○		○
N								
S								
H								
O								

CCMT

		NEW		NEW		NEW		NEW
		-SMQ CTCP125-P	-M25 CTCM120	-SF CTPM125	-M25 CTPM125	-F43 CTCM130	-M25 CTCM130	-SM CTCM130
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F CCMT	F CCMT	F CCMT	F CCMT	F CCMT	F CCMT	M CCMT
		76 194 ...	75 210 ...	75 042 ...	75 210 ...	75 031 ...	75 210 ...	75 047 ...
ISO	RE mm							
060204EN	0,4		10400	20400	204		30400	30400
09T304EN	0,4	51601	11600	21600	216	31600	31600	31600
09T308EN	0,8	51801	11800		218	31800	31800	31800
120404EN	0,4	52801						32800
120408EN	0,8	53001						33000
P		●	○	○	○	○	○	○
M			●	●	●	●	●	●
K		○						
N								
S						○	○	○
H								
O								

CCMT / CCGT

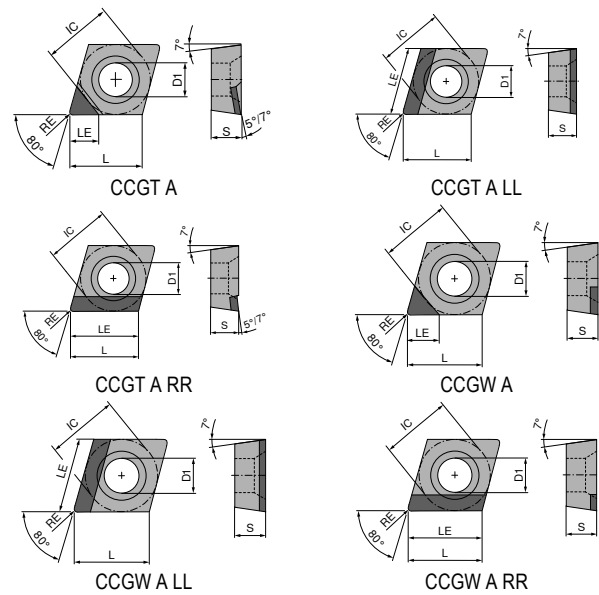
		-M55 CTCM120	-M55 CTPM125	-M55 CTCM130	-23P H216T	-25P H210T	-25P CTPX710
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN			DRAGONSKIN
		M CCMT	M CCMT	M CCMT	F CCGT	F CCGT	M CCGT
		75 211 ...	75 211 ...	75 211 ...	70 255 ...	70 248 ...	70 248 ...
ISO	RE mm						
060202FN	0,2				652	636	70200
060204EN	0,4	10400	204	30400			
060204FN	0,4				654	638	70400
09T302FN	0,2					639	71400
09T304EN	0,4	11600	216	31600			
09T304FN	0,4				656	640	71600
09T308EN	0,8	11800	218	31800			
09T308FN	0,8				658	641	71800
120402FN	0,2					643	
120404EN	0,4	12800	228	32800			
120404FN	0,4					642	72800
120408EN	0,8	13000	230	33000			
120408FN	0,8					644	73000
P			○	○			●
M		●	●	●			●
K					○	○	
N					●	●	●
S					○	○	●
H							
O					○	○	

CCGT / CCMT / CCET

		-25Q H210T	-25Q CTPX710	-27 H10T	-27 CTPX715	-29 H216T	NEW -29 CTPX715	NEW -F05 CTPX710
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN
		M		M		M		F
		CCGT		CCGT		CCMT		CCET
		70 248 ...	70 248 ...	70 254 ...	70 254 ...	70 245 ...	70 245 ...	76 243 ...
ISO	RE mm							
060201FN	0,1							10100
060202FN	0,2			600	80200			10200
060204EN	0,4					60400	70400	
060204FN	0,4	678	75400	602	80400			10400
09T302FN	0,2			604	81400			
09T304EN	0,4					61600	71600	
09T304FN	0,4	680	76600	606	81600			
09T308EN	0,8					61800	71800	
09T308FN	0,8	681	76800	608	81800			
09T316FN	1,6				72200			
120402FN	0,2			610	82600			
120404FN	0,4	682	77800	612	82800			
120408FN	0,8	686	78000	614	83000			
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. 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

ISO	RE mm	TCE (NOI)	LE mm	CTDMD05	CTDPD20	CTDPD20	-Q CTDPD20	-Q CTDPD20
060201FN	0,1	A (1)	3,4					
060201FN	0,1	A (1)	3,5					
060202FN	0,2	A (1)	2,5	050		10100		101
060202FN	0,2	A (1)	3,3				102	102
060202FN	0,2	A (1)	3,4		100	100		
060204FN	0,4	A (1)	2,5	052				
060204FN	0,4	A (1)	3,1				104	104
060204FN	0,4	A (1)	3,2		102	102		
060208FN	0,8	A (1)	2,5	05300				
060208FN	0,8	A (1)	3,0		10300	10300		
09T301FN	0,1	A (1)	4,5				111	111
09T302FN	0,2	A (1)	4,4				112	112
09T302FN	0,2	A (1)	4,5		10500	10500		
09T304FN	0,4	A (1)	2,5	054				
09T304FN	0,4	A (1)	4,2				114	114
09T304FN	0,4	A (1)	4,3		104	104		
09T308FN	0,8	A (1)	2,5					
09T308FN	0,8	A (1)	4,1	056	106	106		
120402FN	0,2	A (1)	4,4				122	122
120404FN	0,4	A (1)	4,2				124	124
120404FN	0,4	A (1)	4,3		108	108		
120408FN	0,8	A (1)	4,1		110	110		

P					
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K					
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H					
O	•	•	•	•	•

CCGW / CCGT

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

ISO	RE mm	TCE (NOI)	LE mm							
				71 172 ...	71 172 ...	71 300 ...	71 168 ...	71 305 ...	71 169 ...	
060202FN	0,2	A (1)	3,40			102				
060204FN	0,4	A (1)	3,10			104		104		
060204FN	0,4	A (1)	3,20			104	10001			
060204FRR	0,4	A (1)	6,45							
060204FLL	0,4	A (1)	6,45	10001	10101					
060208FN	0,8	A (1)	3,00			10600				
09T302FN	0,2	A (1)	4,40							10001
09T302FN	0,2	A (1)	4,50			112				
09T304FN	0,4	A (1)	4,20					114		10101
09T304FN	0,4	A (1)	4,30			114				
09T308FN	0,8	A (1)	4,10			118				
09T308FRR	0,8	A (1)	9,70							
09T308FLL	0,8	A (1)	9,70	10201	10301					
09T312FLL	1,2	A (1)	9,70	10401						
120404FN	0,4	A (1)	4,20						124	10201
120404FN	0,4	A (1)	4,30			124				
120408FN	0,8	A (1)	4,10			128				
120412FRR	1,2	A (1)	12,90							
120412FLL	1,2	A (1)	12,90	10501	10601					
P										
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N				•	•	•	•	•	•	•
S										
H										
O				•	•	•	•	•	•	•

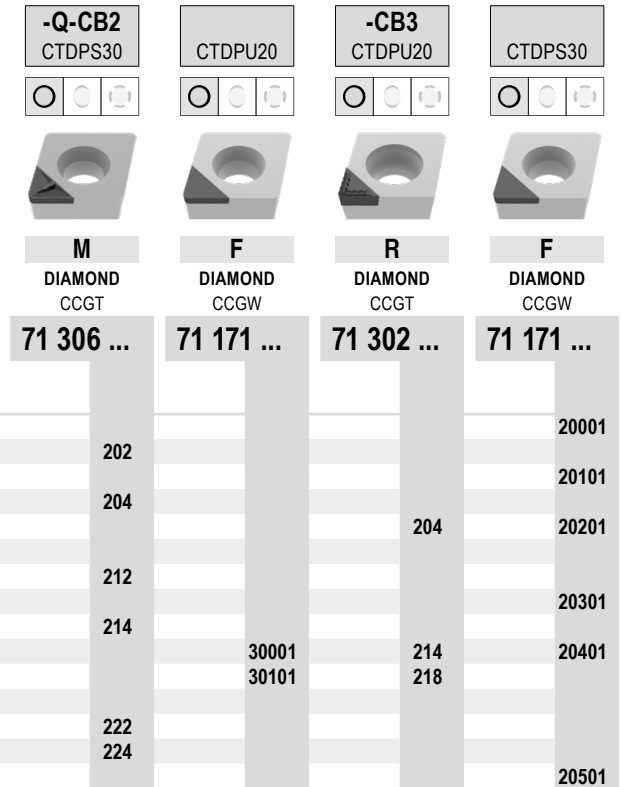
CCGT / CCGW

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

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

CCGT / CCGW

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

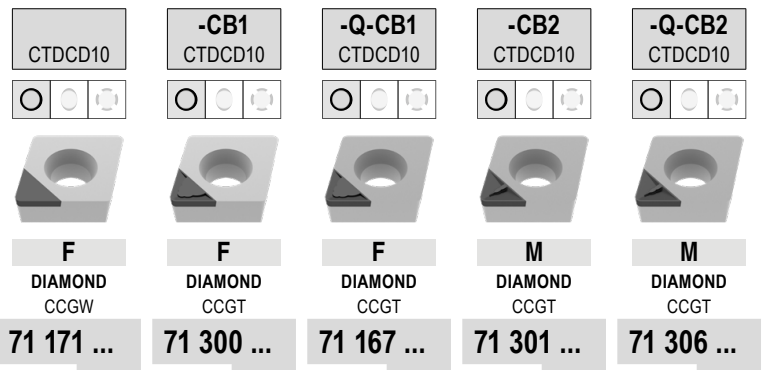


ISO	RE mm	TCE (NOI)	LE mm
060201FN	0,1	A (1)	3,5
060202FN	0,2	A (1)	3,3
060202FN	0,2	A (1)	3,4
060204FN	0,4	A (1)	3,1
060204FN	0,4	A (1)	3,2
09T302FN	0,2	A (1)	4,4
09T302FN	0,2	A (1)	4,5
09T304FN	0,4	A (1)	4,2
09T304FN	0,4	A (1)	4,3
09T308FN	0,8	A (1)	4,1
120402FN	0,2	A (1)	4,4
120404FN	0,4	A (1)	4,2
120404FN	0,4	A (1)	4,3

P				
M				
K				
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S				
H				
O		•	•	•

CCGW / CCGT

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



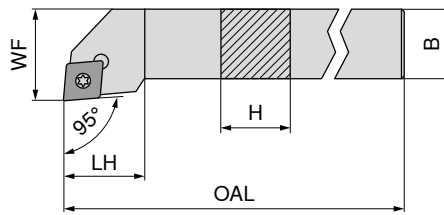
ISO	RE mm	TCE (NOI)	LE mm	71 171 ...	71 300 ...	71 167 ...	71 301 ...	71 306 ...
060202FN	0,2	A (1)	2,3			40001		
060202FN	0,2	A (1)	2,4	40001	302		30200	
060204FN	0,4	A (1)	2,1			40101		304
060204FN	0,4	A (1)	2,2	40101	304		304	
060208FN	0,8	A (1)	2,0		30600			
09T302FN	0,2	A (1)	2,3					31200
09T302FN	0,2	A (1)	2,4	40201			31200	
09T304FN	0,4	A (1)	2,1			40201		314
09T304FN	0,4	A (1)	2,2	40301	314		314	
09T308FN	0,8	A (1)	2,0	40401			31600	
120404FN	0,4	A (1)	2,1			40301		324
120404FN	0,4	A (1)	2,2				32600	
120408FN	0,8	A (1)	2,0	40501				
120408FN	0,8	A (1)	2,1				328	

P								
M								
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S								
H								
O				•	•	•	•	•

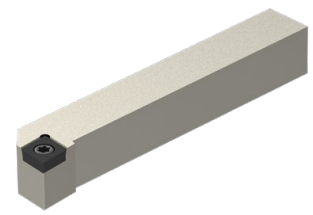
MaxiLock-S – SCLC 95° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



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

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

	 Key D 80 950 ...	 Clamping screw 70 950 ...	 Carbide type C 70 950 ...	 Threaded sleeve 70 950 ...
	039	857		
	039	857		
	120	87900		
	120	87900		
	120	87900		
	120	820	166	170
	120	820	166	170
	120	820	166	170
	120	820	166	170

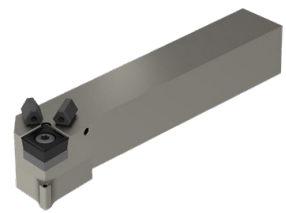
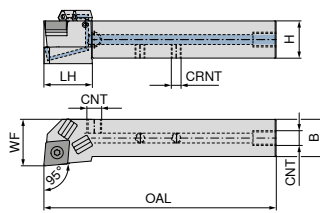
**Spare parts
for Article no.**

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

MaxiLock-S – SCLC 95° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions

NEW Left-hand **70 770 ...**
NEW Right-hand **70 770 ...**

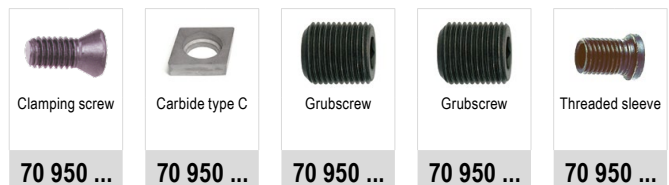
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	70 770 ...	70 770 ...
SCLC R/L 1010 E06 DC	10	10	70	14	12	M6	M6	1,2	CC.. 0602	01001	01000
SCLC R/L 1212 F09 DC	12	12	80	19	16	M6	M6	3,2	CC.. 09T3	01201	01200
SCLC R/L 1616 H09 DC	16	16	100	26	20	M6	G1/8"	3,2	CC.. 09T3	11601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

Spare parts for Article no.

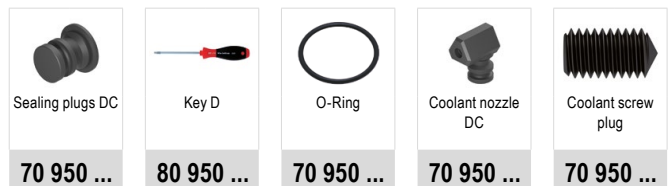
Article no.	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 770 01000 / 70 770 01001	857			86700	
70 770 01200 / 70 770 01201	859			86700	
70 770 01600 / 70 770 11601	87900	165	88000	86700	171
70 770 02000 / 70 770 12001	87900	165	88000	86700	171
70 770 11600 / 70 770 01601	820	166	88000	86700	170
70 770 12000 / 70 770 02001	820	166	88000	86700	170
70 770 02500 / 70 770 02501	820	166	88000	86700	170
70 770 03200 / 70 770 03201	820	166	88000		170

Spare parts for Article no.

Article no.	70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...
70 770 01000 / 70 770 01001		039			
70 770 01200 / 70 770 01201		120			
70 770 01600 / 70 770 11601	87600	120	88100	87700	294
70 770 02000 / 70 770 12001	87600	120	88100	87700	294
70 770 11600 / 70 770 01601	87600	120	88100	87700	294
70 770 12000 / 70 770 02001	87600	120	88100	87700	294
70 770 02500 / 70 770 02501	87600	120	88100	87700	294
70 770 03200 / 70 770 03201	87600	120	88100	87700	294



Clamping screw	Carbide type C	Grubscrew	Grubscrew	Threaded sleeve
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...

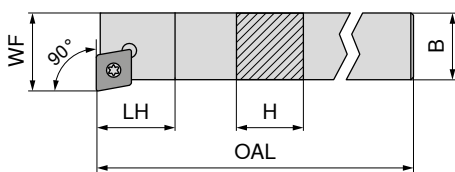


Sealing plugs DC	Key D	O-Ring	Coolant nozzle DC	Coolant screw plug
70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...

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

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



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

1) nickel-plated

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

Spare parts for Article no.

70 760 008	110
70 760 010	110
70 760 012	113
70 760 016	398
70 760 020 / 70 761 02000	398

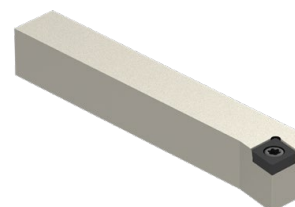
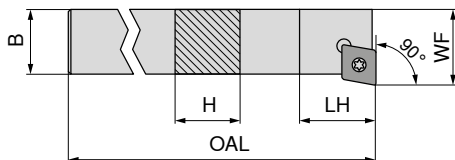
Key D	Combination Key	Clamping screw	Carbide type C	Threaded sleeve
80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
110		13800		
110		13800		
113		113		
	398	113	165	171
	398	114	166	170

9

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

Scope of supply:

Tool holder with Torx key



NEW

Left-hand

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

for Article no.

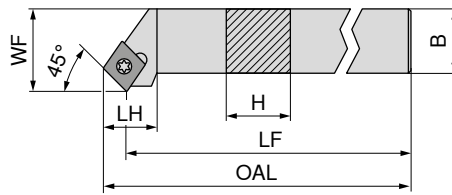
70 635 00800	039
70 635 01000	039
70 635 01200	120
70 635 01600	120

Key D	Clamping screw
80 950 ...	70 950 ...
039	857
039	857
120	87900
120	87900

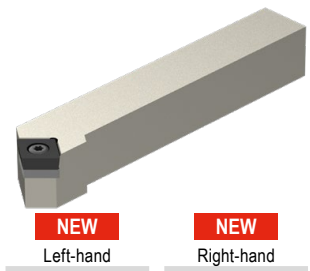
MaxiLock-S – SCSC 45° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



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
SCSC R 1616 H12	16	16	100	20	20	5	CC.. 1204	70 638 ...	70 638 ...
SCSC R/L 2020 K12	20	20	125	20	25	5	CC.. 1204	02000	01601 02001
SCSC R/L 2525 M12	25	25	150	20	32	5	CC.. 1204	02500	02501

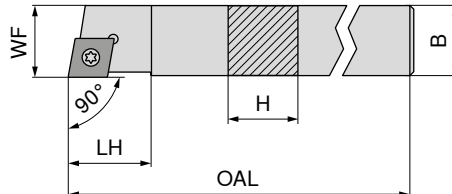
Spare parts for Article no.	Key D	Clamping screw	Carbide type C	Threaded sleeve
70 638 01601	T15 - IP	80 950 ...	70 950 ...	70 950 ...
70 638 02001 / 70 638 02000	T15 - IP	120	820	166
70 638 02501 / 70 638 02500	T15 - IP	120	820	166
				M4,5
				M4,5
				170
				170

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

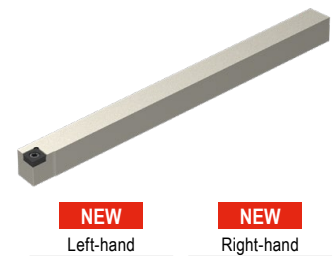
▲ for sliding head lathes

Scope of supply:

Tool holder with Torx key



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
SCAC R/L 0808 K06	8	8	125	9	8	1,2	CC.. 0602	70 633 ...	70 633 ...
SCAC R/L 0808 D06	8	8	60	9	8	1,2	CC.. 0602	10800	10801 00800 00801
SCAC R/L 1010 E06	10	10	70	9	10	1,2	CC.. 0602	01000	01001 11000 11001
SCAC R/L 1010 M06	10	10	150	9	10	1,2	CC.. 0602	01200	01201 11200 11201
SCAC R/L 1212 F09	12	12	80	13	12	3,2	CC.. 09T3	11600	11601 11601
SCAC R/L 1212 M09	12	12	150	13	12	3,2	CC.. 09T3	12000	12001
SCAC R/L 1616 H09	16	16	100	13	16	3,2	CC.. 09T3		
SCAC R/L 2020 K12	20	20	125	17	20	5	CC.. 1204		

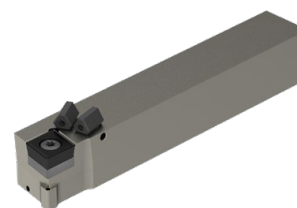
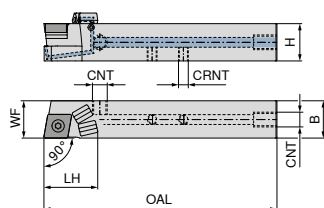
Spare parts for Article no.	Key D	Clamping screw	Carbide type C	Threaded sleeve
70 633 10801 / 70 633 10800	039	857		
70 633 00801 / 70 633 00800	039	857		
70 633 01001 / 70 633 01000	039	857		
70 633 11001 / 70 633 11000	039	857		
70 633 01201 / 70 633 01200	120	87900		
70 633 11201 / 70 633 11200	120	87900		
70 633 11601 / 70 633 11600	120	87900		
70 633 12001 / 70 633 12000	120	820	166	170

MaxiLock-S – SCAC 90° DC – Tool holder with screw clamping

▲ for sliding head lathes

Scope of supply:

Tool holder with blind plug and Torx key



NEW

Left-hand

NEW

Right-hand

70 766 ...

70 766 ...

Illustrations show right-hand versions

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

Spare parts

for Article no.

for Article no.	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 766 11200 / 70 766 11201	859			86700	
70 766 01200 / 70 766 01201	859			86700	
70 766 01600 / 70 766 01601	87900	165	88000	86700	171
70 766 02000 / 70 766 02001	820	166	88000	86700	170

Spare parts

for Article no.

for Article no.	70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...
70 766 11200 / 70 766 11201		120			
70 766 01200 / 70 766 01201		120			
70 766 01600 / 70 766 01601	87600	120	88100	87700	294
70 766 02000 / 70 766 02001	87600	120	88100	87700	294

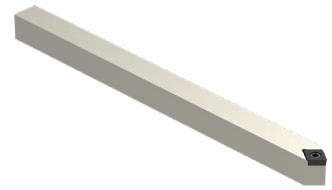
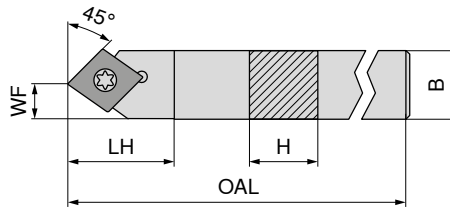
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...

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

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

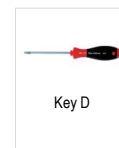
Scope of supply:

Tool holder with Torx key



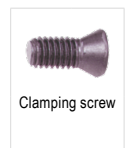
NEW
Left-hand
70 634 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	
SCDC L 0808 K06	8	8	125	13	4	1,2	CC.. 0602	00800
SCDC L 1010 M06	10	10	150	13	5	1,2	CC.. 0602	01000
SCDC L 1212 M09	12	12	150	18	6	3,2	CC.. 09T3	01200
SCDC L 1414 M09	14	14	150	18	7	3,2	CC.. 09T3	01400



Key D

80 950 ...



Clamping screw

70 950 ...

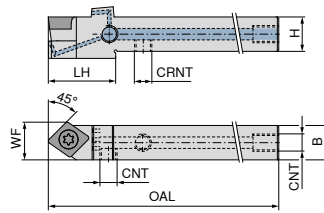
**Spare parts
for Article no.**

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

MaxiLock-S – SCDC 45° DC – Tool holder with screw clamping

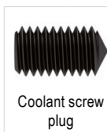
Scope of supply:

Tool holder with blind plug and Torx key



NEW
Left-hand
70 767 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	
SCDC L 0808 K06 DC	8	8	125	17	8,5	M5	M5	1,2	CC.. 0602	00801
SCDC L 1010 M06 DC	10	10	150	17	10,0	M6	M6	1,2	CC.. 0602	01001
SCDC L 1212 M09 DC	12	12	150	23	13,0	M6	M6	3,2	CC.. 09T3	01201
SCDC L 1414 M09 DC	14	14	150	25	14,0	M6	G1/8"	3,2	CC.. 09T3	01401



Coolant screw plug

70 950 ...



Clamping screw

70 950 ...

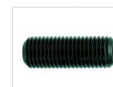


Grubscrew

70 950 ...

**Spare parts
for Article no.**

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



Cylindrical screw

83 950 ...



Key D

80 950 ...

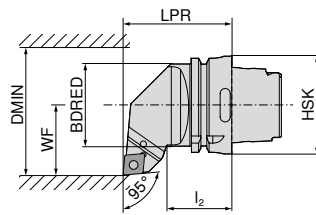
**Spare parts
for Article no.**

70 767 00801										
70 767 01001								M5x5 - SW2,5	157	T08 - IP 039
70 767 01201										T08 - IP 039
70 767 01401										T15 - IP 120
										T15 - IP 120

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

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Left-hand	Right-hand
74 541 ...	74 540 ...
512	512

ISO designation	Adapter	LPR mm	I ₂ mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert
HSK T63 SCLC R/L 12	HSK-T 63	70	42	53	45	100	5	CC.. 1204



Combination Key

70 950 ...



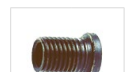
Clamping screw

70 950 ...



Carbide type C

70 950 ...



Threaded sleeve

70 950 ...

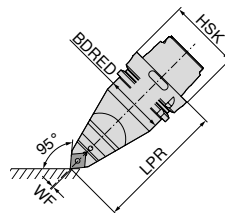
Spare parts for Article no.

74 540 512 / 74 541 512	T15/SW	398	M4,5x12	114	166	M4,5	170
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MaxiLock-S – SCMC 50° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Neutral	74 542 ...
	512

ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert
HSK T63 SCMC N 12	HSK-T 63	115	53	0	5	CC.. 1204



Combination Key

70 950 ...



Clamping screw

70 950 ...



Carbide type C

70 950 ...



Threaded sleeve

70 950 ...

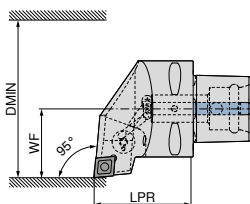
Spare parts for Article no.

74 542 512	T15/SW	398	M4,5x12	114	166	M4,5	170
------------	--------	-----	---------	-----	-----	------	-----

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	Left-hand	Right-hand
								84 655 ...	84 654 ...
PSC40 SCLC R/L 50050-12	PSC 40	50	27	50	5	CC.. 1204	DC	01295	01295
PSC50 SCLC R/L 65060-12	PSC 50	60	35	65	5	CC.. 1204	DC	01294	01294
PSC63 SCLC R/L 80065-12	PSC 63	65	45	80	5	CC.. 1204	DC	01293	01293

The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra → **Page 40.**

**Spare parts
for Article no.**

84 654 01295 / 84 655 01295	27500
84 654 01294 / 84 655 01294	27500
84 654 01293 / 84 655 01293	27500



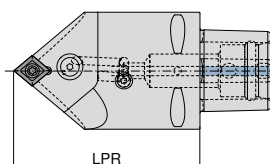
Clamping screw

84 950 ...

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

Scope of supply:

without high-performance coolant set




ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Direct cooling compatible	Neutral
						84 674 ...
PSC63 SMC N 0100-12	PSC 63	100	5	CC.. 1204	DC	01293
PSC63 SMC N 0130-12	PSC 63	130	5	CC.. 1204	DC	11293

The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra → **Page 40.**

**Spare parts
for Article no.**

84 674 01293	27500
84 674 11293	27500



Clamping screw

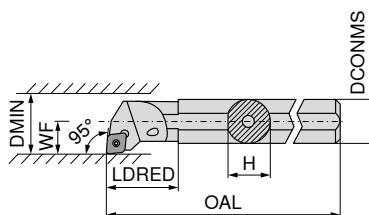
84 950 ...

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

▲ A... = with thro' coolant
▲ S... = without thro' coolant

Scope of supply:

Boring bar with Torx key



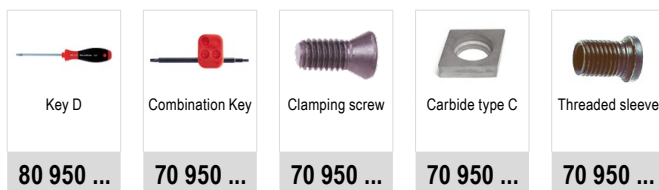
Illustrations show right-hand versions



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 ...
S08H SCLC R/L 06	8	7,2	100	11,0	5	11	1,2	CC.. 0602	008	008
A08F SCLC R/L 06	8	7,6	80	17,0	5	11	1,2	CC.. 0602	208	208
S10K SCLC R/L 06	10	9,0	125	15,0	7	13	1,2	CC.. 0602	010	010
A10H SCLC R/L 06	10	9,5	100	19,0	7	13	1,2	CC.. 0602	210	210
S12Q SCLC R/L 06	12	11,0	180	18,8	9	16	1,2	CC.. 0602	012	012
A12K SCLC R/L 06	12	11,5	125	22,0	9	16	1,2	CC.. 0602	212	212
A16M SCLC R/L 06	16	14,0	150	50,0	9	18	1,2	CC.. 0602	116	116
S16R SCLC R/L 09	16	14,5	200	25,0	11	20	3,2	CC.. 09T3	016	016
A16M SCLC R/L 09	16	15,0	150	29,0	11	20	3,2	CC.. 09T3	216	216
S20S SCLC R/L 09	20	18,0	250	25,0	13	25	3,2	CC.. 09T3	020	020
A20Q SCLC R/L 09	20	18,5	180	32,0	13	25	3,2	CC.. 09T3	220	220
S25T SCLC R/L 09	25	23,0	300	20,0	17	32	3,2	CC.. 09T3	025	025
A25R SCLC R/L 09	25	23,0	200	36,0	17	32	3,2	CC.. 09T3	225	225
A32S SCLC R/L 12	32	30,0	250	50,0	22	40	5	CC.. 1204	232	232
A40T SCLC R/L 12	40	38,0	300	60,0	27	50	5	CC.. 1204	240	240

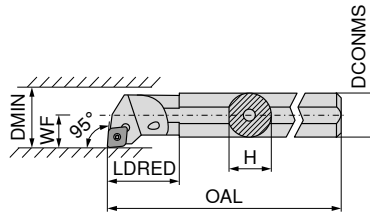
Spare parts for Article no.

	80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 716 008 / 70 717 008	110		116		
70 716 208 / 70 717 208	110		116		
70 716 010 / 70 717 010	110		116		
70 716 210 / 70 717 210	110		116		
70 716 012 / 70 717 012	110		116		
70 716 212 / 70 717 212	110		116		
70 716 116 / 70 717 116	110		116		
70 716 016 / 70 717 016	113		110		
70 716 216 / 70 717 216	113		110		
70 716 020 / 70 717 020	113		110		
70 716 220 / 70 717 220	113		304		
70 716 025 / 70 717 025	113		113		
70 716 225 / 70 717 225	113		304		
70 716 232 / 70 717 232		398	114	166	170
70 716 240 / 70 717 240		398	114	166	170



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		Right-hand	
									70 719 ...	70 718 ...	70 719 ...	70 718 ...
E-A08F SCLC R/L 06	8	7,5	80	20,60	6	12	1,2	CC.. 0602	208		208	
E-A10H SCLC R/L 06	10	9,0	100	31,75	7	14	1,2	CC.. 0602	210		210	
E-A12K SCLC R/L 06	12	11,0	125	20,00	9	18	1,2	CC.. 0602	212		212	
E-A16M SCLC R/L 09	16	15,0	150	45,30	11	22	3,2	CC.. 09T3	216		216	
E-A20Q SCLC R/L 09	20	18,0	180	38,00	13	26	3,2	CC.. 09T3	220		220	
E-A25R SCLC R/L 09	25	23,0	200	40,25	17	34	3,2	CC.. 09T3	225		225	
E-A32S SCLC R/L 12	32	30,0	250	50,25	22	39	5	CC.. 1204	232		232	



Key D



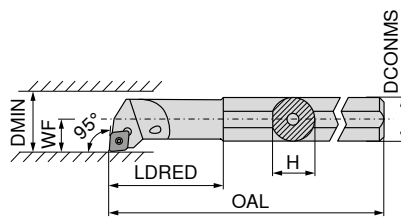
Clamping screw

Spare parts for Article no.

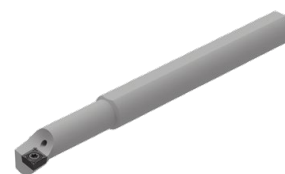
Article no.	Part	80 950 ...	70 950 ...
70 718 208 / 70 719 208	T08	110	116
70 718 210 / 70 719 210	T08	110	116
70 718 212 / 70 719 212	T08	110	116
70 718 216 / 70 719 216	T15	113	449
70 718 220 / 70 719 220	T15	113	449
70 718 225 / 70 719 225	T15	113	449
70 718 232 / 70 719 232	T15	113	174

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	Article no.	
									Left-hand	Right-hand
E-A0608F SCLC R/L 06	8	7,5	100	25	4	8	1,2	CC.. 0602	70 719 308	70 718 308
E-A0810H SCLC R/L 06	10	9,0	110	32	6	12	1,2	CC.. 0602	70 719 310	70 718 310
E-A1012K SCLC R/L 06	12	11,0	125	38	7	14	1,2	CC.. 0602	70 719 312	70 718 312
E-A1216M SCLC R/L 06	16	15,0	150	50	9	18	1,2	CC.. 0602	70 719 316	70 718 316

Spare parts for Article no.

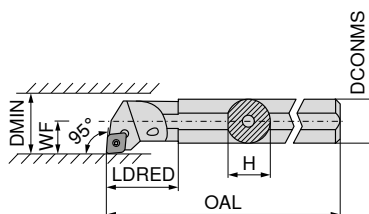
Article no.	Key D	Clamping screw
70 718 308 / 70 719 308	T08	M2,5x5
70 718 310 / 70 719 310	T08	M2,5x5
70 718 312 / 70 719 312	T08	M2,5x5
70 718 316 / 70 719 316	T08	M2,5x5

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

▲ Type: Solid carbide

Scope of supply:

Boring bar with Torx key



Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Article no.	
									Left-hand	Right-hand
E08H SCLC R/L 06	8	7,6	100	20	6	11	1,2	CC.. 0602	70 719 008	70 718 008
E10K SCLC R/L 06	10	9,0	125	22	7	13	1,2	CC.. 0602	70 719 010	70 718 010
E12Q SCLC R/L 06	12	11,5	180	26	9	16	1,2	CC.. 0602	70 719 012	70 718 012
E16R SCLC R/L 09	16	15,0	200	34	11	20	3,2	CC.. 09T3	70 719 016	70 718 016
E20S SCLC R/L 09	20	18,5	250	38	13	25	3,2	CC.. 09T3	70 719 020	70 718 020
E25T SCLC R/L 09	25	23,0	300	43	17	32	3,2	CC.. 09T3	70 719 025	70 718 025

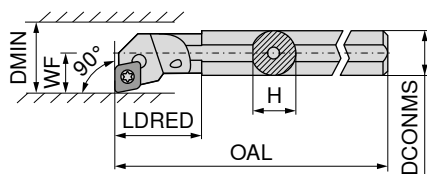
Spare parts for Article no.

Article no.	Key D	Clamping screw
70 719 008 / 70 718 008	T08	M2,5x5
70 719 010 / 70 718 010	T08	M2,5x5
70 719 012 / 70 718 012	T08	M2,5x5
70 719 016 / 70 718 016	T15	M3,5x7,2
70 719 020 / 70 718 020	T15	M3,5x8,6
70 719 025 / 70 718 025	T15	M3,5x11

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

Scope of supply:

Boring bar with Torx key



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 ...	70 793 ...	70 792 ...
A08F SCFC R/L 06	8	7,6	80	17	5	11	1,2	CC.. 0602	208		208	
A10H SCFC R/L 06	10	9,5	100	19	7	13	1,2	CC.. 0602	210		210	
A12K SCFC R/L 06	12	11,5	125	22	9	16	1,2	CC.. 0602	212		212	



Key D

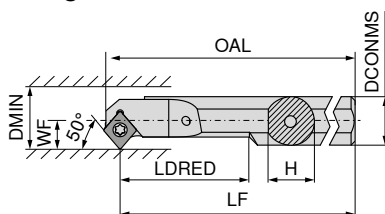


Clamping screw

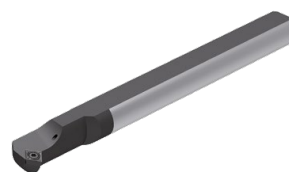
**Spare parts
for Article no.**

Article no.	Key	Clamping screw
70 792 208 / 70 793 208	T08	110 M2,5x5
70 792 210 / 70 793 210	T08	110 M2,5x5
70 792 212 / 70 793 212	T08	110 M2,5x5

MaxiLock-S – SMC 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 ...	70 723 ...	70 722 ...
A08H SMC R/L 06	8	7	104,15	100	20	5,5	10,5	1,2	CC.. 0602	208		208	
A10H SMC R/L 06	10	9	114,15	110	26	6,0	11,0	1,2	CC.. 0602	210		210	
A12K SMC R/L 06	12	11	129,15	125	32	7,0	13,0	1,2	CC.. 0602	212		212	
A16M SMC R/L 06	16	15	154,15	150	40	9,0	16,0	1,2	CC.. 0602	216		216	



Key D



Clamping screw

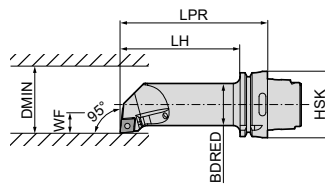
**Spare parts
for Article no.**

Article no.	Key	Clamping screw
70 723 208 / 70 722 208	T08	110 M2,5x5
70 723 210 / 70 722 210	T08	110 M2,5x5
70 723 212 / 70 722 212	T08	110 M2,5x5
70 723 216 / 70 722 216	T08	110 M2,5x5

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

Scope of supply:

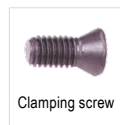
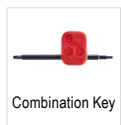
Boring bar with Torx key



Illustrations show right-hand versions

Left-hand	Right-hand
74 564 ...	74 563 ...
512	512

ISO designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert
HSK T63 40L SCLC R/L 12	HSK-T 63	140	114	40	27	50	5	CC.. 1204



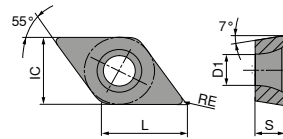
70 950 ...	70 950 ...	70 950 ...	70 950 ...
398	114	166	170

**Spare parts
for Article no.**

74 563 512 / 74 564 512	T15/SW	M4,5x12	M4,5
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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

ISO	RE mm	-CF05 CTEP110		-CF55 CTEP110		-SF TCM407		-SF TCM10		-SMF TCM10		NEW -SF CTCP125-P		NEW -SF CTCP115-P	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		F		F		F		F		F		F		F	
		CERMET DCGT		CERMET DCMT		CERMET DCGT		CERMET DCGT		CERMET DCMT		DCGT		DCMT	
		76 245 ...		76 246 ...		70 257 ...		70 257 ...		70 265 ...		76 257 ...		76 259 ...	
070201EN	0,1														
070202EN	0,2		002	002				898							
070204EN	0,4		004	004				900							
						852		902					50201		
11T302EN	0,2		014												
11T304EN	0,4		016	016				904							
11T308EN	0,8		018	018				906							31601
						854		908							31801
						856									
						858									
P			●	●	●	●	●	●	●	●	●	●	●	●	●
M			○	○	○	○	○	○	○	○	○	○	○	○	○
K			○	○	○	○	○	○	○	○	○	○	○	○	○
N															
S															
H															
O															

DCMT / DCGT

		NEW	NEW	NEW	NEW	NEW	NEW	NEW
		-SF CTCP125-P	-SF CTCP135-P	-SMF CTCP115-P	-SMF CTCP125-P	-SMF CTCP135-P	-SM CTCP125-P	-SM CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F DCMT	F DCMT	F DCMT	F DCMT	F DCMT	M DCGT	M DCGT
		76 259 ...	76 259 ...	76 265 ...	76 265 ...	76 265 ...	76 256 ...	76 256 ...
ISO	RE mm							
070202EN	0,2							
070204EN	0,4	50401	70401		50401	70401 70601	50201	70201
070208EN	0,8							
11T304EN	0,4	51601	71601	31601	51601	71601		
11T308EN	0,8	51801	71801	31801	51801	71801		
P		●	●	●	●	●	●	●
M			○			○		○
K		○		○	○		○	
N								
S								
H								
O								

DCMT

			NEW	NEW	NEW	NEW	
		-SM CTCK110	-SM CTCK120	-SM CTCP115-P	-SM CTCP115-P	-SM CTCP125-P	-SM CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M DCMT	M DCMT	M DCMT	M DCMT	M DCMT	M DCMT
		70 258 ...	70 258 ...	76 183 ...	76 258 ...	76 258 ...	76 258 ...
ISO	RE mm						
070204EN	0,4		004	554	30401	50401	70401
070208EN	0,8		006	506	30601	50601	70601
11T304EN	0,4		016	516	31601	51601	71601
11T308EN	0,8		018	518	31801	51801	71801
11T312EN	1,2			32001		52001	
P			○	○	●	●	●
M							○
K			●	●	○	○	○
N							
S							
H							
O							

DCMT

		NEW	NEW		NEW		NEW	NEW
		-SMQ CTCP115-P	-SMQ CTCP125-P	-M25 CTCM120	-SF CTPM125	-M25 CTPM125	-SM CTPM125	-F43 CTCM130
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M DCMT	M DCMT	F DCMT	F DCMT	F DCMT	M DCMT	F DCMT
		76 195 ...	76 195 ...	75 213 ...	75 044 ...	75 213 ...	75 048 ...	75 032 ...
ISO	RE mm							
070202EN	0,2			10200		202		30200
070204EN	0,4	30401	50401	10400	20400	204		30400
11T302EN	0,2			11400		214		31400
11T304EL	0,4	31601	51601					
11T304EN	0,4	31501	51501	11600	21600	216		31600
11T304ER	0,4	31701	51701					
11T308EN	0,8	31801	51801	11800	21800	218	21800	31800
P		●	●	○	○	○	○	○
M				●	●	●	●	●
K		○	○					
N								
S								○
H								
O								

9

DCMT / DCGT

					NEW		NEW
		-M25 CTCM130	-M55 CTCM120	-M55 CTPM125	-SM CTCM130	-M55 CTCM130	-SF CTPM125
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F DCMT	M DCMT	M DCMT	M DCMT	M DCMT	F DCGT
		75 213 ...	75 214 ...	75 214 ...	75 048 ...	75 214 ...	75 043 ...
ISO	RE mm						
070202EN	0,2		30200				20200
070204EN	0,4		30400	10400	204	30400	
070208EN	0,8			10600	206	30600	
11T302EN	0,2		31400				
11T304EN	0,4		31600	11600	216	31600	
11T308EN	0,8		31800	11800	218	31800	
P		○	○	○	○	○	○
M		●	●	●	●	●	●
K							
N							
S		○			○	○	
H							
O							

DCGT

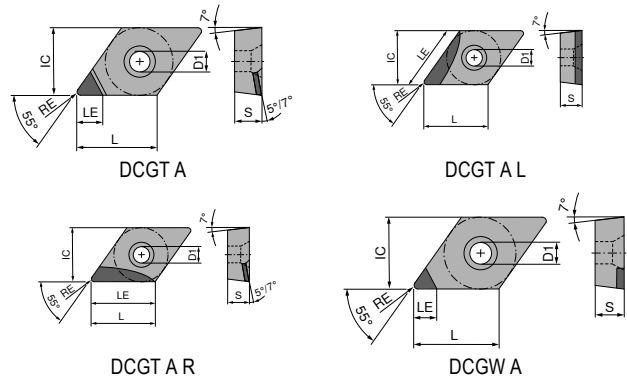
		-23P H216T	-25P H210T	-25P CTPX710 <small>DRAGONSKIN</small>	-25Q H210T	-25Q CTPX710 <small>DRAGONSKIN</small>	-27 H10T	-27 CTPX715 <small>DRAGONSKIN</small>
		F DCGT	F DCGT	M DCGT	M DCGT	M DCGT	M DCGT	M DCGT
		70 261 ...	70 263 ...	70 263 ...	70 263 ...	70 263 ...	70 260 ...	70 260 ...
ISO	RE mm							
070202FN	0,2		632	70200			600	80200
070204FN	0,4	654	634	70400			602	80400
11T302FN	0,2		635	71400			604	81400
11T304FN	0,4	664	636	71600	660	75600	606	81600
11T304FL	0,4				670	75700		
11T304FR	0,4				680	75800		
11T308FN	0,8	666	638	71800	662	76000	608	81800
11T308FL	0,8				672			
11T308FR	0,8				682			
P				●		●		●
M				●		●		●
K		○	○		○		○	○
N		●	●	●	●	●	●	●
S			○	●	○	●		●
H								
O		○	○		○		○	○

DCMT / DCET

ISO	RE mm	-29 H216T	NEW -29 CTPX715 DRAGONSKIN	-F05 CTPX710 DRAGONSKIN
0702005FN	0,05	70 246 ... 60400	70 246 ... 70400	10200
070201FN	0,10			10400
0702015FN	0,15			10600
070202FN	0,20			10800
070204EN	0,40			
11T3005FN	0,05	61600	71600	11400
11T301FN	0,10			11600
11T3015FN	0,15			11800
11T302FN	0,20			12000
11T304EN	0,40			
11T304FN	0,40	61800	71800	12200
11T308EN	0,80			
P			●	●
M			●	●
K		○	○	
N		●	●	●
S			●	●
H				
O		○	○	

DCGW / DCGT

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



DCGW / DCGT

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

ISO	RE mm	TCE (NOI)	LE mm	CTDMD05		-Q CTDMD05		CTDPD20	
				71 130 ...	71 134 ...	71 178 ...	71 176 ...	71 130 ...	71 134 ...
070202FN	0,2	A (1)	2,5	00200	050				
070202FN	0,2	A (1)	3,7	00400	052			100	100
070204FN	0,4	A (1)	2,5	00600	054			102	102
070204FR	0,4	A (1)	2,5				50001	104	104
070204FN	0,4	A (1)	3,4						
070208FN	0,8	A (1)	2,5						
070208FN	0,8	A (1)	3,0						
11T302FN	0,2	A (1)	2,5	056	056				
11T302FN	0,2	A (1)	3,0						
11T302FN	0,2	A (1)	4,7					106	106
11T304FN	0,4	A (1)	2,5						
11T304FL	0,4	A (1)	3,0			50001			
11T304FN	0,4	A (1)	3,0	058					
11T304FN	0,4	A (1)	4,3					108	108
11T308FN	0,8	A (1)	2,5		060				
11T308FN	0,8	A (1)	4,0					110	110
11T312FN	1,2	A (1)	3,5						11200
11T312FN	1,2	A (1)	3,6					11200	

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

DCGW / DCGT

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

ISO	RE mm	TCE (NOI)	LE mm	CTDPS30		CTDPS30		CTDPS30		CTDPS30		-CB1 CTDPU20		-CB2 CTDPU20	
				○	○	○	○	○	○	○	○	○	○	○	○
				F DIAMOND DCGW		F DIAMOND DCGT		F DIAMOND DCGT		F DIAMOND DCGT		F DIAMOND DCGT		M DIAMOND DCGT	
				71 177 ...	71 173 ...	71 173 ...	71 173 ...	71 174 ...	71 175 ...						
070201FN	0,1	A (1)	3,8	20001			20001								
070202FN	0,2	A (1)	3,7	20101			20101					30001			
070204FN	0,4	A (1)	3,4	20201								30101		30001	
070204FL	0,4	A (1)	5,5		20201										
070208FN	0,8	A (1)	3,0	20301											
11T301FN	0,1	A (1)	4,8	20401			20301								
11T302FN	0,2	A (1)	4,7	20501			20401								
11T304FN	0,4	A (1)	4,3	20601								30201		30101	
11T304FL	0,4	A (1)	7,5		20501										
11T308FN	0,8	A (1)	4,0	20701								30301			
11T308FL	0,8	A (1)	7,0		20601										
11T308FR	0,8	A (1)	7,0					20701							
11T312FN	1,2	A (1)	3,6	20801											
11T312FL	1,2	A (1)	6,5		20801										
11T312FR	1,2	A (1)	6,5					20901							
P															
M															
K															
N		•	•	•	•	•	•	•	•	•	•	•	•	•	•
S															
H															
O		•	•	•	•	•	•	•	•	•	•	•	•	•	•

DCGT / DCGW

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

ISO	RE mm	TCE (NOI)	LE mm	CTDPD20		-Q		-CB1		-Q	
				71 136 ...	71 135 ...	71 144 ...	71 145 ...	71 310 ...	71 138 ...		
070201FN	0,1	A (1)	3,8							10100	
070202FN	0,2	A (1)	3,7							102	
070204FL	0,4	A (1)	3,0								
070204FR	0,4	A (1)	3,0								
070204FN	0,4	A (1)	3,4			104				104	
070204FRR	0,4	A (1)	5,5								
070204FLL	0,4	A (1)	5,5	102							
070208FN	0,8	A (1)	3,0							108	
070208FRR	0,8	A (1)	5,0								
070208FLL	0,8	A (1)	5,0	104							
11T301FN	0,1	A (1)	4,8							11100	
11T302FR	0,2	A (1)	4,0								162
11T302FN	0,2	A (1)	4,7							112	
11T304FL	0,4	A (1)	4,0								
11T304FR	0,4	A (1)	4,0								
11T304FN	0,4	A (1)	4,3			114				114	
11T304FRR	0,4	A (1)	7,5								
11T304FLL	0,4	A (1)	7,5	108		108					
11T308FN	0,8	A (1)	4,0							118	
11T308FRR	0,8	A (1)	7,0								
11T308FLL	0,8	A (1)	7,0	110		110					
P											
M											
K											
N											
S											
H											
O											

DCGW / DCGT

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

ISO	RE mm	TCE (NOI)	LE mm	Insert Options					
				71 139 ...	71 144 ...	71 145 ...	71 310 ...	71 311 ...	71 312 ...
				-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
070201FL	0,1	A (1)	3,0			151			
070201FR	0,1	A (1)	3,0		15000				
070201FN	0,1	A (1)	3,8				20100		
070202FL	0,2	A (1)	3,0			152			
070202FR	0,2	A (1)	3,0		152				
070202FN	0,2	A (1)	3,7				202 204	202 204 208	
070204FN	0,4	A (1)	3,4						204
070208FN	0,8	A (1)	3,0						
11T301FR	0,1	A (1)	4,0		161				
11T301FL	0,1	A (1)	4,0			161			
11T301FN	0,1	A (1)	4,8				21100	21100	
11T302FL	0,2	A (1)	4,0			162			
11T302FR	0,2	A (1)	4,0		162				
11T302FN	0,2	A (1)	4,7				212	212	
11T304FL	0,4	A (1)	4,0	164					
11T304FN	0,4	A (1)	4,3				214 218	214 218	214 218
11T308FN	0,8	A (1)	4,0						
P									
M									
K									
N				•	•	•	•	•	•
S									
H									
O				•	•	•	•	•	•

DCGW / DCGT

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

CTDPU20	CTDCD10	-CB1 CTDCD10	-CB2 CTDCD10
F DIAMOND DCGW	F DIAMOND DCGW	F DIAMOND DCGT	M DIAMOND DCGT
71 177 ...	71 177 ...	71 310 ...	71 311 ...
	40001	302	30200
	40101	304	304
30001			
	40201		308
30101			
	40301	31200	31200
	40401	314	314
30201			
	40501	318	318
30301			

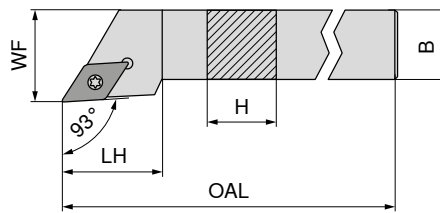
ISO	RE mm	TCE (NOI)	LE mm
070202FN	0,2	A (1)	2,6
070204FN	0,4	A (1)	2,3
070204FN	0,4	A (1)	3,4
070208FN	0,8	A (1)	2,0
070208FN	0,8	A (1)	3,0
11T302FN	0,2	A (1)	2,6
11T304FN	0,4	A (1)	2,3
11T304FN	0,4	A (1)	4,3
11T308FN	0,8	A (1)	2,0
11T308FN	0,8	A (1)	4,0

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

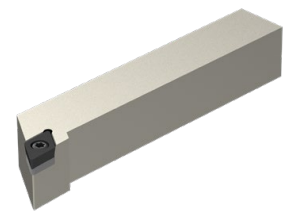
MaxiLock-S – SDJC 93° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



	NEW Left-hand 70 643 ...	NEW Right-hand 70 643 ...
	00800	00801
	01000	01001
	01200	01201
	01600	01601
	02000	02001
	02500	02501
	03200	03201

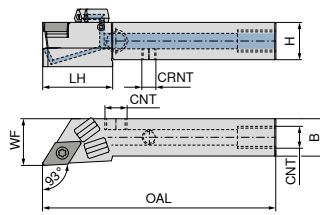
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert
SDJC R/L 0808 D07	8	8	60	13,0	10	1,2	DC.. 0702
SDJC R/L 1010 E07	10	10	70	13,0	12	1,2	DC.. 0702
SDJC R/L 1212 F07	12	12	80	14,3	16	1,2	DC.. 0702
SDJC R/L 1616 H11	16	16	100	19,3	20	3,2	DC.. 11T3
SDJC R/L 2020 K11	20	20	125	19,9	25	3,2	DC.. 11T3
SDJC R/L 2525 M11	25	25	150	21,2	32	3,2	DC.. 11T3
SDJC R/L 3225 P11	32	25	170	21,2	32	3,2	DC.. 11T3

Spare parts for Article no.	Key D		Clamping screw		Solid Carbide Seat D		Threaded sleeve	
	80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	
70 643 00800 / 70 643 00801	T08 - IP	039	M2,5x6 - IP	857				
70 643 01000 / 70 643 01001	T08 - IP	039	M2,5x6 - IP	857				
70 643 01200 / 70 643 01201	T08 - IP	039	M2,5x6 - IP	857				
70 643 01600 / 70 643 01601	T15 - IP	120	M3,5x11	87900	106	M3,5	171	
70 643 02000 / 70 643 02001	T15 - IP	120	M3,5x11	87900	106	M3,5	171	
70 643 02500 / 70 643 02501	T15 - IP	120	M3,5x11	87900	106	M3,5	171	
70 643 03200 / 70 643 03201	T15 - IP	120	M3,5x11	87900	106	M3,5	171	

MaxiLock-S – SDJC 93° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions

	NEW	NEW
	Left-hand	Right-hand
	70 773 ...	70 773 ...
	01001	01000
	01201	01200
	01601	01600
	02001	02000
	02501	02500

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

Spare parts for Article no.

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

	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
Clamping screw					
Solid Carbide Seat D					
Grubscrew					
Grubscrew					
Threaded sleeve					
	857			86700	
	857			86700	
	87900	106	88000	86700	171
	87900	106	88000	86700	171
	87900	106	88000	86700	171

Spare parts for Article no.

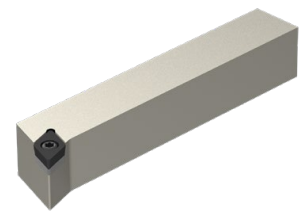
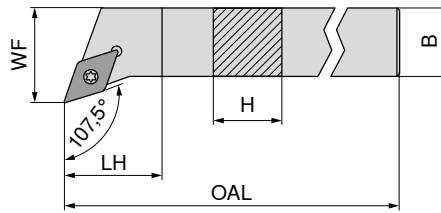
- 70 773 01000 / 70 773 01001
- 70 773 01200 / 70 773 01201
- 70 773 01600 / 70 773 01601
- 70 773 02000 / 70 773 02001
- 70 773 02500 / 70 773 02501

	70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...
Sealing plugs DC					
Key D					
O-Ring					
Coolant nozzle DC					
Coolant screw plug					
		039			
		039			
	87600	120	88100	87700	294
	87600	120	88100	87700	294
	87600	120	88100	87700	294

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

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

NEW	
Left-hand	Right-hand
70 642 ...	70 642 ...
01000	01001
01200	01201
01600	01601
02000	02001
02500	02501

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert
SDHC R/L 1010 E07	10	10	70	7,6	12	1,2	DC.. 0702
SDHC R/L 1212 F07	12	12	80	12,2	16	1,2	DC.. 0702
SDHC R/L 1616 H11	16	16	100	11,6	20	3,2	DC.. 11T3
SDHC R/L 2020 K11	20	20	125	14,1	25	3,2	DC.. 11T3
SDHC R/L 2525 M11	25	25	150	20,5	32	3,2	DC.. 11T3

Key D	Clamping screw	Solid Carbide Seat D	Threaded sleeve
80 950 ...	70 950 ...	70 950 ...	70 950 ...
039	857		
039	857		
120	87900	106	171
120	87900	106	171
120	87900	106	171

Spare parts

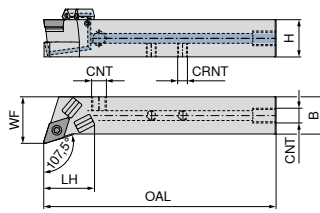
for Article no.

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

MaxiLock-S – SDHC 107.5° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions

NEW Left-hand **70 772 ...**
NEW Right-hand **70 772 ...**

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

Spare parts for Article no.

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

Clamping screw 70 950 ...	Solid Carbide Seat D 70 950 ...	Grubscrew 70 950 ...	Grubscrew 70 950 ...	Threaded sleeve 70 950 ...
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Spare parts for Article no.

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

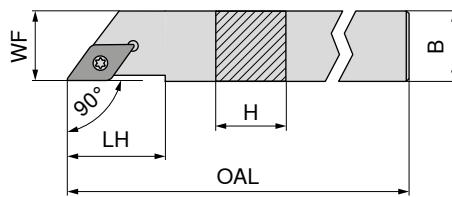
Sealing plugs DC 70 950 ...	Key D 80 950 ...	O-Ring 70 950 ...	Coolant nozzle DC 70 950 ...	Coolant screw plug 70 950 ...
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MaxiLock-S – SDAC 90° – Toolholder with screw clamping

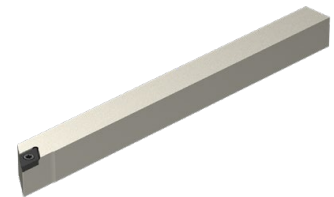
▲ for sliding head lathes

Scope of supply:

Tool holder with Torx key

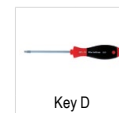


Illustrations show right-hand versions



	NEW Left-hand	NEW Right-hand
70 639 ...	70 639 ...	70 639 ...
00800	00801	00801
01000	01001	01001
01200	01201	01201
11200	11201	11201
01400	01401	01401

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



Key D



Clamping screw

80 950 ...

70 950 ...

Spare parts

for Article no.

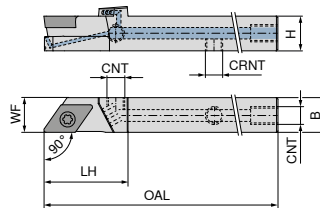
70 639 00800 / 70 639 00801	T08 - IP	039	M2,5x6 - IP	857
70 639 01000 / 70 639 01001	T08 - IP	039	M2,5x6 - IP	857
70 639 01200 / 70 639 01201	T08 - IP	039	M2,5x6 - IP	857
70 639 11200 / 70 639 11201	T15 - IP	120	M3,5x11	87900
70 639 01400 / 70 639 01401	T15 - IP	120	M3,5x11	87900

MaxiLock-S – SDAC 90° DC – Tool holder with screw clamping

▲ for sliding head lathes

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions



	NEW Left-hand	NEW Right-hand
70 771 ...	70 771 ...	70 771 ...
00801	00800	00800
01001	01000	01000
01201	01200	01200
11201	11200	11200

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert
SDAC R/L 0808 K07 DC	8	8	125	21	8	M5	M5	1,2	DC.. 0702
SDAC R/L 1010 M07 DC	10	10	150	21	10	M6	M6	1,2	DC.. 0702
SDAC R/L 1212 M07 DC	12	12	150	21	12	M6	M6	1,2	DC.. 0702
SDAC R/L 1212 M11 DC	12	12	150	29	12	M6	M6	3,2	DC.. 11T3



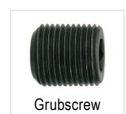
Cylindrical screw



Key D



Clamping screw



Grubscrew

83 950 ...

80 950 ...

70 950 ...

70 950 ...

Spare parts

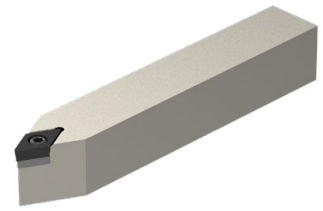
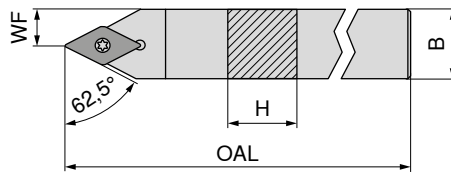
for Article no.

70 771 00800 / 70 771 00801	157	039	13800	86700
70 771 01000 / 70 771 01001		039	13800	86700
70 771 01200 / 70 771 01201		039	13800	86700
70 771 11200 / 70 771 11201		120	113	86700

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





Scope of supply:

Tool holder with Torx key



NEW
Neutral
70 645 ...

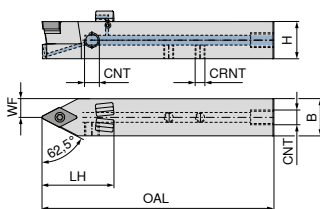
ISO designation	H mm	B mm	OAL mm	WF mm	torque moment Nm	Insert	
SDNC N 0808 K07	8	8	125	4,0	1,2	DC.. 0702	00800
SDNC N 1010 M07	10	10	150	5,0	1,2	DC.. 0702	11000
SDNC N 1010 E07	10	10	70	5,0	1,2	DC.. 0702	01000
SDNC N 1212 F07	12	12	80	6,0	1,2	DC.. 0702	01200
SDNC N 1212 M07	12	12	150	6,0	1,2	DC.. 0702	11200
SDNC N 1212 M11	12	12	150	6,0	3,2	DC.. 11T3	21200
SDNC N 1616 H11	16	16	100	8,0	3,2	DC.. 11T3	01600
SDNC N 2020 K11	20	20	125	10,0	3,2	DC.. 11T3	02000
SDNC N 2525 M11	25	25	150	12,5	3,2	DC.. 11T3	02500

Spare parts for Article no.	 Key D 80 950 ...				 Clamping screw 70 950 ...		 Solid Carbide Seat D 70 950 ...		 Threaded sleeve 70 950 ...	
70 645 00800	T08 - IP	039	M2,5x6 - IP	857						
70 645 11000	T08 - IP	039	M2,5x6 - IP	857						
70 645 01000	T08 - IP	039	M2,5x6 - IP	857						
70 645 01200	T08 - IP	039	M2,5x6 - IP	857						
70 645 11200	T08 - IP	039	M2,5x6 - IP	857						
70 645 21200	T15 - IP	120	M3,5x11	87900						
70 645 01600	T15 - IP	120	M3,5x11	87900	106	M3,5			171	
70 645 02000	T15 - IP	120	M3,5x11	87900	106	M3,5			171	
70 645 02500	T15 - IP	120	M3,5x11	87900	106	M3,5			171	

MaxiLock-S – SDNC 62.5° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



NEW
Neutral
70 774 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	
SDNC N 1212 M07 DC	12	12	150	24	6,0	M6	M6	1,2	DC.. 0702	11200
SDNC N 1212 F07 DC	12	12	80	24	6,0	M6	M6	1,2	DC.. 0702	01200
SDNC N 1212 M11 DC	12	12	150	31	6,0	M6	M6	3,2	DC.. 11T3	21200
SDNC N 1616 H11 DC	16	16	100	30	8,0	M6	G1/8"	3,2	DC.. 11T3	01600
SDNC N 2020 K11 DC	20	20	125	39	10,0	M6	G1/8"	3,2	DC.. 11T3	02000
SDNC N 2525 M11 DC	25	25	150	30	12,5	M6	G1/8"	3,2	DC.. 11T3	02500

**Spare parts
for Article no.**

Article no.	Clamping screw	Solid Carbide Seat D	Grubscrew	Grubscrew	Threaded sleeve
70 774 11200	857			86700	
70 774 01200	857			86700	
70 774 21200	859			86700	
70 774 01600	87900	106	88000	86700	171
70 774 02000	87900	106	88000	86700	171
70 774 02500	87900	106	88000	86700	171

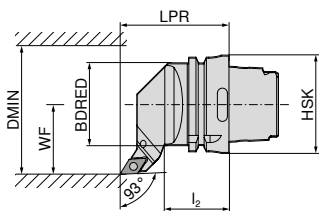
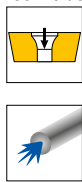
**Spare parts
for Article no.**

Article no.	Sealing plugs DC	Key D	O-Ring	Coolant nozzle DC	Coolant screw plug
70 774 11200		039			
70 774 01200		039			
70 774 21200		120			
70 774 01600	87600	120	88100	87700	294
70 774 02000	87600	120	88100	87700	294
70 774 02500	87600	120	88100	87700	294

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

Scope of supply:

Tool holder with Torx key

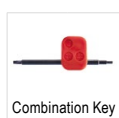


Illustrations show right-hand versions

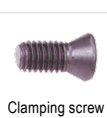


Left-hand **74 544 ...**
Right-hand **74 543 ...**

ISO designation	Adapter	LPR mm	l ₂ mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand	Right-hand
HSK T63 SDJC R/L 11	HSK-T 63	70	42	53	45	100	3.2	DC.. 11T3	511	511



Combination Key



Clamping screw



Solid Carbide Seat D



Threaded sleeve

70 950 ...

70 950 ...

70 950 ...

70 950 ...

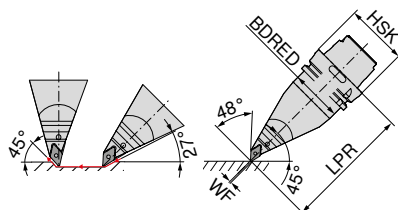
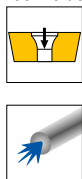
Spare parts for Article no.

74 543 511 / 74 544 511	T15/SW	398	M3,5x11	113	106	M3,5	171
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MaxiLock-S – SDMC 48° – Toolholder with screw clamping

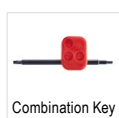
Scope of supply:

Tool holder with Torx key

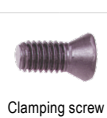


Left-hand **74 546 ...**

ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert	Left-hand
HSK T63 SDMC L 11	HSK-T 63	130	53	0	3.2	DC.. 11T3	511



Combination Key



Clamping screw



Solid Carbide Seat D



Threaded sleeve

70 950 ...

70 950 ...

70 950 ...

70 950 ...

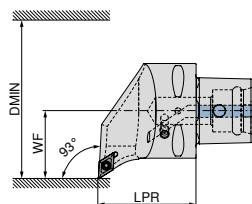
Spare parts for Article no.

74 546 511	T15/SW	398	M3,5x11	113	106	M3,5	171
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MaxiLock-S – SDUC 93° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key

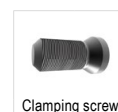


Illustrations show right-hand versions



ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert
PSC40 SDUC R/L 50050-11	PSC 40	50	27	50	3	DC.. 11T3
PSC50 SDUC R/L 65060-11	PSC 50	60	35	65	3	DC.. 11T3
PSC63 SDUC R/L 80065-11	PSC 63	65	45	80	3	DC.. 11T3

Left-hand	Right-hand
84 659 ...	84 658 ...
01195	01195
01194	01194
01193	01193



Clamping screw

84 950 ...

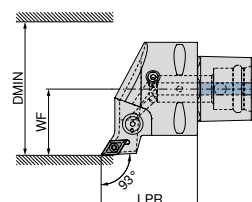
**Spare parts
for Article no.**

84 658 01195 / 84 659 01195	27600
84 658 01194 / 84 659 01194	27600
84 658 01193 / 84 659 01193	27600

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

Scope of supply:

without high-performance coolant set



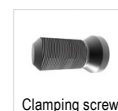
Illustrations show right-hand versions



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

Left-hand	Right-hand
84 663 ...	84 662 ...
01195	01195
01194	01194
01193	01193

1 The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra → **Page 40.**



Clamping screw

84 950 ...

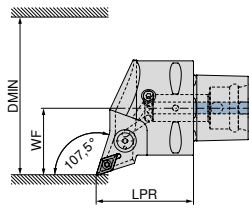
**Spare parts
for Article no.**

84 662 01195 / 84 663 01195	27600
84 662 01194 / 84 663 01194	27600
84 662 01193 / 84 663 01193	27600

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

Scope of supply:

without high-performance coolant set



Illustrations show right-hand versions

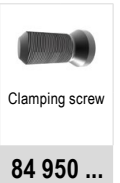


ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Direct cooling compatible	Left-hand	Right-hand
								84 667 ...	84 666 ...
PSC40 SDHC R/L 50050-11	PSC 40	50	27	50	3	DC.. 11T3	DC	01195	01195
PSC50 SDHC R/L 65060-11	PSC 50	60	35	65	3	DC.. 11T3	DC	01194	01194
PSC63 SDHC R/L 80065-11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

The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra → **Page 40.**

**Spare parts
for Article no.**

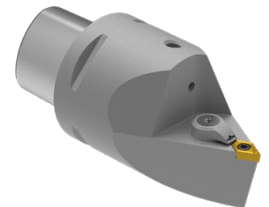
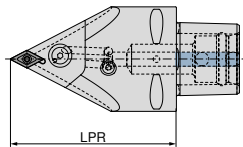
84 666 01195 / 84 667 01195	27600
84 666 01194 / 84 667 01194	27600
84 666 01193 / 84 667 01193	27600



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

Scope of supply:

without high-performance coolant set

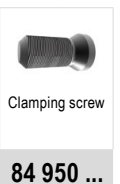


ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Direct cooling compatible	Neutral
						84 677 ...
PSC63 SDNC N 0100-11	PSC 63	100	3	DC.. 11T3	DC	01193
PSC63 SDNC N 0130-11	PSC 63	130	3	DC.. 11T3	DC	11193

The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra → **Page 40.**

**Spare parts
for Article no.**

84 677 01193	27600
84 677 11193	27600

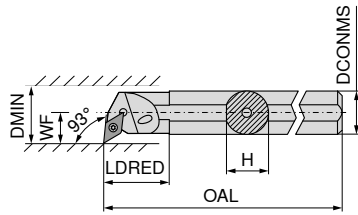


MaxiLock-S – SDUC 93° – Boring bar with screw clamping

▲ A... = with thro' coolant
▲ S... = without thro' coolant

Scope of supply:

Boring bar with Torx key



Illustrations show right-hand versions

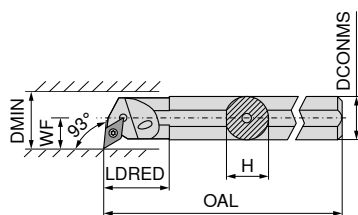


ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand	Right-hand
									70 737 ...	70 736 ...
S12Q SDUC R/L 07	12	11,0	180	12,5	9	17	1,2	DC.. 0702	012	012
A12K SDUC R/L 07	12	11,5	125	22,0	9	16	1,2	DC.. 0702	212	212
S16R SDUC R/L 07	16	15,0	200	13,0	11	21	1,2	DC.. 0702	016	016
A16M SDUC R/L 07	16	15,0	150	29,0	11	20	1,2	DC.. 0702	216	216
S20S SDUC R 07	20	18,0	250	20,0	13	25	1,2	DC.. 0702		020
A20Q SDUC R/L 07	20	18,5	180	32,0	13	25	1,2	DC.. 0702	220	220
S20S SDUC R 11	20	18,0	250	20,0	13	25	3,2	DC.. 11T3		120
A20Q SDUC R/L 11	20	19,0	180	32,0	13	25	3,2	DC.. 11T3	320	320
S25T SDUC R/L 11	25	23,0	300		17	32	3,2	DC.. 11T3	125	125
A25R SDUC R/L 11	25	24,0	200	36,0	17	32	3,2	DC.. 11T3	325	325
S32U SDUC R 11	32	30,0	350		22	40	3,2	DC.. 11T3		132
A32S SDUC R/L 11	32	31,0	250	50,0	22	40	3,2	DC.. 11T3	332	332
A40T SDUC R/L 11	40	39,0	300	60,0	27	50	3,2	DC.. 11T3	340	340

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 ...
70 736 012 / 70 737 012	110		13800		
70 736 212 / 70 737 212	110		13800		
70 736 016 / 70 737 016	110		13800		
70 736 216 / 70 737 216	110		13800		
70 736 020	110		13800		
70 736 220 / 70 737 220	110		13800		
70 736 120	113		110		
70 736 320 / 70 737 320	113		110		
70 736 125 / 70 737 125		398	113	106	171
70 736 325 / 70 737 325	113		113		
70 736 132		398	113	106	171
70 736 332 / 70 737 332		398	113	106	171
70 736 340 / 70 737 340		398	113	106	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	28,0	8	13	1,2	DC.. 0702
E-A12K SDUC R/L 07	12	11	125	18,0	9	18	1,2	DC.. 0702
E-A16M SDUC R/L 07	16	15	150	30,0	11	22	1,2	DC.. 0702
E-A20Q SDUC R/L 07	20	18	180	38,0	13	26	1,2	DC.. 0702
E-A20Q SDUC R/L 11	20	18	180	38,0	13	26	3,2	DC.. 11T3
E-A25R SDUC R/L 11	25	23	200	40,0	17	34	3,2	DC.. 11T3
E-A32S SDUC R/L 11	32	30	250	39,5	22	39	3,2	DC.. 11T3

Left-hand	Right-hand
70 739 ...	70 738 ...
210	210
212	212
216	216
220	220
320	320
225	225
232	232

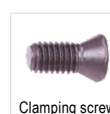
Spare parts

for Article no.

70 738 210 / 70 739 210	110	13800
70 738 212 / 70 739 212	110	13800
70 738 216 / 70 739 216	110	13800
70 738 220 / 70 739 220	110	13800
70 738 320 / 70 739 320	113	449
70 738 225 / 70 739 225	113	449
70 738 232 / 70 739 232	113	449



Key D



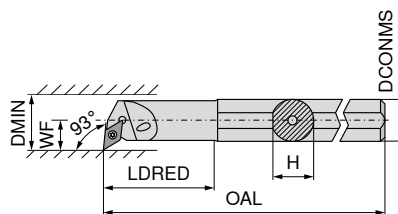
Clamping screw

80 950 ...

70 950 ...

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

▲ with carbide core



Illustrations show right-hand versions



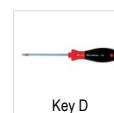
ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert
E-A0810H SDUC R/L 07	10	9	100	22	7	12,5	1,2	DC.. 0702
E-A1012K SDUC R/L 07	12	11	125	28	9	15,5	1,2	DC.. 0702
E-A1216M SDUC R/L 07	16	15	150	36	11	19,5	1,2	DC.. 0702

Left-hand	Right-hand
70 739 ...	70 738 ...
410	410
412	412
416	416

Spare parts

for Article no.

70 738 410 / 70 739 410	110	13800
70 738 412 / 70 739 412	110	13800
70 738 416 / 70 739 416	110	13800



Key D



Clamping screw

80 950 ...

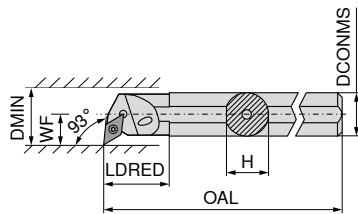
70 950 ...

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

▲ Type: Solid carbide

Scope of supply:

Boring bar with Torx key



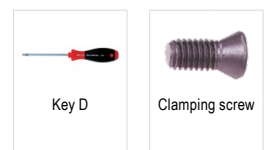
Illustrations show right-hand versions



ISO designation	DCONMS		H	OAL	LDRED	WF	DMIN	torque moment	Insert	Article no.	
	mm	mm								Left-hand	Right-hand
E12Q SDUC R/L 07	12	11,5	180	26	9	16	1,2	DC.. 0702	70 739 ...	70 738 ...	
E16R SDUC R/L 07	16	15,0	200	34	11	20	1,2	DC.. 0702	012	012	
E20S SDUC R/L 11	20	18,5	250	38	13	25	3,2	DC.. 11T3	016	016	
E25T SDUC R/L 11	25	23,0	300	43	17	32	3,2	DC.. 11T3	120	120	
									125	125	

Spare parts
for Article no.

70 739 012 / 70 738 012	110	13800
70 739 016 / 70 738 016	110	13800
70 739 120 / 70 738 120	113	304
70 739 125 / 70 738 125	113	113

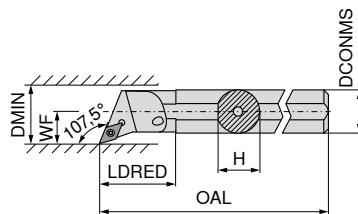


80 950 ... 70 950 ...

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

Scope of supply:

Boring bar with Torx key



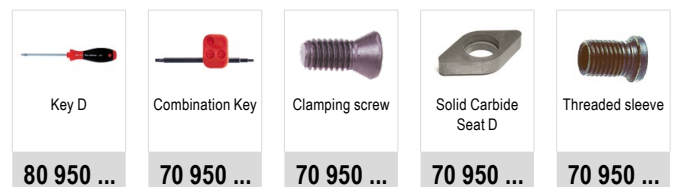
Illustrations show right-hand versions



ISO designation	DCONMS		H	OAL	LDRED	WF	DMIN	torque moment	Insert	Article no.	
	mm	mm								Left-hand	Right-hand
A10H SDQC R/L 07	10	9,0	100	22	7	12,5	1,2	DC.. 0702	70 741 ...	70 740 ...	
A12K SDQC R/L 07	12	11,5	125	22	9	16,0	1,2	DC.. 0702	210	210	
A16M SDQC R/L 07	16	15,0	150	29	11	20,0	1,2	DC.. 0702	212	212	
A20Q SDQC R/L 07	20	18,5	180	32	13	25,0	1,2	DC.. 0702	216	216	
A25R SDQC R/L 11	25	23,0	200	36	17	32,0	3,2	DC.. 11T3	220	220	
A32S SDQC R/L 11	32	30,0	250	50	22	40,0	3,2	DC.. 11T3	225	225	
A40T SDQC R/L 11	40	38,0	300	60	27	50,0	3,2	DC.. 11T3	232	232	
									240	240	

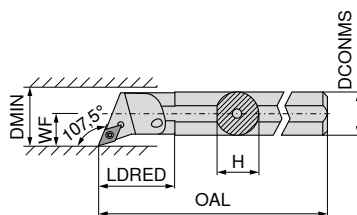
Spare parts
for Article no.

70 740 210 / 70 741 210	110	13800
70 740 212 / 70 741 212	110	13800
70 740 216 / 70 741 216	110	13800
70 740 220 / 70 741 220	110	13800
70 740 225 / 70 741 225	398	113
70 740 232 / 70 741 232	398	113
70 740 240 / 70 741 240	398	113
		106
		106
		171
		171



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

▲ with carbide core



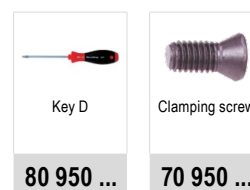
Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand		Right-hand	
									70 751 ...	70 750 ...	70 751 ...	70 750 ...
E-A12K SDQC R/L 07	12	11	125	24	9	18	1,2	DC.. 0702	012		012	
E-A16M SDQC R/L 07	16	15	150	30	11	22	1,2	DC.. 0702	016		016	
E-A20Q SDQC R/L 07	20	18	180	38	13	26	1,2	DC.. 0702	020		020	
E-A20Q SDQC R/L 11	20	18	180	45	13	26	3,2	DC.. 11T3	120		120	
E-A25R SDQC R/L 11	25	23	200	38	17	34	3,2	DC.. 11T3	025		025	
E-A32S SDQC R/L 11	32	30	250	43	22	39	3,2	DC.. 11T3	032		032	

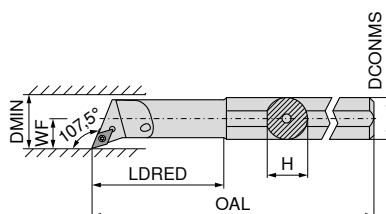
Spare parts for Article no.

70 750 012 / 70 751 012	110	13800
70 750 016 / 70 751 016	110	13800
70 750 020 / 70 751 020	110	13800
70 750 120 / 70 751 120	113	449
70 750 025 / 70 751 025	113	449
70 750 032 / 70 751 032	113	449



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

▲ with carbide core



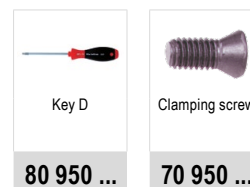
Illustrations show right-hand versions



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

Spare parts for Article no.

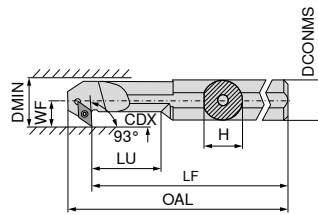
70 750 210 / 70 751 210	110	13800
70 750 212 / 70 751 212	110	13800
70 750 216 / 70 751 216	110	13800



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

Scope of supply:

Boring bar with Torx key



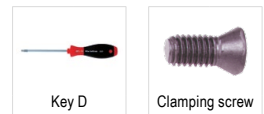
Illustrations show right-hand versions



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

Spare parts
for Article no.

70 733 212 / 70 732 212	110	13800
70 733 216 / 70 732 216	110	13800
70 733 220 / 70 732 220	113	304
70 733 225 / 70 732 225	113	304

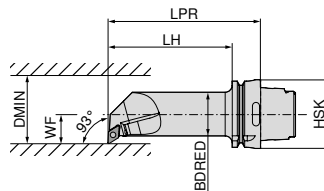


80 950 ... 70 950 ...

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

Scope of supply:

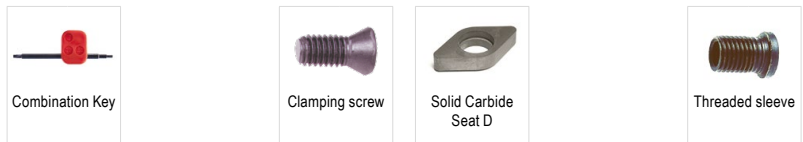
Boring bar with Torx key



Illustrations show right-hand versions



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



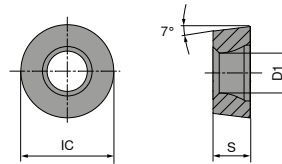
70 950 ... 70 950 ... 70 950 ... 70 950 ...

Spare parts
for Article no.

74 565 511 / 74 566 511	T15/SW	398	M3,5x11	113	106	M3,5	171
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RCMT / RCGT / RCMX

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 10T3..	3,97	4,4	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
RCMX 2507..	7,94	10,5	25



RCMT / RCGT

		NEW		NEW		NEW		NEW		NEW	
		-SMF	-SM	-SM	-SM	-SM	-SM	-SM	-SM	-SM	-SM
		CTCK110	CTCP115-P	CTCP115-P	CTCP115-P	CTCP125-P	CTCP125-P	CTCP125-P	CTCP135-P	CTCP135-P	CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F	M	M	M	M	M	M	M	M	M
		RCMT	RCGT	RCMT	RCMT	RCGT	RCMT	RCMT	RCGT	RCMT	RCGT
		70 188 ...	76 185 ...	76 186 ...	76 264 ...	76 262 ...	76 264 ...	76 264 ...	76 262 ...	76 262 ...	76 262 ...
ISO	RE mm										
0602M0EN	3,0						50201				70201
0803M0EN	4,0		30401				51201				71201
1003M0SN	5,0								51401		
1204M0SN	6,0				32801				52601		
1606M0EN	8,0	038									
1606M0SN	8,0				34001				53801		
2006M0SN	10,0			35001					55001		
2507M0SN	12,5				36201				56201		
P		○	●	●	●	●	●	●	●	●	●
M											○
K		●	○	○	○	○	○	○	○	○	
N											
S											
H											
O											

RCMT / RCMX

ISO	RE mm	NEW -SM CTCP135-P	NEW -M23 CTCP115-P	NEW -M23 CTCP115-P	NEW -M23 CTCP115-P	NEW -M23 CTCP125-P	NEW -SM CTCM120	NEW -SM CTPM125
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M RCMT	M RCMT	M RCMX	M RCMT	M RCMT	M RCMT	M RCMT
		76 264 ...	74 117 ...	74 117 ...	74 121 ...	74 121 ...	75 221 ...	75 221 ...
1003M0SN	5,0	71401					11400	
10T3M0SN	5,0				21400			
1204M0SN	6,0	72601			22600	62600		
1606M0SN	8,0	73801			23800	63800		
2006M0SN	10,0	75001	25000			65000		25000
2507M0SN	12,5	76201		25400				
2507M0SN	12,5							26200
P		●	●	●	●	●	○	○
M		○					●	●
K			○	○	○	○		
N								
S								
H								
O								

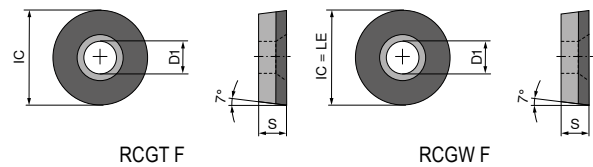
9

RCGT / RCMT

ISO	RE mm	NEW -25P H210T	-27 H10T	NEW -SM CTPX710	-27 CTPX715
		DRAGONSKIN		DRAGONSKIN	DRAGONSKIN
		F RCGT	M RCGT	M RCMT	M RCGT
		70 241 ...	70 266 ...	75 221 ...	70 266 ...
0602M0FN	3		600		70200
0803M0FN	4	60200	602		80200
1003M0FN	5		604		80400
1003M0SN	5			61400	
1204M0FN	6				72800
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..	3,18	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

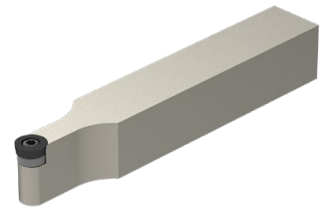
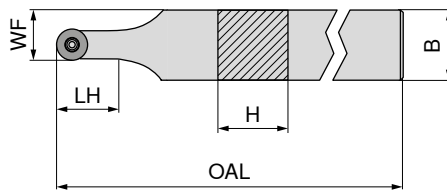
ISO	RE mm	TCE (NOI)	LE mm	CTDPD20	-CB1 CTDPD20	CTDPS30	-CB1 CTDPS30	-CB2 CTDPS30
0602M0FN	3	F	6	71 179 ...	71 315 ...	71 179 ...	71 315 ...	71 316 ...
0803M0FN	4	F	8	10001	102	20001	202	202
1003M0FN	6	F	10	10101		20101		
10T3M0FN	5	F	10	10201				
1204M0FN	6	F	12	10301	104		204	204

ISO	RE mm	TCE (NOI)	LE mm	CTDPD20	-CB1 CTDPD20	CTDPS30	-CB1 CTDPS30	-CB2 CTDPS30
P								
M								
K								
N				•	•	•	•	•
S								
H								
O				•	•	•	•	•

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

Scope of supply:

Tool holder with Torx key



NEW
Neutral
70 646 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	
SRDC N 1212 F06	12	12	80	12,0	9,0	1,2	RC.. 0602	01200
SRDC N 1616 H06	16	16	100	12,0	11,0	1,2	RC.. 0602	01600
SRDC N 2020 K06	20	20	125	12,0	13,0	1,2	RC.. 0602	02000
SRDC N 2525 M06	25	25	150	12,4	15,5	1,2	RC.. 0602	02500
SRDC N 1616 H08	16	16	100	16,0	12,0	1,8	RC.. 0803	11600
SRDC N 2020 K08	20	20	125	16,5	14,0	1,8	RC.. 0803	12000
SRDC N 2525 M08	25	25	150	16,5	16,5	1,8	RC.. 0803	12500
SRDC N 1616 H10	16	16	100	20,9	13,0	3,2	RC.. 1003 / RC.. 10T3	21600
SRDC N 2020 K10	20	20	125	20,0	15,0	3,2	RC.. 1003 / RC.. 10T3	22000
SRDC N 2525 M10	25	25	150	20,9	17,5	3,2	RC.. 1003 / RC.. 10T3	22500

1 When using WSP RC .. 10T3 indexable inserts, use insert seat article no. 70 950 92100.

	Key D	Clamping screw	Solid carbide support R	Threaded sleeve
	80 950 ...	70 950 ...	70 950 ...	70 950 ...
70 646 01200	039	857		
70 646 01600	039	857		
70 646 02000	039	857		
70 646 02500	039	857		
70 646 11600	118	819		
70 646 12000	118	819		
70 646 12500	118	819		
70 646 21600	120	87900	117	171
70 646 22000	120	87900	117	171
70 646 22500	120	87900	117	171

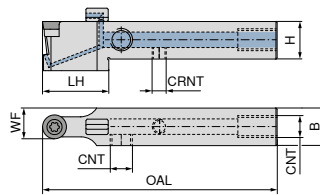
Spare parts for Article no.

70 646 01200
70 646 01600
70 646 02000
70 646 02500
70 646 11600
70 646 12000
70 646 12500
70 646 21600
70 646 22000
70 646 22500

MaxiLock-S – SRDC 0° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



NEW
Neutral
70 775 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	
SRDC N 1212 F06 DC	12	12	80	26	9,0	M6	M6	1,2	RC.. 0602	01200
SRDC N 1616 H06 DC	16	16	100	30	11,0	M6	G1/8"	1,2	RC.. 0602	01600
SRDC N 2020 K06 DC	20	20	125	30	13,0	M6	G1/8"	1,2	RC.. 0602	02000
SRDC N 2525 M06 DC	25	25	150	30	15,5	M6	G1/8"	1,2	RC.. 0602	02500
SRDC N 1616 H08 DC	16	16	100	30	12,0	M6	G1/8"	1,8	RC.. 0803	11600
SRDC N 2020 K08 DC	20	20	125	30	14,0	M6	G1/8"	1,8	RC.. 0803	12000
SRDC N 2525 M08 DC	25	25	150	31	16,5	M6	G1/8"	1,8	RC.. 0803	12500
SRDC N 1616 H10 DC	16	16	100	30	13,0	M6	G1/8"	3,2	RC.. 1003 / RC.. 10T3	21600
SRDC N 2020 K10 DC	20	20	125	30	15,0	M6	G1/8"	3,2	RC.. 1003 / RC.. 10T3	22000
SRDC N 2525 M10 DC	25	25	150	36	17,5	M6	G1/8"	3,2	RC.. 1003 / RC.. 10T3	22500

When using WSP RC .. 10T3 indexable inserts, use insert seat article no. 70 950 92100.

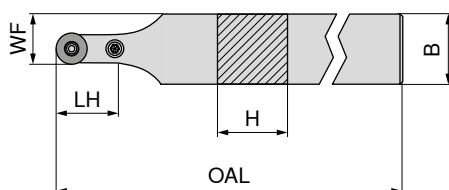
Spare parts for Article no.					
	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 775 01200	857			86700	
70 775 01600	857		88000	86700	
70 775 02000	857		88000	86700	
70 775 02500	857		88000	86700	
70 775 11600	819		88000	86700	
70 775 12000	819		88000	86700	
70 775 12500	819		88000	86700	
70 775 21600	87900	117	88000	86700	171
70 775 22000	87900	117	88000	86700	171
70 775 22500	87900	117	88000	86700	171

Spare parts for Article no.					
	70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...
70 775 01200		039			
70 775 01600	87600	039	88100	87700	294
70 775 02000	87600	039	88100	87700	294
70 775 02500	87600	039	88100	87700	294
70 775 11600	87600	118	88100	87700	294
70 775 12000	87600	118	88100	87700	294
70 775 12500	87600	118	88100	87700	294
70 775 21600	87600	120	88100	87700	294
70 775 22000	87600	120	88100	87700	294
70 775 22500	87600	120	88100	87700	294

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

Scope of supply:

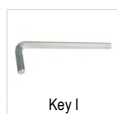
Tool holder with allen key



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	RC.. 1204	025
PRDC N 3225 P12	32	25	170	24	18,5	3	RC.. 1204	032
PRDC N 3225 P16	32	25	170	28	20,5	4	RC.. 1606	132



Key I



Shim



Assembly pin



Lever



Clamping screw



Solid carbide support R

70 950 ...

70 950 ...

70 950 ...

70 950 ...

70 950 ...

70 950 ...

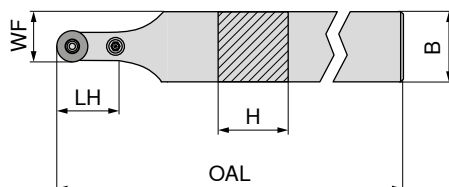
Spare parts for Article no.

70 544 025	SW2,5	175	197	191	178	208	215
70 544 032	SW2,5	175	197	191	178	208	215
70 544 132	SW3	176	196	192	387	390	384

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

Scope of supply:

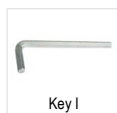
Tool holder with allen key



Neutral

70 545 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	
PRDC N 3232 P20	32	32	170	32	26,0	5	RC.. 2006	23200
PRDC N 4040 S25	40	40	250	42	32,5	6	RCMT 2507 / RCMX 2507	40400



Key I



Shim



Assembly pin



Lever



Clamping screw



Solid carbide support R

70 950 ...

70 950 ...

70 950 ...

70 950 ...

70 950 ...

70 950 ...

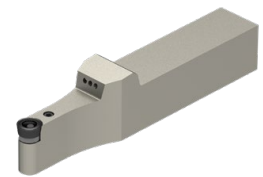
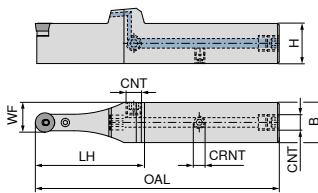
Spare parts for Article no.

70 545 23200	177	391	394	28100	28500	27400
70 545 40400	396	392	395	28400	28600	27500

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

Scope of supply:

Tool holder with allen key



NEW
Neutral
70 595 ...

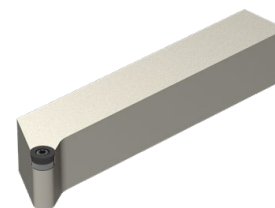
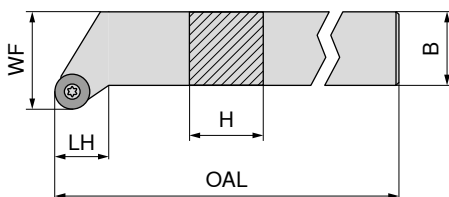
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	
PRDC N 2020 X12-T DC	20	20	132	63	16,0	M6	G1/8"	3	RC.. 1204	02000
PRDC N 2525 X12-T DC	25	25	152	68	18,5	M6	G1/8"	3	RC.. 1204	02500
PRDC N 3225 X12-T DC	32	25	168	68	18,5	M6	G1/8"	3	RC.. 1204	03200
PRDC N 3225 X16-T DC	32	25	172	72	20,5	M6	G1/8"	4	RC.. 1606	13200
PRDC N 3232 X20-T DC	32	32	176	76	26,0	M6	G1/8"	5	RC.. 2006	23200
PRDC N 4040 X25-T DC	40	40	216	91	32,5	M6	G1/8"	6	RCMT 2507 / RCMX 2507	04000

Spare parts for Article no.	Key I	Shim	Assembly pin	Coolant screw plug	Lever	Clamping screw	Solid carbide support R	Grubscrew
70 595 02000	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 595 02500								
70 595 03200								
70 595 13200								
70 595 23200								
70 595 04000								

MaxiLock-S – SRGC – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key

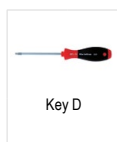


NEW Left-hand **NEW** Right-hand

Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	70 647 ...	70 647 ...
SRGC R/L 1212 F06	12	12	80	12,5	16	1,2	RC.. 0602	01200	01201
SRGC R 1616 H06	16	16	100	12,5	20	1,2	RC.. 0602		01601
SRGC R/L 2020 K06	20	20	125	15,0	25	1,2	RC.. 0602	02000	02001
SRGC R/L 2525 M06	25	25	150	18,5	32	1,2	RC.. 0602	02500	02501
SRGC R/L 1616 H08	16	16	100	13,6	20	1,8	RC.. 0803	11600	11601
SRGC R 2020 K08	20	20	125	16,1	25	1,8	RC.. 0803		12001
SRGC R/L 2525 M08	25	25	150	19,6	32	1,8	RC.. 0803	12500	12501
SRGC R/L 2020 K10	20	20	125	16,1	25	3,2	RC.. 1003 / RC.. 10T3	22000	22001
SRGC R/L 2525 M10	25	25	150	19,6	32	3,2	RC.. 1003 / RC.. 10T3	22500	22501

When using WSP RC .. 10T3 indexable inserts, use insert seat article no. 70 950 92100.

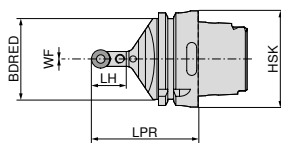
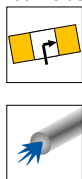


Spare parts for Article no.	80 950 ...	70 950 ...	70 950 ...	70 950 ...
70 647 01200 / 70 647 01201	T08 - IP	039	M2,5x6 - IP	857
70 647 01601	T08 - IP	039	M2,5x6 - IP	857
70 647 02000 / 70 647 02001	T08 - IP	039	M2,5x6 - IP	857
70 647 02500 / 70 647 02501	T08 - IP	039	M2,5x6 - IP	857
70 647 11600 / 70 647 11601	T09 - IP	118	M3x7 - IP	819
70 647 12001	T09 - IP	118	M3x7 - IP	819
70 647 12500 / 70 647 12501	T09 - IP	118	M3x7 - IP	819
70 647 22000 / 70 647 22001	T15 - IP	120	M3,5x11	87900
70 647 22500 / 70 647 22501	T15 - IP	120	M3,5x11	87900
			117	M3,5
			117	M3,5
				171
				171

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

Scope of supply:

Tool holder with allen key



Neutral
74 548 ...

ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert	
HSK T63 PRDC N 12	HSK-T 63	70	53	0	3	RC.. 1204 M0	512
HSK T100 PRDC N 12	HSK-T 100	80	88	0	3	RC.. 1204 M0	712
HSK T100 PRDC N 16	HSK-T 100	80	88	0	4	RC.. 1606 M0	716

Key I	Shim	Assembly pin	Lever	Clamping screw	Solid carbide support R
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...

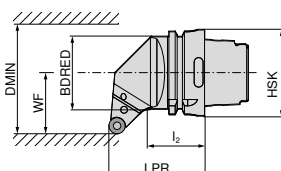
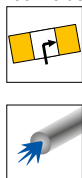
Spare parts for Article no.

74 548 512	SW2,5	175	197	191	178	208	215
74 548 712	SW2,5	175	197	191	178	208	215
74 548 716	SW3	176	196	192	387	390	384

MaxiLock-N – PRSC – Toolholder with lever clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions

Left-hand **74 552 ...**
Right-hand **74 551 ...**

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

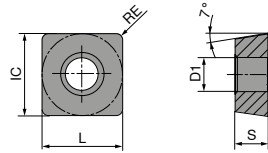
Key I	Shim	Assembly pin	Lever	Clamping screw	Solid carbide support R
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...

Spare parts for Article no.

74 551 512 / 74 552 512	SW2,5	175	197	191	178	208	215
74 551 712 / 74 552 712	SW2,5	175	197	191	178	208	215
74 551 716 / 74 552 716	SW3	176	196	192	387	390	384

SCGT / SCMT

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



SCGT / SCMT

ISO	RE mm	-CF05 CTEP110	-CF55 CTEP110	-SF TCM10	NEW -SF CTCP115-P	NEW -SF CTCP125-P	NEW -SMF CTCP115-P	NEW -SMF CTCP135-P
09T304EN	0,4							
09T308EN	0,8	004 006	004 006	902 904	30601	50401 50601	30401 30601	
120408EN	0,8					51801		71801
P		●	●	●	●	●	●	●
M		○	○	○				○
K		○	○	○	○	○	○	
N								
S								
H								
O								

9

SCMT

ISO	RE mm	-SM CTCK110	-SM CTCK120	NEW -SM CTCP115-P	NEW -SM CTCP125-P	NEW -SM CTCP135-P
09T304EN	0,4					
09T308EN	0,8	004 006	504 506	30401 30601	50401 50601	70401 70601
120408EN	0,8	018	518	31801	51801	71801
120412EN	1,2	020	520		52001	
P		○	○	●	●	●
M						○
K		●	●	○	○	
N						
S						
H						
O						

SCMT

ISO	RE mm	-M25 CTPM125	-SM CTPM125	-M55 CTCM120	-M55 CTPM125	-M55 CTCM130
09T304EN	0,4	70400	20600	10600	206	30600
09T308EN	0,8		21800	11800	218	31800
120408EN	0,8					

Material	-M25	-SM	-M55	-M55	-M55
P	○	○	○	○	○
M	●	●	●	●	●
K					
N					
S					○
H					
O					

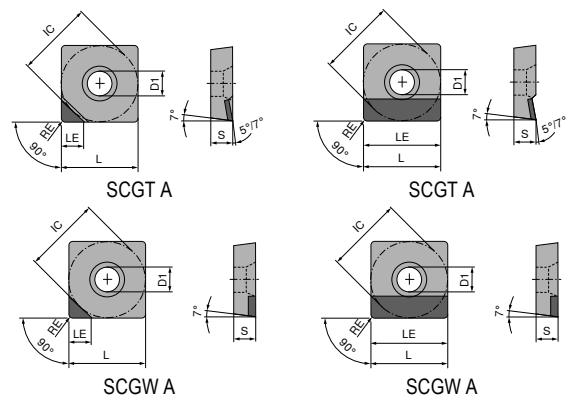
SCGT

ISO	RE mm	-25P H210T	-25P CTPX710	-27 CTPX715	-27 H10T
09T304FN	0,4	80400	600		
09T308FN	0,8	80600	602		
120408FN	0,8	634	71600	71800	604

Material	-25P	-25P	-27	-27
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

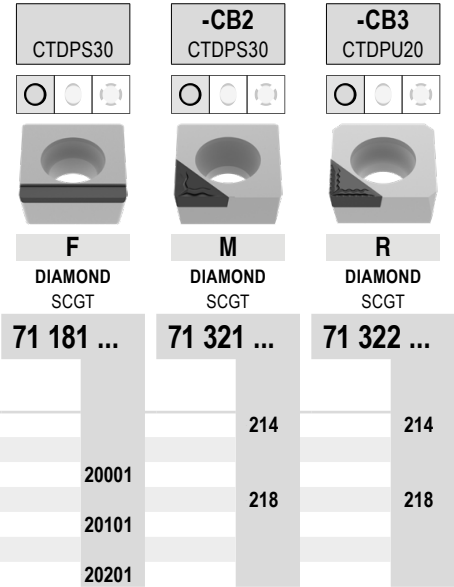
▲ TCE(NOI) = Design and number of equipped cutting edge corners

	CTDPD20	CTDPD20	-CB1 CTDPD20	CTDPS30	CTDPS30
	F	F	F	F	F
	DIAMOND SCGW	DIAMOND SCGW	DIAMOND SCGT	DIAMOND SCGW	DIAMOND SCGT
	71 182 ...	71 183 ...	71 320 ...	71 182 ...	71 180 ...
ISO	RE mm	TCE (NOI)	LE mm		
09T304FN	0,4	A (1)	9,52		
09T304FN	0,4	A (1)	4,40	10001	20001
09T308FN	0,8	A (1)	9,52		
09T308FN	0,8	A (1)	4,30	10101	20101
09T312FN	1,2	A (1)	4,20	10201	20201
120404FN	0,4	A (1)	12,70		
120404FN	0,4	A (1)	4,40	10301	
120408FN	0,8	A (1)	4,30	10401	
120408FN	0,8	A (1)	12,70	10301	
120412FN	1,2	A (1)	4,20	10501	
120412FN	1,2	A (1)	12,70	10401	

P					
M					
K					
N					
S					
H					
O					

SCGT

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



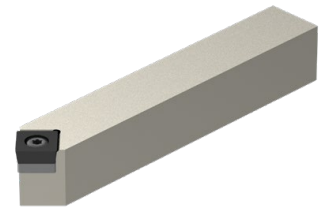
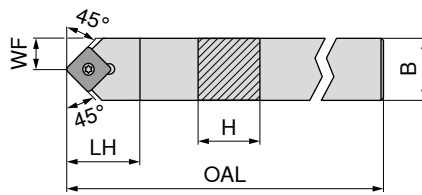
ISO	RE mm	TCE (NOI)	LE mm
09T304FN	0,4	A (1)	4,4
09T308FN	0,8	A (1)	9,5
09T308FN	0,8	A (1)	4,3
120408FN	0,8	A (1)	12,7
120412FN	1,2	A (1)	12,0

P			
M			
K			
N		•	•
S			
H			
O		•	•

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

Scope of supply:

Tool holder with Torx key



NEW
Neutral
70 651 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	
SSDC N 1212 F09	12	12	80	16	6,0	3,2	SC.. 09T3..	01200
SSDC N 1616 H09	16	16	100	20	8,0	3,2	SC.. 09T3..	01600
SSDC N 2020 K09	20	20	125	20	10,0	3,2	SC.. 09T3..	02000
SSDC N 1616 H12	16	16	100	25	8,0	5	SC.. 1204..	11600
SSDC N 2020 K12	20	20	125	25	10,0	5	SC.. 1204..	12000
SSDC N 2525 M12	25	25	150	25	12,5	5	SC.. 1204..	12500

 Key D 80 950 ...	 Clamping screw 70 950 ...	 Solid Carbide support S 70 950 ...	 Threaded sleeve 70 950 ...
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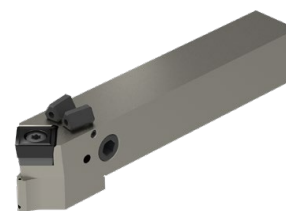
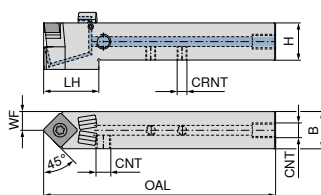
Spare parts for Article no.

Article no.	Key D	Clamping screw	Solid Carbide support S	Threaded sleeve
70 651 01200	120	87900		
70 651 01600	120	87900		
70 651 02000	120	87900	167	171
70 651 11600	120	820	168	170
70 651 12000	120	820	168	170
70 651 12500	120	820	168	170

MaxiLock-S – SSDC 45° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



NEW
Neutral
70 776 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	
SSDC N 1212 F09 DC	12	12	80	25	12,8	M6	M6	3,2	SC..09T3..	01200
SSDC N 1616 H09 DC	16	16	100	30	16,0	M6	G1/8"	3,2	SC..09T3..	01600
SSDC N 2020 K09 DC	20	20	125	30	20,0	M6	G1/8"	3,2	SC..09T3..	02000
SSDC N 1616 H12 DC	16	16	100	29	17,3	M6	G1/8"	5	SC..1204..	11600
SSDC N 2020 K12 DC	20	20	125	30	20,0	M6	G1/8"	5	SC..1204..	12000
SSDC N 2525 M12 DC	25	25	150	30	25,0	M6	G1/8"	5	SC..1204..	02500

**Spare parts
for Article no.**

Article no.	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 776 01200	87900			86700	
70 776 01600	87900	167	88000	86700	171
70 776 02000	87900	167	88000	86700	171
70 776 11600	820	168	88000	86700	170
70 776 12000	820	168	88000	86700	170
70 776 02500	820	168	88000	86700	170

**Spare parts
for Article no.**

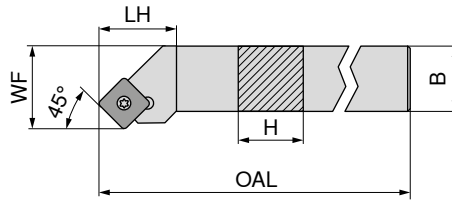
Article no.	70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...
70 776 01200		120			
70 776 01600	87600	120	88100	87700	294
70 776 02000	87600	120	88100	87700	294
70 776 11600	87600	120	88100	87700	294
70 776 12000	87600	120	88100	87700	294
70 776 02500	87600	120	88100	87700	294

Clamping screw	Solid Carbide support S	Grubscrew	Grubscrew	Threaded sleeve
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
Sealing plugs DC	Key D	O-Ring	Coolant nozzle DC	Coolant screw plug
70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...

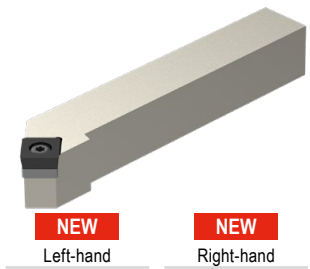
MaxiLock-S – SSSC 45° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



	NEW Left-hand 70 654 ...	NEW Right-hand 70 654 ...
ISO designation		
SSSC R/L 1212 F09	01200	01201
SSSC R/L 1616 H09	01600	01601
SSSC R/L 2020 K09	02000	02001
SSSC R/L 1616 H12	11600	11601
SSSC R/L 2020 K12	12000	12001
SSSC R/L 2525 M12	12500	12501
SSSC R 3225 P12		13201

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert
SSSC R/L 1212 F09	12	12	80	18	16	3,2	SC.. 09T3..
SSSC R/L 1616 H09	16	16	100	20	20	3,2	SC.. 09T3..
SSSC R/L 2020 K09	20	20	125	20	25	3,2	SC.. 09T3..
SSSC R/L 1616 H12	16	16	100	25	20	5	SC.. 1204..
SSSC R/L 2020 K12	20	20	125	25	25	5	SC.. 1204..
SSSC R/L 2525 M12	25	25	150	25	32	5	SC.. 1204..
SSSC R 3225 P12	32	25	170	25	32	5	SC.. 1204..

	80 950 ...	70 950 ...	70 950 ...	70 950 ...
Key D				
Clamping screw				
Solid Carbide support S				
Threaded sleeve				
Spare parts for Article no.				
70 654 01201 / 70 654 01200	120	87900		
70 654 01601 / 70 654 01600	120	87900	167	171
70 654 02001 / 70 654 02000	120	87900	167	171
70 654 11601 / 70 654 11600	120	820	168	170
70 654 12001 / 70 654 12000	120	820	168	170
70 654 12501 / 70 654 12500	120	820	168	170
70 654 13201	120	820	168	170

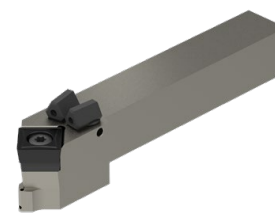
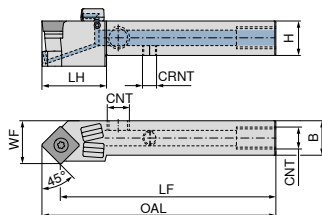
Spare parts
for Article no.

70 654 01201 / 70 654 01200
70 654 01601 / 70 654 01600
70 654 02001 / 70 654 02000
70 654 11601 / 70 654 11600
70 654 12001 / 70 654 12000
70 654 12501 / 70 654 12500
70 654 13201

MaxiLock-S – SSSC 45° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



NEW Left-hand **NEW** Right-hand

70 777 ... 70 777 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	70 777 ...	70 777 ...
SSSC R/L 1212 F09 DC	12	12	86,5	22	16,0	M6	M6	3,2	SC..09T3..	01201	01200
SSSC R/L 1616 H09 DC	16	16	106,5	30	20,0	M6	G1/8"	3,2	SC..09T3..	01601	01600
SSSC R/L 2020 K09 DC	20	20	131,5	30	25,0	M6	G1/8"	3,2	SC..09T3..	02001	02000
SSSC R/L 1616 H12 DC	16	16	108,5	30	20,0	M6	G1/8"	5	SC..1204..	11601	11600
SSSC R/L 2020 K12 DC	20	20	133,5	30	25,0	M6	G1/8"	5	SC..1204..	12001	12000
SSSC R/L 2525 M12 DC	25	25	158,5	32	32,0	M6	G1/8"	5	SC..1204..	02501	02500
SSSC L 3225 P 12 DC	32	25	178,5	32	32,1	G1/8"	G1/8"	5	SC..1204..	03201	

Illustrations show right-hand versions

Clamping screw	Solid Carbide support S	Grubscrew	Grubscrew	Threaded sleeve
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...

Spare parts for Article no.

70 777 01200 / 70 777 01201	859			86700	
70 777 01600 / 70 777 01601	87900	167	88000	86700	171
70 777 02000 / 70 777 02001	87900	167	88000	86700	171
70 777 11600 / 70 777 11601	820	168	88000	86700	170
70 777 12000 / 70 777 12001	820	168	88000	86700	170
70 777 02500 / 70 777 02501	820	168	88000	86700	170
70 777 03201	820	168	88000		170

Sealing plugs DC	Key D	O-Ring	Coolant nozzle DC	Coolant screw plug
70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...

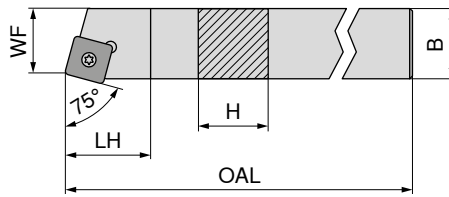
Spare parts for Article no.

70 777 01200 / 70 777 01201		120			
70 777 01600 / 70 777 01601	87600	120	88100	87700	294
70 777 02000 / 70 777 02001	87600	120	88100	87700	294
70 777 11600 / 70 777 11601	87600	120	88100	87700	294
70 777 12000 / 70 777 12001	87600	120	88100	87700	294
70 777 02500 / 70 777 02501	87600	120	88100	87700	294
70 777 03201	87600	120	88100	87700	294

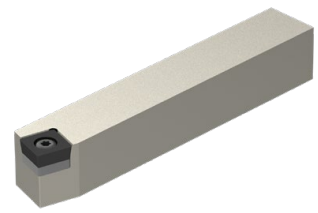
MaxiLock-S – SSBC 75° – Toolholder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions



	NEW Left-hand	NEW Right-hand
70 650 ...		
	12000	12001
	12500	12501

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert		
SSBC R/L 2020 K12	20	20	125	20	17	5	SC.. 1204..		
SSBC R/L 2525 M12	25	25	150	20	22	5	SC.. 1204..		

Key D	Clamping screw	Solid Carbide support S	Threaded sleeve
80 950 ...	70 950 ...	70 950 ...	70 950 ...
120	820	168	170
120	820	168	170

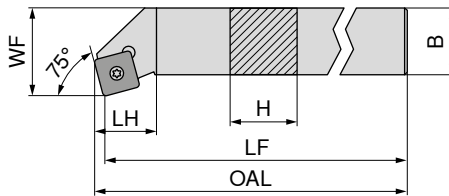
**Spare parts
for Article no.**

70 650 12001 / 70 650 12000
70 650 12501 / 70 650 12500

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

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions



	Left-hand	Right-hand
70 669 ...		
	016	016
	020	020
	120	120
	125	125

ISO designation	H mm	B mm	LF mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert		
SSKC R/L 1616 H09	16	16	100	102,3	22	20	3,2	SC.. 09T3..		
SSKC R/L 2020 K09	20	20	125	127,3	22	25	3,2	SC.. 09T3..		
SSKC R 2020 K12	20	20	125	127,3	23	25	5	SC.. 1204..		
SSKC R 2525 M12	25	25	150	153,3	23	32	5	SC.. 1204..		

Key D	Combination Key	Clamping screw	Solid Carbide support S	Threaded sleeve
80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
113	398	113	167	171
113	398	113	167	171
113	398	114	168	170
113	398	114	168	170

**Spare parts
for Article no.**

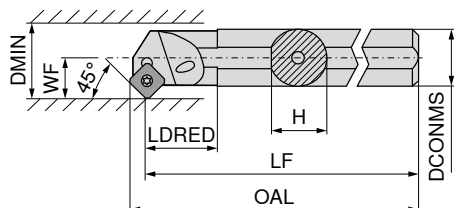
70 668 016 / 70 669 016
70 668 020 / 70 669 020
70 668 120
70 668 125

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

▲ A... = with thro' coolant
▲ S... = without thro' coolant

Scope of supply:

Tool holder with Torx key



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	Article no.	
										Left-hand 70 721 ...	Right-hand 70 720 ...
S16R SSSC R 09	16	15,00	200	206,0	13,97	11	20	3,2	SC.. 09T3..		016
A16M SSSC R/L 09	16	15,25	150	156,0	29,00	11	20	3,2	SC.. 09T3..	216	216
A20Q SSSC R/L 09	20	19,00	180	186,0	32,00	13	25	3,2	SC.. 09T3..	220	220
A25R SSSC R/L 09	25	24,50	200	206,0	36,00	17	32	3,2	SC.. 09T3..	225	225
A32S SSSC R/L 12	32	31,00	250	258,3	50,00	22	40	5	SC.. 1204..	232	232
A40T SSSC R/L 12	40	39,00	300	308,1	60,00	27	50	5	SC.. 1204..	240	240

Part	Article no.
Key D	80 950 ...
Combination Key	70 950 ...
Clamping screw	70 950 ...
Solid Carbide support S	70 950 ...
Threaded sleeve	70 950 ...

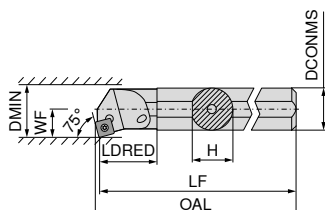
Spare parts for Article no.

70 720 016	113										
70 720 216 / 70 721 216	113										
70 720 220 / 70 721 220	113										
70 720 225 / 70 721 225	113										
70 720 232 / 70 721 232								398		114	170
70 720 240 / 70 721 240								398		114	170

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

Scope of supply:

Tool holder with Torx key



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	Article no.	
										Left-hand 70 725 ...	Right-hand 70 724 ...
A16M SSKC R/L 09	16	15,0	150	152,4	29	11	20	3,2	SC.. 09T3..	216	216
A20Q SSKC R/L 09	20	18,5	180	182,4	32	13	25	3,2	SC.. 09T3..	220	220
A25R SSKC R/L 09	25	23,0	200	202,4	36	17	32	3,2	SC.. 09T3..	225	225

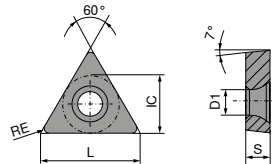
Part	Article no.
Key D	80 950 ...
Clamping screw	70 950 ...

Spare parts for Article no.

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

ISO	RE mm	-CF05 CTEP110		-CF55 CTEP110		-SF TCM10		-SMF TCM10		NEW -SF CTCP125-P		NEW -SMF CTCP115-P		NEW -SMF CTCP135-P	
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F	F	F	F	F	F	F	F	F	F	F	F	F	
		CERMET TCGT	CERMET TCMT	CERMET TCGT	CERMET TCMT	CERMET TCGT	CERMET TCMT	CERMET TCMT	CERMET TCMT	TCMT	TCMT	TCMT	TCMT	TCMT	
		76 272 ...	76 266 ...	70 273 ...	70 284 ...	76 275 ...	76 284 ...	76 284 ...	76 284 ...						
110202EN	0,2	014		900											
110204EN	0,4	016	016	902	902	51601									
110208EN	0,8	018				51801					31801			71801	
16T304EN	0,4	028		906		52801					32801				
16T308EN	0,8		030			53001					33001				
P		●	●	●	●	●	●	●	●	●	●	●	●	●	
M		○	○	○	○	○	○	○	○	○	○	○	○	○	
K		○	○	○	○	○	○	○	○	○	○	○	○	○	
N															
S															
H															
O															

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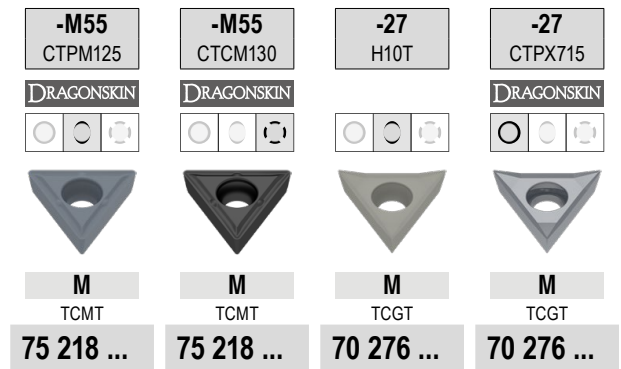
TCGT / TCMT

		NEW		NEW		NEW		NEW	
		-SM CTCP135-P	-SM CTCK110	-SM CTCK120	-SM CTCP115-P	-SM CTCP115-P	-SM CTCP125-P	-SM CTCP135-P	
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	
		M TCGT	M TCMT	M TCMT	M TCMT	M TCMT	M TCMT	M TCMT	
		76 270 ...	70 274 ...	70 274 ...	76 189 ...	76 274 ...	76 274 ...	76 274 ...	
ISO	RE mm	71401							
090204EN	0,4						50401		70401
110202EN	0,2								
110204EN	0,4		016	516		31601	51601		71601
110208EN	0,8		018	518		31801			71801
16T304EN	0,4		028	528		32801	52801		72801
16T308EN	0,8		030	530		33001	53001		73001
16T312EN	1,2		032	532					
220408EN	0,8				34201		54201		74201
P		●	○	○	●	●	●	●	●
M		○	○	○	○	○	○	○	○
K			●	●	○	○	○		
N									
S									
H									
O									

TCMT

		NEW		NEW		NEW	
		-F43 CTCM130	-M25 CTCM120	-M25 CTPM125	-M25 CTCM130	-SM CTPM125	-M55 CTCM120
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F TCMT	F TCMT	F TCMT	F TCMT	M TCMT	M TCMT
		75 033 ...	75 217 ...	75 217 ...	75 217 ...	75 050 ...	75 218 ...
ISO	RE mm						
090204EN	0,4			20400		20400	10400
110204EN	0,4	31600	11600	216	31600	21600	11600
16T304EN	0,4	32800	12800	228	32800	22800	
16T308EN	0,8	33000	13000	230	33000	23000	13000
220408EN	0,8					24200	
220412EN	1,2					24400	
P		○	○	○	○	○	○
M		●	●	●	●	●	●
K							
N							
S		○			○		
H							
O							

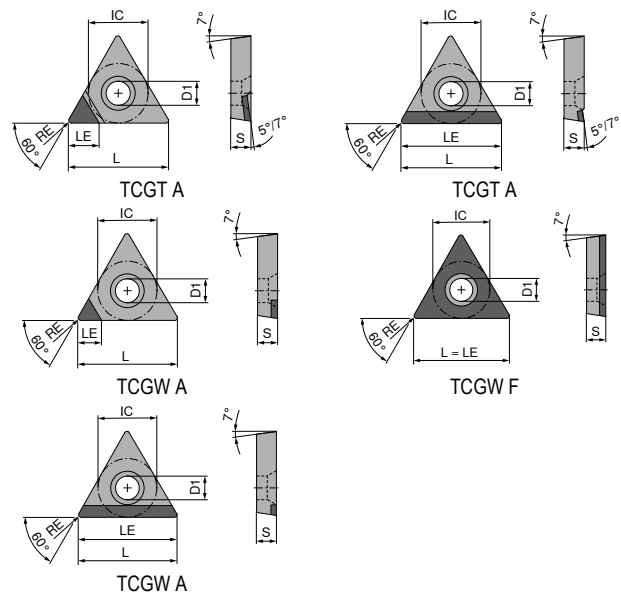
TCMT / TCGT



ISO	RE mm	75 218 ... M TCMT	75 218 ... M TCMT	70 276 ... M TCGT	70 276 ... M TCGT
090204EN	0,4	204	30400		
110202FN	0,2			600	71400
110204EN	0,4	216	31600	602	81600
110204FN	0,4			604	
16T302FN	0,2			606	72800
16T304FN	0,4			608	
16T308EN	0,8	230	33000		
16T308FN	0,8				83000
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

ISO	RE mm	TCE (NOI)	LE mm	CTDPD20						-CB1	CTDPS30
				71 188 ...	71 187 ...	71 140 ...	71 184 ...	71 325 ...	71 184 ...		
090202FN	0,2	A (1)	3,7								
090204FN	0,4	A (1)	3,4								
090208FN	0,8	A (1)	3,0								
090208FN	0,8	A (1)	9,6	10001							
110202FN	0,2	A (1)	3,7								
110202FN	0,2	F	11,0		10001						
110204FN	0,4	A (1)	3,4								
110204FN	0,4	F	11,0		10101						
110204FN	0,4	A (1)	11,0	10101							
110208FN	0,8	A (1)	3,0								
110208FN	0,8	A (1)	11,0	10201							
16T304FN	0,4	A (1)	4,6								
16T304FN	0,4	A (1)	16,5	10301							
16T308FN	0,8	A (1)	4,2								
16T308FN	0,8	A (1)	16,5	10401							
16T312FN	1,2	A (1)	3,8			11600					

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

TCGW / TCGT

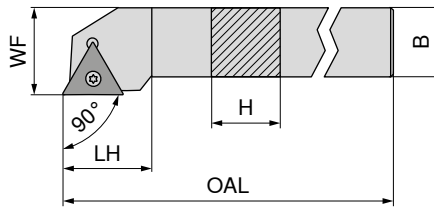
▲ TCE(NOI) = Design and number of equipped cutting edge corners

ISO	RE mm	TCE (NOI)	LE mm	Insert Options					
				CTDPS30	CTDPS30	-CB2 CTDPS30	CTDPU20	-CB3 CTDPU20	CTDCD10
				F DIAMOND TCGW	F DIAMOND TCGT	M DIAMOND TCGT	F DIAMOND TCGW	R DIAMOND TCGT	F DIAMOND TCGW
				71 186 ...	71 185 ...	71 326 ...	71 188 ...	71 327 ...	71 186 ...
090202FN	0,2	A (1)	3,7	20001		212			
090204FN	0,4	A (1)	3,4			214			
090204FN	0,4	A (1)	9,6		20001				
110202FN	0,2	A (1)	2,6						40001
110202FN	0,2	A (1)	3,7	20101		222			
110204FN	0,4	A (1)	2,3						40101
110204FN	0,4	A (1)	3,4	20201		224		224	
110204FN	0,4	A (1)	11,0		20101		30001		
110208FN	0,8	A (1)	2,0		20201				40201
110208FN	0,8	A (1)	11,0						
16T304FN	0,4	A (1)	2,3						40301
16T304FN	0,4	A (1)	4,6		20301	234			
16T304FN	0,4	A (1)	16,5						
16T308FN	0,8	A (1)	2,0						40401
16T308FN	0,8	A (1)	4,2					238	
16T308FN	0,8	A (1)	16,5		20401				
P	[Color bar]								
M	[Color bar]								
K	[Color bar]								
N		•	•	•	•	•	•	•	•
S	[Color bar]								
H	[Color bar]								
O		•	•	•	•	•	•	•	•

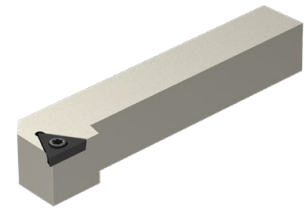
MaxiLock-S – STGC 90° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



NEW Left-hand **70 659 ...**
NEW Right-hand **70 659 ...**

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand	Right-hand
STGC R/L 1212 F11	12	12	80	15	16	1,2	TC.. 1102	01200	01201
STGC R/L 1616 H16	16	16	100	22	20	3,2	TC.. 16T3	01600	01601
STGC R/L 2020 K16	20	20	125	22	25	3,2	TC.. 16T3	02000	02001
STGC R/L 2525 M16	25	25	150	22	32	3,2	TC.. 16T3	02500	02501

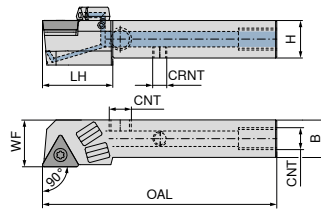
Part Name	Article No.
Key D	80 950 ...
Clamping screw	70 950 ...
Solid Carbide Seat T	70 950 ...
Threaded sleeve	70 950 ...

Spare parts for Article no.	Key D	Clamping screw	Solid Carbide Seat T	Threaded sleeve
70 659 01201 / 70 659 01200	039	857		
70 659 01601 / 70 659 01600	120	87900	169	171
70 659 02001 / 70 659 02000	120	87900	169	171
70 659 02501 / 70 659 02500	120	87900	169	171

MaxiLock-S – STGC 90° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions

NEW Left-hand **70 778 ...**
NEW Right-hand **70 778 ...**

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	70 778 ...	70 778 ...
STGC R/L 1212 F11 DC	12	12	80	17,1	16	M6	M6	1,2	TC.. 1102	01201	01200
STGC R/L 1616 H16 DC	16	16	100	30,0	20	M6	G1/8"	3,2	TC.. 16T3	01601	01600
STGC R/L 2020 K16 DC	20	20	125	28,0	25	M6	G1/8"	3,2	TC.. 16T3	02001	02000
STGC R/L 2525 M16 DC	25	25	150	30,0	32	M6	G1/8"	3,2	TC.. 16T3	02501	02500

Spare parts for Article no.

70 778 01200 / 70 778 01201	857			86700	
70 778 01600 / 70 778 01601	87900	169	88000	86700	171
70 778 02000 / 70 778 02001	87900	169	88000	86700	171
70 778 02500 / 70 778 02501	87900	169	88000	86700	171

Clamping screw 70 950 ...	Solid Carbide Seat T 70 950 ...	Grubscrew 70 950 ...	Grubscrew 70 950 ...	Threaded sleeve 70 950 ...
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Spare parts for Article no.

70 778 01200 / 70 778 01201		039			
70 778 01600 / 70 778 01601	87600	120	88100	87700	294
70 778 02000 / 70 778 02001	87600	120	88100	87700	294
70 778 02500 / 70 778 02501	87600	120	88100	87700	294

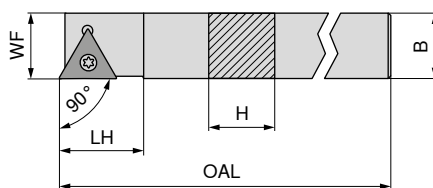
Sealing plugs DC 70 950 ...	Key D 80 950 ...	O-Ring 70 950 ...	Coolant nozzle DC 70 950 ...	Coolant screw plug 70 950 ...
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MaxiLock-S – STAC 90° – Toolholder with screw clamping

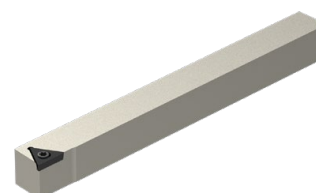
▲ for sliding head lathes

Scope of supply:

Tool holder with Torx key

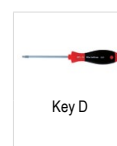


Illustrations show right-hand versions



	NEW Left-hand	NEW Right-hand
70 655 ...	01200	01201

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert
STAC R/L 1212 K11	12	12	125	15	12	1,2	TC.. 1102



80 950 ...



70 950 ...

Spare parts for Article no.

70 655 01201 / 70 655 01200

T08 - IP

039

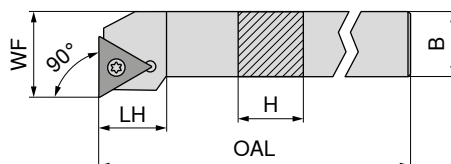
M2,5x6 - IP

857

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

Scope of supply:

Tool holder with Torx key

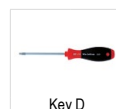


Illustrations show right-hand versions



	NEW Left-hand	NEW Right-hand
70 658 ...	01200	01201
70 658 ...	01600	01601
70 658 ...	02000	02001
70 658 ...	02500	02501

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert
STFC R/L 1212 F11	12	12	80	15	16	1,2	TC.. 1102
STFC R/L 1616 H16	16	16	100	20	20	3,2	TC.. 16T3
STFC R/L 2020 K16	20	20	125	20	25	3,2	TC.. 16T3
STFC R/L 2525 M16	25	25	150	20	32	3,2	TC.. 16T3



80 950 ...



70 950 ...



70 950 ...



70 950 ...

Spare parts for Article no.

70 658 01200 / 70 658 01201

039

857

70 658 01600 / 70 658 01601

120

87900

169

171

70 658 02000 / 70 658 02001

120

87900

169

171

70 658 02500 / 70 658 02501

120

87900

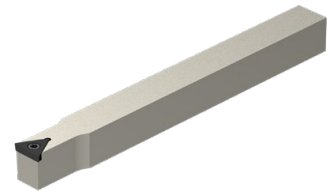
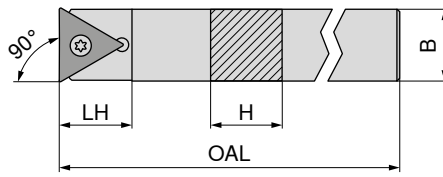
169

171

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

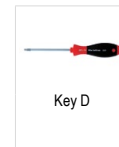
Scope of supply:

Tool holder with Torx key



NEW
Neutral
70 657 ...

ISO designation	H mm	B mm	OAL mm	LH mm	torque moment Nm	Insert	
STCC N 0808 K09	8	8	125	11	1	TC.. 0902	00800
STCC N 1010 K11	10	10	125	15	1,2	TC.. 1102	01000
STCC N 1212 K11	12	12	125	15	1,2	TC.. 1102	01200
STCC N 1414 K11	14	14	125	21	1,2	TC.. 1102	01400
STCC N 1616 K11	16	16	125	24	1,2	TC.. 1102	01600



80 950 ...



70 950 ...

Spare parts for Article no.

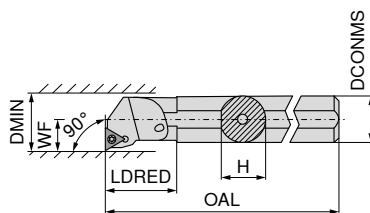
70 657 00800	T07 - IP	117	M2,2x5 - IP	856
70 657 01000	T08 - IP	039	M2,5x6 - IP	857
70 657 01200	T08 - IP	039	M2,5x6 - IP	857
70 657 01400	T08 - IP	039	M2,5x6 - IP	857
70 657 01600	T08 - IP	039	M2,5x6 - IP	857

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

- ▲ A... = with thro' coolant
- ▲ S... = without thro' coolant

Scope of supply:

Boring bar with Torx key



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 ...	70 729 ...	70 728 ...
A10H STFC R/L 09	10	9,5	100	19	7	13	1	TC.. 0902	210		210	
A12K STFC R/L 11	12	11,5	125	22	9	16	1,2	TC.. 1102	212		212	
A16M STFC R/L 11	16	15,0	150	29	11	20	1,2	TC.. 1102	216		216	
S16R STFC R 11	16	15,0	200	21	11	21	1,2	TC.. 1102				016
S20S STFC R 11	20	18,0	250	15	13	25	1,2	TC.. 1102				020
A20Q STFC R/L 11	20	18,5	180	32	13	25	1,2	TC.. 1102	220		220	
A25R STFC R/L 16	25	24,0	200	36	17	32	3,2	TC.. 16T3	225		225	
A32S STFC R/L 16	32	31,0	250	50	22	40	3,2	TC.. 16T3	232		232	
A40T STFC R/L 16	40	39,0	300	60	27	50	3,2	TC.. 16T3	240		240	

Spare parts for Article no.

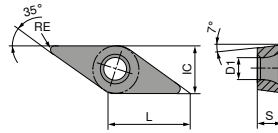
Article no.	Part description	70 950 ...	70 950 ...	70 950 ...
70 728 020	M2,5x6 - T08	13800		
70 729 210 / 70 728 210	M2,2x5	111		
70 728 016	M2,5x6 - T08	13800		
70 729 212 / 70 728 212	M2,5x6 - T08	13800		
70 729 216 / 70 728 216	M2,5x6 - T08	13800		
70 729 220 / 70 728 220	M2,5x6 - T08	13800		
70 729 225 / 70 728 225	M3,5x11	113	169	M3,5 171
70 729 232 / 70 728 232	M3,5x11	113	169	M3,5 171
70 729 240 / 70 728 240	M3,5x11	113	169	M3,5 171

Spare parts for Article no.

Article no.	Part description	80 950 ...	70 950 ...
70 728 020	T08	110	
70 729 210 / 70 728 210	T07	109	
70 728 016	T08	110	
70 729 212 / 70 728 212	T08	110	
70 729 216 / 70 728 216	T08	110	
70 729 220 / 70 728 220	T08	110	
70 729 225 / 70 728 225	T15/SW		398
70 729 232 / 70 728 232	T15/SW		398
70 729 240 / 70 728 240	T15/SW		398

VCGT / VCMT / VCET

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



VCGT / VCMT

		-CF05 CTEP110	-CF55 CTEP110	-SF TCM407	-SF TCM10	-SMF TCM10	NEW -SF CTCP115-P	NEW -SF CTCP115-P
		DRAGONSKIN	DRAGONSKIN				DRAGONSKIN	DRAGONSKIN
		F CERMET VCGT	F CERMET VCMT	F CERMET VCGT	F CERMET VCGT	F CERMET VCMT	F VCMT	F VCMT
		76 276 ...	76 292 ...	70 277 ...	70 277 ...	70 288 ...	76 279 ...	76 277 ...
ISO	RE mm							
110301EN	0,1							
110302EN	0,2	014			892			
110304EN	0,4	016	016	844	894			31401
110308EN	0,8			846	896	896		31601
160404EN	0,4	028	028	850	900	900	32801	31801
160408EN	0,8	030	030		902	902	33001	
P		●	●	●	●	●	●	●
M		○	○	○	○	○	○	○
K		○	○	○	○	○	○	○
N								
S								
H								
O								

9

VCGT / VCMT

		NEW -SF CTCP125-P	NEW -SF CTCP125-P	NEW -SF CTCP135-P	NEW -SF CTCP135-P	NEW -SMF CTCP115-P	NEW -SMF CTCP125-P	NEW -SMF CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F VCGT	F VCMT	F VCGT	F VCMT	F VCMT	F VCMT	F VCMT
		76 277 ...	76 279 ...	76 277 ...	76 279 ...	76 288 ...	76 288 ...	76 285 ...
ISO	RE mm							
110302EN	0,2	51401		71401				71401
110304EN	0,4	51601		71601		31601	51601	
110308EN	0,8	51801		71801				
160404EN	0,4		52801		72801	32801	52801	
160408EN	0,8		53001			33001	53001	
P		●	●	●	●	●	●	●
M				○	○			○
K		○	○			○	○	
N								
S								
H								
O								

VCMT

ISO	RE mm	76 288 ...	70 278 ...	70 278 ...	76 278 ...	76 278 ...	76 278 ...
110304EN	0,4	71601					
160404EN	0,4	72801	028	528	32801	52801	72801
160406EN	0,6				32901		
160408EN	0,8	73001	030	530	33001	53001	73001
160412EN	1,2		032	532	33201	53201	73201

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

VCGT / VCMT

ISO	RE mm	75 045 ...	75 046 ...	75 219 ...	75 219 ...	75 219 ...	75 051 ...	75 220 ...
110302EN	0,2	21400						
110304EN	0,4	21600						
160404EN	0,4		22800	12800	228	32800	22800	12800
160408EN	0,8		23000	13000	23000	33000	23000	13000

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

VCMT / VCGT

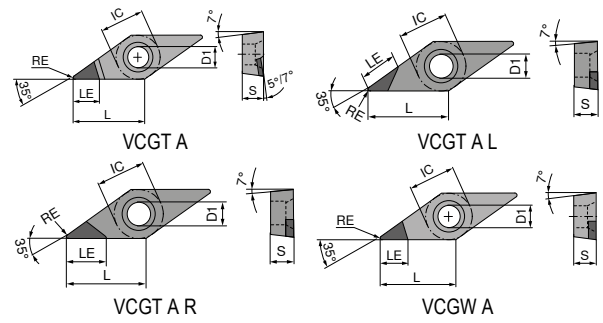
		-M55 CTPM125		-M55 CTCM130		-25P H210T		-25P CTPX710		-25Q H210T		NEW -25Q CTPX710	
		DRAGONSKIN		DRAGONSKIN				DRAGONSKIN					
		M VCMT		M VCMT		F VCGT		M VCGT		M VCGT		M VCGT	
		75 220 ...		75 220 ...		70 282 ...		70 282 ...		70 282 ...		70 282 ...	
ISO	RE mm												
110302FN	0,2					638		71400					
110304FL	0,4					640		71600		670		81600	
110304FN	0,4					640		71600		680		81700	
110304FR	0,4												
160404EN	0,4	228		32800		642		72800					
160404FN	0,4					642		72800					
160408EN	0,8	230		33000		644		73000					
160408FN	0,8					646		73200					
160412FN	1,2					648		75000					
220530FN	3,0					648		75000					
P		○		○		●		●		●		●	
M		●		●		●		●		●		●	
K						○		○		○		○	
N						●		●		●		●	
S				○		○		●		○		●	
H													
O						○		○		○		○	

VCGT / VCMT / VCET

		-27 H10T		-27 CTPX715 DRAGONSKIN		-29 H216T		NEW -29 CTPX715 DRAGONSKIN		-F05 CTPX710 DRAGONSKIN	
		M VCGT		M VCGT		M VCMT		M VCMT		F VCET	
		70 280 ...		70 280 ...		70 247 ...		70 247 ...		76 255 ...	
ISO	RE mm										
1103005FN	0,05										11400
110301FN	0,10										11600
1103015FN	0,15										11800
110302FN	0,20		606		81400						12000
160404EN	0,40						62800		72800		
110304FN	0,40		608		81600						12200
160404FN	0,40		612		82800						
160408EN	0,80						63000		73000		
160408FN	0,80		614		83000						
110308FN	0,80		610		71800						
160412FN	1,20		616								
160412EN	1,20						63200		73200		
220530FN	3,00		618								
P					●				●		●
M					●				●		●
K		○		○		○		○			
N		●		●		●		●			●
S				●				●			●
H											
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. 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

ISO	RE mm	TCE (NOI)	LE mm	CTDMD05						CTDPD20							
				71 189 ...	71 160 ...	71 160 ...	71 062 ...	71 063 ...	71 064 ...	71 189 ...	71 160 ...	71 160 ...	71 062 ...	71 063 ...	71 064 ...		
070202FN	0,2	A (1)		50001													
070204FN	0,4	A (1)		50101													
110301FN	0,1	A (1)	5,4														
110302FN	0,2	A (1)	3,0														
110302FN	0,2	A (1)	4,6	50201													
110304FN	0,4	A (1)	3,0														
110304FN	0,4	A (1)	3,9	50301													
110304FR	0,4	A (1)	6,5														
110304FL	0,4	A (1)	6,5														
110308FN	0,8	A (1)	3,3														
110308FR	0,8	A (1)	6,0														
110308FL	0,8	A (1)	6,0														
160401FN	0,1	A (1)	6,0														
160402FN	0,2	A (1)	5,9														
160402FN	0,2	A (1)		50401													
160404FN	0,4	A (1)	5,5														
160404FN	0,4	A (1)		50501													
160404FR	0,4	A (1)	7,5														
160404FL	0,4	A (1)	7,5														
160408FN	0,8	A (1)	5,0														
160408FR	0,8	A (1)	7,0														
160408FL	0,8	A (1)	7,0														
160408FN	0,8	A (1)		50601													
160412FN	1,2	A (1)	4,5														
160412FR	1,2	A (1)	7,0														
160412FL	1,2	A (1)	7,0														
P																	
M																	
K																	
N																	
S																	
H																	
O																	

VCGT / VCGW

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

ISO	RE mm	TCE (NOI)	LE mm	Insert Options									
				71 330 ...	71 191 ...	71 189 ...	71 330 ...	71 331 ...	71 191 ...				
				-CB1 CTDPD20		CTDPS30		-CB1 CTDPS30		-CB2 CTDPS30		CTDPU20	
				F DIAMOND VCGT		F DIAMOND VCGW		F DIAMOND VCGT		M DIAMOND VCGT		F DIAMOND VCGW	
070201FN	0,1	A (1)	3,8										
070202FN	0,2	A (1)	3,6										
070204FN	0,4	A (1)	3,2										
110301FN	0,1	A (1)	5,4	11000	20201	20101							
110302FN	0,2	A (1)	4,6	112	20301	20201	21200		212				
110304FN	0,4	A (1)	3,9	114	20401	20301	214		214				
110308FN	0,8	A (1)	3,3						21800				
130302FN	0,2	A (1)	5,9		20501	20401							
160401FN	0,1	A (1)	6,0		20601	20501							
160402FN	0,2	A (1)	5,9	13200		20601			23200				
160404FN	0,4	A (1)	5,5	134	20701	20701	234		234				30001
160408FN	0,8	A (1)	5,0	138	20801		238		238				
160412FN	1,2	A (1)	4,5	14000	20901		24000		242				
P													
M													
K													
N				•	•	•	•	•	•	•	•	•	•
S													
H													
O				•	•	•	•	•	•	•	•	•	•

VCGT / VCGW

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

	-CB2 CTDPU20	-CB3 CTDPU20	CTDCD10	-CB1 CTDCD10	-CB2 CTDCD10
	M DIAMOND VCGT	R DIAMOND VCGT	F DIAMOND VCGW	F DIAMOND VCGT	M DIAMOND VCGT
	71 190 ...	71 332 ...	71 191 ...	71 330 ...	71 331 ...

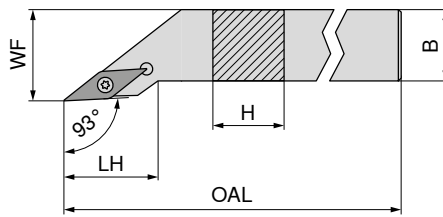
ISO	RE mm	TCE (NOI)	LE mm	71 190 ...	71 332 ...	71 191 ...	71 330 ...	71 331 ...
110301FN	0,1	A (1)	3,0				31000	
110302FN	0,2	A (1)	3,0			40001	312	312
110304FN	0,4	A (1)	3,0			40101	314	314
110304FN	0,4	A (1)	3,9		214			
110308FN	0,8	A (1)	3,0			40201		
160402FN	0,2	A (1)	3,0			40301	32200	33200
160404FN	0,4	A (1)	3,0			40401	32400	334
160404FN	0,4	A (1)	5,5	30001	234			
160408FN	0,8	A (1)	3,0			40501	32600	338
160412FN	1,2	A (1)	3,0				32800	34000

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

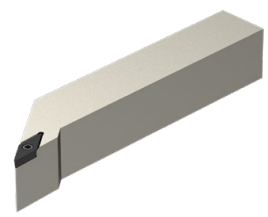
MaxiLock-S – SVJC 93° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



	NEW Left-hand 70 663 ...	NEW Right-hand 70 663 ...
SVJC R/L 1212 F11	01200	01201
SVJC R/L 1616 H11	01600	01601
SVJC R/L 2020 K11	02000	02001
SVJC R/L 2525 M11	02500	02501
SVJC R/L 2020 K16	12000	12001
SVJC R/L 2525 M16	12500	12501
SVJC R/L 3225 P16	13200	13201

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert
SVJC R/L 1212 F11	12	12	80	21,6	16	1,2	VC.. 1103
SVJC R/L 1616 H11	16	16	100	21,6	20	1,2	VC.. 1103
SVJC R/L 2020 K11	20	20	125	23,0	25	1,2	VC.. 1103
SVJC R/L 2525 M11	25	25	150	25,5	32	1,2	VC.. 1103
SVJC R/L 2020 K16	20	20	125	29,4	25	3,2	VC.. 1604
SVJC R/L 2525 M16	25	25	150	32,5	32	3,2	VC.. 1604
SVJC R/L 3225 P16	32	25	170	32,5	32	3,2	VC.. 1604

**Spare parts
for Article no.**

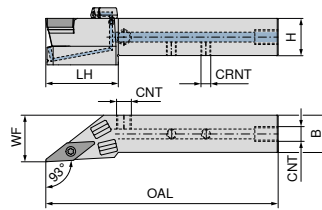
70 663 01201 / 70 663 01200
70 663 01601 / 70 663 01600
70 663 02001 / 70 663 02000
70 663 02501 / 70 663 02500
70 663 12001 / 70 663 12000
70 663 12501 / 70 663 12500
70 663 13201 / 70 663 13200

Key D	Clamping screw	Solid Carbide Seat V	Threaded sleeve
80 950 ...	70 950 ...	70 950 ...	70 950 ...
039	857		
039	857		
039	857		
039	857		
120	87900	107	171
120	87900	107	171
120	87900	107	171

MaxiLock-S – SVJC 93° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions

NEW Left-hand **70 780 ...**
NEW Right-hand **70 780 ...**

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	70 780 ...	70 780 ...
SVJC R/L 1212 F11 DC	12	12	80	30	16	M6	M6	1,2	VC.. 1103	01201	01200
SVJC R/L 1616 H11 DC	16	16	100	27	20	M6	G1/8"	1,2	VC.. 1103	01601	01600
SVJC R/L 2020 K11 DC	20	20	125	39	25	M6	G1/8"	1,2	VC.. 1103	02001	02000
SVJC R/L 2525 M11 DC	25	25	150	41	32	M6	G1/8"	1,2	VC.. 1103	02501	02500
SVJC R/L 2020 K16 DC	20	20	125	39	25	M6	G1/8"	3,2	VC.. 1604	12001	12000
SVJC R/L 2525 M16 DC	25	25	150	41	32	M6	G1/8"	3,2	VC.. 1604	12501	12500
SVJC R/L 3225 P16 DC	32	25	170	41	32	G1/8"	G1/8"	3,2	VC.. 1604	03201	03200

Spare parts for Article no.

70 780 01200 / 70 780 01201	70 780 01600 / 70 780 01601	70 780 02000 / 70 780 02001	70 780 02500 / 70 780 02501	70 780 12000 / 70 780 12001	70 780 12500 / 70 780 12501	70 780 03200 / 70 780 03201
857	857	857	857	87900	87900	87900
				107	107	107
			88000	88000	88000	88000
			86700	86700	86700	86700
						171
						171

Spare parts for Article no.

70 780 01200 / 70 780 01201	70 780 01600 / 70 780 01601	70 780 02000 / 70 780 02001	70 780 02500 / 70 780 02501	70 780 12000 / 70 780 12001	70 780 12500 / 70 780 12501	70 780 03200 / 70 780 03201
						039
87600	87600	87600	87600	87600	87600	87600
						039
						039
						120
						120
						88100
						87700
						294
						294

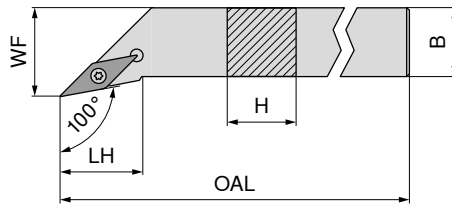
Clamping screw	Solid Carbide Seat V	Grubscrew	Grubscrew	Threaded sleeve
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...

Sealing plugs DC	Key D	O-Ring	Coolant nozzle DC	Coolant screw plug
70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...

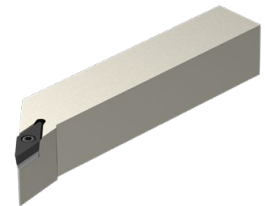
MaxiLock-S – SVZC 100° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



NEW	NEW
Left-hand	Right-hand
70 667 ...	70 667 ...
02500	02501

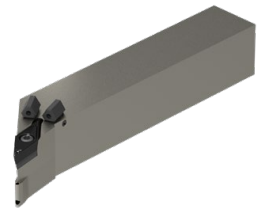
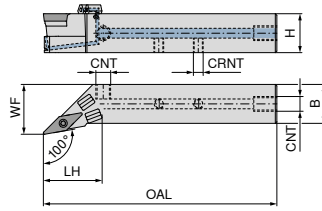
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert
SVZC R/L 2525 M16	25	25	150	27,3	32	3,2	VC.. 1604

Spare parts for Article no.	Key D	Clamping screw	Solid Carbide Seat V	Threaded sleeve
70 667 02500 / 70 667 02501	80 950 ...	70 950 ...	70 950 ...	70 950 ...
T15 - IP	120	M3,5x11	87900	107
			M3,5	171

MaxiLock-S – SVZC 100° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



NEW

Left-hand

70 783 ...

NEW

Right-hand

70 783 ...

Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert		
SVZC R/L 2525 M16 DC	25	25	150	38	32	M6	G1/8"	3,2	VC.. 1604	02501	02500

Spare parts for Article no.

70 783 02500 / 70 783 02501

Clamping screw	Solid Carbide Seat V	Grubscrew	Grubscrew	Threaded sleeve
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
87900	107	88000	86700	171

Spare parts for Article no.

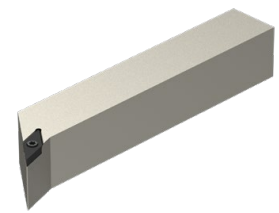
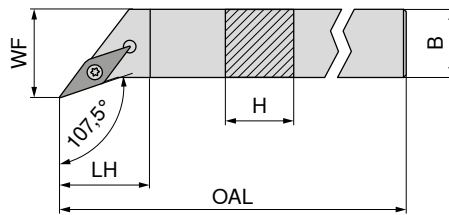
70 783 02500 / 70 783 02501

Sealing plugs DC	Key D	O-Ring	Coolant nozzle DC	Coolant screw plug
70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...
87600	120	88100	87700	294

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

Scope of supply:

Tool holder with Torx key







Illustrations show right-hand versions

NEW Left-hand **70 662 ...**
NEW Right-hand **70 662 ...**

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	70 662 ...	70 662 ...
SVHC R/L 1212 F11	12	12	80	11,9	16	1,2	VC.. 1103	01200	01201
SVHC R/L 1616 H11	16	16	100	11,9	20	1,2	VC.. 1103	01600	01601
SVHC R/L 2020 K11	20	20	125	14,7	25	1,2	VC.. 1103	02000	02001
SVHC R/L 2525 M11	25	25	150	20,1	32	1,2	VC.. 1103	02500	02501
SVHC R/L 2020 K16	20	20	125	13,7	25	3,2	VC.. 1604	12000	12001
SVHC R/L 2525 M16	25	25	150	20,0	32	3,2	VC.. 1604	12500	12501
SVHC R/L 3225 P16	32	25	170	20,0	32	3,2	VC.. 1604	13200	13201
SVHC R/L 2525 M22	25	25	150	21,9	32	5	VC.. 2205	22500	22501

**Spare parts
for Article no.**

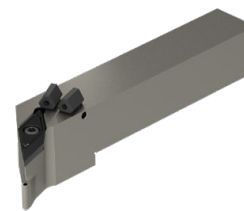
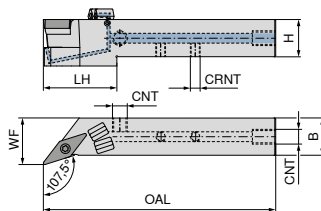
for Article no.	80 950 ...	70 950 ...	70 950 ...	70 950 ...
70 662 01201 / 70 662 01200	039	857		
70 662 01601 / 70 662 01600	039	857		
70 662 02001 / 70 662 02000	039	857		
70 662 02501 / 70 662 02500	039	857		
70 662 12001 / 70 662 12000	120	87900	107	171
70 662 12501 / 70 662 12500	120	87900	107	171
70 662 13201 / 70 662 13200	120	87900	107	171
70 662 22501 / 70 662 22500	120	820	109	170

 Key D	 Clamping screw	 Solid Carbide Seat V	 Threaded sleeve
80 950 ...	70 950 ...	70 950 ...	70 950 ...

MaxiLock-S – SVHC 107.5° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions

NEW Left-hand 70 779 ...
NEW Right-hand 70 779 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	70 779 ...	70 779 ...
SVHC R/L 1212 F11 DC	12	12	80	28	16	M6	M6	1,2	VC.. 1103	01201	01200
SVHC R/L 1616 H11 DC	16	16	100	27	20	M6	G1/8"	1,2	VC.. 1103	01601	01600
SVHC R/L 2020 K11 DC	20	20	125	37	27	M6	G1/8"	1,2	VC.. 1103	02001	02000
SVHC R/L 2525 M11 DC	25	25	150	38	32	M6	G1/8"	1,2	VC.. 1103	02501	02500
SVHC R/L 2020 K16 DC	20	20	125	38	25	M6	G1/8"	3,2	VC.. 1604	12001	12000
SVHC R/L 2525 M16 DC	25	25	150	38	32	M6	G1/8"	3,2	VC.. 1604	12501	12500
SVHC R/L 3225 P16 DC	32	25	170	38	32	M6	G1/8"	3,2	VC.. 1604	03201	03200
SVHC R/L 2525 M22 DC	25	25	150	41	32	M6	G1/8"	5	VC.. 2205	22501	22500

Spare parts for Article no.

Article no.	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 779 01200 / 70 779 01201	857			86700	
70 779 01600 / 70 779 01601	857		88000	86700	
70 779 02000 / 70 779 02001	857		88000	86700	
70 779 02500 / 70 779 02501	857		88000	86700	
70 779 12000 / 70 779 12001	87900	107	88000	86700	171
70 779 12500 / 70 779 12501	87900	107	88000	86700	171
70 779 03200 / 70 779 03201	87900	107	88000	86700	171
70 779 22500 / 70 779 22501	820	109	88000	86700	170

Spare parts for Article no.

Article no.	70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...
70 779 01200 / 70 779 01201		039			
70 779 01600 / 70 779 01601	87600	039	88100	87700	294
70 779 02000 / 70 779 02001	87600	039	88100	87700	294
70 779 02500 / 70 779 02501	87600	039	88100	87700	294
70 779 12000 / 70 779 12001	87600	120	88100	87700	294
70 779 12500 / 70 779 12501	87600	120	88100	87700	294
70 779 03200 / 70 779 03201	87600	120	88100	87700	294
70 779 22500 / 70 779 22501	87600	120	88100	87700	294

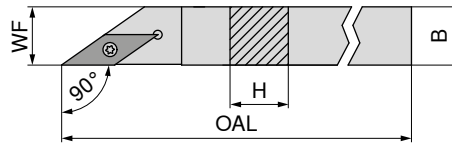
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...

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

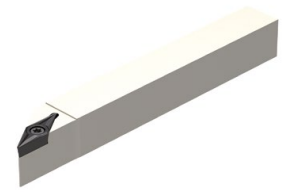
▲ for sliding head lathes

Scope of supply:

Tool holder with Torx key



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 ...
008	008
010	010
012	012

Spare parts

for Article no.

70 694 008 / 70 695 008	T08	110	M2,5x6 - T08	13800
70 694 010 / 70 695 010	T08	110	M2,5x6 - T08	13800
70 694 012 / 70 695 012	T08	110	M2,5x6 - T08	13800



Key D



Clamping screw

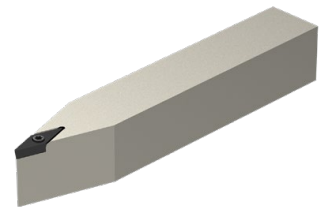
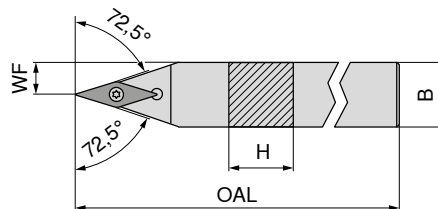
80 950 ...

70 950 ...

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

Scope of supply:

Tool holder with Torx key



NEW

Neutral

70 666 ...

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

Spare parts

for Article no.

70 666 01200	039	857		
70 666 01600	039	857		
70 666 02000	039	857		
70 666 02500	039	857		
70 666 12000	120	87900	107	171
70 666 12500	120	87900	107	171
70 666 13200	120	87900	107	171



Key D



Clamping screw



Solid Carbide
Seat V



Threaded sleeve

80 950 ...

70 950 ...

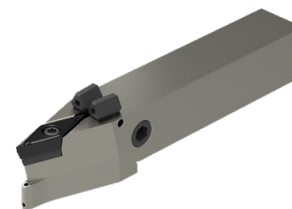
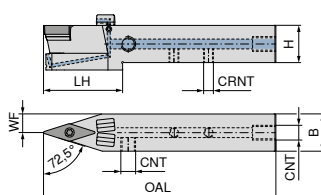
70 950 ...

70 950 ...

MaxiLock-S – SVVC 72.5° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



NEW
Neutral
70 781 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	
SVVC N 1212 F11 DC	12	12	80	29,0	6,0	M6	M6	1,2	VC.. 1103	01200
SVVC N 1616 H11 DC	16	16	100	29,5	8,0	M6	G1/8"	1,2	VC.. 1103	01600
SVVC N 2020 K11 DC	20	20	125	43,0	10,0	M6	G1/8"	1,2	VC.. 1103	02000
SVVC N 2525 M11 DC	25	25	150	43,0	12,5	M6	G1/8"	1,2	VC.. 1103	02500
SVVC N 2020 K16 DC	20	20	125	43,0	10,0	M6	G1/8"	3,2	VC.. 1604	12000
SVVC N 2525 M16 DC	25	25	150	43,0	12,5	M6	G1/8"	3,2	VC.. 1604	12500
SVVC N 3225 P16 DC	32	25	170	44,0	12,5	G1/8"	G1/8"	3,2	VC.. 1604	03200

**Spare parts
for Article no.**

	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 781 01200	857			86700	
70 781 01600	857		88000	86700	
70 781 02000	857		88000	86700	
70 781 02500	857		88000	86700	
70 781 12000	87900	107	88000	86700	171
70 781 12500	87900	107	88000	86700	171
70 781 03200	87900	107	88000		171

**Spare parts
for Article no.**

	70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...
70 781 01200		039			
70 781 01600	87600	039	88100	87700	294
70 781 02000	87600	039	88100	87800	294
70 781 02500	87600	039	88100	87700	294
70 781 12000	87600	120	88100	87800	294
70 781 12500	87600	120	88100	87800	294
70 781 03200	87600	120	88100	87700	294

Clamping screw	Solid Carbide Seat V	Grubscrew	Grubscrew	Threaded sleeve
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...

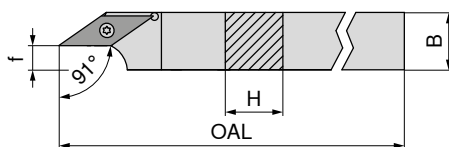
Sealing plugs DC	Key D	O-Ring	Coolant nozzle DC	Coolant screw plug
70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...

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

▲ for sliding head lathes

Scope of supply:

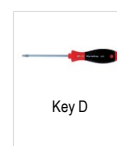
Tool holder with Torx key



Illustrations show right-hand versions



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



Key D



Clamping screw

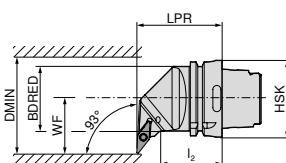
Spare parts for Article no.

70 690 010 / 70 691 010	T08	110	M2,5x6 - T08	13800
70 690 012 / 70 691 012	T08	110	M2,5x6 - T08	13800
70 690 016 / 70 691 016	T08	110	M2,5x6 - T08	13800
70 690 020 / 70 691 020	T15	113	M3,5x11	113

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

Scope of supply:

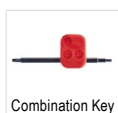
Tool holder with Torx key



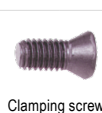
Illustrations show right-hand versions



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



Combination Key



Clamping screw



Solid Carbide
Seat V



Threaded sleeve

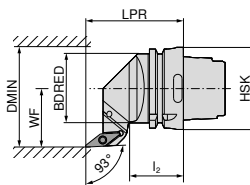
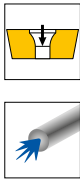
Spare parts for Article no.

74 558 516 / 74 557 516	T15/SW	398	M3,5x11	113	107	M3,5	171
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MaxiLock-S – SVJC 93° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key







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 74 556 ...	Right-hand 74 555 ...
HSK T63 SVJC R/L 16	HSK-T 63	75	42	53	45	100	3.2	VC.. 1604	516	516

**Spare parts
for Article no.**

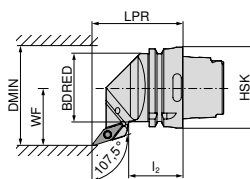
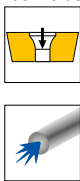
74 555 516 / 74 556 516	T15/SW	398	M3,5x11	113	107	M3,5	171
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 Combination Key	 Clamping screw	 Solid Carbide Seat V	 Threaded sleeve
70 950 ...	70 950 ...	70 950 ...	70 950 ...

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

Scope of supply:

Tool holder with Torx key







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 74 554 ...	Right-hand 74 553 ...
HSK T63 SVHC R/L 16	HSK-T 63	70	42	53	45	100	3.2	VC.. 1604	516	516

**Spare parts
for Article no.**

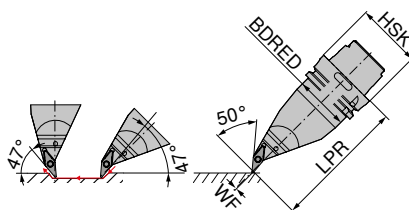
74 553 516 / 74 554 516	T15/SW	398	M3,5x11	113	107	M3,5	171
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 Combination Key	 Clamping screw	 Solid Carbide Seat V	 Threaded sleeve
70 950 ...	70 950 ...	70 950 ...	70 950 ...

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

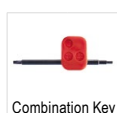
Scope of supply:

Tool holder with Torx key



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	516



70 950 ...



70 950 ...



70 950 ...



70 950 ...

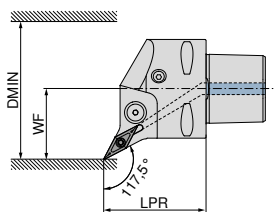
Spare parts for Article no.

74 560 516	T15/SW	398	M3,5x11	113	107	M3,5	171
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MaxiLock-S – SVPC 117,5° – Toolholder with screw clamping

Scope of supply:

without high-performance coolant set



Illustrations show right-hand versions



Left-hand **84 671 ...** 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	01695	01695
PSC50 SVPC R/L 65060-16	PSC 50	60	35	65	3	VC.. 1604	DC	01694	01694
PSC63 SVPC R/L 80065-16	PSC 63	65	45	80	3	VC.. 1604	DC	01693	01693

The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra → **Page 40.**



84 950 ...

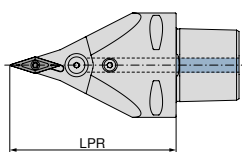
Spare parts for Article no.

84 670 01695 / 84 671 01695	27600
84 670 01694 / 84 671 01694	27600
84 670 01693 / 84 671 01693	27600

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

Scope of supply:

without high-performance coolant set



Neutral

84 678 ...

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

The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra → **Page 40.**



Clamping screw

84 950 ...

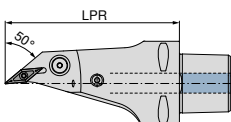
**Spare parts
for Article no.**

84 678 01693	27600
84 678 11693	27600

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

Scope of supply:

without high-performance coolant set



Neutral

84 681 ...

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

The high-performance coolant set with article number **84 950 27400** can be ordered as an optional extra → **Page 40.**



Clamping screw

84 950 ...

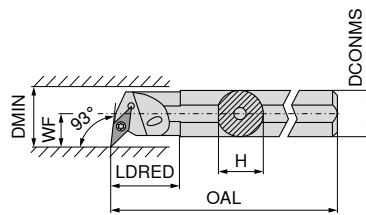
**Spare parts
for Article no.**

84 681 11693	27600
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MaxiLock-S – SVUC 93° – Boring bar with screw clamping

Scope of supply:

Boring bar with Torx key



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
									70 745 ...	70 744 ...
A16M SVUC R/L 11	16	15	150	29	11	20	1,2	VC.. 1103	216	216
A20Q SVUC R/L 11	20	19	180	43	13	25	1,2	VC.. 1103	220	220
A25R SVUC R/L 11	25	24	200	38	17	32	1,2	VC.. 1103	225	225
A32S SVUC R/L 16	32	31	250	50	22	40	3,2	VC.. 1604	232	232
A40T SVUC R/L 16	40	39	300	60	27	50	3,2	VC.. 1604	240	240

Key D	Combination Key	Clamping screw	Solid Carbide Seat V	Threaded sleeve
80 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
110		13800		
110		13800		
110		13800		
	398	113	107	171
	398	113	107	171

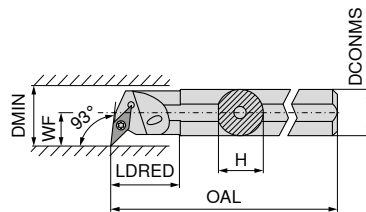
Spare parts

for Article no.

70 744 216 / 70 745 216	110	13800
70 744 220 / 70 745 220	110	13800
70 744 225 / 70 745 225	110	13800
70 744 232 / 70 745 232		113
70 744 240 / 70 745 240		113

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 ...
E-A16M SVUC R 11	16	15	150	16,5	11	21	1,2	VC.. 1103	216
E-A20Q SVUC R 11	20	18	180	20,5	13	25	1,2	VC.. 1103	220
E-A25R SVUC R 11	25	23	200	25,5	17	31	1,2	VC.. 1103	225
E-A25R SVUC R 16	25	23	200	25,5	17	31	3,2	VC.. 1604	325
E-A32S SVUC R 16	32	30	250	32,5	22	39	3,2	VC.. 1604	232

Key D	Clamping screw
80 950 ...	70 950 ...
110	13800
110	13800
110	13800
113	449
113	449

Spare parts
for Article no.

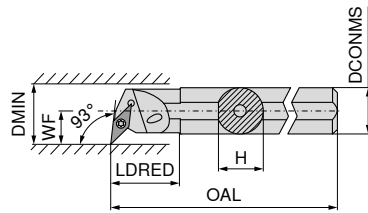
70 746 216	110	13800
70 746 220	110	13800
70 746 225	110	13800
70 746 325	113	449
70 746 232	113	449

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

▲ Type: Solid carbide

Scope of supply:

Boring bar with Torx key



Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert
E16R SVUC L 11	16	15,0	200	34	11	20	1,2	VC.. 1103
E16R SVUC R 11	16	15,5	200	34	11	20	1,2	VC.. 1103
E20S SVUC L 11	20	18,5	250	38	13	25	1,2	VC.. 1103
E20S SVUC R 11	20	19,0	250	38	13	25	1,2	VC.. 1103

Left-hand	Right-hand
70 747 ...	70 746 ...
016	016
020	020

Spare parts for Article no.

70 747 016	T08	110	M2,5x6 - T08	13800
70 746 016	T08	110	M2,5x6 - T08	13800
70 747 020	T08	110	M2,5x6 - T08	13800
70 746 020	T08	110	M2,5x6 - T08	13800



Key D



Clamping screw

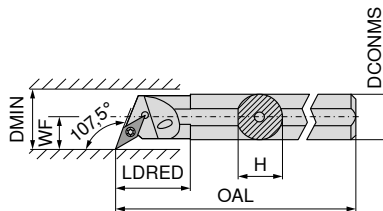
80 950 ...

70 950 ...

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

Scope of supply:

Boring bar with Torx key



Illustrations show right-hand versions



ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert
A16M SVQC R/L 11	16	15,0	150	29	11	20	1,2	VC.. 1103
A20Q SVQC R/L 11	20	18,5	180	32	13	25	1,2	VC.. 1103
A25R SVQC R/L 11	25	23,0	200	36	17	32	1,2	VC.. 1103
A32S SVQC R/L 16	32	30,0	250	50	22	40	3,2	VC.. 1604
A40T SVQC R/L 16	40	38,0	300	60	27	50	3,2	VC.. 1604

Left-hand	Right-hand
70 749 ...	70 748 ...
216	216
220	220
225	225
232	232
240	240

Spare parts for Article no.

70 748 216 / 70 749 216	110		13800		
70 748 220 / 70 749 220	110		13800		
70 748 225 / 70 749 225	110		13800		
70 748 232 / 70 749 232		398	113	107	171
70 748 240 / 70 749 240		398	113	107	171



Key D



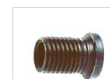
Combination Key



Clamping screw



Solid Carbide Seat V



Threaded sleeve

80 950 ...

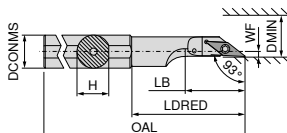
70 950 ...

70 950 ...

70 950 ...

70 950 ...

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



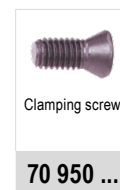
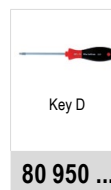
Left-hand
70 727 ...

ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert
A16M SVJC L 11	16	15	150	50,0	2	22	1,2	VC.. 1103
A20M SVJC L 11	20	19	150	55,5	2	25	1,2	VC.. 1103
A25M SVJC L 16	25	24	150	58,0	5	28	3,2	VC.. 1604

216
220
225

**Spare parts
for Article no.**

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

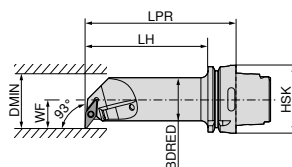


110 **13800**
110 **13800**
113 **174**

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

Scope of supply:

Boring bar with Torx key



Illustrations show right-hand versions



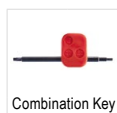
Left-hand
74 568 ...

Right-hand
74 567 ...

ISO designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert
HSK T63 40L SVUC R/L 16	HSK-T 63	140	114	40	27	50	3.2	VC.. 1604

516

516



**Spare parts
for Article no.**

74 567 516 / 74 568 516

T15/SW

398

M3,5x11

113

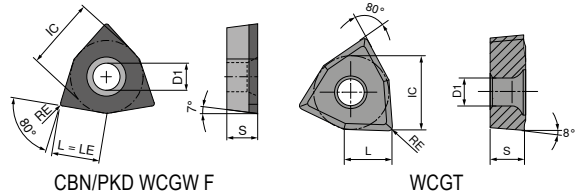
107

M3,5

171

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 DRAGONSKIN	-SF H216T
F	F	F
CERMET WCGT	WCGT	WCGT
70 287 ...	70 287 ...	70 287 ...
900	450	600
902	452	602

ISO	RE mm			
020102EN	0,2			
020104EN	0,4			
P		●	●	
M		○	●	
K		○	○	○
N			○	●
S			○	
H				
O				○

WCGW

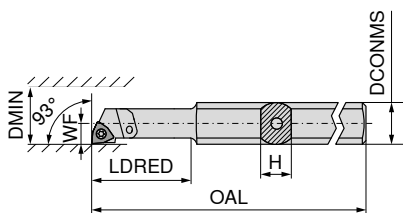
▲ TCE(NOI) = Design and number of equipped cutting edge corners

CTDPD20
F
DIAMOND WCGW
71 154 ...
100
102

ISO	RE mm	TCE (NOI)	LE mm	
020102FN	0,2	F	2,7	
020104FN	0,4	F	2,7	
P				
M				
K				
N				●
S				
H				
O				●

9

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



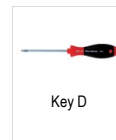
Illustrations show right-hand versions



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

**Spare parts
for Article no.**

70 731 005 / 70 730 005	T06	108	M1,8x3,4	334
70 731 006 / 70 730 006	T06	108	M1,8x3,4	334



Key D

80 950 ...

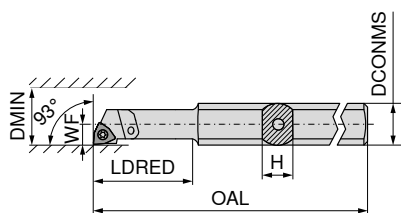


Clamping screw

70 950 ...

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

▲ with carbide core

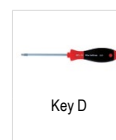


Illustrations show right-hand versions



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

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



Key D

80 950 ...



Clamping screw

70 950 ...

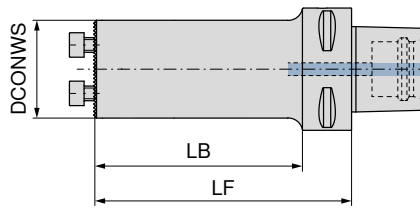
**Spare parts
for Article no.**

70 743 005 / 70 742 005	T06	108	M1,8x3,4	334
70 743 006 / 70 742 006	T06	108	M1,8x3,4	334

MaxiChange – Base holders for the exchangeable head system

Scope of supply:

Includes clamping screws



NEW

84 192 ...

Adapter	LF mm	LB mm	DCONWS mm	
PSC 40	40	20	16	01695
PSC 40	50	30	20	02095
PSC 40	55	35	25	02595
PSC 40	75	55	32	03295
PSC 40	80		40	04095
PSC 50	40	20	16	01694
PSC 50	50	30	20	02094
PSC 50	55	35	25	02594
PSC 50	75	55	32	03294
PSC 50	100	80	40	04094
PSC 63	40	18	16	01693
PSC 63	50	28	20	02093
PSC 63	65	43	25	02593
PSC 63	90	68	32	03293
PSC 63	125	103	32	13293
PSC 63	100	78	40	04093
PSC 63	140	118	40	14093



Clamping Screw

84 950 ...

**Spare parts
for Article no.**

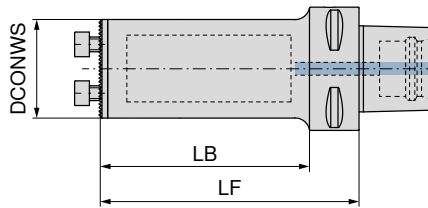
84 192 02595	M4X12 (SW3)	30000
84 192 03295	M5X14 (SW4)	29900
84 192 04095	M6X16 (SW5)	29800
84 192 02594	M4X12 (SW3)	30000
84 192 03294	M5X14 (SW4)	29900
84 192 04094	M6X16 (SW5)	29800
84 192 02593	M4X12 (SW3)	30000
84 192 03293	M5X14 (SW4)	29900
84 192 04093	M6X16 (SW5)	29800
84 192 13293	M5X14 (SW4)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

MaxiChange – Base holders for the exchangeable head system – vibration-damped

▲ Heavy metal core reduces vibrations

Scope of supply:

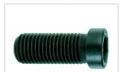
Includes clamping screws



Adapter	LF mm	LB mm	DCONWS mm
PSC 63	115	93	25
PSC 63	150	128	32
PSC 63	185	163	40

84 195 ...

**02593
03293
04093**



Clamping Screw

84 950 ...

**Spare parts
for Article no.**

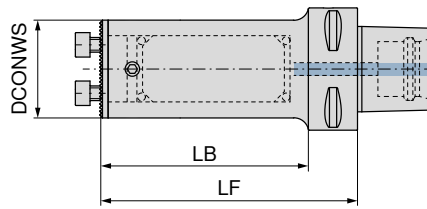
84 195 02593	30000
84 195 03293	29900
84 195 04093	29800

MaxiChange – Base holders for the exchangeable head system – actively vibration-damped

- ▲ Reduction of vibrations through actively mounted dampers
- ▲ Improvement in surface finish and chip evacuation

Scope of supply:

Includes clamping screws



NEW

84 198 ...

Adapter	LF mm	LB mm	DCONWS mm	
PSC 40	88	68	16	31695
PSC 40	107	87	20	32095
PSC 40	132	112	25	42595
PSC 40	154	134	32	43295
PSC 40	173		40	44095
PSC 50	85	65	16	31694
PSC 50	109	89	20	32094
PSC 50	133	113	25	32594
PSC 50	180	160	25	42594
PSC 50	154	134	32	33294
PSC 50	224	204	32	43294
PSC 50	194	174	40	34094
PSC 50	288	268	40	44094
PSC 63	90	68	16	31693
PSC 63	110	88	20	32093
PSC 63	132	110	25	32593
PSC 63	180	158	25	42593
PSC 63	230	208	25	52593
PSC 63	159	137	32	33293
PSC 63	224	202	32	43293
PSC 63	288	266	32	53293
PSC 63	198	176	40	34093
PSC 63	288	266	40	44093
PSC 63	368	346	40	54093

9



Clamping Screw

84 950 ...

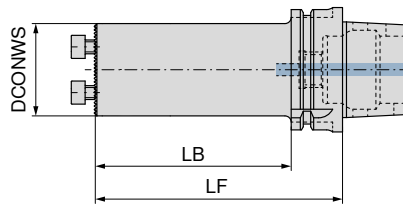
Spare parts for Article no.

84 198 42595	30000
84 198 43295	29900
84 198 44095	29800
84 198 32594	30000
84 198 33294	29900
84 198 42594	30000
84 198 34094	29800
84 198 43294	29900
84 198 44094	29800
84 198 32593	30000
84 198 33293	29900
84 198 42593	30000
84 198 34093	29800
84 198 43293	29900
84 198 52593	30000
84 198 53293	29900
84 198 44093	29800
84 198 54093	29800

MaxiChange – Base holders for the exchangeable head system

Scope of supply:

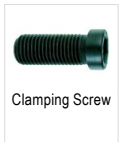
Includes clamping screws



NEW

84 193 ...

Adapter	LF mm	LB mm	DCONWS mm	
HSK-T 40	55	35	25	02539
HSK-T 40	75	55	25	12539
HSK-T 40	80	60	32	03239
HSK-T 40	80		40	04039
HSK-T 63	56	30	16	01637
HSK-T 63	80	54	20	02037
HSK-T 63	80	44	25	02537
HSK-T 63	90	64	32	03237
HSK-T 63	100	74	40	04037
HSK-T 63	125	99	32	13237
HSK-T 63	140	114	40	14037
HSK-T 100	140	111	40	04035



84 950 ...

**Spare parts
for Article no.**

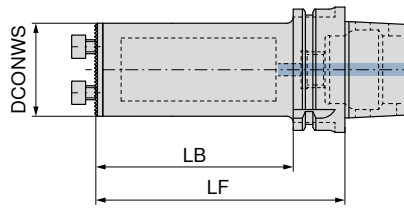
84 193 02539	M4X12 (SW3)	30000
84 193 12539	M4X12 (SW3)	30000
84 193 03239	M5X14 (SW4)	29900
84 193 04039	M6X16 (SW5)	29800
84 193 02537	M4X12 (SW3)	30000
84 193 03237	M5X14 (SW4)	29900
84 193 04037	M6X16 (SW5)	29800
84 193 13237	M5X14 (SW4)	29900
84 193 14037	M6X16 (SW5)	29800
84 193 04035	M6X16 (SW5)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

MaxiChange – Base holders for the exchangeable head system – vibration-damped

▲ Heavy metal core reduces vibrations

Scope of supply:

Includes clamping screws



NEW

84 195 ...

Adapter	LF mm	LB mm	DCONWS mm
HSK-T 63	115	89	25
HSK-T 63	150	124	32
HSK-T 63	185	159	40

02537

03237

04037



Clamping Screw

84 950 ...

**Spare parts
for Article no.**

84 195 02537

30000

84 195 03237

30000

84 195 04037

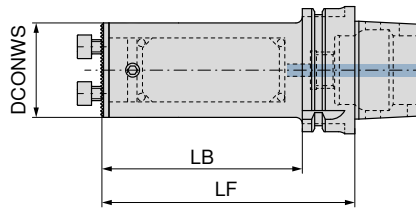
30000

MaxiChange – Base holders for the exchangeable head system – actively vibration-damped

- ▲ Reduction of vibrations through actively mounted dampers
- ▲ Improvement in surface finish and chip evacuation

Scope of supply:

Includes clamping screws



NEW

84 198 ...

Adapter	LF mm	LB mm	DCONWS mm	
HSK-T 63	90	64	16	31637
HSK-T 63	106	80	20	32037
HSK-T 63	126	100	25	32537
HSK-T 63	151	125	25	42537
HSK-T 63	154	128	32	33237
HSK-T 63	186	160	32	43237
HSK-T 63	186	160	40	34037
HSK-T 63	226	200	40	44037



Clamping Screw

84 950 ...

Spare parts for Article no.

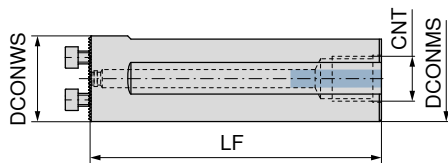
84 198 42537	30000
84 198 32537	30000
84 198 43237	29900
84 198 33237	29900
84 198 44037	29800
84 198 34037	29800

MaxiChange – Base holders for the exchangeable head system – cylindrical

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

Scope of supply:

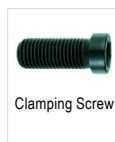
Includes clamping screws



NEW

84 194 ...

DCONWS	LF	DCONMS	CNT	
mm	mm	mm		
25	100	25	M8 x 1	12599
32	120	32	M8 x 1	13299
40	120	40	M8 x 1	14099
25	200	25	1/4	02599
32	218	32	3/8	03299
40	283	40	1/2	04099



84 950 ...

Spare parts for Article no.

84 194 02599	M4X12 (SW3)	30000
84 194 03299	M5X14 (SW4)	29900
84 194 04099	M6X16 (SW5)	29800

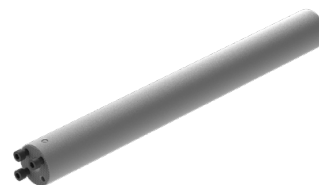
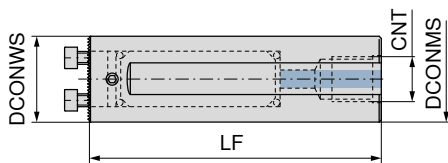
MaxiChange –

Base holders for the exchangeable head system – actively vibration-damped

- ▲ Reduction of vibrations through actively mounted dampers
- ▲ Improvement in surface finish and chip evacuation

Scope of supply:

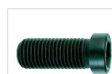
Includes clamping screws



NEW

84 198 ...

DCONWS mm	LF mm	DCONMS mm	CNT	
16	170	16	1/4	31699
20	200	20	1/4	32099
25	255	25	1/4	32599
32	320	32	1/2	33299
40	408	40	1/2	34099



Clamping Screw

84 950 ...

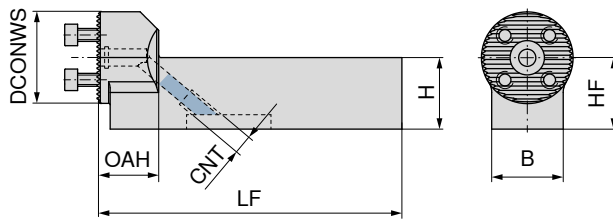
Spare parts for Article no.

84 198 31699	44800
84 198 32099	44900
84 198 32599	30000
84 198 33299	29900
84 198 34099	29800

MaxiChange – 0° base holders for the exchangeable head system

Scope of supply:

Includes clamping screws



DCONWS mm	H mm	B mm	HF mm	OAH mm	LF mm	CNT
25	20	20	20	21	106	M8x1
32	20	20	20	21	106	M8x1
32	25	25	25	21	106	M8x1
40	25	25	25	21	106	M8x1

NEW	84 185 ...	
		02500
		03200
		13200
		14000

Clamping Screw	84 950 ...

**Spare parts
for Article no.**

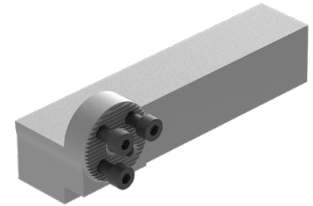
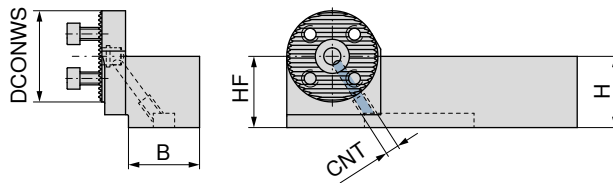
84 185 02500	30000
84 185 03200	29900
84 185 13200	29900
84 185 14000	29800

→ **Chapter 16 Adapters and accessories**
Here you will find the suitable base adaptors.

MaxiChange – 90° base holders for the exchangeable head system

Scope of supply:

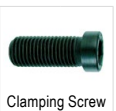
Includes clamping screws



NEW

84 184 ...

DCONWS mm	H mm	B mm	HF mm	CNT	
25	20	20	20	M8x1	02500
32	20	20	20	M8x1	03200
32	25	25	25	M8x1	13200
40	25	25	25	M8x1	14000



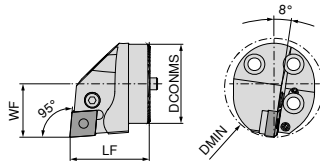
84 950 ...

**Spare parts
for Article no.**

84 184 02500	30000
84 184 03200	30000
84 184 13200	30000
84 184 14000	29800

→ **Chapter 16 Adapters and accessories**
Here you will find the suitable base adaptors.

MaxiChange-N – Exchangeable cutting head PCLN 95°



Illustrations show right-hand versions

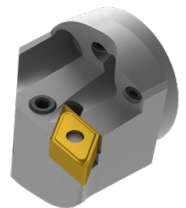
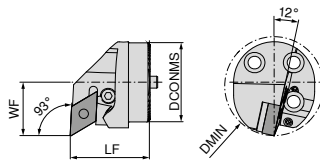
DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert	Left-hand		Right-hand	
						84 159 ...	84 160 ...	84 159 ...	84 160 ...
25	35	32	17	5	CN.. 1204	02500	02500	02500	02500
32	35	40	22	5	CN.. 1204	03200	03200	03200	03200
40	40	50	27	5	CN.. 1204	04000	04000	04000	04000

Shim	Elbow lever screw	Lever	Carbide type C
84 950 ...	84 950 ...	84 950 ...	84 950 ...

Spare parts
for Article no.

84 160 02500 / 84 159 02500	29200	M8X1/L17 SW3	28700	29000	27800
84 160 03200 / 84 159 03200	29200	M8X1/L17 SW3	28700	29000	27800
84 160 04000 / 84 159 04000	29200	M8X1/L17 SW3	28700	29000	27800

MaxiChange-N – Exchangeable cutting head PDUN 93°



Illustrations show right-hand versions

DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert	Left-hand		Right-hand	
						84 161 ...	84 162 ...	84 161 ...	84 162 ...
25	35	32	17	5	DN.. 1104	02500	02500	02500	02500
32	35	40	22	5	DN.. 1104	03200	03200	03200	03200
32	35	40	22	5	DN.. 1504 / 1506	13200	13200	13200	13200
40	40	50	27	5	DN.. 1104	04000	04000	04000	04000
40	40	50	27	5	DN.. 1504 / 1506	14000	14000	14000	14000

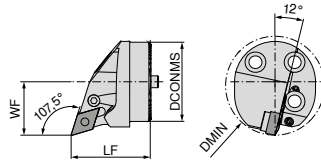
When using DN.. 1504 indexable inserts, use insert seat article no. 84 950 28200.

Shim	Elbow lever screw	Lever	Solid Carbide Seat D
84 950 ...	84 950 ...	84 950 ...	84 950 ...

Spare parts
for Article no.

84 162 02500 / 84 161 02500	29300	M6/ L14 SW2,5	28800	29100	28100
84 162 03200 / 84 161 03200	29300	M6/ L14 SW2,5	28800	29100	28100
84 162 13200 / 84 161 13200	29200	M8X1/L17 SW3	28700	28900	27900
84 162 04000 / 84 161 04000	29300	M6/ L14 SW2,5	28800	29100	28100
84 162 14000 / 84 161 14000	29200	M8X1/L17 SW3	28700	28900	27900

MaxiChange-N – Exchangeable cutting head PDQN 107.5°



Illustrations show right-hand versions

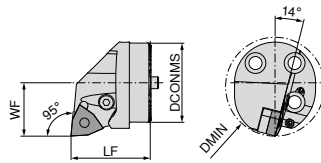
DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert	Left-hand	Right-hand
						84 163 ...	84 164 ...
25	35	32	17	5	DN.. 1104	02500	02500
32	35	40	22	5	DN.. 1104	03200	03200
40	40	50	27	5	DN.. 1104	04000	04000

Shim	Elbow lever screw	Lever	Solid Carbide Seat D
84 950 ...	84 950 ...	84 950 ...	84 950 ...

Spare parts
for Article no.

84 163 02500 / 84 164 02500	29300	M6/ L14 SW2,5	28800	29100	28100
84 163 03200 / 84 164 03200	29300	M6/ L14 SW2,5	28800	29100	28100
84 163 04000 / 84 164 04000	29300	M6/ L14 SW2,5	28800	29100	28100

MaxiChange-N – Exchangeable cutting head PWLN 95°



Illustrations show right-hand versions

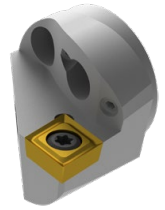
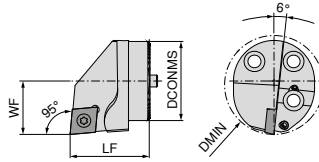
DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert	Left-hand	Right-hand
						84 165 ...	84 166 ...
32	35	40	22	5	WN.. 0804	03200	03200
40	40	50	27	5	WN.. 0804	04000	04000

Shim	Elbow lever screw	Lever	Solid Carbide Seat W
84 950 ...	84 950 ...	84 950 ...	84 950 ...

Spare parts
for Article no.

84 166 03200 / 84 165 03200	29200	M8X1/L17 SW3	28700	28900	27700
84 166 04000 / 84 165 04000	29200	M8X1/L17 SW3	28700	28900	27700

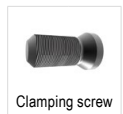
MaxiChange-S – SCLC 95° – Exchangeable cutting head with screw clamping



Illustrations show right-hand versions

DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert
16	20	20	11	0.9	CC.. 0602
20	20	25	13	3	CC.. 09T3
25	35	32	17	5	CC.. 1204
32	35	40	22	5	CC.. 1204
40	40	50	27	5	CC.. 1204

NEW	
Left-hand	Right-hand
84 147 ...	84 148 ...
01600	01600
02000	02000
02500	02500
03200	03200
04000	04000



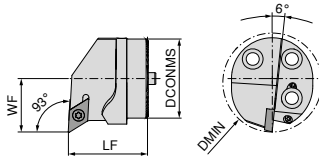
Clamping screw

84 950 ...

**Spare parts
for Article no.**

84 148 02500 / 84 147 02500	27500
84 148 03200 / 84 147 03200	27500
84 148 04000 / 84 147 04000	27500

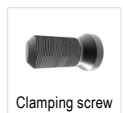
MaxiChange-S – SDUC 93° – Exchangeable cutting head with screw clamping



Illustrations show right-hand versions

DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert
16	20	20	11	0,9	DC.. 0702
20	20	25	13	3	DC.. 11T3
25	35	32	17	3	DC.. 11T3
32	35	40	22	3	DC.. 11T3
40	40	50	27	3	DC.. 11T3

NEW	
Left-hand	Right-hand
84 143 ...	84 144 ...
01600	01600
02000	02000
02500	02500
03200	03200
04000	04000



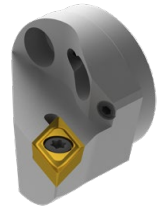
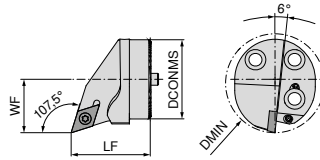
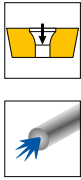
Clamping screw

84 950 ...

**Spare parts
for Article no.**

84 144 01600 / 84 143 01600	44700
84 144 02000 / 84 143 02000	27600
84 144 02500 / 84 143 02500	27600
84 144 03200 / 84 143 03200	27600
84 144 04000 / 84 143 04000	27600

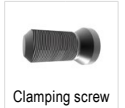
MaxiChange-S – SDQC 107.5° – Exchangeable cutting head with screw clamping



Illustrations show right-hand versions

DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert
20	20	25	13	3	DC.. 11T3
25	35	32	17	3	DC.. 11T3
32	35	40	22	3	DC.. 11T3
40	40	50	27	3	DC.. 11T3

NEW	
Left-hand	Right-hand
84 145 ...	84 146 ...
02000	02000
02500	02500
03200	03200
04000	04000



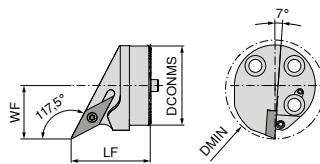
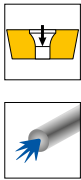
Clamping screw

84 950 ...

**Spare parts
for Article no.**

84 146 02500 / 84 145 02500	27600
84 146 03200 / 84 145 03200	27600
84 146 04000 / 84 145 04000	27600

MaxiChange-S – SVPC 117.5° – Exchangeable cutting head with screw clamping



Illustrations show right-hand versions

DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert
25	35	32	17	3	VC.. 1103
32	35	40	22	3	VC.. 1604
40	40	50	27	3	VC.. 1604

NEW	
Left-hand	Right-hand
84 176 ...	84 176 ...
12500	02500
13200	03200
14000	04000



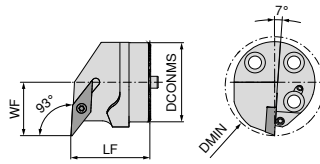
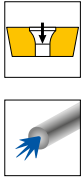
Clamping screw

84 950 ...

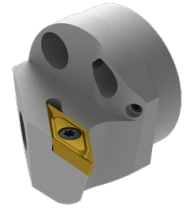
for Article no.

84 176 02500 / 84 176 12500	27600
84 176 03200 / 84 176 13200	27600
84 176 04000 / 84 176 14000	27600

MaxiChange-S – SVUC 93° – Exchangeable cutting head with screw clamping



Illustrations show right-hand versions

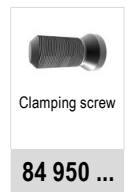


DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert
20	20	25	13	3	VC.. 1103
25	35	32	17	3	VC.. 1103
32	35	40	22	3	VC.. 1604
40	40	50	27	3	VC.. 1604

	NEW Left-hand	NEW Right-hand
	84 177 ...	84 177 ...
	12000	02000
	12500	02500
	13200	03200
	14000	04000

**Spare parts
for Article no.**

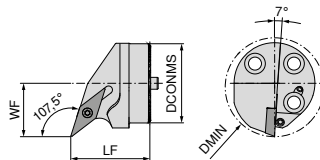
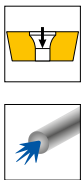
84 177 02000 / 84 177 12000	27600
84 177 02500 / 84 177 12500	27600
84 177 03200 / 84 177 13200	27600
84 177 04000 / 84 177 14000	27600



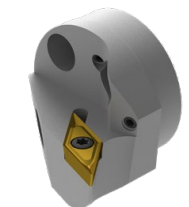
Clamping screw

84 950 ...

MaxiChange-S – SVQC 107.5° – Exchangeable cutting head with screw clamping



Illustrations show right-hand versions

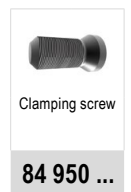


DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert
20	20	25	13	3	VC.. 1103
25	35	32	17	3	VC.. 1103
32	35	40	22	3	VC.. 1604
40	40	50	27	3	VC.. 1604

	NEW Left-hand	NEW Right-hand
	84 178 ...	84 178 ...
	12000	02000
	12500	02500
	13200	03200
	14000	04000

for Article no.

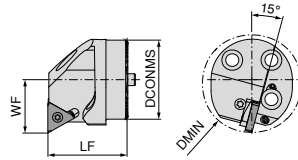
84 178 02000 / 84 178 12000	27600
84 178 02500 / 84 178 12500	27600
84 178 03200 / 84 178 13200	27600
84 178 04000 / 84 178 14000	27600



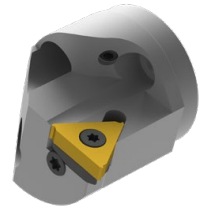
Clamping screw

84 950 ...

MaxiChange – 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 ..

Left-hand	Right-hand
84 167 ...	84 168 ...
02500	02500
03200	03200
04000	04000




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




Shim

84 950 ...



Screw-U

84 950 ...



Clamping screw

84 950 ...

**Spare parts
for Article no.**

Article no.	Shim	UNC	Screw-U	Clamping screw
84 168 02500	29500	UNC5x7,3	29700	29400
84 167 02500	29600	UNC5x7,3	29700	29400
84 168 03200	29500	UNC5x7,3	29700	29400
84 167 03200	29600	UNC5x7,3	29700	29400
84 168 04000	29500	UNC5x7,3	29700	29400
84 167 04000	29600	UNC5x7,3	29700	29400

Flexible coolant hoses

- ▲ incl. prefitted quick-coupler and coupler connector
- ▲ extremely flexible
- ▲ pressure-resistant up to 300 bar

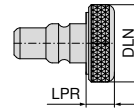


Designation	BD mm	CND mm	OAL mm	
MU.KSS-DN3-150	6,0	3	150	11005
MU.KSS-DN3-250	6,0	3	250	11006
MU.KSS-DN5-200	9,5	5	200	11001
MU.KSS-DN5-300	9,5	5	300	11002
MU.KSS-DN5-400	9,5	5	400	11003
MU.KSS-DN5-500	9,5	5	500	11004

72 990 ...

Sealing plugs

- ▲ for closing off the quick-coupler to protect against contamination

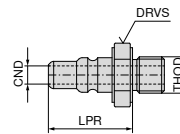


Designation	LPR mm	DLN mm	
MU.KSVS	5,5	15,5	17001

72 994 ...

Coupler connector

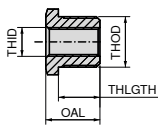
- ▲ pressure-resistant up to at least 400 bar



Designation	LPR mm	CND mm	DRVS mm	OAL mm	
MU.KSKS-M8x1	18,5	4	12	19	13001

72 992 ...

Threaded adapter



THID	THOD	THLGTH mm	DRVS mm	OAL mm	
G1/8"	G1/4"	11,5	17	15,0	01005
G1/8"	M8x1	11,5	14	15,0	01006
G1/8"	M12x1	11,5	14	15,0	01007
G1/8"	M14x1	11,5	17	15,0	01008
M8x1	G1/4"	11,5	17	15,0	01003
M8x1	M12x1	11,5	14	15,0	01001
M8x1	M14x1	11,5	17	15,0	01002
M8x1	G1/8"	11,5	14	23,5	01004

72 988 ...

G1/8" screw plug

- ▲ Max. 200 bar/2900 psi
- ▲ No sealing ring required

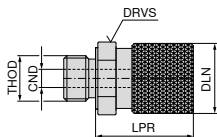


Designation	THSZMS	
VS.G1/8	G1/8"	010

72 950 ...

Quick-coupler

- ▲ pressure-resistant up to at least 400 bar
- ▲ rapid change of coolant distribution without screws thanks to click system



THOD mm	BD mm	DLN mm	LPR mm	CND mm	DRVS mm	
G1/8"	16	15,5	21,5	4	14	15001

72 993 ...

Angled coolant connection for distributor

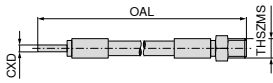


Designation	THOD	THID	
MU.KS-KA-KSV	G1/8"	G1/8"	18003

72 987 ...

Hose (connecting piece/thread)

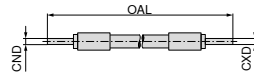
- ▲ Max. 200 bar/2900 psi
- ▲ No sealing ring required



72 305 ...			
Designation	THSZMS	CXD mm	OAL mm
HDKS.150.M5-4	M5	4	150
HDKS.200.M5-4	M5	4	200
HDKS.300.M5-4	M5	4	300
HDKS.500.M5-4	M5	4	500

Hose (connecting piece/connecting piece)

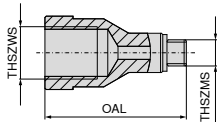
- ▲ Max. 200 bar/2900 psi



72 305 ...			
Designation	CND mm	CXD mm	OAL mm
HDKS.150.4-4	4	4	150
HDKS.200.4-4	4	4	200
HDKS.300.4-4	4	4	300
HDKS.500.4-4	4	4	500

Reducer fitting

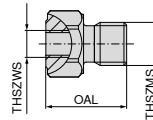
- ▲ Max. 200 bar/2900 psi
- ▲ Includes sealing ring



72 301 ...			
Designation	THSZWS	THSZMS	OAL mm
RV.100.M5-M6	M6	M5	15
RV.100.M5-M8x1	M8x1	M5	23
RV.100.M5-M10x1	M10x1	M5	27
RV.100.M5-G1/8	G1/8"	M5	27

Reducer fitting

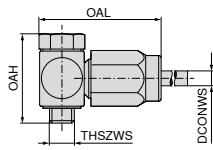
- ▲ Max. 200 bar/2900 psi
- ▲ No sealing ring required



72 301 ...			
Designation	THSZWS	THSZMS	OAL mm
RV.100.M6-M5	M5	M6	18
RV.100.M8x1-M5	M5	M8x1	15
RV.100.M10x1-M5	M5	M10x1	15
RV.100.G1/8-M5	M5	G1/8"	15

Swivel fitting

▲ Max. 200 bar/2900 psi

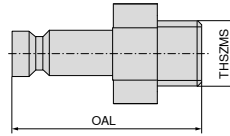


72 307 ...

Designation	DCONWS mm	OAH mm	THSZMS	OAL mm	
KA.SV.M5-4	4	21	M5	28	017
KA.SV.G1/8-4	4	30	G1/8"	37	012

Quick connection (connector)

▲ Max. 200 bar/2900 psi
▲ No sealing ring required

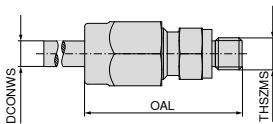


72 320 ...

Designation	THSZMS	OAL mm	
SAG.M5	M5	20	001

Straight fitting

▲ Max. 200 bar/2900 psi

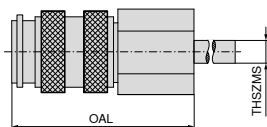


72 307 ...

Designation	DCONWS mm	THSZMS	OAL mm	
KA. M5-4	4	M5	27	009
KA. G1/8-4	4	G1/8"	32	003

Quick connection (coupling)

▲ Max. 200 bar/2900 psi



72 319 ...

Designation	THSZMS	OAL mm	
KIG.M5	M5	26	001


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	< 0,45 % C 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	< 0,75 % C 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
S.1.2			Fe - basis 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			Ni or Co basis Age-hardened	1180 N/mm ² / 350 HB	2.4668	NiCr19Nb5Mo3 (Inconel 718)	2.4955	NiFe25Cr20NbTi
S.2.3			Ni or Co basis 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

Index	DRAGONSKIN														H210T	H10T H216T
	TCM407	TCM10	CTEP110	CTCP115-P	CTCP125-P	CTCP135-P	CTCK110	CTCK120	CTPM125	CTCM120	CTCM130	CTPX710 -F05 -F34 -M34 -M42	CTPX710 -25P -25Q	CTPX715 -27 -29		
v _c in m/min																
P.1.1	380	310	460	370	295	210	395	330	200	230	185	325	340	275		
P.1.2	330	265	400	315	250	175	345	280	170	200	150	290	300	235		
P.1.3	280	230	350	270	210	145	300	240	140	175	125	250	260	200		
P.1.4	265	210	330	250	200	135	280	220	130	165	115	240	250	190		
P.1.5	240	190	300	230	180	120	260	200	120	150	100	220	235	170		
P.2.1	335	270	410	325	260	180	350	290	175	200	160	290	300	240		
P.2.2	260	210	325	250	195	130	280	220	130	160	110	235	250	185		
P.2.3	240	190	300	230	180	120	260	200	120	150	100	220	235	170		
P.2.4	180	145	230	170	130	85	200	150	80	115	60	175	190	125		
P.3.1	280	220	345	200	170	150	270	220	140	160	125	140	150	140		
P.3.2	225	170	280	140	105	95	225	175	100	115	80	85	95	80		
P.3.3	170	115	210	85	40	35	180	130	50	75	40	30	35	25		
P.4.1	280	220	345	200	170	155			140	160	125	140	155	140		
P.4.2	250	195	310	170	135	125			120	140	100	115	130	110		
M.1.1	280	220	345			155			140	160	125	140	150	140		
M.2.1						95			100	115	80	85	90	80		
M.3.1						135			130	150	110	125	130	120		
K.1.1			410	255	170		400	275						200	170	140
K.1.2			310	235	160		310	265						160	130	115
K.2.1	355	260	440	270	180		320	290						190	180	150
K.2.2	315	215	350	205	160		275	230						150	130	110
K.3.1	325	300	415	250	200		310	275						210	190	170
K.3.2	250	205	250	210	160		265	230						180	160	140
N.1.1												1840	1840	1750	1650	1400
N.1.2												1600	1600	1500	1350	1100
N.2.1												1250	1250	1200	1200	950
N.2.2												1250	1250	1200	1100	950
N.2.3												750	750	700	600	500
N.3.1												650	650	625	525	425
N.3.2												630	630	600	500	400
N.3.3												500	500	475	375	275
N.4.1												340	340	325	275	225
S.1.1											35	100	110	40	45	
S.1.2											25	80	85	30	35	
S.2.1											20	65	75	30	35	
S.2.2											20	40	45	25	25	
S.2.3											20	40	45	20	20	
S.3.1											110	95	100	110	110	
S.3.2											65	55	60	70	70	
S.3.3											45	40	45	50	50	
H.1.1																
H.1.2																
H.1.3																
H.1.4																
H.2.1																
H.3.1																
O.1.1														140	160	130
O.1.2																
O.2.1														150	140	105
O.2.2																
O.3.1																

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

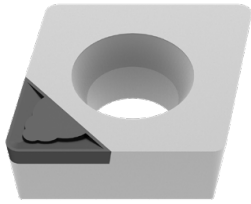
Cutting data standard values for diamond cutting materials CTD PD20 / PS30 / PU20 / CD10 / MD05

Index	Material group	Tool Material	$a_p = 0,04-0,4 \text{ mm}$		$a_p = 0,4-1,0 \text{ mm}$		$a_p = 0,4-2,5 \text{ mm}$	
			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 $f=0,05-0,5 \text{ mm/rev.}$	Tool Material v_c in m/min	PD20 / PU20 / CD10 / MD05 min. 400	PD20 / PU20 / CD10 / MD05 min. 400	PD20 / PU20 / CD10 / MD05 min. 400	PD20 / PU20 / CD10 / MD05 min. 400	PD20 / PU20 / CD10 / MD05 min. 400	PD20 / PU20 / CD10 / MD05 min. 400
		Tool Material v_c in m/min		PD20 / CD10 min. 400		PD20 / CD10 min. 400		PD20 / CD10 min. 400
		Tool Material v_c in m/min	PD20 / PU20 min. 400	PD20 / PU20 min. 400	PD20 / PU20 min. 400	PD20 / PU20 min. 400	PD20 / PU20 min. 400	PD20 / PU20 min. 400
N.2.1	Cast Aluminium Alloys $\text{Si} \leq 12\% - \text{hardened}$ or $\text{Si} = 12-20\% - \text{non hardened}$ $f=0,05-0,5 \text{ mm/rev.}$	Tool Material v_c in m/min	PS30 / PU20 / CD10 / MD05 min. 600	PS30 / PU20 / CD10 / MD05 min. 600	PS30 / PU20 / CD10 / MD05 min. 600	PS30 / PU20 / CD10 / MD05 min. 600	PS30 / PU20 / CD10 / MD05 min. 600	PS30 / PU20 / CD10 / MD05 min. 600
		Tool Material v_c in m/min	PD20 / PU20 / CD10 min. 400	PD20 / PU20 / CD10 min. 400	PD20 / PU20 / CD10 min. 400	PS30 / PU20 / CD10 min. 600	PS30 / PU20 / CD10 min. 400	PS30 / PU20 / CD10 min. 400
		Tool Material v_c in m/min	PS30 min. 600	PS30 min. 600	PS30 min. 600	PS30 min. 600	PS30 min. 600	PS30 min. 600
N.2.2 N.2.3	Aluminium cast alloys $\text{Si} = 12-20\%$ $f=0,05-0,5 \text{ mm/rev.}$	Tool Material v_c in m/min	PU20 / CD10 / MD05 min. 800	PU20 / CD10 / MD05 min. 400	PU20 / CD10 / MD05 min. 700	PU20 / CD10 / MD05 min. 400	PU20 / CD10 / MD05 min. 600	PU20 / CD10 / MD05 min. 400
		Tool Material v_c in m/min		PU20 / CD10 min. 600		PU20 / CD10 min. 600		PU20 / CD10 min. 600
		Tool Material v_c in m/min		PU20 min. 600		PU20 min. 600		
N.3.1 N.3.2 N.3.3	Copper and copper wrought alloys $f=0,05-0,5 \text{ mm/rev.}$	Tool Material v_c in m/min	PD20 / PU20 / CD10 / MD05 min. 400	PD20 / PU20 / CD10 / MD05 min. 400	PD20 / PU20 / CD10 / MD05 min. 400	PS30 / PU20 / CD10 / MD05 300-1600	PD20 / PU20 / CD10 / MD05 min. 400	PD20 / PU20 / CD10 / MD05 min. 400
		Tool Material v_c in m/min	PU20 / CD10 min. 300	PD20 / PU20 / CD10 min. 300	PD20 / PU20 / CD10 min. 400	PS30 / PU20 / CD10 min. 300	PD20 / PU20 / CD10 min. 400	PD20 / PU20 / CD10 min. 300
		Tool Material v_c in m/min		PD20 / PU20 min. 300		PS30 / PU20 min. 300	PD20 / PU20 min. 300	PS30 / PU20 min. 200
O.1.1 O.1.2	Plastic materials without reinforcement (acrylic glass) $f=0,05-0,7 \text{ mm/rev.}$	Tool Material v_c in m/min		PD20 / CD10 / MD05 min. 400		PD20 / CD10 / MD05 min. 300		PS30 / CD10 / MD05 min. 200
		Tool Material v_c in m/min		PD20 / CD10 min. 300		PD20 / CD10 min. 200		PS30 / CD10 min. 200
		Tool Material v_c in m/min		PD20 / CD10 min. 400		PD20 / CD10 min. 300		PD20 / CD10 min. 200
O.2.1 O.2.2	Plastic materials with reinforcement (glass-fibre, carbon-fibre reinforced) $f=0,05-0,7 \text{ mm/rev.}$	Tool Material v_c in m/min	PS30 / PU20 / CD10 / MD05 min. 500		PS30 / PU20 / CD10 / MD05 min. 400	PS30 / PU20 / CD10 / MD05 min. 300	PS30 / PU20 / CD10 / MD05 min. 300	PS30 / PU20 / CD10 / MD05 min. 200
		Tool Material v_c in m/min	PS30 / PU20 / CD10 min. 400		PS30 / PU20 / CD10 min. 300	PS30 / PU20 / CD10 min. 200	PS30 / PU20 / CD10 min. 200	PS30 / PU20 / CD10 min. 200
		Tool Material v_c in m/min	PU20 min. 500		PU20 min. 400	PU20 min. 300	PU20 min. 300	
O.3.1	Graphite	Tool Material v_c in m/min	PD20 / PS30 / PU20 / CD10 min. 100		PD20 / PS30 / PU20 / CD10 min. 100		PD20 / PS30 / PU20 / CD10 min. 100	

Smooth cut	Irregular cutting depth	Interrupted cut
------------	-------------------------	-----------------

Cutting data standard values for the CB chip breaker geometries

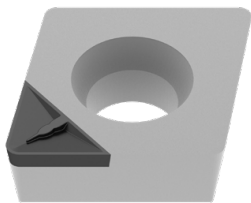
-CB1



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

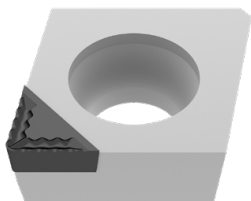
-CB2



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.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	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												

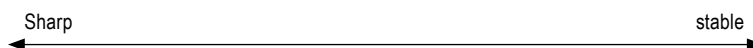
Sharp ← → stable

 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.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	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	0,35	0,7	1,0	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
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																		




Designation	-M60						-M34						-M42					
	f			a _p			f			a _p			f			a _p		
	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.
	mm/rev.			mm			mm/rev.			mm			mm/rev.			mm		
CN.. 090304																		
CN.. 090308																		
CN.. 120404							0,08	0,12	0,18	1,0	1,5	3,0	0,1	0,2	0,25	0,8	1,5	4,0
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	0,2	0,3	0,44	1,0	2,5	4,0
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	0,28	0,35	0,55	1,2	3,0	4,2
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													0,15	0,25	0,3	1,0	2,0	3,5
DN.. 110408													0,2	0,3	0,4	1,2	2,5	4,0
DN.. 110412																		
DN.. 150404							0,08	0,12	0,18	0,8	1,2	2,5	0,15	0,25	0,35	1,0	2,0	4,0
DN.. 150408	0,25	0,3	0,45	1,5	2,5	6,0	0,10	0,15	0,30	1,0	1,8	3,5	0,2	0,3	0,4	1,2	2,5	5,0
DN.. 150412	0,3	0,4	0,55	1,5	2,5	6,0	0,13	0,20	0,38	1,5	2,0	4,0						
DN.. 150416																		
DN.. 150604													0,15	0,25	0,35	1,0	2,0	4,0
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	0,2	0,3	0,44	1,2	2,5	5,0
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	0,15	0,25	0,4	1,0	2,0	4,5
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	0,2	0,25	0,45	1,0	2,0	5,0
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													0,1	0,2	0,3	0,8	2,0	5,0
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	0,12	0,2	0,35	0,8	2,0	5,0
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													0,1	0,22	0,35	0,5	1,0	3,0
WN.. 060408	0,25	0,30	0,45	1,5	2,0	4,0							0,1	0,22	0,35	0,5	1,0	3,0
WN.. 060412	0,30	0,35	0,50	2,0	2,5	4,5												
WN.. 080404													0,1	0,2	0,35	0,4	1,5	4,0
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	0,15	0,25	0,4	0,8	1,5	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	0,2	0,3	0,45	1,0	2,0	4,0
WN.. 080416																		



Cutting data values for positive inserts

Designation	-CF05						-SF					
	f			a _p			f			a _p		
	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	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.. 0602MO												
RC.. 0803MO												
RC.. 1003MO												
RC.. 1204MO												
RC.. 1606MO												
RC.. 2006MO												
RC.. 2507MO												
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

Sharp ← → stable

 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.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	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.. 0602MO													0,2	0,3	0,5	0,2	0,5	1,5
RC.. 0803MO													0,2	0,3	0,6	0,2	0,6	2
RC.. 1003MO													0,25	0,4	0,7	0,2	0,7	2,5
RC.. 1204MO													0,3	0,5	0,8	0,2	0,8	3
RC.. 1606MO							0,15	0,3	0,6	0,25	2	3,5	0,4	0,6	1	0,3	1	3,5
RC.. 2006MO													0,5	0,8	1,2	0,4	1,2	4
RC.. 2507MO													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																		



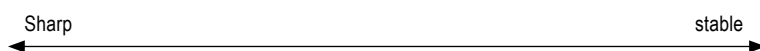
Cutting data values for positive inserts


Designation	-SMQ						-M25					
	f			a _p			f			a _p		
	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	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.. 0602MO												
RC.. 0803MO												
RC.. 1003MO												
RC.. 1204MO												
RC.. 1606MO												
RC.. 2006MO												
RC.. 2507MO												
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												

Sharp ← → stable

 The data shows reference values. An adjustment to the actual conditions may be required.

Designation	-M55						-F05					
	f			a _p			f			a _p		
	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.
	mm/rev.			mm			mm/rev.			mm		
CC.. 060200												
CC.. 060201							0,02	0,03	0,05	0,1	1	2
CC.. 060202							0,02	0,05	0,1	0,1	1	2
CC.. 060204	0,06	0,13	0,20	0,4	1,5	2,6	0,02	0,1	0,2	0,1	1	2
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.. 0602MO												
RC.. 0803MO												
RC.. 1003MO												
RC.. 1204MO												
RC.. 1606MO												
RC.. 2006MO												
RC.. 2507MO												
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												



 Information on the cutting data of chip breakers not included in this overview, can be found on → Page 211–217

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 Trailing edge inserts for machining aluminium, non ferrous metals, plastics, ...

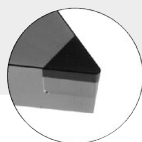
The cutting materials

	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	<ul style="list-style-type: none"> ▲ perfect sharp edges ▲ no cutting pressure ▲ very close tolerances ▲ highest abrasion resistance with highest toughness ▲ very high heat conductivity 	<ul style="list-style-type: none"> ▲ high sharpness ▲ lower cutting pressure than PDC-S ▲ close tolerance ▲ lower abrasion resistance with increased toughness 	<ul style="list-style-type: none"> ▲ very sharp cutting edge ▲ reduced cutting pressure ▲ tight tolerances ▲ very high level of wear resistance and toughness 	<ul style="list-style-type: none"> ▲ 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

Cutting Geometries

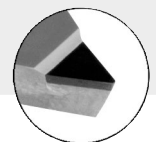
Neutral rake angle:

- ▲ higher cutting force
- ▲ higher temperature
- ▲ improved surface quality
- ▲ for stable workpieces



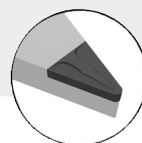
Positive rake angle: 5° / 7°

- ▲ lower cutting force
- ▲ lower temperature
- ▲ reduction in surface quality
- ▲ for unstable workpieces
- ▲ improved accuracy



CB chip breaker geometries:





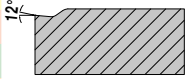

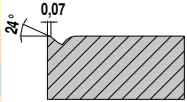

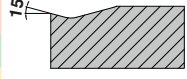

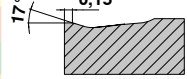

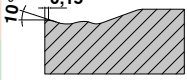
- ▲ reliable chip control
- ▲ ideal for low-alloy aluminium
- ▲ For F | M | R applications



Notes on diamond usage






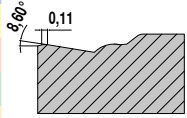
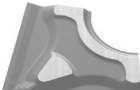
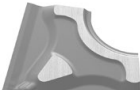
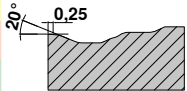
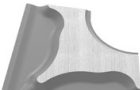
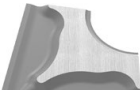
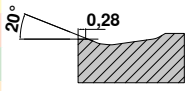
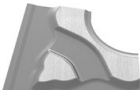
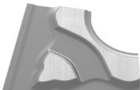
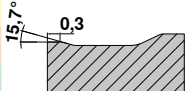


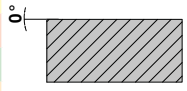
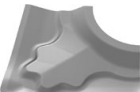
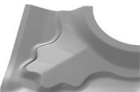
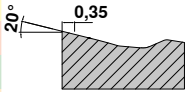
- ▲ Coolant is not generally needed, however it facilitates chip removal
- ▲ Note the chemical reaction to carbide-forming elements (PCD)
- ▲ Note the thermal interaction and critical temperature:
PCD: 600 °C, CVD: 700 °C
Depending on the material, use cooling.

Standard chip breakers / application notes

Negative	Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration		Geometry
					a _p mm	f mm	
-CF / -CF20 ▲ Fine finishing ▲ Sharp cutting edge for low cutting forces ▲ Good chip control even at small depths of cut	 F	CTEP110 / TCM10			 12°	CN.. DN.. TN.. WN..	
		CTEP110 / TCM10					
		CTEP110 / TCM10					
					0,30–1,50	0,07–0,25	
-F40 ▲ Fine turning chip breaker for machining steels ▲ Good chip control ▲ Ideal for copy turning work	 F	CTCP125-P	CTCP125-P		 24° 0,07	VN..	
		CTCP125-P	CTCP125-P				
					0,50–2,00	0,10–0,30	
-F50 ▲ Fine turning chip breaker for fine machining ▲ Steel and stainless steels ▲ Excellent chip control ▲ High surface quality	 F	CTCP115-P / CTCP125-P	CTCP115-P / CTCP125-P / CTCP135-P	CTCP135-P	 15°	CN.. DN.. SN.. TN.. VN.. WN..	
			CTCP135-P	CTCP135-P			
					0,10–2,60	0,06–0,35	
-TFQ ▲ Wiper geometry ▲ Finishing to medium machining ▲ Very high feeds ▲ High surface quality	 F	CTEP110 / CTCP115-P	CTCP115-P / CTCP125-P		 17° 0,15	CN.. DN.. WN..	
		CTCP110					
		CTEP110 / CTCP115-P	CTCP115-P / CTCP125-P				
					0,50–5,00	0,10–0,60	
-XU ▲ Finishing to light roughing ▲ Universal chip breaker ▲ Copy turning ▲ Excellent chip formation ▲ Low cutting forces	 M	CTCP115-P / CTCP125-P	CTCP115-P / CTCP125-P	CTCP125-P	 10° 0,15	CN.. DN.. VN.. WN..	
		CTCP115-P	CTCP115-P / CTCP125-P				
					0,40–4,50	0,12–0,40	

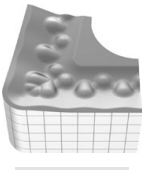
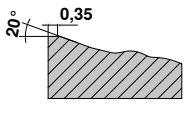

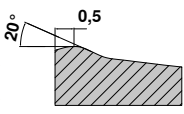

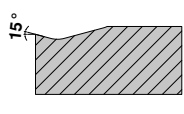

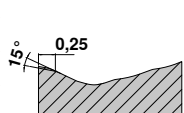

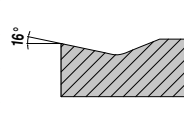

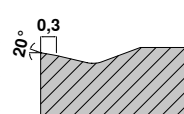
Main application steel and cast iron, secondary application stainless steels

Standard chip breakers / application notes





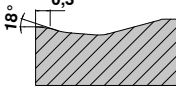

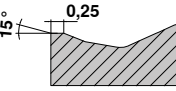

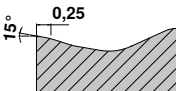

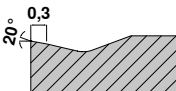
Negative	Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration		Geometry
					a _p mm	f mm	
-M40 ▲ Stable geometry ▲ Medium feed rates ▲ Can be used for any application ▲ Good chip control  M	 M	CTCP125-P	CTCP125-P		 8,60°, 0,11	VN..	
		CTCP125-P	CTCP125-P				
-M50 ▲ Medium machining ▲ First choice for steel machining ▲ Universal application ▲ Wide range of applications  M	 M	CTCP115-P / CTCP125-P / CTCK110 / CTCK120	CTCP115-P / CTCP125-P	CTCP125-P / CTCP135-P	 20°, 0,25	CN.. DN.. SN.. TN.. VN.. WN..	
		CTCP115-P	CTCP125-P	CTCP135-P			
		CTCP115-P / CTCP125-P / CTCK110 / CTCK120	CTCP115-P / CTCP125-P / CTCK110 / CTCK120	CTCP125-P / CTCK120			
-TMQ ▲ Wiper geometry ▲ Light to medium rough machining ▲ Very high feeds ▲ High surface quality  M	 M	CTCP115-P	CTCP125-P		 20°, 0,28	CN.. DN.. WN..	
		CTCP125-P	CTCP125-P				
		CTCP125-P	CTCP125-P				
-M70 ▲ Light to medium rough machining ▲ Cast crust and forging skin ▲ Stable cutting edge ▲ Interrupted cut ▲ Raw materials and forgings  M R	 M R	CTCK110 / CTCK120 / CTCP115-P	CTCP115-P / CTCP125-P	CTCP125-P / CTCP135-P	 15,7°, 0,3	CN.. DN.. SN.. TN.. WN..	
		CTCP115-P	CTCP125-P	CTCP135-P			
		CTCK110 / CTCK120 / CTCP115-P / CTCP125-P	CTCK120 / CTCP125-P	CTCP125-P / CTCK120			
-NMA ▲ Rough machining ▲ Stable cutting edge ▲ For short-chipping materials ▲ First choice for grey cast iron  R	 R				 0°	CN.. DN.. SN.. TN.. WN..	
		CTCK110	CTCK110 / CTCK120	CTCK120			
-R28 ▲ Single sided roughing geometry ▲ Longitudinal, face and copy turning ▲ Varying depths of cut ▲ Steels with low tensile strength (800 N / mm ²) ▲ Good chip control  R	 R	CTCP115-P / CTCP125-P	CTCP115-P / CTCP125-P / CTCP135-P	CTCP135-P	 20°, 0,35	CN.. DN.. SN..	
		CTCP115-P / CTCP125-P	CTCP125-P / CTCP135-P	CTCP135-P			
		CTCP115-P	CTCP125-P	CTCP135-P			

Main application steel and cast iron, secondary application stainless steels


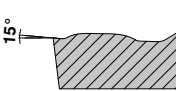

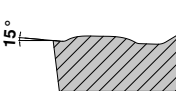

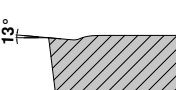
Standard chip breakers / application notes

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-P / CTCP125-P	CTCP115-P / CTCP125-P / CTCP135-P	CTCP135-P		1,50-12,00	0,30-1,20	CN.. DN.. SN.. TN..
	<ul style="list-style-type: none"> ▲ Single sided roughing geometry ▲ Longitudinal and face turning ▲ Light interrupted cut ▲ Low cutting forces ▲ Unstable machines 		CTCP115-P / CTCP125-P	CTCP125-P / CTCP135-P	CTCP135-P				
	CTCP115-P		CTCP115-P / CTCP125-P	CTCP125-P					
	-R88	 R	CTCP115-P / CTCP125-P	CTCP115-P / CTCP125-P / CTCP135-P	CTCP135-P		3,50-16,00	0,50-1,50	SN..
<ul style="list-style-type: none"> ▲ Single sided roughing geometry ▲ Longitudinal and face turning ▲ High feedrate ▲ Large depths of cut ▲ Heavily interrupted cut 	CTCP115-P / CTCP125-P		CTCP115-P / CTCP125-P	CTCP135-P					
	CTCP115-P		CTCP115-P / CTCP125-P	CTCP125-P					
Main application stainless steels, secondary application steel and super alloys	-F30	 F	CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130	CTCM130		0,08-2,5	0,10-0,35	CN.. DN.. SN.. TN.. VN.. WN..
	<ul style="list-style-type: none"> ▲ Finishing of stainless steels ▲ Continuous cut ▲ High surface quality ▲ Good swarf control 		CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130	CTCM130				
	-M30	 F M	CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130	CTCM130		1,00-4,50	0,15-0,40	CN.. DN.. SN.. TN.. VN.. WN..
<ul style="list-style-type: none"> ▲ Option for stainless steel machining ▲ Good swarf control ▲ Little edg build up ▲ Low cutting forces ▲ Little built-up edge ▲ Applicable on unstable machines 	CTCM120 / CTPM125		CTCM120 / CTPM125 / CTCM130	CTCM130					
	-42	 M			CTCM130		0,50-4,50	0,05-0,35	CN..
<ul style="list-style-type: none"> ▲ Extremely soft-cutting chip breaker ▲ For small and medium widths of cut ▲ Suitable for thin-walled parts 				CTCM130					
				CTCM130					
	-M42	 M			CTCM130		1,00-3,50	0,15-0,40	DN.. SN.. TN.. WN..
<ul style="list-style-type: none"> ▲ For medium machining on stainless steels ▲ As a secondary application for general steels and super alloys 				CTCM130					
				CTCM130					


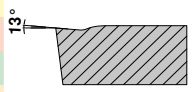
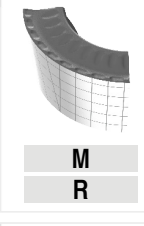
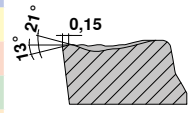
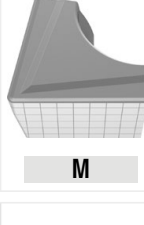
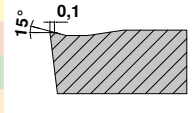

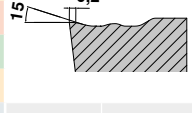
Standard chip breakers / application notes

Negative		Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration		Geometry	
						a _p mm	f mm		
Main application super alloys, secondary application stainless steels	-M60 ▲ Light to medium roughing ▲ Stable cutting edge ▲ Interrupted cut ▲ Forged skin and cast crust	 M R	CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130	CTCM130		1,50–6,00	0,25–0,50	CN.. DN.. SN.. TN.. WN..
			CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130	CTCM130				
			CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130	CTCM130				
			CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130	CTCM130				
Main application super alloys, secondary application stainless steels	-F34 ▲ Stable, positive cutting edge ▲ Also for slightly interrupted cuts	 F	CTPX710	CTPX710			0,50–2,50	0,08–0,25	CN.. WN..
			CTPX710	CTPX710					
			CTPX710	CTPX710					
			CTPX710	CTPX710					
Main application super alloys, secondary application stainless steels	-M34 ▲ First choice for superalloys ▲ Light cutting geometry ▲ Little built-up edge ▲ Low cutting forces	 M	CTPX710	CTPX710			0,80–3,0	0,10–0,30	CN.. DN.. SN.. VN.. WN..
			CTPX710	CTPX710					
			CTPX710	CTPX710					
			CTPX710	CTPX710					
Main application super alloys, secondary application stainless steels	-M42 ▲ For medium machining on stainless steels ▲ As a secondary application for general steels and super alloys	 M	CTCM130	CTCM130	CTCM130		1,0–3,50	0,15–0,40	CN.. DN..
			CTPX710	CTPX710					
			CTPX710	CTPX710					
			CTPX710	CTPX710					

Positive


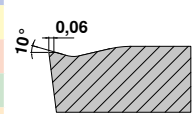
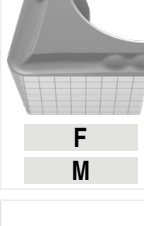
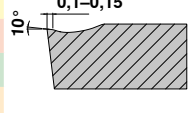

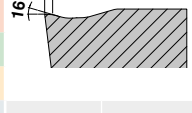
Main application steel and cast iron, secondary application stainless steels and super alloys	-CF05 ▲ Fine finishing ▲ For all common steel materials, stainless steels and GGG ▲ Good swarf control ▲ High surface quality	 F	CTEP110 / TCM407	TCM10 / TCM407			0,20–1,30	0,06–0,25	CC.. DC.. SC.. TC.. VC..
			CTEP110						
			CTEP110	TCM10 / TCM407					
			CTEP110	TCM10 / TCM407					
Main application steel and cast iron, secondary application stainless steels and super alloys	-SF ▲ Finishing / contour turning ▲ Good swarf control ▲ High surface quality ▲ Low cutting forces	 F	CTCP115-P	CTCP125-P	CTCP125-P / CTCP135-P		0,05–2,50	0,05–0,25	CC.. DC.. SC.. TC.. VC.. WC..
			CTCP115-P	CTCP125-P	CTCP125-P / CTCP135-P				
			CTCP115-P	CTCP125-P	CTCP125-P / CTCP135-P				
			CTCP115-P	CTCP125-P	CTCP125-P / CTCP135-P				
Main application steel and cast iron, secondary application stainless steels and super alloys	-CF55 ▲ Finishing to medium machining ▲ Suitable for general and stainless steels ▲ Low cutting forces ▲ Good swarf control ▲ High surface quality	 F M	CTEP110	TCM10 / CTEP110			0,20–1,30	0,06–0,25	CC.. DC.. SC.. TC.. VC..
			CTEP110	TCM10 / CTEP110					
			CTEP110	TCM10 / CTEP110					
			CTEP110	TCM10 / CTEP110					

Standard chip breakers / application notes





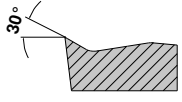
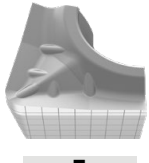
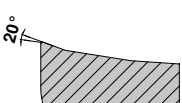

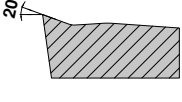

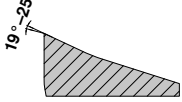

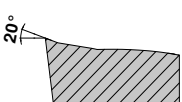
Positive		Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration		Geometry	
						a_p mm	f mm		
Main application steel and cast iron, secondary application stainless steels and super alloys	-SMF		CTEP110 / CTCP115-P	TCM10 / CTCP125-P / CTCP115-P	CTCP135-P		0,20-1,30	0,06-0,25	CC.. DC.. SC.. TC.. VC..
	▲ Finishing to medium machining		CTEP110	CTCP135-P	CTCP135-P				
	▲ Low cutting forces		CTEP110						
	▲ Good swarf control								
▲ High surface quality									
	-M23		CTCP115-P / CTCP125-P	CTCP125-P	CTCP125-P		0,30-4,0	1,0-0,45	RC..
	▲ Soft cutting geometry with outstanding chip breaking behaviour at low cutting depths in finish machining		CTCP115-P / CTCP125-P	CTCP125-P	CTCP125-P				
	-SM		CTCP115-P / CTCP125-P	CTCP125-P / CTCP135-P / CTCP115-P	CTCP125-P / CTCP135-P		0,05-5,00	0,15-0,45	CC.. DC.. RC.. SC.. TC.. VC..
	▲ Medium machining		CTCP115-P / CTCK110 / CTCK120	CTCP135-P	CTCP135-P				
	▲ Universal application			CTCP125-P / CTCK110 / CTCK120	CTCK120				
	▲ Stable cutting edge								
▲ Varying depths of cut									
▲ Wide range of applications									
	-SMQ		CTCP115-P	CTCP125-P	CTCP125-P		1,00-4,00	0,15-0,45	CC.. DC..
	▲ Positive wiper geometry		CTCP125-P / CTCP115-P	CTCP125-P	CTCP125-P				
	▲ Finishing to medium machining								
	▲ Very high feeds								
▲ High surface quality									

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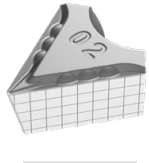
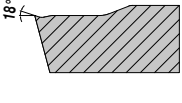
Positive

	-F43				CTCM130		0,50-2,50	0,05-0,25	CC.. DC.. TC..
	▲ For the light to medium machining of all stainless steels, general steels and superalloys				CTCM130				
					CTCM130				
	-M25		CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130	CTCM130		0,40-3,20	0,10-0,30	CC.. DC.. TC.. VC..
	▲ First choice for medium machining of stainless steels		CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130	CTCM130				
	▲ High surface quality								
	▲ Little built-up edge								
	-M55		CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130	CTCM130		0,40-4,80	0,06-0,35	CC.. DC.. SC.. TC.. VC..
	▲ First choice for medium machining to roughing of stainless steels		CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130	CTCM130				
	▲ Smooth to lightly interrupted cut								
	▲ Good swarf control								
▲ Stable cutting edge									

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 ▲ Low adhesion ▲ Good chip control with soft aluminium alloys	 F	H216T H216T	H216T H216T	H216T H216T		0,2-4,0 0,05-0,3	CC.. DC..
	-25P ▲ Sharp cutting edge ▲ Good swarf control on soft aluminium alloys ▲ Low adhesion	 F M	CTPX710 CTPX710 CTPX710 / H216T CTPX710	CTPX710 CTPX710 CTPX710 / H216T CTPX710	CTPX710 CTPX710 CTPX710 / H216T CTPX710		0,50-4,50 0,05-0,60	CC.. DC.. SC.. VC..
	-25Q ▲ Wiper geometry ▲ High feeds ▲ High surface quality ▲ Good chip control with softer aluminium alloys ▲ Low adhesion	 M	CTPX710 CTPX710 H210T H210T / CTPX710 H210T / CTPX710	CTPX710 CTPX710 H210T H210T / CTPX710 H210T / CTPX710	CTPX710 CTPX710 H210T H210T / CTPX710 H210T / CTPX710		0,05-6,50 0,05-0,60	CC.. DC.. VC..
	-27 ▲ The universal Alu geometry ▲ Sharp cutting edge ▲ Extremely positive rake angle ▲ Low adhesion ▲ High feed rates	 M R	CTPX715 CTPX715 CTPX715 / H216T CTPX715 / H216T CTPX715	CTPX715 CTPX715 CTPX715 / H216T CTPX715 / H216T CTPX715	CTPX715 CTPX715 CTPX715 / H216T CTPX715 / H216T CTPX715		1,00-10,00 0,10-0,75	CC.. DC.. RC.. SC.. TC.. VC..
	-29 ▲ Direct sintered aluminium geometry ▲ Positive rake angle ▲ Good chip control ▲ For medium to rough machining	 M R	CTPX710 CTPX710 CTPX710 H216T CTPX710	CTPX710 CTPX710 CTPX710 H216T CTPX710	CTPX710 CTPX710 CTPX710 H216T CTPX710		1,00-6,00 0,25-0,60	CC.. DC.. VC..

Positive

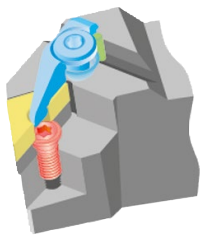
Main application super alloys and stainless steels, secondary application steels and non-ferrous metals	-F05 ▲ Maximum tolerance class ▲ Outstanding chip control, even with the smallest cutting depths ▲ Very low cutting forces	 F	CTPX710 CTPX710 CTPX710 CTPX710 CTPX710	CTPX710 CTPX710 CTPX710 CTPX710 CTPX710	CTPX710 CTPX710 CTPX710 CTPX710 CTPX710		0,10-2,50 0,02-0,25	DC.. VC..
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Supplementary chip breakers / application notes

	Model	Smooth cut	Irregular cutting depth	Interrupted cut
-EN ▲ Universal chip breaker for general steels		CTCP115-P	CTCP125-P	CTCP135-P
		CTCP125-P	CTCP135-P	CTCP135-P
		CTCK110	CTCK120	CTCP125-P
-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			CTCP125-P	CTCP135-P

Clamping systems

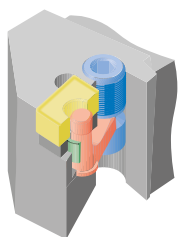
MaxiLock D



- Clamping element
- Inserts
- Insert seat
- Pin
- Screw

The first-choice tool for machining with negative centre-hole inserts. Secure and precise positioning of the indexable insert thanks to the double clamping effect of the clamping element.

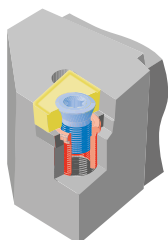
MaxiLock N



- Clamping element
- Inserts
- Insert seat
- Shim
- Lever

This clamping system is suitable for all centre-hole inserts with a negative basic shape. The clamping screw is easy to access from the top and bottom of the holder. When the clamping system is released, there are no loose spare parts.

MaxiLock S

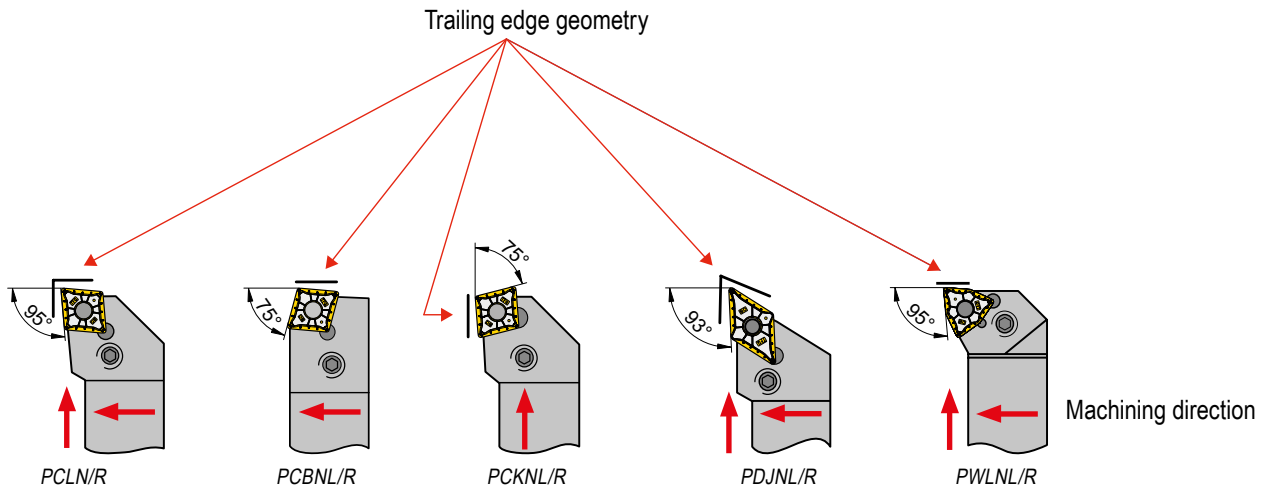


- Clamping element
- Inserts
- Insert seat
- Threaded sleeve

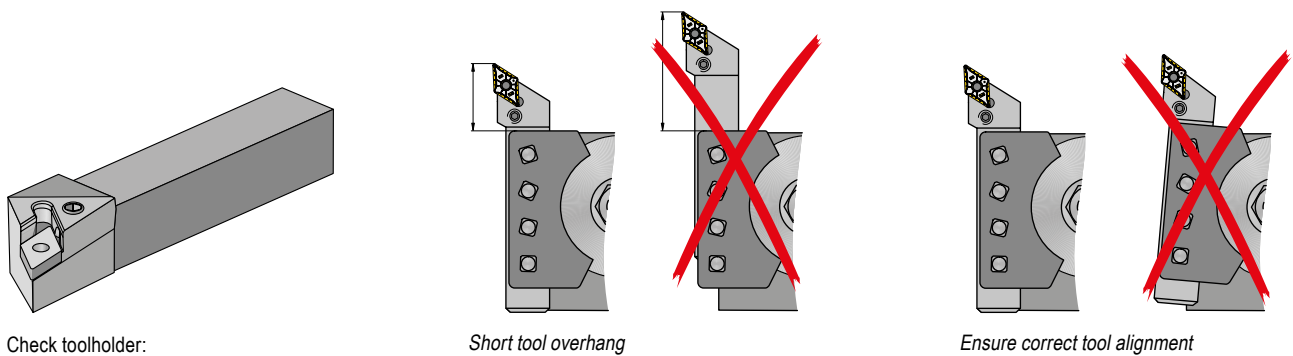
The positive screw clamping guarantees a secure connection between the indexable insert and the tool holder. The chip flow is not disrupted by protruding clamping elements. Thanks to the neutral insert position, the effective available rake angle is identical to the rake angle of the indexable insert.

Trailing edge geometry – information

High-quality surfaces can be produced inexpensively using indexable inserts with wiper geometry (-TFQ; -TMQ; -SMQ; -25Q).



All turning inserts with trailing edge are clamped in standard ISO tool holders



Check toolholder:

- ▲ Insert seat
- ▲ Shim
- ▲ Clamping Lever

Feed rate guide values for surface finish quality

Roughness range R_z in μm	R_{th}	Corresponds to R_a	Roughness index	ISO 1302	Corner radius r_c in mm and feed rate f in mm/rev.						
					RE = 0,1	RE = 0,2	RE = 0,4	RE = 0,8	RE = 1,2	RE = 1,6	RE = 2,4
63–100	$\sqrt{R_{th}63}$	12,5–25	N11	$\frac{25}{\nabla}$	0,22*	0,32*	0,45*	0,63	0,78	0,9	1,1
40–63	$\sqrt{R_{th}40}$	6,3–12,5	N10	$\frac{12,5}{\nabla}$	0,18*	0,25*	0,36	0,51	0,62	0,72	0,88
31,5–40	$\sqrt{R_{th}31,5}$	4,9–6,3	N9	$\frac{6,3}{\nabla}$	0,16*	0,22*	0,32	0,45	0,55	0,63	0,78
25–31,5	$\sqrt{R_{th}25}$	4,0–4,9			0,14*	0,2*	0,28	0,4	0,49	0,57	0,69
16–25	$\sqrt{R_{th}16}$	2,5–4,0	N8	$\frac{3,2}{\nabla}$	0,11*	0,16	0,23	0,32	0,39	0,45	0,55
10–16	$\sqrt{R_{th}10}$	1,6–2,5			0,09	0,13	0,18	0,25	0,31	0,36	0,44
6,3–10	$\sqrt{R_{th}6,3}$	1,0–1,6	N7	$\frac{1,6}{\nabla}$	0,07	0,1	0,14	0,2	0,25	0,28	0,35
4–6,3	$\sqrt{R_{th}4}$	0,8–1,0	N6	$\frac{0,8}{\nabla}$	0,06	0,08	0,11	0,16	0,2	0,23	0,28
2,5–4	$\sqrt{R_{th}2,5}$	0,4–0,8	N5	$\frac{0,4}{\nabla}$	0,04	0,06	0,09	0,13	0,15	0,18	0,22
1,6–2,5	$\sqrt{R_{th}1,6}$	0,2–0,4	N4	$\frac{0,2}{\nabla}$	0,04	0,05	0,07	0,1	0,12	0,14	0,18
1–1,6	$\sqrt{R_{th}1}$	0,1–0,2	N3	$\frac{0,1}{\nabla}$	0,03	0,04	0,06	0,08	0,1	0,11	0,14

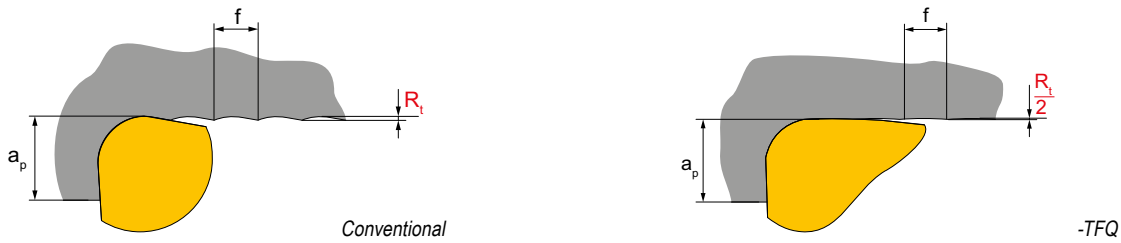
*Please ensure that the feed rate values used do not exceed the corner radius (RE).

Trailing edge geometry – operating principle

Relationship of feed rate to surface roughness

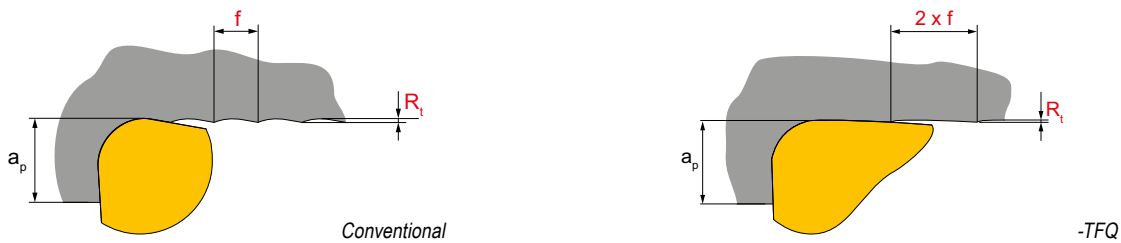
Improved Surface Quality

Given identical feed rates, the indexable insert with wiper geometry attains an R_t value that is many times better than a conventional indexable insert.



Shorter machining time

If the same R_t value is achieved as with a standard indexable insert, the indexable insert with the wiper geometry can be moved at twice the feed speed (= lower cycle times!)



9

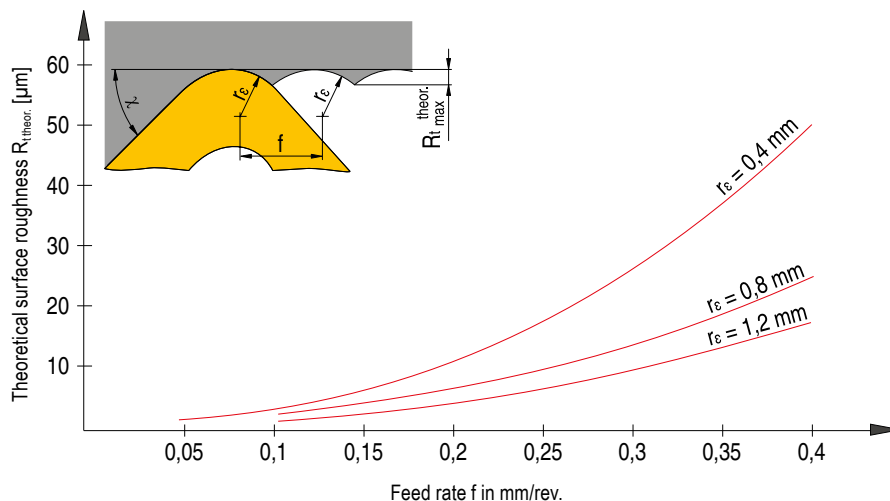
Theoretical Surface Quality

The maximum theoretical surface roughness with turning $R_{t,theor.}$ is the combination of feed rate and corner radius:

or approximately:

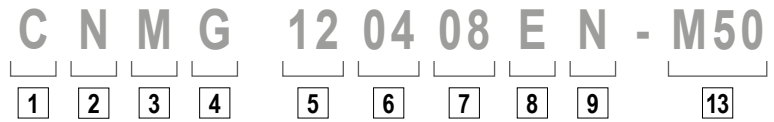
$$R_{t,theor.} = \left(r_\epsilon - \sqrt{r_\epsilon^2 - \frac{f^2}{4}} \right) \cdot 1000$$

$$R_{t,theor.} = \frac{125 \cdot f^2}{r_\epsilon} \text{ [}\mu\text{m]}$$

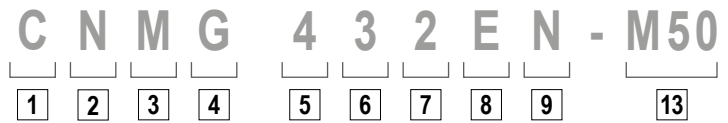


ISO designation system for inserts

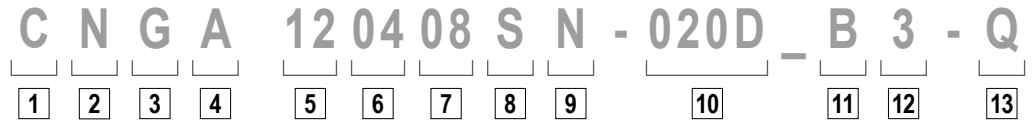
Indexable inserts – metric



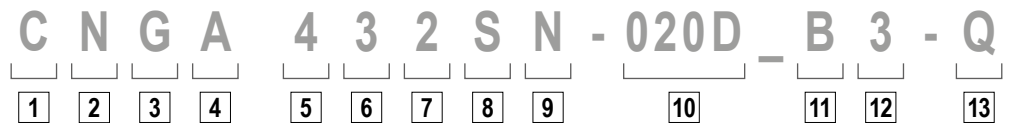
Indexable inserts – inch



Indexable inserts, CBN, ceramic – metric



Indexable inserts, CBN, ceramic – inch



1

Insert shape

V	35°	Included angle
D	55°	
E	75°	
C	80°	
M	86°	Included angle
K	55°	
B	82°	
A	85°	Other shapes
L	90°	
P	108°	
H	120°	
O	135°	
R	-	
S	90°	
T	60°	
W	80°	

2

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.

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

mm		inch		Code	
1,59	1/16	01	1		
2,38	3/32	02	1.5		
3,18	1/8	03	2		
3,97	5/32	T3	2.5		
4,76	3/16	04	3		
5,56	7/32	05	3.5		
6,35	1/4	06	4		
7,94	5/16	07	5		
9,52	3/8	09	6		

7

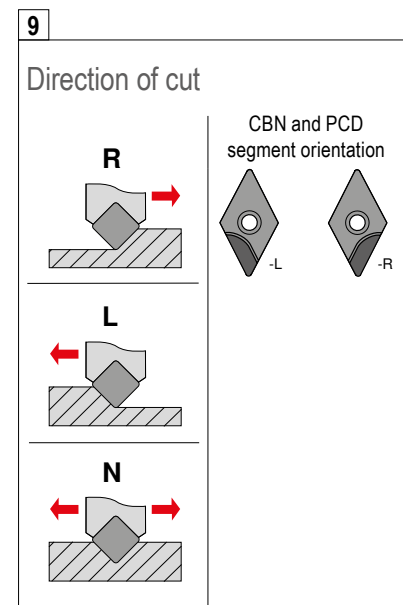
Corner radius

mm		inch		Code		
≤ 0,05	.0015	00	X0			RN 00 RC MO
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			

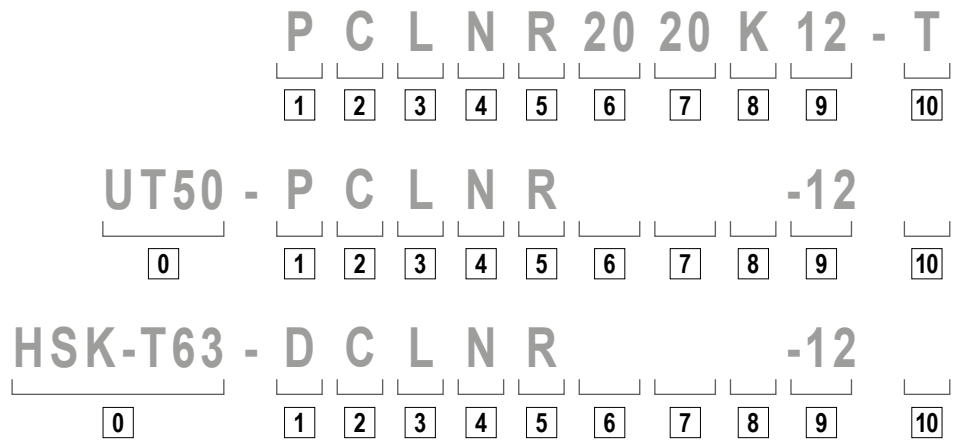
8

Cutting edge

F	Sharp
E	rounded
T	chamfered
S	Chamfered and honed
K	Double-chamfered
P	Double-chamfered and honed
R	Round chamfer



ISO designation system for tool holders



0

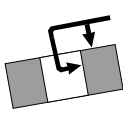
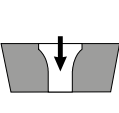
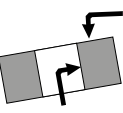
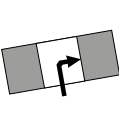
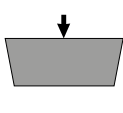
System/size

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

<p>D</p>  <p>Retained from above and via bore</p>	<p>S</p>  <p>Retained via centre screw</p>
<p>M</p>  <p>Retained from above and via bore</p>	<p>P</p>  <p>Retained via the bore</p>
<p>C</p>  <p>Retained from above</p>	<p>X</p> <p>Special version</p>

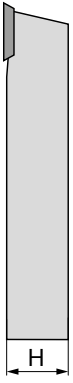
2

Insert shape

V 35°	Included angle
D 55°	
E 75°	
C 80°	Included angle
M 86°	
K 55°	Included angle
B 82°	
A 85°	Other shapes
L 90°	
P 108°	
H 120°	
O 135°	
R -	
S 90°	
T 60°	
W 80°	

6


Shank height



H

7

Shank width

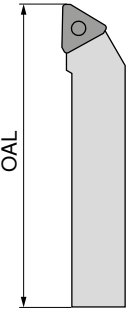


B

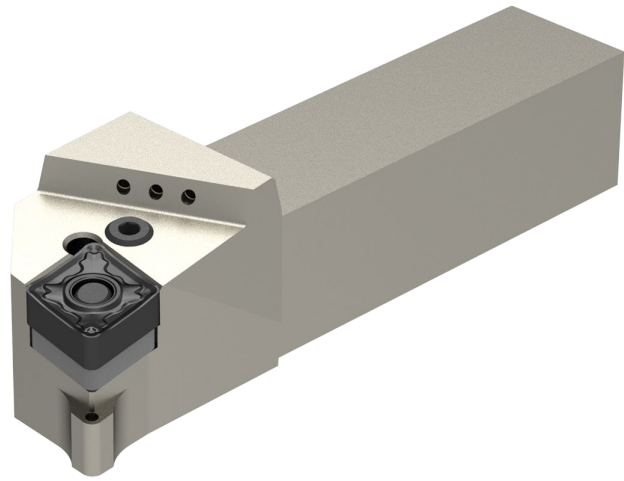
8

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			



OAL



3

Style

A 90° B 75° C 90° D 45° E 60°
 F 90° G 90° H 107,5° J 93° K 75°
 L 95° M 50° N 63° P 117,5° R 75°
 S 45° T 60° U 93° V 72,5° W 60°
 Y 85°

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

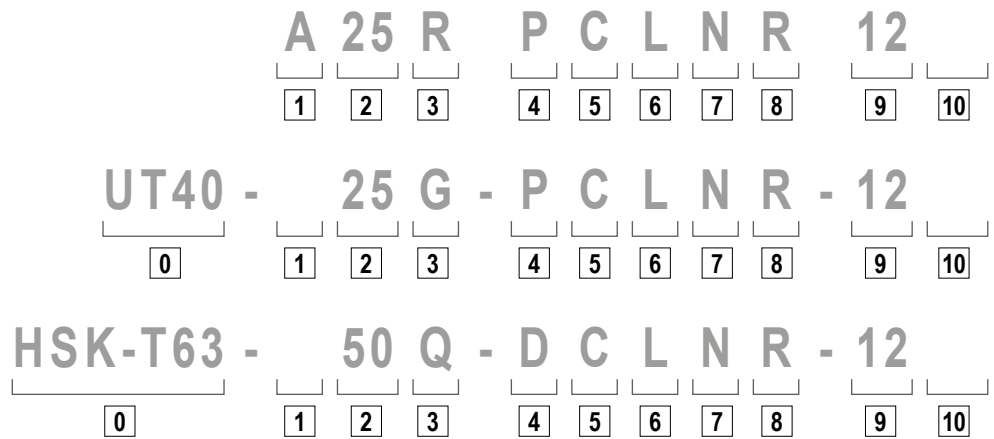
L S R
 ABK T VDECM
 O H P W

10

Manufacturer specification

T = Toggle
 Special length (mm)
 Insert thickness (deviating from standard)
 Special version (X.)
 Machine manufacturer (specific)
 DC = DirectCooling

ISO designation system for boring bars



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°	Other shapes
P 108°	
H 120°	
O 135°	
R -	
S 90°	
T 60°	
W 80°	

6

Style

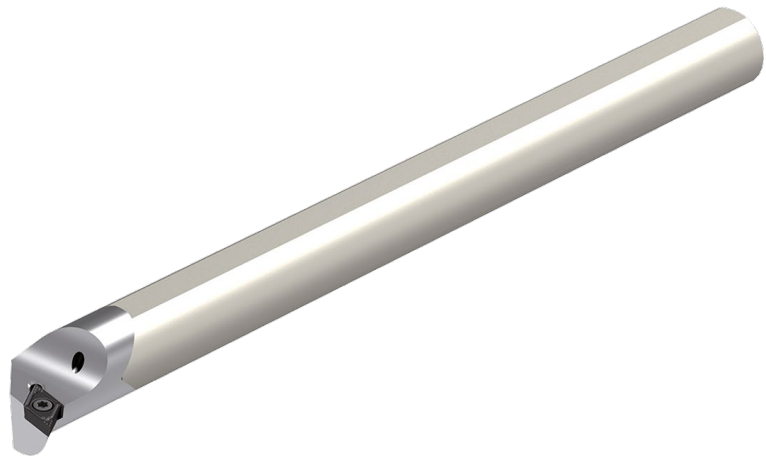
*) CERATIZIT factory standard

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

<p>D</p> <p>Retained from above and via bore</p>	<p>S</p> <p>Retained via centre screw</p>
<p>M</p> <p>Retained from above and via bore</p>	<p>P</p> <p>Retained via the bore</p>
<p>C</p> <p>Retained from above</p>	<p>X</p> <p>Special version</p>

9

8

Direction of cut

R

L

9

Cutting length

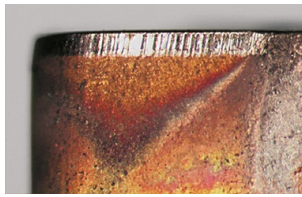
10

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.

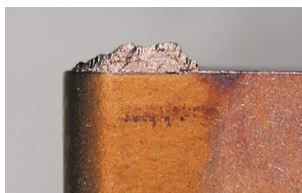
Cause

- ▲ 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

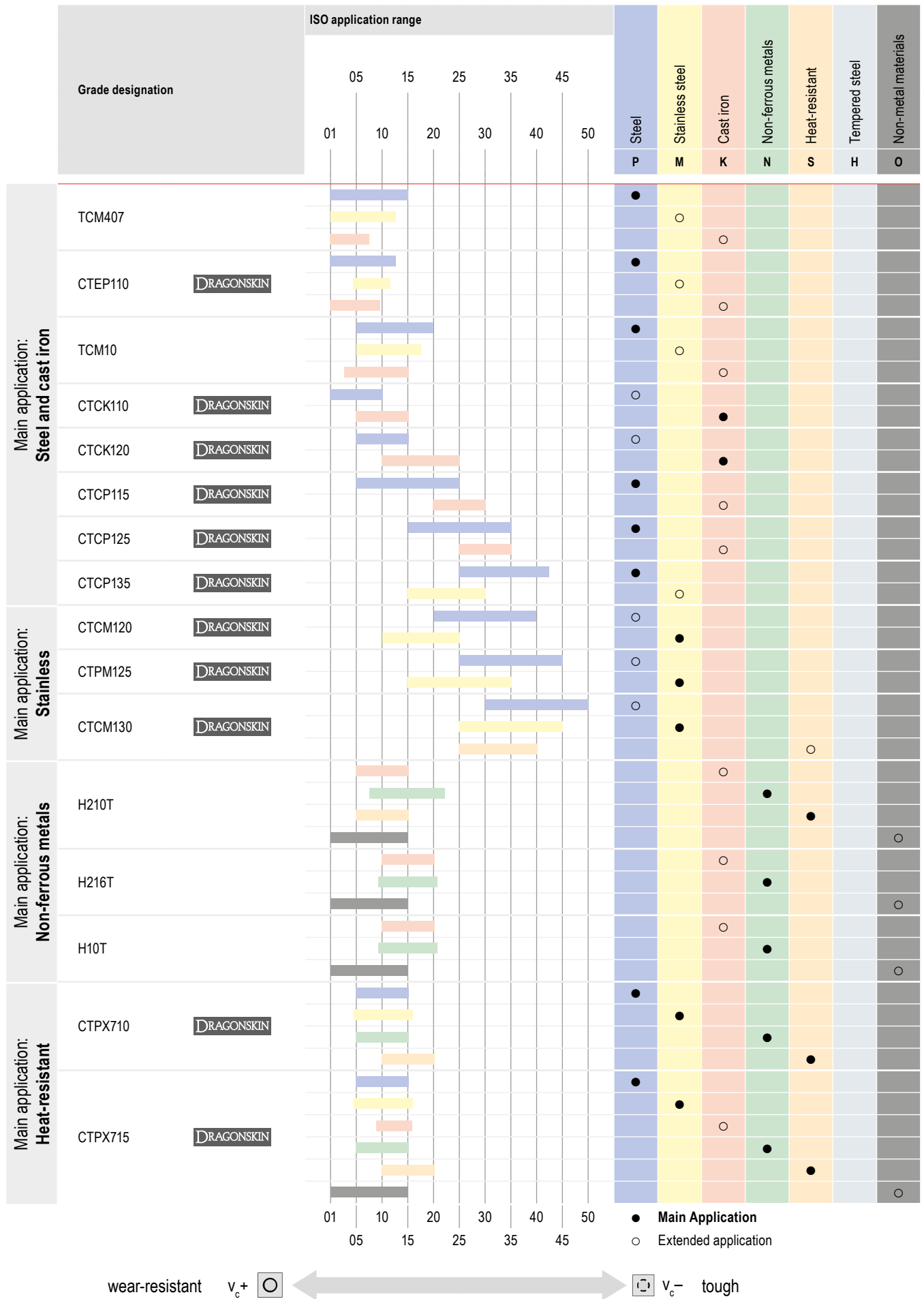
Type of problem																
Type of wear						Work piece problems			Swarf control							
Wear on clearance face	Cratering	Edge chipping	Plastic deformation	Insert breakage	Built-up edge	Vibration	Formation of pips and burrs	Chattered surface	Surface quality	Chip too long (snarf chip)	Chip too short (fragmented chip)					
↓	↓		↓		↓	↓			↑	↓		Cutting speed		Cutting data		
~		↓	↓	↓		↑		↓	↓	↑	↓	Feed rate				
↓	↓	↓	↓				↓	↓	↓			Feed rate at centre				
		↑	~		↓	~	↓	↓	↓	↓	↑	↑	↑	↓	Insert selection	
↑		↑	↑	↑		↓	↓	↓	↑			↑	↑	↓		Corner radius
↑	↑	↓	↑	↓										↓		Tool Material
		~		~		~		~	~						General criteria	
		~		~		~		~	~							Tool clamping
		~		~		~		~	~							Work piece clamping
		~		~		~			↓							Overhang
~		~				~	~		~							Tip height
●	~		●		●		●		●	●					Cooling lubricant	

raise, increase large influence
 raise, increase small influence

avoid, reduce large influence
 avoid, reduce small influence

check, optimise
 use

Grades Overview



Grade description

TCM407



ISO | P10 | M05 | K05



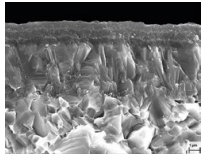
Specification:

Composition: Co 8.0%; WC 16.0%; TaNbC 10.0%; TiCN balance | Grain size: 2-3 μm | Hardness: HV30 1760

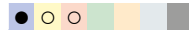
Usage recommendation:

The uncoated cermet grade for fine finishing steel materials.

CTEP110



ISO | P10 | M10 | K05



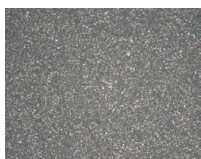
Specification:

Composition: Co/Ni 12.2%; WC 15.0%; TaNbC 10.0%; TiCN balance | Grain size: 2-3 μm | Hardness: HV30 1650 | Layer system: CVD TiCN-Al₂O₃ Multilayer

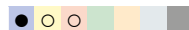
Usage recommendation:

The cermet grade with toughness reserves for finish machining at high cutting speeds.

TCM10



P15 | K10



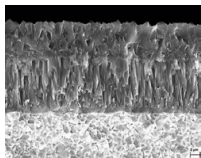
Specification:

Composition: Cermet Co/Ni 12,2%; WC 15,0%; TaNbC 10,0%; TiCN balance | Grain size: 2-3 μm | Hardness: HV₃₀ 1650

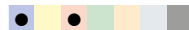
Usage recommendation:

The uncoated cermet grade for finishing steel, stainless steel and tempered steel.

CTCK110



ISO | P10 | K10



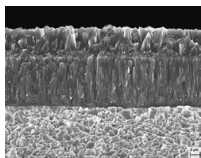
Specification:

Composition: Co 5.0%, mixed carbides 2.0%, WC balance | Grain size: 1-2 μm | Hardness: HV30 1730 | Layer system: CVD TiCN-Al₂O₃

Usage recommendation:

The wear-resistant grade for machining cast iron materials and steels at high cutting speeds with a continuous cut.

CTCK120



ISO | P20 | K20



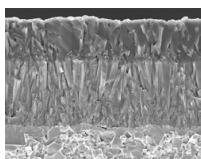
Specification:

Composition: Co 6.0%, mixed carbides 2.0%, WC balance | Grain size: 1 μm | Hardness: HV₃₀ 1630 | Layer system: CVD TiCN-Al₂O₃

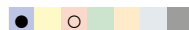
Usage recommendation:

The grade for cast iron machining with high toughness reserves for difficult conditions and interrupted cuts.

CTCP115-P



ISO | P15 | K25



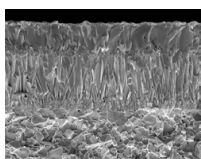
Specification:

Composition: Co 5.5%; mixed carbides 6.4%; WC balance | Grain size: 1 μm | Hardness: HV₃₀ 1530 | Layer system: CVD TiCN-Al₂O₃

Usage recommendation:

The wear-resistant high-performance grade for steel machining with stable conditions and a continuous cut.

CTCP125-P



ISO | P25 | K30



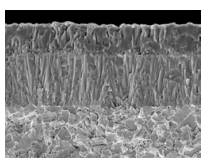
Specification:

Composition: Co 7.0%, mixed carbides 6.0%, WC balance | Grain size: 1-2 μm | Hardness: HV₃₀ 1500 | Layer system: CVD TiCN-Al₂O₃

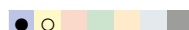
Usage recommendation:

The first choice for the universal machining of steels.

CTCP135-P



ISO | P35 | M25



Specification:

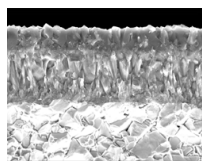
Composition: Co 9.6%, mixed carbides 7.8%, WC balance | Grain size: 1-2 μm | Hardness: HV₃₀ 1460 | Layer system: CVD TiCN-Al₂O₃

Usage recommendation:

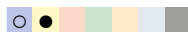
The tough alternative for extremely interrupted cutting conditions.

Grade description

CTCM120



ISO | P15 | M20



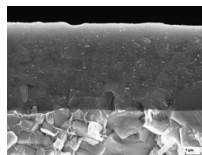
Specification:

Composition: Co 7%, mixed carbides 6%, WC balance | Grain size: 1-2 μm | Hardness: HV₃₀ 1500 | Layer system: CVD TiCN-Al₂O₃

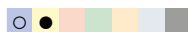
Usage recommendation:

Wear-resistant carbide grade for austenitic, stainless steel with the best levels of performance with a smooth cut.

CTPM125



ISO | P35 | M25



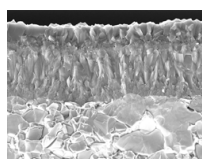
Specification:

Composition: Co 9.6%; mixed carbides 7.8%; others 0.4%; WC balance | Grain size: 1 - 2 μm | Hardness: HV₃₀ 1460 | Coating specification: PVD TiAlTaN

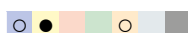
Recommended application:

The first choice for the machining of austenitic steels

CTCM130



ISO | P25 | M30 | S30



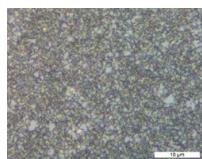
Specification:

Composition: Co 9.6%, mixed carbides 7.8%, WC balance | Grain size: 1-2 μm | Hardness: HV₃₀ 1460 | Layer system: CVD TiCN-Al₂O₃

Usage recommendation:

Robust turning grade for austenitic stainless steel with interrupted cuts.

H210T



ISO | K10 | N10 | S10 | O10



Specification:

Composition: Co 6.0%; WC balance | Grain size: 0.8 μm | Hardness: HV₃₀ 1850

Recommended application:

The wear-resistant uncoated carbide grade for the machining of aluminium and other non-ferrous metals.

H10T



ISO | K15 | N15 | S15 | O10



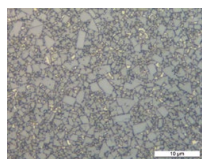
Specification:

Composition: Co 6.0%; WC balance | Grain size: 1 μm | Hardness: HV₃₀ 1630

Recommended application:

The uncoated carbide grade for the machining of aluminium and other non-ferrous metals

H216T



ISO | K15 | N15 | S15 | O10



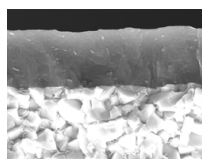
Specification:

Composition: Co 6.0%; WC balance | Grain size: 1 μm | Hardness: HV₃₀ 1630

Recommended application:

The uncoated carbide grade for the machining of aluminium and other non-ferrous metals

CTPX710



ISO | P10 | M10 | K10 | N10 | S15



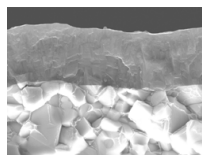
Specification:

Composition: Co 6.0%; WC balance | Grain size: 0.8 μm | Hardness: HV₃₀ 1820 | Layer system: PVD AlTiN

Usage recommendation:

The universal carbide grade for the most demanding machining requirements on multiple materials.

CTPX715



ISO | P15 | M15 | K15 | N15 | S20 | O10



Specification:

Composition: Co 6.0%; WC balance | Grain size: 1 μm | Hardness: HV₃₀ 1650 | Layer system: PVD AlTiN

Usage recommendation:

The universal carbide grade for the most demanding machining requirements on multiple materials.

Grade description

