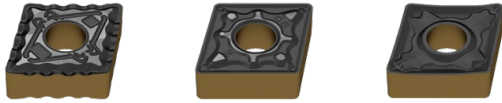


New products for machining technicians

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

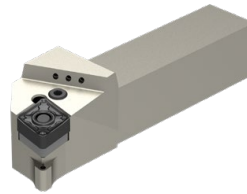
Tool holder with square shank – MaxiLock-S DC for positive indexable inserts



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 190+191**

NEW

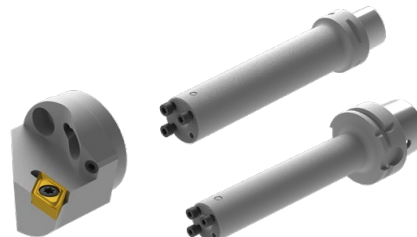
-M23 chip breaker



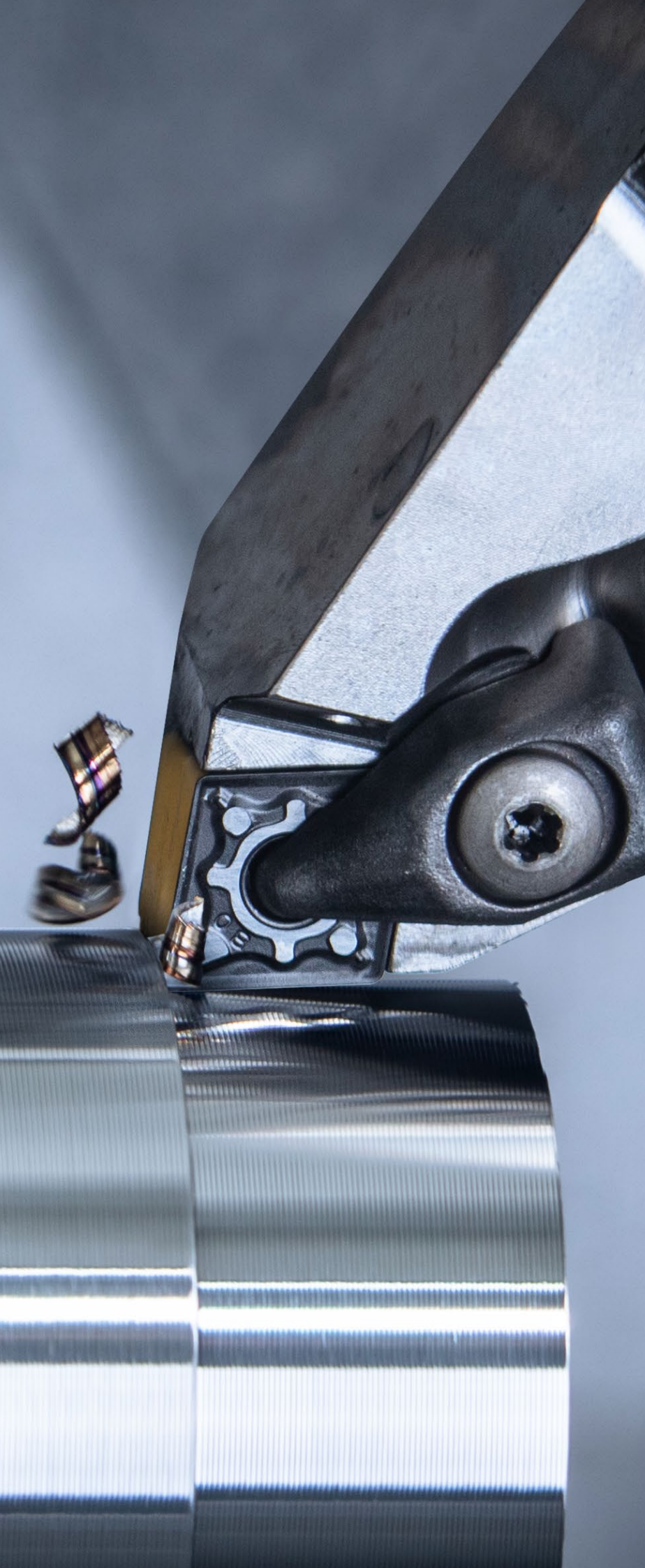
Soft cutting geometry with excellent Chip breaking behavior at low cutting depths for steel machining. Available for positive round inserts in the ISO-P carbide grades.

NEW

Exchangeable head system



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



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

Table of contents

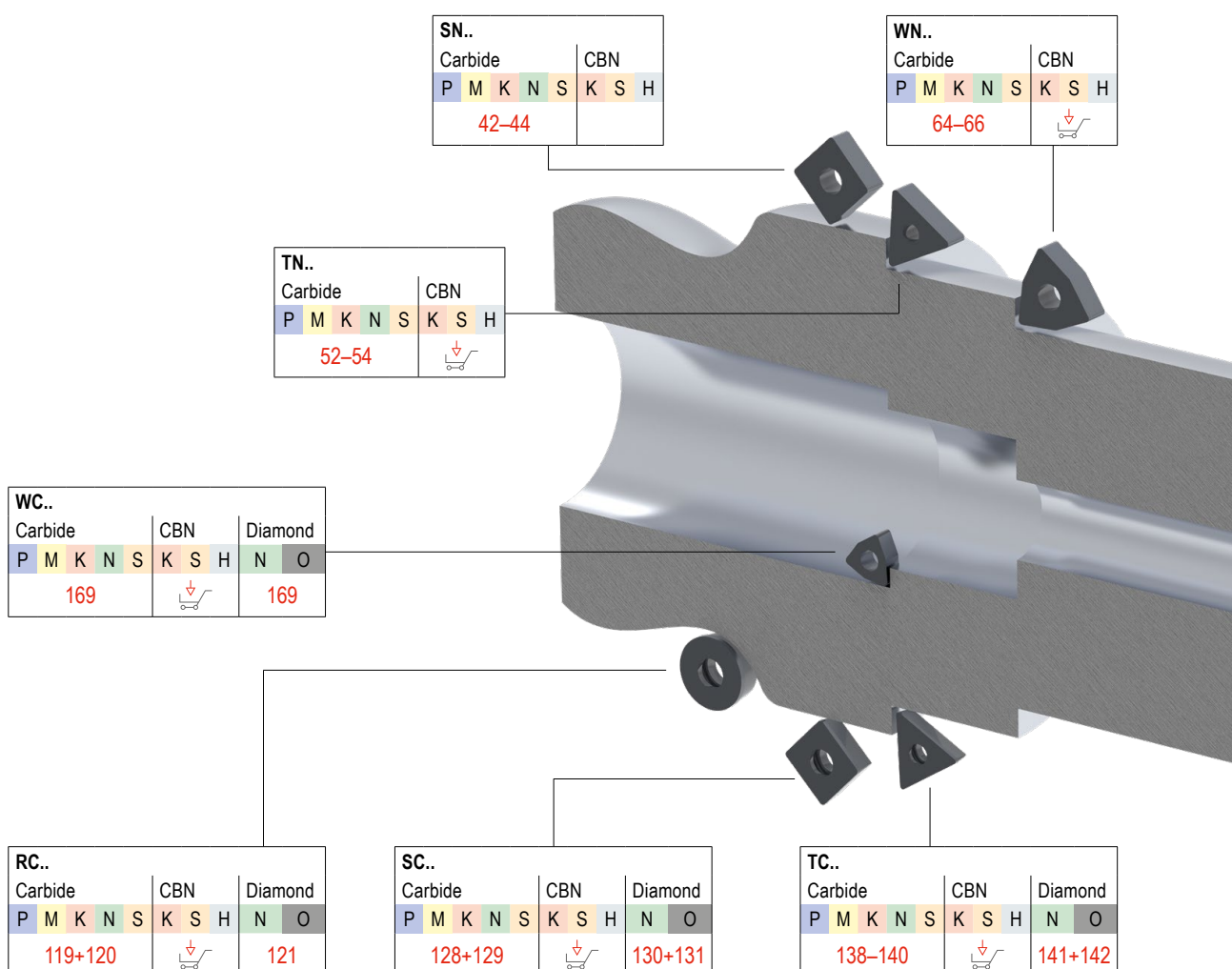
Symbol explanation	5
Chip Breakers Overview / Grade description	6
Toolfinder – Application	4+5
Toolfinder – negative inserts	7
Toolfinder – positive inserts	8
Toolfinder – holders	9
Toolfinder – exchange head system	10
Product programme	11–185
Technical Information	
Cutting Data	186–199
Diamond as a cutting material	200
Chip breakers	201–207
Clamping systems	207
Trailing edge geometry – information	208+209
ISO designation system	210–215
Wear types in indexable inserts	216+217
Grades Overview	218–221

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

F Fine Machining
M Medium Machining
R Rough Machining



Smooth cut
 Irregular cutting depth
 Interrupted cut



Int. coolant supply



DirectCooling

A detailed overview of grades can be found in the technical appendix on → **page 218**

9

CN..					CBN			Diamond	
Carbide									
P	M	K	N	S	K	S	H	N	S
11-15								16	

DN..					CBN			Diamond	
Carbide									
P	M	K	N	S	K	S	H	N	S
25-28								29	

VN..					CBN		
Carbide							
P	M	K	N	S	K	S	H
59+60							

KN..				
Carbide				
P	M	K	N	S

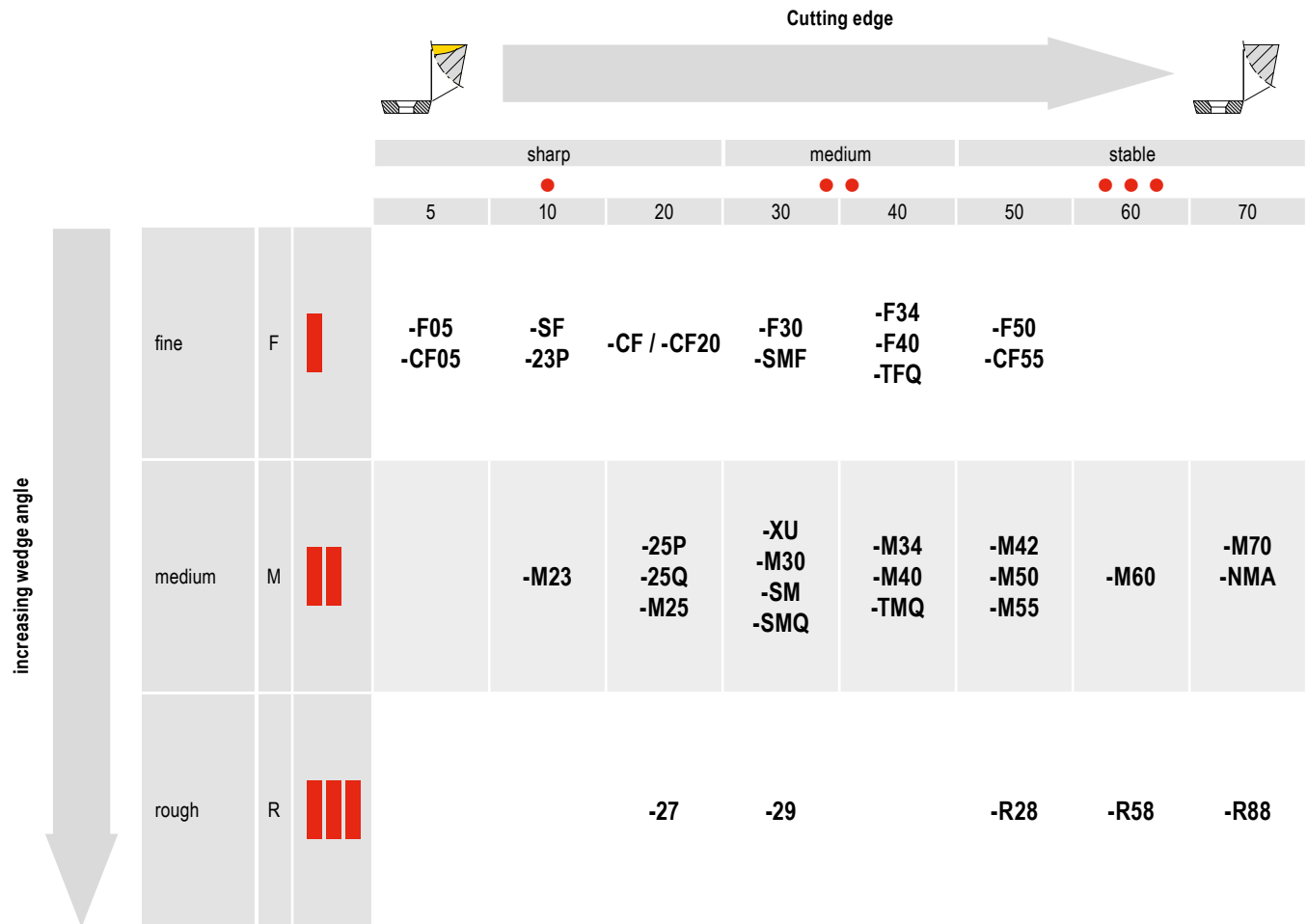
CC..					CBN			Diamond	
Carbide									
P	M	K	N	S	K	S	H	N	O
72-75								76-80	

VC..					CBN			Diamond	
Carbide									
P	M	K	N	S	K	S	H	N	O
148-150								151-153	

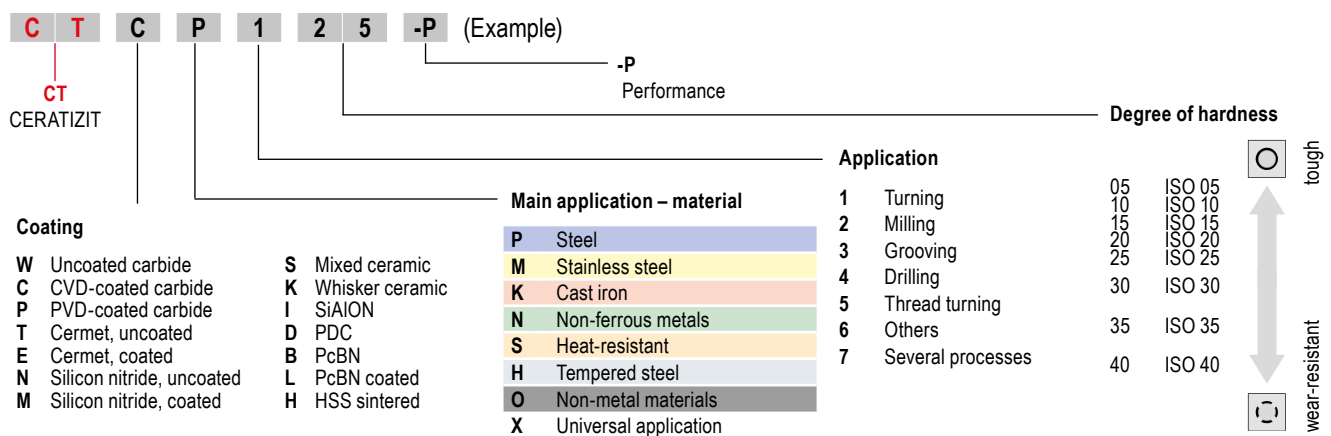
DC..					CBN			Diamond	
Carbide									
P	M	K	N	S	K	S	H	N	O
95-98								99-103	

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

Chip Breakers Overview



Grade description



Toolfinder – negative inserts



		Material							Geometry						
		Steel	Stainless steel	Cast iron	Non-ferrous metals	Heat-resistant	Tempered steel	Non-metal materials							
		P	M	K	N	S	H	O	CN..	DN..	KN..	SN..	TN..	VN..	WN..
Main application: Steel and cast iron	Fine	-CF / -CF20		●	○	○			11	25			52		64
		-F40		●	○									59	
		-F50		●	○				11	25		42	52	59	64
		-TFQ		●	○	○			11+12	25+26					64
	Medium	-XU		●	○				12	26				59	65
		-M40		●	○									59	
		-M50		●	○	○			12	26+27		42	52	59	65
		-TMQ		●	○				12	27					65
	Rough	-M70 -11, -12		●	○	○			12+13	27		42+43	53		65
		.NMA		●	○				13	27		43	53		66
Main application: Stainless	Fine	-F30		○	●		○		14	28		44	54	59	66
		-M30		○	●		○		14	28		44	54	60	66
	Medium	-M42		○	●		●		15	28					
		-M60		○	●		○		15	28		44	54		66
Main application: Heat-resistant	Fine	-F32		●		○	●								
		-F34							15						66
	Medium	-M34		●	●		○	●	15	28		44	54	60	66
		-M42		○	●		○	●	15						
		-M52		●		○	●								
Main application: Non-ferrous metals	Diamond	FN , FL, FR			●			●	16	29					

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

Toolfinder – positive inserts



								Geometry									
		Steel	Stainless steel	Cast iron	Non-ferrous metals	Heat-resistant	Tempered steel	Non-metal materials	CC..	DC..	RC..	SC..	SP..	TC..	TP..	VC..	WC..
		P	M	K	N	S	H	O									
Main application: Steel and cast iron	Fine	-CF05		•	○	○			72	95		128		138		148	
		-SF		•	○	○			72+73	95+96		128		138		148	169
	Medium	-CF55		•	○	○			72	95		128		138		148	
		-M23		•		○					120						
		-SMF		•	○	○			72+73	95+96	119	128		138		148+149	
		-SM		•	○	•			73	96	119+120	128		138		149	
		-SMQ		•		○			73+74	97							
		-EN, -EL, -ER		•	○	•											
Main application: Stainless	Fine	-F43		○	•		•										
		-M81		○	•		○										
	Medium	-M25		○	•		•		74	97		129		139		149	
		-M55		○	•		•		74	97		129		139		149	
Main application: Non-ferrous metals	Fine	-23P			○	•		○	74	97							
		-25P		•	•	○	•	○	74	97	120	129				150	
	Medium	-25Q		•	•	○	•	○	74	97						150	
		-27		•	•	○	•	○	74	98	120	129		140		150	
		-29			○	•		○	75	98						150	
	Diamond	-FN, -FL, -FR				•		•	76–80	99–103	121	130+131		141+142		151–153	169
		CB1				•		•	77+80	100–103	121	130		141		152+153	
		CB2				•		•	77–80	100 102+103	121	131		142		152+153	
		CB3				•		•	79	102		131		142		153	
Main application: Heat-resistant	Fine	-F05		•	•	•	•		75	98						150	
		-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..	17–20	23+24	21	22
DN..	30–33	40+41	33–35	36–39
SN..	45–50	51	50	
TN..	55–57	58		
VN..	61		62	62+63
WN..	67+68	70+71	69	69

Toolholders and boring bars for positive inserts

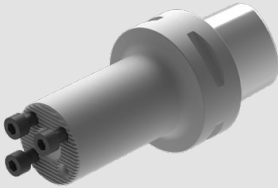
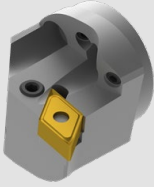
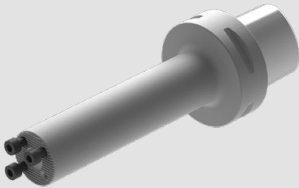
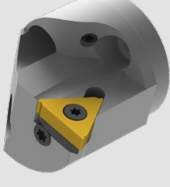
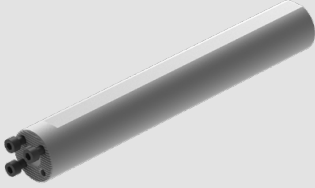


Geometry	Tool holder	Boring bars	HSK-T	PSC
CC..	81–87	90–94	88	89
DC..	104–110	114–118	111	112+113
RC..	122–126		127	
SC..	132–136	137		
TC..	143–146	147		
VC..	154–162	166–168	162–164	164+165
WC..		170		



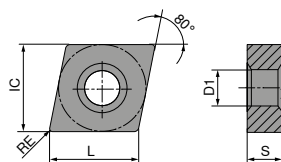
Suitable coolant accessories can be found on → **page 183–185.**

Overview of exchangeable head system

Exchangeable cutting heads	Basic holder
PCLN 95° CN.. 1204  178	PSC 40/50/63  171
PDUN 93° DN.. 1104 DN.. 1506  178	PSC 63 Vibration damped  172
PDQN 107,5° DN.. 1104  179	PSC 40/50/63 Actively vibration-damped  173
PWLN 95° WN.. 0804  179	NEW
SCLC 95° CC.. 1204  180	HSK-T 40/63/100  174
SDUC 93° DC.. 11T3  180	HSK-T 63 Vibration damped  175
SDQC 107,5° DC.. 11T3  181	HSK-T 63 Actively vibration-damped  176
For internal thread 16 ..  182	cylindrical 25 mm 32 mm 40 mm  177

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



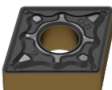
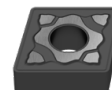
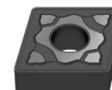
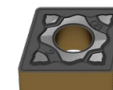
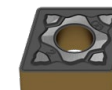
CNMG

		-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															

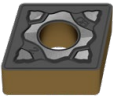
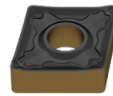
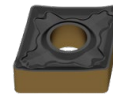
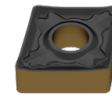
CNMG

		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								

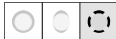
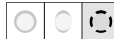
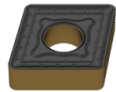
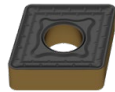
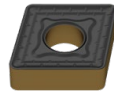
CNMG

		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						
120408EN	0,8	73001	33001	53001	030	530	33001	53001
120412EN	1,2	73201	32001	53201	032	532	32001	53201
120416EN	1,6	73401			034	534	33401	53401
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								

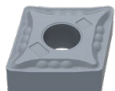
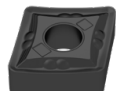
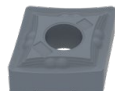
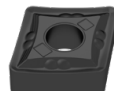
CNMG / CNMA / CNMM

		NEW				NEW		NEW		NEW		NEW	
		-M70		CTCK110		CTCK120		-R28		-R28		-R28	
		CTCP135-P		CTCP110		CTCP120		CTCP115-P		CTCP125-P		CTCP135-P	
		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin	
													
													
		M		R		R		R		R		R	
		CNMG		CNMA		CNMA		CNMM		CNMM		CNMM	
		76 119 ...		70 100 ...		70 100 ...		76 114 ...		76 114 ...		76 114 ...	
ISO	RE mm												
120404EN	0,4			028		528							
120408EN	0,8	73001		030		530		33001		53001			
120412EN	1,2	73201		032		532		33201		53201		73201	
120416EN	1,6	73401		034		534		33401		53401		73401	
160608EN	0,8	74201		042		542							
160612EN	1,2	74401		044		544		34401		54401		74401	
160616EN	1,6	74601		046		546		34601		54601		74601	
160624EN	2,4	74801										74801	
190608EN	0,8	75401											
190612EN	1,2	75601		056		556		35601		55601		75601	
190616EN	1,6	75801		058		558		35801		55801		75801	
190624EN	2,4	76001						36001		56001		76001	
250924EN	2,4							38401		58401		78401	
P		●		○		○		●		●		●	
M		○										○	
K				●		●		○		○			
N													
S													
H													
O													

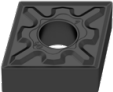
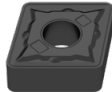
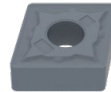
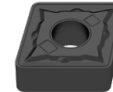
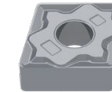
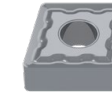
CNMM

		NEW		NEW		NEW		NEW		NEW	
		-R58 CTCP125-P		-R58 CTCP135-P		-R88 CTCP115-P		-R88 CTCP125-P		-R88 CTCP135-P	
		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin	
											
											
		R CNMM		R CNMM		R CNMM		R CNMM		R CNMM	
		76 115 ...		76 115 ...		76 133 ...		76 133 ...		76 133 ...	
ISO	RE mm										
120408EN	0,8	53001		73001							
120412EN	1,2	53201		73201							
120416EN	1,6	53401		73401							
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		36001		56001		76001	
190624SN	2,4										
250924EN	2,4	58401		78401							
250924SN	2,4					38401		58401		78401	
P		●		●		●		●		●	
M				○						○	
K		○				○		○			
N											
S											
H											
O											

CNMG

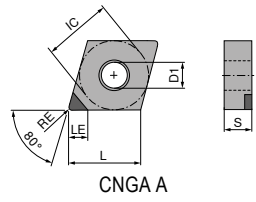
		-F30 CTCM120		-F30 CTPM125		-F30 CTCM130		-M30 CTCM120		-M30 CTPM125		-M30 CTCM130	
		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin	
													
													
		F CNMG		F CNMG		F CNMG		M CNMG		M CNMG		M CNMG	
		75 010 ...		75 010 ...		75 010 ...		75 011 ...		75 011 ...		75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

CNMG

		NEW				NEW		NEW	
		-M42 CTCM130	-M60 CTCM120	-M60 CTPM125	-M60 CTCM130	-F34 CTPX710	-M34 CTPX710	-M42 CTPX710	
		DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin	
									
									
		M CNMG	M CNMG	M CNMG	M CNMG	F CNMG	M CNMG	M CNMG	
		75 029 ...	75 012 ...	75 012 ...	75 012 ...	75 299 ...	75 003 ...	75 007 ...	
ISO	RE mm								
120404EN	0,4	32800				62800	62800		
120408EN	0,8	33000	13000	230	33000	63000	63000		63000
120412EN	1,2	33200	13200	232	33200	63200	63200		63200
120416EN	1,6		13400	234	33400		63400		
160612EN	1,2		14400	24400	34400				
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

F

DIAMOND
CNGA

71 127 ...

10001
10101
10201

CTDPS30

F

DIAMOND
CNGA

71 127 ...

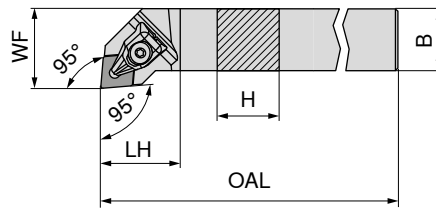
20001
20101
20201

P	
M	
K	
N	•
S	
H	
O	•

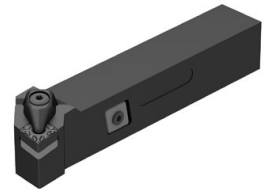
MaxiLock-D – DCLN 95° – Toolholder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Left-hand	Right-hand
70 509 ...	70 508 ...
516	516
520	520
620	620
625	625
632	632
725	725
732	732
832	832
940	940
440	440

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
DCLN R/L 2020 K12	20	20	125	32	25	4	CN.. 1204
DCLN R/L 2525 M12	25	25	150	32	32	4	CN.. 1204
DCLN R/L 3225 P12	32	25	170	32	32	4	CN.. 1204
DCLN R/L 2525 M16	25	25	150	38	32	6,5	CN.. 1606
DCLN R/L 3232 P16	32	32	170	36	40	6,5	CN.. 1606
DCLN R/L 3232 P19	32	32	170	42	40	6,5	CN.. 1906
DCLN R/L 4040 S19	40	40	250	42	50	6,5	CN.. 1906
DCLN R/L 4040 S25	40	40	250	60	50	6,5	CN.. 2509



70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Carbide type C

70 950 ...

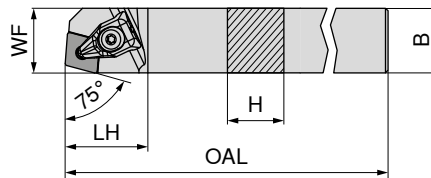
Spare parts for Article no.

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	Right-hand
70 501 ...	70 500 ...
825	825

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



70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Carbide type C

70 950 ...

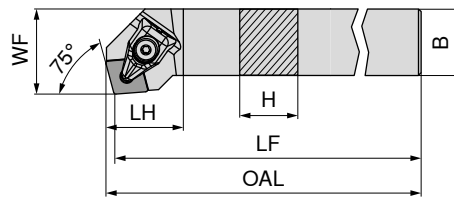
Spare parts for Article no.

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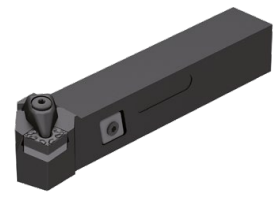
MaxiLock-D – DCKN 75° – Toolholder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



Left-hand	Right-hand
70 505 ...	70 504 ...
825	825

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



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Carbide type C

70 950 ...

Spare parts for Article no.

70 505 825 / 70 504 825

824

T15 - IP

128

M4,5x12 - IP

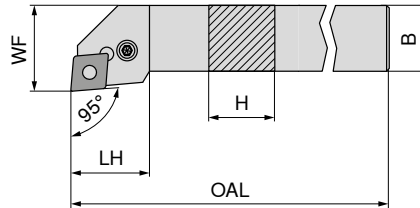
820

810

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

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left-hand	Right-hand
70 509 ...	70 508 ...
016	016
020	020
025	025
032	032
125	125
132	132
232	232
54000	54000
340	340

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



Key I

70 950 ...



Shim

70 950 ...



Assembly pin

70 950 ...



Lever

70 950 ...



Clamping screw

70 950 ...



Carbide type C

70 950 ...

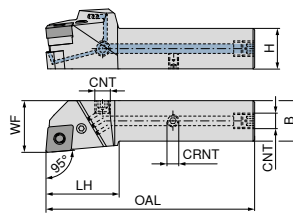
Spare parts for Article no.

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

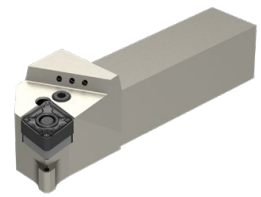
MaxiLock-N – PCLN 95° DC – Toolholder with lever clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



NEW

Left-hand

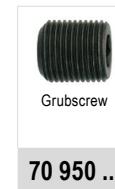
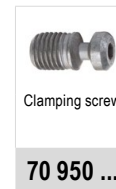
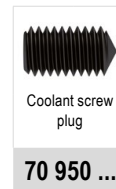
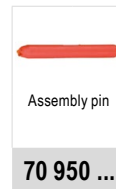
NEW

Right-hand

70 592 ...

70 592 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CNT	CRNT	torque moment Nm	Insert		
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



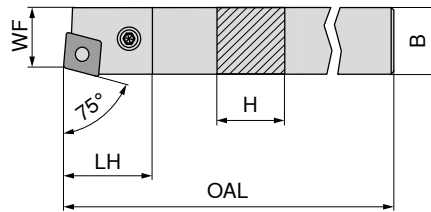
Spare parts for Article no.

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



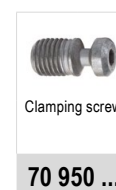
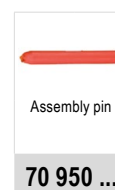
Left-hand

Right-hand

70 501 ...

70 500 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert		
PCBN R/L 2525 M12	25	25	150	27,70	22	4	CN.. 1204	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

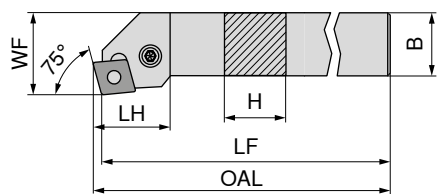


Spare parts for Article no.

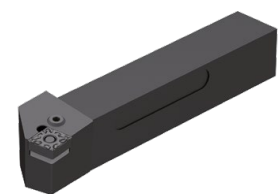
70 500 025 / 70 501 025	SW3	176	198	192	187	209	233
70 500 125 / 70 501 12500	SW3	176	391	394	385	388	380
70 500 032 / 70 501 032	SW4	396	392	395	386	389	381

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

Scope of supply:
Tool holder with allen key



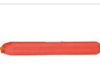
Illustrations show right-hand versions



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

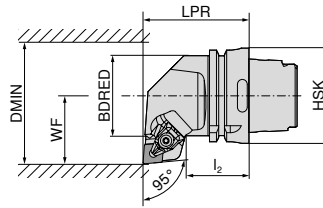
Spare parts
for Article no.
70 505 025 / 70 504 025

					
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	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	I ₂ mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 504 ...		Right-hand 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	

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



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



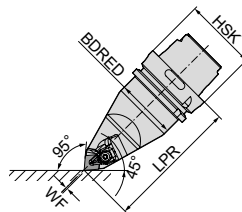
Carbide type C

70 950 ...

MaxiLock-D – DCMN 95° – 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	Neutral 74 506 ...	
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 ...

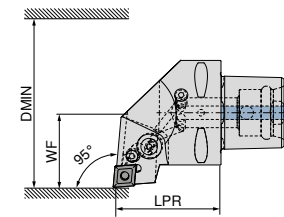
Spare parts for Article no.

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

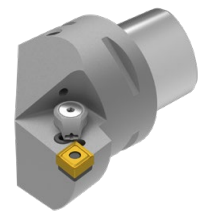
MaxiLock-N – PCLN 95° – Toolholder with lever clamping

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 39.

Spare parts for Article no.					
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



Shim

84 950 ...



Elbow lever screw

84 950 ...



Lever

84 950 ...



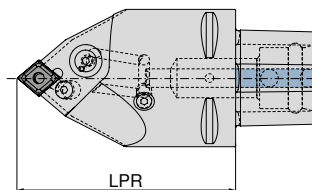
Carbide type C

84 950 ...

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 39.

Spare parts for Article no.					
84 675 01293	29200	M8X1/L17 SW3	28700	29000	27800
84 675 11293	29200	M8X1/L17 SW3	28700	29000	27800



Shim

84 950 ...



Elbow lever screw

84 950 ...



Lever

84 950 ...



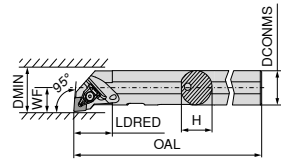
Carbide type C

84 950 ...

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 70 557 ...	Right-hand 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

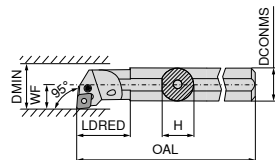
MaxiLock-N – PCLN 95° – Boring bar with lever clamping

▲ 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 70 557 ...	Right-hand 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 ...

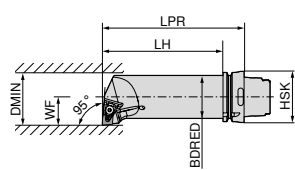
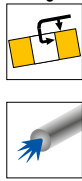
Spare parts

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	824	T15 - IP	128	M4,5x12 - IP	820	810
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XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...

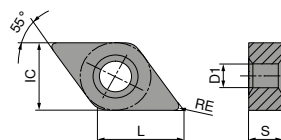


Carbide type C

70 950 ...

DNMG / DNMA / DNMM

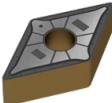
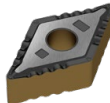
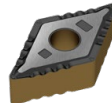
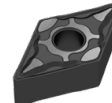
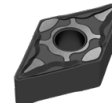
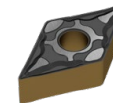
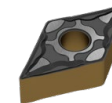
Designation	L mm	S mm	D1 mm	IC mm
DNMG 1104..	11,6	4,76	3,81	9,52
DNMG 1504..	15,5	4,76	5,16	12,70
DNM. 1506..	15,5	6,35	5,16	12,70



DNMG

		-CF TCM10	-CF20 CTEP110	-TFQ CTEP110	NEW -F50 CTCP115-P	NEW -F50 CTCP125-P	NEW -F50 CTCP135-P	NEW -TFQ CTCP115-P
		F CERMET DNMG	F CERMET DNMG	F CERMET DNMG	DNMG	DNMG	DNMG	DNMG
		70 155 ...	76 102 ...	76 153 ...	76 134 ...	76 134 ...	76 134 ...	76 153 ...
ISO	RE mm							
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	32801
150608EN	0,8		030	030	33001	53001	73001	33001
150612EN	1,2		032		33201	53201	73201	
P		●	●	●	●	●	●	●
M		○	○	○			○	
K		○	○	○	○	○		○
N								
S								
H								
O								

DNMG

		NEW		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		M		M		M		M		M		M	
		DNMG		DNMG		DNMG		DNMG		DNMG		DNMG		DNMG	
		76 153 ...		76 291 ...		76 291 ...		70 133 ...		70 133 ...		76 136 ...		76 136 ...	
ISO	RE mm														
110404EN	0,4											30401		50401	
110408EN	0,8											30601		50601	
110412EN	1,2											30801		50801	
150404EN	0,4											31601		51401	
150408EN	0,8							018		518		31801		51801	
150412EN	1,2							020		520		32001		51601	
150416EN	1,6											32201		52201	
150604EN	0,4	52801		32801		52801						32801		52801	
150608EN	0,8	53001		33001		53001		030		530		33001		53001	
150612EN	1,2			33201		53201		032		532		33201		53201	
150616EN	1,6											33401		53401	
P		●		●		●		○		○		●		●	
M															
K		○		○		○		●		●		○		○	
N															
S															
H															
O															

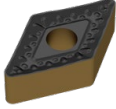
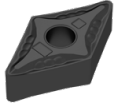
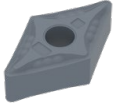
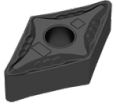
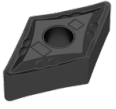
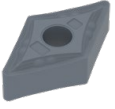
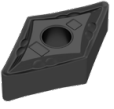
DNMG

		NEW	NEW			NEW	NEW	NEW
		-M50 CTCP135-P	-TMQ CTCP125-P	-M70 CTCK110	-M70 CTCK120	-M70 CTCP115-P	-M70 CTCP125-P	-M70 CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		M	M	M	M	M	M	M
		DNMG	DNMG	DNMG	DNMG	DNMG	DNMG	DNMG
		76 136 ...	76 197 ...	70 263 ...	70 263 ...	76 263 ...	76 263 ...	76 263 ...
ISO	RE mm							
110404EN	0,4	70401						
110408EN	0,8	70601				30601	50601	70601
110412EN	1,2	70801				30801	50801	70801
150404EN	0,4	71601						
150408EN	0,8	71801		018	518	31801	51801	71801
150412EN	1,2	72001		020	520	32001	52001	72001
150416EN	1,6	72201				32201	52201	72201
150604EN	0,4	72801						
150608EN	0,8	73001	53001	030	530	33001	53001	73001
150612EN	1,2	73201	53201	032	532	33201	53201	73201
150616EN	1,6	73401		034	534	33401	53401	73401
P		●	●	○	○	●	●	●
M		○						○
K			○	●	●	○	○	
N								
S								
H								
O								

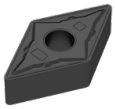
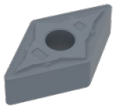
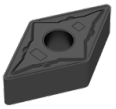
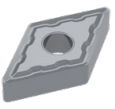
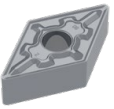
DNMA / DNMM

				NEW	NEW	NEW	NEW	NEW
		CTCK110	CTCK120	-R28 CTCP115-P	-R28 CTCP125-P	-R28 CTCP135-P	-R58 CTCP115-P	-R58 CTCP125-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		R	R	R	R	R	R	R
		DNMA	DNMA	DNMM	DNMM	DNMM	DNMM	DNMM
		70 156 ...	70 156 ...	76 165 ...	76 165 ...	76 165 ...	76 166 ...	76 166 ...
ISO	RE mm							
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

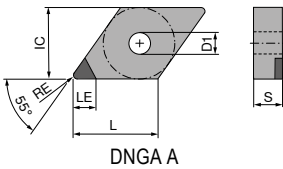
		NEW						
		-R58 CTCP135-P	-F30 CTCM120	-F30 CTPM125	-F30 CTCM130	-M30 CTCM120	-M30 CTPM125	-M30 CTCM130
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		R DNMM	F DNMG	F DNMG	F DNMG	M DNMG	M DNMG	M DNMG
		76 166 ...	75 013 ...	75 013 ...	75 013 ...	75 014 ...	75 014 ...	75 014 ...
ISO	RE mm							
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			
150408EN	0,8		11800		31800	11800		31800
150412EN	1,2					12000		32000
150604EN	0,4		12800	228	32800			
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				
		-M60 CTCM120	-M60 CTPM125	-M60 CTCM130	-M34 CTPX710	-M42 CTPX710
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
		M DNMG	M DNMG	M DNMG	M DNMG	M DNMG
		75 015 ...	75 015 ...	75 015 ...	75 004 ...	75 027 ...
ISO	RE mm					
150404EN	0,4				61600	
150408EN	0,8		11800		61800	
150412EN	1,2		12000		62000	
150608EN	0,8		13000	230	63000	
150612EN	1,2		13200	232	63200	63000
P		○	○	○	●	●
M		●	●	●	●	●
K						
N					○	○
S				○	●	●
H						
O						

DNGA

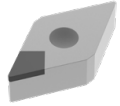
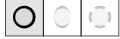
Designation	L mm	S mm	D1 mm	IC mm
DNGA 1504..	15,5	4,76	5,16	12,7
DNGA 1506..	15,5	6,35	5,16	12,7



DNGA

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

CTDPD20



F
DIAMOND
DNGA

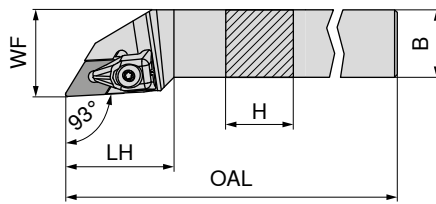
71 128 ...

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



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 541 ...		Right-hand 70 540 ...	
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	

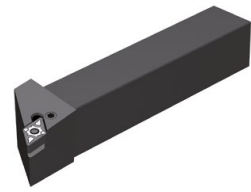
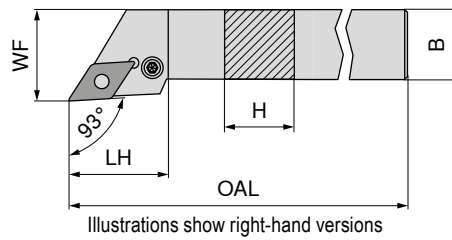
 When using DN.. 1504 indexable inserts, use insert seat article no. 70 950 40000.

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



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

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

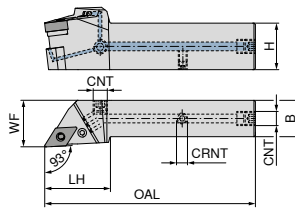
1) nickel-plated

						
	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.						
70 540 116 / 70 541 116	SW2,5	175	122	191	121	208
70 540 12000 / 70 541 12000	SW2,5	175	122	191	121	208
70 540 12500 / 70 541 12500	SW2,5	175	122	191	121	208
70 540 020 / 70 541 020	SW3	176	198	192	188	388
70 540 025 / 70 541 025	SW3	176	198	192	188	388
70 540 032 / 70 541 032	SW3	176	198	192	188	388
70 540 13200 / 70 541 13200	SW3	176	198	192	188	388

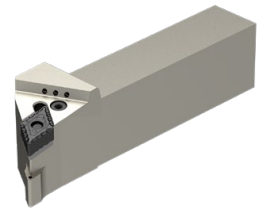
MaxiLock-N – PDJN 93° DC – Toolholder with lever clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



NEW

Left-hand

NEW

Right-hand

70 593 ...

70 593 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert		
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

70 950 ...



Shim

70 950 ...



Assembly pin

70 950 ...



Coolant screw
plug

70 950 ...



Lever

70 950 ...



Clamping screw

70 950 ...



Solid Carbide
Seat D

70 950 ...



Grubscrew

70 950 ...

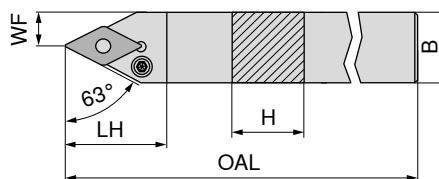
Spare parts for Article no.

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

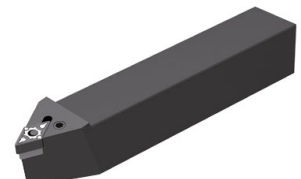
MaxiLock-N – PDNN 63° – Toolholder with lever clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions



Left-hand

Right-hand

70 537 ...

70 536 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert		
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

70 950 ...



Shim

70 950 ...



Assembly pin

70 950 ...



Lever

70 950 ...



Clamping screw

70 950 ...



Solid Carbide
Seat D

70 950 ...

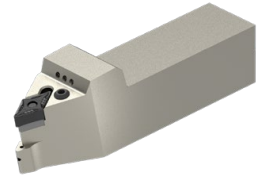
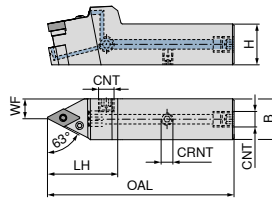
Spare parts for Article no.

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

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	NEW Left-hand 70 594 ...	NEW Right-hand 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.

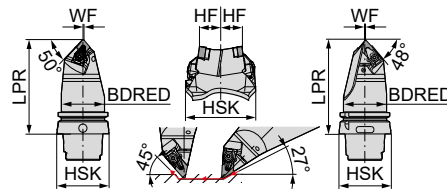
70 594 02501 / 70 594 02500	175	122	191	294	121	208	120	86700
70 594 12501 / 70 594 12500	176	198	192	294	188	209	236	86700

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 ...

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

Scope of supply:

Tool holder with Torx key



ISO designation	Adapter	LPR mm	BDRED mm	WF mm	HF mm	torque moment Nm	Insert	Neutral 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

XPress type	Key D	Clamping screw	Solid Carbide Seat D	Carbide type C
70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...

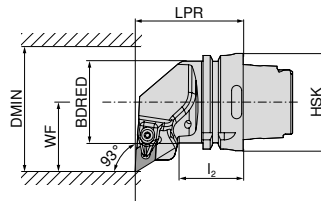
Spare parts for Article no.	
74 600 501	824 T15 - IP
74 600 701	824 T15 - IP

824	T15 - IP	128	M4,5x12 - IP	820	811	810
824	T15 - IP	128	M4,5x12 - IP	820	811	810

MaxiLock-D – DDUN 93° – 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	torque moment Nm	Insert	Left-hand 74 516 ...	Right-hand 74 515 ...
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

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



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



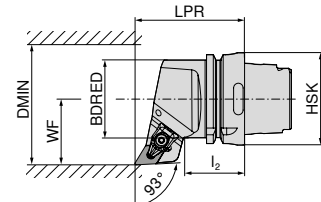
Solid Carbide
Seat D

70 950 ...

MaxiLock-D – DDJN 93° – 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	torque moment Nm	Insert	Left-hand 74 512 ...	Right-hand 74 511 ...
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

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



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



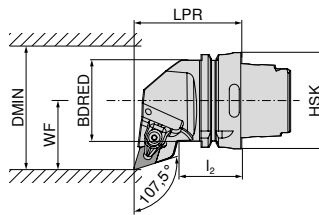
Solid Carbide
Seat D

70 950 ...

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

Scope of supply:

Tool holder with Torx key



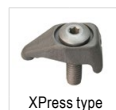
Illustrations show right-hand versions



ISO designation	Adapter	LPR mm	I ₂ mm	BORED 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

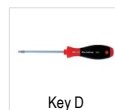
Spare parts for Article no.

74 508 515 / 74 507 515



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Solid Carbide
Seat D

70 950 ...

824

T15 - IP

128

M4,5x12 - IP

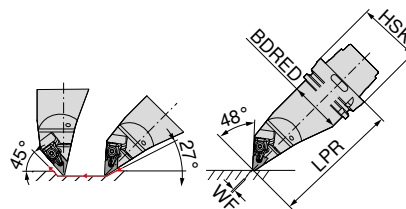
820

811

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

Scope of supply:

Tool holder with Torx key



ISO designation	Adapter	LPR mm	BORED 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

Spare parts for Article no.

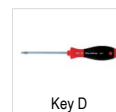
74 519 515

74 519 715



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Solid Carbide
Seat D

70 950 ...

824

824

128

128

820

820

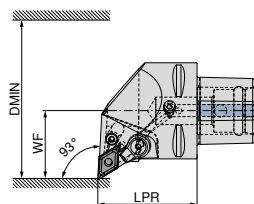
811

811

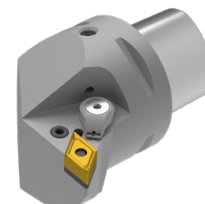
MaxiLock-N – PDUN 93° – Toolholder with lever clamping

Scope of supply:

without high-performance coolant set



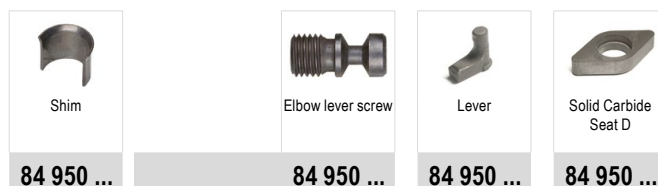
Illustrations show right-hand versions



ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Direct cooling compatible	Left-hand 84 661 ...	Right-hand 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

Spare parts for Article no.

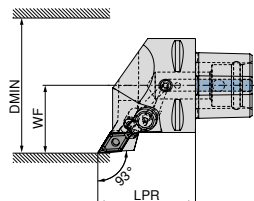
84 660 01593 / 84 660 01594	29200	M8X1/L17 SW3	28700	28900	27900
84 660 01595 / 84 661 01593	29200	M8X1/L17 SW3	28700	28900	27900
84 661 01594 / 84 661 01595	29200	M8X1/L17 SW3	28700	28900	27900



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

Scope of supply:

without high-performance coolant set



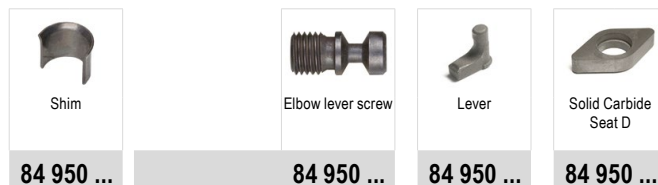
Illustrations show right-hand versions



ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Direct cooling compatible	Left-hand 84 665 ...	Right-hand 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

Spare parts Adapter

PSC 40	29200	M8X1/L17 SW3	28700	28900	27900
PSC 50	29200	M8X1/L17 SW3	28700	28900	27900
PSC 63	29200	M8X1/L17 SW3	28700	28900	27900



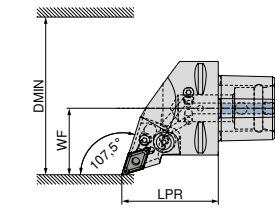
The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → Page 39.

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

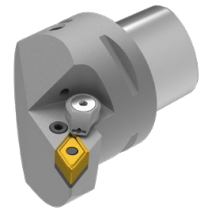
MaxiLock-N – PDHN 107,5° – Toolholder with lever clamping

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 84 669 ...	Right-hand 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

Spare parts for Article no.

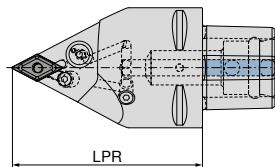
84 668 01595 / 84 669 01595	29200	28700	28900	27900
84 668 01594 / 84 669 01594	29200	28700	28900	27900
84 668 01593 / 84 669 01593	29200	28700	28900	27900

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

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

Spare parts for Article no.

84 676 01593	29200	28700	28900	27900
84 676 11593	29200	28700	28900	27900

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

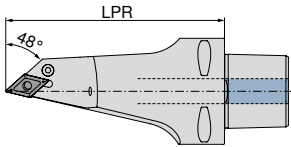
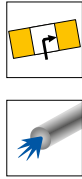


The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → Page 39.

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

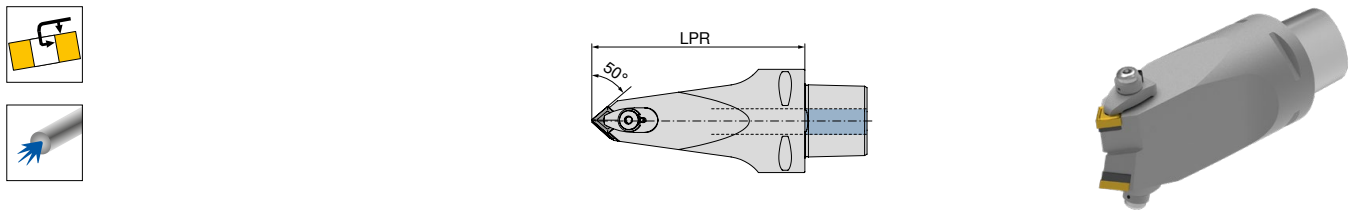
Spare parts
for Article no.
84 680 11593

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



The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page 39.**
When using DN1504.. inserts Shim item no. 84 950 28200

MaxiLock-D – DCMN + DDMN 50°/48° – Toolholder with top clamping



					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

Spare parts
for Article no.
84 683 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

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

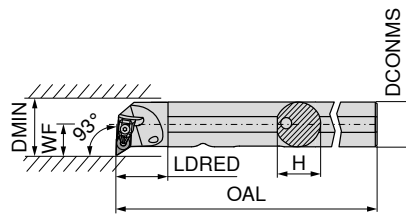
Scope of supply:
Direct cooling nozzle and O-ring



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

Scope of supply:

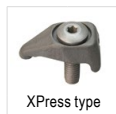
Boring bar with Torx key



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	725	725
A32S DDUN R/L 11	32	31	250	40	22	40	2	DN.. 1104	732	732
A40T DDUN R/L 15	40	39	300	45	27	50	4	DN.. 1506	840	840



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...

Solid Carbide
Seat D

70 950 ...

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

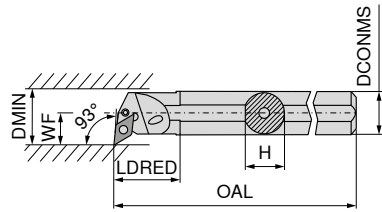
MaxiLock-N – PDUN 93° – Boring bar with lever clamping

▲ 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 70 569 ...	Right-hand 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

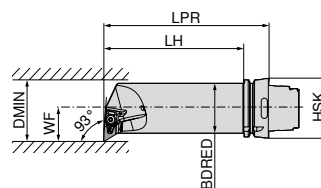
1) nickel-plated

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	191	121	208	120
70 568 132 / 70 569 13200	SW2,5	175	122	191	121	208	120
70 568 232 / 70 569 232	SW3	176	198	192	188	209	236
70 568 240 / 70 569 240	SW3	176	198	192	188	209	236
70 568 050 / 70 569 050	SW3	176	198	192	188	388	236

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

Scope of supply:

Boring bar with Torx key



Illustrations show right-hand versions

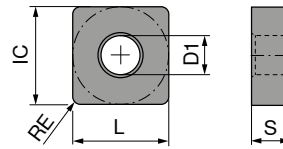


ISO designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 533 ...	Right-hand 74 532 ...
HSK T63 50Q DDUN R/L 15	HSK-T 63	175	149	50	35	63	4	DN.. 1506	515	515

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

		NEW						
		-F50 CTCP115-P	-F50 CTCP125-P	-F50 CTCP135-P	-M50 CTCP115-P	-M50 CTCP125-P	-M50 CTCP135-P	-M70 CTCK110
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F SNMG	F SNMG	F SNMG	M SNMG	M SNMG	M SNMG	M SNMG
		76 140 ...	76 140 ...	76 140 ...	76 137 ...	76 137 ...	76 137 ...	70 225 ...
ISO	RE mm							
090308EN	0,8	30601	50601	70601				
120404EN	0,4	31601	51601	71601				
120408EN	0,8	31801	51801	71801	31801	51801	71801	018
120412EN	1,2	32001	52001	72001	32001	52001	72001	020
120416EN	1,6				32201	52201	72201	022
150608EN	0,8							
150608EN	1,6							
150612EN	1,2				33001	53001	73001	032
150616EN	1,6				33201	53201	73201	034
					33401	53401	73401	
190612EN	1,2							044
190616EN	1,6							046
P		●	●	●	●	●	●	○
M				○			○	
K		○	○		○	○		●
N								
S								
H								
O								

SNMG / SNMA

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

9

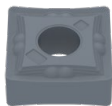
SNMA / SNMM

			NEW		NEW		NEW		NEW		NEW	
		CTCK120	-R28 CTCP115-P		-R28 CTCP125-P		-R28 CTCP135-P		-R58 CTCP115-P		-R58 CTCP125-P	
		DRAGONSKIN	DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
												
												
		R SNMA	R SNMM		R SNMM		R SNMM		R SNMM		R SNMM	
		70 114 ...	76 128 ...		76 128 ...		76 128 ...		76 129 ...		76 129 ...	
ISO	RE mm											
120408EN	0,8	518							31801	51801	71801	
120412EN	1,2	520							32001	52001	72001	
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												

SNMM / SNMG

		NEW		NEW		NEW					
		-R88	-R88	-R88	-F30	-F30	-F30	-M30			
		CTCP115-P	CTCP125-P	CTCP135-P	CTCM120	CTPM125	CTCM130	CTCM120			
		DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin			
											
		R	R	R	F	F	F	M			
		SNMM	SNMM	SNMM	SNMG	SNMG	SNMG	SNMG			
		76 130 ...	76 130 ...	76 130 ...	75 016 ...	75 016 ...	75 016 ...	75 017 ...			
ISO	RE mm										
120404EN	0,4										
120408EN	0,8				11600	216	31600				
120412EN	1,2				11800	218	31800				11800 12000
190616SN	1,6	34601	54601	74601							
190624SN	2,4	34801	54801	74801							
250724SN	2,4	36001	56001	76001							
250924SN	2,4	37001	57001	77001							
P		●	●	●	○	○	○	○			
M				○	●	●	●	●			●
K		○	○								
N											
S								○			
H											
O											

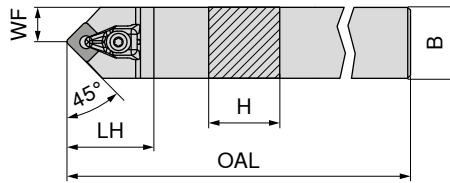
SNMG

		-M30	-M30	-M60	-M60	-M60	-M34		
		CTPM125	CTCM130	CTCM120	CTPM125	CTCM130	CTPX710		
		DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin		
									
		M	M	M	M	M	M		
		SNMG	SNMG	SNMG	SNMG	SNMG	SNMG		
		75 017 ...	75 017 ...	75 018 ...	75 018 ...	75 018 ...	75 005 ...		
ISO	RE mm								
120408EN	0,8		218	31800	11800	218	31800	61800	
120412EN	1,2			32000	12000	210	32000	62000	
120416EN	1,6				12200	220	32200		
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 ...

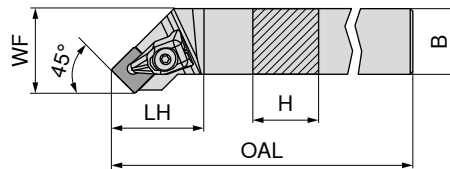
Spare parts for Article no.

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

70 513 ...

Right-hand

70 512 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert		
DSSN R/L 2020 K12	20	20	125	35	25	4	SN.. 1204	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 ...

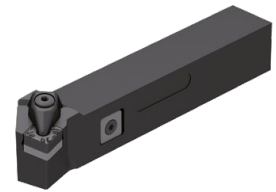
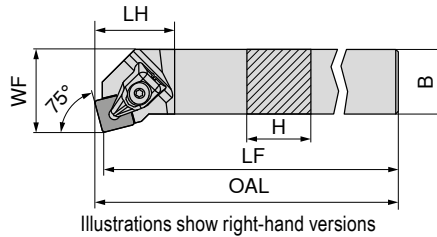
Spare parts for Article no.

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

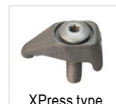
Scope of supply:

Tool holder with Torx key



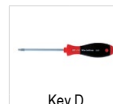
Left-hand	Right-hand
70 525 ...	70 524 ...
625	625

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



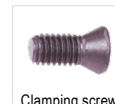
XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Solid Carbide support S

70 950 ...

Spare parts for Article no.

70 525 625 / 70 524 625

824

T15 - IP

128

M4,5x12 - IP

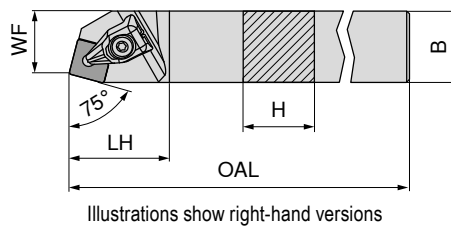
820

813

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

Scope of supply:

Tool holder with Torx key



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

620

625

725

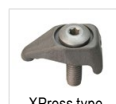
832

732

840

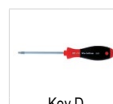
940

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



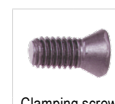
XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Solid Carbide support S

70 950 ...

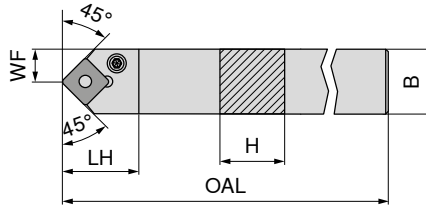
Spare parts for Article no.

70 520 620	824	T15 - IP	128	M4,5x12 - IP	820	813
70 520 625	824	T15 - IP	128	M4,5x12 - IP	820	813
70 520 725	825	T20 - IP	129	M5x14 - IP	821	833
70 520 832	825	T20 - IP	129	M5x14 - IP	821	833
70 520 732	826	T20 - IP	129	M5x14 - IP	821	817
70 520 840	826	T20 - IP	129	M5x14 - IP	821	817
70 520 940	827	T25 - IP	122	M6x16 - IP	822	818

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



Key I



Shim



Assembly pin



Lever



Clamping screw



Solid Carbide support S

70 950 ...

70 950 ...

70 950 ...

70 950 ...

70 950 ...

70 950 ...

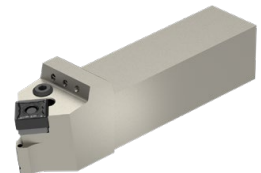
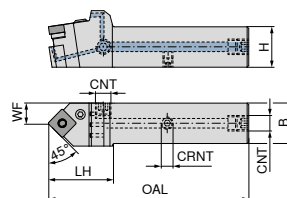
Spare parts for Article no.

70 516 020	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



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 ...

Spare parts for Article no.

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

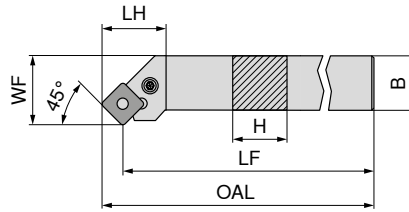


When using SN.. 2509 indexable inserts, use insert seat article no. 70 950 40200.

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



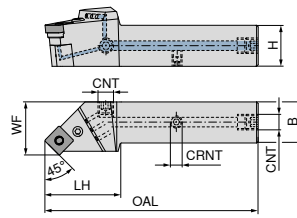
When using SN.. 2509 indexable inserts, use insert seat article no. 70 950 40200.

							
		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.							
70 512 01600 / 70 513 016	SW2,5	175	197	191	185	208	229
70 512 020 / 70 513 020	SW3	176	198	192	187	209	230
70 512 025 / 70 513 025	SW3	176	198	192	187	209	230
70 512 032 / 70 513 032	SW3	176	198	192	187	209	230
70 512 125	SW3	176	391	394	385	388	382
70 512 132	SW3	176	391	394	385	388	382
70 512 232	SW4	396	392	395	386	389	383
70 513 232	SW4	396	392	395	386	389	383
70 512 04000	SW5	265	621	623	620	622	27600

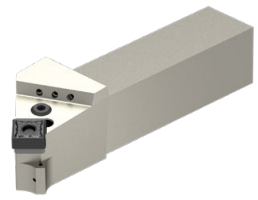
MaxiLock-N – PSSN 45° DC – Toolholder with lever clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions

**NEW**

Left-hand

70 597 ...**NEW**

Right-hand

70 597 ...

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

02000**02500****03200****13200****02001****02501****03201****12501****13201****23201****04001**

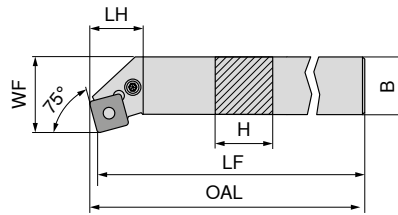
 When using SN.. 2509 indexable inserts, use insert seat article no. 70 950 40200.

	 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 ...
Spare parts for Article no.								
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

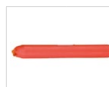
ISO designation	H mm	LF mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert
PSKN R/L 1616 H09	16	100	16	102,5	18,7	20	3	SNM. 0903
PSKN R/L 2020 K12	20	125	20	128,3	24,1	25	4	SNM. 1204
PSKN R/L 2525 M12	25	150	25	153,3	24,1	32	4	SNM. 1204
PSKN R/L 3225 P12	32	170	25	173,1	24,1	32	4	SNM. 1204
PSKN R 4040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

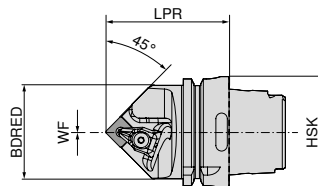
Spare parts for Article no.

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

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

Scope of supply:

Tool holder with Torx key



Neutral
74 522 ...

ISO designation	Adapter	LPR mm	BRED 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 ...

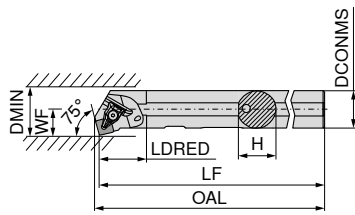
Spare parts for Article no.

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:

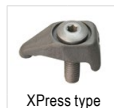
Boring bar with Torx key



Illustrations show right-hand versions

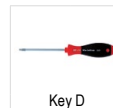


ISO designation	DCONMS mm	H mm	LF mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 561 ...	Right-hand 70 560 ...
A32S DSKN R/L 12	32	31	250	254,2	40	22	40	4	SN.. 1204	832	832



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

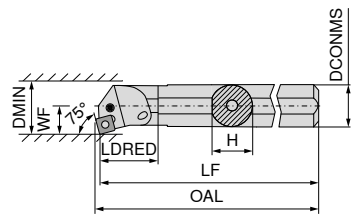
820

813

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

Scope of supply:

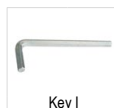
Boring bar with Allen key



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

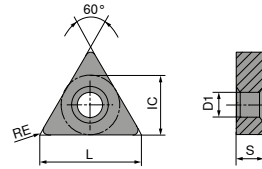
187

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						
		-CF20 CTCP110	-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								
S								
H								
O								

TNMG

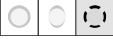
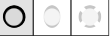
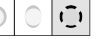
		NEW		NEW		NEW		NEW		NEW	
		-M70 CTCK110	-M70 CTCK120	-M70 CTCP115-P	-M70 CTCP125-P	-M70 CTCP135-P	CTCP125-P	CTCP135-P	CTCP125-P	CTCP135-P	
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	
		M TNMG	M TNMG	M TNMG	M TNMG	M TNMG	M TNMG	M TNMG	M TNMG	M TNMG	
		70 155 ...	70 155 ...	76 155 ...	76 155 ...	76 155 ...	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				71601	
160408ER	0,8						51601	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											

9

TNMA / TNMM

		NEW		NEW		NEW		NEW		NEW	
		CTCK110	CTCK120	-R28 CTCP115-P	-R28 CTCP125-P	-R28 CTCP135-P	-R58 CTCP115-P	-R58 CTCP115-P	-R58 CTCP125-P		
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN		
		R TNMA	M TNMA	R TNMM	R TNMM	R TNMM	R TNMM	R TNMM	R TNMM		
		70 134 ...	70 134 ...	76 154 ...	76 154 ...	76 154 ...	76 154 ...	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							
160408EN	0,8		11600	216	31600			
160412EN	1,2		11800	218	31800	11800	218	31800
220412EN	1,2	73201				12000	220	32000
P		●	○	○	○	○	○	○
M		○	●	●	●	●	●	●
K								
N								
S					○			○
H								
O								

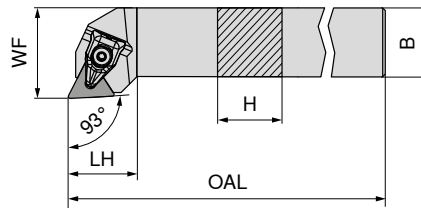
TNMG

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

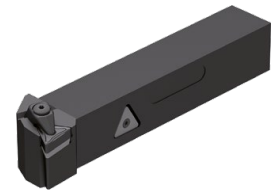
MaxiLock-D – DTJN 93° – Toolholder with top clamping

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	820	820
DTJN R/L 2525 M16	25	25	150	24	32	2	TNM. 1604	825	825



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Solid Carbide
Seat T

70 950 ...

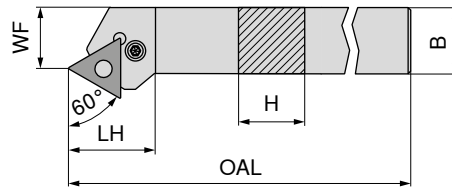
Spare parts for Article no.

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	020	020
PTTN R/L 2525 M22	25	25	150	32,7	22	4	TNM. 2204	025	025



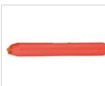
Key I

70 950 ...



Shim

70 950 ...



Assembly pin

70 950 ...



Lever

70 950 ...



Clamping screw

70 950 ...



Solid Carbide
Seat T

70 950 ...

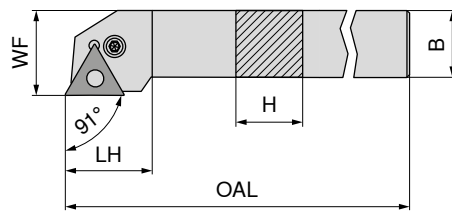
Spare parts for Article no.

70 529 020 / 70 528 020	SW2,5	175	197	191	185	208	225
70 529 025 / 70 528 025	SW3	176	198	192	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

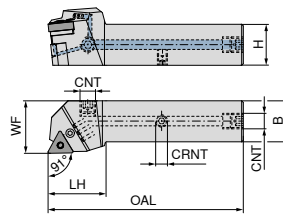
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert
PTGN R/L 1616 H16	16	16	100	20	20	3	TNM. 1604
PTGN R/L 2020 K16	20	20	125	20	25	3	TNM. 1604
PTGN R/L 2525 M16	25	25	150	22	32	3	TNM. 1604
PTGN R/L 3225 P16	32	25	170	22	32	3	TNM. 1604
PTGN R/L 2525 M22	25	25	150	29	32	4	TNM. 2204
PTGN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

	 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.							
70 532 016 / 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		
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

70 950 ...



Shim

70 950 ...



Assembly pin

70 950 ...



Coolant screw
plug

70 950 ...



Lever

70 950 ...



Clamping screw

70 950 ...



Solid Carbide
Seat T

70 950 ...



Grubscrew

70 950 ...

Spare parts

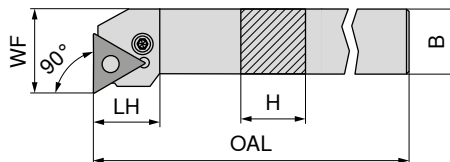
for Article no.

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		
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

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.

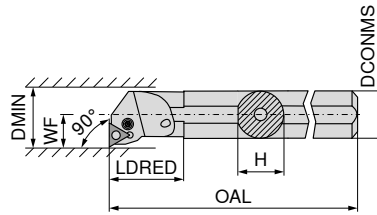
70 534 016 / 70 535 016	SW2,5	175	197	191	185	208	225
70 534 020 / 70 535 020	SW2,5	175	197	191	185	208	225
70 534 025 / 70 535 025	SW2,5	175	197	191	185	208	225
70 534 125 / 70 535 125	SW3	176	198	192	187	209	226
70 534 132 / 70 535 132	SW3	176	198	192	187	209	226

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



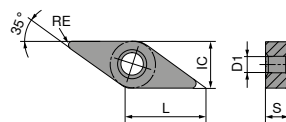
ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 565 ...		Right-hand 70 564 ...	
S25T PTFN R 16	25	23	300	36	17	32	3	TNM. 1604				02500
A25R PTFN R/L 16	25	23	200	36	17	32	3	TNM. 1604	225			225
A32S PTFN R/L 16	32	30	250	50	22	40	3	TNM. 1604	232			232
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
70 564 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

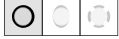
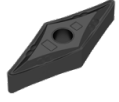
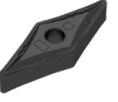
		NEW	NEW	NEW	NEW	NEW	NEW	NEW
		-F40 CTCP125-P	-F50 CTCP115-P	-F50 CTCP125-P	-F50 CTCP135-P	-XU CTCP115-P	-XU CTCP125-P	-M40 CTCP125-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F VNMG	F VNMG	F VNMG	F VNMG	M VNMG	M VNMG	M VNMG
		76 000 ...	76 156 ...	76 156 ...	76 156 ...	76 294 ...	76 294 ...	76 001 ...
ISO	RE mm							
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								

9

VNMG

		NEW	NEW	NEW	NEW	NEW	NEW	NEW
		-M50 CTCK110	-M50 CTCK120	-M50 CTCP115-P	-M50 CTCP125-P	-F30 CTCM120	-F30 CTPM125	-F30 CTCM130
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M VNMG	M VNMG	M VNMG	M VNMG	F VNMG	F VNMG	F VNMG
		70 190 ...	70 131 ...	76 131 ...	76 131 ...	75 022 ...	75 022 ...	75 022 ...
ISO	RE mm							
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								

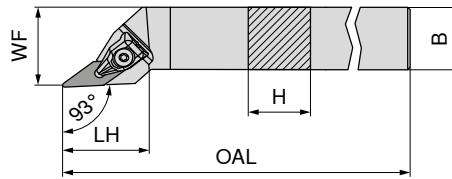
VNMG

		-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 ...	
ISO	RE mm								
160404EN	0,4							61600	
160408EN	0,8	11800		218		31800		61800	
160412EN	1,2							62000	
P		○		○		○		●	
M		●		●		●		●	
K									
N								○	
S						○		●	
H									
O									

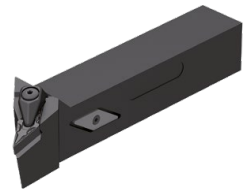
MaxiLock-D – DVJN 93° – Toolholder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 503 ...	Right-hand 70 502 ...
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

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



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



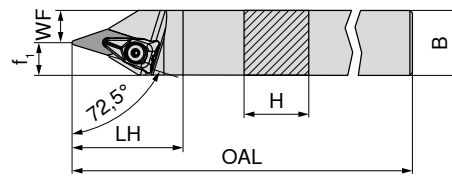
Solid Carbide
Seat V

70 950 ...

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 70 506 ...
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

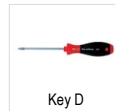
Spare parts for Article no.

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



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



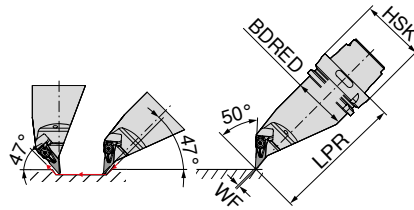
Solid Carbide
Seat V

70 950 ...

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

Scope of supply:

Tool holder with Torx key

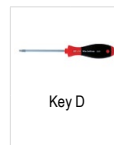


Left-hand
74 525 ...

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



70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



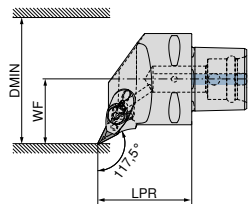
Solid Carbide
Seat V

70 950 ...

Spare parts for Article no.

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

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



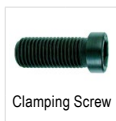
Illustrations show right-hand versions



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



Clamping Screw

84 950 ...



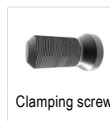
Clamping claw

84 950 ...



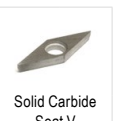
Ring-shaped
nozzle

84 950 ...



Clamping screw

84 950 ...



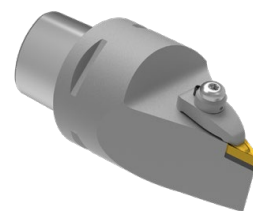
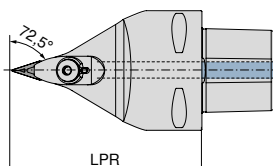
Solid Carbide
Seat V

84 950 ...

Spare parts for Article no.

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

84 950 ...



Clamping claw

84 950 ...



Ring-shaped
nozzle

84 950 ...



Clamping screw

84 950 ...



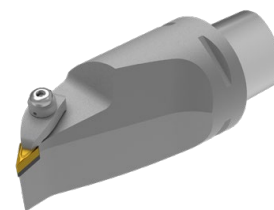
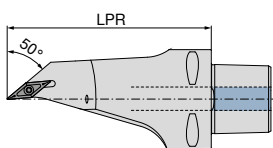
Solid Carbide
Seat V

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

84 950 ...



Clamping claw

84 950 ...



Ring-shaped
nozzle

84 950 ...



Clamping screw

84 950 ...



Solid Carbide
Seat V

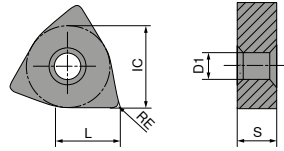
84 950 ...

Spare parts
for Article no.

84 682 01693	M6X28 SW4	28300	28600	28400	27600	28000
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WNMG / WNMA

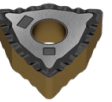
Designation	L mm	S mm	D1 mm	IC mm
WNMG 0604..	6,5	4,76	3,81	9,52
WNM. 0804..	8,6	4,76	5,16	12,70



WNMG

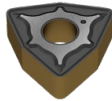
		NEW		NEW		NEW		NEW		NEW	
		-CF20 CTEP110	-TFQ CTEP110	-F50 CTCP115-P	-F50 CTCP125-P	-F50 CTCP135-P	-TFQ CTCP115-P	-TFQ CTCP125-P			
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN			
		F	F	F	F	F	F	F			
		CERMET WNMG	CERMET WNMG	WNMG	WNMG	WNMG	WNMG	WNMG			
		76 171 ...	76 177 ...	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		NEW	
		-M50		-M50		-M50		-M50		-XU		-XU	
		CTCP115-P		CTCP125-P		CTCK110		CTCK120		CTCP115-P		CTCP125-P	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
													
													
		M		M		M		M		M		M	
		WNMG		WNMG		WNMG		WNMG		WNMG		WNMG	
		76 139 ...		76 139 ...		70 139 ...		70 139 ...		76 295 ...		76 295 ...	
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	
080408EN	0,8	31801		51801		018		518		31801		51801	
080412EN	1,2	32001		52001		020		520		32001		52001	
080416EN	1,6	32201		52201								72201	
P		●		●		○		○		●		●	
M												○	
K		○		○		●		●		○		○	
N													
S													
H													
O													

9

WNMG

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

WNMA / WNMG

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

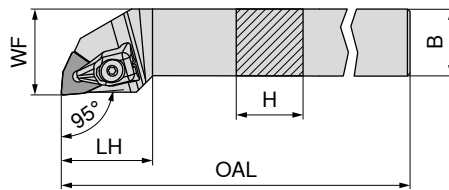
WNMG

		-M30 CTCM130	-M60 CTCM120	-M60 CTPM125	-M60 CTCM130	NEW -F34 CTPX710	-M34 CTPX710
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
		M WNMG	M WNMG	M WNMG	M WNMG	F WNMG	M WNMG
		75 025 ...	75 026 ...	75 026 ...	75 026 ...	75 313 ...	75 008 ...
ISO	RE mm						
060408EN	0,8	30600	10600	206	30600		
060412EN	1,2	30800	10800	208	30800		
080408EN	0,8	31800	11800	218	31800	61800	61800
080412EN	1,2	32000	12000	220	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



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



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Solid Carbide
Seat W

70 950 ...

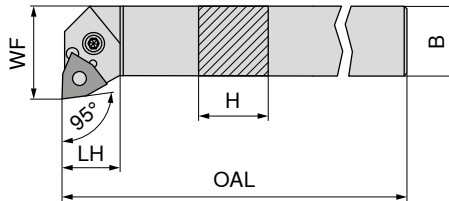
Spare parts for Article no.

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



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

1) nickel-plated



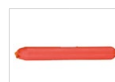
Key I

70 950 ...



Shim

70 950 ...



Assembly pin

70 950 ...



Lever

70 950 ...



Clamping screw

70 950 ...



Solid Carbide
Seat W

70 950 ...

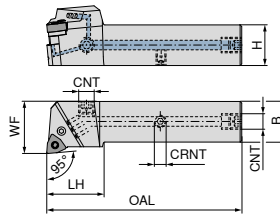
Spare parts for Article no.

70 542 11600 / 70 543 116	SW2,5	175	122	191	185	208	127
70 542 12000 / 70 543 12000	SW2,5	175	122	191	185	208	127
70 542 12500 / 70 543 125	SW2,5	175	122	191	185	208	127
70 542 020 / 70 543 020	SW3	176	198	192	187	209	235
70 542 025 / 70 543 025	SW3	176	198	192	187	209	235
70 542 032 / 70 543 032	SW3	176	198	192	187	209	235

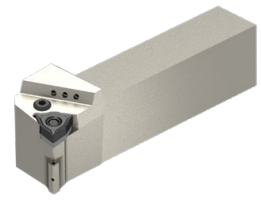
MaxiLock-N – PWLN 95° DC – Toolholder with lever clamping

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		
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



Coolant screw plug



Lever



Clamping screw



Solid Carbide Seat W



Grubscrew

70 950 ...

70 950 ...

70 950 ...

70 950 ...

70 950 ...

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



Key I



Shim



Assembly pin

70 950 ...

70 950 ...

70 950 ...

Spare parts

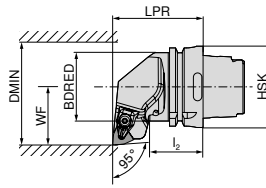
for Article no.

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

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 74 529 ...	Right-hand 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	708



XPress type

70 950 ...



Key D

80 950 ...



Clamping screw

70 950 ...



Solid Carbide
Seat W

70 950 ...

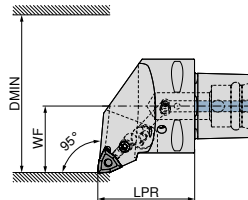
Spare parts for Article no.

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 84 653 ...	Right-hand 84 652 ...
PSC40 PWLN R/L 50050-08	PSC 40	50	27	50	5	WN.. 0804	DC	00895	00895
PSC50 PWLN R/L 65060-08	PSC 50	60	35	65	5	WN.. 0804	DC	00894	00894
PSC63 PWLN R/L 80065-08	PSC 63	65	45	80	5	WN.. 0804	DC	00893	00893

 The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → Page 39.



Shim

84 950 ...



Elbow lever screw

84 950 ...



Lever

84 950 ...



Solid Carbide
Seat W

84 950 ...

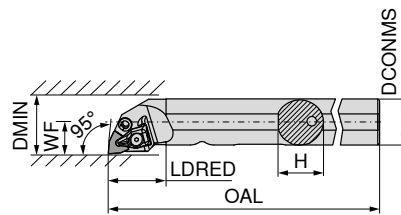
Spare parts for Article no.

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

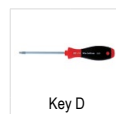


ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 573 ...	Right-hand 70 572 ...
A25R DWLN R/L 06	25	24	200	32	17	32	2	WN.. 0604	725	725
A32S DWLN R/L 08	32	31	250	40	22	44	4	WN.. 0804	732	732
A40T DWLN R/L 08	40	39	300	45	27	50	4	WN.. 0804	64000	640



XPress type

70 950 ...



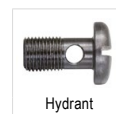
Key D

80 950 ...



Clamping screw

70 950 ...



Hydrant

70 950 ...



Solid Carbide
Seat W

70 950 ...

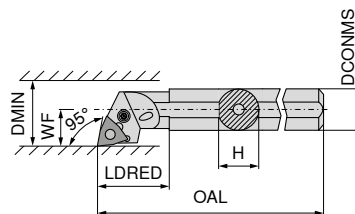
Spare parts for Article no.

70 572 725 / 70 573 725	823	T09 - IP	126	M3x7 - IP	819	834	807
70 572 732 / 70 573 732	824	T15 - IP	128	M4,5x12 - IP	820	834	812
70 572 640 / 70 573 64000	824	T15 - IP	128	M4,5x12 - IP	820	834	812

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

Scope of supply:

Boring bar with Allen key

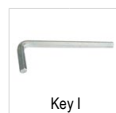


Illustrations show right-hand versions



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

1) nickel-plated



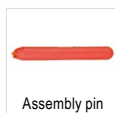
Key I

70 950 ...



Shim

70 950 ...



Assembly pin

70 950 ...



Lever

70 950 ...



Clamping screw

70 950 ...



Solid Carbide
Seat W

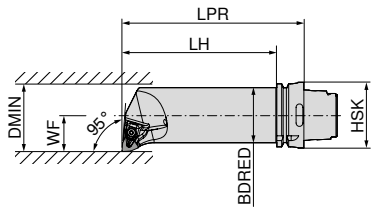
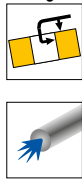
70 950 ...

Spare parts for Article no.

70 572 11600 / 70 573 11600	SW2	177			129	217	
70 572 12100 / 70 573 12100	SW2	177			129	217	
70 572 12500 / 70 573 12500	SW2,5	175	122	191	185	208	127
70 572 132 / 70 573 132	SW2,5	175	122	191	185	208	127
70 572 225 / 70 573 225	SW3	176			187	205	
70 572 032 / 70 573 032	SW3	176	198	192	187	209	235
70 572 040 / 70 573 040	SW3	176	198	192	187	209	235

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

Spare parts
for Article no.
74 536 508 / 74 537 508



XPress type

70 950 ...



Key D

80 950 ...

T15 - IP

128



Clamping screw

70 950 ...

M4,5x12 - IP

820



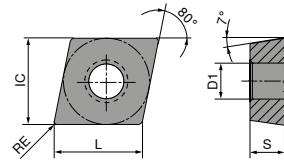
Solid Carbide
Seat W

70 950 ...

812

CCGT / CCMT / CCET

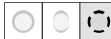
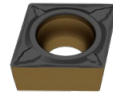
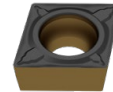
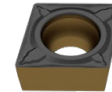
Designation	L mm	S mm	D1 mm	IC mm
CC.T 0602..	6,4	2,38	2,8	6,35
CC.T 09T3..	9,7	3,97	4,4	9,52
CC.T 1204..	12,9	4,76	5,5	12,70



CCGT / CCMT

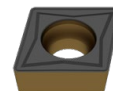
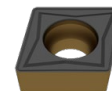
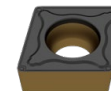
		-CF05 CTEP110		-CF55 CTEP110		-SF TCM407		-SF TCM10		-SMF TCM10		NEW -SF CTCP125-P		NEW -SF CTCP135-P	
		DRAGONSKIN		DRAGONSKIN								DRAGONSKIN		DRAGONSKIN	
		F		F		F		F		F		F		F	
		CERMET CCGT		CERMET CCMT		CERMET CCGT		CERMET CCGT		CERMET CCMT		CCGT		CCGT	
		76 247 ...		76 248 ...		70 251 ...		70 251 ...		70 249 ...		76 251 ...		76 251 ...	
ISO	RE mm														
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

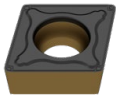
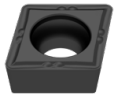
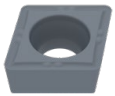
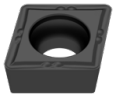
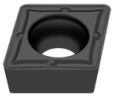
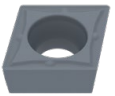
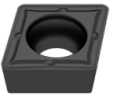
		NEW	NEW	NEW	NEW	NEW	NEW	NEW
		-SF CTCP115-P	-SF CTCP125-P	-SF CTCP135-P	-SMF CTCP115-P	-SMF CTCP125-P	-SMF CTCP135-P	-SM CTCP125-P
		DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin
								
								
		F CCMT	F CCMT	F CCMT	F CCMT	F CCMT	F CCMT	M CCGT
		76 253 ...	76 253 ...	76 253 ...	76 249 ...	76 249 ...	76 249 ...	76 250 ...
ISO	RE mm							
060202EN	0,2							50201
060204EN	0,4	30401	50401	70401		50401 50601	70401	
060208EN	0,8							
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

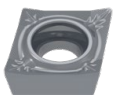
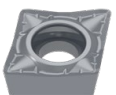
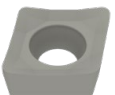
CCGT / CCMT

		NEW			NEW	NEW	NEW	NEW
		-SM CTCP135-P	-SM CTCK110	-SM CTCK120	-SM CTCP115-P	-SM CTCP125-P	-SM CTCP135-P	-SMQ CTCP115-P
		DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin	DRAGONSkin
								
								
		M CCGT	M CCMT	M CCMT	M CCMT	M CCMT	M CCMT	F 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								

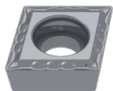
CCMT

		NEW						
		-SMQ CTCP125-P	-M25 CTCM120	-M25 CTPM125	-M25 CTCM130	-M55 CTCM120	-M55 CTPM125	-M55 CTCM130
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		F CCMT	F CCMT	F CCMT	F CCMT	M CCMT	M CCMT	M CCMT
		76 194 ...	75 210 ...	75 210 ...	75 210 ...	75 211 ...	75 211 ...	75 211 ...
ISO	RE mm							
060204EN	0,4		10400	204	30400	10400	204	30400
09T304EN	0,4	51601	11600	216	31600	11600	216	31600
09T308EN	0,8	51801	11800	218	31800	11800	218	31800
120404EN	0,4	52801				12800	228	32800
120408EN	0,8	53001				13000	230	33000
P		●	○	○	○	○	○	○
M			●	●	●	●	●	●
K		○						
N								
S					○			○
H								
O								

CCGT

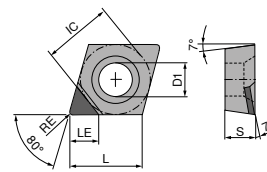
		-23P H216T	-25P H210T	-25P CTPX710	-25Q H210T	-25Q CTPX710	-27 H10T	-27 CTPX715
				DRAGONSKIN		DRAGONSKIN		DRAGONSKIN
								
		F CCGT	F CCGT	M CCGT	M CCGT	M CCGT	M CCGT	M CCGT
		70 255 ...	70 248 ...	70 248 ...	70 248 ...	70 248 ...	70 254 ...	70 254 ...
ISO	RE mm							
060202FN	0,2	652	636	70200			600	80200
060204FN	0,4	654	638	70400	678	75400	602	80400
09T302FN	0,2		639	71400			604	81400
09T304FN	0,4	656	640	71600	680	76600	606	81600
09T308FN	0,8	658	641	71800	681	76800	608	81800
09T316FN	1,6							72200
120402FN	0,2		643				610	82600
120404FN	0,4		642	72800	682	77800	612	82800
120408FN	0,8		644	73000	686	78000	614	83000
P				●		●		●
M				●		●		●
K		○	○		○		○	○
N		●	●	●	●	●	●	●
S			○	●	○	●		●
H								
O		○	○		○		○	○

CCET / CCMT

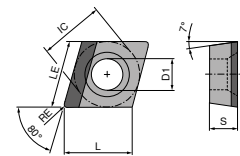
		NEW		
		-F05 CTPX710	-29 H216T	-29 CTPX715
		DRAGONSKIN		DRAGONSKIN
				
		F	M	M
		CCET	CCMT	CCMT
		76 243 ...	70 245 ...	70 245 ...
ISO	RE mm			
060201FN	0,1	10100		
060202FN	0,2	10200		
060204EN	0,4		60400	70400
060204FN	0,4	10400		
09T304EN	0,4		61600	71600
09T308EN	0,8		61800	71800
P		●		●
M		●		●
K			○	○
N		●	●	●
S		●		●
H				
O			○	○

CCGW / CCGT

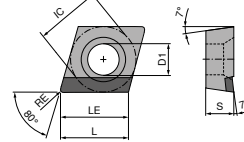
Designation	L mm	S mm	D1 mm	IC mm
CCG. 0602..	6,4	2,38	2,8	6,35
CCG. 09T3..	9,7	3,97	4,4	9,52
CCG. 1204..	12,9	4,76	5,5	12,70



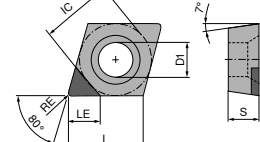
CCGT A



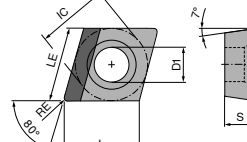
CCGT A LL



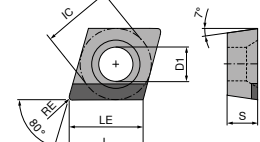
CCGT A RR



CCGW A



CCGW A LL



CCGW A RR

CCGW / CCGT

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

	CTDMD05	CTDPD20	CTDPD20	-Q CTDPD20	-Q CTDPD20
	F	F	F	F	F
	DIAMOND	DIAMOND	DIAMOND	DIAMOND	DIAMOND
	CCGW	CCGW	CCGT	CCGW	CCGT
	71 120 ...	71 120 ...	71 124 ...	71 125 ...	71 126 ...
ISO	RE mm	TCE (NOI)	LE mm		
060201FN	0,1	A (1)	3,4		101
060201FN	0,1	A (1)	3,5		
060202FN	0,2	A (1)	2,5		
060202FN	0,2	A (1)	3,3		
060202FN	0,2	A (1)	3,4		102
060204FN	0,4	A (1)	2,5		
060204FN	0,4	A (1)	3,1		104
060204FN	0,4	A (1)	3,2		
060208FN	0,8	A (1)	2,5		
060208FN	0,8	A (1)	3,0		
09T301FN	0,1	A (1)	4,5		111
09T302FN	0,2	A (1)	4,4		112
09T302FN	0,2	A (1)	4,5		
09T304FN	0,4	A (1)	2,5		
09T304FN	0,4	A (1)	4,2		114
09T304FN	0,4	A (1)	4,3		
09T308FN	0,8	A (1)	2,5		
09T308FN	0,8	A (1)	4,1		
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		
120408FN	0,8	A (1)	4,1		

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

CCGW / CCGT

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

ISO	RE mm	TCE (NOI)	LE mm						
				CTDPD20	CTDPD20	-CB1 CTDPD20	-CB2 CTDPD20	-CB1 CTDPD20	-Q-CB2 CTDPD20
				F DIAMOND CCGW	F DIAMOND CCGW	F DIAMOND CCGT	M DIAMOND CCGT	F DIAMOND CCGT	M DIAMOND CCGT
				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		10601				
120412FLL	1,2	A (1)	12,90	10501					
P									
M									
K									
N				•	•	•	•	•	•
S									
H									
O				•	•	•	•	•	•

CCGT / CCGW

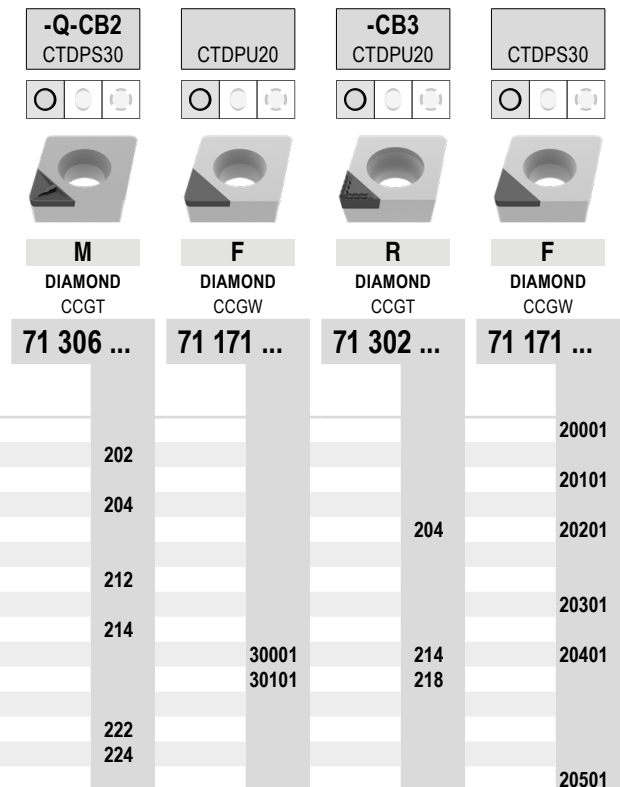
▲ TCE(NOI) = Design and number of equipped cutting edge corners

				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 ...
ISO	RE mm	TCE (NOI)	LE mm						
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
060204FN	0,4	A (1)	3,20						204
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				20201	20301	
060208FLL	0,8	A (1)	6,45						
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
09T304FN	0,4	A (1)	4,30						214
09T308FN	0,8	A (1)	4,10						218
09T308FRR	0,8	A (1)	9,70				20401	20501	
09T308FLL	0,8	A (1)	9,70						
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
120408FN	0,8	A (1)	4,10						228
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	202			20001
060202FN	0,2	A (1)	3,4				20101
060204FN	0,4	A (1)	3,1	204			
060204FN	0,4	A (1)	3,2			204	20201
09T302FN	0,2	A (1)	4,4	212			
09T302FN	0,2	A (1)	4,5				20301
09T304FN	0,4	A (1)	4,2	214			
09T304FN	0,4	A (1)	4,3		30001 30101	214 218	20401
09T308FN	0,8	A (1)	4,1				
120402FN	0,2	A (1)	4,4	222			
120404FN	0,4	A (1)	4,2	224			
120404FN	0,4	A (1)	4,3				20501
P							
M							
K							
N				•	•	•	•
S							
H							
O				•	•	•	•



CCGW / CCGT

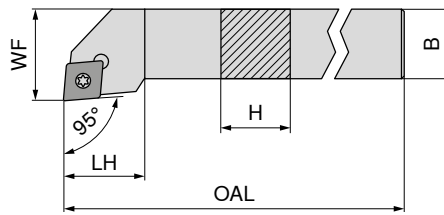
▲ TCE(NOI) = Design and number of equipped cutting edge corners

				CTDCD10	-CB1 CTDCD10	-Q-CB1 CTDCD10	-CB2 CTDCD10	-Q-CB2 CTDCD10
								
								
				F DIAMOND CCGW	F DIAMOND CCGT	F DIAMOND CCGT	M DIAMOND CCGT	M DIAMOND CCGT
				71 171 ...	71 300 ...	71 167 ...	71 301 ...	71 306 ...
ISO	RE mm	TCE (NOI)	LE mm					
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								
K								
N				•	•	•	•	•
S								
H								
O				•	•	•	•	•

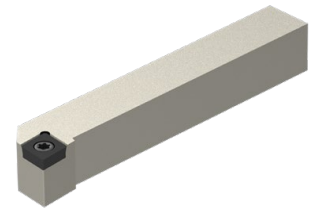
MaxiLock-S – SCLC 95° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



NEW

Left-hand

70 636 ...

NEW

Right-hand

70 636 ...

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	00800	00801
SCLC R/L 1010 E06	10	10	70	9	12	1,2	CC.. 0602	01000	01001
SCLC R/L 1212 F09	12	12	80	15	16	3,2	CC.. 09T3	01200	01201
SCLC R/L 1616 H09	16	16	100	17	20	3,2	CC.. 09T3	01600	01601
SCLC R/L 2020 K09	20	20	125	17	25	3,2	CC.. 09T3	02000	02001
SCLC R/L 1616 H12	16	16	100	20	20	5	CC.. 1204	11600	11601
SCLC R/L 2020 K12	20	20	125	20	25	5	CC.. 1204	12000	12001
SCLC R/L 2525 M12	25	25	150	20	32	5	CC.. 1204	12500	12501
SCLC R/L 3225 P12	32	25	170	20	32	5	CC.. 1204	13200	13201

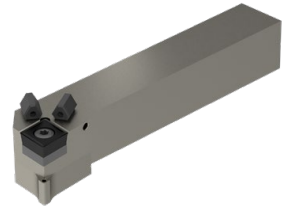
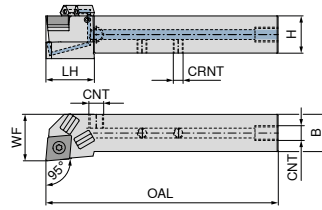
Spare parts for Article no.

	Key D	Clamping screw	Carbide type C	Threaded sleeve
70 636 00800 / 70 636 00801	039	857		
70 636 01000 / 70 636 01001	039	857		
70 636 01200 / 70 636 01201	120	87900		
70 636 01600 / 70 636 01601	120	87900		
70 636 02000 / 70 636 02001	120	87900		
70 636 11600 / 70 636 11601	120	820	166	170
70 636 12000 / 70 636 12001	120	820	166	170
70 636 12500 / 70 636 12501	120	820	166	170
70 636 13200 / 70 636 13201	120	820	166	170

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

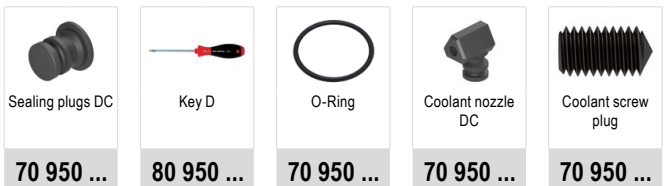
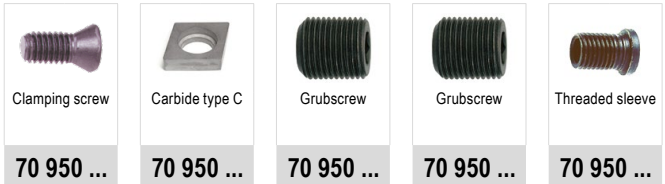
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	NEW Left-hand 70 770 ...	NEW Right-hand 70 770 ...
SCLC R/L 1010 E06 DC	10	10	70	14	12	M6	M6	1,2	CC.. 0602	01001	01000
SCLC R/L 1212 F09 DC	12	12	80	19	16	M6	M6	3,2	CC.. 09T3	01201	01200
SCLC R/L 1616 H09 DC	16	16	100	26	20	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.

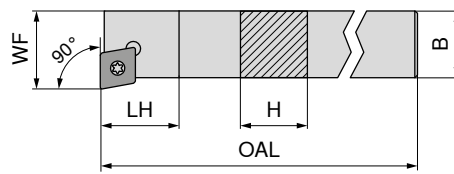
	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 770 01000 / 70 770 01001	857			86700	
70 770 01200 / 70 770 01201	859			86700	
70 770 01600 / 70 770 11601	87900	165	88000	86700	171
70 770 02000 / 70 770 12001	87900	165	88000	86700	171
70 770 11600 / 70 770 01601	820	166	88000	86700	170
70 770 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.

	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



A schematic diagram of a mold. It consists of two yellow trapezoidal blocks on either side of a central white rectangular cavity. A black arrow points vertically downwards from the top of the cavity, indicating the direction of flow or pressure.



Right-hand

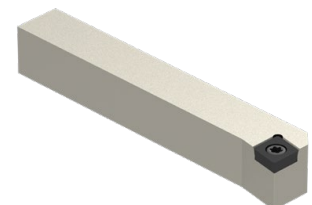
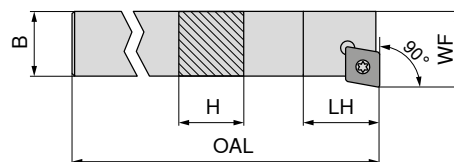
70 760 ...

02000¹⁾

020

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



Left-hand

70 635 ...

0080

SCFC L 0808 D06	8	8	60	10	10	1,2	CC.. 0602	0080
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SCFC L 1010 E06	10	10	70	10	12	1,2	CC.. 0602	0100
-----------------	----	----	----	----	----	-----	-----------	------

SCFC L 1212 F09	12	12	80	13	16	3,2	CC..09T3	0120
-----------------	----	----	----	----	----	-----	----------	------

SCFC L 1616 H09	16	16	100	13	20	3,2	CC.. 09T3	0160
-----------------	----	----	-----	----	----	-----	-----------	------

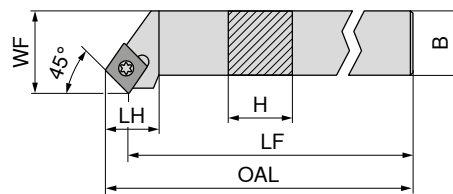
	
Key D	Clamping screw
80 950 ...	70 950 ...
039	857
039	857
120	87900
120	87900

70 635 00800	039	857
70 635 01000	039	857
70 635 01200	120	87900
70 635 01600	120	87900

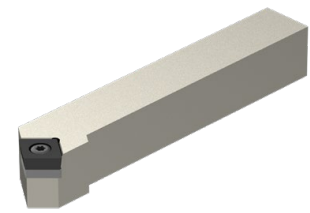
MaxiLock-S – SCSC 45° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



NEW

Left-hand

70 638 ...

NEW

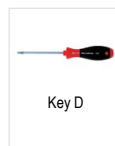
Right-hand

70 638 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert		
SCSC R 1616 H12	16	16	100	20	20	5	CC.. 1204		
SCSC R/L 2020 K12	20	20	125	20	25	5	CC.. 1204	02000	01601
SCSC R/L 2525 M12	25	25	150	20	32	5	CC.. 1204	02500	02001

Spare parts for Article no.

70 638 01601	T15 - IP	120	M4,5x12 - IP	820	166	M4,5	170
70 638 02001 / 70 638 02000	T15 - IP	120	M4,5x12 - IP	820	166	M4,5	170
70 638 02501 / 70 638 02500	T15 - IP	120	M4,5x12 - IP	820	166	M4,5	170



Key D



Clamping screw



Carbide type C



Threaded sleeve

80 950 ...

70 950 ...

70 950 ...

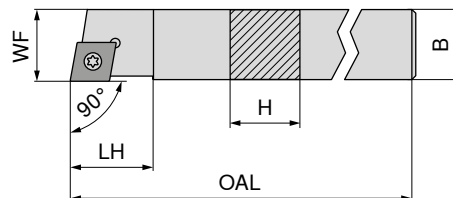
70 950 ...

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

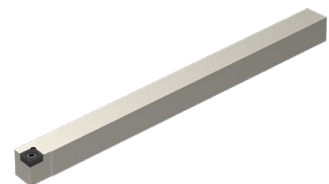
▲ for sliding head lathes

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



NEW

Left-hand

70 633 ...

NEW

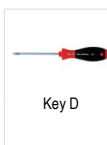
Right-hand

70 633 ...

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

Spare parts for Article no.

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



Key D



Clamping screw



Carbide type C



Threaded sleeve

80 950 ...

70 950 ...

70 950 ...

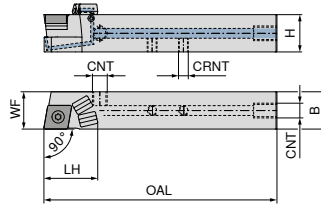
70 950 ...

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

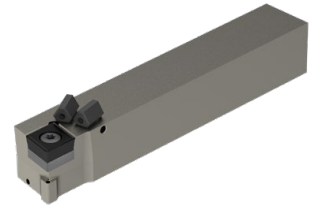
▲ for sliding head lathes

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions

**NEW**

Left-hand

NEW

Right-hand

70 766 ...

70 766 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert		
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.

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.

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

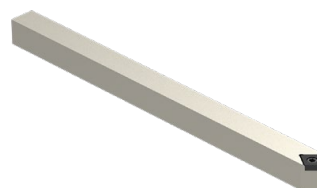
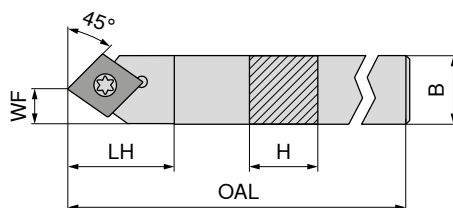
Clamping screw	Carbide type C	Grubscrew	Grubscrew	Threaded sleeve
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...

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 – SCDC 45° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key

**NEW**

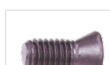
Left-hand

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



Clamping screw

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

Spare parts

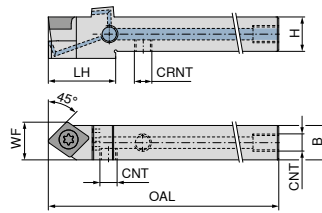
for Article no.

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

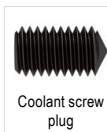


NEW

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

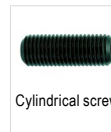
70 950 ...

Spare parts for Article no.

70 767 00801	M2,5x6 - T08	13800		
70 767 01001	M2,5x6 - T08	13800	M6x6	86700
70 767 01201	M3,5x11	113	M6x6	86700
70 767 01401	M3,5x11	113	M6x6	86700

G 1/8"

294



Cylindrical screw

83 950 ...



Key D

80 950 ...

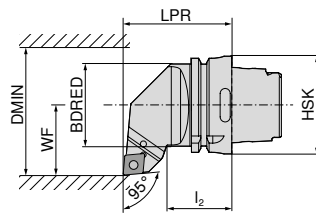
Spare parts for Article no.

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



Clamping screw



Carbide type C



Threaded sleeve

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

Spare parts for Article no.

74 540 512 / 74 541 512

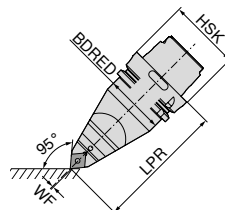
T15/SW

M4,5x12

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

Scope of supply:

Tool holder with Torx key



Neutral
74 542 ...

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

512



Combination Key



Clamping screw



Carbide type C



Threaded sleeve

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

Spare parts for Article no.

74 542 512

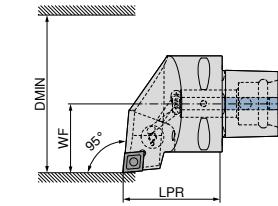
T15/SW

M4,5x12

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 84 655 ...	Right-hand 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 39.

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



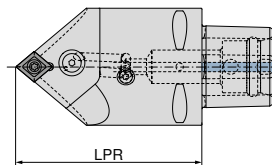
Clamping screw

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 39.

Spare parts for Article no.

84 674 01293	27500
84 674 11293	27500



Clamping screw

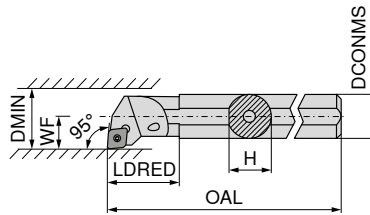
84 950 ...

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



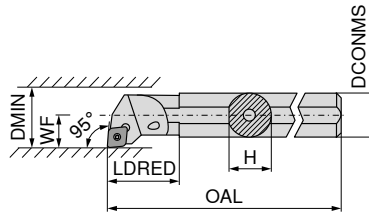
ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 717 ...		Right-hand 70 716 ...	
S08H SCLC R/L 06	8	7,2	100	11,0	5	11	1,2	CC.. 0602	008		008	
A08F SCLC R/L 06	8	7,6	80	17,0	5	11	1,2	CC.. 0602	208		208	
S10K SCLC R/L 06	10	9,0	125	15,0	7	13	1,2	CC.. 0602	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.

	Key D	Combination Key	Clamping screw	Carbide type C	Threaded sleeve
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		304		
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 70 719 ...		Right-hand 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



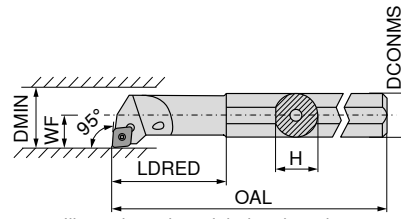
Clamping screw

**Spare parts
for Article no.**

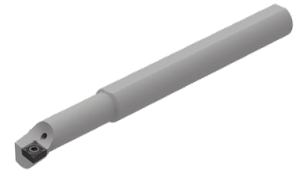
		80 950 ...		70 950 ...	
70 718 208 / 70 719 208	T08	110	M2,5x5	116	
70 718 210 / 70 719 210	T08	110	M2,5x5	116	
70 718 212 / 70 719 212	T08	110	M2,5x5	116	
70 718 216 / 70 719 216	T15	113	M4x9,5	449	
70 718 220 / 70 719 220	T15	113	M4x9,5	449	
70 718 225 / 70 719 225	T15	113	M4x9,5	449	
70 718 232 / 70 719 232	T15	113	M4x11	174	

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

▲ with carbide core



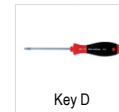
Illustrations show right-hand versions



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

Spare parts for Article no.

70 718 308 / 70 719 308	T08	110	M2,5x5	116
70 718 310 / 70 719 310	T08	110	M2,5x5	116
70 718 312 / 70 719 312	T08	110	M2,5x5	116
70 718 316 / 70 719 316	T08	110	M2,5x5	116



Key D



Clamping screw

80 950 ...

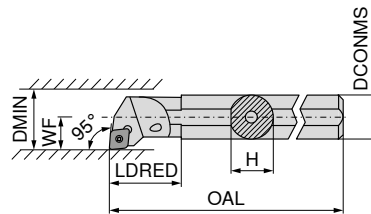
70 950 ...

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

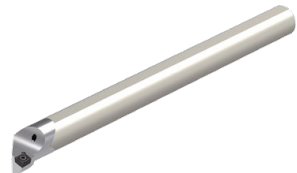
▲ Type: Solid carbide

Scope of supply:

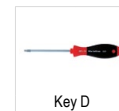
Boring bar with Torx key



Illustrations show right-hand versions



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



Key D



Clamping screw

80 950 ...

70 950 ...

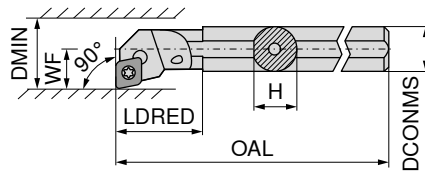
Spare parts for Article no.

70 719 008 / 70 718 008	T08	110	M2,5x5	116
70 719 010 / 70 718 010	T08	110	M2,5x5	116
70 719 012 / 70 718 012	T08	110	M2,5x5	116
70 719 016 / 70 718 016	T15	113	M3,5x7,2	110
70 719 020 / 70 718 020	T15	113	M3,5x8,6	304
70 719 025 / 70 718 025	T15	113	M3,5x11	113

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 70 793 ...	Right-hand 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

Spare parts for Article no.

70 792 208 / 70 793 208	T08	110	M2,5x5	116
70 792 210 / 70 793 210	T08	110	M2,5x5	116
70 792 212 / 70 793 212	T08	110	M2,5x5	116



Key D

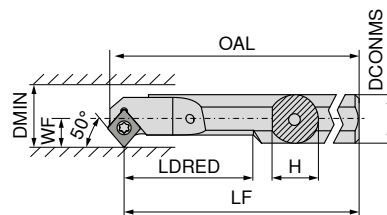


Clamping screw

80 950 ...

70 950 ...

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 70 723 ...	Right-hand 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

Spare parts for Article no.

70 723 208 / 70 722 208	T08	110	M2,5x5	116
70 723 210 / 70 722 210	T08	110	M2,5x5	116
70 723 212 / 70 722 212	T08	110	M2,5x5	116
70 723 216 / 70 722 216	T08	110	M2,5x5	116



Key D



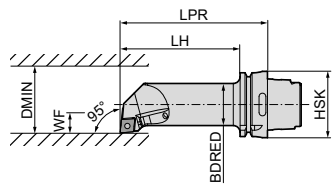
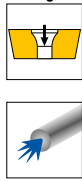
Clamping screw

80 950 ...

70 950 ...

MaxiLock-S – SCLC 95° – Boring bar with screw 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		
HSK T63 40L SCLC R/L 12	HSK-T 63	140	114	40	27	50	5	CC.. 1204	Left-hand 74 564 ...	Right-hand 74 563 ...
									512	512

Spare parts
for Article no.

74 563 512 / 74 564 512	T15/SW	398	M4,5x12	114	166	M4,5	170
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Combination Key



Clamping screw



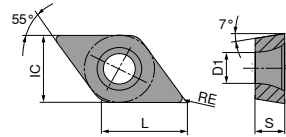
Carbide type C



Threaded sleeve

DCGT / DCMT / DCET

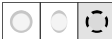
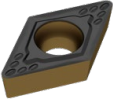
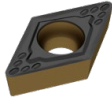
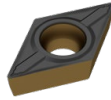
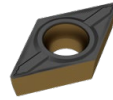
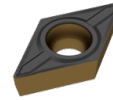
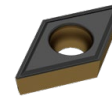
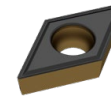
Designation	L mm	S mm	D1 mm	IC mm
DC.T 0702..	7,75	2,38	2,8	6,35
DC.T 11T3..	11,60	3,97	4,4	9,52



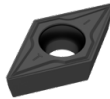
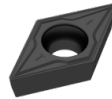
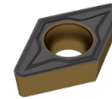
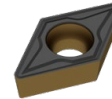
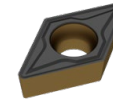
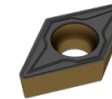
DCGT / DCMT

		-CF05 CTEP110		-CF55 CTEP110		-SF TCM407		-SF TCM10		-SMF TCM10		NEW -SF CTCP125-P		NEW -SF CTCP115-P	
		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 ...	
ISO	RE mm														
070201EN	0,1							898							
070202EN	0,2	002		002				900				50201			
070204EN	0,4	004		004		852		902		898				30401	
11T302EN	0,2	014				854		904							
11T304EN	0,4	016		016		856		906		904				31601	
11T308EN	0,8	018		018		858		908		906				31801	
P		●		●		●		●		●		●		●	
M		○		○		○		○		○		○		○	
K		○		○		○		○		○		○		○	
N															
S															
H															
O															

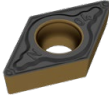
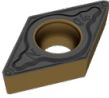
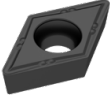
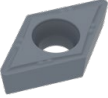
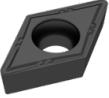
DCMT / DCGT

		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								

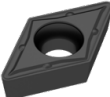
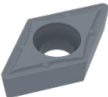
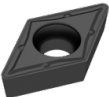
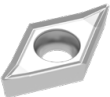
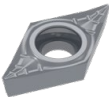
DCMT

		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									

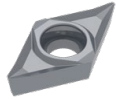
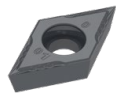
DCMT

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

DCMT / DCGT

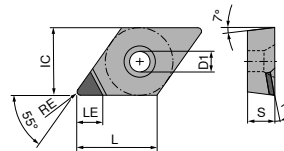
		-M55 CTCM120		-M55 CTPM125		-M55 CTCM130		-23P H216T		-25P H210T		-25P CTPX710		-25Q H210T	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN				DRAGONSKIN					
															
															
		M DCMT		M DCMT		M DCMT		F DCGT		F DCGT		M DCGT		M DCGT	
		75 214 ...		75 214 ...		75 214 ...		70 261 ...		70 263 ...		70 263 ...		70 263 ...	
ISO	RE mm														
070202FN	0,2									632		70200			
070204EN	0,4	10400		204		30400		654		634		70400			
070204FN	0,4														
070208EN	0,8	10600		206		30600									
11T302FN	0,2									635		71400			
11T304EN	0,4	11600		216		31600									
11T304FL	0,4							664		636		71600		670	
11T304FN	0,4													660	
11T304FR	0,4													680	
11T308EN	0,8	11800		218		31800									
11T308FL	0,8							666		638		71800		672	
11T308FN	0,8													662	
11T308FR	0,8													682	
P		○		○		○						●			
M		●		●		●						●			
K								○		○				○	
N								●		●		●		●	
S						○				○		●		○	
H															
O								○		○				○	

DCGT / DCET / DCMT

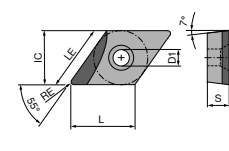
		-25P H210T		-27 H10T		-27 CTPX715		-F05 CTPX710		-29 H216T		NEW -29 CTPX715	
													
													
		F DCGT		M DCGT		M DCGT		F DCET		M DCMT		M DCMT	
		70 263 ...		70 260 ...		70 260 ...		76 254 ...		70 246 ...		70 246 ...	
ISO	RE mm												
0702005FN	0,05							10200					
070201FN	0,10							10400					
0702015FN	0,15							10600					
070202FN	0,20	632		600		80200		10800					
070204FN	0,40	634		602		80400				60400		70400	
070204EN	0,40												
11T3005FN	0,05							11400					
11T301FN	0,10							11600					
11T3015FN	0,15							11800					
11T302FN	0,20	635		604		81400		12000					
11T304FN	0,40	636		606		81600		12200					
11T304EN	0,40									61600		71600	
11T308FN	0,80	638		608		81800				61800		71800	
11T308EN	0,80												
P						●		●				●	
M						●		●				●	
K		○		○		○				○		○	
N		●		●		●		●		●		●	
S		○				●		●				●	
H													
O		○		○		○				○		○	

DCGW / DCGT

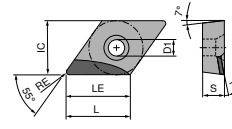
Designation	L mm	S mm	D1 mm	IC mm
DCG. 0702..	7,75	2,38	2,8	6,35
DCG. 11T3..	11,60	3,97	4,4	9,52



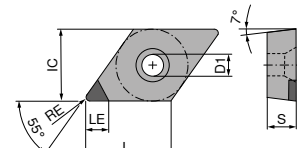
DCGT A



DCGT A L



DCGT A R



DCGW A

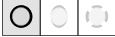
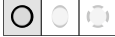
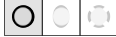
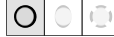
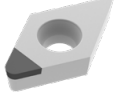
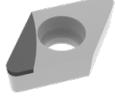
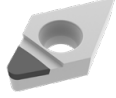
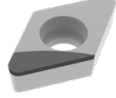
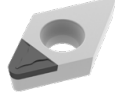
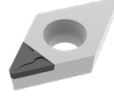
DCGW / DCGT

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

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

DCGW / DCGT

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

				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 ...
ISO	RE mm	TCE (NOI)	LE mm						
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

				CTDPD20	CTDPD20	-Q CTDPD20	-Q CTDPD20	-CB1 CTDPD20	-Q CTDPS30		
				F DIAMOND DCGT	F DIAMOND DCGT	F DIAMOND DCGT	F DIAMOND DCGT	F DIAMOND DCGT	F DIAMOND DCGW		
				71 136 ...	71 135 ...	71 144 ...	71 145 ...	71 310 ...	71 138 ...		
ISO	RE mm	TCE (NOI)	LE mm								
070201FN	0,1	A (1)	3,8								
070202FN	0,2	A (1)	3,7								
070204FL	0,4	A (1)	3,0								
070204FR	0,4	A (1)	3,0								
070204FN	0,4	A (1)	3,4								
070204FRR	0,4	A (1)	5,5								
070204FLL	0,4	A (1)	5,5	102	102	104		104	10100 102		
070208FN	0,8	A (1)	3,0								
070208FRR	0,8	A (1)	5,0								
070208FLL	0,8	A (1)	5,0	104	104	114		108			
11T301FN	0,1	A (1)	4,8								
11T302FR	0,2	A (1)	4,0								
11T302FN	0,2	A (1)	4,7								
11T304FL	0,4	A (1)	4,0								
11T304FR	0,4	A (1)	4,0								
11T304FN	0,4	A (1)	4,3								
11T304FRR	0,4	A (1)	7,5								
11T304FLL	0,4	A (1)	7,5	108	108	114	114	112	162		
11T308FN	0,8	A (1)	4,0								
11T308FRR	0,8	A (1)	7,0								
11T308FLL	0,8	A (1)	7,0	110	110			118	164		
P											
M											
K											
N				•	•	•	•	•	•		
S											
H											
O				•	•	•	•	•	•		

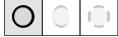
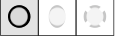
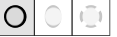
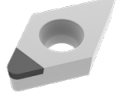
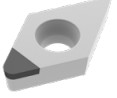
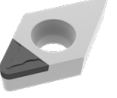
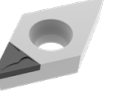
DCGW / DCGT

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

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

DCGW / DCGT

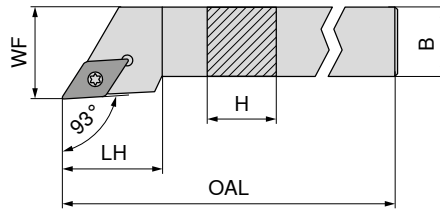
▲ TCE(NOI) = Design and number of equipped cutting edge corners

ISO	RE mm	TCE (NOI)	LE mm				
				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 ...
070202FN	0,2	A (1)	2,6		40001	302	30200
070204FN	0,4	A (1)	2,3		40101	304	304
070204FN	0,4	A (1)	3,4	30001			
070208FN	0,8	A (1)	2,0		40201		308
070208FN	0,8	A (1)	3,0	30101			
11T302FN	0,2	A (1)	2,6		40301	31200	31200
11T304FN	0,4	A (1)	2,3		40401	314	314
11T304FN	0,4	A (1)	4,3	30201			
11T308FN	0,8	A (1)	2,0		40501	318	318
11T308FN	0,8	A (1)	4,0	30301			
P							
M							
K							
N				•	•	•	•
S							
H							
O				•	•	•	•

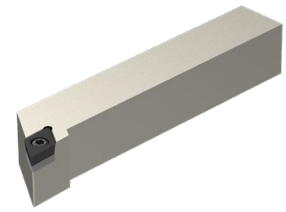
MaxiLock-S – SDJC 93° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



NEW

Left-hand

70 643 ...

NEW

Right-hand

70 643 ...

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

00800

01000

01200

01600

02000

02500

03200

00801

01001

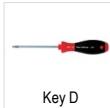
01201

01601

02001

02501

03201



Key D



Clamping screw



Solid Carbide
Seat D



Threaded sleeve

80 950 ...

70 950 ...

70 950 ...

70 950 ...

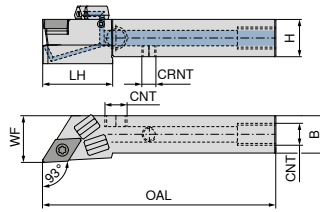
Spare parts for Article no.

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.

	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 773 01000 / 70 773 01001	857			86700	
70 773 01200 / 70 773 01201	857			86700	
70 773 01600 / 70 773 01601	87900	106	88000	86700	171
70 773 02000 / 70 773 02001	87900	106	88000	86700	171
70 773 02500 / 70 773 02501	87900	106	88000	86700	171

Spare parts for Article no.

	70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...
70 773 01000 / 70 773 01001		039			
70 773 01200 / 70 773 01201		039			
70 773 01600 / 70 773 01601	87600	120	88100	87700	294
70 773 02000 / 70 773 02001	87600	120	88100	87700	294
70 773 02500 / 70 773 02501	87600	120	88100	87700	294

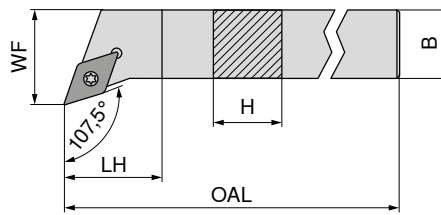
Clamping screw	Solid Carbide Seat D	Grubscrew	Grubscrew	Threaded sleeve
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...

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

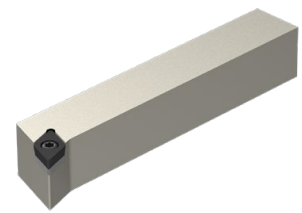
MaxiLock-S – SDHC 107.5° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



NEW

Left-hand

70 642 ...

NEW

Right-hand

70 642 ...

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	01000	01001
SDHC R/L 1212 F07	12	12	80	12,2	16	1,2	DC.. 0702	01200	01201
SDHC R/L 1616 H11	16	16	100	11,6	20	3,2	DC.. 11T3	01600	01601
SDHC R/L 2020 K11	20	20	125	14,1	25	3,2	DC.. 11T3	02000	02001
SDHC R/L 2525 M11	25	25	150	20,5	32	3,2	DC.. 11T3	02500	02501

Spare parts for Article no.

	Key D	Clamping screw	Solid Carbide Seat D	Threaded sleeve
70 642 01000 / 70 642 01001	039	857		
70 642 01200 / 70 642 01201	039	857		
70 642 01600 / 70 642 01601	120	87900	106	171
70 642 02000 / 70 642 02001	120	87900	106	171
70 642 02500 / 70 642 02501	120	87900	106	171



Key D

80 950 ...



Clamping screw

70 950 ...



Solid Carbide
Seat D

70 950 ...



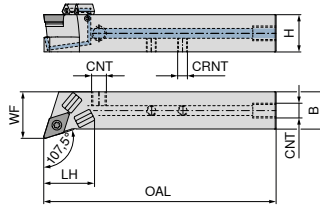
Threaded sleeve

70 950 ...

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		
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

Spare parts for Article no.

70 772 01201 / 70 772 01200		039			
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

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

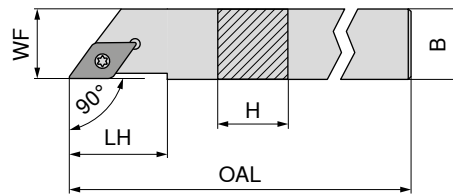
70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...

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

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	70 639 ...	70 639 ...
SDAC R/L 0808 K07	8	8	125	14	8	1,2	DC.. 0702	00800	00801
SDAC R/L 1010 M07	10	10	150	14	10	1,2	DC.. 0702	01000	01001
SDAC R/L 1212 M07	12	12	150	14	12	1,2	DC.. 0702	01200	01201
SDAC R/L 1212 M11	12	12	150	21	12	3,2	DC.. 11T3	11200	11201
SDAC R/L 1414 M11	14	14	150	21	14	3,2	DC.. 11T3	01400	01401

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

Key D

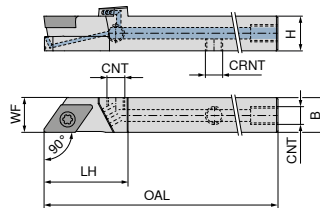
Clamping screw

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

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	70 771 ...	70 771 ...
SDAC R/L 0808 K07 DC	8	8	125	21	8	M5	M5	1,2	DC.. 0702	00801	00800
SDAC R/L 1010 M07 DC	10	10	150	21	10	M6	M6	1,2	DC.. 0702	01001	01000
SDAC R/L 1212 M07 DC	12	12	150	21	12	M6	M6	1,2	DC.. 0702	01201	01200
SDAC R/L 1212 M11 DC	12	12	150	29	12	M6	M6	3,2	DC.. 11T3	11201	11200

Spare parts

for Article no.

70 771 00800 / 70 771 00801	157	039	13800	00800
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

Cylindrical screw

Key D

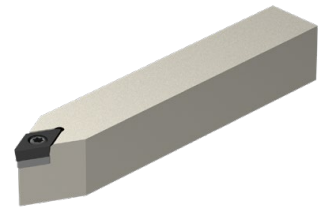
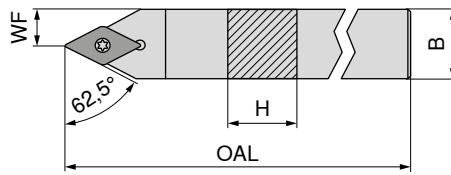
Clamping screw

Grubscrew

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



Key D



Clamping screw

Solid Carbide
Seat D

Threaded sleeve

80 950 ...

70 950 ...

70 950 ...

70 950 ...

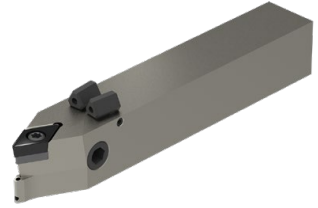
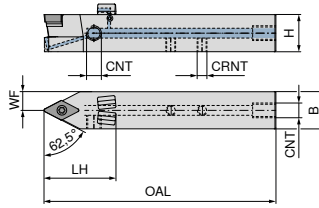
Spare parts for Article no.

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.

	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

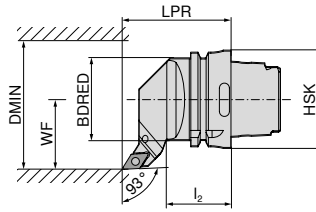
Spare parts for Article no.

	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	Right-hand
74 544 ...	74 543 ...
511	511

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



Combination Key



Clamping screw



Solid Carbide
Seat D



Threaded sleeve

70 950 ...	70 950 ...	70 950 ...	70 950 ...
398	113	106	171

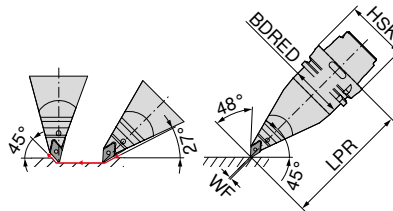
Spare parts for Article no.

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

Scope of supply:

Tool holder with Torx key



Left-hand
74 546 ...
511

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



Combination Key



Clamping screw



Solid Carbide
Seat D



Threaded sleeve

70 950 ...	70 950 ...	70 950 ...	70 950 ...
398	113	106	171

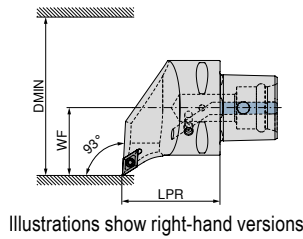
Spare parts for Article no.

74 546 511	T15/SW	M3,5x11	M3,5
------------	--------	---------	------

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	Left-hand 84 659 ...	Right-hand 84 658 ...
PSC40 SDUC R/L 50050-11	PSC 40	50	27	50	3	DC.. 11T3	01195	01195
PSC50 SDUC R/L 65060-11	PSC 50	60	35	65	3	DC.. 11T3	01194	01194
PSC63 SDUC R/L 80065-11	PSC 63	65	45	80	3	DC.. 11T3	01193	01193



Clamping screw

84 950 ...

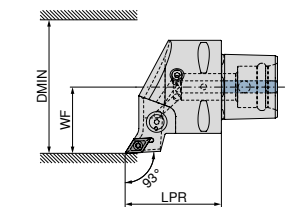
Spare parts for Article no.

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

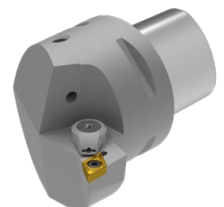
MaxiLock-S – SDJC 93° – Toolholder with screw clamping

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	Left-hand 84 663 ...	Right-hand 84 662 ...
PSC40 SDJC R/L 50050-11	PSC 40	50	27	50	3	DC.. 11T3	DC	01195	01195
PSC50 SDJC R/L 65060-11	PSC 50	60	35	65	3	DC.. 11T3	DC	01194	01194
PSC63 SDJC R/L 80065-11	PSC 63	65	45	80	3	DC.. 11T3	DC	01193	01193



Clamping screw

84 950 ...

Spare parts for Article no.

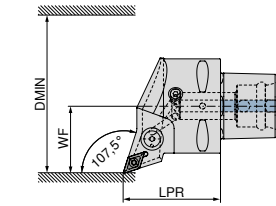
84 662 01195 / 84 663 01195	27600
84 662 01194 / 84 663 01194	27600
84 662 01193 / 84 663 01193	27600

 The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page 39.**

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 84 667 ...		Right-hand 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 39.

Spare parts

for Article no.

84 666 01195 / 84 667 01195

84 666 01194 / 84 667 01194

84 666 01193 / 84 667 01193



Clamping screw

84 950 ...

27600

27600

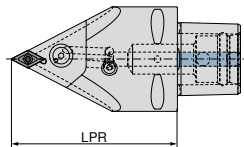
27600

9

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

Scope of supply:

without high-performance coolant set



Neutral

84 677 ...

ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Direct cooling compatible	
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 39.



Clamping screw

84 950 ...

27600

27600

Spare parts

for Article no.

84 677 01193

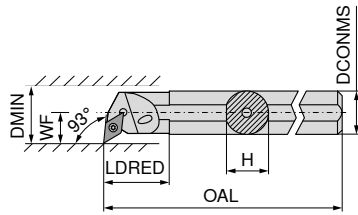
84 677 11193

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



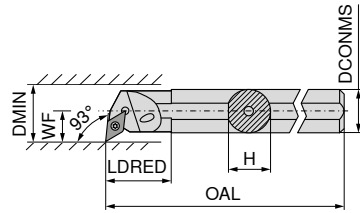
ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 737 ...		Right-hand 70 736 ...	
S12Q SDUC R/L 07	12	11,0	180	12,5	9	17	1,2	DC.. 0702		012		012
A12K SDUC R/L 07	12	11,5	125	22,0	9	16	1,2	DC.. 0702		212		212
S16R SDUC R/L 07	16	15,0	200	13,0	11	21	1,2	DC.. 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.

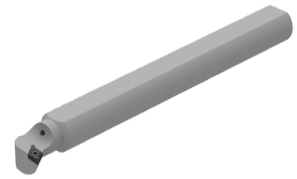
	Key D	Combination Key	Clamping screw	Solid Carbide Seat D	Threaded sleeve
70 736 012 / 70 737 012	110			13800	
70 736 212 / 70 737 212	110			13800	
70 736 016 / 70 737 016	110			13800	
70 736 216 / 70 737 216	110			13800	
70 736 020	110			13800	
70 736 220 / 70 737 220	110			13800	
70 736 120	113			110	
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 70 739 ...	Right-hand 70 738 ...
210	210
212	212
216	216
220	220
320	320
225	225
232	232

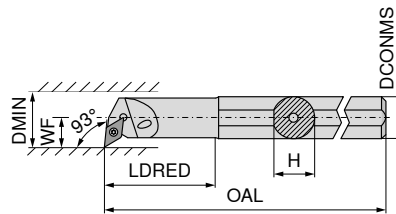
**Spare parts
for Article no.**

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

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

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

▲ with carbide core



Illustrations show right-hand versions



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

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

**Spare parts
for Article no.**

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

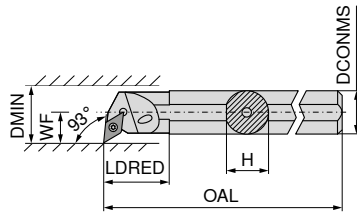
Key D 80 950 ...	Clamping screw 70 950 ...
110	13800
110	13800
110	13800

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

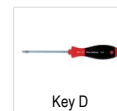


ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment	Insert	Left-hand	Right-hand
	mm	mm	mm	mm	mm	mm	Nm		70 739 ...	70 738 ...
E12Q SDUC R/L 07	12	11,5	180	26	9	16	1,2	DC.. 0702	012	012
E16R SDUC R/L 07	16	15,0	200	34	11	20	1,2	DC.. 0702	016	016
E20S SDUC R/L 11	20	18,5	250	38	13	25	3,2	DC.. 11T3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



Key D



Clamping screw

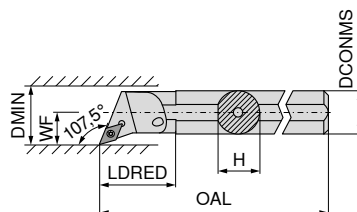
80 950 ...

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

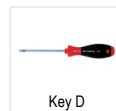


ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment	Insert	Left-hand	Right-hand
	mm	mm	mm	mm	mm	mm	Nm		70 741 ...	70 740 ...
A10H SDQC R/L 07	10	9,0	100	22	7	12,5	1,2	DC.. 0702	210	210
A12K SDQC R/L 07	12	11,5	125	22	9	16,0	1,2	DC.. 0702	212	212
A16M SDQC R/L 07	16	15,0	150	29	11	20,0	1,2	DC.. 0702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

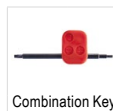
Spare parts

for Article no.

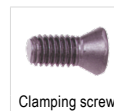
70 740 210 / 70 741 210	110	13800
70 740 212 / 70 741 212	110	13800
70 740 216 / 70 741 216	110	13800
70 740 220 / 70 741 220	110	13800
70 740 225 / 70 741 225		
70 740 232 / 70 741 232	398	113
70 740 240 / 70 741 240	398	113
		106
		171



Key D



Combination Key



Clamping screw



Solid Carbide Seat D



Threaded sleeve

80 950 ...

70 950 ...

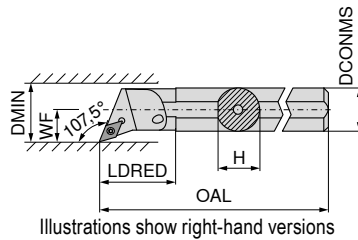
70 950 ...

70 950 ...

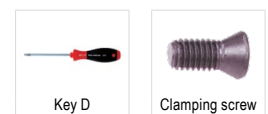
70 950 ...

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

▲ with carbide core



ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment	Insert	Left-hand 70 751 ...	Right-hand 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

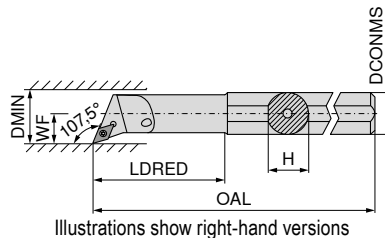


Spare parts for Article no.

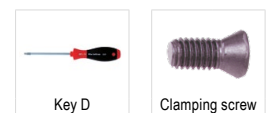
70 750 012 / 70 751 012	110	13800
70 750 016 / 70 751 016	110	13800
70 750 020 / 70 751 020	110	13800
70 750 120 / 70 751 120	113	449
70 750 025 / 70 751 025	113	449
70 750 032 / 70 751 032	113	449

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

▲ with carbide core



ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment	Insert	Left-hand 70 751 ...	Right-hand 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



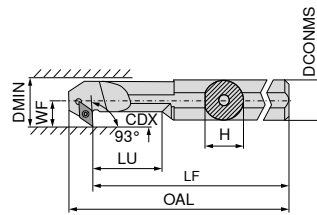
Spare parts for Article no.

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 mm	H mm	LF mm	OAL mm	LU mm	WF mm	DMIN mm	CDX mm	torque moment Nm	Insert	Left-hand 70 733 ...	Right-hand 70 732 ...
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



Key D



Clamping screw

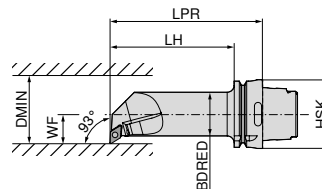
Spare parts for Article no.

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

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



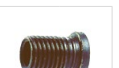
Combination Key



Clamping screw



Solid Carbide
Seat D



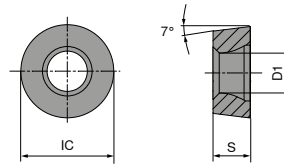
Threaded sleeve

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 2005..	6,35	6,5	20
RCMT 2507..	7,94	7,2	25
RCMX 2507..	7,94	10,5	25



RCMT / RCGT

		NEW						
		-SMF CTCK110	-SM CTCP115-P	-SM CTCP115-P	-SM CTCP125-P	-SM CTCP125-P	-SM CTCP135-P	-SM CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F RCMT	M RCMT	M RCMT	M RCGT	M RCMT	M RCGT	M RCMT
		70 188 ...	76 186 ...	76 264 ...	76 262 ...	76 264 ...	76 262 ...	76 264 ...
ISO	RE mm							
0602M0EN	3,0				50201		70201	
0803M0EN	4,0				51201		71201	
1003M0SN	5,0					51401		71401
1204M0SN	6,0			32801		52601		72601
1606M0EN	8,0	038		34001		53801		73801
1606M0SN	8,0					55001		75001
2006M0SN	10,0		35001			56201		76201
2507M0SN	12,5			36201				
P		○	●	●	●	●	●	●
M							○	○
K		●	○	○	○	○		
N								
S								
H								
O								

RCMT / RCMX

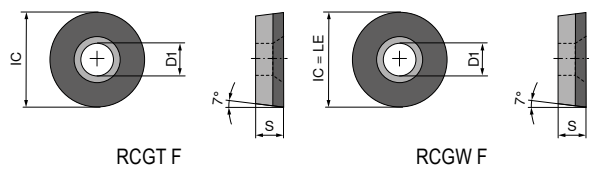
		NEW						
		-SM CTPX710	-SM CTCM120	-SM CTPM125	-M23 CTCP115-P	-M23 CTCP115-P	-M23 CTCP115-P	-M23 CTCP125-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M RCMT	M RCMT	M RCMT	M RCMT	M RCMX	M RCMT	M RCMT
		75 221 ...	75 221 ...	75 221 ...	74 117 ...	74 117 ...	74 121 ...	74 121 ...
ISO	RE mm							
1003M0SN	5,0	61400	11400					
10T3M0SN	5,0						21400	
1204M0SN	6,0						22600	62600
1606M0SN	8,0						23800	63800
2005M0SN	10,0				25000			
2006M0SN	10,0			25000				65000
2507M0SN	12,5					25400		
P		●	○	○	●	●	●	●
M		●	●	●				
K					○	○	○	○
N		○						
S		●						
H								
O								

RCGT

		-25P H210T	-27 H10T	-27 CTPX715
				DRAGONSKIN
		F RCGT	M RCGT	M RCGT
		70 241 ...	70 266 ...	70 266 ...
ISO	RE mm			
0602M0FN	3		600	70200
0803M0FN	4	60200	602	80200
1003M0FN	5		604	80400
P				●
M				●
K			○	○
N		●	●	●
S		○		●
H				
O		○	○	○

RCGW / RCGT

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



RCGW / RCGT

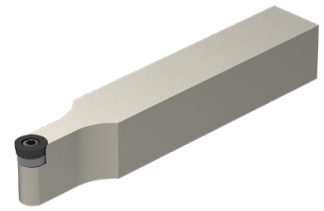
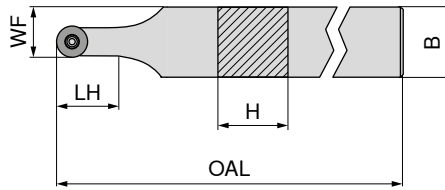
▲ TCE(NOI) = Design and number of equipped cutting edge corners

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



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

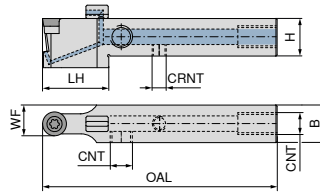
Spare parts for Article no.

	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

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.

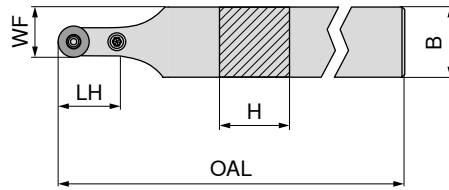
	Clamping screw 70 950 ...	Solid carbide support R 70 950 ...	Grubscrew 70 950 ...	Grubscrew 70 950 ...	Threaded sleeve 70 950 ...
Spare parts for Article no.					
70 775 01200	857			86700	
70 775 01600	857		88000	86700	
70 775 02000	857		88000	86700	
70 775 02500	857		88000	86700	
70 775 11600	819		88000	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

	Sealing plugs DC 70 950 ...	Key D 80 950 ...	O-Ring 70 950 ...	Coolant nozzle DC 70 950 ...	Coolant screw plug 70 950 ...
Spare parts for Article no.					
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



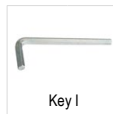
Neutral

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

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



Key I



Shim



Assembly pin



Lever



Clamping screw



Solid carbide support R

70 950 ...

70 950 ...

70 950 ...

70 950 ...

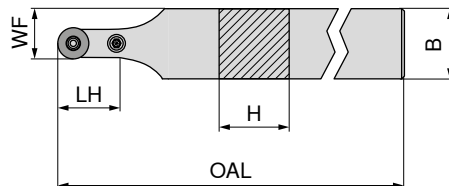
70 950 ...

70 950 ...

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

Scope of supply:

Tool holder with allen key



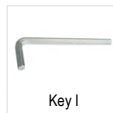
Neutral

70 545 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	
PRDC N 3225 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

Spare parts for Article no.

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



Key I



Shim



Assembly pin



Lever



Clamping screw



Solid carbide support R

70 950 ...

70 950 ...

70 950 ...

70 950 ...

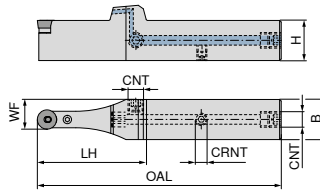
70 950 ...

70 950 ...

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

Scope of supply:

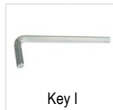
Tool holder with allen key

**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



Key I

70 950 ...

Shim

70 950 ...

Assembly pin

70 950 ...Coolant screw
plug**70 950 ...**

Lever

70 950 ...

Clamping screw

70 950 ...Solid carbide
support R**70 950 ...**

Grubscrew

70 950 ...

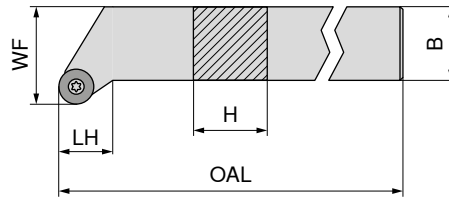
Spare parts for Article no.

70 595 02000	175	197	191	294	178	208	215	86700
70 595 02500	175	197	191	294	178	208	215	86700
70 595 03200	175	197	191	294	178	208	215	86700
70 595 13200	175	196	192	294	387	390	384	86700
70 595 23200	177	391	394	294	28100	28500	27400	86700
70 595 04000	396	392	395	294	28400	28600	27500	86700

MaxiLock-S – SRGC – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



NEW

Left-hand

70 647 ...

NEW

Right-hand

70 647 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert		
SRGC R/L 1212 F06	12	12	80	12,5	16	1,2	RC.. 0602		
SRGC R 1616 H06	16	16	100	12,5	20	1,2	RC.. 0602	01200	01201
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.



Key D



Clamping screw



Solid carbide
support R



Threaded sleeve

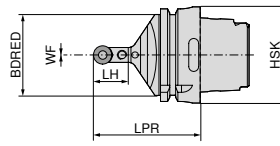
Spare parts for Article no.

		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	117	M3,5		171
70 647 22500 / 70 647 22501	T15 - IP	120	M3,5x11	87900	117	M3,5		171

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

Scope of supply:

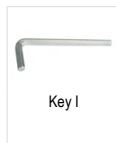
Tool holder with allen key



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 ...

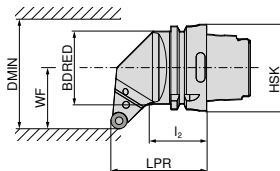
Spare parts for Article no.

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

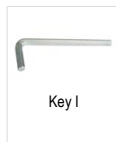
Left-hand

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 ...

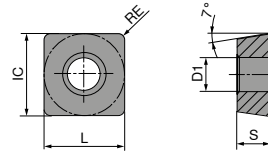
70 950 ...

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

		NEW		NEW		NEW		NEW	
		-CF05 CTEP110	-CF55 CTEP110	-SF TCM10	-SF CTCP115-P	-SF CTCP125-P	-SMF CTCP115-P	-SMF CTCP135-P	
		DRAGONSKIN	DRAGONSKIN		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	
		F CERMET SCGT	F CERMET SCMT	F CERMET SCGT	F SCMT	F SCMT	F SCMT	F SCMT	
		76 261 ...	76 260 ...	70 271 ...	76 187 ...	76 269 ...	76 267 ...	76 267 ...	
ISO	RE mm								
09T304EN	0,4		004						
09T308EN	0,8		006		30601	50401 50601	30401 30601		
120408EN	0,8					51801		71801	
P		●	●	●	●	●	●	●	
M		○	○	○				○	
K		○	○	○	○	○	○		
N									
S									
H									
O									

SCMT

		NEW		NEW		NEW	
		-SM CTCK110	-SM CTCK120	-SM CTCP115-P	-SM CTCP125-P	-SM CTCP135-P	
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	
		M SCMT	M SCMT	M SCMT	M SCMT	M SCMT	
		70 268 ...	70 268 ...	76 268 ...	76 268 ...	76 268 ...	
ISO	RE mm						
09T304EN	0,4		004	504	30401	50401	70401
09T308EN	0,8		006	506	30601	50601	70601
120408EN	0,8		018	518	31801	51801	71801
120412EN	1,2		020	520		52001	
P		○	○	●	●	●	
M							○
K		●	●	○	○		
N							
S							
H							
O							

SCMT

NEW

-M25
CTPM125

DRAGONS

F
SCMT

75 222 ...

-M55
CTCM120

DRAGONS

M
SCMT

75 216 ...

-M55
CTPM125

DRAGONS

M
SCMT

75 216 ...

-M55
CTCM130

DRAGONS

M
SCMT

75 216 ...

ISO	RE mm				
09T304EN	0,4		70400		
09T308EN	0,8			10600	206
120408EN	0,8			11800	218
					30600
					31800

P

M

K

N

S

H

O

○	○	○	○
●	●	●	●
			○

SCGT

-25P
H210T

DRAGONS

F
SCGT

70 283 ...

-25P
CTPX710

DRAGONS

M
SCGT

70 283 ...

-27
CTPX715

DRAGONS

M
SCGT

70 270 ...

-27
H10T

DRAGONS

M
SCGT

70 270 ...

ISO	RE mm				
09T304FN	0,4			80400	600
09T308FN	0,8			80600	602
120408FN	0,8	634	71600	71800	604

P

M

K

N

S

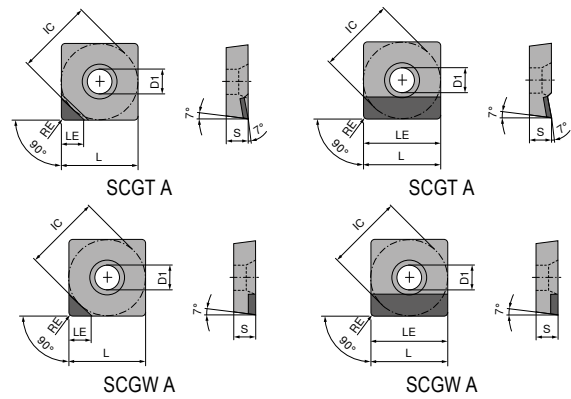
H

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

ISO	RE mm	TCE (NOI)	LE mm					
				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 ...
09T304FN	0,4	A (1)	9,52		10001			
09T304FN	0,4	A (1)	4,40	10001		114	20601	20001
09T308FN	0,8	A (1)	9,52		10101			
09T308FN	0,8	A (1)	4,30	10101		118		20101
09T312FN	1,2	A (1)	4,20	10201				20201
120404FN	0,4	A (1)	12,70		10201			
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			

CTDPS30

F

DIAMOND

SCGT

71 181 ...

-CB2
CTDPS30

M

DIAMOND

SCGT

71 321 ...

-CB3
CTDPU20

R

DIAMOND

SCGT

71 322 ...

214

218

20001

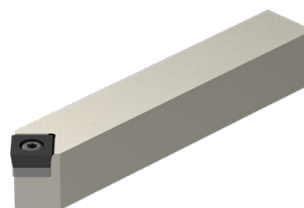
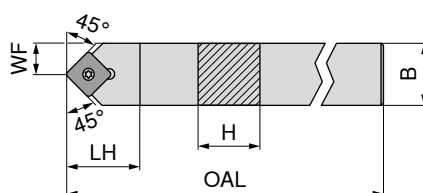
20101

20201

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

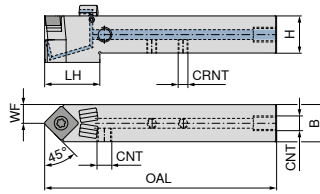
Spare parts for Article no.

	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.

	70 776 01200	70 776 01600	70 776 02000	70 776 11600	70 776 12000	70 776 02500
Clamping screw	87900	87900	87900	820	820	820
Solid Carbide support S		167	167	168	168	168
Grubscrew			88000	88000	88000	88000
Grubscrew				86700	86700	86700
Threaded sleeve						171

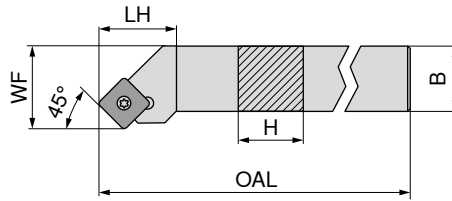
Spare parts for Article no.

	70 776 01200	70 776 01600	70 776 02000	70 776 11600	70 776 12000	70 776 02500
Sealing plugs DC		87600	87600	87600	87600	87600
Key D		120	120	120	120	120
O-Ring			88100	88100	88100	88100
Coolant nozzle DC				87700	87700	87700
Coolant screw plug						294

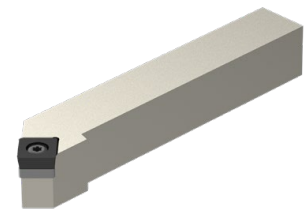
MaxiLock-S – SSSC 45° – Toolholder with screw clamping

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	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..	01200	01201
SSSC R/L 1616 H09	16	16	100	20	20	3,2	SC.. 09T3..	01600	01601
SSSC R/L 2020 K09	20	20	125	20	25	3,2	SC.. 09T3..	02000	02001
SSSC R/L 1616 H12	16	16	100	25	20	5	SC.. 1204..	11600	11601
SSSC R/L 2020 K12	20	20	125	25	25	5	SC.. 1204..	12000	12001
SSSC R/L 2525 M12	25	25	150	25	32	5	SC.. 1204..	12500	12501
SSSC R 3225 P12	32	25	170	25	32	5	SC.. 1204..	13201	

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



Key D

80 950 ...



Clamping screw

70 950 ...

Solid Carbide
support S

70 950 ...



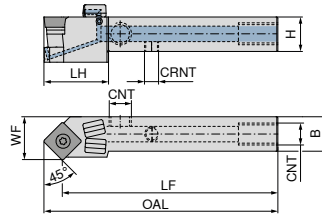
Threaded sleeve

70 950 ...

MaxiLock-S – SSSC 45° 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

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		
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	



Clamping screw

70 950 ...



Solid Carbide support S

70 950 ...



Grubscrew

70 950 ...



Grubscrew

70 950 ...



Threaded sleeve

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

70 950 ...



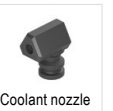
Key D

80 950 ...



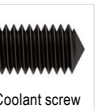
O-Ring

70 950 ...



Coolant nozzle DC

70 950 ...



Coolant screw plug

70 950 ...

Spare parts

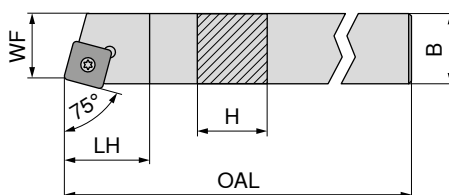
for Article no.

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

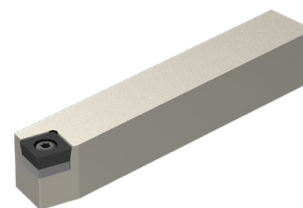
MaxiLock-S – SSBC 75° – Toolholder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions



NEW

Left-hand

70 650 ...

NEW

Right-hand

70 650 ...

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..	12000	12001
SSBC R/L 2525 M12	25	25	150	20	22	5	SC.. 1204..	12500	12501

Spare parts for Article no.

70 650 12001 / 70 650 12000

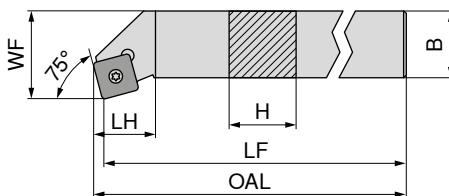
70 650 12501 / 70 650 12500

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

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

70 669 ...

Right-hand

70 668 ...

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..	016	016
SSKC R/L 2020 K09	20	20	125	127,3	22	25	3,2	SC.. 09T3..	020	020
SSKC R 2020 K12	20	20	125	127,3	23	25	5	SC.. 1204..	120	120
SSKC R 2525 M12	25	25	150	153,3	23	32	5	SC.. 1204..	125	125

Spare parts for Article no.

70 668 016 / 70 669 016

70 668 020 / 70 669 020

70 668 120

70 668 125

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

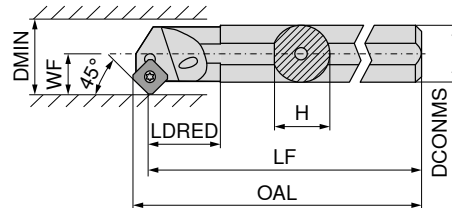
MaxiLock-S – SSSC 45° – Boring bar with screw clamping

▲ A... = with thro' coolant

▲ S... = without thro' coolant

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



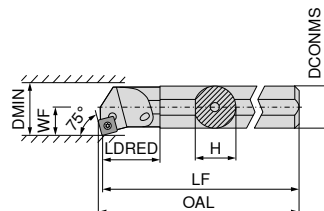
ISO designation	DCONMS mm	H mm	LF mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 721 ...	Right-hand 70 720 ...
S16R SSSC R 09	16	15,00	200	206,0	13,97	11	20	3,2	SC.. 09T3..		016
A16M SSSC R/L 09	16	15,25	150	156,0	29,00	11	20	3,2	SC.. 09T3..	216	216
A20Q SSSC R/L 09	20	19,00	180	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

Spare parts**for Article no.**

	Key D	Combination Key	Clamping screw	Solid Carbide support S	Threaded sleeve
70 720 016	113		110		
70 720 216 / 70 721 216	113		110		
70 720 220 / 70 721 220	113		304		
70 720 225 / 70 721 225	113		304		
70 720 232 / 70 721 232		398	114	168	170
70 720 240 / 70 721 240		398	114	168	170

MaxiLock-S – SSKC 75° – Boring bar with screw clamping**Scope of supply:**

Tool holder with Torx key



Illustrations show right-hand versions



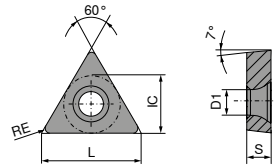
ISO designation	DCONMS mm	H mm	LF mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 725 ...	Right-hand 70 724 ...
A16M SSKC R/L 09	16	15,0	150	152,4	29	11	20	3,2	SC.. 09T3..	216	216
A20Q SSKC R/L 09	20	18,5	180	182,4	32	13	25	3,2	SC.. 09T3..	220	220
A25R SSKC R/L 09	25	23,0	200	202,4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

Spare parts**for Article no.**

	Key D	Clamping screw
70 724 216 / 70 725 216	T15	M3,5x7,2
70 724 220	T15	M3,5x8,6
70 725 220	T15	M3,5x8,6
70 724 225 / 70 725 225	T15	M3,5x8,6

TCGT / TCMT

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



TCGT / TCMT

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

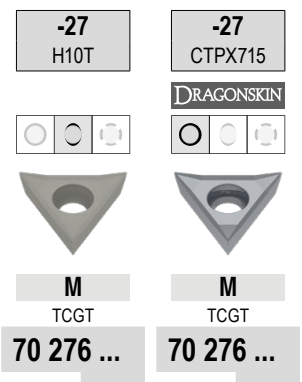
TCGT / TCMT

		NEW		NEW		NEW		NEW		NEW	
		-SM CTCP135-P		-SM CTCK110		-SM CTCK120		-SM CTCP115-P		-SM CTCP115-P	
		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin	
											
											
		M TCGT		M TCMT		M TCMT		M TCMT		M TCMT	
		76 270 ...		70 274 ...		70 274 ...		76 189 ...		76 274 ...	
ISO	RE mm										
090204EN	0,4									50401	70401
110202EN	0,2	71401									
110204EN	0,4			016		516				51601	71601
110208EN	0,8			018		518				51801	71801
16T304EN	0,4			028		528				52801	72801
16T308EN	0,8			030		530				53001	73001
16T312EN	1,2			032		532					
220408EN	0,8							34201		54201	74201
P		●		○		○		●		●	
M		○									
K				●		●		○		○	
N											
S											
H											
O											

TCMT

		-M25 CTCM120		-M25 CTPM125		-M25 CTCM130		-M55 CTCM120		-M55 CTPM125		-M55 CTCM130	
		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin		DRAGONSkin	
													
													
		F TCMT		F TCMT		F TCMT		M TCMT		M TCMT		M TCMT	
		75 217 ...		75 217 ...		75 217 ...		75 218 ...		75 218 ...		75 218 ...	
ISO	RE mm												
090204EN	0,4			20400				10400		204		30400	
110204EN	0,4	11600		216		31600		11600		216		31600	
16T304EN	0,4	12800		228		32800		13000		230		33000	
16T308EN	0,8	13000		230		33000							
P		○		○		○		○		○		○	
M		●		●		●		●		●		●	
K													
N													
S						○						○	
H													
O													

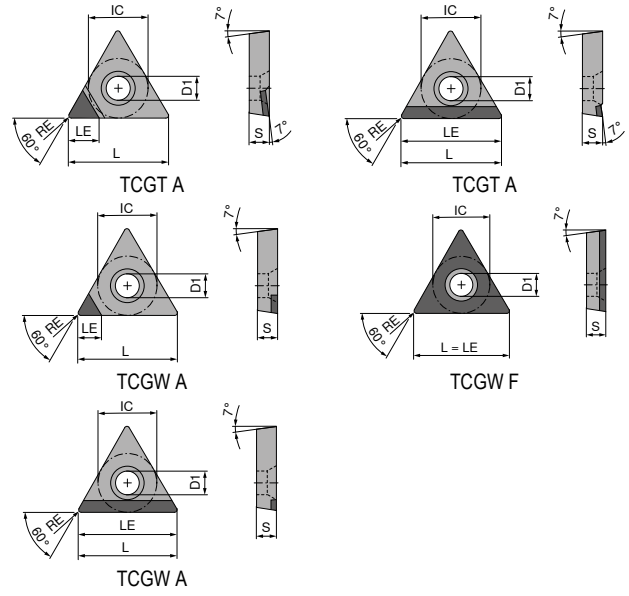
TCGT



ISO	RE mm		
110202FN	0,2		
110204FN	0,4		
16T302FN	0,2		
16T304FN	0,4		
16T308FN	0,8		
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	CTDPD20	CTDPD20	CTDPD20	-CB1 CTDPD20	CTDPS30
				F	F	F	F	F	F
				DIAMOND	DIAMOND	DIAMOND	DIAMOND	DIAMOND	DIAMOND
				TCGW	TCGW	TCGW	TCGT	TCGT	TCGT
				71 188 ...	71 187 ...	71 140 ...	71 184 ...	71 325 ...	71 184 ...
090202FN	0,2	A (1)	3,7			100		112	20001
090204FN	0,4	A (1)	3,4			102		114	20101
090208FN	0,8	A (1)	3,0			104	10001		
090208FN	0,8	A (1)	9,6	10001					
110202FN	0,2	A (1)	3,7			106	10101	122	
110202FN	0,2	F	11,0		10001				
110204FN	0,4	A (1)	3,4			108	10201	124	20201
110204FN	0,4	F	11,0		10101				
110204FN	0,4	A (1)	11,0	10101					
110208FN	0,8	A (1)	3,0			110	10301		
110208FN	0,8	A (1)	11,0	10201					
16T304FN	0,4	A (1)	4,6			112	10401	134	20301
16T304FN	0,4	A (1)	16,5	10301					
16T308FN	0,8	A (1)	4,2			114	10501	13600	
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

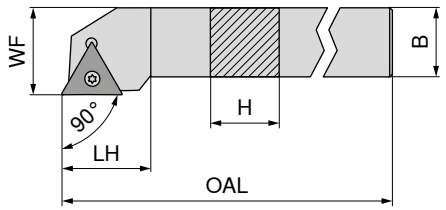
▲ TCE (NOI) = Design and number of equipped cutting edge corners

				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 ...
ISO	RE mm	TCE (NOI)	LE mm	20001	20001	212 214	30001	224	40001
090202FN	0,2	A (1)	3,7						
090204FN	0,4	A (1)	3,4						
090204FN	0,4	A (1)	9,6						
110202FN	0,2	A (1)	2,6						
110202FN	0,2	A (1)	3,7						
110204FN	0,4	A (1)	2,3						
110204FN	0,4	A (1)	3,4						
110204FN	0,4	A (1)	11,0						
110208FN	0,8	A (1)	2,0						
110208FN	0,8	A (1)	11,0						
				20101	20101	222	224	238	40101
16T304FN	0,4	A (1)	2,3						
16T304FN	0,4	A (1)	4,6						
16T304FN	0,4	A (1)	16,5						
16T308FN	0,8	A (1)	2,0						
16T308FN	0,8	A (1)	4,2						
16T308FN	0,8	A (1)	16,5						
P									
M									
K									
N				•	•	•	•	•	•
S									
H									
O				•	•	•	•	•	

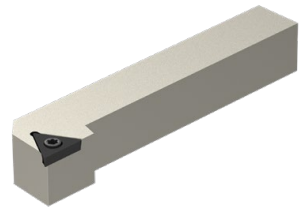
MaxiLock-S – STGC 90° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



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

70 659 ...	70 659 ...
01200	01201
01600	01601
02000	02001
02500	02501

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert
STGC R/L 1212 F11	12	12	80	15	16	1,2	TC.. 1102
STGC R/L 1616 H16	16	16	100	22	20	3,2	TC.. 16T3
STGC R/L 2020 K16	20	20	125	22	25	3,2	TC.. 16T3
STGC R/L 2525 M16	25	25	150	22	32	3,2	TC.. 16T3

Key D	Clamping screw	Solid Carbide Seat T	Threaded sleeve
80 950 ...	70 950 ...	70 950 ...	70 950 ...
039	857		
120	87900	169	171
120	87900	169	171
120	87900	169	171

Spare parts

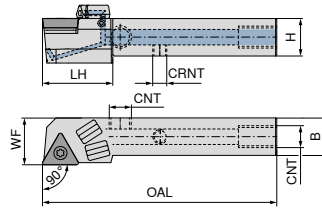
for Article no.

70 659 01201 / 70 659 01200
70 659 01601 / 70 659 01600
70 659 02001 / 70 659 02000
70 659 02501 / 70 659 02500

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

NEW

Right-hand

70 778 ...

70 778 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert		
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	Solid Carbide Seat T	Grubscrew	Grubscrew	Threaded sleeve
70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...

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

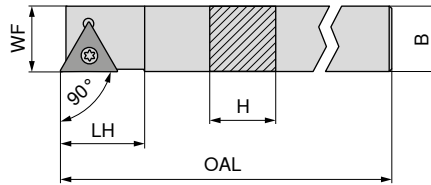
Sealing plugs DC	Key D	O-Ring	Coolant nozzle DC	Coolant screw plug
70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...

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

▲ for sliding head lathes

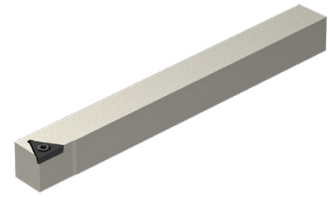
Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

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	70 655 ...	70 655 ...
								01200	01201

**NEW**
Left-hand**NEW**
Right-hand**Spare parts
for Article no.**

70 655 01201 / 70 655 01200

T08 - IP

Key D

80 950 ...

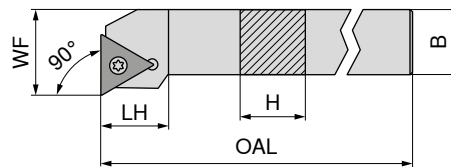
039

Clamping screw

70 950 ...

MaxiLock-S – STFC 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		
STFC R/L 1212 F11	12	12	80	15	16	1,2	TC.. 1102	70 658 ...	70 658 ...
STFC R/L 1616 H16	16	16	100	20	20	3,2	TC.. 16T3	01200	01201
STFC R/L 2020 K16	20	20	125	20	25	3,2	TC.. 16T3	01600	01601
STFC R/L 2525 M16	25	25	150	20	32	3,2	TC.. 16T3	02000	02001
								02500	02501

**Spare parts
for Article no.**

70 658 01200 / 70 658 01201

70 658 01600 / 70 658 01601

70 658 02000 / 70 658 02001

70 658 02500 / 70 658 02501

Key D

80 950 ...

039

Clamping screw

70 950 ...

857

Solid Carbide
Seat T

70 950 ...

169

Threaded sleeve

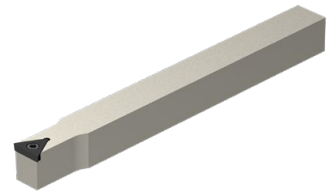
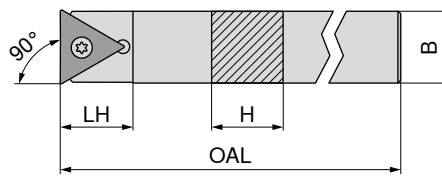
70 950 ...

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



Key D



Clamping screw

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

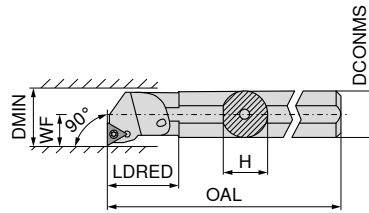
MaxiLock-S – STFC 90° – Boring bar with screw clamping

▲ 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 70 729 ...	Right-hand 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.**

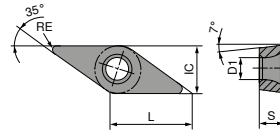
70 728 020	M2,5x6 - T08	13800		
70 729 210 / 70 728 210	M2,2x5	111		
70 728 016	M2,5x6 - T08	13800		
70 729 212 / 70 728 212	M2,5x6 - T08	13800		
70 729 216 / 70 728 216	M2,5x6 - T08	13800		
70 729 220 / 70 728 220	M2,5x6 - T08	13800		
70 729 225 / 70 728 225	M3,5x11	113	169	M3,5 171
70 729 232 / 70 728 232	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.**

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		F		F		F		F		F		F	
		CERMET VCGT		CERMET VCMT		CERMET VCGT		CERMET VCGT		CERMET VCMT		VCMT		VCGT	
		76 276 ...		76 292 ...		70 277 ...		70 277 ...		70 288 ...		76 279 ...		76 277 ...	
ISO	RE mm														
110301EN	0,1														
110302EN	0,2														
110304EN	0,4														
110308EN	0,8														
160404EN	0,4														
160408EN	0,8														
P															
M															
K															
N															
S															
H															
O															

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		F		F		F		F		F		F	
		VCGT		VCMT		VCGT		VCMT		VCMT		VCMT		VCMT	
		76 277 ...		76 279 ...		76 277 ...		76 279 ...		76 288 ...		76 288 ...		76 285 ...	
ISO	RE mm														
110302EN	0,2														
110304EN	0,4														
110308EN	0,8														
160404EN	0,4														
160408EN	0,8														
P															
M															
K															
N															
S															
H															
O															

VCMT

		NEW		NEW		NEW		NEW	
		-SMF	-SM	-SM	-SM	-SM	-SM	-SM	-SM
		CTCP135-P	CTCK110	CTCK120	CTCP115-P	CTCP125-P	CTCP135-P	CTCP135-P	CTCP135-P
		DRAGONS	DRAGONS	DRAGONS	DRAGONS	DRAGONS	DRAGONS	DRAGONS	DRAGONS
		F	M	M	M	M	M	M	M
		VCMT	VCMT	VCMT	VCMT	VCMT	VCMT	VCMT	VCMT
		76 288 ...	70 278 ...	70 278 ...	76 278 ...	76 278 ...	76 278 ...	76 278 ...	76 278 ...
ISO	RE								
	mm								
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									

VCMT

		-M25	-M25	-M25	-M55	-M55	-M55
		CTCM120	CTPM125	CTCM130	CTCM120	CTPM125	CTCM130
		DRAGONS	DRAGONS	DRAGONS	DRAGONS	DRAGONS	DRAGONS
		F	F	F	M	M	M
		VCMT	VCMT	VCMT	VCMT	VCMT	VCMT
		75 219 ...	75 219 ...	75 219 ...	75 220 ...	75 220 ...	75 220 ...
ISO	RE						
	mm						
160404EN	0,4	12800	228	32800	12800	228	32800
160408EN	0,8	13000	23000	33000	13000	230	33000
P		○	○	○	○	○	○
M		●	●	●	●	●	●
K							
N							
S				○			○
H							
O							

9

VCGT

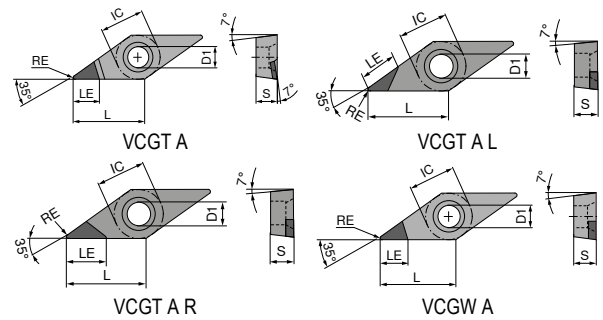
		-25P H210T		-25P CTPX710		-25Q H210T		NEW -25Q CTPX710		-27 H10T		-27 CTPX715	
		F VCGT		M VCGT		M VCGT		M VCGT		M VCGT		M VCGT	
		70 282 ...		70 282 ...		70 282 ...		70 282 ...		70 280 ...		70 280 ...	
ISO	RE mm												
110302FN	0,2	638		71400						606		81400	
110304FL	0,4					670		81600		608		81600	
110304FN	0,4	640		71600		680		81700		610		71800	
110304FR	0,4									612		82800	
110308FN	0,8									614		83000	
160404FN	0,4	642		72800						616			
160408FN	0,8	644		73000									
160412FN	1,2	646		73200									
220530FN	3,0	648		75000						618			
P				●				●				●	
M				●				●				●	
K		○				○				○		○	
N		●		●		●		●		●		●	
S		○		●		○		●				●	
H													
O		○				○				○		○	

VCET / VCMT

		-F05 CTPX710		-29 H216T		NEW -29 CTPX715	
		F VCET		M VCMT		M VCMT	
		76 255 ...		70 247 ...		70 247 ...	
ISO	RE mm						
1103005FN	0,05	11400					
110301FN	0,10	11600					
1103015FN	0,15	11800					
110302FN	0,20	12000					
110304FN	0,40	12200					
160404EN	0,40			62800		72800	
160408EN	0,80			63000		73000	
160412EN	1,20			63200		73200	
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	CTDMD05	CTDPD20	CTDPD20	CTDPD20	CTDPD20
				F	F	F	F	F	F
				DIAMOND	DIAMOND	DIAMOND	DIAMOND	DIAMOND	DIAMOND
				VCGT	VCGW	VCGW	VCGT	VCGT	VCGT
				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		050		10100		
110302FN	0,2	A (1)	4,6	50201		100	100		
110304FN	0,4	A (1)	3,0		052				
110304FN	0,4	A (1)	3,9	50301		102	102		
110304FR	0,4	A (1)	6,5					102	
110304FL	0,4	A (1)	6,5						102
110308FN	0,8	A (1)	3,3			104	104		
110308FR	0,8	A (1)	6,0					104	
110308FL	0,8	A (1)	6,0						104
160401FN	0,1	A (1)	6,0						
160402FN	0,2	A (1)	5,9				10700		
160402FN	0,2	A (1)		50401		105	105		
160404FN	0,4	A (1)	5,5						
160404FN	0,4	A (1)		50501		106	106		
160404FR	0,4	A (1)	7,5					106	
160404FL	0,4	A (1)	7,5						106
160408FN	0,8	A (1)	5,0		07800	108	108		
160408FR	0,8	A (1)	7,0					108	
160408FL	0,8	A (1)	7,0						108
160408FN	0,8	A (1)		50601					
160412FN	1,2	A (1)	4,5			110	110		
160412FR	1,2	A (1)	7,0					110	
160412FL	1,2	A (1)	7,0						110
P									
M									
K									
N				•	•	•	•	•	•
S									
H									
O				•	•	•	•	•	•

VCGT / VCGW

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

				-CB1 CTDPD20   F DIAMOND VCGT 71 330 ...	CTDPS30   F DIAMOND VCGW 71 191 ...	CTDPS30   F DIAMOND VCGT 71 189 ...	-CB1 CTDPS30   F DIAMOND VCGT 71 330 ...	-CB2 CTDPS30   M DIAMOND VCGT 71 331 ...	CTDPU20   F DIAMOND VCGW 71 191 ...		
ISO	RE mm	TCE (NOI)	LE mm								
070201FN	0,1	A (1)	3,8				20001				
070202FN	0,2	A (1)	3,6		20001						
070204FN	0,4	A (1)	3,2		20101						
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

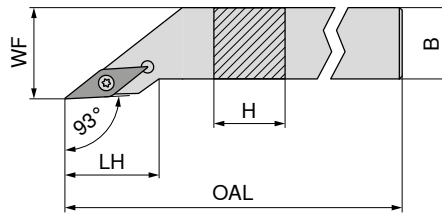
▲ TCE (NOI) = Design and number of equipped cutting edge corners

				-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					
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								

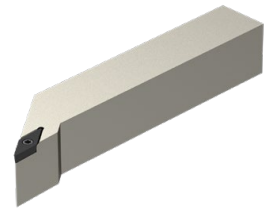
MaxiLock-S – SVJC 93° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



NEW

Left-hand

NEW

Right-hand

70 663 ...

70 663 ...

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	01200	01201
SVJC R/L 1616 H11	16	16	100	21,6	20	1,2	VC.. 1103	01600	01601
SVJC R/L 2020 K11	20	20	125	23,0	25	1,2	VC.. 1103	02000	02001
SVJC R/L 2525 M11	25	25	150	25,5	32	1,2	VC.. 1103	02500	02501
SVJC R/L 2020 K16	20	20	125	29,4	25	3,2	VC.. 1604	12000	12001
SVJC R/L 2525 M16	25	25	150	32,5	32	3,2	VC.. 1604	12500	12501
SVJC R/L 3225 P16	32	25	170	32,5	32	3,2	VC.. 1604	13200	13201

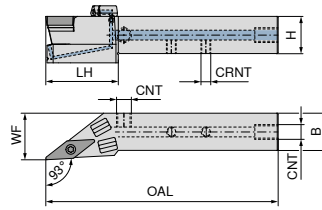
Spare parts for Article no.

	Key D	Clamping screw	Solid Carbide Seat V	Threaded sleeve
70 663 01201 / 70 663 01200	039	857		
70 663 01601 / 70 663 01600	039	857		
70 663 02001 / 70 663 02000	039	857		
70 663 02501 / 70 663 02500	039	857		
70 663 12001 / 70 663 12000	120	87900	107	171
70 663 12501 / 70 663 12500	120	87900	107	171
70 663 13201 / 70 663 13200	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

NEW

Right-hand

70 780 ...

70 780 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert		
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

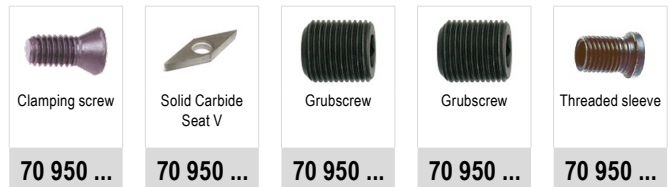
for Article no.

	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
70 780 01200 / 70 780 01201	857			86700	
70 780 01600 / 70 780 01601	857		88000	86700	
70 780 02000 / 70 780 02001	857		88000	86700	
70 780 02500 / 70 780 02501	857		88000	86700	
70 780 12000 / 70 780 12001	87900	107	88000	86700	171
70 780 12500 / 70 780 12501	87900	107	88000	86700	171
70 780 03200 / 70 780 03201	87900	107	88000		171

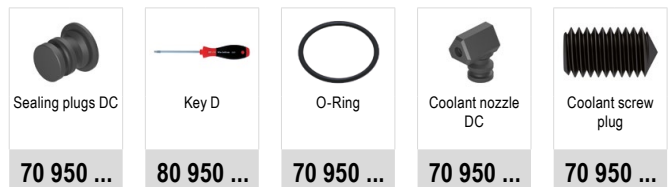
Spare parts

for Article no.

	70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...
70 780 01200 / 70 780 01201		039			
70 780 01600 / 70 780 01601	87600	039	88100	87700	294
70 780 02000 / 70 780 02001	87600	039	88100	87700	294
70 780 02500 / 70 780 02501	87600	039	88100	87700	294
70 780 12000 / 70 780 12001	87600	120	88100	87700	294
70 780 12500 / 70 780 12501	87600	120	88100	87700	294
70 780 03200 / 70 780 03201	87600	120	88100	87700	294



70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
857			86700	
857		88000	86700	
857		88000	86700	
857		88000	86700	
87900	107	88000	86700	171
87900	107	88000	86700	171
87900	107	88000		171

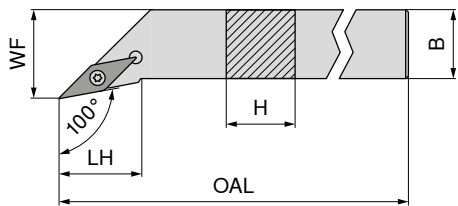


70 950 ...	80 950 ...	70 950 ...	70 950 ...	70 950 ...
	039			
87600	039	88100	87700	294
87600	039	88100	87700	294
87600	039	88100	87700	294
87600	120	88100	87700	294
87600	120	88100	87700	294
87600	120	88100	87700	294

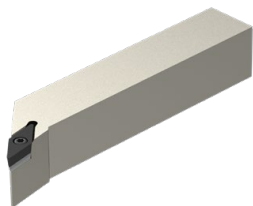
MaxiLock-S – SVZC 100° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



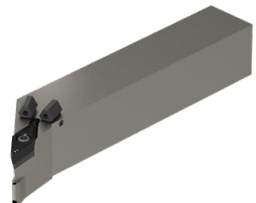
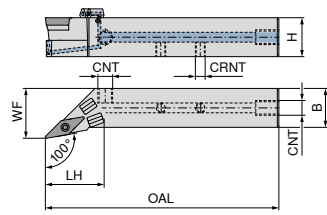
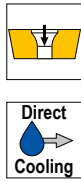
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert		
SVZC R/L 2525 M16	25	25	150	27,3	32	3,2	VC.. 1604		
								NEW Left-hand 70 667 ... 02500	NEW Right-hand 70 667 ... 02501

Spare parts
for Article no.

70 667 02500 / 70 667 02501	T15 - IP	Key D 80 950 ... 120	Clamping screw 70 950 ... 87900	Solid Carbide Seat V 70 950 ... 107	Threaded sleeve 70 950 ... 171
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MaxiLock-S – SVZC 100° 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
70 783 ...	70 783 ...
02501	02500

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		

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

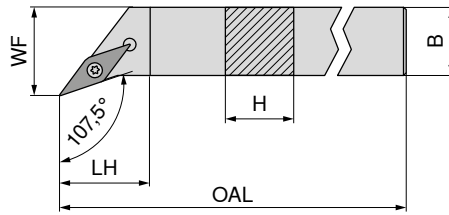
Spare parts
for Article no.
70 783 02500 / 70 783 02501

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

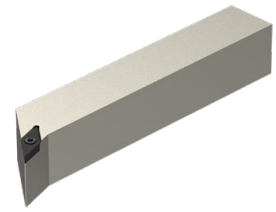
MaxiLock-S – SVHC 107.5° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions



NEW

Left-hand

NEW

Right-hand

70 662 ...

70 662 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert		
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

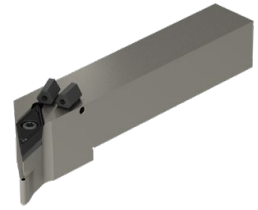
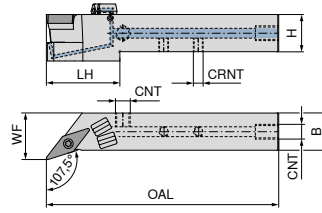
Spare parts for Article no.

	Key D	Clamping screw	Solid Carbide Seat V	Threaded sleeve
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

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		
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.

	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.

	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



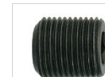
Clamping screw

70 950 ...



Solid Carbide
Seat V

70 950 ...



Grubscrew

70 950 ...



Grubscrew

70 950 ...



Threaded sleeve

70 950 ...



Sealing plugs DC

70 950 ...



Key D

80 950 ...



O-Ring

70 950 ...



Coolant nozzle
DC

70 950 ...



Coolant screw
plug

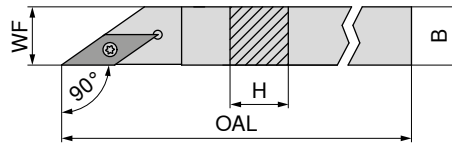
70 950 ...

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

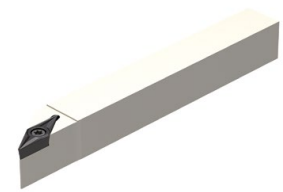
▲ for sliding head lathes

Scope of supply:

Tool holder with Torx key

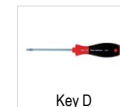


Illustrations show right-hand versions



Left-hand	Right-hand
70 695 ...	70 694 ...
008	008
010	010
012	012

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



Key D



Clamping screw

Spare parts

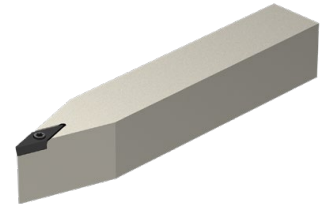
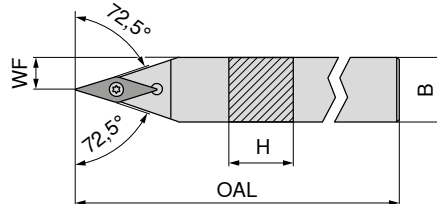
for Article no.

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

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

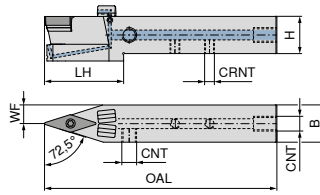


Threaded sleeve

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.

	Clamping screw	Solid Carbide Seat V	Grubscrew	Grubscrew	Threaded sleeve
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.

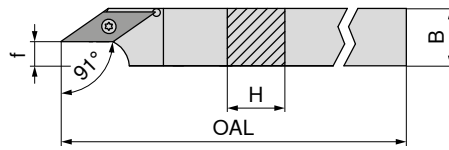
	Sealing plugs DC	Key D	O-Ring	Coolant nozzle DC	Coolant screw plug
70 781 01200		039			
70 781 01600	87600	039	88100	87700	294
70 781 02000	87600	039	88100	87800	294
70 781 02500	87600	039	88100	87700	294
70 781 12000	87600	120	88100	87800	294
70 781 12500	87600	120	88100	87800	294
70 781 03200	87600	120	88100	87700	294

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

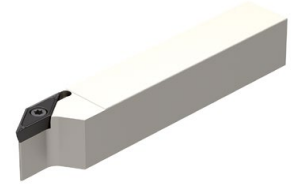
▲ for sliding head lathes

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

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



Key D



Clamping screw

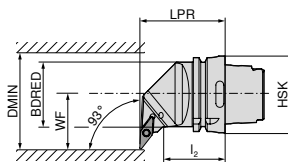
80 950 ...

70 950 ...

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

Scope of supply:

Tool holder with Torx key



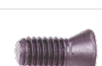
Illustrations show right-hand versions



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



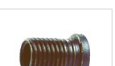
Combination Key



Clamping screw



Solid Carbide
Seat V



Threaded sleeve

70 950 ...

70 950 ...

70 950 ...

70 950 ...

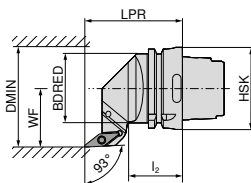
Spare parts for Article no.

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

				
	Combination Key	Clamping screw	Solid Carbide Seat V	Threaded sleeve
	70 950 ...	70 950 ...	70 950 ...	70 950 ...
Spare parts for Article no.				
74 555 516 / 74 556 516	T15/SW 398	M3,5x11 113	107	M3,5 171



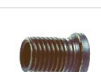
Combination Key



Clamping screw



Solid Carbide Seat V

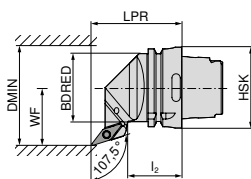


Threaded sleeve

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

				
	Combination Key	Clamping screw	Solid Carbide Seat V	Threaded sleeve
	70 950 ...	70 950 ...	70 950 ...	70 950 ...
Spare parts for Article no.				
74 553 516 / 74 554 516	T15/SW 398	M3.5x11 113	107 M3.5	171



Combination Key



Clamping screw



Solid Carbide Seat V

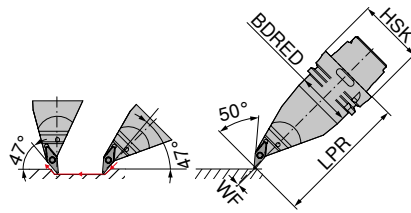


Threaded sleeve

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



Combination Key

70 950 ...



Clamping screw

70 950 ...



Solid Carbide
Seat V

70 950 ...



Threaded sleeve

70 950 ...

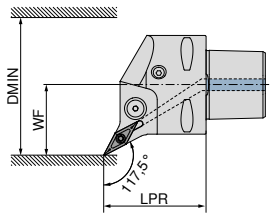
Spare parts for Article no.

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 39.



Clamping screw

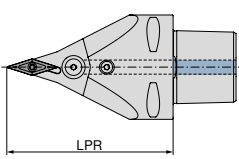
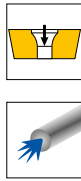
84 950 ...

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 ...
01693
11693

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

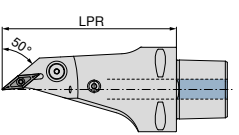
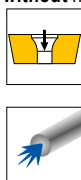
 The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page 39.**


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 ...
11693

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

 The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page 39.**

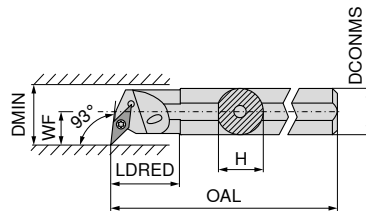

Clamping screw
84 950 ...

Spare parts for Article no.	
84 681 11693	27600

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 70 745 ...	Right-hand 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

Spare parts

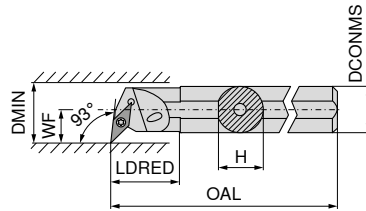
for Article no.

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		398	113	107	171
70 744 240 / 70 745 240		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 – 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

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

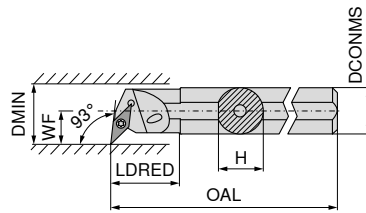
Key D	Clamping screw
80 950 ...	70 950 ...

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	Left-hand 70 747 ...	Right-hand 70 746 ...
E16R SVUC L 11	16	15,0	200	34	11	20	1,2	VC.. 1103	016	
E16R SVUC R 11	16	15,5	200	34	11	20	1,2	VC.. 1103		016
E20S SVUC L 11	20	18,5	250	38	13	25	1,2	VC.. 1103	020	
E20S SVUC R 11	20	19,0	250	38	13	25	1,2	VC.. 1103		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

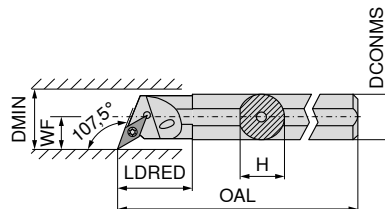
Clamping screw

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	Left-hand 70 749 ...	Right-hand 70 748 ...
A16M SVQC R/L 11	16	15,0	150	29	11	20	1,2	VC.. 1103	216	216
A20Q SVQC R/L 11	20	18,5	180	32	13	25	1,2	VC.. 1103	220	220
A25R SVQC R/L 11	25	23,0	200	36	17	32	1,2	VC.. 1103	225	225
A32S SVQC R/L 16	32	30,0	250	50	22	40	3,2	VC.. 1604	232	232
A40T SVQC R/L 16	40	38,0	300	60	27	50	3,2	VC.. 1604	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 ...

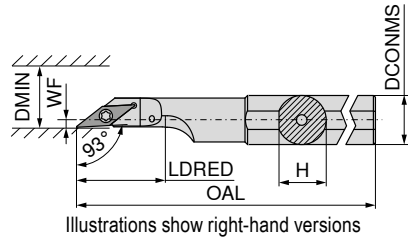
70 950 ...

70 950 ...

70 950 ...

70 950 ...

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



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

Left-hand 70 727 ...	Right-hand 70 726 ...
216	216
220	220
225	225

Spare parts for Article no.

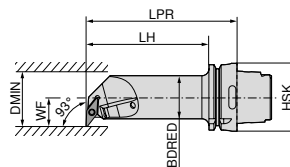
70 727 216 / 70 726 216
70 727 220 / 70 726 220
70 727 225 / 70 726 225

Key D 80 950 ...	Clamping screw 70 950 ...
110	13800
110	13800
113	174

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

Scope of supply:

Boring bar with Torx key



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

Left-hand 74 568 ...	Right-hand 74 567 ...
516	516

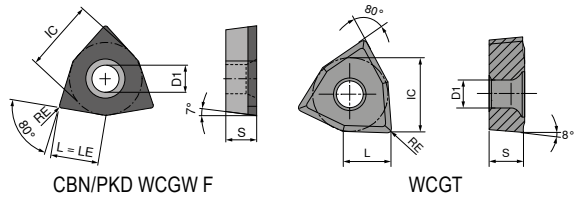
Spare parts for Article no.

74 567 516 / 74 568 516

			
Combination Key	Clamping screw	Solid Carbide Seat V	Threaded sleeve
70 950 ...	70 950 ...	70 950 ...	70 950 ...
T15/SW	M3,5x11	M3,5	
398	113	107	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	-SF H216T
F CERMET WCGT	F WCGT	F 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	○

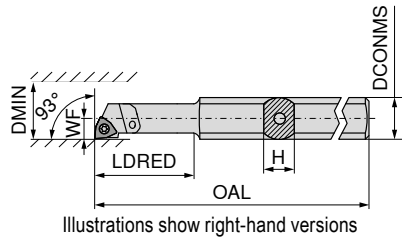
WCGW

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

CTDPD20
F DIAMOND WCGW
71 154 ...

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			●

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



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

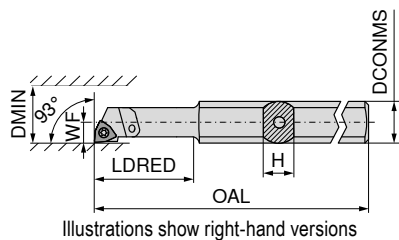
Clamping screw

80 950 ...

70 950 ...

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

▲ with carbide core



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

Clamping screw

80 950 ...

70 950 ...

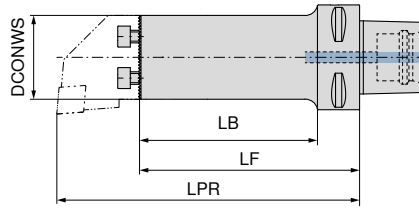
Spare parts
for Article no.

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

Base holders for the exchangeable head system

Scope of supply:

Includes clamping screws



right / left

84 192 ...

Adapter	LPR mm	LF mm	LB mm	DCONWS mm	
PSC 40	90	55	35	25	02595
PSC 40	110	75	55	32	03295
PSC 40	120	80		40	04095
PSC 50	90	55	35	25	02594
PSC 50	110	75	55	32	03294
PSC 50	140	100	80	40	04094
PSC 63	100	65	43	25	02593
PSC 63	125	90	68	32	03293
PSC 63	160	125	103	32	13293
PSC 63	140	100	78	40	04093
PSC 63	180	140	118	40	14093

Clamping Screw

84 950 ...

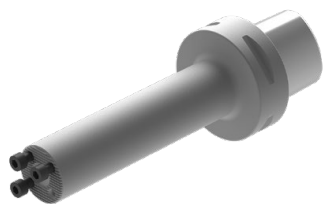
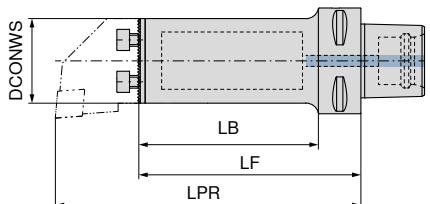
Spare parts for Article no.

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

Base holders for the exchangeable head system – vibration-damped

▲ Heavy metal core reduces vibrations

Scope of supply:
Includes clamping screws



right / left
84 195 ...
02593
03293
04093

Adapter	LPR mm	LF mm	LB mm	DCONWS mm
PSC 63	150	115	93	25
PSC 63	185	150	128	32
PSC 63	225	185	163	40


Clamping Screw
84 950 ...

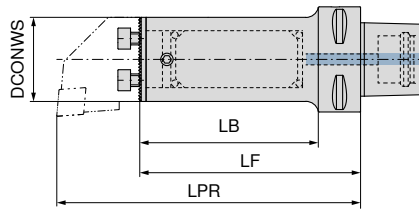
Spare parts for Article no.	
84 195 02593	30000
84 195 03293	29900
84 195 04093	29800

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

right / left

84 198 ...

Adapter	LPR mm	LF mm	LB mm	DCONWS mm	
PSC 40	167	132	112	25	42595 ¹⁾
PSC 40	189	154	134	32	43295 ¹⁾
PSC 40	213	173		40	44095 ¹⁾
PSC 50	168	133	113	25	32594 ¹⁾
PSC 50	215	180	160	25	42594 ¹⁾
PSC 50	189	154	134	32	33294 ¹⁾
PSC 50	259	224	204	32	43294 ¹⁾
PSC 50	234	194	174	40	34094 ¹⁾
PSC 50	328	288	268	40	44094 ¹⁾
PSC 63	167	132	110	25	32593 ¹⁾
PSC 63	215	180	158	25	42593 ¹⁾
PSC 63	265	230	208	25	52593 ¹⁾
PSC 63	194	159	137	32	33293 ¹⁾
PSC 63	259	224	202	32	43293 ¹⁾
PSC 63	323	288	266	32	53293 ¹⁾
PSC 63	238	198	176	40	34093 ¹⁾
PSC 63	328	288	266	40	44093 ¹⁾
PSC 63	408	368	346	40	54093 ¹⁾

1) Not ex-stock



Clamping Screw

84 950 ...

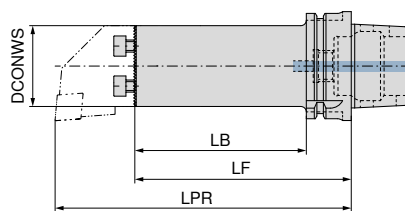
Spare parts for Article no.

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

Base holders for the exchangeable head system

Scope of supply:

Includes clamping screws



right / left

84 193 ...

Adapter	LPR mm	LF mm	LB mm	DCONWS mm	
HSK-T 40	90	55	35	25	02539
HSK-T 40	110	75	55	25	12539
HSK-T 40	115	80	60	32	03239
HSK-T 40	120	80		40	04039
HSK-T 63	105	70	44	25	02537
HSK-T 63	125	90	64	32	03237
HSK-T 63	140	100	74	40	04037
HSK-T 63	160	125	99	32	13237
HSK-T 63	180	140	114	40	14037
HSK-T 100	180	140	111	40	04035



Clamping Screw

84 950 ...Spare parts
for Article no.

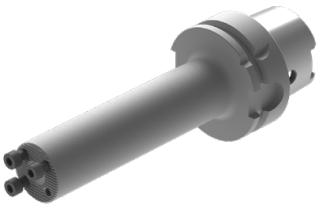
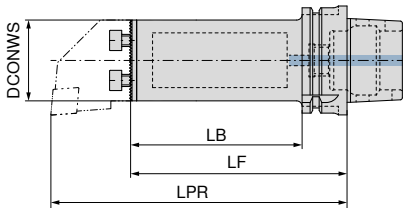
84 193 02539	M4X12 (SW3)	30000
84 193 12539	M4X12 (SW3)	30000
84 193 03239	M5X14 (SW4)	29900
84 193 04039	M6X16 (SW5)	29800
84 193 02537	M4X12 (SW3)	30000
84 193 03237	M5X14 (SW4)	29900
84 193 04037	M6X16 (SW5)	29800
84 193 13237	M5X14 (SW4)	29900
84 193 14037	M6X16 (SW5)	29800
84 193 04035	M6X16 (SW5)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

Base holders for the exchangeable head system – vibration-damped

▲ Heavy metal core reduces vibrations

Scope of supply:

Includes clamping screws



NEW
right / left
84 195 ...
02537
03237
04037

Adapter	LPR mm	LF mm	LB mm	DCONWS mm
HSK-T 63	150	115	89	25
HSK-T 63	185	150	124	32
HSK-T 63	225	185	159	40

Clamping Screw
84 950 ...

Spare parts
for Article no.

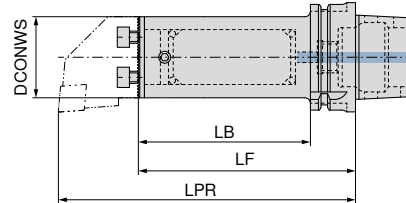
84 195 02537
84 195 03237
84 195 04037

30000
30000
30000

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
right / left
84 198 ...

Adapter	LPR mm	LF mm	LB mm	DCONWS mm	
HSK-T 63	161	126	100	25	32537 ¹⁾
HSK-T 63	186	151	125	25	42537 ¹⁾
HSK-T 63	189	154	128	32	33237 ¹⁾
HSK-T 63	221	186	160	32	43237 ¹⁾
HSK-T 63	226	186	160	40	34037 ¹⁾
HSK-T 63	266	226	200	40	44037 ¹⁾

1) Not ex-stock



Clamping Screw

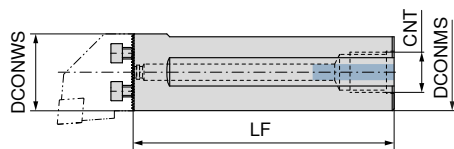
84 950 ...

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

Base holders for the exchangeable head system – cylindrical

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

Scope of supply:
Includes clamping screws



right / left
84 194 ...
02599
03299
04099

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

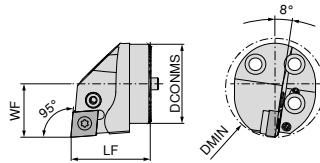


Clamping Screw

Spare parts
for Article no.

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

Exchangeable cutting head PCLN 95°



Illustrations show right-hand versions



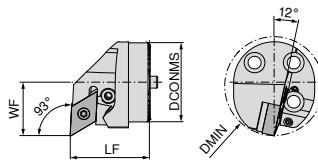
DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert	Left-hand 84 159 ...	Right-hand 84 160 ...
25	35	32	17	5	CN.. 1204	02500	02500
32	35	40	22	5	CN.. 1204	03200	03200
40	40	50	27	5	CN.. 1204	04000	04000

Spare parts for Article no.

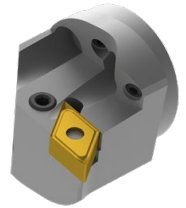
84 160 02500 / 84 159 02500	29200	M8X1/L17 SW3	28700	29000	27800
84 160 03200 / 84 159 03200	29200	M8X1/L17 SW3	28700	29000	27800
84 160 04000 / 84 159 04000	29200	M8X1/L17 SW3	28700	29000	27800

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

Exchangeable cutting head PDUN 93°



Illustrations show right-hand versions



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

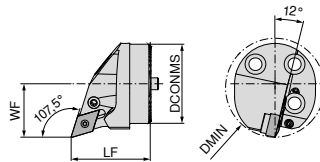
When using DN.. 1504 indexable inserts, use insert seat article no. 84 950 28200.

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

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

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 84 163 ...	Right-hand 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

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



Shim

84 950 ...



Elbow lever screw

84 950 ...



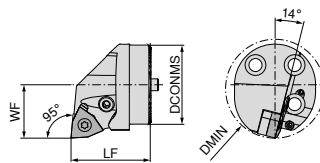
Lever

84 950 ...

Solid Carbide
Seat D

84 950 ...

Exchangeable cutting head PWLN 95°



Illustrations show right-hand versions



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

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



Shim

84 950 ...



Elbow lever screw

84 950 ...



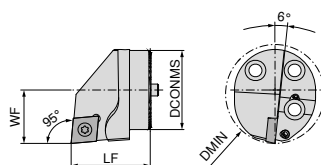
Lever

84 950 ...

Solid Carbide
Seat W

84 950 ...

Exchangeable cutting head SCLC 95°



Illustrations show right-hand versions



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

Left-hand	Right-hand
84 147 ...	84 148 ...
02500	02500
03200	03200
04000	04000

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

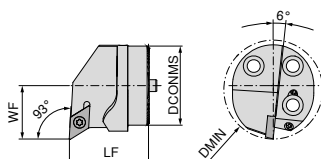
27500



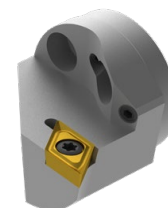
Clamping screw

84 950 ...

Exchangeable cutting head SDUC 93°



Illustrations show right-hand versions



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

Left-hand	Right-hand
84 143 ...	84 144 ...
02500	02500
03200	03200
04000	04000

Spare parts
for Article no.

84 144 02500 / 84 143 02500

27600

84 144 03200 / 84 143 03200

27600

84 144 04000 / 84 143 04000

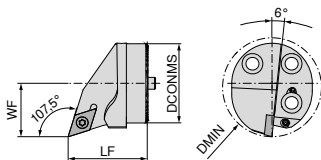
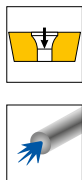
27600



Clamping screw

84 950 ...

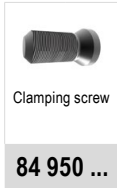
Exchangeable cutting head SDQC 107.5°



Illustrations show right-hand versions



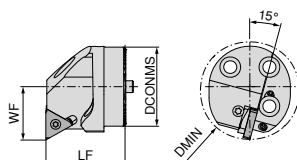
DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert	Left-hand	Right-hand
						84 145 ...	84 146 ...
25	35	32	17	3	DC.. 11T3	02500	02500
32	35	40	22	3	DC.. 11T3	03200	03200
40	40	50	27	3	DC.. 11T3	04000	04000



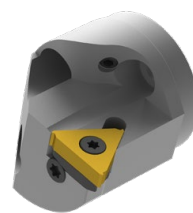
Clamping screw

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

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 6-31**

Shim



Screw-U



Clamping screw

Spare parts
for Article no.

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

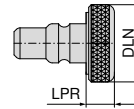


Designation	BD mm	CND mm	OAL mm	
MU.KSS-DN3-150	6,0	3	150	11005
MU.KSS-DN3-250	6,0	3	250	11006
MU.KSS-DN5-200	9,5	5	200	11001
MU.KSS-DN5-300	9,5	5	300	11002
MU.KSS-DN5-400	9,5	5	400	11003
MU.KSS-DN5-500	9,5	5	500	11004

72 990 ...

Sealing plugs

- ▲ for closing off the quick-coupler to protect against contamination

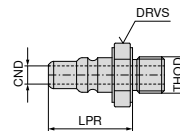


Designation	LPR mm	DLN mm	
MU.KSVS	5,5	15,5	17001

72 994 ...

Coupler connector

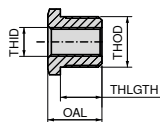
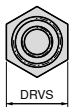
- ▲ pressure-resistant up to at least 400 bar



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 ...

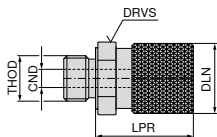
G1/8" screw plug

- ▲ Max. 200 bar/2900 psi
- ▲ No sealing ring required



Quick-coupler

- ▲ pressure-resistant up to at least 400 bar
- ▲ rapid change of coolant distribution without screws thanks to click system



THOD	BD mm	DLN mm	LPR mm	CND mm	DRVS mm	
G1/8"	16	15,5	21,5	4	14	15001

72 993 ...

Designation	THSZMS	
VS.G1/8	G1/8"	010

72 950 ...

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

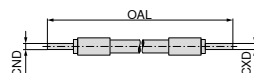


72 305 ...			
Designation	THSZMS	CXD mm	OAL mm
HDKS.150.M5-4	M5	4	150
HDKS.200.M5-4	M5	4	200
HDKS.300.M5-4	M5	4	300
HDKS.500.M5-4	M5	4	500

010
021
033
045

Hose (connecting piece / connecting piece)

- ▲ Max. 200 bar/2900 psi

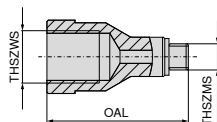


72 305 ...			
Designation	CND mm	CXD mm	OAL mm
HDKS.150.4-4	4	4	150
HDKS.200.4-4	4	4	200
HDKS.300.4-4	4	4	300
HDKS.500.4-4	4	4	500

003
014
025
037

Reducer fitting

- ▲ Max. 200 bar/2900 psi
- ▲ Includes sealing ring

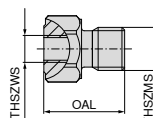


72 301 ...			
Designation	THSZWS	THSZMS	OAL mm
RV.100.M5-M6	M6	M5	15
RV.100.M5-M8x1	M8x1	M5	23
RV.100.M5-M10x1	M10x1	M5	27
RV.100.M5-G1/8	G1/8"	M5	27

001
003
005
004

Reducer fitting

- ▲ Max. 200 bar/2900 psi
- ▲ No sealing ring required

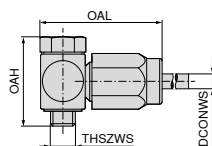


72 301 ...			
Designation	THSZWS	THSZMS	OAL mm
RV.100.M6-M5	M5	M6	18
RV.100.M8x1-M5	M5	M8x1	15
RV.100.M10x1-M5	M5	M10x1	15
RV.100.G1/8-M5	M5	G1/8"	15

002
008
007
006

Swivel fitting

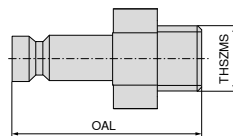
▲ Max. 200 bar/2900 psi



72 307 ...				
Designation	DCONWS mm	OAH mm	THSZMS	OAL mm
KA.SV.M5-4	4	21	M5	28
KA.SV.G1/8-4	4	30	G1/8"	37
				017
				012

Quick connection (connector)

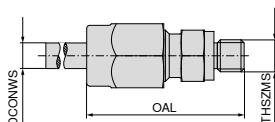
▲ Max. 200 bar/2900 psi
▲ No sealing ring required



72 320 ...		
Designation	THSZMS	OAL mm
SAG.M5	M5	20
		001

Straight fitting

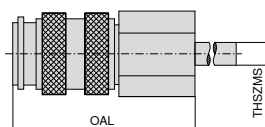
▲ Max. 200 bar/2900 psi



72 307 ...			
Designation	DCONWS mm	THSZMS	OAL mm
KA. M5-4	4	M5	27
KA. G1/8-4	4	G1/8"	32
			009
			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		Tempered	840 N/mm ² / 250 HB	1.1191	C45E	1.0535	C55
		P.1.4	< 0,75 % C	Annealed	910 N/mm ² / 270 HB	1.1223	C60R	1.0535	C55
		P.1.5		Tempered	1010 N/mm ² / 300 HB	1.1223	C60R	1.0727	45S20
	Low-alloy steel	P.2.1		Annealed	610 N/mm ² / 180 HB	1.7131	16MnCr5	1.6587	17CrNiMo6
		P.2.2		Tempered	930 N/mm ² / 275 HB	1.7131	16MnCr5	1.6587	17CrNiMo6
		P.2.3		Tempered	1010 N/mm ² / 300 HB	1.7225	42CrMo4	1.3505	100Cr6
		P.2.4		Tempered	1200 N/mm ² / 375 HB	1.7225	42CrMo4	1.3505	100Cr6
	High-alloy steel and high-alloy tool steel	P.3.1		Annealed	680 N/mm ² / 200 HB	1.4021	X20Cr13	1.4034	X46Cr13
		P.3.2		Hardened and tempered	1100 N/mm ² / 300 HB	1.2343	X38CrMoV5-1	1.4034	X46Cr13
		P.3.3		Hardened and tempered	1300 N/mm ² / 400 HB	1.2343	X38CrMoV5-1	1.4034	X46Cr13
	Stainless steel	P.4.1	Ferritic / martensitic	Annealed	680 N/mm ² / 200 HB	1.4016	X6Cr17	1.2316	X36CrMo16
		P.4.2	Martensitic	Tempered	1010 N/mm ² / 300 HB	1.4112	X90CrMoV18	1.2316	X36CrMo16
M	Stainless steel	M.1.1	Austenitic / austenitic-ferritic	Quenched	610 N/mm ² / 180 HB	1.4301	X5CrNi18-10	1.4571	X6CrNiMoTi17-12-2
		M.2.1	Austenitic	Tempered	300 HB	1.4841	X15CrNiSi25-21	1.4539	X1NiCrMoCu25-20-5
		M.3.1	Austenitic / ferritic (Duplex)		780 N/mm ² / 230 HB	1.4462	X2CrNiMoN22-5-3	1.4501	X2CrNiMoCuWN25-7-4
K	Grey cast iron	K.1.1	Pearlitic / ferritic		350 N/mm ² / 180 HB	0.6010	GG-10	0.6025	GG-25
		K.1.2	Pearlitic (martensitic)		500 N/mm ² / 260 HB	0.6030	GG-30	0.6045	GG-45
	Spherulitic graphite cast iron	K.2.1	Ferritic		540 N/mm ² / 160 HB	0.7040	GGG-40	0.7060	GGG-60
		K.2.2	Pearlitic		845 N/mm ² / 250 HB	0.7070	GGG-70	0.7080	GGG-80
	Malleable iron	K.3.1	Ferritic		440 N/mm ² / 130 HB	0.8035	GTW-35-04	0.8045	GTW-45
		K.3.2	Pearlitic		780 N/mm ² / 230 HB	0.8165	GTS-65-02	0.8170	GTS-70-02
N	Aluminium wrought alloy	N.1.1	Non-hardenable		60 HB	3.0255	Al99,5	3.3315	AlMg1
		N.1.2	Hardenable	Age-hardened	340 N/mm ² / 100 HB	3.1355	AlCuMg2	3.2315	AlMgSi1
	Cast aluminium alloy	N.2.1	≤ 12 % Si, non-hardenable		250 N/mm ² / 75 HB	3.2581	G-AlSi12	3.2163	G-AlSi9Cu3
		N.2.2	≤ 12 % Si, hardenable	Age-hardened	300 N/mm ² / 90 HB	3.2134	G-AlSi5Cu1Mg	3.2373	G-AlSi9Mg
		N.2.3	> 12 % Si, non-hardenable		440 N/mm ² / 130 HB		G-AlSi17Cu4Mg		G-AlSi18CuNiMg
	Copper and copper alloys (bronze/brass)	N.3.1	Free-machining alloys, PB > 1 %		375 N/mm ² / 110 HB	2.0380	CuZn39Pb2 (Ms58)	2.0410	CuZn44Pb2
		N.3.2	CuZn, CuSnZn		300 N/mm ² / 90 HB	2.0331	CuZn15	2.4070	CuZn28Sn1As
		N.3.3	CuSn, lead-free copper and electrolytic copper		340 N/mm ² / 100 HB	2.0060	E-Cu57	2.0590	CuZn40Fe
	Magnesium alloys	N.4.1	Magnesium and magnesium alloys		70 HB	3.5612	MgAl6Zn	3.5312	MgAl3Zn
S	Heat-resistant alloys	S.1.1	Fe - basis	Annealed	680 N/mm ² / 200 HB	1.4864	X12NiCrSi 36-16	1.4865	G-X40NiCrSi38-18
		S.1.2		Age-hardened	950 N/mm ² / 280 HB	1.4980	X6NiCrTiMoVB25-15-2	1.4876	X10NiCrAlTi32-20
		S.2.1	Ni or Co basis	Annealed	840 N/mm ² / 250 HB	2.4631	NiCr20TiAl (Nimonic80A)	3.4856	NiCr22Mo9Nb
		S.2.2		Age-hardened	1180 N/mm ² / 350 HB	2.4668	NiCr19Nb5Mo3 (Inconel 718)	2.4955	NiFe25Cr20NbTi
		S.2.3		Cast	1080 N/mm ² / 320 HB	2.4765	CoCr20W15Ni	1.3401	G-X120Mn12
	Titanium alloys	S.3.1	Pure titanium		400 N/mm ²	3.7025	Ti99,8	3.7034	Ti99,7
		S.3.2	Alpha + beta alloys	Age-hardened	1050 N/mm ² / 320 HB	3.7165	TiAl6V4	Ti-6246	Ti-6Al-2Sn-4Zr-6Mo
		S.3.3	Beta alloys		1400 N/mm ² / 410 HB	Ti555.3	Ti-5Al-5V-5Mo-3Cr	R56410	Ti-10V-2Fe-3Al
H	Hardened steel	H.1.1		Hardened and tempered	46–55 HRC				
		H.1.2		Hardened and tempered	56–60 HRC				
		H.1.3		Hardened and tempered	61–65 HRC				
		H.1.4		Hardened and tempered	66–70 HRC				
	Chilled iron	H.2.1		Cast	400 HB				
	Hardened cast iron	H.3.1		Hardened and tempered	55 HRC				
O	Non-metal materials	O.1.1	Plastics, duroplastic		≤ 150 N/mm ²				
		O.1.2	Plastics, thermoplastic		≤ 100 N/mm ²				
		O.2.1	Aramid fibre-reinforced		≤ 1000 N/mm ²				
		O.2.2	Glass/carbon-fibre reinforced		≤ 1000 N/mm ²				
		O.3.1	Graphite						

* Tensile strength

Cutting data standard values

Index	DRAGONSKIN																H210T	H10T H216T
	TCM407	TCM10	CTEP110	CTCP115-P	CTCP125-P	CTCP135-P	CTCK110	CTCK120	CTPM125	CTCM120	CTCM130	CTPX710 -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. $\pm 20\%$ according to the usage conditions.

Cutting data standard values for diamond cutting materials CTD PD20 / PS30 / PU20 / CD10 / MD05

Index	Material group			$a_p = 0,04\text{--}0,4\text{ mm}$		$a_p = 0,4\text{--}1,0\text{ mm}$		$a_p = 0,4\text{--}2,5\text{ mm}$	
				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 $f=0.05\text{--}0.5\text{ mm/rev.}$		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 Si≤12 % – hardened or Si=12–20% – non hardened $f=0.05\text{--}0,5\text{ mm/rev.}$		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	
N.2.2 N.2.3	Aluminium cast alloys Si=12–20 % $f=0.05\text{--}0.5\text{ mm/rev.}$		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 $f=0.05\text{--}0.5\text{ mm/rev.}$		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) $f=0.05\text{--}0.7\text{ mm/rev.}$		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) $f=0.05\text{--}0.7\text{ mm/rev.}$		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



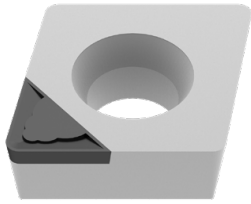
Irregular cutting depth



Interrupted cut

Cutting data standard values for the CB chip breaker geometries

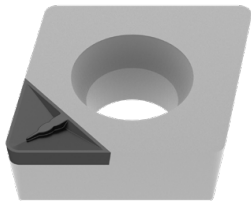
-CB1



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

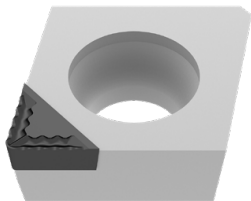
-CB2



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	-TFQ						-XU						-M50					
	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	0,10	0,15	0,35	0,4	1,0	3,0	0,08	0,15	0,25	0,3	1,5	2,5	0,10	0,20	0,30	0,4	2,0	5,0
CN.. 120408	0,10	0,25	0,50	0,5	1,5	4,0	0,13	0,25	0,35	0,6	2,0	3,0	0,15	0,25	0,40	0,6	2,0	5,0
CN.. 120412	0,15	0,30	0,70	0,8	2,0	5,0	0,15	0,30	0,45	0,9	2,0	3,5	0,20	0,30	0,50	1,0	2,0	5,0
CN.. 120416													0,25	0,40	0,60	1,4	2,0	5,0
CN.. 160608													0,15	0,25	0,40	0,6	3,0	8,0
CN.. 160612													0,20	0,30	0,50	1,0	3,0	8,0
CN.. 160616													0,25	0,40	0,60	1,4	3,0	8,0
CN.. 160624																		
CN.. 190608																		
CN.. 190612																		
CN.. 190616																		
CN.. 190624																		
CN.. 250924																		
DN.. 110402																		
DN.. 110404													0,10	0,20	0,30	0,4	1,5	4,0
DN.. 110408													0,15	0,25	0,40	0,6	1,5	4,0
DN.. 110412													0,20	0,30	0,50	1,0	1,5	4,0
DN.. 150404													0,10	0,20	0,30	0,4	2,0	5,0
DN.. 150408													0,15	0,25	0,40	0,6	2,0	5,0
DN.. 150412													0,20	0,30	0,50	1,0	2,0	5,0
DN.. 150416													0,25	0,40	0,60	1,4	2,0	5,0
DN.. 150604	0,10	0,15	0,30	0,4	1,0	3,0	0,08	0,15	0,25	0,3	1,5	2,5	0,10	0,20	0,30	0,4	2,0	5,0
DN.. 150608	0,10	0,25	0,40	0,5	1,5	4,0	0,13	0,25	0,35	0,6	2,0	3,0	0,15	0,25	0,40	0,6	2,0	5,0
DN.. 150612							0,15	0,25	0,40	0,9	2,0	3,5	0,20	0,30	0,50	1,0	2,0	5,0
DN.. 150616													0,25	0,40	0,60	1,4	2,0	5,0
SN.. 090308																		
SN.. 120404																		
SN.. 120408													0,15	0,25	0,40	0,6	2,0	5,0
SN.. 120412													0,20	0,30	0,50	1,0	2,0	5,0
SN.. 120416													0,25	0,40	0,60	1,4	2,0	5,0
SN.. 150608													0,15	0,25	0,40	0,6	3,0	8,0
SN.. 150612													0,20	0,30	0,50	1,0	3,0	8,0
SN.. 150616													0,25	0,40	0,60	1,4	3,0	8,0
SN.. 190612																		
SN.. 190616																		
SN.. 190624																		
SN.. 250724																		
SN.. 250924																		
TN.. 110304																		
TN.. 110308																		
TN.. 160404													0,10	0,20	0,30	0,4	2,0	5,0
TN.. 160408													0,15	0,25	0,40	0,6	2,0	5,0
TN.. 160412													0,20	0,30	0,50	1,0	2,0	5,0
TN.. 220404																		
TN.. 220408													0,15	0,25	0,40	0,6	3,0	8,0
TN.. 220412													0,20	0,30	0,50	1,0	3,0	8,0
TN.. 220416																		
VN.. 160404							0,08	0,15	0,20	0,3	1,0	1,8	0,10	0,20	0,30	0,4	1,0	4,0
VN.. 160408							0,13	0,20	0,30	0,6	1,5	2,5	0,15	0,25	0,40	0,6	1,0	4,0
VN.. 160412													0,20	0,30	0,50	1,0	1,0	4,0
WN.. 060404	0,10	0,18	0,35	0,4	0,8	3,0							0,10	0,20	0,30	0,4	1,0	3,0
WN.. 060408	0,10	0,20	0,50	0,5	1,5	3,0							0,15	0,25	0,40	0,6	1,0	3,0
WN.. 060412													0,20	0,30	0,50	1,0	1,0	3,0
WN.. 080404							0,08	0,15	0,25	0,3	1,5	2,5	0,10	0,20	0,30	0,4	1,5	4,0
WN.. 080408	0,10	0,25	0,50	0,5	1,5	4,0	0,13	0,22	0,35	0,6	2,0	3,0	0,15	0,25	0,40	0,6	1,5	4,0
WN.. 080412	0,15	0,30	0,70	0,8	2,0	5,0	0,15	0,25	0,45	0,9	2,0	3,5	0,20	0,30	0,50	1,0	1,5	4,0
WN.. 080416													0,25	0,40	0,60	1,4	1,5	4,0

sharp stable



Information on the cutting data of chip breakers not included in this overview, can be found on → Page 201–207

Cutting data standard values for negative inserts

Designation	-TMQ						-M70					
	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												
CN.. 090308												
CN.. 120404												
CN.. 120408	0,20	0,40	0,65	0,8	3,0	5,0	0,20	0,30	0,45	0,8	3,0	6,0
CN.. 120412	0,25	0,50	0,85	1,0	3,0	6,0	0,25	0,40	0,60	1,2	3,0	6,0
CN.. 120416							0,30	0,45	0,70	1,6	3,0	6,0
CN.. 160608							0,20	0,30	0,45	0,8	4,0	8,0
CN.. 160612							0,25	0,40	0,60	1,2	4,0	8,0
CN.. 160616							0,30	0,45	0,70	1,6	4,0	8,0
CN.. 160624							0,40	0,70	1,20	2,4	4,0	8,0
CN.. 190608							0,20	0,30	0,45	0,8	4,5	9,0
CN.. 190612							0,25	0,40	0,60	1,2	4,5	9,0
CN.. 190616							0,30	0,45	0,70	1,6	4,5	9,0
CN.. 190624							0,40	0,70	1,20	2,4	4,5	9,0
CN.. 250924							0,40	0,70	1,20	2,4	6,0	13,0
DN.. 110402												
DN.. 110404												
DN.. 110408							0,20	0,25	0,45	0,8	2,0	5,0
DN.. 110412							0,25	0,35	0,60	1,2	2,0	5,0
DN.. 150404												
DN.. 150408							0,20	0,25	0,45	0,8	2,5	6,0
DN.. 150412							0,25	0,35	0,60	1,2	2,5	6,0
DN.. 150416							0,30	0,40	0,70	1,6	2,5	6,0
DN.. 150604												
DN.. 150608	0,15	0,30	0,50	0,8	2,5	5,0	0,20	0,25	0,45	0,8	2,5	6,0
DN.. 150612	0,20	0,40	0,60	1,0	3,0	5,0	0,25	0,35	0,60	1,2	2,5	6,0
DN.. 150616							0,30	0,40	0,70	1,6	2,5	6,0
SN.. 090308												
SN.. 120404												
SN.. 120408							0,20	0,30	0,50	0,8	3,0	6,0
SN.. 120412							0,25	0,40	0,65	1,2	3,0	6,0
SN.. 120416							0,30	0,45	0,70	1,6	3,0	6,0
SN.. 150608												
SN.. 150612							0,25	0,40	0,65	1,2	4,0	8,0
SN.. 150616							0,30	0,45	0,75	1,6	4,0	8,0
SN.. 190612							0,25	0,40	0,65	1,2	4,5	9,0
SN.. 190616							0,30	0,45	0,75	1,6	4,5	9,0
SN.. 190624							0,40	0,70	1,20	2,4	4,5	9,0
SN.. 250724												
SN.. 250924							0,40	0,70	1,20	2,4	6,0	13,0
TN.. 110304												
TN.. 110308												
TN.. 160404												
TN.. 160408							0,20	0,25	0,45	0,8	2,5	6,0
TN.. 160412							0,25	0,35	0,60	1,2	2,5	6,0
TN.. 220404							0,15	0,20	0,30	0,4	3,0	7,0
TN.. 220408							0,20	0,25	0,45	0,8	3,0	7,0
TN.. 220412							0,25	0,35	0,60	1,2	3,0	7,0
TN.. 220416							0,30	0,40	0,70	1,6	3,0	7,0
VN.. 160404												
VN.. 160408												
VN.. 160412												
WN.. 060404												
WN.. 060408							0,20	0,30	0,45	0,8	2,0	4,0
WN.. 060412							0,25	0,40	0,60	1,2	2,0	4,0
WN.. 080404												
WN.. 080408	0,20	0,30	0,65	0,8	3,0	5,0	0,20	0,30	0,45	0,8	2,5	5,0
WN.. 080412	0,25	0,40	0,85	1,0	3,0	6,0	0,25	0,40	0,60	1,2	2,5	5,0
WN.. 080416							0,30	0,45	0,70	1,6	2,5	5,0

sharp → stable



The data shows reference values. An adjustment to the actual conditions may be required.

Designation	-R28						-R58						-R88					
	f			a _p			f			a _p			f			a _p		
	min.	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							0,45	0,80	1,30	2,5	8,0	16,0	0,60	1,00	1,50	3,5	10,0	18,0
DN.. 110402																		
DN.. 110404																		
DN.. 110408																		
DN.. 110412																		
DN.. 150404																		
DN.. 150408																		
DN.. 150412																		
DN.. 150416																		
DN.. 150604																		
DN.. 150608																		
DN.. 150612	0,25	0,45	0,70	1,0	2,5	6,0	0,30	0,50	0,80	1,5	2,5	6,0						
DN.. 150616	0,30	0,60	0,85	1,5	2,5	6,0	0,35	0,60	0,90	2,0	2,5	6,0						
SN.. 090308																		
SN.. 120404																		
SN.. 120408							0,25	0,45	0,70	1,0	3,0	7,0						
SN.. 120412							0,30	0,55	0,85	1,5	3,0	7,0						
SN.. 120416																		
SN.. 150608																		
SN.. 150612	0,30	0,35	0,70	1,0	4,0	9,0	0,30	0,55	0,85	1,5	4,0	9,0						
SN.. 150616	0,35	0,60	0,90	1,5	4,0	9,0	0,35	0,65	1,00	2,0	4,0	9,0						
SN.. 190612							0,35	0,55	0,85	1,5	5,5	12,0						
SN.. 190616	0,35	0,60	0,90	1,5	5,5	12,0	0,40	0,65	1,00	2,0	5,5	12,0	0,40	0,70	1,00	2,0	5,0	12,0
SN.. 190624							0,40	0,75	1,20	2,0	5,5	12,0	0,40	0,70	1,20	2,0	5,0	12,0
SN.. 250724	0,35	0,65	1,00	2,0	7,0	16,0	0,45	0,80	1,30	2,5	8,0	16,0	0,60	1,00	1,50	3,5	10,0	18,0
SN.. 250924	0,35	0,65	1,00	2,0	7,0	16,0	0,45	0,80	1,30	2,5	8,0	16,0	0,60	1,00	1,50	3,5	10,0	18,0
TN.. 110304																		
TN.. 110308																		
TN.. 160404																		
TN.. 160408																		
TN.. 160412																		
TN.. 220404																		
TN.. 220408																		
TN.. 220412							0,30	0,50	0,80	1,5	3,0	7,0						
TN.. 220416	0,30	0,55	0,85	1,5	3,0	7,0												
VN.. 160404																		
VN.. 160408																		
VN.. 160412																		
WN.. 060404																		
WN.. 060408																		
WN.. 060412																		
WN.. 080404																		
WN.. 080408																		
WN.. 080412																		
WN.. 080416																		

sharp stable



Information on the cutting data of chip breakers not included in this overview, can be found on → Page 201–207

Cutting data standard values for negative inserts

Designation	-F30						-M30					
	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												
CN.. 090308												
CN.. 120404	0,05	0,15	0,25	0,4	1,0	2,0						
CN.. 120408	0,10	0,22	0,35	0,8	1,5	2,5	0,15	0,25	0,40	1,0	2,0	4,5
CN.. 120412							0,20	0,30	0,50	1,2	2,5	5,0
CN.. 120416							0,25	0,35	0,55	1,6	2,5	5,0
CN.. 160608												
CN.. 160612												
CN.. 160616												
CN.. 160624												
CN.. 190608												
CN.. 190612												
CN.. 190616												
CN.. 190624												
CN.. 250924												
DN.. 110402												
DN.. 110404	0,05	0,15	0,25	0,4	1,0	2,0						
DN.. 110408	0,10	0,20	0,35	0,8	1,5	2,5	0,15	0,25	0,40	1,0	2,0	4,5
DN.. 110412							0,20	0,30	0,50	1,2	2,0	4,5
DN.. 150404												
DN.. 150408												
DN.. 150412												
DN.. 150416												
DN.. 150604	0,05	0,15	0,25	0,4	1,0	2,0						
DN.. 150608	0,10	0,20	0,35	0,8	1,5	2,5	0,15	0,25	0,40	1,0	2,0	5,5
DN.. 150612							0,20	0,30	0,50	1,2	2,0	5,5
DN.. 150616												
SN.. 090308												
SN.. 120404	0,10	0,15	0,30	0,4	1,0	2,0						
SN.. 120408	0,15	0,20	0,40	0,8	1,5	2,5	0,20	0,25	0,45	1,0	2,0	4,5
SN.. 120412	0,15	0,20	0,40	1,2	1,8	2,5	0,25	0,30	0,50	1,2	2,0	5,0
SN.. 120416												
SN.. 150608												
SN.. 150612												
SN.. 150616												
SN.. 190612												
SN.. 190616												
SN.. 190624												
SN.. 250724												
SN.. 250924												
TN.. 110304												
TN.. 110308												
TN.. 160404	0,05	0,15	0,25	0,4	1,0	2,0						
TN.. 160408	0,10	0,15	0,35	0,8	1,5	2,5	0,15	0,25	0,40	1,0	2,0	4,5
TN.. 160412							0,20	0,30	0,50	1,2	2,0	4,5
TN.. 220404												
TN.. 220408												
TN.. 220412												
TN.. 220416												
VN.. 160404	0,08	0,10	0,20	0,4	1,0	2,0						
VN.. 160408	0,10	0,15	0,30	0,8	1,5	2,5	0,15	0,25	0,40	1,0	1,5	4,0
VN.. 160412												
WN.. 060404	0,05	0,15	0,25	0,4	1,0	2,0						
WN.. 060408	0,10	0,20	0,30	0,8	1,5	2,5	0,15	0,25	0,40	1,0	1,5	3,5
WN.. 060412							0,20	0,30	0,45	1,2	1,5	4,0
WN.. 080404	0,05	0,15	0,25	0,4	1,0	2,0						
WN.. 080408	0,10	0,20	0,35	0,8	1,5	2,5	0,15	0,25	0,40	1,0	2,0	4,5
WN.. 080412							0,20	0,30	0,50	1,2	2,0	5,0
WN.. 080416												

sharp → stable



The data shows reference values. An adjustment to the actual conditions may be required.

Designation	-M60						-M34					
	f			a _p			f			a _p		
	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.
	mm/rev.			mm			mm/rev.			mm		
CN.. 090304												
CN.. 090308												
CN.. 120404							0,08	0,12	0,18	1,0	1,5	3,0
CN.. 120408	0,25	0,30	0,50	1,5	2,5	6,0	0,10	0,15	0,35	1,0	1,8	3,5
CN.. 120412	0,30	0,35	0,55	2,0	3,0	6,0	0,13	0,20	0,40	1,5	2,0	4,0
CN.. 120416	0,30	0,40	0,60	2,0	3,0	6,0	0,15	0,25	0,45	2,0	3,0	4,5
CN.. 160608												
CN.. 160612	0,30	0,35	0,55	2,0	3,0	8,0						
CN.. 160616												
CN.. 160624												
CN.. 190608												
CN.. 190612												
CN.. 190616												
CN.. 190624												
CN.. 250924												
DN.. 110402												
DN.. 110404												
DN.. 110408												
DN.. 110412												
DN.. 150404							0,08	0,12	0,18	0,8	1,2	2,5
DN.. 150408							0,10	0,15	0,30	1,0	1,8	3,5
DN.. 150412							0,13	0,20	0,38	1,5	2,0	4,0
DN.. 150416												
DN.. 150604												
DN.. 150608	0,25	0,30	0,45	1,5	2,5	6,0	0,10	0,15	0,30	1,0	1,8	3,5
DN.. 150612	0,30	0,40	0,55	1,5	2,5	6,0	0,13	0,20	0,38	1,5	2,0	4,0
DN.. 150616												
SN.. 090308												
SN.. 120404												
SN.. 120408	0,30	0,35	0,50	1,5	2,0	6,0	0,15	0,25	0,40	1,0	2,0	4,0
SN.. 120412	0,30	0,40	0,55	2,0	2,5	6,0	0,15	0,25	0,45	1,5	2,5	4,5
SN.. 120416	0,30	0,40	0,60	2,0	2,5	6,0						
SN.. 150608												
SN.. 150612												
SN.. 150616												
SN.. 190612												
SN.. 190616												
SN.. 190624												
SN.. 250724												
SN.. 250924												
TN.. 110304												
TN.. 110308												
TN.. 160404												
TN.. 160408	0,25	0,25	0,45	1,5	2,5	5,0	0,10	0,15	0,35	1,0	2,0	4,0
TN.. 160412	0,30	0,30	0,55	2,0	2,5	5,5						
TN.. 220404							0,10	0,15	0,35	1,0	2,0	4,0
TN.. 220408							0,13	0,20	0,40	1,5	2,5	4,0
TN.. 220412												
TN.. 220416							0,15	0,25	0,45	2,0	2,5	4,5
VN.. 160404							0,07	0,10	0,18	0,8	1,2	2,0
VN.. 160408							0,10	0,15	0,20	1,0	1,5	2,5
VN.. 160412							0,13	0,18	0,25	1,5	1,8	3,0
WN.. 060404												
WN.. 060408	0,25	0,30	0,45	1,5	2,0	4,0						
WN.. 060412	0,30	0,35	0,50	2,0	2,5	4,5						
WN.. 080404												
WN.. 080408	0,25	0,30	0,50	1,5	2,0	5,0	0,10	0,15	0,35	1,0	2,0	4,0
WN.. 080412	0,30	0,35	0,55	2,0	2,5	5,5	0,13	0,20	0,40	1,5	2,0	4,0
WN.. 080416												

sharp → stable



Information on the cutting data of chip breakers not included in this overview, can be found on → Page 201–207

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																		

sharp stable



Information on the cutting data of chip breakers not included in this overview, can be found on → Page 201–207

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												

sharp ← → stable



Information on the cutting data of chip breakers not included in this overview, can be found on → **Page 201–207**

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, ...

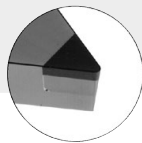
The cutting materials

	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	▲ perfect sharp edges ▲ no cutting pressure ▲ very close tolerances ▲ highest abrasion resistance with highest toughness ▲ very high heat conductivity	▲ high sharpness ▲ lower cutting pressure than PDC-S ▲ close tolerance ▲ lower abrasion resistance with increased toughness	▲ very sharp cutting edge ▲ reduced cutting pressure ▲ tight tolerances ▲ very high level of wear resistance and toughness	▲ high sharpness ▲ lower cutting pressure ▲ close tolerance ▲ lower abrasion resistance than with the PDC, with increased toughness
Material	suitable for superfinishing and semi-finishing of all non ferrous metals and NE-composite materials with small to high levels of abrasiveness	suitable for fine machining of all NE-materials with low abrasiveness	suitable for finishing to roughing non-ferrous metals and non-ferrous materials with highly abrasive alloying element. High chip removal on fibre-reinforced plastics such as CFRP and GFRP.	suitable for fine machining of all NE-materials and non-ferrous metals with low to very high levels of abrasiveness

Cutting Geometries

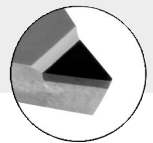
Neutral rake angle:

- ▲ higher cutting force
- ▲ higher temperature
- ▲ improved surface quality
- ▲ for stable workpieces



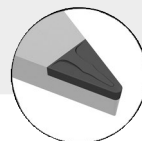
Positive rake angle:

- ▲ lower cutting force
- ▲ lower temperature
- ▲ reduction in surface quality
- ▲ for unstable workpieces
- ▲ improved accuracy



CB chip breaker geometries:

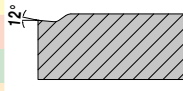
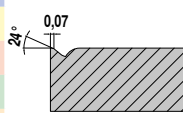
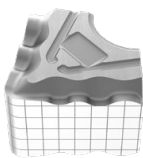
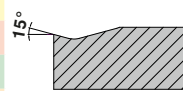
- ▲ reliable chip control
- ▲ ideal for low-alloy aluminium
- ▲ for F | M | R applications



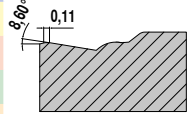
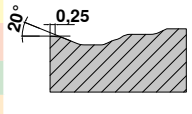
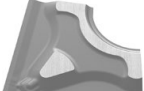
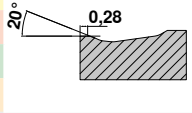
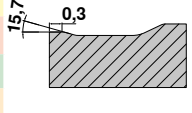
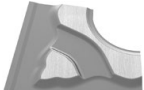
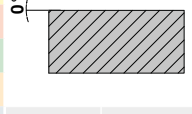
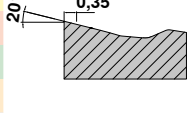
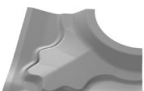
Notes on diamond usage

- ▲ coolant is not generally needed, however it facilitates chip removal
- ▲ note the chemical reaction to carbide-forming elements (PCD)
- ▲ note the thermal interaction and critical temperature:
PCD: 600 °C, CVD: 700 °C
Depending on the material, use cooling.

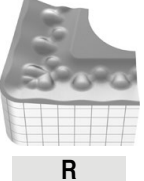
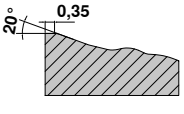
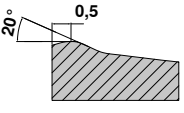
Standard chip breakers / application notes

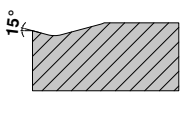
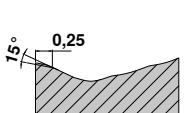
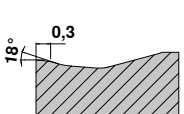
Negative		Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration		Geometry
						a _p mm	f mm	
Main application steel and cast iron, secondary application stainless steels	-CF / -CF20		CTEP110 / TCM10					CN.. DN.. TN.. WN..
	▲ Fine finishing ▲ Sharp cutting edge for low cutting forces ▲ Good chip control even at small depths of cut	F	CTEP110 / TCM10				0,30–1,50 0,07–0,25	
			CTEP110 / TCM10					
	-F40		CTCP125-P	CTCP125-P				VN..
▲ Fine turning chip breaker for machining steels ▲ Good chip control ▲ Ideal for copy turning work	F	CTCP125-P	CTCP125-P			0,50–2,00 0,10–0,30		
	-F50		CTCP115-P / CTCP125-P	CTCP115-P / CTCP125-P / CTCP135-P	CTCP135-P			CN.. DN.. SN.. TN.. VN.. WN..
▲ Fine turning chip breaker for fine machining ▲ Steel and stainless steels ▲ Excellent chip control ▲ High surface quality	F	CTCP135-P	CTCP135-P			0,10–2,60 0,06–0,35		
								</

Standard chip breakers / application notes

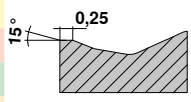
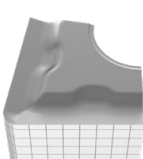
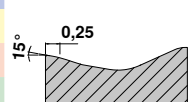
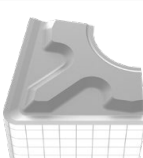
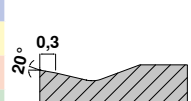
Negative	Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration		Geometry
					a_p mm	f mm	
Main application steel and cast iron, secondary application stainless steels	-M40					0,50–3,00	VN..
	 M	CTCP125-P	CTCP125-P				
		CTCP125-P	CTCP125-P				
	-M50					0,50–5,00	CN.. DN.. TN.. VN.. WN..
	 M	CTCP115-P / CTCP125-P / CTCK110 / CTCK120	CTCP115-P / CTCP125-P	CTCP125-P / CTCP135-P			
		CTCP115-P	CTCP125-P	CTCP135-P			
		CTCP115-P / CTCP125-P / CTCK110 / CTCK120	CTCP115-P / CTCP125-P / CTCK110 / CTCK120	CTCP125-P / CTCK120			
	-TMQ					0,80–6,00	CN.. DN.. WN..
	 M	CTCP115-P	CTCP125-P				
		CTCP125-P	CTCP125-P				
		CTCP125-P	CTCP125-P				
	-M70					1,50–4,50	CN.. DN.. TN.. WN..
	 M R	CTCK110 / CTCK120 / CTCP115-P	CTCP115-P / CTCP125-P	CTCP125-P / CTCP135-P			
		CTCP115-P	CTCP125-P	CTCP135-P			
		CTCK110 / CTCK120 / CTCP115-P / CTCP125-P	CTCK120 / CTCP125-P	CTCP125-P / CTCK120			
	-NMA					1,50–4,50	CN.. DN.. TN.. WN..
	 M R						
		CTCK110	CTCK110 / CTCK120	CTCK120			
	-R28					1,00–12,00	CN.. DN.. SN..
	 R	CTCP115-P / CTCP125-P	CTCP115-P / CTCP125-P / CTCP135-P	CTCP135-P			
		CTCP115-P / CTCP125-P	CTCP125-P / CTCP135-P	CTCP135-P			
		CTCP115-P	CTCP125-P	CTCP135-P			

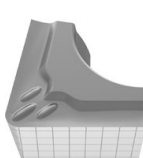
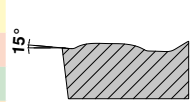
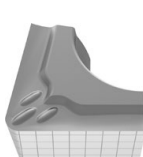
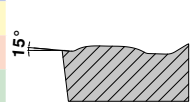
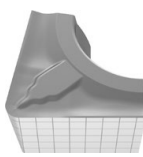
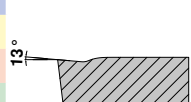
Standard chip breakers / application notes

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	 20° 0,35	1,50–12,00 0,30–1,20	CN.. DN.. SN.. TN..
	▲ Single sided roughing geometry		CTCP115-P / CTCP125-P	CTCP125-P / CTCP135-P	CTCP135-P			
	▲ Longitudinal and face turning		CTCP115-P	CTCP115-P / CTCP125-P	CTCP125-P			
	▲ Light interrupted cut							
Main application steel and cast iron, secondary application stainless steels	-R88	 R	CTCP115-P / CTCP125-P	CTCP115-P / CTCP125-P / CTCP135-P	CTCP135-P	 20° 0,5	3,50–16,00 0,50–1,50	SN..
	▲ Single sided roughing geometry		CTCP115-P / CTCP125-P	CTCP115-P / CTCP125-P	CTCP135-P			
	▲ Longitudinal and face turning		CTCP115-P	CTCP115-P / CTCP125-P	CTCP125-P			
	▲ High feedrate							

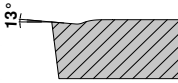
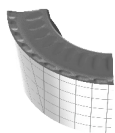
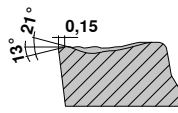
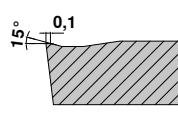
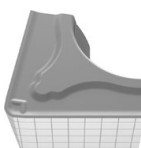
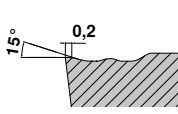
Negative		Model	Smooth cut 	Irregular cutting depth 	Interrupted cut 	Sectional illustration		Geometry
						a_p mm	f mm	
Main application stainless steels, secondary application steel and super alloys	-F30	 F	CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130	CTCM130	 15°	0,08–2,5 0,10–0,35	CN.. DN.. SN.. VN.. WN..
	▲ Finishing of stainless steels		CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130	CTCM130			
	▲ Continuous cut							
	▲ High surface quality							
Main application stainless steels, secondary application steel and super alloys	-M30	 F M	CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130	CTCM130	 15° 0,25	1,00–4,50 0,15–0,40	CN.. DN.. SN.. TN.. VN.. WN..
	▲ Option for stainless steel machining		CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130	CTCM130			
	▲ Good swarf control							
	▲ Little edge build up							
Main application stainless steels, secondary application steel and super alloys	-M60	 M R	CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130	CTCM130	 18° 0,3	1,50–6,00 0,25–0,50	CN.. DN.. SN.. TN.. WN..
	▲ Light to medium roughing		CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130	CTCM130			
	▲ Stable cutting edge							
	▲ Interrupted cut							

Standard chip breakers / application notes

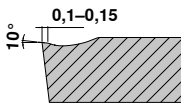
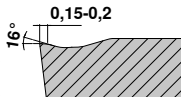
Negative		Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration		Geometry
						a_p mm	f mm	
Main application super alloys, secondary application stainless steels	-F34	 F	CTPX710	CTPX710		 15° 0,25	0,50–2,50 0,08–0,25	CN.. WN..
	▲ Stable, positive cutting edge							
	▲ Also for slightly interrupted cuts							
			CTPX710	CTPX710				
	-M34	 M	CTPX710	CTPX710		 15° 0,25	0,80–3,0 0,10–0,30	CN.. DN.. SN.. VN.. WN..
	▲ First choice for superalloys		CTPX710	CTPX710				
	▲ Light cutting geometry							
	▲ Little built-up edge		CTPX710	CTPX710				
▲ Low cutting forces	CTPX710		CTPX710					
-M42	 M	CTCM130	CTCM130	CTCM130	 20° 0,3	1,0–3,50 0,15–0,40	CN.. DN..	
▲ For medium machining on stainless steels								
▲ As a secondary application for general steels and super alloys								
		CTPX710	CTPX710					

Positive								
Main application steel and cast iron, secondary application stainless steels and super alloys	-CF05	 F	CTEP110 / TCM407	TCM10 / TCM407		 15°	0,20–1,30 0,06–0,25	CC.. DC.. SC.. TC.. VC..
	▲ Fine finishing		CTEP110					
	▲ For all common steel materials, stainless steels and GGG		CTEP110	TCM10 / TCM407				
	▲ Good swarf control							
	▲ High surface quality							
	-SF	 F	CTCP115-P	CTCP125-P	CTCP125-P / CTCP135-P	 15°	0,05–2,50 0,05–0,25	CC.. DC.. SC.. TC.. VC.. WC..
	▲ Finishing / contour turning							
	▲ Good swarf control			CTCP125-P	CTCP125-P			
	▲ High surface quality							
▲ Low cutting forces								
-CF55	 F M	CTEP110	TCM10 / CTEP110		 13°	0,20–1,30 0,06–0,25	CC.. DC.. SC.. TC.. VC..	
▲ Finishing to medium machining		CTEP110	CTEP110					
▲ Suitable for general and stainless steels		CTEP110	CTEP110					
▲ Low cutting forces								
▲ Good swarf control								
▲ High surface quality								

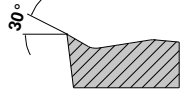
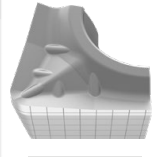
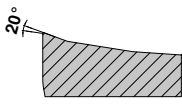
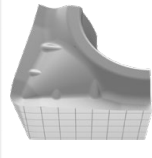
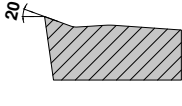
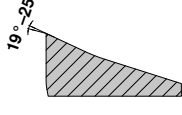
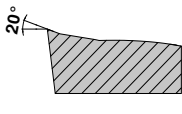
Standard chip breakers / application notes

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 CTEP110 CTEP110	TCM10 / CTCP125-P / CTCP115-P CTCP135-P	CTCP135-P CTCP135-P		0,20–1,30	0,06–0,25	CC.. DC.. SC.. TC.. VC..
	-M23		CTCP115-P / CTCP125-P CTCP115-P / CTCP125-P	CTCP125-P CTCP125-P	CTCP125-P CTCP125-P		0,30–4,0	1,0–0,45	RC..
	-SM		CTCP115-P / CTCP125-P CTCP115-P / CTCK110 / CTCK120	CTCP125-P / CTCP135-P / CTCP115-P CTCP135-P CTCP125-P / CTCK110 / CTCK120	CTCP125-P / CTCP135-P CTCP135-P CTCK120		0,05–5,00	0,15–0,45	CC.. DC.. RC.. SC.. TC.. VC..
	-SMQ		CTCP115-P CTCP125-P / CTCP115-P	CTCP125-P CTCP125-P	CTCP125-P CTCP125-P		1,00–4,00	0,15–0,45	CC.. DC..

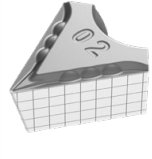
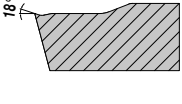
Positive

	-M25		CTCM120 / CTPM125 CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130 CTCM120 / CTPM125 / CTCM130	CTCM130 CTCM130		0,40–3,20	0,10–0,30	CC.. DC.. TC.. VC..
	-M55		CTCM120 / CTPM125 CTCM120 / CTPM125	CTCM120 / CTPM125 / CTCM130 CTCM120 / CTPM125 / CTCM130	CTCM130 CTCM130		0,40–4,80	0,06–0,35	CC.. DC.. SC.. TC.. VC..

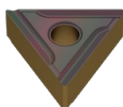
Standard chip breakers / application notes

Positive		Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration		Geometry	
						a_p mm	f mm		
Main application non-ferrous metals, secondary application stainless steels, steels, super alloys, cast iron	-23P	 F	H216T H216T H216T	H216T H216T H216T	H216T H216T H216T		0,2–4,0	0,05–0,3	CC.. DC..
	-25P	 F M	CTPX710 CTPX710 CTPX710 / H216T CTPX710 CTPX710	CTPX710 CTPX710 CTPX710 / H216T CTPX710 CTPX710	CTPX710 CTPX710 CTPX710 / H216T CTPX710 CTPX710		0,50–4,50	0,05–0,60	CC.. DC.. SC.. VC..
	-25Q	 M	CTPX710 CTPX710 H210T H210T / CTPX710 H210T / CTPX710 H210T	CTPX710 CTPX710 H210T H210T / CTPX710 H210T / CTPX710 H210T	CTPX710 CTPX710 H210T H210T / CTPX710 H210T / CTPX710 H210T		0,05–6,50	0,05–0,60	CC.. DC.. VC..
	-27	 M R	CTPX715 CTPX715 CTPX715 / H216T CTPX715 / H216T CTPX715 CTPX715 / H216T	CTPX715 CTPX715 CTPX715 / H216T CTPX715 / H216T CTPX715 CTPX715 / H216T	CTPX715 CTPX715 CTPX715 / H216T CTPX715 / H216T CTPX715 CTPX715 / H216T		1,00–10,00	0,10–0,75	CC.. DC.. RC.. SC.. TC.. VC..
	-29	 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

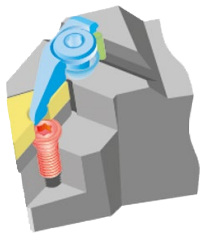
Main application super alloys and stainless steels, secondary application steels and non-ferrous metals	-F05						0,10–2,50	0,02–0,25	DC.. VC..
	▲ Maximum tolerance class	F	CTPX710	CTPX710					
	▲ Outstanding chip control, even with the smallest cutting depths		CTPX710	CTPX710					
	▲ Very low cutting forces		CTPX710	CTPX710					
			CTPX710	CTPX710					
			CTPX710	CTPX710					
			CTPX710	CTPX710					

Supplementary chip breakers / application notes

	Model	Smooth cut	Irregular cutting depth	Interrupted cut
-EN ▲ Universal chip breaker for general steels	 M	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	 M		CTCP125-P	CTCP135-P

Clamping systems

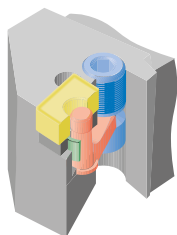
MaxiLock-D



- 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.

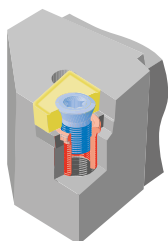
MaxiLock-N



- 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

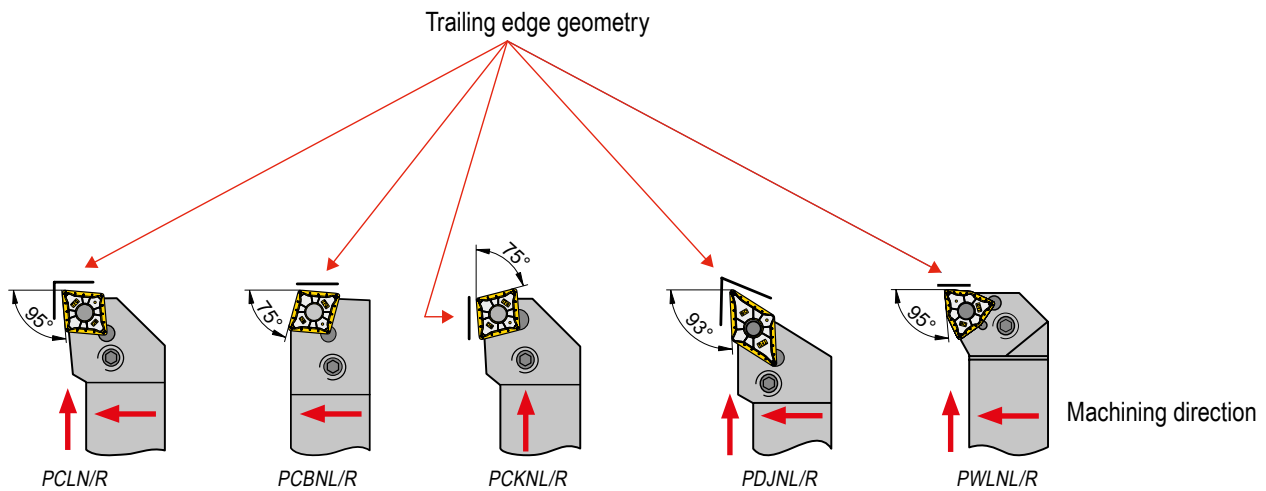


- Clamping element
- Inserts
- Insert seat
- Threaded sleeve

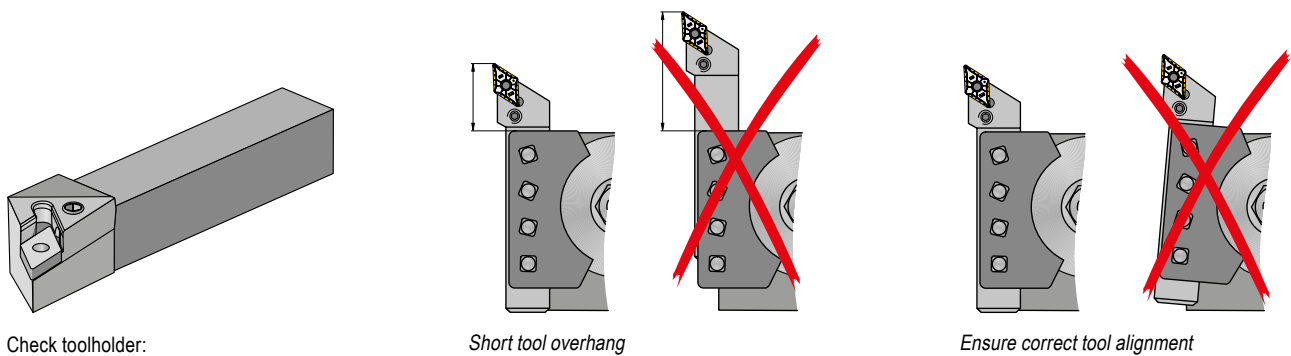
The positive screw clamping guarantees a secure connection between the indexable insert and the tool holder. The chip flow is not disrupted by protruding clamping elements. Thanks to the neutral insert position, the effective available rake angle is identical to the rake angle of the indexable insert.

Trailing edge geometry – information

High-quality surfaces can be produced inexpensively using indexable inserts with trailing edge geometry (-TFQ; -TMQ; -SMQ; -25Q).



All turning inserts with trailing edge are clamped in standard ISO tool holders



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 trailing edge 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 trailing edge geometry can be moved at twice the feed speed (= **lower cycle times!**).



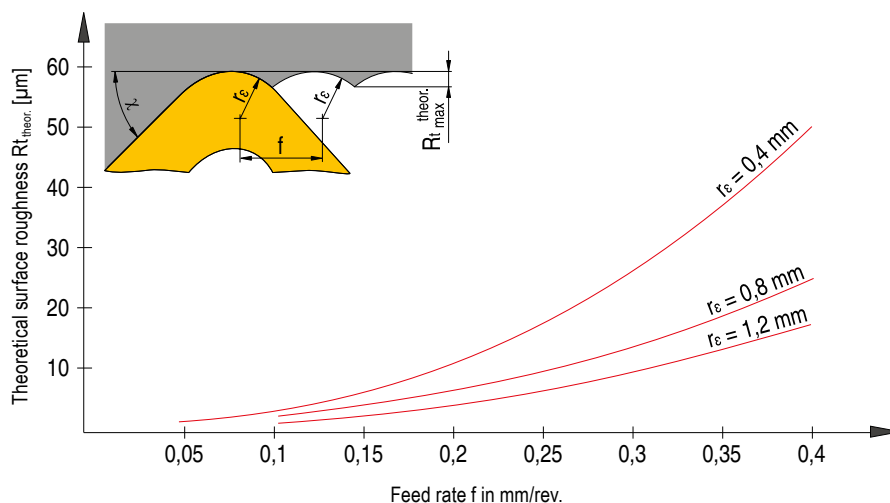
Theoretical Surface Quality

The maximum theoretical surface roughness with turning $R_{t \text{ theor.}}$ is the combination of feed rate and corner radius:

or approximately:

$$R_{t \text{ theor.}} = \left(r_\epsilon - \sqrt{r_\epsilon^2 - \frac{f^2}{4}} \right) \cdot 1000$$

$$R_{t \text{ theor.}} = \frac{125 \cdot f^2}{r_\epsilon} \text{ } [\mu\text{m}]$$



ISO designation system for inserts

Indexable inserts – metric

C N M G 12 04 08 E N - M50

1 2 3 4 5 6 7 8 9 13

Indexable inserts – inch

C N M G 4 3 2 E N - M50

1 2 3 4 5 6 7 8 9 13

Indexable inserts, CBN,
ceramic – metric

C N G A 12 04 08 S N - 020D - B 3 - Q

1 2 3 4 5 6 7 8 9 10 11 12 13

Indexable inserts, CBN,
ceramic – inch

C N G A 4 3 2 S N - 020D - B 3 - Q

1 2 3 4 5 6 7 8 9 10 11 12 13

1			
Insert shape			
V	35°	Included angle	
D	55°		
E	75°		
C	80°		
M	86°	Included angle	
K	55°		
B	82°		
A	85°		
L	90°	Other shapes	
P	108°		
H	120°		
O	135°		
R	-		
S	90°		
T	60°		
W	80°		

2			
Clearance angle			
	α		α
A	3°	F	25°
B	5°	G	30°
C	7°	N	0°
D	15°	P	11°
E	20°		
O	Clearance angles not included within the standard for which particular information is necessary.		

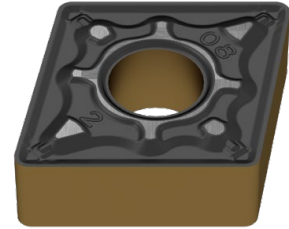
3						
Tolerances						
	IC±		BS		S	
	mm	inch	mm	inch	mm	inch
A	0,025	.0010	0,005	.0002	0,025	.001
F	0,013	.0005	0,005	.0002	0,025	.001
C	0,025	.0010	0,013	.0005	0,025	.001
H	0,013	.0005	0,013	.0005	0,025	.001
E	0,025	.0010	0,025	.0010	0,025	.001
G	0,025	.0010	0,025	.0010	0,13	.005
J	0,05-0,15*	.002-.006*	0,005	.0002	0,025	.001
K	0,05-0,15*	.002-.006*	0,013	.0005	0,025	.001
L	0,05-0,15*	.002-.006*	0,025	.0010	0,025	.001
M	0,05-0,15*	.002-.006*	0,05-0,20*	.003-.008*	0,13	.005
N	0,05-0,15*	.002-.006*	0,05-0,20*	.003-.008*	0,025	.001
U	0,08-0,25*	.003-.010*	0,13-0,38*	.005-.015*	0,13	.005
* Depends on insert size						

6				
Insert thickness				
		Code		
mm	inch	mm	inch	
1,59	1/16	01	1	
2,38	3/32	02	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				
		Code		
mm	inch	mm	inch	
≤ 0,05	.0015	00	X0	
0,1	.004	01	0	
0,2	.008	02	.5	
0,4	1/64	04	1	
0,8	1/32	08	2	
1,2	3/64	12	3	
1,6	1/16	16	4	
2,0	5/64	20	5	
2,4	3/32	24	6	
2,8	7/64	28	7	
3,2	1/8	32	8	

8	
Cutting edge	
F	Sharp
E	rounded
T	chamfered
S	Chamfered and honed
K	Double-chamfered
P	Double-chamfered and honed
R	Round chamfer

9	
Direction of cut	
CBN and PCD segment orientation	



4

Characteristics

N	
R	
F	
A	
M, P	
G, P	
W	
T	
Q	
U	
B	
H	
C	
J	
X	Special version

inch

Change at inscribed circle IK < 1/4"

IK > 1/4"	IK < 1/4"
N / R / F	E
A / M / G	D
X	X

5

Cutting length

Type	ISO	ANSI	L		IC	
			mm	inch	mm	inch
C	06	2	6,4	.250	6,35	.250
	09	3	9,7	.382	9,525	.375
	12	4	12,9	.508	12,70	.500
	16	5	16,1	.634	15,875	.625
	19	6	19,3	.760	19,05	.750
	25	8	25,8	1.016	25,4	1.000
S	32	12	35,24	1.269	31,75	1.250
	06	2	6,35	.250	6,35	.250
	09	3	9,525	.375	9,525	.375
	12	4	12,7	.500	12,7	.500
	15	5	15,875	.625	15,875	.625
	19	6	19,05	.750	19,05	.750
D	25	8	25,4	1.000	25,4	1.000
	31	10	31,75	1.250	31,75	1.250
	07	2	7,7	.303	6,35	.250
	11	3	11,6	.457	9,525	.375
	15	4	15,5	.610	12,70	.500
V	11	2	11,1	.437	6,35	.250
	16	3	16,6	.653	9,525	.375
	22	4	22,10	.870	12,70	.500
L						

* inch version

Type	ISO	ANSI	L		IC	
			mm	inch	mm	inch
T	06	1.2	6,9	.272	3,97	.156
	09	1.8	9,6	.378	5,56	.219
	11	2	11,0	.433	6,35	.250
	16	3	16,5	.650	9,525	.375
	22	4	22,	.079	12,70	.039
	27	5	27,5	1.083	15,875	.625
W	33	6	33,0	1.299	19,05	.750
	06	3	6,5	.256	9,525	.375
	08	4	8,7	.331	12,70	.039
	10	5	10,9	.429	15,875	.625
R	06	2	6,35	.250	6,35	.250
	08	-	8,0	.315	8,0	.315
	09	3	9,52	.375	9,52	.375
	10	-	10,0	.394	10,0	.394
	12*	-	12,0	.472	12,0	.472
	12	4	12,7	.488	12,70	.488
IC	15	5	15,875	.625	15,875	.625
	16	-	16,0	.630	16,0	.630
	19	6	19,05	.750	19,05	.750
	25	8	25,0	.984	25,0	.984
	25*	-	25,4	1.000	25,4	1.000
	31	10	31,75	1.250	31,75	1.250
32	-		32,0	1.260	32,0	1.260

9

10

Chamfer type

		mm	inch		
015	0,15	.006	A	05°	
020	0,20	.008	B	10°	
025	0,25	.010	C	15°	
050	0,50	.020	D	20°	
075	0,75	.030	E	25°	
100	1,00	.040	F	30°	
			G	35°	

1) Two letters are assigned for double-chamfered cutting edges
e.g. BE =
chamfer angle 1 (γ_1) = 10°
chamfer angle 2 (γ_2) = 25°

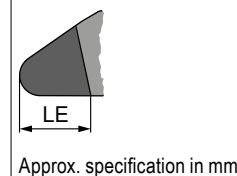
11

Number of cutting edges

Single sided		Complete insert thickness	
A		T	
B		U	
C		V	
D		W	
G		X	
H		Y	
Double sided		Entire clamping flat	
K		S	
L		F	
M		E	
N			
P			
Q			

12

Segment length



13

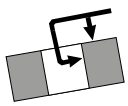
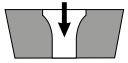
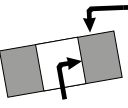
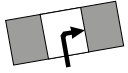
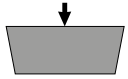
Chip breaker designation

You can find a comprehensive chip breaker overview on
→ page 201–207

ISO designation system for tool holders

P	C	L	N	R	20	20	K	12	-	T
1	2	3	4	5	6	7	8	9	10	
UT50	-	P	C	L	N	R			-12	
0	1	2	3	4	5	6	7	8	9	10
HSK-T63	-	D	C	L	N	R			-12	
0	1	2	3	4	5	6	7	8	9	10

0
System/size
UT = UTS according to ISO 26622 UT40 = UTS 40 mm UT50 = UTS 50 mm UT63 = UTS 63 mm
HSK-T according to ISO 12164 HSK-T63 = 63 mm HSK-T100 = 100 mm

1
Tool holder
D  Retained from above and via bore S  Retained via centre screw
M  Retained from above and via bore P  Retained via the bore
C  Retained from above X Special version

2	
Insert shape	
V 35°	Included angle
D 55°	
E 75°	
C 80°	
M 86°	
K 55°	Included angle
B 82°	
A 85°	
L 90°	
P 108°	
H 120°	
O 135°	
R -	
S 90°	
T 60°	
W 80°	
Other shapes	

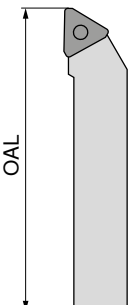
6
Shank height

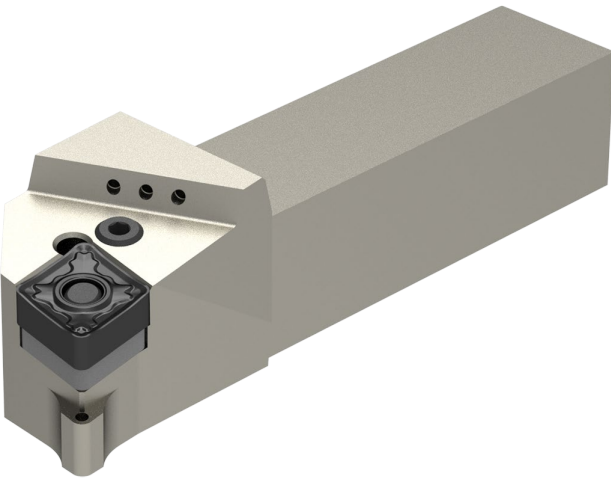

7
Shank width


8

Tool length

OAL			OAL		
mm	inch		mm	inch	
32	4.000	A	160	4.500	N
40	4.500	B	170	5.500	P
50	5.000	C	180	–	Q
60	6.000	D	200	6.000	R
70	7.000	E	250	7.000	S
80	8.000	F	300	8.000	T
90	5.500	G	350	5.500	U
100	5.625	H	400	3.500	V
110	5.300	J	450	3.500	W
125	14.000	K	500	3.750	Y
140	6.800	L	Special version		X
150	4.400	M			





3

Style

90°

A

75°

B

90°

C

45°

D

60°

E

90°

F

90°

G

107,5°

H

93°

J

75°

K

95°

L

50°

M

63°

N

117,5°

P

75°

R

45°

S

60°

T

93°

U

72,5°

V

60°

W

85°

Y

4

Clearance angle

	α		α
A	3°	F	25°
B	5°	G	30°
C	7°	N	0°
D	15°	P	11°
E	20°		

O Clearance angles not included within the standard for which particular information is necessary.

5

Direction of cut

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
A Steel shank with coolant hole
B Steel shank with antivibration system
D Steel shank with coolant hole and antivibration system
C Carbide shank with steel head
E As C with coolant hole
F As C with antivibration system
G As C with coolant hole and antivibration system
H Heavy metal
J Heavy metal with coolant hole

5
Insert shape
V 35°
D 55°
E 75°
C 80°
M 86°
K 55°
B 82°
A 85°
L 90°
P 108°
H 120°
O 135°
R -
S 90°
T 60°
W 80°
Included angle
Included angle
Other shapes

6
Style
F 90°
K 75°
L 95°
Q 107,5°
S 45°
U 93°
W 60°
X 93°
Y 85°
*) CERATIZIT factory standard

7
Clearance angle
α
A 3°
B 5°
C 7°
D 15°
E 20°
F 25°
G 30°
N 0°
P 11°
O Clearance angles not included within the standard for which particular information is necessary.



2

Shank type & size

DCONMS mm	DCONMS inch
08	
10	
12	
16	
20	
25	
32	
40	
50	
60	

A two-digit figure indicating the boring bar diameter in 1/16 of an inch.

3

Tool length

OAL		
mm	inch	
80	3	F
100	3,5	H
110	4	J
125	4,5	K
140	5	L
150	5,5	M
160	6	N
170	6,5	P
180	6,75	Q
200	7	R
250	8	S
300	10	T
350	12	U
400	14	V
450	16	W
500	18	Y
	20	
Special version		X

4

Clamping method

D Retained from above and via bore	S Retained via centre screw
M Retained from above and via bore	P Retained via the bore
C Retained from above	X Special version

8

Direction of cut

R

L

9

Cutting length

10

Manufacturer specification

T = Toggle
Special length (mm)
Insert thickness (deviating from standard)
Special version (X..)
Machine manufacturer (specific)

Types of wear

Wear on clearance face



Abrasion on flank: normal wear after a certain machining time

Cause

- ▲ Too high cutting speed
- ▲ Carbide grade with too low wear resistance
- ▲ Feed rate not adapted

Remedy

- ▲ Reduce cutting speed
- ▲ Use grade with higher wear resistance
- ▲ Adapt feed rate to cutting speed and cutting depth

Edge chipping



Through excessive mechanical stress at the cutting edge fracture and chipping can occur.

Cause

- ▲ Grade with too high wear resistance
- ▲ Vibration
- ▲ Too high cutting speed and / or feed rate
- ▲ Interrupted cut
- ▲ Swarf damage

Remedy

- ▲ Use tougher grade
- ▲ Use negative cutting edge geometry with chip groove
- ▲ Improve stability (tool, work piece)

Cratering



The hot chip which is being evacuated causes cratering at the rake face of the cutting edge.

Cause

- ▲ Too high cutting speed and / or feed rate
- ▲ Rake angle too shallow
- ▲ Grade with insufficient wear resistance
- ▲ Insufficient coolant supply

Remedy

- ▲ Reduce cutting speed and / or feed rate
- ▲ Use grade with higher wear resistance
- ▲ Increase coolant quantity and / or pressure, optimise coolant supply
- ▲ Use grade which is more resistant to cratering

Plastic deformation



High machining temperature and simultaneous mechanical stress can lead to plastic deformation.

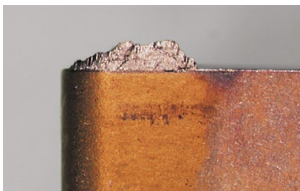
Cause

- ▲ Too high machining temperature resulting in softening of substrate
- ▲ Damage of coating
- ▲ Grade with insufficient wear resistance
- ▲ Insufficient coolant supply

Remedy

- ▲ Reduce cutting speed
- ▲ Use grade with higher wear resistance
- ▲ Provide cooling

Built-up edge



Built-up material / edges occur when the chip is not evacuated properly due to insufficient cutting temperature.

Cause

- ▲ Insufficient cutting speed
- ▲ Rake angle too shallow
- ▲ Wrong cutting material
- ▲ Lack of cooling / lubrication

Remedy

- ▲ Increase cutting speed
- ▲ Increase rake angle
- ▲ Apply TiN coating
- ▲ Use emulsion with higher concentration

Insert breakage



Excessive stress of the insert causes breakage.

Cause

- ▲ Excessive stress of cutting material
- ▲ Lack of stability
- ▲ Clearance angle too small

Remedy

- ▲ Use tougher grade
- ▲ Use protective edge chamfer
- ▲ Increase edge hone
- ▲ Use geometry with higher stability

Recommendation for Optimum Results

Type of problem																
Type of wear						Work piece problems				Swarf control						
Wear on clearance face	Cratering	Edge chipping	Plastic deformation	Insert breakage	Built-up edge	Vibration	Formation of pips and burrs	Chattered surface	Surface quality	Chip too long (snarl chip)	Chip too short (fragmented chip)					
⬇	⬇		⬇		⬇	⬇			⬆	⬇		Cutting speed	Cutting data	Remedy measures		
⋈		⬇	⬇	⬇		⬆		⬇	⬇	⬆	⬇				Feed rate	
⬇	⬇	⬇	⬇				⬇	⬇	⬇							Feed rate at centre
		⬆	⋈		⬇	⋈	⬇	⬇	⬇	⬇	⬆	Chip groove	Insert selection			
⬆		⬆	⬆	⬆		⬇	⬇	⬇	⬆						Corner radius	
⬆	⬆	⬇	⬆	⬇												Tool Material
		⋈		⋈		⋈		⋈	⋈			Tool clamping	General criteria			
		⋈		⋈		⋈		⋈	⋈						Work piece clamping	
		⋈		⋈		⋈			⬇							Overhang
⋈		⋈				⋈	⋈		⋈			Tip height				
●	⋈		●		●		●		●	●			Cooling lubricant			

⬆

raise, increase
large influence

⬆

raise, increase
small influence

⬇

avoid, reduce
large influence

⬇

avoid, reduce
small influence

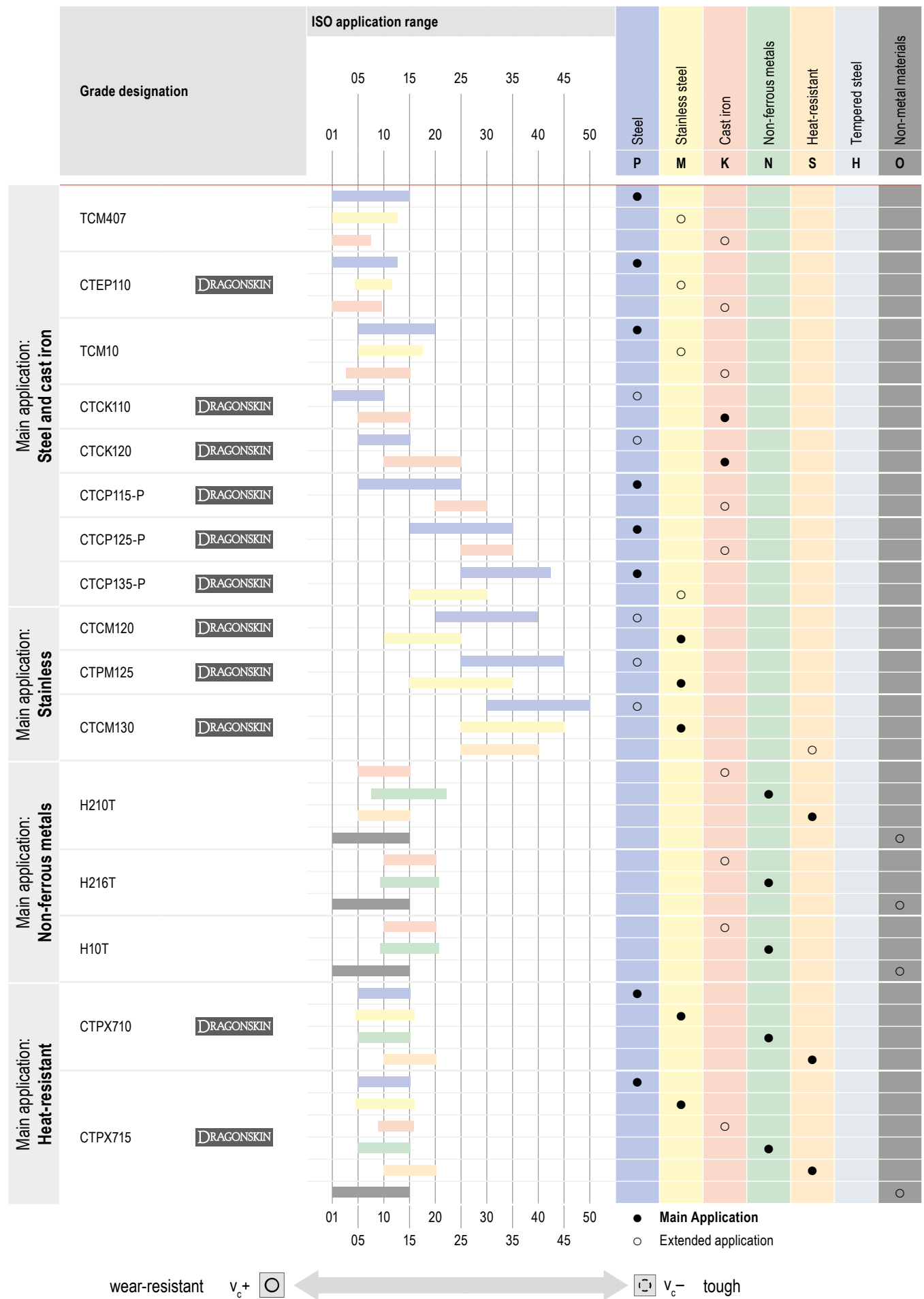
⋈

check, optimise

●

use

Grades Overview



Grade description

TCM407



ISO | P10 | M05 | K05

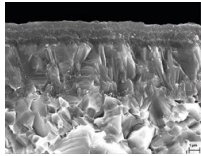
**Specification:**

Composition: Co 8.0%; WC 16.0%; TaNbC 10.0%; TiCN balance | Grain size: 2-3 µm |
Hardness: HV₃₀ 1760

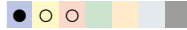
Usage recommendation:

The uncoated cermet grade for fine finishing steel materials.

CTEP110



ISO | P10 | M10 | K05

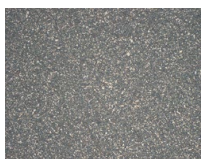
**Specification:**

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

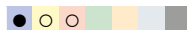
Usage recommendation:

The cermet grade with toughness reserves for finish machining at high cutting speeds.

TCM10



P15 | K10

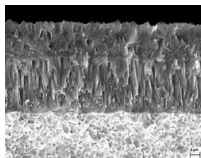
**Specification:**

Composition: Cermet Co/Ni 12.2%; WC 15.0%; TaNbC 10.0%; TiCN balance | Grain size: 2-3 µm |
Hardness: HV₃₀ 1650

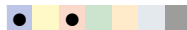
Usage recommendation:

The uncoated cermet grade for finishing steel, stainless steel and tempered steel.

CTCK110



ISO | P05 | K10

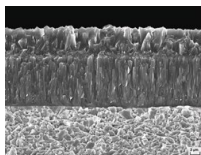
**Specification:**

Composition: Co 5.0%, mixed carbides 2.0%, WC balance | Grain size: 1-2 µm | Hardness: HV₃₀ 1730 |
Layer system: CVD TiCN-Al₂O₃

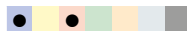
Usage recommendation:

The wear-resistant grade for machining cast iron materials and steels at high cutting speeds with a continuous cut.

CTCK120



ISO | P10 | K20

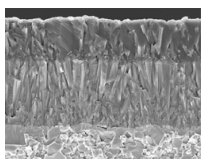
**Specification:**

Composition: Co 6.0%, mixed carbides 2.0%, WC balance | Grain size: 1 µm | Hardness: HV₃₀ 1630 |
Layer system: CVD TiCN-Al₂O₃

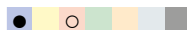
Usage recommendation:

The grade for cast iron machining with high toughness reserves for difficult conditions and interrupted cuts.

CTCP115-P



ISO | P15 | K25

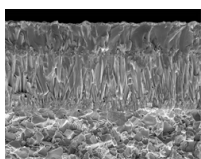
**Specification:**

Composition: Co 5.5%; mixed carbides 6.4%; WC balance | Grain size: 1 µm | Hardness: HV₃₀ 1530 |
Layer system: CVD TiCN-Al₂O₃

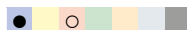
Usage recommendation:

The wear-resistant high-performance grade for steel machining with stable conditions and a continuous cut.

CTCP125-P



ISO | P25 | K30

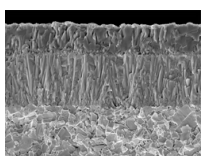
**Specification:**

Composition: Co 7.0%, mixed carbides 6.0%, WC balance | Grain size: 1-2 µm | Hardness: HV₃₀ 1500 |
Layer system: CVD TiCN-Al₂O₃

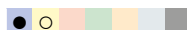
Usage recommendation:

The first choice for the universal machining of steels.

CTCP135-P



ISO | P35 | M25

**Specification:**

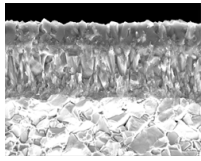
Composition: Co 9.6%, mixed carbides 7.8%, WC balance | Grain size: 1-2 µm | Hardness: HV₃₀ 1460 |
Layer system: CVD TiCN-Al₂O₃

Usage recommendation:

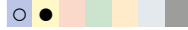
The tough alternative for extremely interrupted cutting conditions.

Grade description

CTCM120



ISO | P15 | M20

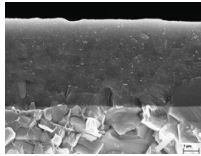
**Specification:**

Composition: Co 7%, mixed carbides 6%, WC balance | Grain size: 1-2 μm | Hardness: HV₃₀ 1500 | Layer system: CVD TiCN-Al₂O₃

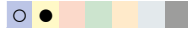
Usage recommendation:

Wear-resistant carbide grade for austenitic, stainless steel with the best levels of performance with a smooth cut.

CTPM125



ISO | P35 | M25

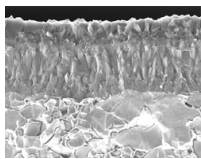
**Specification:**

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

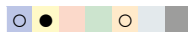
Recommended application:

The first choice for the machining of austenitic steels

CTCM130



ISO | P25 | M30 | S30

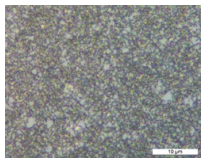
**Specification:**

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

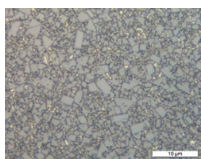
**Specification:**

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

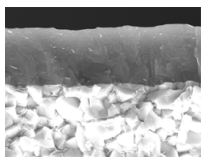
**Specification:**

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

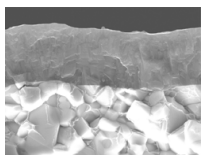
**Specification:**

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

