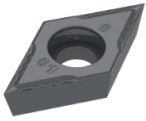


New products for machining technicians

NEW High precision finishing insert in “E” tolerance



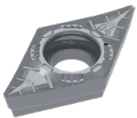
F05 – extremely sharp chip breaker ideal for fine finishing of superalloys and stainless steels. New universal grade of the X7 line for machining almost all materials.

NEW New CBN grades CTB H15U and CTB H15C

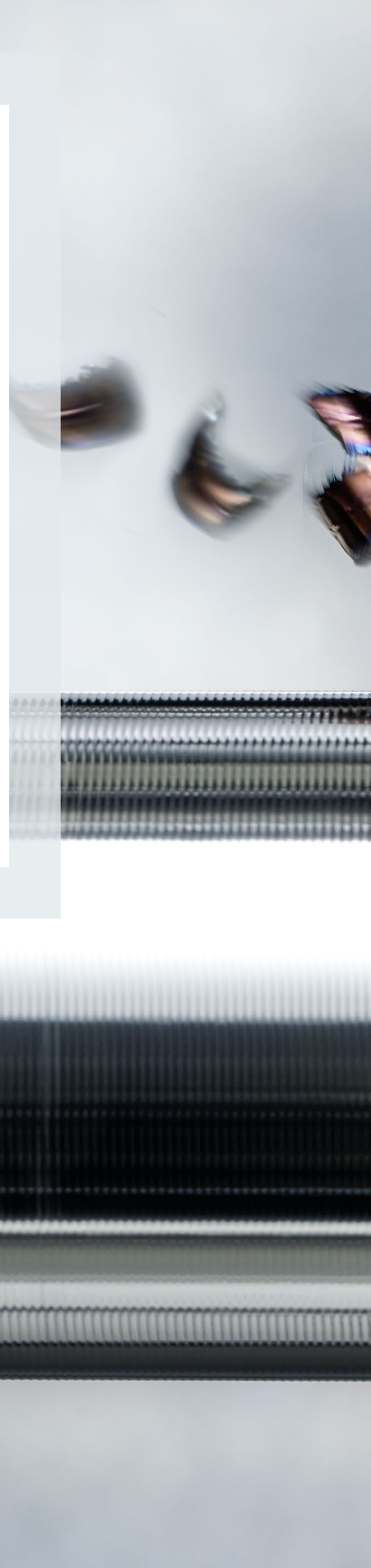


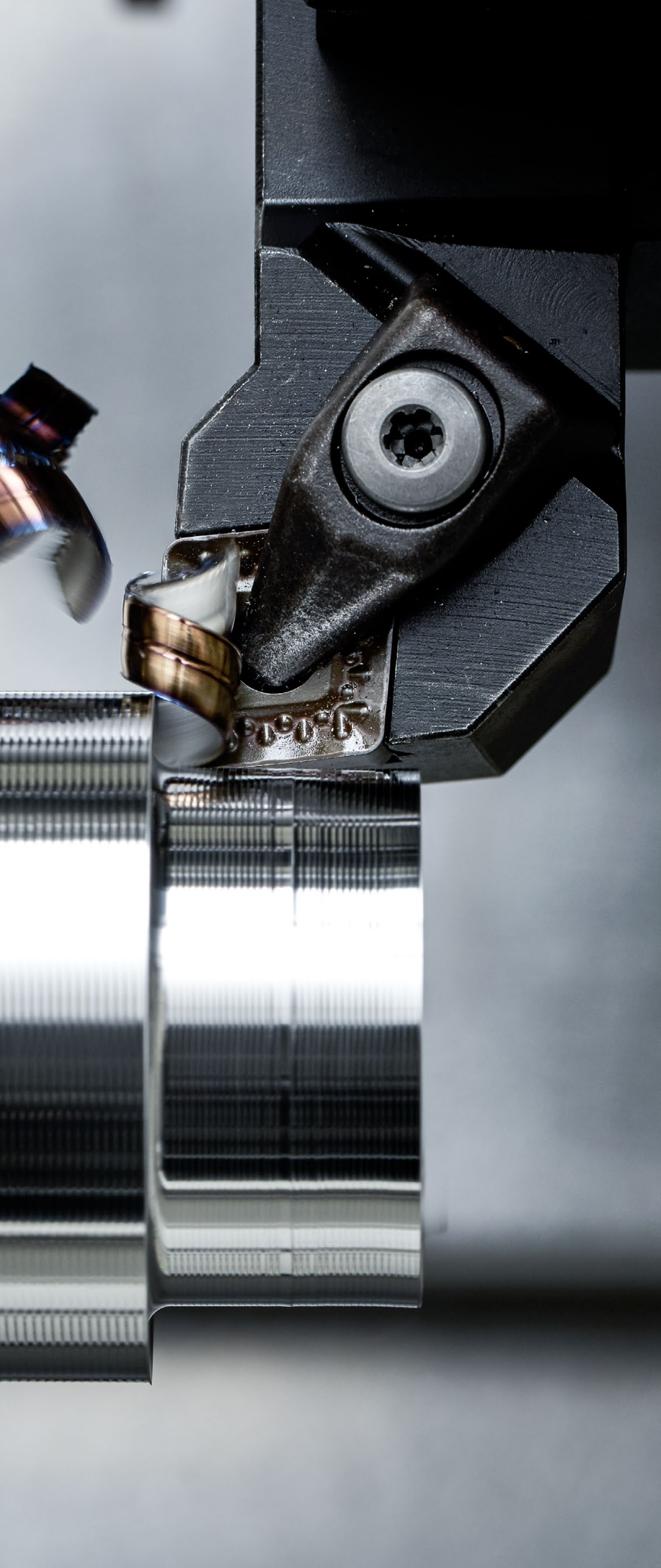
Coated and uncoated CBN grade for smooth cutting from 32 HRC.

NEW Precision sintered insert with -29 chip breaker



Comprehensive aluminum turning insert with -29 chip breaker for medium to rough machining. Uncoated and with proven AMZ coating.





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

9 Turning Tools

9

Turning

10 EcoCut

11 Grooving Tools

12 Miniature turning tools

Milling

13 HSS Milling Cutters

14 Solid Carbide milling cutters

15 Milling tools with indexable inserts

Tool Clamping

16 Adapters

17 Accessories

18 Material examples and article no. index

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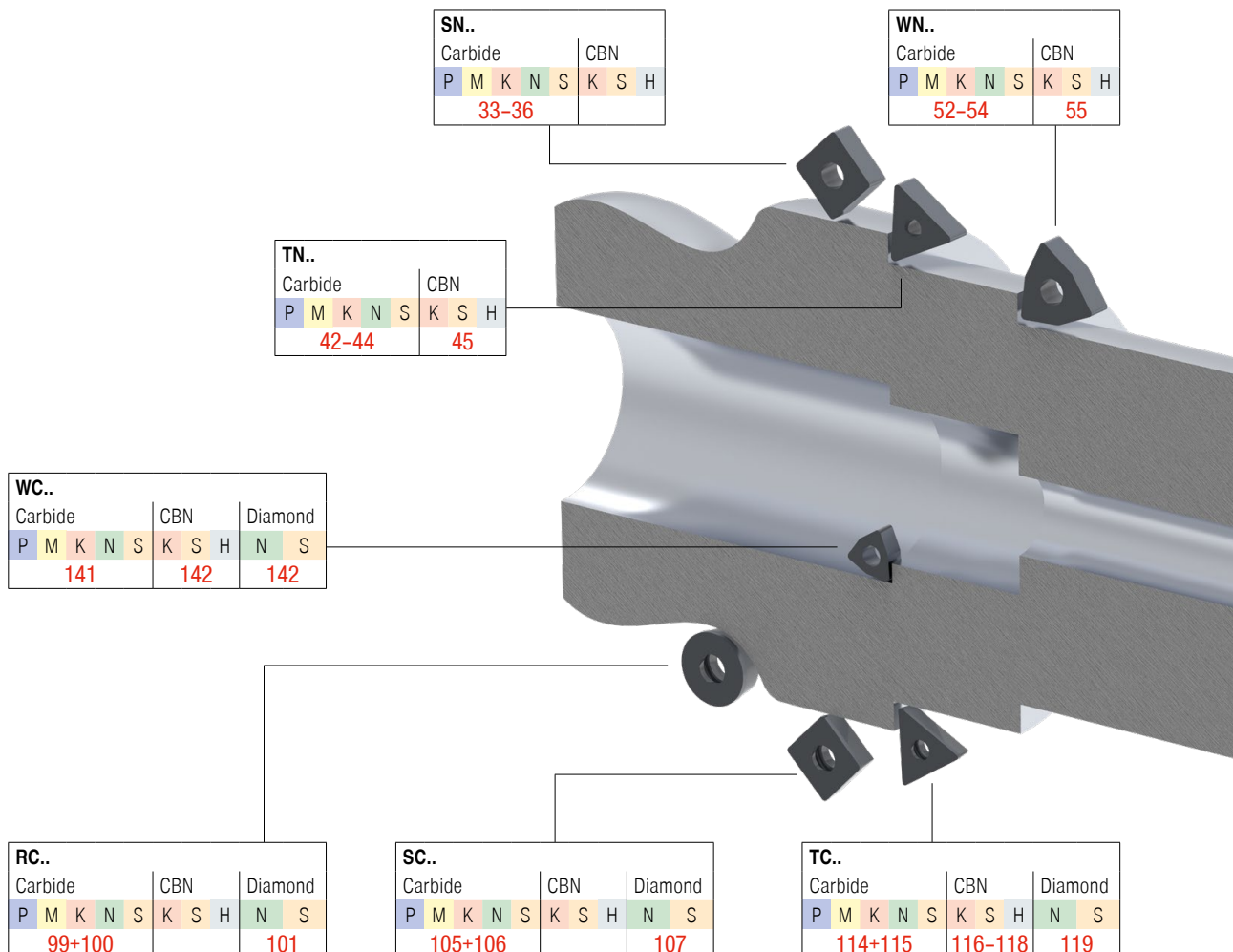
Symbol explanation / Coding of the chip breaker	3
Toolfinder – Application	2+3
Toolfinder – negative inserts	4+5
Toolfinder – positive inserts	6+7
Product programme	8-143
Technical Information	
Cutting Data	144-167
Chip breakers	168-175
Masterfinish – wiper geometry – notes	176+177
ISO designation system	178-183
Wear types in indexable inserts	184+185
Grades Overview	186+187

CERATIZIT \ Performance

Premium quality tools for high performance.

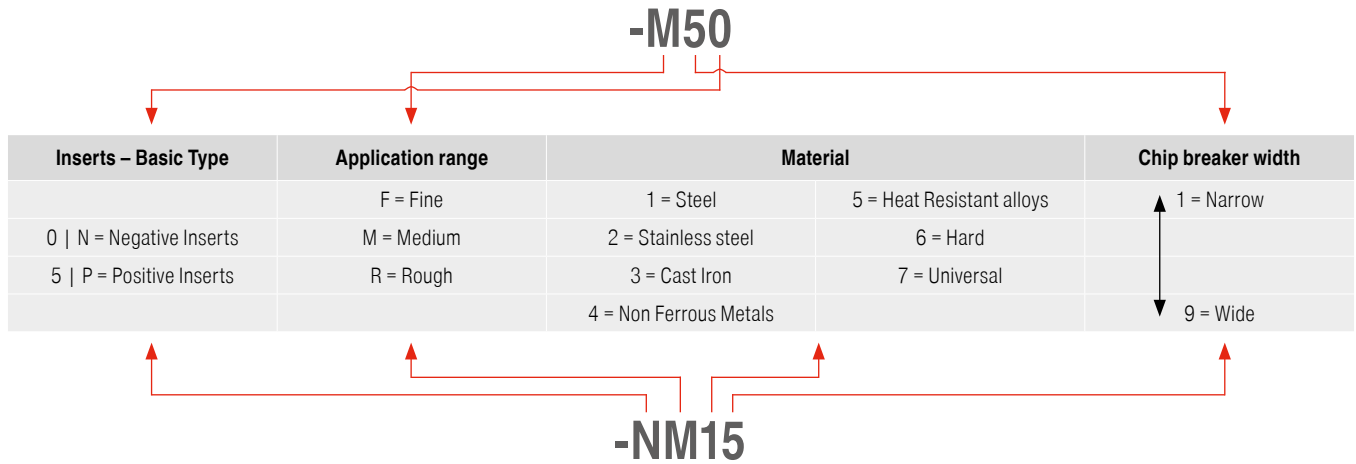
The premium quality tools from the **CERATIZIT Performance** product line have been designed for specific applications and are distinguished by their outstanding performance. If you make high demands on the performance of your production and want to achieve the very best results, we recommend the Premium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

Toolfinder – Application



Coding of the chip breakers

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

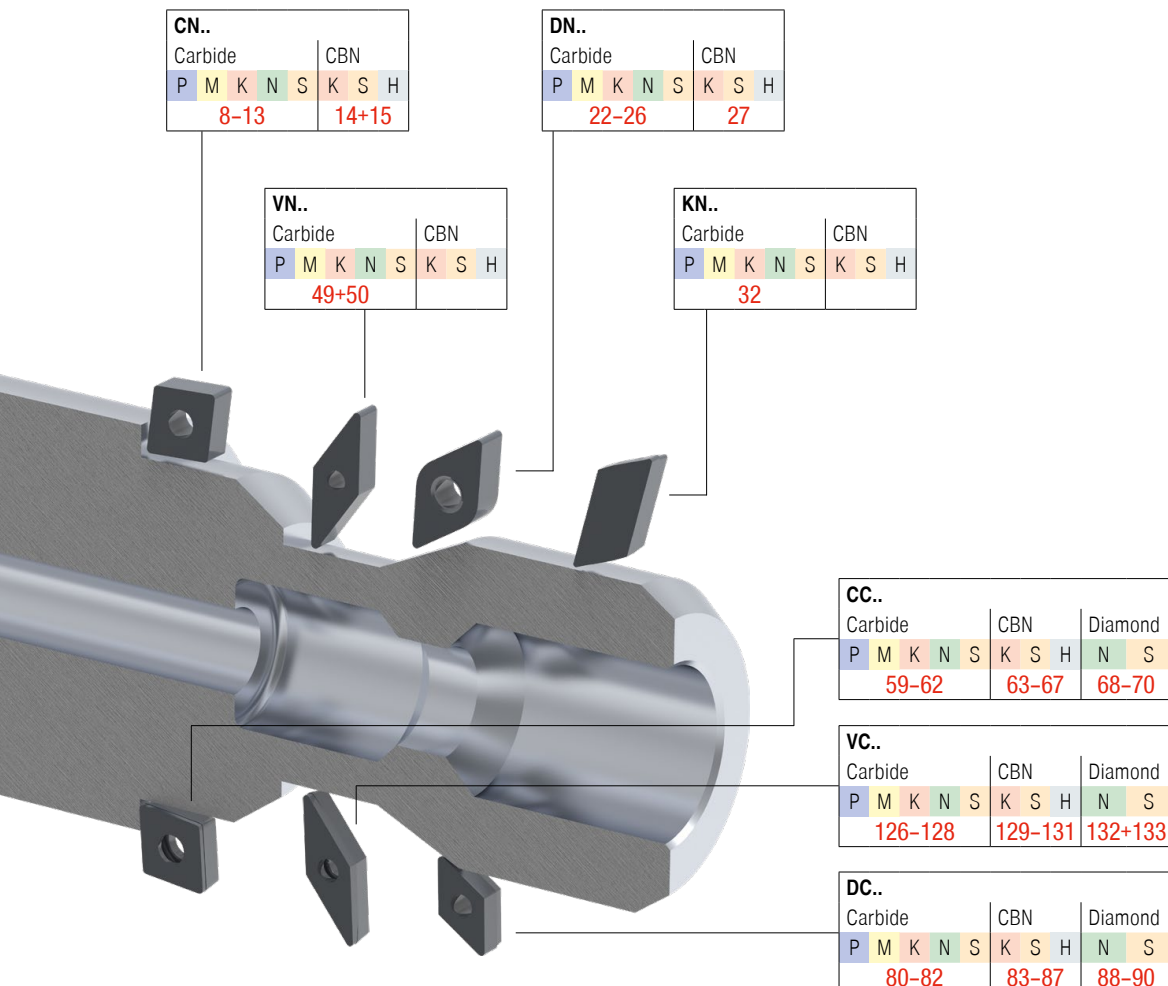


i Detailed information on the chip breakers can be found in the technical appendix → **pages 168–175**

Symbol explanation

CTCP125	<i>Carbide Grade</i>	F Fine Machining	○ ○ ○	○ Smooth cut
HCX1125		M Medium Machining		○ Irregular cutting depth
		R Rough Machining		⊠ Interrupted cut

i A detailed overview of grades can be found in the technical appendix on → **page 186**



Toolfinder – negative inserts



Steel	Stainless steel	Cast iron	Non ferrous metals	Heat resistant alloys
P	M	K	N	S

Geometry

CN..	DN..	KN..	SN..	TN..	VN..	WN..

Main application: Steel and cast iron	sharp stable		<table border="1"> <tr> <td>Steel</td> <td>Stainless steel</td> <td>Cast iron</td> <td>Non ferrous metals</td> <td>Heat resistant alloys</td> </tr> <tr> <td>P</td> <td>M</td> <td>K</td> <td>N</td> <td>S</td> </tr> </table>	Steel	Stainless steel	Cast iron	Non ferrous metals	Heat resistant alloys	P	M	K	N	S	Geometry						
				Steel	Stainless steel	Cast iron	Non ferrous metals	Heat resistant alloys												
				P	M	K	N	S												
				Fine	-CF / -CF20 (-CF / -NF12)		●	○	○			8	22				52			
					-F40		●	○	○							49				
					-F50 (-NF15)		●	○	○	○		8	22		33	42	49	52		
					-TFQ		●	○	○			8+9	22+23					52		
				Medium	-42		●	○		○		9								
					-XU		●	○	○			9	23				49	53		
					-M40		●	○	○							49				
					-M50 (-NM15)		●	○	●	○		9+10	23+24		33	42	49	53		
					-TMQ		●	○	○			10	24					53		
				Rough	-M70 -11, -12 (-NM19)		●	○	●	○		10+11	24	32	33+34	42+43		53		
.NMA		●			●			11	24		34+35	43		54						
-R28 (-NR14)		●	○		○	○		11	24		35	43								
-R58 (-NR17)		●	○		○	○		12	24+25		35	43								
-R88 (-NR19)		●	○		○	○		12			36									
Main application: Stainless	sharp stable		<table border="1"> <tr> <td>Steel</td> <td>Stainless steel</td> <td>Cast iron</td> <td>Non ferrous metals</td> <td>Heat resistant alloys</td> </tr> <tr> <td>P</td> <td>M</td> <td>K</td> <td>N</td> <td>S</td> </tr> </table>	Steel	Stainless steel	Cast iron	Non ferrous metals	Heat resistant alloys	P	M	K	N	S	Geometry						
				Steel	Stainless steel	Cast iron	Non ferrous metals	Heat resistant alloys												
				P	M	K	N	S												
				Fine	-F30 (-NF23)		○	●				12	25		36	44	49	54		
					-42		○	●		●		13								
				Medium	-M30 (-NM23)		○	●		○		13	25		36	44	49	54		
					-M42		○	●		●		13	25		36	44		54		
-M60 (-NM26)		○	●			○		13	25		36	44		54						
-M70 (-NM19)		○	●		●		13	25		36	44		54							
Main application: Heat-resistant	sharp stable		<table border="1"> <tr> <td>Steel</td> <td>Stainless steel</td> <td>Cast iron</td> <td>Non ferrous metals</td> <td>Heat resistant alloys</td> </tr> <tr> <td>P</td> <td>M</td> <td>K</td> <td>N</td> <td>S</td> </tr> </table>	Steel	Stainless steel	Cast iron	Non ferrous metals	Heat resistant alloys	P	M	K	N	S	Geometry						
				Steel	Stainless steel	Cast iron	Non ferrous metals	Heat resistant alloys												
				P	M	K	N	S												
				Fine	-F32		●	○	○	●		13	25				49			
					-M34		○			●		13	26		36	44	49+50	54		
Medium	-M42		○	●	○	○	●	13	26			44		54						
	-M52		○	○	○	●		13	26		36	44		54						
Suitable tool holders								16-19	28+29	32	37-40	46+47	51	56						
Suitable boring bars								20+21	30+31		41	48		57+58						

Toolfinder – negative inserts



Material	Cast Iron K	Sintered steels P	Heat-resistant S	Hardened H	Geometry						
					CN..	DN..	KN..	SN..	TN..	VN..	WN..

Main application: Cast iron, sintered steels, heat resistant, hardened	Fine	CTBS10U (PBC10) CTBS20C (PBC15-S)		•	•	•			14	27			45		55	
		CTBH15U CTBH15C	< 32 HRC				•		14	27						
		CTBH21U (PBC25)	52-65 HRC				•		15	27				45		55
		CTBH20C (PBC25-S)	48-62 HRC				•									
		CTBH40U (PBC40)	54-65 HRC				•		15	27				45		55
		CTBH40C (PBC40-S)	48-65 HRC				•									
	Suitable tool holders								16-19	28+29				46+47		56
	Suitable boring bars								20+21	30+31				48		57+58

Toolfinder – positive inserts



			Steel	Stainless steel	Cast iron	Non-ferrous metals	Heat-resistant	Geometry										
			P	M	K	N	S	CC..	DC..	RC..	SC..	SP..	TC..	TP..	VC..	WC..		
Main application: Steel and cast iron	sharp	Fine	-CF05 (-PF14)	●	○	○			59	80		105		114		126		
		-SF (-ZF)	●	○	○	○		59+60	80		105		114		126			
	stable	Medium	-CF55 (-PF15)	●	○	○			60	80		105		114		126		
		-SMF	●	○	●	○		60	80	99	105		114+115		126+127			
		-SM (-ZM)	●	○	●	○		60	80+81	99	105		115		127			
		-SMQ	●	○	○			60+61	81									
		EN, EL, ER	●	○	●	○						105	113		123			
Main application: Stainless	sharp	Fine	-SF (-ZF)	○	●		●	61	81						127	141		
		-F43	○	●		●	61	81				115						
		-M81	○	●		○	61	81							127			
	stable	Medium	-M25 (-PF23)	○	●			61	81				115		127			
		-SM (-ZM)	○	●		●	61	81		105		115		127				
		-M55 (-PF26)	○	●			61	81		106		115		127				
Main application: Non-ferrous metals	sharp	Fine	-23P	○	○	○	●	61	82									
		-25P	○	○	○	●	61	82		106					127			
		Medium	-25Q	○	○	○	●	61	82							128		
		-27 (-AL)	○	○	○	●	61+62	82	99+100	106		115		128				
		-29	○	○	○	●	62	82						128				
	stable	Diamond	-CB1	○	○	○	●	69+70	89+90	101	107		119		133			
		-CB2	○	○	○	●	69+70	90	101	107		119		133				
		-CB3	○	○	○	●	70	90		107		119		133				
		Smooth		○	○	○	●	68+69	88-90				119		132	142		
				Suitable tool holders		71-74	91-93	102-104	108-110		120+121	124	134-137					
		Suitable boring bars		75-79	94-98		111+112		122	125	138-140	143						

Toolfinder – positive inserts



Steel	Stainless steel	Cast iron	Non-ferrous metals	Heat-resistant
P	M	K	N	S

Geometry

CC..	DC..	RC..	SC..	SP..	TC..	TP..	VC..	WC..

Main application: Heat-resistant	sharp ↕ stable	Fine	-F05 (-F05)		●	●	○	○	●		82							128
			-F23 (-F23)			●	○	○	●	62	82							

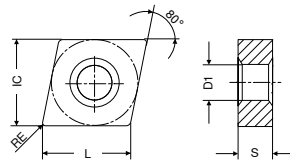
Cast iron	Sintered steels	Heat-resistant	Hardened
K	P	S	H

Main application: Cast iron, sintered steels, heat resistant, hardened	Fine	CTBS10U (PBC10) CTBS20C (PBC15-S)		●	●	●			63+64	83+84					116			129+130	142	
		CTBH15U CTBH15C	< 32 HRC			●			65	85					116-118			129+130	142	
		CTBH21U (PBC25)	52-65 HRC				●		66	85-87					117+118			130+131	142	
		CTBH20C (PBC25-S)	48-62 HRC				●													
		CTBH40U (PBC40)	54-65 HRC					●		67	85-87					117+118			130+131	142
		CTBH40C (PBC40-S)	48-65 HRC					●												

Suitable tool holders	71-74	91-93	102-104	108-110		120+121	124	134-137	
Suitable boring bars	75-79	94-98		111+112		122	125	138-140	143

CNMG / CNMA / CNMM / CNGP

Designation	L	S	D1	IC
	mm	mm	mm	mm
CNMG 0903..	9.7	3.18	3.81	9.52
CN.. 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	-F50 CTCP115	-F50 CTCP125	-F50 CTCP135	-TFQ CTEP110	-TFQ CTCP115	
		-CF CWC10	-NF12 DCC1110	-NF15 HCX1115	-NF15 HCX1125	-NF15 HCR1135	-TFQ DCC1110	-TFQ HCX1115	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		F	F	F	F	F	F	F	
		CERMET CNMG	CERMET CNMG	CNMG	CNMG	CNMG	CERMET CNMG	CNMG	
		1A/78	1A/78	1A/08	1A/08	1A/08	1A/78	1A/08	
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	
	mm	70 101 ...	76 101 ...	76 132 ...	76 132 ...	76 132 ...	76 110 ...	76 110 ...	
		£	£	£	£	£	£	£	
090304EN	0.4			6.75 316	6.77 516	6.75 716			
090308EN	0.8			6.75 318	6.77 518	6.75 718			
120404EN	0.4	8.80 904	9.19 028	10.38 328	10.38 528	10.38 728	10.68 028	11.90 328	
120408EN	0.8	8.80 908	9.19 030	10.38 330	10.38 530	10.38 730	10.68 030	11.90 330	
120412EN	1.2			10.38 332	10.38 532	10.38 732	10.68 032	11.90 320	
Steel		●	●	●	●	●	●	●	
Stainless steel			○	○	○	○	○	○	
Cast iron		○	○	○	○	○	○	○	
Non ferrous metals									
Heat resistant alloys						○			


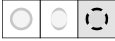


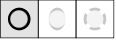

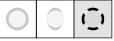
CNMG

		-TFQ CTCP125		-42 CTCP135		-XU CTCP115		-XU CTCP125		-M50 CTCK110		-M50 CTCK120		-M50 CTCP115	
		-TFQ HCX1125		-42 HCR1135		-XU HCX1115		-XU HCX1125		-NM15 DCX3110		-NM15 HCF3120		-NM15 HCX1115	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		F		M		M		M		M		M		M	
		CNMG		CNMG		CNMG		CNMG		CNMG		CNMG		CNMG	
		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08	
ISO	RE	Article no.		Article no.		Article no.		Article no.		Article no.		Article no.		Article no.	
	mm	£		£		£		£		£		£		£	
120404EN	0.4	11.90	528			10.42	328	10.42	528	10.38	028			10.38	328
120408EN	0.8	11.90	530	10.38	730	10.42	330	10.42	530	10.38	030	10.38	530	10.38	330
120412EN	1.2	11.90	532			10.42	332	10.42	532	10.38	032	10.38	532	10.38	320
120416EN	1.6													10.38	334
160608EN	0.8													16.78	342
160612EN	1.2													16.78	344
160616EN	1.6													16.78	346
Steel			●		●		●		●		●		●		●
Stainless steel			○		○		○		○		○		○		○
Cast iron			○		○		○		○		●		●		○
Non ferrous metals															
Heat resistant alloys					○										

CNMG

		-M50 CTCP125		-M50 CTCP135		-TMQ CTCP115		-TMQ CTCP125		-M70 CTCK110		-M70 CTCK120		-M70 CTCP115	
		-NM15 HCX1125		-NM15 HCR1135		-TMQ HCX1115		-TMQ HCX1125		-NM19 DCX3110		-NM19 HCF3120		-NM19 HCX1115	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		M		M		M		M		M		M		M	
		CNMG		CNMG		CNMG		CNMG		CNMG		CNMG		CNMG	
		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08	
ISO	RE	Article no.		Article no.		Article no.		Article no.		Article no.		Article no.		Article no.	
	mm	£		£		£		£		£		£		£	
120404EN	0.4	10.38	528	10.38	728					10.38	030	10.38	530	10.38	330
120408EN	0.8	10.38	530	10.38	730			11.90	530	10.38	032	10.38	532	10.38	320
120412EN	1.2	10.38	532	10.38	732	11.90	320	11.90	532	10.38	034	10.38	534	10.38	320
120416EN	1.6	10.38	534	10.38	734					10.38	034	10.38	534	10.38	334
160608EN	0.8	16.78	542	16.78	742					16.78	042	16.78	542	16.78	342
160612EN	1.2	16.78	544	16.78	744					16.78	044	16.78	544	16.78	344
160616EN	1.6	16.78	546	16.78	746					16.78	046	16.78	546	16.78	346
160624EN	2.4													16.78	348
190608EN	0.8													23.70	354
190612EN	1.2									23.70	056	23.70	556	23.70	356
190616EN	1.6									23.70	058	23.70	558	23.70	358
190624EN	2.4													23.70	360
Steel		●		●		●		●		●		●		●	
Stainless steel		○		○		○		○		○		○		○	
Cast iron		○				○		○		●		●		○	
Non ferrous metals															
Heat resistant alloys				○											

CNMG / CNMA / CNMM

		-M70 CTCP125		-M70 CTCP135		CTCK110		CTCK120		-R28 CTCP115		-R28 CTCP125		-R28 CTCP135	
		-NM19 HCX1125		-NM19 HCR1135		DCX3110		HCF3120		-NR14 HCX1115		-NR14 HCX1125		-NR14 HCR1135	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
		M		M		R		R		R		R		R	
		CNMG		CNMG		CNMA		CNMA		CNMM		CNMM		CNMM	
		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08	
ISO	RE	Article no.		Article no.		Article no.		Article no.		Article no.		Article no.		Article no.	
	mm	76 119 ...		76 119 ...		70 100 ...		70 100 ...		76 114 ...		76 114 ...		76 114 ...	
		£		£		£		£		£		£		£	
120404EN	0.4					10.38	028	10.38	528						
120408EN	0.8	10.38	530	10.38	730	10.38	030	10.38	530	10.57	330	10.57	530		
120412EN	1.2	10.38	532	10.38	732	10.38	032	10.38	532	10.57	332	10.57	532	10.57	732
120416EN	1.6	10.38	534	10.38	734	10.38	034	10.38	534	10.57	334	10.57	534	10.57	734
160608EN	0.8	16.78	542	16.78	742	16.78	042	16.78	542						
160612EN	1.2	16.78	544	16.78	744	16.78	044	16.78	544	16.78	344	16.78	544	16.78	744
160616EN	1.6	16.78	546	16.78	746	16.78	046	16.78	546	16.78	346	16.78	546	16.78	746
160624EN	2.4	16.78	548	16.78	748										
190608EN	0.8	23.70	554	23.70	754										
190612EN	1.2	23.70	556	23.70	756	23.70	056	23.70	556	23.70	356	23.70	556	23.70	756
190616EN	1.6	23.70	558	23.70	758	23.70	058	23.73	558	23.70	358	23.70	558	23.70	758
190624EN	2.4	23.70	560	23.70	760					23.70	360	23.70	560	23.70	760
250924EN	2.4									54.71	38400	54.71	58400	54.71	78400
Steel		●		●						●		●		●	
Stainless steel		○		○						○		○		○	
Cast iron		○				●		●		○		○			
Non ferrous metals															
Heat resistant alloys				○										○	

CNMM / CNMG

		-R58 CTCP115		-R58 CTCP125		-R58 CTCP135		-R88 CTCP115		-R88 CTCP125		-R88 CTCP135		-F30 CTPM125	
		-NR17 HCX1115		-NR17 HCX1125		-NR17 HCR1135		-NR19 HCX1115		-NR19 HCX1125		-NR19 HCR1135		-NF23 HCN2125	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		R		R		R		R		R		R		F	
		CNMM		CNMM		CNMM		CNMM		CNMM		CNMM		CNMG	
		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08	
ISO	RE	Article no.		Article no.		Article no.		Article no.		Article no.		Article no.		Article no.	
	mm	76 115 ...	76 115 ...	76 115 ...	76 115 ...	76 133 ...	76 133 ...	76 133 ...	76 133 ...	76 133 ...	76 133 ...	75 010 ...	75 010 ...	75 010 ...	75 010 ...
		£	£	£	£	£	£	£	£	£	£	£	£	£	£
120404EN	0.4														
120408EN	0.8	10.57	330	10.57	530	10.57	730							10.38	280
120412EN	1.2	10.57	332	10.57	532	10.57	732							10.38	230
120416EN	1.6	10.57	334	10.57	534	10.57	734								
160612EN	1.2	16.78	344	16.78	544	16.78	744								
160616EN	1.6	16.78	346	16.78	546	16.78	746								
160624EN	2.4	16.78	348	16.78	548	16.78	748								
160624SN	2.4							16.78	348	16.78	548	16.78	748		
190612EN	1.2	23.70	356	23.70	556	23.70	756								
190616EN	1.6	23.70	358	23.70	558	23.70	758								
190616SN	1.6							23.70	358	23.70	558	23.70	758		
190624EN	2.4	23.70	360	23.70	524	23.70	760								
190624SN	2.4							23.70	360	23.70	560	23.70	760		
250924EN	2.4	54.71	384	54.71	584	54.71	784								
250924SN	2.4							54.71	384	54.71	584	54.71	784		
Steel		●		●		●		●		●		●		○	
Stainless steel		○		○		○		○		○		○		○	●
Cast iron		○		○				○		○					
Non ferrous metals															
Heat resistant alloys						○						○			

CNMG / CNGP

		-42 CTC2135	-M30 CTPM125	-M42 CTC2135	-M60 CTPM125	-M70 CTC2135	-F32 CTP2120	-M34 CTP5110
		-42 CWN2135	-NM23 HCN2125	-M42 CWN2135	-NM26 HCN2125	-NM19 CWN2135	-F32 CCN2120	-M34 HCN5110
		M CNMG	M CNMG	M CNMG	M CNMG	M CNMG	F CNGP	M CNMG
		1A/08	1A/08	1A/08	1A/08	1A/08	1A/08	1A/08
ISO	RE	Article no. 70 103 ...	Article no. 75 011 ...	Article no. 70 130 ...	Article no. 75 012 ...	Article no. 70 119 ...	Article no. 70 102 ...	Article no. 75 003 ...
	mm	£	£	£	£	£	£	£
120402FN	0.2						13.94 602	
120404EN	0.4			9.30 404				9.77 428
120404FN	0.4						13.94 604	
120408EN	0.8	9.30 462	10.38 230	9.30 408	10.38 230	9.30 430	13.94 608	9.77 430
120408FN	0.8							
120412EN	1.2		10.38 232	9.30 410	10.38 232	9.30 432		9.77 432
120416EN	1.6		10.38 234		10.38 234			
160612EN	1.2					16.78 442		
190612EN	1.2					23.70 456		
190616EN	1.6					23.70 458		
Steel		○	○	○	○	○	○	○
Stainless steel		●	●	●	●	●	●	○
Cast iron							○	
Non ferrous metals							○	
Heat resistant alloys		●	○	●	○	●	●	●

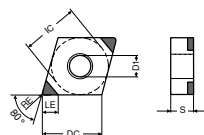
9

CNMG

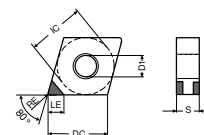
		-M34 CTP5115	-M42 CTP2120	-M52 CTP2120
		-M34 HCN5115	-M42 CCN2120	-M52 CCN2120
		M CNMG	M CNMG	M CNMG
		1A/08	1A/08	1A/08
ISO	RE	Article no. 75 003 ...	Article no. 70 130 ...	Article no. 70 117 ...
	mm	£	£	£
120404EN	0.4	9.77 528	9.30 604	9.30 604
120408EN	0.8	9.77 530	9.30 608	9.30 608
120412EN	1.2	9.77 532		
120416EN	1.6	9.77 534		
Steel			○	○
Stainless steel			○	○
Cast iron			○	○
Non ferrous metals			○	○
Heat resistant alloys		●	●	●

CNGA

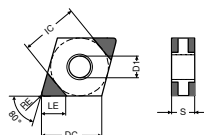
Designation	L	S	D1	IC
	mm	mm	mm	mm
CNGA 1204..	12.9	4.76	5.13	12.7



-B

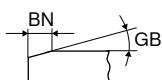


-K (-2SC)



-L (-4SC)

CNGA

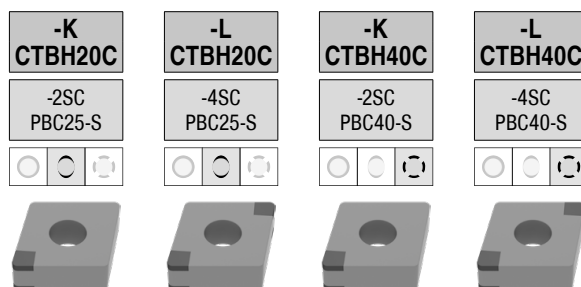


-K CTBS20C	-L CTBS20C	-B CTBH15C	-B CTBH15C
-2SC PBC15-S	-4SC PBC15-S		
F	F	F	F
CBN CNGA	CBN CNGA	CBN CNGA	CBN CNGA

ISO	RE	GB	BN	LE	-K CTBS20C		-L CTBS20C		-B CTBH15C		-B CTBH15C	
					Article no. 71 400 ...	£	Article no. 71 401 ...	£	Article no. 71 003 ...	£	Article no. 71 005 ...	£
120404SN	0.4	10	0.09	2.8			84.59	122				
120404SN	0.4	15	0.09	2.8			84.59	132				
120404SN	0.4	15	0.11	2.8	54.73	142			79.70	32814		
120404SN	0.4	15	0.11	3.0								
120404SN	0.4	20	0.09	2.8			84.59	152				
120404SN	0.4	20	0.14	2.8	54.73	162						
120404SN	0.4	25	0.13	3.0					79.70	32829		
120404SN	0.4	30	0.18	2.8	54.73	182	84.59	182				
120404RN	0.4			3.0					79.70	22800		
120408SN	0.8	10	0.09	2.5			84.59	124				
120408SN	0.8	15	0.09	2.5			84.59	134				
120408SN	0.8	15	0.11	2.5	54.73	144						
120408SN	0.8	15	0.11	2.7					79.70	33014		
120408SN	0.8	20	0.09	2.5			84.59	154				
120408SN	0.8	20	0.14	2.5	54.73	164						
120408SN	0.8	25	0.13	2.7					79.70	33029		
120408SN	0.8	30	0.18	2.5	54.73	184	84.59	184				
120408RN	0.8			2.7					79.70	23000		
120412SN	1.2	10	0.09	2.2			84.59	126				
120412SN	1.2	15	0.09	2.2			84.59	136				
120412SN	1.2	15	0.11	2.2	54.73	146					79.70	33214
120412SN	1.2	15	0.11	2.4								
120412SN	1.2	20	0.09	2.2			84.59	156				
120412SN	1.2	20	0.14	2.2	54.73	166						
120412SN	1.2	25	0.13	2.4							79.70	33229
120412SN	1.2	30	0.18	2.2	54.73	186	84.59	186				
120412RN	1.2			2.4							79.70	23200

Cast iron	•	•		
Sintered steels	•	•		
Heat resistant alloys	•	•		
hardened < 45 HRC			•	•
hardened 46–55 HRC			•	•
hardened 56–60 HRC			•	•
hardened 61–65 HRC				

CNGA

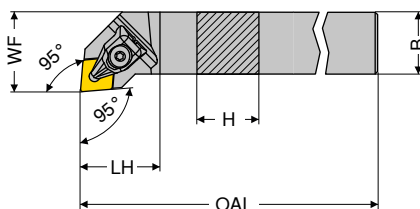


ISO	RE mm	GB °	BN mm	LE mm	-K CTBH20C		-L CTBH20C		-K CTBH40C		-L CTBH40C	
					Article no. 71 400 ...	£	Article no. 71 401 ...	£	Article no. 71 400 ...	£	Article no. 71 401 ...	£
120404TN	0.4	15	0.09	2.8	54.73	222						
120404SN	0.4	20	0.09	2.8							84.59	332
120404SN	0.4	20	0.11	2.8			84.59	242				
120404TN	0.4	25	0.11	2.8	54.73	252						
120404SN	0.4	25	0.11	2.8					54.73	352	84.59	352
120404SN	0.4	25	0.13	2.8			84.59	262				
120404FN	0.4			2.8	54.73	212						
120404SN	0.4	30	0.14	2.8							84.59	372
120404SN	0.4	35	0.14	2.8					54.73	382		
120408TN	0.8	15	0.09	2.5	54.73	224						
120408TN	0.8	20	0.09	2.5	54.73	234						
120408SN	0.8	20	0.09	2.5							84.59	334
120408SN	0.8	20	0.11	2.5			84.59	244				
120408TN	0.8	25	0.11	2.5	54.73	254						
120408SN	0.8	25	0.11	2.5					54.73	354	84.59	354
120408SN	0.8	25	0.13	2.5			84.59	264			84.59	364
120408SN	0.8	30	0.14	2.5			84.59	274			84.59	374
120408SN	0.8	35	0.14	2.5					54.73	384		
120408EN	0.8			2.5					54.73	314		
120412TN	1.2	15	0.09	2.2	54.73	226						
120412SN	1.2	20	0.09	2.2							84.59	336
120412SN	1.2	20	0.11	2.2			84.59	246				
120412TN	1.2	25	0.11	2.2	54.73	256						
120412SN	1.2	25	0.11	2.2					54.73	356	84.59	356
120412SN	1.2	25	0.13	2.2			84.59	266			84.59	366
120412SN	1.2	30	0.14	2.2							84.59	376
120412SN	1.2	35	0.14	2.2					54.73	386		
120412FN	1.2			2.2	54.73	216						

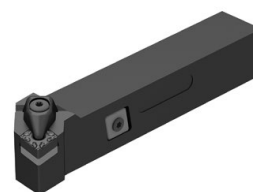
Cast iron				
Sintered steels				
Heat resistant alloys				
hardened < 45 HRC				
hardened 46–55 HRC		•	•	•
hardened 56–60 HRC		•	•	•
hardened 61–65 HRC				•

i For fast and efficient determination of the most appropriate edge preparation CNGA test inserts are available. → Page 161

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



Illustrations show right-hand versions

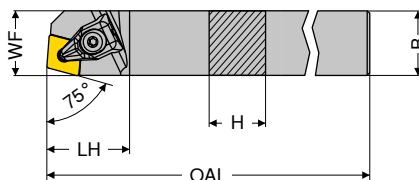


ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 509 ...	£	Article no. 70 508 ...	£
DCLN R/L 1616 H09	16	16	100	23	20	2	CN.. 0903	69.39	516	69.39	516
DCLN R/L 2020 K09	20	20	125	24	25	2	CN.. 0903	77.31	520	77.31	520
DCLN R/L 2020 K12	20	20	125	32	25	4	CN.. 1204	77.31	620	77.31	620
DCLN R/L 2525 M12	25	25	150	32	32	4	CN.. 1204	79.97	625	79.97	625
DCLN R/L 3225 P12	32	25	170	32	32	4	CN.. 1204	85.79	632	85.79	632
DCLN R/L 2525 M16	25	25	150	38	32	6,5	CN.. 1606	79.97	725	79.97	725
DCLN R/L 3232 P16	32	32	170	36	40	6,5	CN.. 1606	108.00	732	108.00	732
DCLN R/L 3232 P19	32	32	170	42	40	6,5	CN.. 1906	108.00	832	108.00	832
DCLN R/L 4040 S19	40	40	250	42	50	6,5	CN.. 1906	134.27	940	134.27	940
DCLN R/L 4040 S25	40	40	250	60	50	6,5	CN.. 2509	134.27	440	134.27	440

i Tool holders with HSK-T or PSC interface can be found in → Chapter 16.

Spare parts for Article no.	2A/28 XPress type		Y7 Key D		2A/28 Clamping screw		2A/28 Carbide type C			
	Article no. 70 950 ...	£	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£		
70 508 516 / 70 509 516	21.91	823	T09 - IP	14.77	126	M3x7 - IP	2.85	819	6.47	848
70 508 520 / 70 509 520	21.91	823	T09 - IP	14.77	126	M3x7 - IP	2.85	819	6.47	848
70 508 620 / 70 509 620	21.61	824	T15 - IP	15.77	128	M4,5x12 - IP	2.71	820	7.17	810
70 508 625 / 70 509 625	21.61	824	T15 - IP	15.77	128	M4,5x12 - IP	2.71	820	7.17	810
70 508 632 / 70 509 632	21.61	824	T15 - IP	15.77	128	M4,5x12 - IP	2.71	820	7.17	810
70 508 725 / 70 509 725	24.26	825	T20 - IP	16.56	129	M5x14 - IP	3.85	821	10.95	814
70 508 732 / 70 509 732	24.26	825	T20 - IP	16.56	129	M5x14 - IP	3.85	821	10.95	814
70 508 832 / 70 509 832	26.54	826	T20 - IP	16.56	129	M5x14 - IP	3.85	821	11.74	816
70 508 940 / 70 509 940	26.54	826	T20 - IP	16.56	129	M5x14 - IP	3.85	821	11.74	816
70 508 440 / 70 509 440	41.34	827	T25 - IP	19.11	130	M6x16 - IP	7.31	822	22.50	625

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



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 501 ...	£	Article no. 70 500 ...	£
DCBN R/L 2525 M12	25	25	150	32	22	4	CN.. 1204	77.31	825	77.31	825

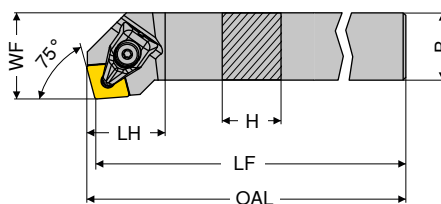
Spare parts

for Article no.

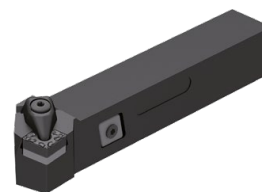
70 501 825 / 70 500 825

2A/28	Y7	2A/28	2A/28
XPress type	Key D	Clamping screw	Carbide type C
Article no. 70 950 ...	Article no. 80 950 ...	Article no. 70 950 ...	Article no. 70 950 ...
£ 21.61	£ 15.77	£ 2.71	£ 7.17
824	128	820	810

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



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LF mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 505 ...	£	Article no. 70 504 ...	£
DCKN R/L 2525 M12	25	25	152.9	150	28.9	32	4	CN.. 1204	77.31	825	77.31	825

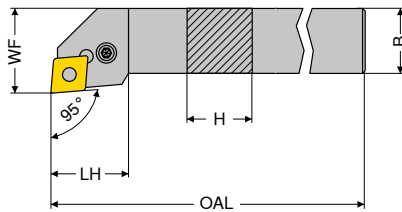
Spare parts

for Article no.

70 505 825 / 70 504 825

2A/28	Y7	2A/28	2A/28
XPress type	Key D	Clamping screw	Carbide type C
Article no. 70 950 ...	Article no. 80 950 ...	Article no. 70 950 ...	Article no. 70 950 ...
£ 21.61	£ 15.77	£ 2.71	£ 7.17
824	128	820	810

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



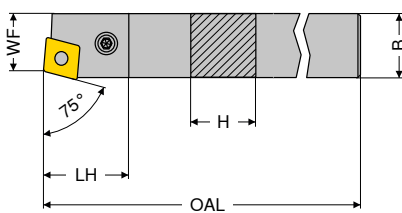
Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 509 ...	£	Article no. 70 508 ...	£
PCLN R/L 1616 H12	16	16	100	26.2	20	4	CN.. 1204	69.39	016	69.39	016
PCLN R/L 2020 K12	20	20	125	27.5	25	4	CN.. 1204	77.31	020	77.31	020
PCLN R/L 2525 M12	25	25	150	28.1	32	4	CN.. 1204	79.97	025	79.97	025
PCLN R/L 3225 P12	32	25	170	28.1	32	4	CN.. 1204	85.79	032	85.79	032
PCLN R/L 2525 M16	25	25	150	32.7	32	4	CN.. 1606	79.97	125	79.97	125
PCLN R/L 3232 P16	32	32	170	32.6	40	4	CN.. 1606	108.00	132	108.00	132
PCLN R/L 3232 P19	32	32	170	38.0	40	8	CN.. 1906	108.00	232	108.00	232
PCLN R/L 4040 S25	40	40	250	50.0	50	8	CN.. 2509	134.27	340	134.27	340

Spare parts for Article no.	Key I	Shim	Assembly pin	Lever	Clamping screw	Carbide type C	Article no. 70 950 ...		Article no. 70 950 ...		Article no. 70 950 ...		Article no. 70 950 ...		Article no. 70 950 ...	
							£		£		£		£		£	
70 508 016 / 70 509 016	SW3	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	7.17	233			
70 508 020 / 70 509 020	SW3	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	7.17	233			
70 508 025 / 70 509 025	SW3	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	7.17	233			
70 508 032 / 70 509 032	SW3	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	7.17	233			
70 508 125 / 70 509 125	SW3	2.23	176	1.02	391	1.11	394	11.35	385	3.45	388	11.35	380			
70 508 132 / 70 509 132	SW3	2.23	176	1.02	391	1.11	394	11.35	385	3.45	388	11.35	380			
70 508 232 / 70 509 232	SW4	2.34	396	1.60	392	1.11	395	17.37	386	3.45	389	17.46	381			
70 508 340 / 70 509 340	SW5	3.35	265	1.02	621	1.72	623	23.48	620	2.07	622	22.50	624			

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



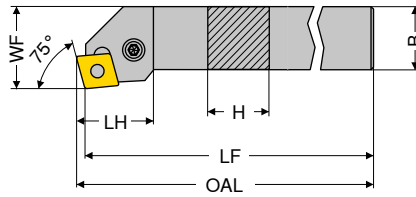
Illustrations show right-hand versions



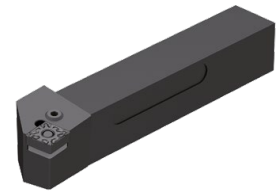
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 501 ...	£	Article no. 70 500 ...	£
PCBN R/L 2525 M12	25	25	150	27.70	22	4	CN.. 1204	77.31	025	77.31	025
PCBN R 2525 M16	25	25	150	31.81	22	4	CN.. 1606			77.31	125
PCBN R/L 3232 P19	32	32	170	38.00	27	8	CN.. 1906	108.00	032	108.00	032

Spare parts for Article no.	Key I	Shim	Assembly pin	Lever	Clamping screw	Carbide type C	Article no. 70 950 ...		Article no. 70 950 ...		Article no. 70 950 ...		Article no. 70 950 ...		Article no. 70 950 ...	
							£		£		£		£		£	
70 500 025 / 70 501 025	SW3	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	7.17	233			
70 500 125	SW3	2.23	176	1.02	391	1.11	394	11.35	385	3.45	388	11.35	380			
70 500 032 / 70 501 032	SW4	2.34	396	1.60	392	1.11	395	17.37	386	3.45	389	17.46	381			

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



Illustrations show right-hand versions



ISO designation	H	B	OAL	LF	LH	WF	torque moment Nm	Insert
	mm	mm	mm	mm	mm	mm		
PCKN R/L 2525 M12	25	25	153.07	150	31.4	32	4	CN.. 1204

Left-hand 2A/24	Right-hand 2A/24
Article no. 70 505 ...	Article no. 70 504 ...
£ 77.31	£ 77.31
025	025

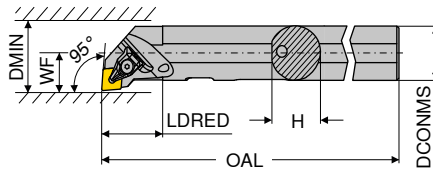
Spare parts

for Article no.

70 505 025 / 70 504 025

2A/28	2A/28	2A/28	2A/28	2A/28	2A/28
Key I	Shim	Assembly pin	Lever	Clamping screw	Carbide type C
Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...
£ 2.23	£ 1.60	£ 1.11	£ 11.45	£ 3.18	£ 7.17
176	198	192	187	209	233

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



Illustrations show right-hand versions

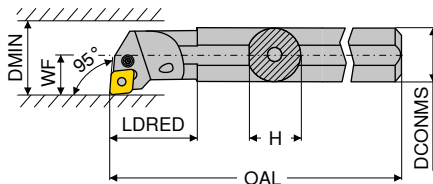
ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 557 ...	£	Article no. 70 556 ...	£
A20Q DCLN R/L 09	20	19	180	35	13	25	2	CN.. 0903	181.27	720	181.27	720
A25R DCLN R/L 12	25	24	200	36	17	32	4	CN.. 1204	202.00	825	202.00	825
A32S DCLN R/L 12	32	31	250	40	22	40	4	CN.. 1204	208.91	832	208.91	832
A40T DCLN R/L 12	40	39	300	45	27	50	4	CN.. 1204	232.73	840	232.73	840

i Tool holders with HSK-T interface can be found in → Chapter 16.

Spare parts	2A/28		Y7		2A/28		2A/28			
	Article no.	£	Article no.	£	Article no.	£	Article no.	£		
for Article no.	70 950 ...		80 950 ...		70 950 ...		70 950 ...			
70 556 720 / 70 557 720	21.91	823	T09 - IP	14.77	126	M3x7 - IP	2.85	819	6.47	848
70 556 825 / 70 557 825	21.61	824	T15 - IP	15.77	128	M4,5x12 - IP	2.71	820	7.17	810
70 556 832 / 70 557 832	21.61	824	T15 - IP	15.77	128	M4,5x12 - IP	2.71	820	7.17	810
70 556 840 / 70 557 840	21.61	824	T15 - IP	15.77	128	M4,5x12 - IP	2.71	820	7.17	810

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

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



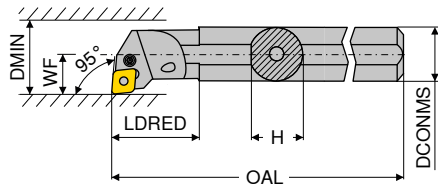
Illustrations show right-hand versions

ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 557 ...	£	Article no. 70 556 ...	£
A25R PCLN R/L 12	25	23	200	36.0	17	32	4	CN.. 1204	202.00	225	202.00	225
S25T PCLN R/L 12	25	23	300	22.0	17	32	4	CN.. 1204	202.00	025	202.00	025
A32S PCLN R/L 12	32	30	250	50.0	22	40	4	CN.. 1204	208.91	232	208.91	232
S32U PCLN R/L 12	32	30	350	24.1	22	40	4	CN.. 1204	208.91	032	208.91	032
A40T PCLN R/L 12	40	38	300	60.0	27	50	4	CN.. 1204	232.73	240	232.73	240
S40V PCLN R/L 12	40	38	400	24.1	27	50	4	CN.. 1204	232.73	040	232.73	040
S50W PCLN R/L 16	50	47	450	31.0	35	63	4	CN.. 1606	288.00	050	288.00	050

Spare parts	2A/28		2A/28		2A/28		2A/28		2A/28		2A/28	
	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£
for Article no.	70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	
70 556 225 / 70 557 225	2.23	176	1.60	198	1.11	192	11.45	187	3.89	205	7.17	233
70 556 025 / 70 557 025	2.23	176	1.60	198	1.11	192	11.45	187	3.89	205	7.17	233
70 556 232 / 70 557 232	2.23	176	1.60	198	1.11	192	11.45	187	3.89	205	7.17	233
70 556 032 / 70 557 032	2.23	176	1.60	198	1.11	192	11.45	187	3.89	205	7.17	233
70 556 240 / 70 557 240	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	7.17	233
70 556 040 / 70 557 040	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	7.17	233
70 556 050 / 70 557 050	2.23	176	1.02	391	1.11	394	11.35	385	3.45	388	11.35	380

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

▲ with carbide core



Illustrations show right-hand versions

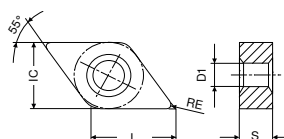
ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 2A		Right-hand 2A	
									Article no. 70 559 ...	Article no. 70 558 ...	Article no. 70 559 ...	Article no. 70 558 ...
E-A25R PCLN R/L 12	25	23	200	40	17	31	4	CN.. 1204	£ 645.09	025	£ 645.09	025
E-A32S PCLN R/L 12	32	30	250	50	22	39	4	CN.. 1204	£ 851.55	032	£ 851.55	032
E-A40T PCLN R/L 12	40	38	300	60	27	48	4	CN.. 1204	£ 1,016.36	040	£ 1,016.36	040

Spare parts for Article no.	2A/28		2A/28		2A/28		2A/28		2A/28		2A/28	
	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
70 558 025 / 70 559 025	SW3	2.23 176	1.60 198	1.11 192	11.45 187	3.89 205	7.17 233					
70 558 032 / 70 559 032	SW3	2.23 176	1.60 198	1.11 192	11.45 187	3.89 205	7.17 233					
70 558 040 / 70 559 040	SW3	2.23 176	1.60 198	1.11 192	11.45 187	3.18 209	7.17 233					



DNMG / DNMA / DNMM / DNGP

Designation	L	S	D1	IC
	mm	mm	mm	mm
DNMG 1104..	11.6	4.76	3.81	9.52
DN.. 1504..	15.5	4.76	5.16	12.70
DN.. 1506..	15.5	6.35	5.16	12.70



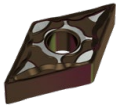
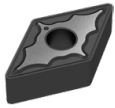
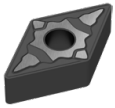
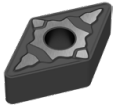
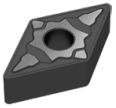
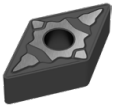
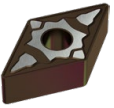
DNMG

		-CF TCM10	-CF20 CTEP110	-F50 CTCP115	-F50 CTCP125	-F50 CTCP135	-TFQ CTEP110	-TFQ CTCP115	
		-CF CWC10	-NF12 DCC1110	-NF15 HCX1115	-NF15 HCX1125	-NF15 HCR1135	-TFQ DCC1110	-TFQ HCX1115	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		F	F	F	F	F	F	F	
		CERMET DNMG 1A/78	CERMET DNMG 1A/78	DNMG 1A/08	DNMG 1A/08	DNMG 1A/08	CERMET DNMG 1A/78	DNMG 1A/08	
ISO	RE	Article no. 70 155 ...	Article no. 76 102 ...	Article no. 76 134 ...	Article no. 76 134 ...	Article no. 76 134 ...	Article no. 76 153 ...	Article no. 76 153 ...	
	mm	£	£	£	£	£	£	£	
110402EN	0.2			11.08 302	11.08 502	11.08 702			
110404EN	0.4	10.57 904	11.08 004	11.08 304	11.08 504	11.08 704			
110408EN	0.8		11.08 006	11.08 306	11.08 506	11.08 706			
110412EN	1.2			11.08 308	11.08 508	11.08 708			
150404EN	0.4			13.43 316	13.43 516	13.43 716			
150408EN	0.8			13.43 318	13.43 518	13.43 718			
150412EN	1.2			13.43 320	13.43 520	13.43 720			
150604EN	0.4	13.85 914	14.55 028	14.55 328	14.55 528	14.55 728	16.17 028	16.78 32800	
150608EN	0.8		14.55 030	14.55 330	14.55 530	14.55 730	16.17 030	16.78 330	
150612EN	1.2		14.55 032	14.55 332	14.55 532	14.55 732			
Steel		●	●	●	●	●	●	●	
Stainless steel			○	○	○	○	○	○	
Cast iron		○	○	○	○	○	○	○	
Non ferrous metals									
Heat resistant alloys						○			

DNMG

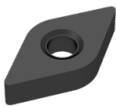
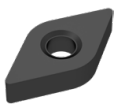
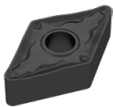
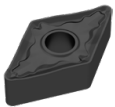
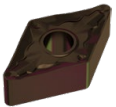

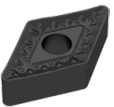
		-TFQ CTCP125	-XU CTCP115	-XU CTCP125	-M50 CTCK110	-M50 CTCK120	-M50 CTCP115	-M50 CTCP125
		-TFQ HCX1125	-XU HCX1115	-XU HCX1125	-NM15 DCX3110	-NM15 HCF3120	-NM15 HCX1115	-NM15 HCX1125
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F	M	M	M	M	M	M
		DNMG	DNMG	DNMG	DNMG	DNMG	DNMG	DNMG
		1A/08	1A/08	1A/08	1A/08	1A/08	1A/08	1A/08
ISO	RE	Article no. 76 153 ...	Article no. 76 291 ...	Article no. 76 291 ...	Article no. 70 133 ...	Article no. 70 133 ...	Article no. 76 136 ...	Article no. 76 136 ...
	mm	£	£	£	£	£	£	£
110404EN	0.4						11.08 304	11.08 504
110408EN	0.8						11.08 306	11.08 506
110412EN	1.2						11.08 308	11.08 508
150404EN	0.4						13.43 316	13.43 514
150408EN	0.8				13.43 018	13.43 518	13.43 318	13.43 518
150412EN	1.2				13.43 020	13.43 520	13.43 320	13.43 516
150416EN	1.6						13.43 322	13.43 522
150604EN	0.4	16.78 528	14.55 328	14.55 528			14.55 328	14.55 528
150608EN	0.8	16.78 530	14.55 330	14.55 530	14.55 030	14.55 530	14.55 330	14.55 530
150612EN	1.2		14.55 332	14.55 532	14.55 032	14.55 532	14.55 332	14.55 532
150616EN	1.6						14.55 334	14.55 534
Steel		●	●	●	●	●	●	●
Stainless steel		○	○	○	○	○	○	○
Cast iron		○	○	○	●	●	○	○
Non ferrous metals								
Heat resistant alloys								

DNMG

		-M50 CTCP135		-TMQ CTCP125		-M70 CTCK110		-M70 CTCK120		-M70 CTCP115		-M70 CTCP125		-M70 CTCP135	
		-NM15 HCR1135		-TMQ HCX1125		-NM19 DCX3110		-NM19 HCF3120		-NM19 HCX1115		-NM19 HCX1125		-NM19 HCR1135	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
		M		M		M		M		M		M		M	
		DNMG		DNMG		DNMG		DNMG		DNMG		DNMG		DNMG	
		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08	
ISO	RE	Article no.		Article no.		Article no.		Article no.		Article no.		Article no.		Article no.	
	mm	£		£		£		£		£		£		£	
110404EN	0.4	11.08	704												
110408EN	0.8	11.08	706							11.08	306	11.08	506	11.08	706
110412EN	1.2	11.08	708							11.08	308	11.08	508	11.08	708
150404EN	0.4	13.43	716												
150408EN	0.8	13.43	718			13.43	018	13.43	518	13.43	318	13.43	518	13.43	718
150412EN	1.2	13.43	720			13.43	020	13.43	520	13.43	320	13.43	520	13.43	720
150416EN	1.6	13.43	722							13.43	322	13.43	522	13.43	722
150604EN	0.4	14.55	728												
150608EN	0.8	14.55	730	16.78	530	14.55	030	14.55	530	14.55	330	14.55	530	14.55	730
150612EN	1.2	14.55	732	16.78	532	14.55	032	14.55	532	14.55	332	14.55	532	14.55	732
150616EN	1.6	14.55	734			14.55	034	14.55	534	14.55	334	14.55	534	14.55	734

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

DNMA / DNMM

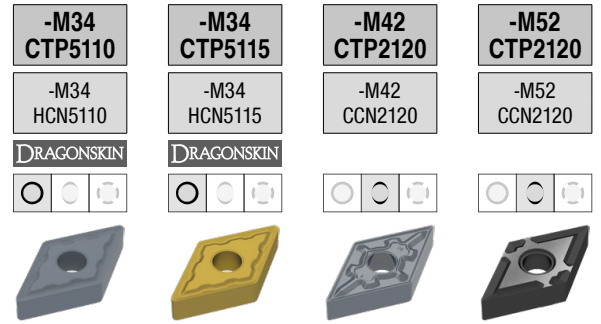
		CTCK110		CTCK120		-R28 CTCP115		-R28 CTCP125		-R28 CTCP135		-R58 CTCP115		-R58 CTCP125	
		DCX3110		HCF3120		-NR14 HCX1115		-NR14 HCX1125		-NR14 HCR1135		-NR17 HCX1115		-NR17 HCX1125	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
		R		R		R		R		R		R		R	
		DNMA		DNMA		DNMM		DNMM		DNMM		DNMM		DNMM	
		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08	
ISO	RE	Article no.		Article no.		Article no.		Article no.		Article no.		Article no.		Article no.	
	mm	£		£		£		£		£		£		£	
150408EN	0.8	13.43	018	13.43	518										
150412EN	1.2	13.43	020	13.43	520										
150608EN	0.8	14.55	030	14.55	530										
150612EN	1.2	14.55	032	14.55	532	14.55	332	14.55	532	14.55	732	14.55	332	14.55	532
150616EN	1.6			14.55	534	14.55	334	14.55	534	14.55	734	14.55	334	14.55	534

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

DNMM / DNMG / DNGP

		-R58 CTCP135		-F30 CTPM125		-M30 CTPM125		-M42 CTC2135		-M60 CTPM125		-M70 CTC2135		-F32 CTP2120	
		-NR17 HCR1135		-NF23 HCN2125		-NM23 HCN2125		-M42 CWN2135		-NM26 HCN2125		-NM19 CWN2135		-F32 CCN2120	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN				DRAGONSKIN					
		R		F		M		M		M		M		F	
		DNMM		DNMG		DNMG		DNMG		DNMG		DNMG		DNGP	
		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08	
ISO	RE	Article no.		Article no.		Article no.		Article no.		Article no.		Article no.		Article no.	
	mm	76 166 ...	75 013 ...	75 014 ...	70 158 ...	75 015 ...	70 263 ...	70 118 ...	£	£	£	£	£	£	£
110404EN	0.4		11.08	204					11.08	600					
110408EN	0.8		11.08	206	11.08	206			11.08	602		11.08	406		
110412EN	1.2				11.08	208									
150402FN	0.2													17.79	602
150404EN	0.4								13.43	614				17.79	604
150404FN	0.4														
150408EN	0.8								13.43	618					
150408FN	0.8													17.79	608
150602FN	0.2													19.43	610
150604EN	0.4		14.55	228					14.55	620				19.43	612
150604FN	0.4														
150608EN	0.8		14.55	230	14.55	230	14.55	622	14.55	230				19.43	614
150608FN	0.8														
150612EN	1.2	14.55			14.55	232			14.55	232					
150616EN	1.6	14.55													
Steel		●	○	○	○	○	○	○	○	○	○	○	○	○	○
Stainless steel		○	●	●	●	●	●	●	●	●	●	●	●	●	●
Cast iron															○
Non ferrous metals															○
Heat resistant alloys		○		○	●	●	●	●	○	○	●	●	●	●	●

DNMG

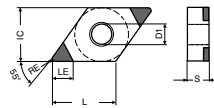


ISO	RE mm	-M34 CTP5110		-M34 CTP5115		-M42 CTP2120		-M52 CTP2120	
		Article no. 75 004 ...	£	Article no. 75 004 ...	£	Article no. 70 158 ...	£	Article no. 70 119 ...	£
150404EN	0.4	14.03	416	14.03	516	13.43	604		
150408EN	0.8	14.03	418	14.03	518				
150412EN	1.2	14.03	420	14.03	520				
150604EN	0.4					14.55	610	14.55	612
150608EN	0.8	15.36	430	15.36	530	14.55	612	14.55	614
150612EN	1.2	15.36	432	15.36	532				

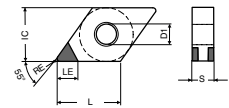
Material	-M34 CTP5110	-M34 CTP5115	-M42 CTP2120	-M52 CTP2120
Steel				
Stainless steel	○	○	○	○
Cast iron			○	○
Non ferrous metals			○	○
Heat resistant alloys	●	●	●	●

DNGA

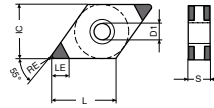
Designation	L	S	D1	IC
	mm	mm	mm	mm
DNGA 1506..	15.5	6.35	5.16	12.7



-B

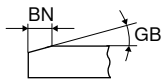


-K (-2SC)



-L (-4SC)

DNGA

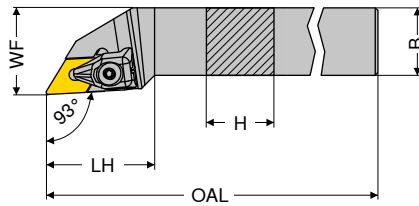


-L CTBS20C	-B CTBH15C	-K CTBH20C	-L CTBH20C	-K CTBH40C	-L CTBH40C
-4SC PBC15-S		-2SC PBC25-S	-4SC PBC25-S	-2SC PBC40-S	-4SC PBC40-S
F	F	F	F	F	F
CBN DNGA Y0	CBN DNGA Y0	CBN DNGA Y0	CBN DNGA Y0	CBN DNGA Y0	CBN DNGA Y0

ISO	RE	GB	BN	LE	-L CTBS20C		-B CTBH15C		-K CTBH20C		-L CTBH20C		-K CTBH40C		-L CTBH40C	
					Article no. 71 403 ...	£	Article no. 71 017 ...	£	Article no. 71 402 ...	£	Article no. 71 403 ...	£	Article no. 71 402 ...	£	Article no. 71 403 ...	£
150604SN	0.4	10	0.09	2.8	84.59	122										
150604TN	0.4	15	0.09	2.8					54.73	222						
150604SN	0.4	15	0.09	2.8	84.59	132										
150604SN	0.4	15	0.11	2.8			79.70	32814								
150604SN	0.4	20	0.09	2.8	84.59	152										
150604SN	0.4	20	0.11	2.8							84.59	242				
150604TN	0.4	25	0.11	2.8					54.73	252						
150604SN	0.4	25	0.11	2.8			79.70	32829			84.59	262	54.73	352	84.59	352
150604FN	0.4			2.8					54.73	212						
150604SN	0.4	30	0.14	2.8											84.59	372
150604SN	0.4	30	0.18	2.8	84.59	182										
150604SN	0.4	35	0.14	2.8								54.73	382			
150608FN	0.8			2.6					54.73	214						
150608SN	0.8	10	0.09	2.6	84.59	124										
150608SN	0.8	15	0.09	2.6	84.59	134										
150608TN	0.8	15	0.09	2.6					54.73	224						
150608SN	0.8	15	0.11	2.6			79.70	33014								
150608SN	0.8	20	0.09	2.6	84.59	154									84.59	334
150608SN	0.8	20	0.11	2.6					54.73	254	84.59	244				
150608TN	0.8	25	0.11	2.6									54.73	354	84.59	354
150608SN	0.8	25	0.11	2.6											84.59	364
150608SN	0.8	25	0.13	2.6			79.70	33029			84.59	264			84.59	374
150608SN	0.8	30	0.14	2.6							84.59	274				
150608SN	0.8	30	0.18	2.6	84.59	184										
150608SN	0.8	35	0.14	2.6								54.73	384			
150612SN	1.2	15	0.11	2.8			79.70	33214								
150612SN	1.2	25	0.13	2.8			79.70	33229								

Cast iron	•					
Sintered steels	•					
Heat resistant alloys	•					
hardened < 45 HRC			•			
hardened 46–55 HRC			•	•	•	•
hardened 56–60 HRC			•	•	•	•
hardened 61–65 HRC					•	•

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



Illustrations show right-hand versions



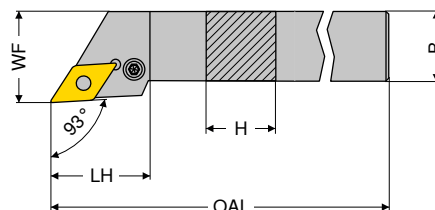
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 541 ...	Article no. 70 540 ...	Article no. 70 541 ...	Article no. 70 540 ...
DDJN R/L 1616 H11	16	16	100	33	20	2	DN.. 1104	£ 69.39	816	£ 69.39	816
DDJN R/L 2020 K11	20	20	125	33	25	2	DN.. 1104	£ 77.31	820	£ 77.31	820
DDJN R/L 2525 M11	25	25	150	33	32	2	DN.. 1104	£ 79.97	825	£ 79.97	825
DDJN R/L 2020 K15	20	20	125	40	25	4	DN.. 1504 / 1506	£ 77.31	720	£ 77.31	720
DDJN R/L 2525 M15	25	25	150	40	32	4	DN.. 1504 / 1506	£ 79.97	725	£ 79.97	725
DDJN R/L 3225 P15	32	25	170	40	32	4	DN.. 1504 / 1506	£ 85.79	832	£ 85.79	832

i Tool holders with HSK-T or PSC interface can be found in → Chapter 16.

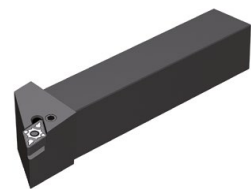
i When using DN.. 1504 indexable inserts, use insert seat article no. 70 950 40000.

Spare parts for Article no.	2A/28		Y7		2A/28		2A/28			
	Article no. 70 950 ...	£	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£		
70 541 816 / 70 540 816	26.15	835	T09 - IP	14.77	126	M3x7 - IP	2.85	819	3.21	808
70 541 820 / 70 540 820	26.15	835	T09 - IP	14.77	126	M3x7 - IP	2.85	819	3.21	808
70 541 825 / 70 540 825	26.15	835	T09 - IP	14.77	126	M3x7 - IP	2.85	819	3.21	808
70 541 720 / 70 540 720	21.61	824	T15 - IP	15.77	128	M4,5x12 - IP	2.71	820	7.17	811
70 541 725 / 70 540 725	21.61	824	T15 - IP	15.77	128	M4,5x12 - IP	2.71	820	7.17	811
70 541 832 / 70 540 832	21.61	824	T15 - IP	15.77	128	M4,5x12 - IP	2.71	820	7.17	811

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



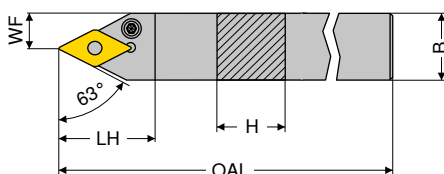
Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 541 ...	Article no. 70 540 ...	Article no. 70 541 ...	Article no. 70 540 ...
PDJN R/L 1616 H11	16	16	100	30.0	20	3	DN.. 1104	£ 69.39	116	£ 69.39	116
PDJN R/L 2020 K11	20	20	125	30.0	25	3	DN.. 1104	£ 77.31	120	£ 77.31	120
PDJN R/L 2525 M11	25	25	150	30.0	32	3	DN.. 1104	£ 79.97	125	£ 79.97	125
PDJN R/L 2020 K15	20	20	125	34.9	25	3,2	DN.. 1506	£ 77.31	020	£ 77.31	020
PDJN R/L 2525 M15	25	25	150	35.4	32	3,2	DN.. 1506	£ 79.97	025	£ 79.97	025
PDJN R/L 3225 P15	32	25	170	35.4	32	3,2	DN.. 1506	£ 85.79	032	£ 85.79	032

Spare parts for Article no.	2A/28		2A/28		2A/28		2A/28		2A/28		2A/28		
	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	
70 541 116 / 70 540 116	2.23	175	SW2,5	1.87	122	1.11	191	13.61	121	2.90	208	6.55	120
70 541 120 / 70 540 120	2.23	175	SW2,5	1.87	122	1.11	191	13.61	121	2.90	208	6.55	120
70 541 125 / 70 540 125	2.23	175	SW2,5	1.87	122	1.11	191	13.61	121	2.90	208	6.55	120
70 541 020 / 70 540 020	2.23	176	SW3	1.60	198	1.11	192	12.44	188	3.45	388	7.17	236
70 541 025 / 70 540 025	2.23	176	SW3	1.60	198	1.11	192	12.44	188	3.45	388	7.17	236
70 541 032 / 70 540 032	2.23	176	SW3	1.60	198	1.11	192	12.44	188	3.45	388	7.17	236

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



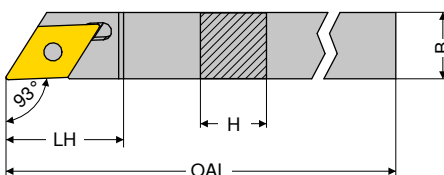
Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 537 ...	£	Article no. 70 536 ...	£
PDNN R/L 2525 M11	25	25	150	30.0	12.5	3	DN.. 1104	79.97	125	79.97	125
PDNN R/L 2525 M15	25	25	150	36.5	12.5	3,2	DN.. 1506	79.97	025	79.97	025

Spare parts for Article no.	2A/28		2A/28		2A/28		2A/28		2A/28		2A/28	
	Key I	Shim	Assembly pin	Lever	Clamping screw	Solid Carbide Seat D	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
70 537 125 / 70 536 125		SW2,5					2.23	175	1.87	122	1.11	191
70 537 025 / 70 536 025		SW3					2.23	176	1.60	198	1.11	192

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



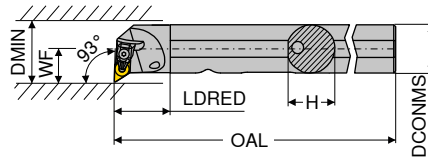
Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	torque moment Nm	Insert	Left-hand X0		Right-hand X0	
							Article no. 70 699 ...	£	Article no. 70 698 ...	£
SDJN R/L 1012 H11	10	12	100	21.3	3,2	DNGU 1104	203.60	010	203.60	010
SDJN R/L 1212 H11	12	12	100	21.3	3,2	DNGU 1104	203.60	012	203.60	012
SDJN R/L 1616 K11	16	16	125	21.3	3,2	DNGU 1104	235.79	016	235.79	016
SDJN R/L 2020 K11	20	20	125	21.3	3,2	DNGU 1104	224.63	020	224.63	020
SDJN R/L 2525 M11	25	25	150	21.3	3,2	DNGU 1104	264.60	025	264.60	025

Spare parts for Article no.	Y7		2A					
	Key D	Clamping screw	Article no. 80 950 ...	£	Article no. 72 950 ...	£		
70 699 010 / 70 698 010			T15 - IP	15.77	128	M4x11	4.36	007
70 699 012 / 70 698 012			T15 - IP	15.77	128	M4x11	4.36	007
70 699 016 / 70 698 016			T15 - IP	15.77	128	M4x11	4.36	007
70 699 020 / 70 698 020			T15 - IP	15.77	128	M4x11	4.36	007
70 699 025 / 70 698 025			T15 - IP	15.77	128	M4x11	4.36	007

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



Illustrations show right-hand versions



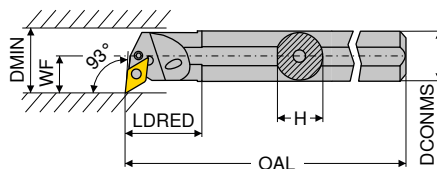
ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 569 ...	£	Article no. 70 568 ...	£
A25R DDUN R/L 11	25	24	200	30	17	32	2	DN.. 1104	202.00	725	202.00	725
A32S DDUN R/L 11	32	31	250	40	22	40	2	DN.. 1104	208.91	732	208.91	732
A40T DDUN R/L 15	40	39	300	45	27	50	4	DN.. 1506	232.73	840	232.73	840

i Tool holders with HSK-T interface can be found in → Chapter 16.

Spare parts for Article no.	2A/28 XPress type		Y7 Key D		2A/28 Clamping screw		2A/28 Solid Carbide Seat D			
	Article no. 70 950 ...	£	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£		
70 568 725 / 70 569 725	26.15	835	T09 - IP	14.77	126	M3x7 - IP	2.85	819	3.21	808
70 568 732 / 70 569 732	26.15	835	T09 - IP	14.77	126	M3x7 - IP	2.85	819	3.21	808
70 568 840 / 70 569 840	21.61	824	T15 - IP	15.77	128	M4,5x12 - IP	2.71	820	7.17	811

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

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



Illustrations show right-hand versions

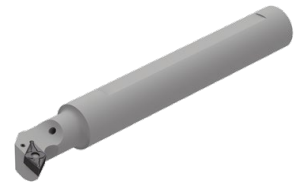
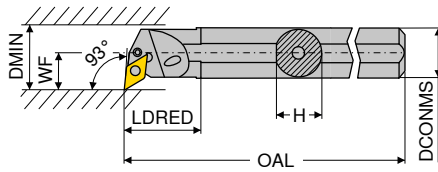


ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 569 ...	£	Article no. 70 568 ...	£
A20Q PDUN R/L 11	20	18.5	180	36	16.0	28	3	DN.. 1104	181.27	120	181.27	120
A25R PDUN R/L 11	25	23.0	200	36	18.5	32	3	DN.. 1104	202.00	125	202.00	125
A32S PDUN R/L 11	32	30.0	250	36	22.0	40	3	DN.. 1104	208.91	132	208.91	132
A32S PDUN R/L 15	32	30.0	250	50	22.0	40	3,2	DN.. 1506	208.91	232	208.91	232
A40T PDUN R/L 15	40	38.0	300	60	27.0	50	3,2	DN.. 1506	232.73	240	232.73	240
S50W PDUN R/L 15	50	47.0	450	31	35.0	63	3,2	DN.. 1506	288.00	050	288.00	050

Spare parts for Article no.	2A/28 Key I		2A/28 Shim		2A/28 Assembly pin		2A/28 Lever		2A/28 Clamping screw		2A/28 Solid Carbide Seat D		
	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	
70 568 120 / 70 569 120	SW2,5	2.23	175				13.61	125	1.97	126			
70 568 125 / 70 569 125	SW2,5	2.23	175	1.87	122	1.11	191	13.61	121	2.90	208	6.55	120
70 568 132 / 70 569 132	SW2,5	2.23	175	1.87	122	1.11	191	13.61	121	2.90	208	6.55	120
70 568 232 / 70 569 232	SW3	2.23	176	1.60	198	1.11	192	12.44	188	3.18	209	7.17	236
70 568 240 / 70 569 240	SW3	2.23	176	1.60	198	1.11	192	12.44	188	3.18	209	7.17	236
70 568 050 / 70 569 050	SW3	2.23	176	1.60	198	1.11	192	12.44	188	3.45	388	7.17	236

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

▲ with carbide core



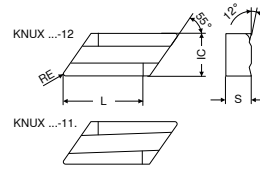
Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 2A		Right-hand 2A	
									Article no. 70 563 ...	£	Article no. 70 562 ...	£
E-A25R PDUN R/L 11	25	23	200	40	17	31	3	DN.. 1104	645.09	025	645.09	025
E-A32S PDUN R/L 15	32	30	250	50	22	39	3,2	DN.. 1506	851.55	032	851.55	032
E-A40T PDUN R/L 15	40	38	300	60	27	48	3,2	DN.. 1506	1,016.36	040	1,016.36	040

Spare parts for Article no.	Key I		Shim		Assembly pin		Lever		Clamping screw		Solid Carbide Seat D	
	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
70 562 025 / 70 563 025	SW2,5	2.23 175	1.87 122		1.11 191	13.61 121	2.90 208	6.55 120				
70 562 032 / 70 563 032	SW3	2.23 176	1.60 198		1.11 192	12.44 188	3.45 388	7.17 236				
70 562 040 / 70 563 040	SW3	2.23 176	1.60 198		1.11 192	12.44 188	3.45 388	7.17 236				

KNUX

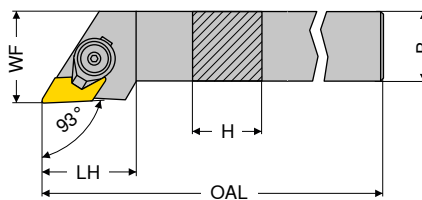
Designation	L	S	IC
	mm	mm	mm
KNUX 1604..	16	4.76	9.52



KNUX

ISO	RE	-11 CTCK110		-11 CTCK120		-11 CTCP135		-12 CTCP135	
		-11 DCX3110		-11 HCF3120		-11 HCR1135		-12 HCR1135	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		F		F		F		M	
		KNUX 1A/13		KNUX 1A/13		KNUX 1A/13		KNUX 1A/13	
		Article no. 70 240 ...		Article no. 70 240 ...		Article no. 76 240 ...		Article no. 76 242 ...	
		£		£		£		£	
160405EL	0.5	13.43	002	13.43	552	13.43	702	13.43	702
160405ER	0.5	13.43	000	13.43	500	13.43	700	13.43	700
160410EL	1.0					13.43	706	13.43	706
160410ER	1.0					13.43	704	13.43	704
Steel			●		●		●		●
Stainless steel			○		○		○		○
Cast iron			●		●				
Non ferrous metals									
Heat resistant alloys							○		○

Simplex – CKJN 93° – Toolholder with top clamping



Illustrations show right-hand versions

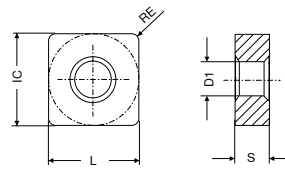


ISO designation	H	B	OAL	LH	WF	torque moment Nm	Insert	Left-hand 2A/23		Right-hand 2A/23	
								Article no. 70 799 ...	£	Article no. 70 798 ...	£
CKJN R/L 2525 M16	25	25	150	35	32	7	KNUX 1604	128.00	025	128.00	025

Spare parts	2A/28		2A/28		2A/28		2A/28		2A/28		2A/28			
	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£		
for Article no. 70 798 025	15.49	612	2.34	396	5.08	615	1.00	603	10.25	613	2.23	616	1.00	617
70 799 025	15.49	618	2.34	396	5.08	615	1.00	603	10.25	614	2.23	616	1.00	617

SNMG / SNMA / SNMM

Designation	L	S	D1	IC
	mm	mm	mm	mm
SNMG 0903..	9.52	3.18	3.81	9.52
SNM. 1204..	12.70	4.76	5.16	12.70
SNM. 1506..	15.87	6.35	6.35	15.87
SNM. 1906..	19.05	6.35	7.94	19.05
SNMM 2507..	25.40	7.94	9.12	25.40
SNMM 2509..	25.40	9.52	9.12	25.40



SNMG

ISO	RE	-F50 CTCP115		-F50 CTCP125		-F50 CTCP135		-M50 CTCP115		-M50 CTCP125		-M50 CTCP135		-M70 CTCK110	
		Article no. 76 140 ...	306	Article no. 76 140 ...	506	Article no. 76 140 ...	706	Article no. 76 137 ...	318	Article no. 76 137 ...	518	Article no. 76 137 ...	718	Article no. 70 225 ...	018
	mm	£		£		£	£		£		£		£		£
090308EN	0.8	6.75	306	6.75	506	6.75	706								
120404EN	0.4	10.57	316	10.57	516	10.57	716	10.57	318	10.57	518	10.57	718	10.57	018
120408EN	0.8	10.57	318	10.57	518	10.57	718	10.57	320	10.57	520	10.57	720	10.57	020
120412EN	1.2	10.57	320	10.57	520	10.57	720	10.57	322	10.57	522	10.57	722	10.57	022
120416EN	1.6							10.57	322	10.57	522	10.57	722	10.57	022
150608EN	0.8							16.78	330	16.78	530	16.78	730		
150612EN	1.2							16.78	332	16.78	532	16.78	732	16.78	032
150616EN	1.6							16.78	334	16.78	534	16.78	734	16.78	034
190612EN	1.2													23.70	044
190616EN	1.6													23.70	046
Steel			●		●		●		●		●		●		●
Stainless steel			○		○		○		○		○		○		○
Cast iron			○		○		○		○		○		○		●
Non ferrous metals															
Heat resistant alloys							○						○		

SNMG / SNMA

		-M70 CTCK120		-M70 CTCP115		-M70 CTCP125		-M70 CTCP135		CTCP125		CTCP135		CTCK110	
		-NM19 HCF3120		-NM19 HCX1115		-NM19 HCX1125		-NM19 HCR1135		HCX1125		HCR1135		DCX3110	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		M		M		M		M		M		M		R	
		SNMG		SNMG		SNMG		SNMG		SNMG		SNMG		SNMA	
		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08	
ISO	RE	Article no.		Article no.		Article no.		Article no.		Article no.		Article no.		Article no.	
	mm	70 225 ...		76 225 ...		76 225 ...		76 225 ...		76 116 ...		76 116 ...		70 114 ...	
		£		£		£		£		£		£		£	
090308EN	0.8									6.75	506	6.75	706		
120408EN	0.8	10.57	518	10.57	318	10.57	518	10.57	718					10.57	018
120412EN	1.2	10.57	520	10.57	320	10.57	520	10.57	720					10.57	020
120416EN	1.6	10.57	522	10.57	322	10.57	522	10.57	722					10.57	022
150612EN	1.2	16.78	532	16.78	332	16.78	532	16.78	732					16.78	032
150616EN	1.6	16.78	534	16.78	334	16.78	534	16.78	734					16.78	034
190612EN	1.2	23.70	544	23.70	344	23.70	544	23.70	744					23.70	044
190616EN	1.6	23.70	546	23.70	346	23.70	546	23.70	746					23.70	046
190624EN	2.4			23.70	348	23.70	548	23.70	748						
Steel		●		●		●		●		●		●			
Stainless steel		○		○		○		○		○		○			
Cast iron		●		○		○		○		○		○		●	
Non ferrous metals															
Heat resistant alloys								○		○		○			

SNMA / SNMM

		CTCK120		-R28 CTCP115		-R28 CTCP125		-R28 CTCP135		-R58 CTCP115		-R58 CTCP125		-R58 CTCP135	
		HCF3120		-NR14 HCX1115		-NR14 HCX1125		-NR14 HCR1135		-NR17 HCX1115		-NR17 HCX1125		-NR17 HCR1135	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		R		R		R		R		R		R		R	
		SNMA		SNMM		SNMM		SNMM		SNMM		SNMM		SNMM	
		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08	
ISO	RE	Article no.		Article no.		Article no.		Article no.		Article no.		Article no.		Article no.	
	mm	70 114 ...	£	76 128 ...	£	76 128 ...	£	76 128 ...	£	76 129 ...	£	76 129 ...	£	76 129 ...	£
120408EN	0.8	10.57	518							10.57	318	10.57	518	10.57	718
120412EN	1.2	10.57	520							10.57	320	10.57	520	10.57	720
120416EN	1.6	10.57	522												
150612EN	1.2	16.78	532	16.78	332	16.78	532	16.78	732	16.78	332	16.78	532	16.78	732
150616EN	1.6	16.78	534	16.78	334	16.78	534	16.78	734	16.78	334	16.78	534	16.78	734
190612EN	1.2	23.70	544							23.70	344	23.70	544	23.70	744
190616EN	1.6	23.70	546	23.70	346	23.70	546	23.70	746	23.70	346	23.70	546	23.70	746
190624EN	2.4									23.70	348	23.70	548	23.70	748
250724EN	2.4							46.58	760	46.58	360	46.58	560	46.58	760
250924EN	2.4			54.71	370	54.71	570	54.71	770	54.71	370	54.71	570	54.71	770
Steel			●		●		●		●		●		●		●
Stainless steel			○		○		○		○		○		○		○
Cast iron		●		○		○		○		○		○		○	
Non ferrous metals															
Heat resistant alloys								○							○

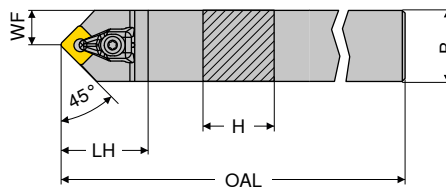
SNMM / SNMG

		-R88 CTCP115		-R88 CTCP125		-R88 CTCP135		-F30 CTPM125		-M30 CTPM125		-M42 CTC2135		-M60 CTPM125	
		-NR19 HCX1115		-NR19 HCX1125		-NR19 HCR1135		-NF23 HCN2125		-NM23 HCN2125		-M42 CWN2135		-NM26 HCN2125	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN				DRAGONSKIN	
		R		R		R		F		M		M		M	
		SNMM		SNMM		SNMM		SNMG		SNMG		SNMG		SNMG	
		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08	
ISO	RE	Article no.		Article no.		Article no.		Article no.		Article no.		Article no.		Article no.	
	mm	76 130 ...		76 130 ...		76 130 ...		75 016 ...		75 017 ...		70 002 ...		75 018 ...	
		£		£		£		£		£		£		£	
120404EN	0.4							10.57	216						
120408EN	0.8							10.57	218	10.57	218	10.57	408	10.57	218
120412EN	1.2							10.57	220			10.57	412	10.57	210
120416EN	1.6													10.57	220
190616SN	1.6	23.70	346	23.70	546	23.70	746								
190624SN	2.4	23.70	348	23.70	548	23.70	748								
250724SN	2.4	46.58	36000	46.58	56000	46.58	760								
250924SN	2.4	54.71	37000	54.71	57000	54.71	770								
Steel			●		●		●		○		○		○		○
Stainless steel			○		○		○		●		●		●		●
Cast iron			○		○										
Non ferrous metals															
Heat resistant alloys							○				○		●		○

SNMG

		-M70 CTC2135		-M34 CTP5110		-M34 CTP5115		-M52 CTP2120	
		-NM19 CWN2135		-M34 HCN5110		-M34 HCN5115		-M52 CCN2120	
				DRAGONSKIN		DRAGONSKIN			
		M		M		M		M	
		SNMG		SNMG		SNMG		SNMG	
		1A/08		1A/08		1A/08		1A/08	
ISO	RE	Article no.		Article no.		Article no.		Article no.	
	mm	70 225 ...		75 005 ...		75 005 ...		70 129 ...	
		£		£		£		£	
120408EN	0.8	10.57	418	11.08	418	11.08	518	10.57	608
120412EN	1.2	10.57	420	11.08	420	11.08	520		
190616EN	1.6	23.70	446						
Steel			○		○		○		○
Stainless steel			●		○		○		○
Cast iron									○
Non ferrous metals									○
Heat resistant alloys			●		●		●		●

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

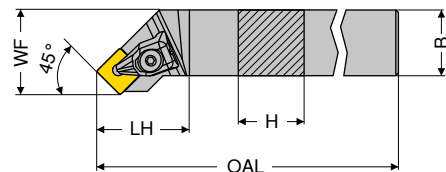


ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Neutral 2A/24	
								Article no.	Price
DSDN N 2020 K12	20	20	125	38	10.3	4	SN.. 1204	70 516 ...	£ 620
DSDN N 2525 M12	25	25	150	38	12.5	4	SN.. 1204	70 516 ...	£ 625

i Tool holders with HSK-T interface can be found in → Chapter 16.

Spare parts	2A/28 XPress type		Y7 Key D		2A/28 Clamping screw		2A/28 Solid Carbide support S	
	Article no.	Price	Article no.	Price	Article no.	Price	Article no.	Price
for Article no.	70 950 ...	£	80 950 ...	£	70 950 ...	£	70 950 ...	£
70 516 620	21.61	824	15.77	128	2.71	820	7.17	813
70 516 625	21.61	824	15.77	128	2.71	820	7.17	813

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



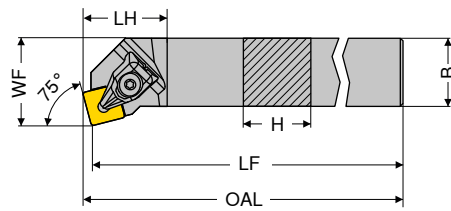
Illustrations show right-hand versions



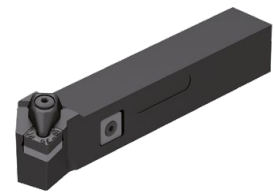
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no.	Price	Article no.	Price
DSSN R/L 2020 K12	20	20	125	35	25	4	SN.. 1204	70 513 ...	£ 620	70 512 ...	£ 620
DSSN R/L 2525 M12	25	25	150	35	32	4	SN.. 1204	70 513 ...	£ 625	70 512 ...	£ 625
DSSN R/L 3225 P12	32	25	170	35	32	4	SN.. 1204	70 513 ...	£ 632	70 512 ...	£ 632

Spare parts	2A/28 XPress type		Y7 Key D		2A/28 Clamping screw		2A/28 Solid Carbide support S	
	Article no.	Price	Article no.	Price	Article no.	Price	Article no.	Price
for Article no.	70 950 ...	£	80 950 ...	£	70 950 ...	£	70 950 ...	£
70 512 620 / 70 513 620	21.61	824	15.77	128	2.71	820	7.17	813
70 512 625 / 70 513 625	21.61	824	15.77	128	2.71	820	7.17	813
70 512 632 / 70 513 632	21.61	824	15.77	128	2.71	820	7.17	813

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



Illustrations show right-hand versions







ISO designation	H mm	B mm	OAL mm	LF mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 525 ...	£	Article no. 70 524 ...	£
DSKN R/L 2525 M12	25	25	153.3	150	28	32	4	SN.. 1204	79.97	625	79.97	625

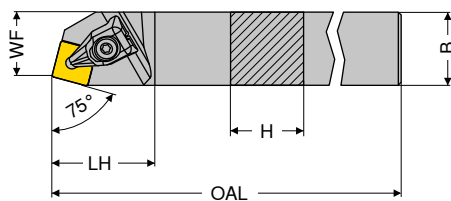
Spare parts

for Article no.

70 525 625 / 70 524 625	21.61	824	T15 - IP	15.77	128	M4,5x12 - IP	2.71	820	7.17	813
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 XPress type Article no. 70 950 ... £	 Key D Article no. 80 950 ... £	 Clamping screw Article no. 70 950 ... £	 Solid Carbide support S Article no. 70 950 ... £
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MaxiLock-D – DSBN 75° – Toolholder with top clamping



Illustrations show right-hand versions







ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 521 ...	£	Article no. 70 520 ...	£
DSBN R/L 2020 K12	20	20	125	35	17	4	SN.. 1204	77.31	620	77.31	620
DSBN R/L 2525 M12	25	25	150	35	22	4	SN.. 1204	79.97	625	79.97	625
DSBN R/L 2525 M15	25	25	150	42	22	6,5	SN.. 1506	79.97	725	79.97	725
DSBN R/L 3232 P15	32	32	170	42	27	6,5	SN.. 1506	108.00	832	108.00	832
DSBN R/L 3232 P19	32	32	170	48	27	6,5	SN.. 1906	108.00	732	108.00	732
DSBN R/L 4040 S19	40	40	250	48	35	6,5	SN.. 1906	134.27	840	134.27	840
DSBN R/L 4040 S25	40	40	250	57	35	6,5	SN.. 2507 / SN.. 2509	134.27	940	134.27	940

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

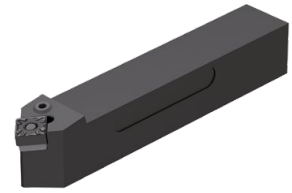
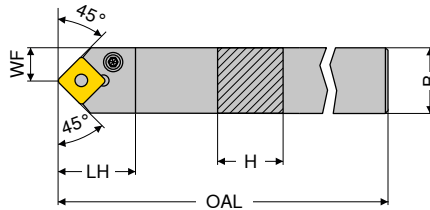
Spare parts

for Article no.

70 521 620 / 70 520 620	21.61	824	T15 - IP	15.77	128	M4,5x12 - IP	2.71	820	7.17	813
70 521 625 / 70 520 625	21.61	824	T15 - IP	15.77	128	M4,5x12 - IP	2.71	820	7.17	813
70 521 725 / 70 520 725	24.26	825	T20 - IP	16.56	129	M5x14 - IP	3.85	821	10.95	833
70 521 832 / 70 520 832	24.26	825	T20 - IP	16.56	129	M5x14 - IP	3.85	821	10.95	833
70 521 732 / 70 520 732	26.54	826	T20 - IP	16.56	129	M5x14 - IP	3.85	821	11.74	817
70 521 840 / 70 520 840	26.54	826	T20 - IP	16.56	129	M5x14 - IP	3.85	821	11.74	817
70 521 940 / 70 520 940	41.34	827	T25 - IP	19.11	130	M6x16 - IP	7.31	822	21.91	818

 XPress type Article no. 70 950 ... £	 Key D Article no. 80 950 ... £	 Clamping screw Article no. 70 950 ... £	 Solid Carbide support S Article no. 70 950 ... £
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MaxiLock-N – PSDN 45° – Toolholder with lever clamping

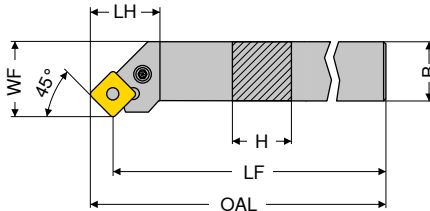


ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Neutral 2A/24	
								Article no. 70 516 ...	£
PSDN N 1616 H09	16	16	100	21.0	8.3	3	SNM. 0903	69.39	016
PSDN N 2020 K12	20	20	125	27.6	10.3	4	SNM. 1204	77.31	020
PSDN N 2525 M12	25	25	150	27.6	12.8	4	SNM. 1204	79.97	025
PSDN N 3225 P19	32	25	170	40.4	12.5	8	SNM. 1906	85.79	03200
PSDN N 4040 S25	40	40	250	48.8	20.0	8	SNM. 2507 / 2509	134.27	04000

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

Spare parts for Article no.	2A/28 Key I		2A/28 Shim		2A/28 Assembly pin		2A/28 Lever		2A/28 Clamping screw		2A/28 Solid Carbide support S		
	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	
70 516 016	SW2,5	2.23	175	1.60	197	1.11	191	11.35	185	2.90	208	5.55	229
70 516 020	SW3	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	5.55	230
70 516 025	SW3	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	5.55	230
70 516 03200	SW4	2.34	396	1.60	392	1.11	395	17.37	386	3.45	389	17.46	383
70 516 04000	SW5	3.35	265	1.02	621	1.72	623	23.48	620	2.07	622	35.92	27600

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



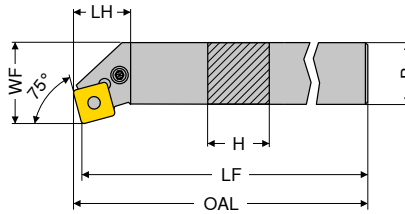
Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LF mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 513 ...	£	Article no. 70 512 ...	£
PSSN R/L 1616 H09	16	16	106.7	100	21.2	20	3	SNM. 0903	69.39	016	69.39	016
PSSN R/L 2020 K12	20	20	134.0	125	29.3	25	4	SNM. 1204	77.31	020	77.31	020
PSSN R/L 2525 M12	25	25	159.0	150	29.3	32	4	SNM. 1204	79.97	025	79.97	025
PSSN R/L 3225 P12	32	25	179.0	170	32.0	32	4	SNM. 1204	85.79	032	85.79	032
PSSN R 2525 M15	25	25	161.2	150	29.3	32	4	SNM. 1506	79.97	025	79.97	125
PSSN R 3232 P15	32	32	181.2	170	32.0	40	4	SNM. 1506	108.00	032	108.00	132
PSSN R/L 3232 P19	32	32	183.5	170	40.2	40	8	SNM. 1906	108.00	232	108.00	232
PSSN R 4040 S25	40	40	268.0	250	48.8	50	8	SNM. 2507 / 2509	131.73	04000	131.73	04000

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

Spare parts for Article no.	2A/28 Key I		2A/28 Shim		2A/28 Assembly pin		2A/28 Lever		2A/28 Clamping screw		2A/28 Solid Carbide support S		
	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	
70 512 016 / 70 513 016	SW2,5	2.23	175	1.60	197	1.11	191	11.35	185	2.90	208	5.55	229
70 512 020 / 70 513 020	SW3	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	5.55	230
70 512 025 / 70 513 025	SW3	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	5.55	230
70 512 032 / 70 513 032	SW3	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	5.55	230
70 512 125	SW3	2.23	176	1.02	391	1.11	394	11.35	385	3.45	388	11.35	382
70 512 132	SW3	2.23	176	1.02	391	1.11	394	11.35	385	3.45	388	11.35	382
70 512 232 / 70 513 232	SW4	2.34	396	1.60	392	1.11	395	17.37	386	3.45	389	17.46	383
70 512 04000	SW5	3.35	265	1.02	621	1.72	623	23.48	620	2.07	622	35.92	27600

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



Illustrations show right-hand versions

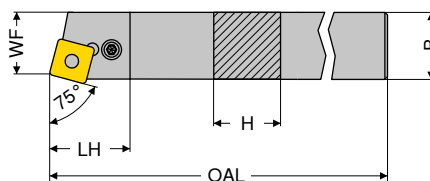


ISO designation	H mm	LF mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 525 ...	£	Article no. 70 524 ...	£
PSKN R/L 1616 H09	16	100	16	102.5	18.7	20	3	SNM. 0903	69.39	016	69.39	016
PSKN R/L 2020 K12	20	125	20	128.3	22.7	25	4	SNM. 1204	77.31	020	77.31	020
PSKN R/L 2525 M12	25	150	25	153.3	22.7	32	4	SNM. 1204	79.97	025	79.97	025

Spare parts for Article no.	Article no. 70 950 ...		Article no. 70 950 ...		Article no. 70 950 ...		Article no. 70 950 ...		Article no. 70 950 ...		Article no. 70 950 ...	
	£		£		£		£		£		£	
70 525 016 / 70 524 016	2.23	175	1.60	197	1.11	191	11.35	185	2.90	208	5.55	229
70 525 020 / 70 524 020	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	5.55	230
70 525 025 / 70 524 025	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	5.55	230



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



Illustrations show right-hand versions



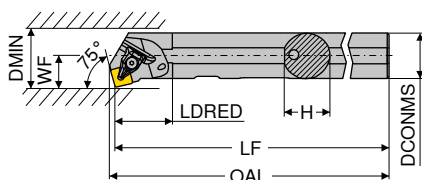
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 521 ...	£	Article no. 70 520 ...	£
PSBN R/L 2020 K12	20	20	125	27.5	17	4	SNM. 1204	77.31	020	77.31	020
PSBN R/L 2525 M12	25	25	150	27.5	22	4	SNM. 1204	79.97	025	79.97	025
PSBN R/L 3225 P12	32	25	170	32.0	22	4	SNM. 1204	85.79	032	85.79	032
PSBN R/L 3232 P15	32	32	170	32.0	27	4	SNM. 1506	108.00	132	108.00	132
PSBN R/L 3232 P19	32	32	170	39.2	27	8	SNM. 1906	108.00	232	108.00	232
PSBN R/L 4040 S19	40	40	250	39.2	35	8	SNM. 1906	134.27	04000	134.27	04000
PSBN R/L 4040 S25	40	40	250	48.0	35	8	SNM. 2507 / 2509	134.27	14000	134.27	14000

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

Spare parts for Article no.	Article no. 70 950 ...		Article no. 70 950 ...		Article no. 70 950 ...		Article no. 70 950 ...		Article no. 70 950 ...		Article no. 70 950 ...	
	£		£		£		£		£		£	
70 520 020 / 70 521 020	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	5.55	230
70 520 025 / 70 521 025	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	5.55	230
70 520 032 / 70 521 032	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	5.55	230
70 520 132 / 70 521 132	2.23	176	1.02	391	1.11	394	11.35	385	3.45	388	11.35	382
70 520 232 / 70 521 232	2.34	396	1.60	392	1.11	395	17.37	386	3.45	389	17.46	383
70 520 04000 / 70 521 04000	2.34	396	1.60	392	1.11	395	17.37	386	3.45	389	17.46	383
70 520 14000 / 70 521 14000	3.35	265	1.02	621	1.72	623	23.48	620	2.07	622	35.92	27600



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



Illustrations show right-hand versions

ISO designation	DCONMS	H	LF	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
										Article no. 70 561 ...	£	Article no. 70 560 ...	£
A32S DSKN R/L 12	32	31	250	254.2	40	22	40	4	SN.. 1204	208.91	832	208.91	832

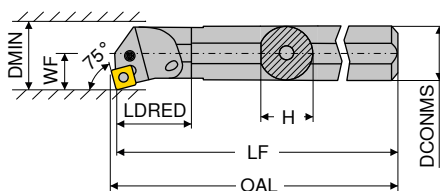
Spare parts

for Article no.

70 561 832 / 70 560 832

2A/28	Y7	2A/28	2A/28
XPress type	Key D	Clamping screw	Solid Carbide support S
Article no. 70 950 ...	Article no. 80 950 ...	Article no. 70 950 ...	Article no. 70 950 ...
£ 21.61 824	£ 15.77 128	£ 2.71 820	£ 7.17 813

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



Illustrations show right-hand versions

ISO designation	DCONMS	H	LF	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
										Article no. 70 561 ...	£	Article no. 70 560 ...	£
A25R PSKN R/L 12	25	23	200	203	15.5	17	32	4	SNM. 1204	202.00	225	202.00	225
A32S PSKN R/L 12	32	30	250	253	16.0	22	40	4	SNM. 1204	208.91	232	208.91	232
A40T PSKN R/L 12	40	38	300	303	23.0	27	50	4	SNM. 1204	232.73	240	232.73	240

Spare parts

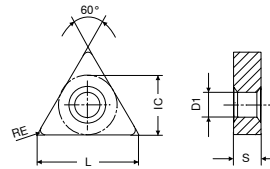
for Article no.

70 561 225 / 70 560 225
70 561 232 / 70 560 232
70 561 240 / 70 560 240

2A/28	2A/28	2A/28	2A/28	2A/28	2A/28
Key I	Shim	Assembly pin	Lever	Clamping screw	Solid Carbide support S
Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...
£ 2.23 176	£ 1.60 198	£ 1.11 192	£ 11.45 187	£ 3.89 205	£ 5.55 230

TNMG / TNMA / TNMM

Designation	L	S	D1	IC
	mm	mm	mm	mm
TNMG 1103..	11.0	3.18	2.26	6.35
TNM. 1604..	16.5	4.76	3.81	9.52
TNM. 2204..	22.0	4.76	5.16	12.70



TNMG

		-CF20 CTEP110	-F50 CTCP115	-F50 CTCP125	-F50 CTCP135	-M50 CTCP115	-M50 CTCP125	-M50 CTCP135
		-NF12 DCC1110	-NF15 HCX1115	-NF15 HCX1125	-NF15 HCR1135	-NM15 HCX1115	-NM15 HCX1125	-NM15 HCR1135
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F	F	F	F	M	M	M
		CERMET TNMG	TNMG	TNMG	TNMG	TNMG	TNMG	TNMG
		1A/78	1A/08	1A/08	1A/08	1A/08	1A/08	1A/08
ISO	RE	Article no. 76 149 ...	Article no. 76 146 ...	Article no. 76 146 ...	Article no. 76 146 ...	Article no. 76 138 ...	Article no. 76 138 ...	Article no. 76 138 ...
	mm	£	£	£	£	£	£	£
110304EN	0.4		5.85 304	5.85 504	5.85 704			
110308EN	0.8		5.85 306	5.85 506	5.85 706			
160404EN	0.4	9.19 016	9.27 316	9.27 516	9.27 716	9.27 316	9.27 516	9.27 716
160408EN	0.8	9.19 018	9.27 318	9.27 518	9.27 718	9.27 318	9.27 518	9.27 718
160412EN	1.2	9.19 020	9.27 320	9.27 520	9.27 720	9.27 320	9.27 520	9.27 720
220408EN	0.8					12.51 330	12.51 530	12.51 730
220412EN	1.2					12.51 332	12.51 532	12.51 732
Steel		●	●	●	●	●	●	●
Stainless steel		○	○	○	○	○	○	○
Cast iron		○	○	○		○	○	
Non ferrous metals								
Heat resistant alloys					○			○

TNMG

		-M70 CTCK110	-M70 CTCK120	-M70 CTCP115	-M70 CTCP125	-M70 CTCP135	CTCP125	CTCP135
		-NM19 DCX3110	-NM19 HCF3120	-NM19 HCX1115	-NM19 HCX1125	-NM19 HCR1135	HCX1125	HCR1135
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M	M	M	M	M	M	M
		TNMG	TNMG	TNMG	TNMG	TNMG	TNMG	TNMG
		1A/08	1A/08	1A/08	1A/08	1A/08	1A/08	1A/08
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	70 155 ...	70 155 ...	76 155 ...	76 155 ...	76 155 ...	76 142 ...	76 142 ...
		£	£	£	£	£	£	£
110302EN	0.2							5.85 702
160404ER	0.4					9.27 516		9.27 716
160408EL	0.8					9.27 518		
160408EN	0.8	9.27 018	9.27 518	9.27 318	9.27 518	9.27 718		
160408ER	0.8					9.27 517		9.27 717
160412EN	1.2	9.27 020	9.27 520	9.27 320	9.27 520	9.27 720		
220404EN	0.4				12.51 528			
220408EN	0.8	12.51 030	12.51 530	12.51 330	12.51 530	12.51 730		
220412EN	1.2	12.51 032	12.51 532	12.51 332	12.51 532	12.51 732		
220416EN	1.6	12.51 034	12.51 534	12.51 334	12.51 534	12.51 734		
Steel		●	●	●	●	●	●	●
Stainless steel		○	○	○	○	○	○	○
Cast iron		●	●	○	○	○	○	○
Non ferrous metals								
Heat resistant alloys						○		○

9

TNMA / TNMM

		CTCK110	CTCK120	-R28 CTCP115	-R28 CTCP125	-R28 CTCP135	-R58 CTCP115	-R58 CTCP125
		DCX3110	HCF3120	-NR14 HCX1115	-NR14 HCX1125	-NR14 HCR1135	-NR17 HCX1115	-NR17 HCX1125
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		R	M	R	R	R	R	R
		TNMA	TNMA	TNMM	TNMM	TNMM	TNMM	TNMM
		1A/08	1A/08	1A/08	1A/08	1A/08	1A/08	1A/08
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	70 134 ...	70 134 ...	76 154 ...	76 154 ...	76 154 ...	76 152 ...	76 152 ...
		£	£	£	£	£	£	£
160408EN	0.8	9.27 018	9.27 518					
160412EN	1.2	9.27 020	9.27 520					
160416EN	1.6	9.27 022	9.27 522					
220408EN	0.8	12.51 030	12.51 530					
220412EN	1.2	12.51 032	12.51 532				12.51 332	12.51 532
220416EN	1.6	12.51 034	12.51 534	12.51 334	12.51 534	12.51 734		
Steel				●	●	●	●	●
Stainless steel				○	○	○	○	○
Cast iron		●	●	○	○	○	○	○
Non ferrous metals								
Heat resistant alloys						○		

TNMM / TNMG

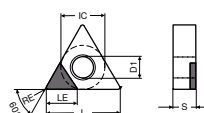
		-R58 CTCP135	-F30 CTPM125	-M30 CTPM125	-M42 CTC2135	-M60 CTPM125	-M70 CTC2135	-M34 CTP5115
		-NR17 HCR1135	-NF23 HCN2125	-NM23 HCN2125	-M42 CWN2135	-NM26 HCN2125	-NM19 CWN2135	-M34 HCN5115
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN		DRAGONSKIN		DRAGONSKIN
		R	F	M	M	M	M	M
		TNMM	TNMG	TNMG	TNMG	TNMG	TNMG	TNMG
		1A/08	1A/08	1A/08	1A/08	1A/08	1A/08	1A/08
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	76 152 ...	75 019 ...	75 020 ...	70 148 ...	75 021 ...	70 155 ...	75 006 ...
		£	£	£	£	£	£	£
160404EN	0.4		9.27 216		9.19 404			
160408EN	0.8		9.27 218	9.27 218	9.19 408	9.27 218	9.19 418	9.19 516
160412EN	1.2			9.27 220		9.27 220		
220404EN	0.4							13.23 528
220408EN	0.8							13.23 530
220412EN	1.2	12.51 732						
220416EN	1.6							13.23 534
Steel		●	○	○	○	○	○	○
Stainless steel		○	●	●	●	●	●	○
Cast iron								
Non ferrous metals								
Heat resistant alloys		○		○	●	○	●	●

TNMG

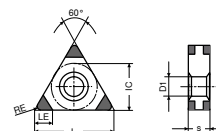
		-M42 CTP2120	-M52 CTP2120
		-M42 CCN2120	-M52 CCN2120
		M	M
		TNMG	TNMG
		1A/08	1A/08
ISO	RE	Article no.	Article no.
	mm	70 148 ...	70 152 ...
		£	£
160404EN	0.4		9.19 604
160408EN	0.8	9.19 608	9.19 608
Steel			
Stainless steel			○
Cast iron			○
Non ferrous metals			○
Heat resistant alloys			●

TNGA

Designation	L	S	D1	IC
	mm	mm	mm	mm
TNGA 1103..	11.0	3.18	2.26	6.35
TNGA 1604..	16.5	4.76	3.81	9.52



-A



-M (-6SC)

TNGA



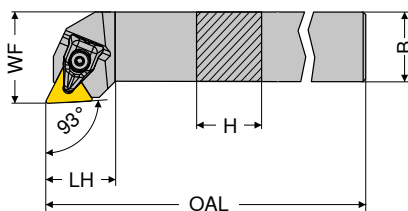
ISO	RE	GB	BN	LE
	mm	°	mm	mm
110304TN	0.4	20	0.14	2.8
110308FN	0.8			2.5
110308TN	0.8	20	0.14	2.5
160404FN	0.4			3.5
160404TN	0.4	15	0.09	2.8
160404SN	0.4	20	0.09	2.8
160404SN	0.4	20	0.11	2.8
160404TN	0.4	20	0.14	3.5
160404SN	0.4	25	0.11	2.8
160404TN	0.4	25	0.11	2.8
160404TN	0.4	25	0.12	3.5
160404FN	0.4			2.8
160404SN	0.4	25	0.13	2.8
160404SN	0.4	30	0.14	2.8
160404SN	0.4	35	0.14	2.8
160408TN	0.8	15	0.09	2.5
160408SN	0.8	15	0.09	2.5
160408SN	0.8	20	0.09	2.5
160408TN	0.8	20	0.09	2.5
160408SN	0.8	20	0.11	2.5
160408TN	0.8	20	0.14	3.0
160408SN	0.8	25	0.11	2.5
160408TN	0.8	25	0.11	2.5
160408TN	0.8	25	0.12	3.0
160408SN	0.8	25	0.13	2.5
160408SN	0.8	30	0.14	2.5
160408SN	0.8	35	0.14	2.5
160408FN	0.8			2.5
160408FN	0.8			3.0
160408EN	0.8			2.5
160412TN	1.2	15	0.09	2.2
160412SN	1.2	20	0.09	2.2
160412SN	1.2	20	0.11	2.2
160412SN	1.2	25	0.11	2.2
160412TN	1.2	25	0.11	2.2
160412SN	1.2	25	0.13	2.2
160412SN	1.2	30	0.14	2.2
160412SN	1.2	35	0.14	2.2
160412FN	1.2			2.2

-A CTBH21U	-M CTBH20C	-A CTBH40U	-M CTBH40C		
PBC25	-6SC PBC25-S	PBC40	-6SC PBC40-S		
F	F	F	F		
CBN TNGA Y0	CBN TNGA Y0	CBN TNGA Y0	CBN TNGA Y0		
Article no. 71 108 ...	Article no. 71 404 ...	Article no. 71 108 ...	Article no. 71 404 ...		
£	£	£	£		
52.75					
500					
		52.75	802 ¹⁾		
52.75					
502					
		52.75	804 ¹⁾		
52.75					
404 ¹⁾	128.25	222			
			128.25	332	
	128.25	242	128.25	342	
			128.25	352	
	128.25	252			
		52.75	904		
	128.25	212			
	128.25	262			
			128.25	372	
			128.25	382	
	128.25	224			
			128.25	324	
			128.25	334	
	128.25	234			
	128.25	244		128.25	344
52.75				128.25	354
	128.25	254			
		52.75	906		
	128.25	264		128.25	364
			128.25	374	
			128.25	384	
	128.25	214			
52.75				128.25	314
406 ¹⁾					
	128.25	226			
				128.25	336
	128.25	246		128.25	346
				128.25	356
	128.25	256			
	128.25	266		128.25	366
				128.25	376
				128.25	386
	128.25	216			

Cast iron				
Sintered steels				
Heat resistant alloys				
hardened < 45 HRC				
hardened 46–55 HRC	•	•	•	•
hardened 56–60 HRC	•	•	•	•
hardened 61–65 HRC			•	•

1) Machining to 60 HRC

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



Illustrations show right-hand versions

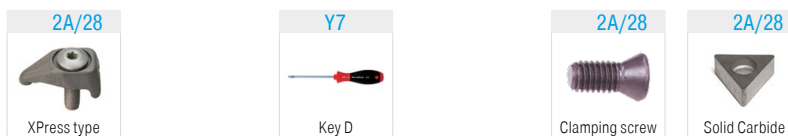


ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 591 ...	£	Article no. 70 590 ...	£
DTJN R/L 2020 K16	20	20	125	23	25	2	TNM. 1604	77.31	820	77.31	820
DTJN R/L 2525 M16	25	25	150	24	32	2	TNM. 1604	79.97	825	79.97	825

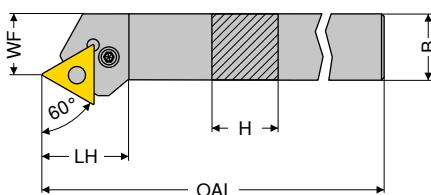
Spare parts

for Article no.

	Article no. 70 950 ...	£	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£			
70 590 820 / 70 591 820		21.91	823	T09 - IP	14.77	126	M3x7 - IP	2.85	819	6.31	847
70 590 825 / 70 591 825		21.91	823	T09 - IP	14.77	126	M3x7 - IP	2.85	819	6.31	847



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



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 529 ...	£	Article no. 70 528 ...	£
PTTN R/L 2020 K16	20	20	125	25.9	17	3	TNM. 1604	77.31	020	77.31	020
PTTN R/L 2525 M22	25	25	150	32.7	22	4	TNM. 2204	79.97	025	79.97	025

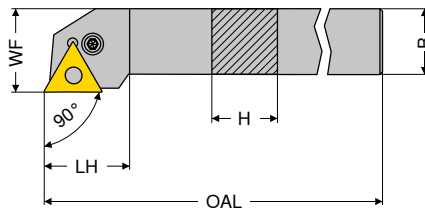
Spare parts

for Article no.

	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£				
70 529 020 / 70 528 020		2.23	175	SW2,5	1.60	197	1.11	191	11.35	185	2.90	208	6.31	225
70 529 025 / 70 528 025		2.23	176	SW3	1.60	198	1.11	192	11.45	187	3.18	209	9.03	226



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



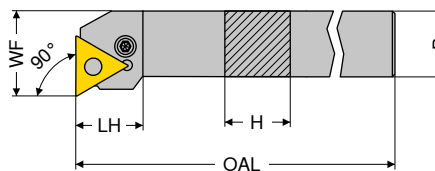
Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 533 ...	Article no. 70 532 ...	Article no. 70 533 ...	Article no. 70 532 ...
PTGN R/L 1616 H16	16	16	100	20	20	3	TNM. 1604	69.39	016	69.39	016
PTGN R/L 2020 K16	20	20	125	20	25	3	TNM. 1604	77.31	020	77.31	020
PTGN R/L 2525 M16	25	25	150	22	32	3	TNM. 1604	79.97	025	79.97	025
PTGN R/L 3225 P16	32	25	170	22	32	3	TNM. 1604	85.79	032	85.79	032
PTGN R/L 2525 M22	25	25	150	29	32	4	TNM. 2204	79.97	125	79.97	125
PTGN R/L 3232 P22	32	32	170	29	40	4	TNM. 2204	108.00	132	108.00	132

Spare parts for Article no.	2A/28		2A/28		2A/28		2A/28		2A/28		2A/28	
	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	
	£	£	£	£	£	£	£	£	£	£	£	
70 532 016 / 70 533 016	2.23	175	1.60	197	1.11	191	11.35	185	2.90	208	6.31	225
70 532 020 / 70 533 020	2.23	175	1.60	197	1.11	191	11.35	185	2.90	208	6.31	225
70 532 025 / 70 533 025	2.23	175	1.60	197	1.11	191	11.35	185	2.90	208	6.31	225
70 532 032 / 70 533 032	2.23	175	1.60	197	1.11	191	11.35	185	2.90	208	6.31	225
70 532 125 / 70 533 125	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	9.03	226
70 532 132 / 70 533 132	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	9.03	226

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



Illustrations show right-hand versions

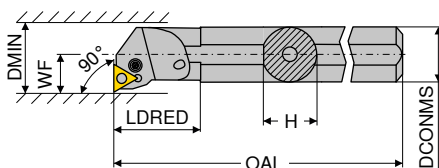


ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 535 ...	Article no. 70 534 ...	Article no. 70 535 ...	Article no. 70 534 ...
PTFN R/L 1616 H16	16	16	100	19.7	20	3	TNM. 1604	69.39	016	69.39	016
PTFN R/L 2020 K16	20	20	125	20.2	25	3	TNM. 1604	77.31	020	77.31	020
PTFN R/L 2525 M16	25	25	150	20.2	32	3	TNM. 1604	79.97	025	79.97	025
PTFN R/L 2525 M22	25	25	150	25.2	32	4	TNM. 2204	79.97	125	79.97	125
PTFN R/L 3225 P22	32	25	170	25.2	32	4	TNM. 2204	85.79	132	85.79	132

Spare parts for Article no.	2A/28		2A/28		2A/28		2A/28		2A/28		2A/28	
	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	
	£	£	£	£	£	£	£	£	£	£	£	
70 534 016 / 70 535 016	2.23	175	1.60	197	1.11	191	11.35	185	2.90	208	6.31	225
70 534 020 / 70 535 020	2.23	175	1.60	197	1.11	191	11.35	185	2.90	208	6.31	225
70 534 025 / 70 535 025	2.23	175	1.60	197	1.11	191	11.35	185	2.90	208	6.31	225
70 534 125 / 70 535 125	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	9.03	226
70 534 132 / 70 535 132	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	9.03	226

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

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



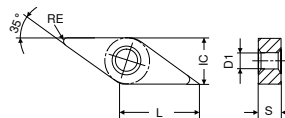
Illustrations show right-hand versions

ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 565 ...	£	Article no. 70 564 ...	£
A16M PTFN R/L 11	16	15.0	150	14.0	11	20	2,2	TNM. 1103	134.27	216	134.27	216
A20Q PTFN R/L 11	20	18.5	180	14.0	13	25	2,2	TNM. 1103	181.27	220	181.27	220
A25R PTFN R/L 16	25	23.0	200	17.5	17	32	3	TNM. 1604	202.00	225	202.00	225
A32S PTFN R/L 16	32	30.0	250	18.0	22	40	3	TNM. 1604	208.91	232	208.91	232
A40T PTFN R/L 22	40	38.0	300	27.0	27	50	4	TNM. 2204	232.73	240	232.73	240
S50W PTFN R 22	50	47.0	450	35.0	35	63	4	TNM. 2204			288.00	050

Spare parts for Article no.	2A/28		2A/28		2A/28		2A/28		2A/28		2A/28	
	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
70 564 216 / 70 565 216	2.23	177					11.45	184	1.93	207		
70 564 220 / 70 565 220	2.23	177					11.45	184	1.93	207		
70 564 225 / 70 565 225	2.23	175	1.60	197	1.11	191	11.35	185	2.90	208	6.31	225
70 564 232 / 70 565 232	2.23	175	1.60	197	1.11	191	11.35	185	2.90	208	6.31	225
70 564 240 / 70 565 240	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	9.03	226
70 564 050	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	9.03	226

VNMG / VNGP

Designation	L	S	D1	IC
	mm	mm	mm	mm
VN.. 1604..	16.6	4.76	3.81	9.52



VNMG

		-F40 CTCP125	-F50 CTCP115	-F50 CTCP125	-F50 CTCP135	-XU CTCP115	-XU CTCP125	-M40 CTCP125					
		-F40 HCX1125	-NF15 HCX1115	-NF15 HCX1125	-NF15 HCR1135	-XU HCX1115	-XU HCX1125	-M40 HCX1125					
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN					
		F VNMG	F VNMG	F VNMG	F VNMG	M VNMG	M VNMG	M VNMG					
		1A/08	1A/08	1A/08	1A/08	1A/08	1A/08	1A/08					
ISO	RE	Article no. 76 000 ...		Article no. 76 156 ...		Article no. 76 156 ...		Article no. 76 294 ...		Article no. 76 294 ...		Article no. 76 001 ...	
	mm	£	516	£	316	£	516	£	316	£	516	£	516
160404EN	0.4	18.71	516	18.71	316	18.71	716	18.67	316	18.67	516	18.71	516
160408EN	0.8	18.71	518	18.71	318	18.71	718	18.67	318	18.67	518	18.71	518
Steel		●	●	●	●	●	●	●	●	●	●	●	●
Stainless steel		○	○	○	○	○	○	○	○	○	○	○	○
Cast iron		○	○	○	○	○	○	○	○	○	○	○	○
Non ferrous metals													
Heat resistant alloys						○							

9

VNMG / VNGP

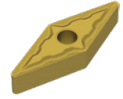
		-M50 CTCK120	-M50 CTCP115	-M50 CTCP125	-F30 CTPM125	-M30 CTPM125	-F32 CTP2120	-M34 CTP5110					
		-NM15 HCX3120	-NM15 HCX1115	-NM15 HCX1125	-NF23 HCN2125	-NM23 HCN2125	-F32 CCN2120	-M34 HCN5110					
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN					
		M VNMG	M VNMG	M VNMG	F VNMG	M VNMG	F VNGP	M VNMG					
		1A/08	1A/08	1A/08	1A/08	1A/08	1A/08	1A/08					
ISO	RE	Article no. 70 131 ...		Article no. 76 131 ...		Article no. 75 022 ...		Article no. 75 023 ...		Article no. 70 167 ...		Article no. 75 009 ...	
	mm	£	518	£	318	£	218	£	218	£	602	£	416
160402FN	0.2							24.92	602			17.79	416
160404EN	0.4			18.71	516	18.71	216						
160404FN	0.4							24.92	604				
160408EN	0.8	18.71	518	18.71	318	18.71	218					17.79	418
160412EN	1.2	18.71	520	18.71	320							17.79	420
Steel		●	●	●	○	○							
Stainless steel			○	○	●	●	●						○
Cast iron		●	○	○									
Non ferrous metals													
Heat resistant alloys							○	●					●

VNMG

-M34
CTP5115

-M34
HCN5115

DRAGONSKIN



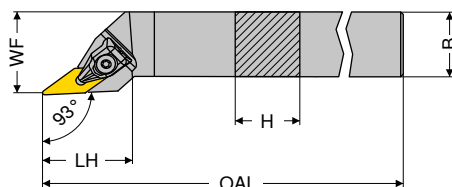
M
VNMG
1A/08

Article no.
75 009 ...

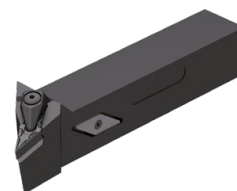
ISO	RE		£	
	mm			
160404EN	0.4		17.79	516
160408EN	0.8		17.79	518
160412EN	1.2		17.79	520

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

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



Illustrations show right-hand versions

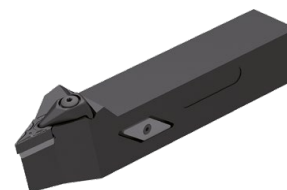
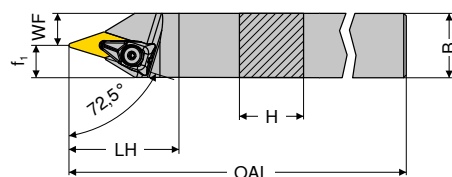


ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 503 ...	£	Article no. 70 502 ...	£
DVJN R/L 2020 K16	20	20	125	39	25	2	VN.. 1604	88.94	620	88.94	620
DVJN R/L 2525 M16	25	25	150	39	32	2	VN.. 1604	94.36	725	94.36	725

i Tool holders with HSK-T interface can be found in → Chapter 16.

Spare parts for Article no.	2A/28 XPress type		Y7 Key D		2A/28 Clamping screw		2A/28 Solid Carbide Seat V			
	Article no. 70 950 ...	£	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£		
70 502 620 / 70 503 620	26.15	835	T09 - IP	14.77	126	M3x7 - IP	2.85	819	5.08	806
70 502 725 / 70 503 725	26.15	835	T09 - IP	14.77	126	M3x7 - IP	2.85	819	5.08	806

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

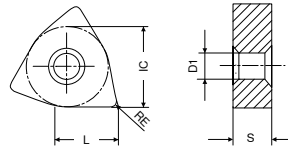


ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	f ₁ mm	torque moment Nm	Insert	Neutral 2A/24	
									Article no. 70 506 ...	£
DVVN N 2020 K16	20	20	125	43	7.5	12.5	2	VN.. 1604	88.94	620
DVVN N 2525 M16	25	25	150	43	12.5	12.5	2	VN.. 1604	94.36	625

Spare parts for Article no.	2A/28 XPress type		Y7 Key D		2A/28 Clamping screw		2A/28 Solid Carbide Seat V			
	Article no. 70 950 ...	£	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£		
70 506 620	26.15	835	T09 - IP	14.77	126	M3x7 - IP	2.85	819	5.08	806
70 506 625	26.15	835	T09 - IP	14.77	126	M3x7 - IP	2.85	819	5.08	806

WNMG / WNMA

Designation	L	S	D1	IC
	mm	mm	mm	mm
WNMG 0604..	6.5	4.76	3.81	9.52
WNM. 0804..	8.6	4.76	5.16	12.70



WNMG

		-CF20 CTEP110	-F50 CTCP115	-F50 CTCP125	-F50 CTCP135	-TFQ CTEP110	-TFQ CTCP115	-TFQ CTCP125
		-NF12 DCC1110	-NF15 HCX1115	-NF15 HCX1125	-NF15 HCR1135	-TFQ DCC1110	-TFQ HCX1115	-TFQ HCX1125
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F	F	F	F	F	F	F
		CERMET WNMG	WNMG	WNMG	WNMG	CERMET WNMG	WNMG	WNMG
		1A/78	1A/08	1A/08	1A/08	1A/78	1A/08	1A/08
ISO	RE	Article no. 76 171 ...	Article no. 76 157 ...	Article no. 76 157 ...	Article no. 76 157 ...	Article no. 76 177 ...	Article no. 76 177 ...	Article no. 76 177 ...
	mm	£	£	£	£	£	£	£
060404EN	0.4	8.80 004	9.05 304	9.05 504	9.05 704	10.47 006	10.47 304	10.47 514
060408EN	0.8	8.80 006	9.05 306	9.05 506	9.05 706	10.47 006	10.47 306	10.47 506
080404EN	0.4		11.39 316	11.39 516	11.39 716	13.11 016		
080408EN	0.8	11.39 018	11.39 318	11.39 518	11.39 718	13.11 018	13.11 318	13.11 518
080412EN	1.2		11.39 320	11.39 520	11.39 720	13.11 320	13.11 520	
Steel		●	●	●	●	●	●	●
Stainless steel		○	○	○	○	○	○	○
Cast iron		○	○	○	○	○	○	○
Non ferrous metals								
Heat resistant alloys					○			

WNMG

		-XU CTCP115		-XU CTCP125		-M50 CTCK110		-M50 CTCK120		-M50 CTCP115		-M50 CTCP125		-M50 CTCP135	
		-XU HCX1115		-XU HCX1125		-NM15 DCX3110		-NM15 HCF3120		-NM15 HCX1115		-NM15 HCX1125		-NM15 HCR1135	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		M		M		M		M		M		M		M	
		WNMG		WNMG		WNMG		WNMG		WNMG		WNMG		WNMG	
		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08	
ISO	RE	Article no.		Article no.		Article no.		Article no.		Article no.		Article no.		Article no.	
	mm	76 295 ...		76 295 ...		70 139 ...		70 139 ...		76 139 ...		76 139 ...		76 139 ...	
		£		£		£		£		£		£		£	
060404EN	0.4									9.05	304	9.05	504	9.05	704
060408EN	0.8									9.05	306	9.05	506	9.05	706
060412EN	1.2									9.05	308	9.05	508	9.05	708
080404EN	0.4	11.40	316	11.40	516					11.39	316	11.39	516	11.39	716
080408EN	0.8	11.40	318	11.40	518	11.39	018	11.39	518	11.39	318	11.39	518	11.39	718
080412EN	1.2	11.40	320	11.40	520	11.39	020	11.39	520	11.39	320	11.39	520	11.39	720
080416EN	1.6					11.39	022	11.39	522	11.39	322	11.39	522	11.39	722
Steel		●		●		●		●		●		●		●	
Stainless steel		○		○		○		○		○		○		○	
Cast iron		○		○		●		●		○		○		○	
Non ferrous metals															
Heat resistant alloys														○	

9

WNMG

		-TMQ CTCP115		-TMQ CTCP125		-M70 CTCK110		-M70 CTCK120		-M70 CTCP115		-M70 CTCP125		-M70 CTCP135	
		-TMQ HCX1115		-TMQ HCX1125		-NM19 DCX3110		-NM19 HCF3120		-NM19 HCX1115		-NM19 HCX1125		-NM19 HCR1135	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		M		M		M		M		M		M		M	
		WNMG		WNMG		WNMG		WNMG		WNMG		WNMG		WNMG	
		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08		1A/08	
ISO	RE	Article no.		Article no.		Article no.		Article no.		Article no.		Article no.		Article no.	
	mm	76 198 ...		76 198 ...		70 273 ...		70 273 ...		76 273 ...		76 273 ...		76 273 ...	
		£		£		£		£		£		£		£	
060408EN	0.8									9.05	306	9.05	506	9.05	706
060412EN	1.2									9.05	308	9.05	508	9.05	708
080408EN	0.8	13.11	31800	13.11	518	11.39	018	11.39	518	11.39	318	11.39	518	11.39	718
080412EN	1.2	13.11	320	13.11	520	11.39	020	11.39	520	11.39	320	11.39	520	11.39	720
080416EN	1.6					11.39	022	11.39	522	11.39	322	11.39	522	11.39	722
Steel		●		●		●		●		●		●		●	
Stainless steel		○		○		○		○		○		○		○	
Cast iron		○		○		●		●		○		○		○	
Non ferrous metals															
Heat resistant alloys														○	

WNMA / WNMG

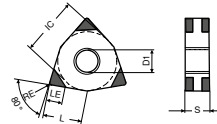
		CTCK110	CTCK120	-F30 CTPM125	-M30 CTPM125	-M42 CTC2135	-M60 CTPM125	-M70 CTC2135
		DCX3110	HCF3120	-NF23 HCN2125	-NM23 HCN2125	-M42 CWN2135	-NM26 HCN2125	-NM19 CWN2135
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN		DRAGONSKIN	
		R	R	F	M	M	M	M
		WNMA	WNMA	WNMG	WNMG	WNMG	WNMG	WNMG
		1A/08	1A/08	1A/08	1A/08	1A/08	1A/08	1A/08
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	70 169 ...	70 169 ...	75 024 ...	75 025 ...	70 178 ...	75 026 ...	70 273 ...
		£	£	£	£	£	£	£
060404EN	0.4			9.05 204		8.80 400		
060408EN	0.8			9.05 206	9.05 206	8.80 402	9.05 206	
060412EN	1.2				9.05 208		9.05 208	
080404EN	0.4			11.39 216		11.39 404		
080408EN	0.8	11.39 018	11.39 518	11.39 218	11.39 218	11.39 406	11.39 218	11.39 418
080412EN	1.2	11.39 020	11.39 520		11.39 220	11.39 408	11.39 220	
080416EN	1.6	11.39 022	11.39 522					
Steel				○	○	○	○	○
Stainless steel				●	●	●	●	●
Cast iron		●	●					
Non ferrous metals								
Heat resistant alloys					○	●	○	●

WNMG

		-M34 CTP5110	-M34 CTP5115	-M42 CTP2120	-M52 CTP2120
		-M34 HCN5110	-M34 HCN5115	-M42 CCN2120	-M52 CCN2120
		DRAGONSKIN	DRAGONSKIN		
		M	M	M	M
		WNMG	WNMG	WNMG	WNMG
		1A/08	1A/08	1A/08	1A/08
ISO	RE	Article no.	Article no.	Article no.	Article no.
	mm	75 008 ...	75 008 ...	70 178 ...	70 179 ...
		£	£	£	£
060404EN	0.4				8.80 604
060408EN	0.8				8.80 608
080404EN	0.4				11.39 612
080408EN	0.8	11.90 418	11.90 518	11.39 608	11.39 614
080412EN	1.2	11.90 420	11.90 520		
Steel					
Stainless steel			○	○	○
Cast iron					○
Non ferrous metals					○
Heat resistant alloys		●	●	●	●

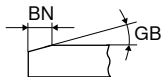
WNGA

Designation	L	S	D1	IC
	mm	mm	mm	mm
WNGA 0804..	8.5	4.76	5.13	12.7



-M (-6SC)

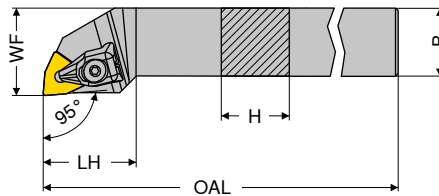
WNGA



	-M CTBS20C	-M CTBH20C	-M CTBH40C
	-6SC PBC15-S	-6SC PBC25-S	-6SC PBC40-S
	F	F	F
	CBN WNGA Y0	CBN WNGA Y0	CBN WNGA Y0
	Article no. 71 405 ...	Article no. 71 405 ...	Article no. 71 405 ...
	£	£	£
080404SN	125.05 122		
080404SN	125.05 132		
080404SN	125.05 152		125.05 332
080404SN		125.05 242	
080404SN			125.05 352
080404SN		125.05 262	
080404SN			125.05 372
080408SN	125.05 124		
080408SN	125.05 134		
080408SN	125.05 154		125.05 334
080408SN		125.05 244	
080408SN			125.05 354
080408SN		125.05 264	125.05 364
080408SN	125.05 174		
080408SN		125.05 274	125.05 376

Cast iron	•		
Sintered steels	•		
Heat resistant alloys	•		
hardened < 45 HRC			
hardened 46-55 HRC		•	•
hardened 56-60 HRC		•	•
hardened 61-65 HRC			•

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



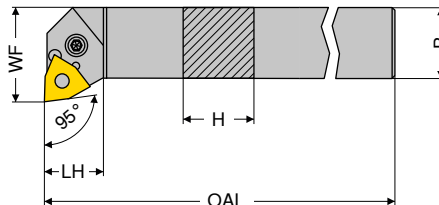
Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 543 ...	£	Article no. 70 542 ...	£
DWLN R/L 1616 H06	16	16	100	25	20	2	WN.. 0604	69.39	716	69.39	716
DWLN R/L 2020 K06	20	20	125	27	25	2	WN.. 0604	77.31	720	77.31	720
DWLN R/L 2525 M06	25	25	150	27	32	2	WN.. 0604	79.97	725	79.97	725
DWLN R/L 2020 K08	20	20	125	34	25	4	WN.. 0804	77.31	620	77.31	620
DWLN R/L 2525 M08	25	25	150	34	32	4	WN.. 0804	79.97	625	79.97	625

i Tool holders with HSK-T or PSC interface can be found in → Chapter 16.

Spare parts	2A/28 XPress type		Y7 Key D		2A/28 Clamping screw		2A/28 Solid Carbide Seat W			
	Article no. 70 950 ...	£	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£		
for Article no.										
70 543 716 / 70 542 716	21.91	823	T09 - IP	14.77	126	M3x7 - IP	2.85	819	3.09	807
70 543 720 / 70 542 720	21.91	823	T09 - IP	14.77	126	M3x7 - IP	2.85	819	3.09	807
70 543 725 / 70 542 725	21.91	823	T09 - IP	14.77	126	M3x7 - IP	2.85	819	3.09	807
70 543 620 / 70 542 620	21.61	824	T15 - IP	15.77	128	M4,5x12 - IP	2.71	820	9.03	812
70 543 625 / 70 542 625	21.61	824	T15 - IP	15.77	128	M4,5x12 - IP	2.71	820	9.03	812

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

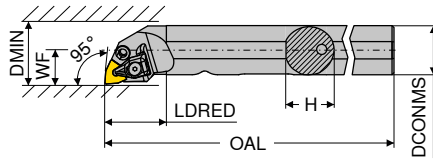


Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 543 ...	£	Article no. 70 542 ...	£
PWLN R/L 1616 H06	16	16	100	20	22.5	3	WNMG 0604	69.39	116	69.39	116
PWLN R/L 2020 K06	20	20	125	26	25.0	3	WNMG 0604	77.31	120	77.31	120
PWLN R/L 2525 M06	25	25	150	19	32.0	3	WNMG 0604	79.97	125	79.97	125
PWLN R/L 2020 K08	20	20	125	22	25.0	4	WNMG 0804	77.31	020	77.31	020
PWLN R/L 2525 M08	25	25	150	22	32.0	4	WNMG 0804	79.97	025	79.97	025
PWLN R/L 3225 P08	32	25	170	22	32.0	4	WNMG 0804	85.79	032	85.79	032

Spare parts	2A/28 Key I		2A/28 Shim		2A/28 Assembly pin		2A/28 Lever		2A/28 Clamping screw		2A/28 Solid Carbide Seat W				
	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£			
for Article no.															
70 542 116 / 70 543 116			SW2,5	2.23	175	1.87	122	1.11	191	11.35	185	2.90	208	6.55	127
70 542 120 / 70 543 120			SW2,5	2.23	175	1.87	122	1.11	191	11.35	185	2.90	208	6.55	127
70 542 125 / 70 543 125			SW2,5	2.23	175	1.87	122	1.11	191	11.35	185	2.90	208	6.55	127
70 542 020 / 70 543 020			SW3	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	7.93	235
70 542 025 / 70 543 025			SW3	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	7.93	235
70 542 032 / 70 543 032			SW3	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	7.93	235

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



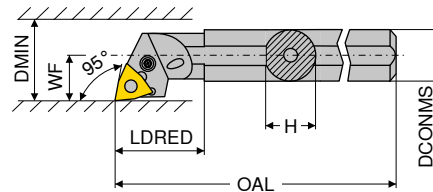
Illustrations show right-hand versions

ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 573 ...	£	Article no. 70 572 ...	£
A25R DWLN R/L 06	25	24	200	32	17	32	2	WN.. 0604	725	202.00	725	202.00
A32S DWLN R/L 08	32	31	250	40	22	40	4	WN.. 0804	732	208.91	732	208.91
A40T DWLN R 08	40	39	300	45	27	50	4	WN.. 0804				232.73

i Tool holders with HSK-T interface can be found in → Chapter 16.

Spare parts for Article no.	2A/28 XPress type		Y7 Key D		2A/28 Clamping screw		2A/28 Hydrant		2A/28 Solid Carbide Seat W	
	Article no. 70 950 ...	£	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
70 572 725 / 70 573 725	823	21.91	T09 - IP	126	14.77	M3x7 - IP	819	2.85	834	18.95
70 572 732 / 70 573 732	824	21.61	T15 - IP	128	15.77	M4,5x12 - IP	820	2.71	834	18.95
70 572 640	824	21.61	T15 - IP	128	15.77	M4,5x12 - IP	820	2.71	834	18.95

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



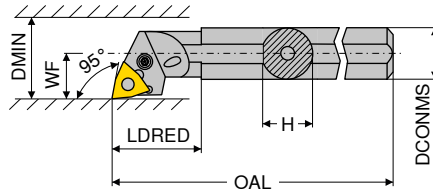
Illustrations show right-hand versions

ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 573 ...	£	Article no. 70 572 ...	£
A16M PWLN R/L 06	16	15	150	20	11	20	3	WNMG 0604	116	164.09	116	164.09
A20Q PWLN R/L 06-1	20	19	180	30	13	25	3	WNMG 0604	121	181.27	121	181.27
A25R PWLN R/L 06	25	23	200	25	17	32	3	WNMG 0604	125	202.00	125	202.00
A32S PWLN R/L 06	32	30	250	50	22	40	3	WNMG 0604	132	208.91	132	208.91
A25R PWLN R/L 08	25	23	200	40	17	31	4	WNMG 0804	225	202.09	225	202.09
A32S PWLN R/L 08	32	30	250	50	22	40	4	WNMG 0804	032	208.91	032	208.91
A40T PWLN R/L 08	40	39	300	60	27	50	4	WNMG 0804	040	232.73	040	232.73

Spare parts for Article no.	2A/28 Key I		2A/28 Shim		2A/28 Assembly pin		2A/28 Lever		2A/28 Clamping screw		2A/28 Solid Carbide Seat W	
	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
70 572 116 / 70 573 116	SW2	2.23	177				13.61	129	3.85	217		
70 572 121 / 70 573 121	SW2	2.23	177				13.61	129	3.85	217		
70 572 125 / 70 573 125	SW2,5	2.23	175	1.87	122	1.11	191	11.35	185	2.90	208	6.55
70 572 132 / 70 573 132	SW2,5	2.23	175	1.87	122	1.11	191	11.35	185	2.90	208	6.55
70 572 225 / 70 573 225	SW3	2.23	176				11.45	187	3.89	205		
70 572 032 / 70 573 032	SW3	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	7.93
70 572 040 / 70 573 040	SW3	2.23	176	1.60	198	1.11	192	11.45	187	3.18	209	7.93

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

▲ with carbide core



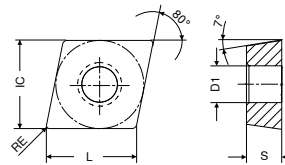
Illustrations show right-hand versions

ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A		Right-hand 2A	
									Article no. 70 567 ...	£	Article no. 70 566 ...	£
E-A16M PWLN R/L 06	16	15	150	24	11	20	3	WNMG 0604	582.18	016	582.18	016
E-A20Q PWLN R/L 06	20	18	180	29	13	27	3	WNMG 0604	622.36	020	622.36	020
E-A25R PWLN R/L 06	25	23	200	40	17	31	3	WNMG 0604	645.09	025	645.09	025
E-A25R PWLN R/L 08	25	23	200	40	17	31	4	WNMG 0804	645.09	125	645.09	125
E-A32S PWLN R/L 08	32	30	250	50	22	39	4	WNMG 0804	851.55	032	851.55	032
E-A40T PWLN R/L 08	40	38	300	60	27	48	4	WNMG 0804	1,016.36	040	1,016.36	040

Spare parts	2A/28		2A/28		2A/28		2A/28		2A/28		2A/28	
	Key I	Shim	Assembly pin	Lever	Clamping screw	Solid Carbide Seat W	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
for Article no.												
70 566 016 / 70 567 016		SW2					2.23	177			13.61	129
70 566 020 / 70 567 020		SW2					2.23	177			13.61	129
70 566 025 / 70 567 025		SW2,5					2.23	175	1.87	122	11.35	185
70 566 125 / 70 567 125		SW3					2.23	176			11.45	187
70 566 032 / 70 567 032		SW3					2.23	176	1.60	198	11.45	187
70 566 040 / 70 567 040		SW3					2.23	176	1.60	198	11.45	187

CCGT / CCMT / CCXT

Designation	L	S	D1	IC
	mm	mm	mm	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	-SF TCM10	-SF TCM407	-SF CTCP125	-SF CTCP135	-SF CTCP115	-SF CTCP125
		-PF14 DCC1110	-ZF CWC10	-ZF CWC407	-ZF HCX1125	-ZF HCR1135	-ZF HCX1115	-ZF HCX1125
		DRAGONSKIN			DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F	F	F	F	F	F	F
		CERMET CCGT	CERMET CCGT	CERMET CCGT	CCGT	CCGT	CCMT	CCMT
		1A/78	1A/78	1A/78	1A/08	1A/08	1A/08	1A/08
ISO	RE	Article no. 76 247 ...	Article no. 70 251 ...	Article no. 70 251 ...	Article no. 76 251 ...	Article no. 76 251 ...	Article no. 76 253 ...	Article no. 76 253 ...
	mm	£	£	£	£	£	£	£
060202EN	0.2	12.60 002	12.21 900	12.21 850	12.60 502	12.60 702		
060204EN	0.4	12.60 004	12.21 902	12.21 852			7.07 304	7.07 504
09T302EN	0.2	13.43 014	12.60 904	12.60 854				
09T304EN	0.4	13.43 016	12.60 906				8.82 316	8.82 516
09T308EN	0.8	13.43 018	12.60 908				8.82 318	8.82 518
120404EN	0.4		15.76 910					12.42 528
120408EN	0.8							12.42 530
Steel		●	●	●	●	●	●	●
Stainless steel		○			○	○	○	○
Cast iron		○	○	○	○		○	○
Non ferrous metals								
Heat resistant alloys						○		

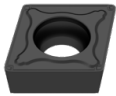



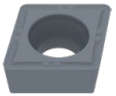

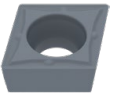
CCMT / CCGT

		-SF CTCP135	-CF55 CTEP110	-SMF TCM10	-SMF CTCP115	-SMF CTCP125	-SMF CTCP135	-SM CTCP125
		-ZF HCR1135	-PF15 DCC1110	-SMF CWC10	-SMF HCX1115	-SMF HCX1125	-SMF HCR1135	-ZM HCX1125
		DRAGONSKIN	DRAGONSKIN		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F	F	F	F	F	F	M
		CCMT	CERMET CCMT	CERMET CCMT	CCMT	CCMT	CCMT	CCGT
		1A/08	1A/78	1A/78	1A/08	1A/08	1A/08	1A/08
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	76 253 ...	76 248 ...	70 249 ...	76 249 ...	76 249 ...	76 249 ...	76 250 ...
		£	£	£	£	£	£	£
060202EN	0.2							12.60 502
060204EN	0.4	7.07 704	6.85 004	6.62 900		7.07 504	7.07 704	
060208EN	0.8					7.07 506		
09T304EN	0.4	8.82 716	8.80 016	8.21 904	8.82 316	8.82 516	8.82 716	
09T308EN	0.8		8.80 018	8.21 906	8.82 318	8.82 518		
120404EN	0.4		12.42 028			12.42 528		
120408EN	0.8				12.42 330		12.42 730	
Steel		●	●	●	●	●	●	●
Stainless steel		○	○		○	○	○	○
Cast iron			○	○	○	○		○
Non ferrous metals								
Heat resistant alloys		○					○	

CCGT / CCMT

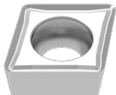

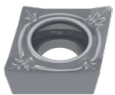

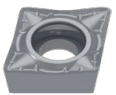
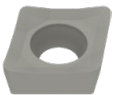

		-SM CTCP135	-SM CTCK110	-SM CTCK120	-SM CTCP115	-SM CTCP125	-SM CTCP135	-SMQ CTCP115
		-ZM HCR1135	-ZM DCX3110	-ZM HCF3120	-ZM HCX1115	-ZM HCX1125	-ZM HCR1135	-SMQ HCX1115
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M	M	M	M	M	M	F
		CCGT	CCMT	CCMT	CCMT	CCMT	CCMT	CCMT
		1A/08	1A/08	1A/08	1A/08	1A/08	1A/08	1A/08
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	76 250 ...	70 252 ...	70 252 ...	76 252 ...	76 252 ...	76 252 ...	76 194 ...
		£	£	£	£	£	£	£
060202EN	0.2	12.60 702						
060204EN	0.4		7.07 004	7.07 554	7.07 304	7.07 504	7.07 704	
060208EN	0.8		7.07 006	7.07 506	7.07 306		7.07 706	
09T304EN	0.4		8.82 016	8.82 516	8.82 316	8.82 516	8.82 716	9.92 31600
09T308EN	0.8		8.82 018	8.82 518	8.82 318	8.82 518	8.82 718	9.92 31800
09T312EN	1.2		8.82 020	8.82 520				
120404EN	0.4		12.42 028	12.42 528	12.42 328	12.42 528	12.42 728	13.94 32800
120408EN	0.8		12.42 030	12.42 530	12.42 330	12.42 530	12.42 730	13.94 330
120412EN	1.2					12.42 532		
Steel		●	●	●	●	●	●	●
Stainless steel		○	○		○	○	○	○
Cast iron			●	●	○	○		○
Non ferrous metals								
Heat resistant alloys		○					○	

CCMT / CCXT

		-SMQ CTCP125	-SF CTC2135	-F43 CTC2135	-M81 CWN2120	-M25 CTPM125	-SM CTC2135	-M55 CTPM125
		-SMQ HCX1125	-ZF CWN2135	-F43 CWN2135		-PF23 HCN2125	-ZM CWN2135	-PF26 HCN2125
		DRAGONSKIN				DRAGONSKIN		DRAGONSKIN
								
		F	F	F	M	F	M	F
		CCMT	CCMT	CCMT	CCXT	CCMT	CCMT	CCMT
		1A/08	1A/08	1A/08	1A	1A/08	1A/08	1A/08
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	£	£	£	£	£	£	£
060202FN	0.2				8.76	100		
060204EN	0.4		6.85	460			7.07	204
060204FN	0.4				8.76	102		
09T302FN	0.2				8.57	104		
09T304EN	0.4	9.92	8.80	464	8.80	460	8.82	216
09T304FN	0.4				8.57	106		
09T308EN	0.8	9.92		462	8.80	462	8.82	218
09T308FN	0.8				8.57	108		
120404EN	0.4	13.94					12.42	678
120408EN	0.8	13.94					12.42	680
Steel		•	○	○	○	○	○	○
Stainless steel		○	•	•	•	•	•	•
Cast iron		○						
Non ferrous metals					○			
Heat resistant alloys			•	•			•	

9

CCGT

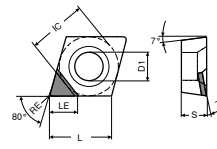
		-23P H216T	-25P H210T	-25P AMZ	-25Q H210T	-25Q AMZ	-27 H10T	-27 CWN15	
		-23P CWK26	-25P CWK20	-25P AMZ	-25Q CWK20	-25Q AMZ	-AL CWK15	-AL CWN15	
									
		F	F	F	M	M	M	M	
		CCGT	CCGT	CCGT	CCGT	CCGT	CCGT	CCGT	
		1A/90	1A/90	1A/90	1A/90	1A	1A/90	1A	
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	
	mm	£	£	£	£	£	£	£	
060202FN	0.2	9.92	652	9.92	636	11.80	556	11.80	558
060204FN	0.4	9.92	654	9.92	638	11.80	558	10.78	678
09T302FN	0.2			10.38	639	12.10	539		
09T304FN	0.4	10.38	656	10.38	640	12.10	560	11.39	680
09T308FN	0.8	10.38	658	10.38	641	12.10	541	11.39	681
120402FN	0.2			12.10	643			16.80	622
120404FN	0.4			12.10	642	15.45	562	13.43	682
120408FN	0.8			12.10	644	15.45	564	13.43	686
Steel					○		○		
Stainless steel					○		○	○	
Cast iron		○	○	○	○	○	○	○	
Non ferrous metals		•	•	•	•	•	•	•	
Heat resistant alloys		○	○				○		

CCGT / CCMT

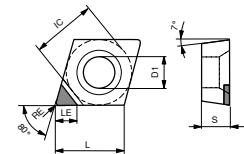
ISO	RE mm	-27 AMZ		-29 H216T		-29 AMZ		-F23 CTP2120	
		-AL AMZ						-F23 CCN2120	
		M CCGT		M CCMT		M CCMT		F CCGT	
		1A/90		NEW 1A/90		NEW 1A/90		1A/08	
		Article no. 70 254 ...		Article no. 70 245 ...		Article no. 70 245 ...		Article no. 70 191 ...	
		£		£		£		£	
060200FN	0.0							12.60	600
060201FN	0.1							12.60	602
060202FN	0.2	11.29	450						
060204EN	0.4			7.15	60400	8.55	40400		
060204FN	0.4	11.29	452						
09T300FN	0.0							14.55	604
09T301FN	0.1							14.55	606
09T302FN	0.2	11.59	454						
09T304EN	0.4			7.61	61600	8.83	41600		
09T304FN	0.4	11.59	456						
09T308EN	0.8			7.61	61800	8.83	41800		
09T308FN	0.8	11.59	458						
120402FN	0.2	14.45	460						
120404FN	0.4	14.45	462						
120408FN	0.8	14.45	464						
Steel			○				○		
Stainless steel			○				○		●
Cast iron			○		○		○		○
Non ferrous metals			●		●		●		○
Heat resistant alloys					○				●

CCGW / CCGT

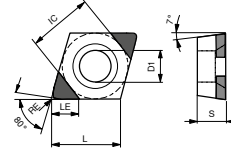
Designation	L	S	D1	IC
	mm	mm	mm	mm
CCG. 0602..	6.40	2.38	2.8	6.35
CCGW 09T3..	9.70	3.97	4.4	9.52
CCGW 1204..	12.90	4.76	5.5	12.70



CCGT -A

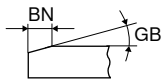


CCGW -A



CCGW-Q-B / -B
(CCGW -2MC / -2Q)

CCGW / CCGT

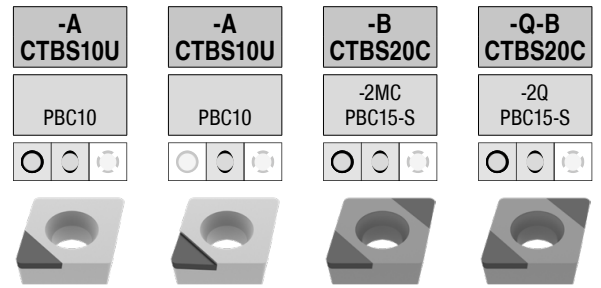
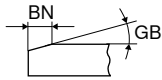


-A CTBS10U	-A CTBS10U	-B CTBS20C	-Q-B CTBS20C
PBC10	PBC10	-2MC PBC15-S	-2Q PBC15-S
F	F	F	F
CBN CCGW Y0	CBN CCGT Y0	CBN CCGW Y0	CBN CCGW Y0

ISO	RE	GB	BN	LE	Article no. 71 120 ...	Article no. 71 124 ...	Article no. 71 161 ...	Article no. 71 162 ...
	mm	°	mm	mm	£	£	£	£
060202SN	0.2	10	0.09	3.4				73.32 120
060202SN	0.2	15	0.11	3.4				73.32 130
060202TN	0.2	20	0.14	3.4	62.03 300			73.32 140
060202TN	0.2	20	0.15	3.4				73.32 150
060202SN	0.2	20	0.16	3.4			73.32 150	73.32 150
060202TN	0.2	25	0.17	3.4			73.32 160	73.32 160
060202FN	0.2			3.4	62.03 200	76.10 200		
060202EN	0.2			3.4			73.32 110	73.32 110
060204SN	0.4	10	0.09	3.1			73.32 121	73.32 121
060204SN	0.4	15	0.11	3.1			73.32 131	73.32 131
060204TN	0.4	20	0.14	3.1	62.03 302			
060204TN	0.4	20	0.15	3.1			73.32 141	73.32 141
060204SN	0.4	20	0.16	3.1			73.32 151	73.32 151
060204TN	0.4	25	0.17	3.1			73.32 161	73.32 161
060204SN	0.4	25	0.18	3.1			73.32 171	73.32 171
060204FN	0.4			3.1	62.03 202	76.10 202		
060208SN	0.8	10	0.09	2.8			73.32 122	
060208SN	0.8	15	0.11	2.8			73.32 132	
060208TN	0.8	20	0.15	2.8			73.32 142	
060208TN	0.8	25	0.17	2.8			73.32 162	
060208SN	0.8	25	0.18	2.8			73.32 172	
060208SN	0.8	30	0.18	2.8			73.32 182	
060208EN	0.8			2.8			73.32 112	
09T302SN	0.2	10	0.09	3.4			73.32 123	
09T302SN	0.2	15	0.11	3.4			73.32 133	
09T302SN	0.2	20	0.16	3.4			73.32 153	
09T302TN	0.2	25	0.17	3.4			73.32 163	
09T302SN	0.2	25	0.18	3.4			73.32 173	
09T302EN	0.2			3.4			73.32 113	

Cast iron	•	•	•	•
Sintered steels	•	•	•	•
Heat resistant alloys	•	•	•	•
hardened < 45 HRC				
hardened 46-55 HRC				
hardened 56-60 HRC				
hardened 61-65 HRC				

CCGW / CCGT



F
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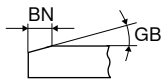
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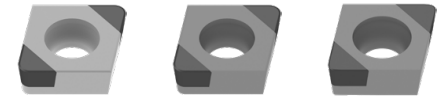
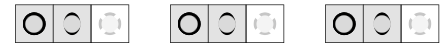
ISO	RE mm	GB °	BN mm	LE mm	-A CTBS10U		-B CTBS20C		-Q-B CTBS20C	
					Article no. 71 120 ... £	Article no. 71 124 ... £	Article no. 71 161 ... £	Article no. 71 162 ... £		
09T304EN	0.4			3.1			73.32	114		
09T304SN	0.4	10	0.09	3.1			73.32	124	73.32	124
09T304SN	0.4	15	0.11	3.1			73.32	134	73.32	134
09T304TN	0.4	20	0.14	2.8	62.03	304				
09T304TN	0.4	20	0.15	3.1			73.32	144	73.32	144
09T304SN	0.4	20	0.16	3.1			73.32	154	73.32	154
09T304TN	0.4	25	0.17	3.1			73.32	164	73.32	164
09T304SN	0.4	25	0.18	3.1			73.32	174	73.32	174
09T304SN	0.4	30	0.18	3.1			73.32	184		
09T304FN	0.4			2.8	62.03	204				
09T308SN	0.8	10	0.09	2.8			73.32	125	73.32	125
09T308SN	0.8	15	0.11	2.8					73.32	135
09T308TN	0.8	20	0.14	2.5	62.03	306				
09T308TN	0.8	20	0.15	2.8			73.32	145	73.32	145
09T308SN	0.8	20	0.16	2.8			73.32	155	73.32	155
09T308TN	0.8	25	0.17	2.8			73.32	165	73.32	165
09T308SN	0.8	25	0.18	2.8			73.32	175		
09T308SN	0.8	30	0.18	2.8			73.32	185		
09T308FN	0.8			2.5	62.03	206				
09T308EN	0.8			2.8					73.32	115
120404FN	0.4			3.1	52.75	208				
120404TN	0.4	20	0.14	3.1	52.75	308				
120408FN	0.8			2.8	52.75	210				
120408TN	0.8	20	0.14	2.8	52.75	310				

Cast iron	•	•	•	•
Sintered steels	•	•	•	•
Heat resistant alloys	•	•	•	•
hardened < 45 HRC				
hardened 46–55 HRC				
hardened 56–60 HRC				
hardened 61–65 HRC				

CCGW



-B
CTBH15U **-B**
CTBH15C **-Q-B**
CTBH15C

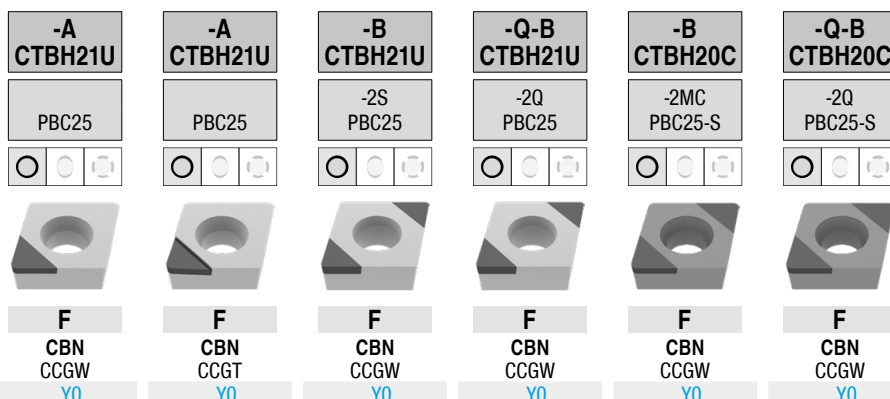


F
CBN
CCGW **F**
CBN
CCGW **F**
CBN
CCGW

ISO	RE	GB	BN	LE	NEW YO		NEW YO		NEW YO	
					Article no.	£	Article no.	£	Article no.	£
060202SN	0.2	15	0.11	3.4						
060202EN	0.2			3.4						
060204SN	0.4	15	0.11	3.1	82.40	30414	79.70	30414		
060204SN	0.4	25	0.13	3.1	82.40	30429	79.70	30429		
060204EN	0.4			3.1	82.40	00400	79.70	00400		
060208EN	0.8			2.8	82.40	00600	79.70	00600		
060208SN	0.8	15	0.11	2.8	82.40	30614	79.70	30614		
060208SN	0.8	25	0.13	2.8	82.40	30629	79.70	30629		
09T302SN	0.2	15	0.11	3.4			79.70	31414		
09T302SN	0.2	25	0.13	3.4			79.70	31429		
09T304SN	0.4	15	0.11	3.1			79.70	31614	92.45	31614
09T304SN	0.4	25	0.13	3.1			79.70	31629	79.70	31629
09T308SN	0.8	15	0.11	2.8			79.70	31814	79.70	31814
09T308SN	0.8	25	0.13	2.8			79.70	31829	79.70	31829

Cast iron			
Sintered steels			
Heat resistant alloys			
hardened < 45 HRC	•	•	•
hardened 46–55 HRC	•	•	•
hardened 56–60 HRC	•	•	•
hardened 61–65 HRC			

CCGW / CCGT

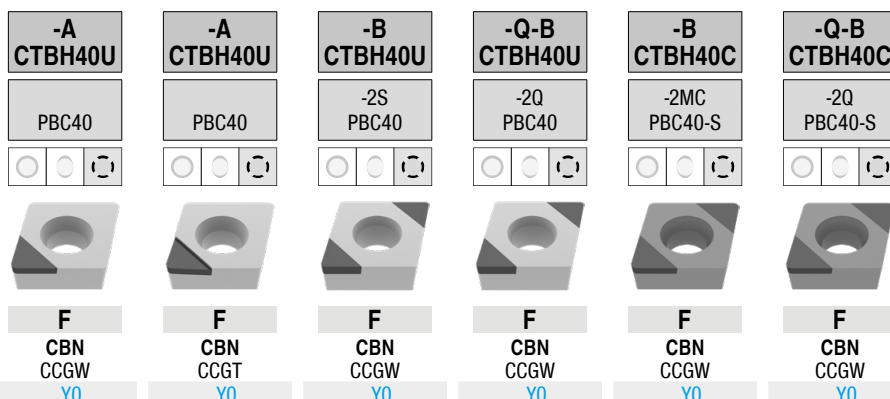


ISO	RE mm	GB °	BN mm	LE mm	-A CTBH21U		-B CTBH21U		-Q-B CTBH21U		-B CTBH20C		-Q-B CTBH20C	
					Article no. 71 120 ... £	Article no. 71 124 ... £	Article no. 71 121 ... £	Article no. 71 123 ... £	Article no. 71 161 ... £	Article no. 71 162 ... £				
060202SN	0.2	10	0.09	3.4						73.32	230	73.32	230	
060202SN	0.2	15	0.11	3.4								73.32	240	
060202SN	0.2	20	0.09	3.4						73.32	250			
060202TN	0.2	20	0.14	3.4	62.03	500								
060202TN	0.2	25	0.14	3.4						73.32	260			
060202EN	0.2			3.4								73.32	220	
060202SN	0.2	25	0.15	3.4						73.32	270			
060202FN	0.2			3.4	62.03	400 ¹⁾	76.10	400				73.32	210	
060204EN	0.4			3.1						73.32	221			
060204SN	0.4	10	0.09	3.1						73.32	231	73.32	231	
060204SN	0.4	15	0.11	3.1						73.32	241	73.32	241	
060204SN	0.4	20	0.09	3.1						73.32	251	73.32	251	
060204TN	0.4	20	0.14	3.1	62.03	502								
060204TN	0.4	25	0.14	3.1						73.32	261	73.32	261	
060204FN	0.4			3.1	62.03	402 ¹⁾	76.10	402						
060204SN	0.4	25	0.15	3.1						73.32	271			
060208SN	0.8	10	0.09	2.8						73.32	232			
060208SN	0.8	20	0.09	2.8						73.32	252			
060208TN	0.8	25	0.14	2.8						73.32	262			
060208SN	0.8	30	0.18	2.8						73.32	282			
060208FN	0.8			2.8						73.32	212			
09T302SN	0.2	10	0.09	3.4						73.32	233			
09T302SN	0.2	15	0.11	3.4						73.32	243			
09T302SN	0.2	20	0.09	3.4						73.32	253			
09T302SN	0.2	25	0.15	3.4						73.32	273			
09T304SN	0.4	10	0.09	3.1						73.32	234			
09T304SN	0.4	15	0.11	3.1						73.32	244			
09T304SN	0.4	20	0.09	3.1						73.32	254			
09T304TN	0.4	20	0.14	2.8	62.03	504								
09T304TN	0.4	20	0.14	3.1			103.14	502	85.72	502				
09T304TN	0.4	25	0.14	3.1						73.32	264			
09T304SN	0.4	25	0.15	3.1						73.32	274			
09T304SN	0.4	30	0.18	3.1						73.32	284			
09T304EN	0.4			3.1						73.32	224			
09T304FN	0.4			3.1			103.14	402 ¹⁾						
09T304FN	0.4			2.8	62.03	404 ¹⁾								
09T308SN	0.8	10	0.09	2.8						73.32	235	73.32	235	
09T308SN	0.8	15	0.11	2.8						73.32	245	73.32	245	
09T308SN	0.8	20	0.09	2.8								73.32	255	
09T308TN	0.8	20	0.14	2.8			103.14	504	85.72	504				
09T308TN	0.8	20	0.14	2.5	62.03	506								
09T308TN	0.8	25	0.14	2.8						73.32	265	73.32	265	
09T308SN	0.8	25	0.15	2.8						73.32	275			
09T308FN	0.8			2.5	62.03	406 ¹⁾								
09T308EN	0.8			2.8								73.32	225	
09T308FN	0.8			2.8			103.14	404 ¹⁾	85.72	404 ¹⁾		73.32	215	
120404TN	0.4	20	0.14	3.1	52.75	508								
120408TN	0.8	20	0.14	2.8	52.75	510								

Cast iron														
Sintered steels														
Heat resistant alloys														
hardened < 45 HRC														
hardened 46–55 HRC						•		•		•		•		•
hardened 56–60 HRC						•		•		•		•		•
hardened 61–65 HRC														

1) Machining to 60 HRC

CCGW / CCGT

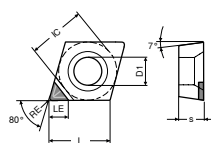


ISO	RE mm	GB °	BN mm	LE mm	-A CTBH40U		-B CTBH40U		-Q-B CTBH40C		-B CTBH40C		-Q-B CTBH40C	
					Article no. 71 120 ...	Article no. 71 124 ...	Article no. 71 121 ...	Article no. 71 123 ...	Article no. 71 161 ...	Article no. 71 162 ...	Article no. 71 162 ...	Article no. 71 162 ...		
					£	£	£	£	£	£	£	£	£	£
060202TN	0.2	20	0.09	3.4						73.32	320			
060202SN	0.2	20	0.09	3.4								73.32	330	
060202SN	0.2	25	0.09	3.4						73.32	350		73.32	350
060202TN	0.2	25	0.11	3.4						73.32	340		73.32	340
060202TN	0.2	25	0.12	3.4	62.69	900								
060202TN	0.2	30	0.14	3.4						73.32	360		73.32	360
060202FN	0.2		3.4		62.69	800	76.10	800						
060204SN	0.4	20	0.09	3.1						73.32	331			
060204SN	0.4	25	0.09	3.1						73.32	351		73.32	351
060204TN	0.4	25	0.11	3.1						73.32	341		73.32	341
060204TN	0.4	25	0.12	3.1	62.69	902								
060204TN	0.4	30	0.14	3.1						73.32	361		73.32	361
060204SN	0.4	30	0.16	3.1						73.32	371		73.32	371
060204SN	0.4	35	0.17	3.1						73.32	381		73.32	381
060204FN	0.4		3.1		62.69	802	76.10	802						
060208TN	0.8	20	0.09	2.8						73.32	322			
060208SN	0.8	25	0.09	2.8						73.32	352			
060208TN	0.8	25	0.11	2.8						73.32	342			
060208TN	0.8	30	0.14	2.8						73.32	362			
060208SN	0.8	30	0.16	2.8						73.32	372			
060208SN	0.8	35	0.17	2.8						73.32	382			
09T302TN	0.2	20	0.09	3.4						73.32	323			
09T302SN	0.2	25	0.09	3.4						73.32	353			
09T302TN	0.2	25	0.11	3.4						73.32	343			
09T302SN	0.2	30	0.16	3.4						73.32	373			
09T302SN	0.2	35	0.17	3.4						73.32	383			
09T304SN	0.4	20	0.09	3.1						73.32	334	73.32	334	
09T304TN	0.4	20	0.09	3.1						73.32	324	73.32	324	
09T304SN	0.4	25	0.09	3.1						73.32	354	73.32	354	
09T304TN	0.4	25	0.11	3.1						73.32	344	73.32	344	
09T304TN	0.4	25	0.12	3.1			103.14	902	85.72	902				
09T304TN	0.4	25	0.12	2.8	62.69	904								
09T304TN	0.4	30	0.14	3.1						73.32	364	73.32	364	
09T304SN	0.4	30	0.16	3.1						73.32	374			
09T304EN	0.4		3.1							73.32	314			
09T304SN	0.4	35	0.17	3.1						73.32	384			
09T304FN	0.4		3.1				103.14	802	85.72	802				
09T304FN	0.4		2.8		62.69	804								
09T308SN	0.8	20	0.09	2.8						73.32	335	73.32	335	
09T308TN	0.8	20	0.09	2.8						73.32	325	73.32	325	
09T308SN	0.8	25	0.09	2.8						73.32	355	73.32	355	
09T308TN	0.8	25	0.11	2.8						73.32	345	73.32	345	
09T308TN	0.8	25	0.12	2.8			103.14	904	85.72	904				
09T308TN	0.8	25	0.12	2.5	62.69	906								
09T308TN	0.8	30	0.14	2.8						73.32	365	73.32	365	
09T308SN	0.8	30	0.16	2.8								73.32	375	
09T308SN	0.8	35	0.17	2.8						73.32	385			
09T308FN	0.8		2.8				103.14	804	85.72	804				
09T308FN	0.8		2.5		62.69	806								
09T308EN	0.8		2.8									73.32	315	
120404FN	0.4		3.1		52.75	808								
120404TN	0.4	25	0.12	3.1	52.75	908								
120408TN	0.8	25	0.12	2.8	52.75	910								

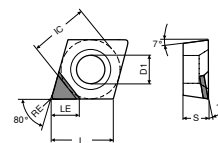
Cast iron														
Sintered steels														
Heat resistant alloys														
hardened < 45 HRC														
hardened 46–55 HRC														
hardened 56–60 HRC														
hardened 61–65 HRC														

CCGW / CCGT

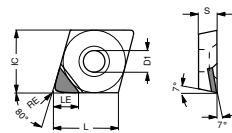
Designation	L	S	D1	IC
	mm	mm	mm	mm
CCG. 0602..	6,45	2,38	2,8	6,35
CCG. 09T3..	9,70	3,97	4,4	9,52
CCG. 1204..	12,90	4,76	5,5	12,70



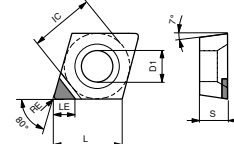
CCGW-Q-A



CCGT-A



CCGT-Q-A



CCGW-A

CCGW / CCGT

-A CTDMD05	-A CTDPD20	-A CTDPD20	-Q-A CTDPD20	-Q-A CTDPD20
MDC	PDC	PDC	-2Q PDC	-2Q PDC
F DIAMOND CCGW Y0	F DIAMOND CCGW Y0	F DIAMOND CCGT Y0	F DIAMOND CCGW Y0	F DIAMOND CCGT Y0

ISO	RE	LE	Article no. 71 120 ... £	Article no. 71 120 ... £	Article no. 71 124 ... £	Article no. 71 125 ... £	Article no. 71 126 ... £
060201FN	0.1	3.4					98.64 101
060202FN	0.2	2.5	346.11 050			98.64 102	98.64 102
060202FN	0.2	3.3		97.26 100	91.24 100		
060202FN	0.2	3.4					
060204FN	0.4	2.5	346.11 052				
060204FN	0.4	3.1					98.64 104
060204FN	0.4	3.2		97.26 102	91.24 102	98.64 104	
09T301FN	0.1	4.5				98.61 111	98.61 111
09T302FN	0.2	4.4				98.61 112	98.61 112
09T304FN	0.4	2.5	353.00 054				
09T304FN	0.4	4.2				98.61 114	98.61 114
09T304FN	0.4	4.3		100.46 104	93.41 104		
09T308FN	0.8	2.5	353.00 056				
09T308FN	0.8	4.1		100.46 106	93.41 106		
120402FN	0.2	4.4				102.27 122	102.27 122
120404FN	0.4	4.2				102.27 124	102.27 124
120404FN	0.4	4.3		78.24 108	78.24 108		
120408FN	0.8	4.1		78.24 110	78.24 110		

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

CCGT / CCGW

ISO	RE mm	LE mm	-A-CB1 CTDPD20		-A-CB1 CTDPD20		-Q-A CTDPS30		-Q-A CTDPS30		-A-CB2 CTDPS30		-A-Q-CB2 CTDPS30	
			-CB1 PDC		-Q-CB1 PDC		-2Q PDC-S		-2Q PDC-S		-CB2 PDC-S		-Q-CB2 PDC-S	
			F DIAMOND CCGT YO	F DIAMOND CCGT YO	F DIAMOND CCGW YO	F DIAMOND CCGT YO	F DIAMOND CCGW YO	F DIAMOND CCGT YO	M DIAMOND CCGT YO	M DIAMOND CCGT YO				
			Article no. 71 300 ...	Article no. 71 305 ...	Article no. 71 125 ...	Article no. 71 126 ...	Article no. 71 126 ...	Article no. 71 301 ...	Article no. 71 306 ...					
			£	£	£	£	£	£	£					
060202FN	0.2	3.3			98.64	152	98.64	152						
060202EN	0.2	3.3							101.43	202				
060202EN	0.2	3.4						88.31	202					
060202FN	0.2	3.4	88.31	102										
060204FN	0.4	3.1		101.43	104									
060204EN	0.4	3.1							101.43	204				
060204EN	0.4	3.2						88.31	204					
060204FN	0.4	3.2	88.31	104										
060208EN	0.8	3.0						92.18	208					
09T302FN	0.2	4.4			98.61	162	98.61	162						
09T302EN	0.2	4.4							102.70	212				
09T302EN	0.2	4.5						91.53	212					
09T302FN	0.2	4.5	86.84	112										
09T304FN	0.4	4.2		102.70	114									
09T304EN	0.4	4.2							102.70	214				
09T304EN	0.4	4.3						91.53	214					
09T304FN	0.4	4.3	86.84	114										
09T308EN	0.8	4.1						99.19	218					
09T308FN	0.8	4.1	94.08	118										
120402FN	0.2	4.4					102.27	172						
120402EN	0.2	4.4							105.22	222				
120404EN	0.4	4.2							105.22	224				
120404FN	0.4	4.2		105.22	124		102.27	174						
120404EN	0.4	4.3						92.10	224					
120404FN	0.4	4.3	92.10	124										
120408EN	0.8	4.1						95.80	228					
120408FN	0.8	4.1	95.80	128										

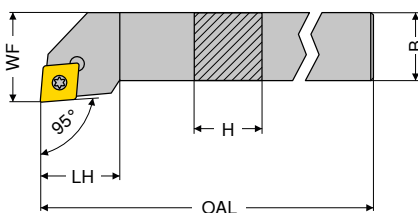
Steel						
Stainless steel						
Cast iron						
Non ferrous metals	•	•	•	•	•	•
Heat resistant alloys			○	○	○	○

CCGT

ISO	RE mm	LE mm	-A-CB3 CTDPU20		-A-CB1 CTDCD10		-A-CB2 CTDCD10		-A-Q-CB2 CTDCD10	
			Article no. 71 302 ...	£	Article no. 71 300 ...	£	Article no. 71 301 ...	£	Article no. 71 306 ...	£
060202FN	0.2	2.4			112.07	302				
060204EN	0.4	2.1							119.32	304
060204FN	0.4	2.2			112.07	304				
060204EN	0.4	2.2					112.07	304		
060204EN	0.4	3.2	70.28	204						
09T304EN	0.4	2.1							125.19	314
09T304FN	0.4	2.2			115.71	314				
09T304EN	0.4	2.2					115.71	314		
09T304EN	0.4	4.3	70.28	214						
09T308EN	0.8	4.1	76.77	218						
120404EN	0.4	2.1							122.96	324
120408EN	0.8	2.1					130.23	328		

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

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



Illustrations show right-hand versions

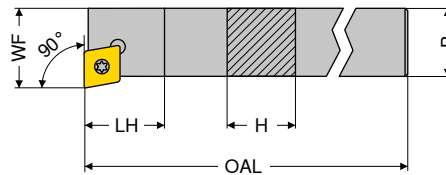


ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 653 ...	£	Article no. 70 652 ...	£
SCLC R/L 0808 D06	8	8	60	9	10	1,2	CC.. 0602	55.38	008	55.38	008
SCLC R/L 1010 E06	10	10	70	9	12	1,2	CC.. 0602	58.72	010	58.72	010
SCLC R/L 1212 F09	12	12	80	15	16	3,2	CC.. 09T3	58.72	012	58.72	012
SCLC R/L 1616 H09	16	16	100	17	20	3,2	CC.. 09T3	72.73	016	72.73	016
SCLC R/L 2020 K09	20	20	125	17	25	3,2	CC.. 09T3	77.31	020	77.31	020
SCLC R/L 1616 H12	16	16	100	20	20	5	CC.. 1204	72.73	116	72.73	116
SCLC R/L 2020 K12	20	20	125	20	25	5	CC.. 1204	77.31	120	77.31	120
SCLC R/L 2525 M12	25	25	150	20	32	5	CC.. 1204	79.97	125	79.97	125
SCLC R/L 3225 P12	32	25	170	20	32	5	CC.. 1204	83.13	132	83.13	132

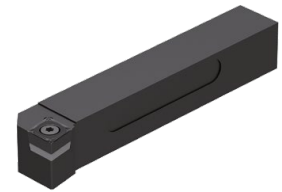
i Tool holders with HSK-T interface can be found in → **Chapter 16.**

Spare parts for Article no.	Y7		2A/28		2A		2A/28		2A/28	
	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
70 653 008 / 70 652 008	10.30	110			2.15	112				
70 653 010 / 70 652 010	10.30	110			2.15	112				
70 653 012 / 70 652 012	12.26	113			2.85	113				
70 653 016 / 70 652 016			7.53	398	2.85	113	8.79	165	4.22	171
70 653 020 / 70 652 020			7.53	398	2.85	113	8.79	165	4.22	171
70 653 116 / 70 652 116			7.53	398	2.34	114	11.25	166	4.22	170
70 653 120 / 70 652 120			7.53	398	2.34	114	11.25	166	4.22	170
70 653 125 / 70 652 125			7.53	398	2.34	114	11.25	166	4.22	170
70 653 132 / 70 652 132			7.53	398	2.34	114	11.25	166	4.22	170

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



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 761 ...	£	Article no. 70 760 ...	£
SCFC R/L 0808 D06	8	8	60	10	10	1,2	CC.. 0602	55.38	008	55.38	008
SCFC R/L 1010 E06	10	10	70	10	12	1,2	CC.. 0602	58.72	010	58.72	010
SCFC R/L 1212 F09	12	12	80	13	16	3,2	CC.. 09T3	58.72	012	58.72	012
SCFC R/L 1616 H09	16	16	100	13	20	3,2	CC.. 09T3	72.73	016	72.73	016
SCFC R/L 2020 K12	20	20	125	17	25	5	CC.. 1204	77.31	020	77.31	020

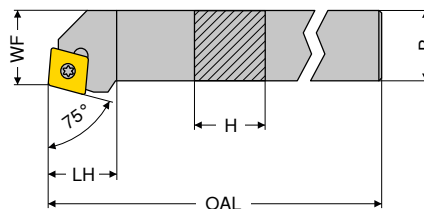
Spare parts

for Article no.

	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
70 761 008 / 70 760 008	110	10.30			112	2.15				
70 761 010 / 70 760 010	110	10.30			112	2.15				
70 761 012 / 70 760 012	113	12.26			113	2.85				
70 761 016 / 70 760 016			398	7.53	113	2.85	165	8.79	171	4.22
70 761 020 / 70 760 020			398	7.53	114	2.34	166	11.25	170	4.22

Y7	2A/28	2A	2A/28	2A/28
Key D	Combination Key	Clamping screw	Carbide type C	Threaded sleeve

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



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 649 ...	£	Article no. 70 648 ...	£
SCRC R 1010 E06	10	10	70	10	11	1,2	CC.. 0602			58.72	010
SCRC R/L 1212 F09	12	12	80	16	13	3,2	CC.. 09T3	58.72	012	58.72	012
SCRC R/L 1616 H09	16	16	100	17	17	3,2	CC.. 09T3	72.73	016	72.73	016
SCRC R/L 2020 K09	20	20	125	17	22	3,2	CC.. 09T3	77.31	020	77.31	020
SCRC R/L 2020 K12	20	20	125	20	22	5	CC.. 1204	77.31	120	77.31	120
SCRC R/L 2525 M12	25	25	150	20	27	5	CC.. 1204	79.97	125	79.97	125

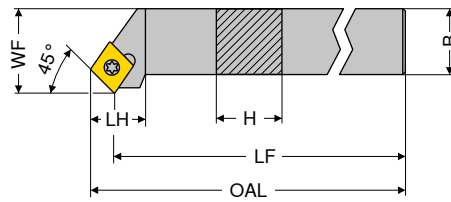
Spare parts

for Article no.

	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
70 648 010	110	10.30			112	2.15				
70 649 012 / 70 648 012	113	12.26			113	2.85				
70 649 016 / 70 648 016			398	7.53	113	2.85	165	8.79	171	4.22
70 649 020 / 70 648 020			398	7.53	113	2.85	165	8.79	171	4.22
70 649 120 / 70 648 120			398	7.53	114	2.34	166	11.25	170	4.22
70 649 125 / 70 648 125			398	7.53	114	2.34	166	11.25	170	4.22

Y7	2A/28	2A	2A/28	2A/28
Key D	Combination Key	Clamping screw	Carbide type C	Threaded sleeve

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



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LF mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 641 ...	£	Article no. 70 640 ...	£
SCSC R 1616 H12	16	16	109.1	100	20	20	5	CC.. 1204			72.73	016
SCSC R/L 2020 K12	20	20	134.1	125	20	25	5	CC.. 1204	77.31	020	77.31	020
SCSC R/L 2525 M12	25	25	159.1	150	20	32	5	CC.. 1204	79.97	025	79.97	025

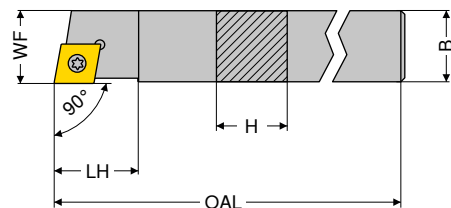
Spare parts

for Article no.	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
70 640 016	T15/SW	7.53 398	M4,5x12	2.34 114	11.25 166	M4,5	4.22 170	
70 641 020 / 70 640 020	T15/SW	7.53 398	M4,5x12	2.34 114	11.25 166	M4,5	4.22 170	
70 641 025 / 70 640 025	T15/SW	7.53 398	M4,5x12	2.34 114	11.25 166	M4,5	4.22 170	



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

▲ for sliding head lathes



Illustrations show right-hand versions



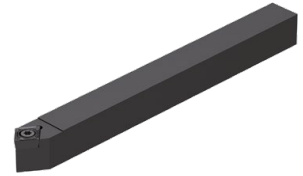
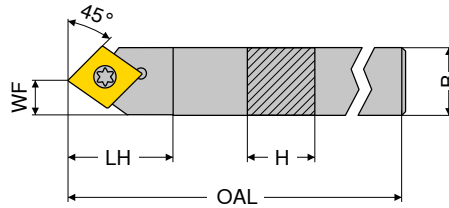
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 757 ...	£	Article no. 70 756 ...	£
SCAC R/L 0808 K06	8	8	125	9	8	1,2	CC.. 0602	58.72	108	58.72	108
SCAC R/L 0808 D06	8	8	60	9	8	1,2	CC.. 0602	55.38	008	55.38	008
SCAC R/L 1010 M06	10	10	150	9	10	1,2	CC.. 0602	58.72	110	58.72	110
SCAC R/L 1010 E06	10	10	70	9	10	1,2	CC.. 0602	58.72	010	58.72	010
SCAC R/L 1212 M09	12	12	150	13	12	3,2	CC.. 09T3	65.68	112	65.68	112
SCAC R/L 1212 F09	12	12	80	13	12	3,2	CC.. 09T3	58.72	012	58.72	012
SCAC R/L 1414 M09	14	14	150	13	14	3,2	CC.. 09T3	65.68	114	65.68	114
SCAC R/L 1616 H09	16	16	100	13	16	3,2	CC.. 09T3	72.73	116	72.73	116
SCAC R/L 2020 K12	20	20	125	17	20	5	CC.. 1204	77.31	120	77.31	120

Spare parts

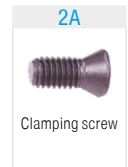
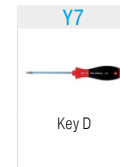
for Article no.	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
70 756 108 / 70 757 108	10.30	110			2.15	112				
70 756 008 / 70 757 008	10.30	110			2.15	112				
70 756 110 / 70 757 110	10.30	110			2.15	112				
70 756 010 / 70 757 010	10.30	110			2.15	112				
70 756 112 / 70 757 112	12.26	113			2.85	113				
70 756 012 / 70 757 012	12.26	113			2.85	113				
70 756 114 / 70 757 114	12.26	113			2.85	113				
70 756 116 / 70 757 116			7.53	398	2.85	113	8.79	165	4.22	171
70 756 120 / 70 757 120			7.53	398	2.34	114	11.25	166	4.22	170



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



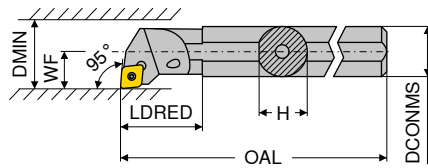
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Neutral 2A/24	
								Article no. 70 752 ...	£
SCDC L 0808 K06	8	8	125	13	4	1,2	CC.. 0602	58.72	008
SCDC L 1010 M06	10	10	150	13	5	1,2	CC.. 0602	58.72	010
SCDC L 1212 M09	12	12	150	18	6	3,2	CC.. 09T3	65.68	012
SCDC L 1414 M09	14	14	150	18	7	3,2	CC.. 09T3	65.68	014



Spare parts for Article no.	Article no. 80 950 ...		Article no. 70 950 ...	
	£		£	
70 752 008	10.30	110	2.15	112
70 752 010	10.30	110	2.15	112
70 752 012	12.26	113	2.85	113
70 752 014	12.26	113	2.85	113

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

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



Illustrations show right-hand versions

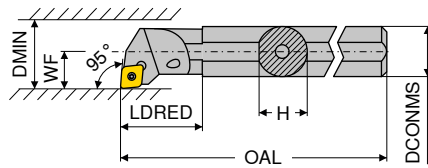
ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 717 ...	£	Article no. 70 716 ...	£
S08H SCLC R/L 06	8	7.2	100		5	11	1,2	CC.. 0602	87.79	008	87.79	008
A08F SCLC R/L 06	8	7.6	80	17	5	11	1,2	CC.. 0602	87.79	208	87.79	208
A10H SCLC R/L 06	10	9.5	100	19	7	13	1,2	CC.. 0602	87.79	210	87.79	210
S10K SCLC R/L 06	10	9.0	125		7	13	1,2	CC.. 0602	87.79	010	87.79	010
A12K SCLC R/L 06	12	11.5	125	22	9	16	1,2	CC.. 0602	87.79	212	87.79	212
S12Q SCLC R/L 06	12	11.0	180		9	16	1,2	CC.. 0602	87.79	012	87.79	012
A16M SCLC R/L 06	16	14.0	150	50	9	18	1,2	CC.. 0602	89.70	116	89.70	116
S16R SCLC R/L 09	16	14.5	200		11	20	3,2	CC.. 09T3	89.70	016	89.70	016
A16M SCLC R/L 09	16	15.0	150	29	11	20	3,2	CC.. 09T3	89.70	216	89.70	216
A20Q SCLC R/L 09	20	18.5	180	32	13	25	3,2	CC.. 09T3	111.82	220	111.82	220
S20S SCLC R/L 09	20	18.0	250		13	25	3,2	CC.. 09T3	111.82	020	111.82	020
S25T SCLC R/L 09	25	23.0	300		17	32	3,2	CC.. 09T3	128.55	025	128.55	025
A25R SCLC R/L 09	25	23.0	200	36	17	32	3,2	CC.. 09T3	128.55	225	128.55	225
A32S SCLC R/L 12	32	30.0	250	50	22	40	5	CC.. 1204	176.73	232	176.73	232
A40T SCLC R/L 12	40	38.0	300	60	27	50	5	CC.. 1204	212.18	240	212.18	240

i Tool holders with HSK-T or PSC interface can be found in → Chapter 16.

Spare parts	Y7		2A/28		2A/28		2A/28		2A/28	
	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£
for Article no.	80 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	
70 716 008 / 70 717 008	10.30	110			2.34	116				
70 716 208 / 70 717 208	10.30	110			2.34	116				
70 716 210 / 70 717 210	10.30	110			2.34	116				
70 716 010 / 70 717 010	10.30	110			2.34	116				
70 716 212 / 70 717 212	10.30	110			2.34	116				
70 716 012 / 70 717 012	10.30	110			2.34	116				
70 716 116 / 70 717 116	10.30	110			2.34	116				
70 716 016 / 70 717 016	12.26	113			2.85	110				
70 716 216 / 70 717 216	12.26	113			2.85	110				
70 716 220 / 70 717 220	12.26	113			2.85	304				
70 716 020 / 70 717 020	12.26	113			2.85	110				
70 716 025 / 70 717 025	12.26	113			2.85	113				
70 716 225 / 70 717 225	12.26	113			2.85	304				
70 716 232 / 70 717 232			7.53	398	2.34	114	11.25	166	4.22	170
70 716 240 / 70 717 240			7.53	398	2.34	114	11.25	166	4.22	170

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

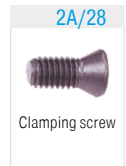
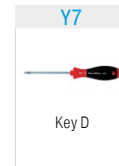
▲ with carbide core



Illustrations show right-hand versions



ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A		Right-hand 2A	
									Article no. 70 719 ...	£	Article no. 70 718 ...	£
E-A08F SCLC R/L 06	8	7.5	80	18	6	12	1,2	CC.. 0602	161.09	208	161.09	208
E-A10H SCLC R/L 06	10	9.0	100	20	7	14	1,2	CC.. 0602	161.09	210	161.09	210
E-A12K SCLC R/L 06	12	11.0	125	20	9	18	1,2	CC.. 0602	173.55	212	173.55	212
E-A16M SCLC R/L 09	16	15.0	150	28	11	22	3,2	CC.. 09T3	294.55	216	294.55	216
E-A20Q SCLC R/L 09	20	18.0	180	38	13	26	3,2	CC.. 09T3	364.18	220	364.18	220
E-A25R SCLC R/L 09	25	23.0	200	38	17	34	3,2	CC.. 09T3	462.27	225	462.27	225
E-A32S SCLC R/L 12	32	30.0	250	43	22	39	5	CC.. 1204	727.36	232	727.36	232



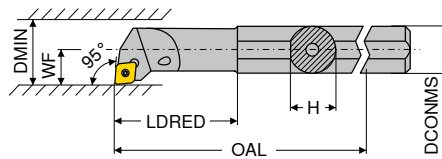
Spare parts

for Article no.

		Article no. 80 950 ...		Article no. 70 950 ...	
		£		£	
70 718 208 / 70 719 208	T08	10.30	110	M2,5x5	2.34 116
70 718 210 / 70 719 210	T08	10.30	110	M2,5x5	2.34 116
70 718 212 / 70 719 212	T08	10.30	110	M2,5x5	2.34 116
70 718 216 / 70 719 216	T15	12.26	113	M4x9,5	2.85 449
70 718 220 / 70 719 220	T15	12.26	113	M4x9,5	2.85 449
70 718 225 / 70 719 225	T15	12.26	113	M4x9,5	2.85 449
70 718 232 / 70 719 232	T15	12.26	113	M4x11	3.09 174

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

▲ with carbide core



Illustrations show right-hand versions



ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A		Right-hand 2A	
									Article no. 70 719 ...	£	Article no. 70 718 ...	£
E-A0608F SCLC R/L 06	8	7.5	100	25	4	8	1,2	CC.. 0602	173.55	308	173.55	308
E-A0810H SCLC R/L 06	10	9.0	110	32	6	12	1,2	CC.. 0602	173.55	310	173.55	310
E-A1012K SCLC R/L 06	12	11.0	125	38	7	14	1,2	CC.. 0602	173.55	312	173.55	312
E-A1216M SCLC R/L 06	16	15.0	150	50	9	18	1,2	CC.. 0602	173.55	316	173.55	316

Y7		2A/28	
	Key D		Clamping screw
Article no. 80 950 ...	£	Article no. 70 950 ...	£
10.30	110	2.34	116
10.30	110	2.34	116
10.30	110	2.34	116
10.30	110	2.34	116

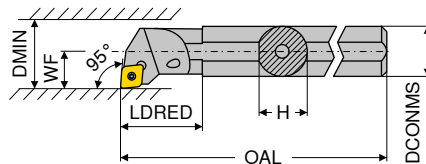
Spare parts

for Article no.

70 718 308 / 70 719 308	10.30	110
70 718 310 / 70 719 310	10.30	110
70 718 312 / 70 719 312	10.30	110
70 718 316 / 70 719 316	10.30	110

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

▲ Type: Solid carbide



Illustrations show right-hand versions



ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 719 ...	£	Article no. 70 718 ...	£
E08H SCLC R/L 06	8	7.6	100	mm	5	11	1,2	CC.. 0602	199.64	008	199.64	008
E10K SCLC R/L 06	10	9.0	125	22	7	13	1,2	CC.. 0602	230.64	010	230.64	010
E12Q SCLC R/L 06	12	11.5	180	26	9	16	1,2	CC.. 0602	302.91	012	302.91	012
E16R SCLC R/L 09	16	15.0	200	34	11	20	3,2	CC.. 09T3	395.82	016	395.82	016
E20S SCLC R/L 09	20	18.5	250	38	13	25	3,2	CC.. 09T3	494.45	020	494.45	020
E25T SCLC R/L 09	25	23.0	300	43	17	32	3,2	CC.. 09T3	871.91	025	871.91	025

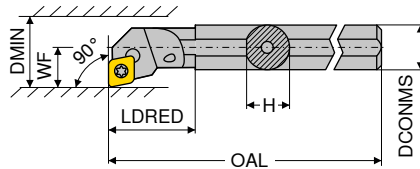
Y7		2A/28	
	Key D		Clamping screw
Article no. 80 950 ...	£	Article no. 70 950 ...	£

Spare parts

for Article no.

70 719 008 / 70 718 008	T08	10.30	110	M2,5x5	2.34	116
70 719 010 / 70 718 010	T08	10.30	110	M2,5x5	2.34	116
70 719 012 / 70 718 012	T08	10.30	110	M2,5x5	2.34	116
70 719 016 / 70 718 016	T15	12.26	113	M3,5x7,2	2.85	110
70 719 020 / 70 718 020	T15	12.26	113	M3,5x8,6	2.85	304
70 719 025 / 70 718 025	T15	12.26	113	M3,5x11	2.85	113

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



Illustrations show right-hand versions

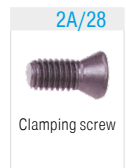
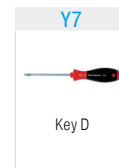


ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 793 ...	£	Article no. 70 792 ...	£
A08F SCFC R/L 06	8	7.6	80	17	5	11	1,2	CC.. 0602	87.79	208	87.79	208
A10H SCFC R/L 06	10	9.5	100	19	7	13	1,2	CC.. 0602	87.79	210	87.79	210
A12K SCFC R/L 06	12	11.5	125	22	9	16	1,2	CC.. 0602	87.79	212	87.79	212

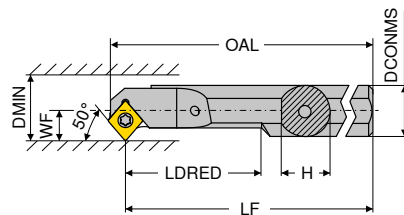
Spare parts

for Article no.

		Article no. 80 950 ...	£		Article no. 70 950 ...	£
70 792 208 / 70 793 208	T08	10.30	110	M2,5x5	2.34	116
70 792 210 / 70 793 210	T08	10.30	110	M2,5x5	2.34	116
70 792 212 / 70 793 212	T08	10.30	110	M2,5x5	2.34	116



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



Illustrations show right-hand versions

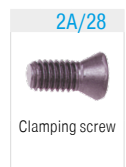
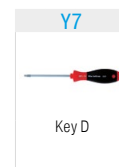


ISO designation	DCONMS	H	OAL	LF	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A		Right-hand 2A	
										Article no. 70 723 ...	£	Article no. 70 722 ...	£
A08H SMC R/L 06	8	7	104.15	100	20	5.5	10.5	1,2	CC.. 0602	87.79	208	87.79	208
A10H SMC R/L 06	10	9	114.15	110	26	6.0	11.0	1,2	CC.. 0602	87.79	210	87.79	210
A12K SMC R/L 06	12	11	129.15	125	32	7.0	13.0	1,2	CC.. 0602	87.79	212	87.79	212
A16M SMC R/L 06	16	14	154.15	150	40	9.0	16.0	1,2	CC.. 0602	89.70	216	89.70	216

Spare parts

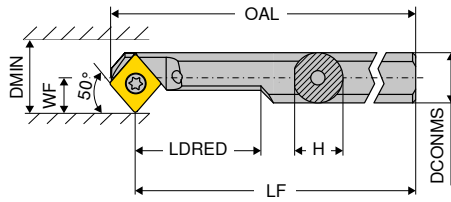
for Article no.

		Article no. 80 950 ...	£		Article no. 70 950 ...	£
70 723 208 / 70 722 208	T08	10.30	110	M2,5x5	2.34	116
70 723 210 / 70 722 210	T08	10.30	110	M2,5x5	2.34	116
70 723 212 / 70 722 212	T08	10.30	110	M2,5x5	2.34	116
70 723 216 / 70 722 216	T08	10.30	110	M2,5x5	2.34	116



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

▲ with carbide core



Illustrations show right-hand versions



ISO designation	DCONMS	H	OAL	LF	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand	Right-hand		
										2A	2A		
										Article no. 70 707 ...	Article no. 70 706 ...		
										£	£		
E-A0608H SMC R/L 06	8	7.5	104.15	100	20	5.5	10.5	1,2	CC.. 0602	173.55	008	173.55	008
E-A0810H SMC R/L 06	10	9.0	114.15	110	26	6.0	11.0	1,2	CC.. 0602	173.55	010	173.55	010
E-A1012K SMC R/L 06	12	11.0	129.15	125	32	7.0	13.0	1,2	CC.. 0602	173.55	012	173.55	012
E-A1216M SMC R/L 06	16	15.0	154.15	150	40	9.0	16.0	1,2	CC.. 0602	173.55	016	173.55	016

Y7		2A/28	
Key D		Clamping screw	
Article no. 80 950 ...		Article no. 70 950 ...	
£		£	
10.30	110	2.34	116
10.30	110	2.34	116
10.30	110	2.34	116
10.30	110	2.34	116

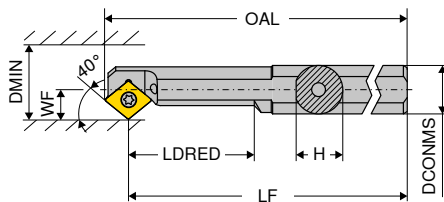
Spare parts

for Article no.

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

MaxiLock-S – SCXC 40° – Boring bar with screw clamping

▲ with carbide core



Illustrations show right-hand versions



ISO designation	DCONMS	H	OAL	LF	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand	Right-hand		
										2A	2A		
										Article no. 70 715 ...	Article no. 70 714 ...		
										£	£		
E-A0608H SCXC R/L 06	8	7.5	105	100	20	5	9.5	1,2	CC.. 0602	173.55	008	173.55	008
E-A0810H SCXC R/L 06	10	9.0	115	110	26	6	11.0	1,2	CC.. 0602	173.55	010	173.55	010
E-A1012K SCXC R/L 06	12	11.0	130	125	32	7	13.0	1,2	CC.. 0602	173.55	012	173.55	012
E-A1216M SCXC R/L 06	16	15.0	155	150	40	9	16.0	1,2	CC.. 0602	173.55	016	173.55	016

Y7		2A/28	
Key D		Clamping screw	
Article no. 80 950 ...		Article no. 70 950 ...	
£		£	
10.30	110	2.34	116
10.30	110	2.34	116
10.30	110	2.34	116
10.30	110	2.34	116

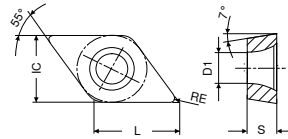
Spare parts

for Article no.

70 714 008 / 70 715 008
70 714 010 / 70 715 010
70 714 012 / 70 715 012
70 714 016 / 70 715 016

DCGT / DCMT / DCXT / DCET

Designation	L	S	D1	IC
	mm	mm	mm	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	-SF TCM10	-SF TCM407	-SF CTCP125	-SF CTCP115	-SF CTCP125	-SF CTCP135
		-PF14 DCC1110	-ZF CWC10	-ZF CWC407	-ZF HCX1125	-ZF HCX1115	-ZF HCX1125	-ZF HCR1135
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F	F	F	F	F	F	F
		CERMET DCGT	CERMET DCGT	CERMET DCGT	DCGT	DCMT	DCMT	DCMT
		1A/78	1A/78	1A/78	1A/08	1A/08	1A/08	1A/08
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	76 245 ...	70 257 ...	70 257 ...	76 257 ...	76 259 ...	76 259 ...	76 259 ...
		£	£	£	£	£	£	£
070201EN	0.1		12.21 898					
070202EN	0.2	12.60 002	12.21 900		12.60 502			
070204EN	0.4	12.60 004	12.21 902	12.21 852		7.07 304	7.07 504	7.07 704
11T302EN	0.2	16.68 014	15.56 904	15.56 854				
11T304EN	0.4	16.68 016	15.56 906	15.56 856		9.94 316	9.94 516	9.94 716
11T308EN	0.8	16.68 018	15.56 908	15.56 858		9.94 318	9.94 518	9.94 718
Steel		●	●	●	●	●	●	●
Stainless steel		○			○	○	○	○
Cast iron		○	○	○	○	○	○	
Non ferrous metals								
Heat resistant alloys								○

DCMT / DCGT

		-CF55 CTEP110	-SMF TCM10	-SMF CTCP115	-SMF CTCP125	-SMF CTCP135	-SM CTCP125	-SM CTCP135
		-PF15 DCC1110	-SMF CWC10	-SMF HCX1115	-SMF HCX1125	-SMF HCR1135	-ZM HCX1125	-ZM HCR1135
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F	F	F	F	F	M	M
		CERMET DCMT	CERMET DCMT	DCMT	DCMT	DCMT	DCGT	DCGT
		1A/78	1A/78	1A/08	1A/08	1A/08	1A/08	1A/08
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	76 246 ...	70 265 ...	76 265 ...	76 265 ...	76 265 ...	76 256 ...	76 256 ...
		£	£	£	£	£	£	£
070202EN	0.2	7.15 002	6.62 898					
070204EN	0.4	7.15 004	6.62 900		7.07 504	7.07 704	12.60 502	12.60 702
070208EN	0.8					7.07 706		
11T304EN	0.4	9.92 016	9.29 904	9.94 316	9.94 516	9.94 716		
11T308EN	0.8	9.92 018	9.29 906	9.94 318	9.94 518	9.94 718		
Steel		●	●	●	●	●	●	●
Stainless steel		○			○	○	○	○
Cast iron		○	○	○	○		○	
Non ferrous metals								
Heat resistant alloys						○		○

DCMT

		-SM CTCK110	-SM CTCK120	-SM CTCP115	-SM CTCP125	-SM CTCP135	-SMQ CTCP115	-SMQ CTCP125
		-ZM DCX3110	-ZM HCF3120	-ZM HCX1115	-ZM HCX1125	-ZM HCR1135	-SMQ HCX1115	-SMQ HCX1125
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M	M	M	M	M	M	M
		DCMT	DCMT	DCMT	DCMT	DCMT	DCMT	DCMT
		1A/08	1A/08	1A/08	1A/08	1A/08	1A/08	1A/08
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	70 258 ...	70 258 ...	76 258 ...	76 258 ...	76 258 ...	76 195 ...	76 195 ...
		£	£	£	£	£	£	£
070204EN	0.4	7.07 004	7.07 554	7.07 304	7.07 504	7.07 704	8.06 304	8.06 504
070208EN	0.8	7.07 006	7.07 506	7.07 306	7.07 506	7.07 706		
11T304EL	0.4							11.08 516
11T304EN	0.4	9.94 016	9.94 516	9.94 316	9.94 516	9.94 716		11.08 515
11T304ER	0.4							11.08 517
11T308EN	0.8	9.94 018	9.94 518	9.94 318	9.94 518	9.94 718		11.08 518
11T312EN	1.2				9.94 520			
Steel		●	●	●	●	●	●	●
Stainless steel		○		○	○	○	○	○
Cast iron		●	●	○	○	○	○	○
Non ferrous metals								
Heat resistant alloys						○		

9

DCGT / DCMT / DCXT

		-SF CTC2135	-SF CTC2135	-F43 CTC2135	-M81 CWN2120	-M25 CTPM125	-SM CTC2135	-M55 CTPM125
		-ZF CWN2135	-ZF CWN2135	-F43 CWN2135		-PF23 HCN2125	-ZM CWN2135	-PF26 HCN2125
						DRAGONSKIN		DRAGONSKIN
		F	F	F	M	F	M	F
		DCGT	DCMT	DCMT	DCXT	DCMT	DCMT	DCMT
		1A/08	1A/08	1A/08	1A	1A/08	1A/08	1A/08
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	70 257 ...	70 259 ...	70 186 ...	70 260 ...	75 213 ...	70 258 ...	75 214 ...
		£	£	£	£	£	£	£
070202EN	0.2	12.60 440		6.85 400		7.07 202		
070202FN	0.2				8.95 100			
070204EN	0.4		6.85 440	6.85 402		7.07 204	6.85 440	7.07 204
070204FN	0.4				8.95 102			
070208EN	0.8						6.85 442	7.07 206
11T302EN	0.2			9.92 404		9.92 214		
11T302FN	0.2				9.30 104			
11T304EN	0.4		9.92 444	9.92 406		9.94 216	9.92 444	9.94 216
11T304FN	0.4				9.30 106			
11T308EN	0.8		9.92 446	9.92 408		9.94 218	9.92 448	9.94 218
11T308FN	0.8				9.30 108			
Steel		○	○	○		○	○	○
Stainless steel		●	●	●	●	●	●	●
Cast iron								
Non ferrous metals					○			
Heat resistant alloys		●	●	●			●	

DCGT

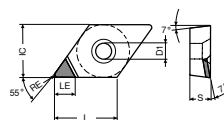
		-23P H216T	-25P H210T	-25P AMZ	-25Q H210T	-25Q AMZ	-27 H10T	-27 CWN15
		-23P CWK26	-25P CWK20	-25P AMZ	-25Q CWK20	-25Q AMZ	-AL CWK15	-AL CWN15
		F	F	F	M	M	M	M
		DCGT	DCGT	DCGT	DCGT	DCGT	DCGT	DCGT
		1A/90	1A/90	1A/90	1A/90	1A	1A/90	1A
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	70 261 ...	70 263 ...	70 263 ...	70 263 ...	70 263 ...	70 260 ...	70 260 ...
		£	£	£	£	£	£	£
070202FN	0.2		8.94 632	10.68 552			8.45 600	10.81 300
070204FN	0.4	8.94 654	8.94 634	10.68 554			8.45 602	10.81 302
11T302FN	0.2		11.08 635	12.92 535			10.57 604	12.78 304
11T304FL	0.4				12.10 670	15.43 620		
11T304FN	0.4				12.10 660	15.43 610	10.57 606	12.78 306
11T304FR	0.4	11.08 664	11.08 636	12.92 556	12.10 680	15.43 630		
11T308FL	0.8				12.10 672	15.43 622		
11T308FN	0.8				12.10 662	15.43 612	10.57 608	12.78 308
11T308FR	0.8	11.08 666	11.08 638	12.92 558	12.10 682	15.43 642		
Steel								
Stainless steel								
Cast iron								
Non ferrous metals								
Heat resistant alloys								

DCGT / DCMT / DCET

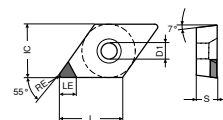
		-27 AMZ	-29 H216T	-29 AMZ	-F05 CTPX710	-F23 CTP2120
		-AL AMZ				-F23 CCN2120
		M	M	M	F	F
		DCGT	DCMT	DCMT	DCET	DCGT
		1A/90	NEW 1A/90	NEW 1A/90	NEW 1H/17	1A/08
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	70 260 ...	70 246 ...	70 246 ...	76 254 ...	70 192 ...
		£	£	£	£	£
0702005FN	0.05				15.24 10200	
070200FN	0.00					12.60 600
0702015FN	0.15				15.24 10600	
070201FN	0.10				15.24 10400	12.60 602
070202FN	0.20	10.26 450			15.24 10800	
070204EN	0.40		6.47 60400	7.96 40400		
070204FN	0.40	10.26 452				
11T3005FN	0.05				20.20 11400	
11T300FN	0.00					16.98 604
11T3015FN	0.15				20.20 11800	
11T301FN	0.10				20.20 11600	16.98 606
11T302FN	0.20	12.42 454			20.20 12000	
11T304EN	0.40		8.73 61600	9.95 41600		
11T304FN	0.40	12.42 456				
11T304N	0.40				20.20 12200	
11T308EN	0.80		8.73 61800	9.95 41800		
11T308FN	0.80	12.42 458				
Steel						
Stainless steel						
Cast iron						
Non ferrous metals						
Heat resistant alloys						

DCGW / DCGT

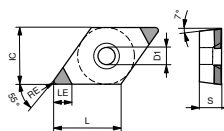
Designation	L	S	D1	IC
	mm	mm	mm	mm
DCG. 0702..	7.75	2.38	2.8	6.35
DCG. 11T3..	11.60	3.97	4.4	9.52



DCGT -A

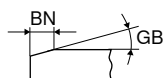


DCGW -A



DCGW-B

DCGW / DCGT

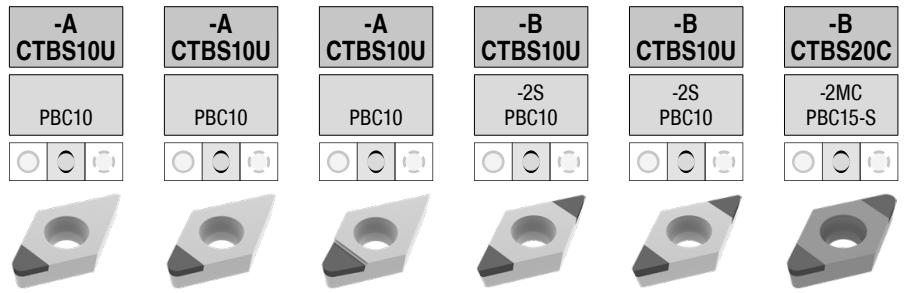
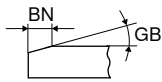


-A CTBS10U	-A CTBS10U	-A CTBS10U	-B CTBS10U	-B CTBS10U	-B CTBS20C
PBC10	PBC10	PBC10	-2S PBC10	-2S PBC10	-2MC PBC15-S
F CBN DCGW	F CBN DCGW	F CBN DCGT	F CBN DCGW	F CBN DCGW	F CBN DCGW
Y0	Y0	Y0	Y0	Y0	Y0

ISO	RE mm	GB °	BN mm	LE mm	-A CTBS10U PBC10		-A CTBS10U PBC10		-A CTBS10U PBC10		-B CTBS10U -2S PBC10		-B CTBS10U -2S PBC10		-B CTBS20C -2MC PBC15-S	
					Article no. 71 130 ...	£	Article no. 71 130 ...	£	Article no. 71 134 ...	£	Article no. 71 131 ...	£	Article no. 71 131 ...	£	Article no. 71 163 ...	£
070202SN	0.2	10	0.09	3.9											73.32	120
070202SN	0.2	15	0.11	3.9											73.32	130
070202TN	0.2	20	0.14	3.9			52.75	300							73.32	140
070202TN	0.2	20	0.15	3.9											73.32	150
070202SN	0.2	20	0.16	3.9											73.32	160
070202TN	0.2	25	0.17	3.9											73.32	
070202FN	0.2			3.9	52.75	200			63.92	200						
070204SN	0.4	10	0.09	3.5											73.32	121
070204SN	0.4	15	0.11	3.5											73.32	131
070204TN	0.4	20	0.14	3.5			52.75	302							73.32	141
070204TN	0.4	20	0.15	3.5											73.32	151
070204SN	0.4	20	0.16	3.5											73.32	161
070204TN	0.4	25	0.17	3.5											73.32	181
070204SN	0.4	30	0.18	3.5											73.32	
070204FN	0.4			3.5	52.75	202			63.92	202						
070208SN	0.8	15	0.11	3.0											73.32	132
070208TN	0.8	20	0.14	3.0			52.75	304							73.32	142
070208TN	0.8	20	0.15	3.0											73.32	152
070208SN	0.8	20	0.16	3.0											73.32	162
070208TN	0.8	25	0.17	3.0											73.32	172
070208SN	0.8	25	0.18	3.0											73.32	112
070208EN	0.8			3.0												
070208FN	0.8			3.0	52.75	204			63.92	204						
11T302SN	0.2	15	0.11	3.9											73.32	133
11T302TN	0.2	20	0.14	3.9			52.75	306			81.11	300			73.32	143
11T302TN	0.2	20	0.15	3.9											73.32	153
11T302SN	0.2	20	0.16	3.9											73.32	

Cast iron	•	•	•	•	•	•
Sintered steels	•	•	•	•	•	•
Heat resistant alloys	•	•	•	•	•	•
hardened < 45 HRC						
hardened 46-55 HRC						
hardened 56-60 HRC						
hardened 61-65 HRC						

DCGW / DCGT



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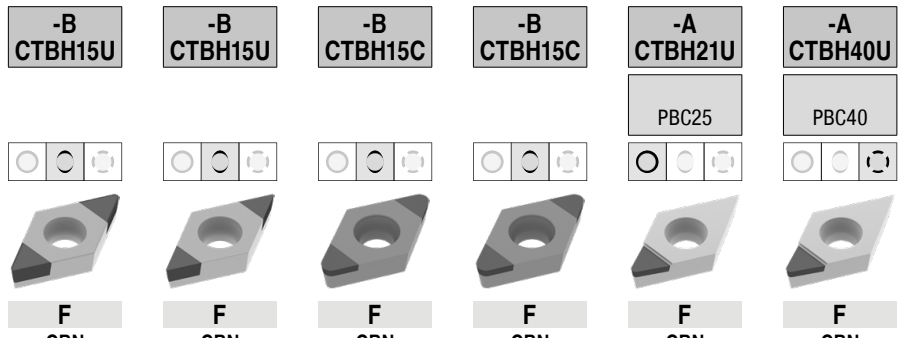
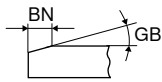
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DCGW

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DCGW

ISO	RE mm	GB °	BN mm	LE mm	-A CTBS10U		-A CTBS10U		-A CTBS10U		-B CTBS10U		-B CTBS10U		-B CTBS20C		
					Article no. 71 130 ...	£	Article no. 71 130 ...	£	Article no. 71 134 ...	£	Article no. 71 131 ...	£	Article no. 71 131 ...	£	Article no. 71 163 ...	£	
11T302TN	0.2	25	0.17	3.9													163
11T302FN	0.2			3.9	52.75	206			65.82	206	81.11	200					73.32
11T302EN	0.2			3.9													113
11T304SN	0.4	10	0.09	3.5													124
11T304TN	0.4	20	0.14	3.5			52.75	308					81.11	302			144
11T304TN	0.4	20	0.15	3.5													154
11T304SN	0.4	20	0.16	3.5													164
11T304TN	0.4	25	0.17	3.5													174
11T304SN	0.4	25	0.18	3.5													184
11T304SN	0.4	30	0.18	3.5													135
11T304FN	0.4			3.5	52.75	208			65.82	208	81.11	202					145
11T308SN	0.8	15	0.11	3.0													155
11T308TN	0.8	20	0.14	3.0			52.75	310					81.11	304			165
11T308TN	0.8	20	0.15	3.0													185
11T308SN	0.8	20	0.16	3.0													115
11T308TN	0.8	25	0.17	3.0													
11T308SN	0.8	30	0.18	3.0													
11T308FN	0.8			3.0	52.75	210			65.82	210	81.11	204					
11T308EN	0.8			3.0													

Cast iron	•	•	•	•	•	•
Sintered steels	•	•	•	•	•	•
Heat resistant alloys	•	•	•	•	•	•
hardened < 45 HRC						
hardened 46–55 HRC						
hardened 56–60 HRC						
hardened 61–65 HRC						

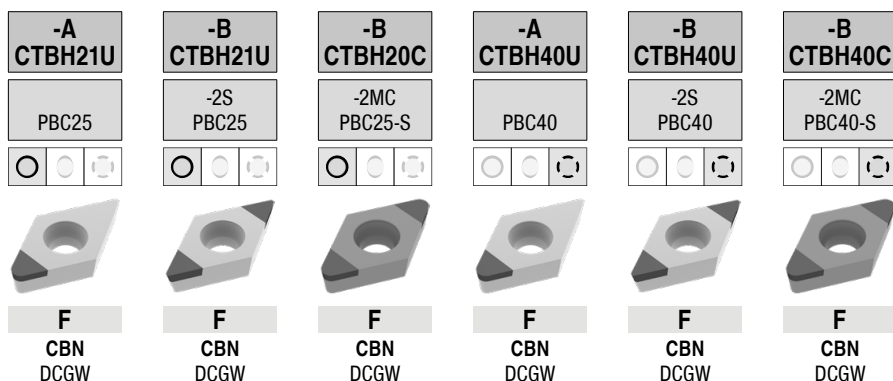
DCGW / DCGT



ISO	RE mm	GB °	BN mm	LE mm	-B CTBH15U		-B CTBH15C		-A CTBH21U		-A CTBH40U	
					NEW	YO	NEW	YO	NEW	YO	NEW	YO
					Article no. 71 008 ...	Article no. 71 012 ...	Article no. 71 007 ...	Article no. 71 009 ...	Article no. 71 134 ...	Article no. 71 134 ...		
					£	£	£	£	£	£		
070202EN	0.2			3.9	87.68 00200		79.70 00200					
070202SN	0.2	15	0.11	3.9	82.40 30214		79.70 30214					
070202FN	0.2			3.9					63.92 400		63.92 800	
070204EN	0.4			3.5	82.40 00400		79.70 00400					
070204SN	0.4	15	0.11	3.5	82.40 30414		79.70 30414					
070204SN	0.4	25	0.13	3.5	82.40 30429		79.70 30429					
070204FN	0.4			3.5					63.92 402		63.92 802	
070208SN	0.8	15	0.11	3.0		82.40 30614		79.70 30614				
070208SN	0.8	25	0.13	3.0		82.40 30629		79.70 30629				
070208EN	0.8			3.0		82.40 00600		79.70 00600				
11T302SN	0.2	15	0.11	3.9			79.70 31414					
11T302RN	0.2			3.9			79.70 21400					
11T302SN	0.2	25	0.13	3.9			79.70 31429					
11T302FN	0.2			3.9					65.82 406		65.82 806	
11T304SN	0.4	15	0.11	3.5			79.70 31614					
11T304SN	0.4	25	0.13	3.5			79.70 31629					
11T304RN	0.4			3.5			79.70 21600					
11T304FN	0.4			3.5					65.82 408		65.82 808	
11T308RN	0.8			3.0			79.70 21800					
11T308SN	0.8	15	0.11	3.0			79.70 31814					
11T308SN	0.8	25	0.13	3.0			79.70 31829					
11T308FN	0.8			3.0					65.82 410		65.82 810	

Cast iron												
Sintered steels												
Heat resistant alloys												
hardened < 45 HRC					•	•	•	•				
hardened 46–55 HRC					•	•	•	•	•			•
hardened 56–60 HRC					•	•	•	•	•			•
hardened 61–65 HRC												•

DCGW

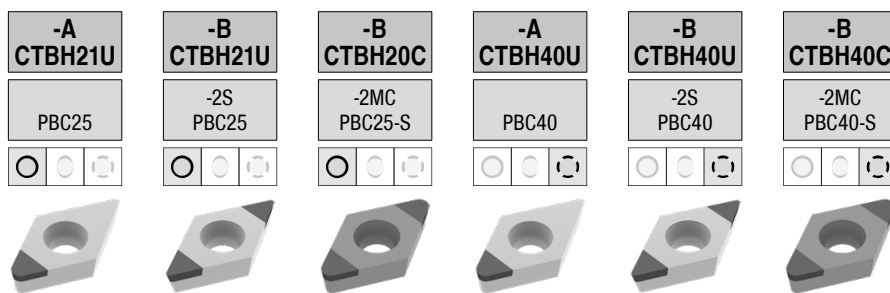


ISO	RE mm	GB °	BN mm	LE mm	-A CTBH21U		-B CTBH21U		-B CTBH20C		-A CTBH40U		-B CTBH40U		-B CTBH40C	
					Article no. 71 130 ...	£	Article no. 71 131 ...	£	Article no. 71 163 ...	£	Article no. 71 130 ...	£	Article no. 71 131 ...	£	Article no. 71 163 ...	£
070202FN	0.2			3.9	52.75	400 ¹⁾					52.75	800				
070202SN	0.2	10	0.09	3.9					73.32	230						
070202SN	0.2	15	0.11	3.9					73.32	240						
070202SN	0.2	20	0.09	3.9					73.32	250						
070202TN	0.2	20	0.09	3.9											73.32	320
070202TN	0.2	20	0.14	3.9	52.75	500										
070202SN	0.2	25	0.09	3.9											73.32	350
070202TN	0.2	25	0.11	3.9											73.32	340
070202TN	0.2	25	0.12	3.9							52.75	900				
070202TN	0.2	25	0.14	3.9					73.32	260						
070202TN	0.2	30	0.14	3.9											73.32	360
070202SN	0.2	30	0.16	3.9											73.32	370
070202SN	0.2	35	0.17	3.9											73.32	380
070202EN	0.2			3.9											73.32	310
070204SN	0.4	10	0.09	3.5					73.32	231						
070204SN	0.4	15	0.11	3.5					73.32	241						
070204SN	0.4	20	0.09	3.5					73.32	251					73.32	331
070204TN	0.4	20	0.14	3.5	52.75	502										
070204SN	0.4	25	0.09	3.5											73.32	351
070204TN	0.4	25	0.11	3.5											73.32	341
070204TN	0.4	25	0.12	3.5							52.75	902				
070204TN	0.4	25	0.14	3.5					73.32	261						
070204SN	0.4	25	0.15	3.5					73.32	271						
070204TN	0.4	30	0.14	3.5											73.32	361
070204SN	0.4	30	0.16	3.5											73.32	371
070204SN	0.4	35	0.17	3.5											73.32	381
070204FN	0.4			3.5	52.75	402 ¹⁾			73.32	211	52.75	802				
070208SN	0.8	10	0.09	3.0					73.32	232						
070208SN	0.8	20	0.09	3.0					73.32	252					73.32	332
070208TN	0.8	20	0.14	3.0	52.75	504										
070208SN	0.8	25	0.09	3.0											73.32	352
070208TN	0.8	25	0.11	3.0											73.32	342
070208TN	0.8	25	0.12	3.0							52.75	904				
070208TN	0.8	25	0.14	3.0					73.32	262						
070208TN	0.8	30	0.14	3.0											73.32	362
070208SN	0.8	30	0.16	3.0											73.32	372
070208SN	0.8	35	0.17	3.0											73.32	382
070208FN	0.8			3.0	52.75	404 ¹⁾			73.32	212	52.75	804				
070208EN	0.8			3.0					73.32	222					73.32	312
11T302FN	0.2			3.9	52.75	406 ¹⁾	81.11	400 ¹⁾			52.75	806	81.11	800 ¹⁾		
11T302SN	0.2	15	0.09	3.9					73.32	233						
11T302SN	0.2	15	0.11	3.9					73.32	243						
11T302SN	0.2	20	0.09	3.9					73.32	253						
11T302TN	0.2	20	0.09	3.9											73.32	323

Cast iron																
Sintered steels																
Heat resistant alloys																
hardened < 45 HRC																
hardened 46-55 HRC									•							•
hardened 56-60 HRC									•							•
hardened 61-65 HRC																•

1) Machining to 60 HRC

DCGW



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CBN
DCGW

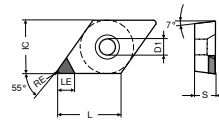
ISO	RE mm	GB °	BN mm	LE mm	-A CTBH21U		-B CTBH21U		-B CTBH20C		-A CTBH40U		-B CTBH40U		-B CTBH40C	
					Article no. 71 130 ...	Article no. 71 131 ...	Article no. 71 163 ...	Article no. 71 130 ...	Article no. 71 131 ...	Article no. 71 163 ...	Article no. 71 130 ...	Article no. 71 131 ...	Article no. 71 163 ...			
					£	£	£	£	£	£	£	£	£	£	£	£
11T302TN	0.2	20	0.14	3.9	52.75	506	81.11	500								
11T302SN	0.2	25	0.09	3.9											73.32	353
11T302TN	0.2	25	0.11	3.9											73.32	343
11T302TN	0.2	25	0.12	3.9							52.75	906	81.11	900		
11T302TN	0.2	25	0.14	3.9						73.32	263					
11T302SN	0.2	25	0.15	3.9						73.32	273					
11T302TN	0.2	30	0.14	3.9											73.32	363
11T302SN	0.2	35	0.17	3.9											73.32	383
11T302EN	0.2			3.9											73.32	313
11T304FN	0.4			3.5	52.75	408 ¹⁾	81.11	402 ¹⁾	73.32	214	52.75	808	81.11	802 ¹⁾		
11T304SN	0.4	10	0.09	3.5					73.32	234						
11T304SN	0.4	15	0.11	3.5					73.32	244						
11T304SN	0.4	20	0.09	3.5					73.32	254					73.32	334
11T304TN	0.4	20	0.09	3.5											73.32	324
11T304TN	0.4	20	0.14	3.5	52.75	508	81.11	502								
11T304SN	0.4	25	0.09	3.5											73.32	354
11T304TN	0.4	25	0.11	3.5											73.32	344
11T304TN	0.4	25	0.12	3.5							52.75	908	81.11	902		
11T304TN	0.4	25	0.14	3.5					73.32	264						
11T304SN	0.4	25	0.15	3.5					73.32	274						
11T304TN	0.4	30	0.14	3.5											73.32	364
11T304SN	0.4	30	0.16	3.5											73.32	374
11T304SN	0.4	30	0.18	3.5					73.32	284						
11T304SN	0.4	35	0.17	3.5											73.32	384
11T304EN	0.4			3.5					73.32	224					73.32	314
11T308SN	0.8	15	0.11	3.0					73.32	245						
11T308SN	0.8	20	0.09	3.0					73.32	255					73.32	335
11T308TN	0.8	20	0.09	3.0											73.32	325
11T308TN	0.8	20	0.14	3.0	52.75	510	81.11	504								
11T308SN	0.8	25	0.09	3.0											73.32	355
11T308TN	0.8	25	0.11	3.0											73.32	345
11T308TN	0.8	25	0.12	3.0							52.75	910	81.11	904		
11T308TN	0.8	25	0.14	3.0					73.32	265						
11T308TN	0.8	30	0.14	3.0											73.32	365
11T308SN	0.8	30	0.16	3.0											73.32	375
11T308SN	0.8	30	0.18	3.0					73.32	285						
11T308SN	0.8	35	0.17	3.0											73.32	385
11T308EN	0.8			3.0					73.32	225						
11T308FN	0.8			3.0	52.75	410 ¹⁾	81.11	404 ¹⁾	73.32	215			81.11	804 ¹⁾		

Cast iron																
Sintered steels																
Heat resistant alloys																
hardened < 45 HRC																
hardened 46-55 HRC						•		•		•		•		•		•
hardened 56-60 HRC						•		•		•		•		•		•
hardened 61-65 HRC												•		•		•

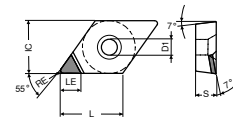
1) Machining to 60 HRC

DCGW / DCGT

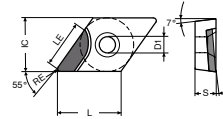
Designation	L	S	D1	IC
	mm	mm	mm	mm
DCG. 0702..	7.75	2.38	2.8	6.35
DCG. 11T3..	11.60	3.97	4.4	9.52



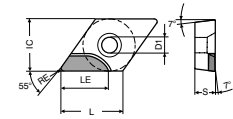
DCGW -A



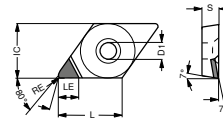
DCGT -A



DCGT-L



DCGT-R



DCGT -Q-A (-2Q)

DCGW / DCGT

ISO	RE	LE	-A CTDMD05		-A CTDMD05		-A CTDPD20		-A CTDPD20		-A CTDPD20		-A CTDPD20	
			MDC	MDC	PDC	PDC	PDC	PDC	PDC	PDC				
	mm	mm	YO	YO	YO	YO	YO	YO	YO	YO	YO	YO	YO	
Article no.	71 130 ...	71 134 ...	71 130 ...	71 134 ...	71 130 ...	71 134 ...	71 135 ...	71 136 ...	71 135 ...	71 136 ...	71 135 ...	71 136 ...	71 135 ...	71 136 ...
£	£	£	£	£	£	£	£	£	£	£	£	£	£	£
070202FN	0.2	2.5		406.61	050	77.85	100	77.85	100					
070202FN	0.2	3.7		406.61	052	77.85	102	77.85	102					
070204FN	0.4	2.5		406.61	054	77.85	104	77.85	104					
070204FN	0.4	3.4		406.61	056	77.85	106	77.85	106					
070204FRR	0.4	5.5		406.61	058	77.85	108	77.85	108	108.09	102	108.09	102	
070204FLL	0.4	5.5		406.61	060	77.85	110	77.85	110	108.09	104	108.09	104	
070208FN	0.8	2.5		406.61	056	79.66	106	79.66	106					
070208FN	0.8	3.0		406.61	058	79.66	108	79.66	108					
070208FRR	0.8	5.0		406.61	060	79.66	110	79.66	110	116.66	108	116.66	108	
070208FLL	0.8	5.0		406.61	060	79.66	110	79.66	110	116.66	110	116.66	110	
11T302FN	0.2	2.5		376.80	056	79.66	106	79.66	106					
11T302FN	0.2	3.0		376.80	058	79.66	108	79.66	108					
11T302FN	0.2	4.7		376.80	060	79.66	110	79.66	110					
11T304FN	0.4	2.5		376.80	056	79.66	106	79.66	106					
11T304FN	0.4	3.0		376.80	058	79.66	108	79.66	108					
11T304FN	0.4	4.3		376.80	060	79.66	110	79.66	110					
11T304FRR	0.4	7.5		376.80	060	79.66	110	79.66	110	116.66	108	116.66	108	
11T304FLL	0.4	7.5		376.80	060	79.66	110	79.66	110	116.66	110	116.66	110	
11T308FN	0.8	2.5		376.80	056	79.66	106	79.66	106					
11T308FN	0.8	4.0		376.80	058	79.66	108	79.66	108					
11T308FRR	0.8	7.0		376.80	060	79.66	110	79.66	110	116.66	108	116.66	108	
11T308FLL	0.8	7.0		376.80	060	79.66	110	79.66	110	116.66	110	116.66	110	

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

DCGT / DCGW

ISO	RE mm	LE mm	-Q-A CTDPD20		-Q-A CTDPD20		-A-CB1 CTDPD20		-Q-A CTDPS30		-Q-A CTDPS30	
			-2Q PDC	-2Q PDC	-2Q PDC	-CB1 PDC	-2Q PDC-S	-2Q PDC-S	Y0	Y0	Y0	Y0
			Article no. 71 144 ...	Article no. 71 145 ...	Article no. 71 310 ...	Article no. 71 138 ...	Article no. 71 139 ...					
			£	£	£	£	£					
070202FN	0.2	3.7			92.10							
070204FL	0.4	3.0		96.91								
070204FR	0.4	3.0	96.91									
070204FN	0.4	3.4			92.10							
070208FN	0.8	3.0			101.43							
11T302FR	0.2	4.0				102.27						
11T302FN	0.2	4.7			94.08							
11T304FR	0.4	4.0	102.27			102.27						
11T304FL	0.4	4.0		102.27								
11T304FN	0.4	4.3			94.08							
11T308FN	0.8	4.0			108.99							
Steel												
Stainless steel												
Cast iron												
Non ferrous metals			•	•	•	•	•					
Heat resistant alloys								○	○			

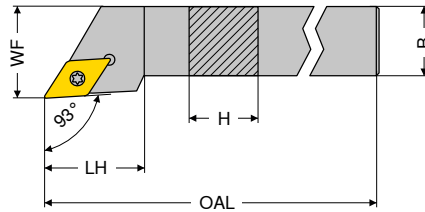
DCGT

ISO	RE mm	LE mm	-Q-A CTDPS30		-Q-A CTDPS30		-A-CB1 CTDPS30		-A-CB2 CTDPS30		-A-CB3 CTDPU20	
			-2Q PDC-S		-2Q PDC-S		-CB1 PDC-S		-CB2 PDC-S		-CB3 PDC-S	
			F DIAMOND DCGT YO		F DIAMOND DCGT YO		F DIAMOND DCGT YO		M DIAMOND DCGT YO		R DIAMOND DCGT YO	
			Article no. 71 144 ...		Article no. 71 145 ...		Article no. 71 310 ...		Article no. 71 311 ...		Article no. 71 312 ...	
			£		£		£		£		£	
070201FL	0.1	3.0			96.91	151						
070202FL	0.2	3.0			96.91	152						
070202FR	0.2	3.0	96.91	152								
070202FN	0.2	3.7					92.10	202				
070202EN	0.2	3.7					92.10	204	92.10	202		
070204FN	0.4	3.4					92.10	204			73.53	204
070204EN	0.4	3.4							92.10	204	101.43	208
070208EN	0.8	3.0										
11T301FL	0.1	4.0			102.27	161						
11T301FR	0.1	4.0	102.27	161	102.27	162						
11T302FR	0.2	4.0	102.27	162								
11T302FL	0.2	4.0			102.27	162						
11T302FN	0.2	4.7					94.08	212				
11T302EN	0.2	4.7					94.08	214	99.19	212		
11T304FN	0.4	4.3							99.19	214	77.85	214
11T304EN	0.4	4.3							108.99	218	87.58	218
11T308EN	0.8	4.0					108.99	218				
11T308FN	0.8	4.0										

DCGT

ISO	RE mm	LE mm	-A-CB1 CTDCD10		-A-CB2 CTDCD10	
			-CB1 CVD		-CB2 CVD	
			F DIAMOND DCGT YO		M DIAMOND DCGT YO	
			Article no. 71 310 ...		Article no. 71 311 ...	
			£		£	
070202FN	0.2	2.6	113.98	302		
070204FN	0.4	2.3	113.98	304		
070204EN	0.4	2.3			113.98	304
070208EN	0.8	2.0			122.96	308
11T304EN	0.4	2.3			115.71	314
11T304FN	0.4	2.3	115.71	314		
11T308EN	0.8	2.0			129.68	318
11T308FN	0.8	2.0	129.68	318		

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



Illustrations show right-hand versions



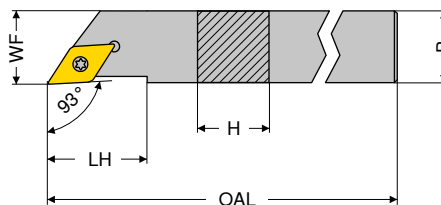
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 685 ...	£	Article no. 70 684 ...	£
SDJC R/L 0808 D07	8	8	60	13.0	10	1,2	DC.. 0702	55.38	008	55.38	008
SDJC R/L 1010 E07	10	10	70	13.0	12	1,2	DC.. 0702	58.72	010	58.72	010
SDJC R/L 1212 F07	12	12	80	14.5	16	1,2	DC.. 0702	58.72	012	58.72	012
SDJC R/L 1616 H11	16	16	100	20.0	20	3,2	DC.. 11T3	72.73	016	72.73	016
SDJC R/L 2020 K11	20	20	125	20.5	25	3,2	DC.. 11T3	77.31	020	77.31	020
SDJC R/L 2525 M11	25	25	150	21.5	32	3,2	DC.. 11T3	79.97	025	79.97	025
SDJC R/L 3225 P11	32	25	170	21.5	32	3,2	DC.. 11T3	83.13	032	83.13	032

i Tool holders with HSK-T or PSC interface can be found in → Chapter 16.

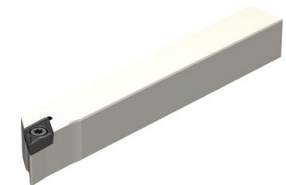
Spare parts	Y7		2A/28		2A		2A/28		2A/28	
	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£
Key D	80 950 ...	10.30	70 950 ...	7.53	70 950 ...	2.15	70 950 ...	6.81	70 950 ...	4.22
Combination Key										
Clamping screw										
Solid Carbide Seat D										
Threaded sleeve										

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

▲ for sliding head lathes



Illustrations show right-hand versions

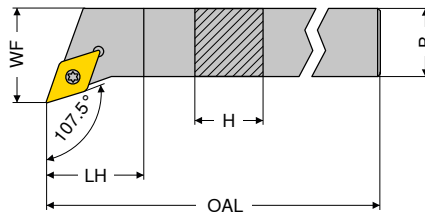


ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand X0		Right-hand X0	
								Article no. 70 685 ...	£	Article no. 70 684 ...	£
SDJC R/L 0808 H07	8	8	100	13.0	8	1,2	DC.. 0702	177.01	108	177.01	108
SDJC R/L 1010 H07	10	10	100	13.0	10	1,2	DC.. 0702	177.01	110	177.01	110
SDJC R/L 1212 H07	12	12	100	14.5	12	1,2	DC.. 0702	198.01	112	198.01	112
SDJC R/L 1616 K07	16	16	125	33.0	16	1,2	DC.. 0702	219.53	116	219.53	116
SDJC R/L 1212 H11	12	12	100	22.0	12	3,2	DC.. 11T3	198.01	212	198.01	212
SDJC R/L 1616 K11	16	16	125	33.0	16	3,2	DC.. 11T3	219.53	216	219.53	216

Spare parts	Y7		2A	
	Article no.	£	Article no.	£
Key D	80 950 ...	10.30	72 950 ...	4.36
Clamping screw				

DC.. 0702	T08	10.30	110	4.36	002
DC.. 11T3	T15	12.26	113	4.36	006

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



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 689 ...	£	Article no. 70 688 ...	£
SDHC R/L 1010 E07	10	10	70	5.5	12	1,2	DC.. 0702	58.72	010	58.72	010
SDHC R/L 1212 F07	12	12	80	12.0	16	1,2	DC.. 0702	58.72	012	58.72	012
SDHC R/L 1616 H11	16	16	100	10.4	20	3,2	DC.. 11T3	72.73	016	72.73	016
SDHC R/L 2020 K11	20	20	125	14.0	32	3,2	DC.. 11T3	77.31	020	77.31	020
SDHC R/L 2525 M11	25	25	150	20.0	32	3,2	DC.. 11T3	79.97	025	79.97	025

Spare parts

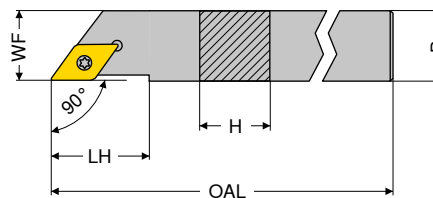
for Article no.

	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
70 689 010 / 70 688 010	110	10.30			112	2.15				
70 689 012 / 70 688 012	110	10.30			112	2.15				
70 689 016 / 70 688 016			398	7.53	113	2.85	106	6.81	171	4.22
70 689 020 / 70 688 020			398	7.53	113	2.85	106	6.81	171	4.22
70 689 025 / 70 688 025			398	7.53	113	2.85	106	6.81	171	4.22

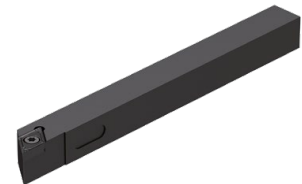
Y7	2A/28	2A	2A/28	2A/28
Key D	Combination Key	Clamping screw	Solid Carbide Seat D	Threaded sleeve
Article no. 80 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...
£	£	£	£	£

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

▲ for sliding head lathes



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 789 ...	£	Article no. 70 788 ...	£
SDAC R/L 0808 K07	8	8	125	14	8	1,2	DC.. 0702	58.72	008	58.72	008
SDAC R/L 1010 M07	10	10	150	14	10	1,2	DC.. 0702	58.72	010	58.72	010
SDAC R/L 1212 M07	12	12	150	14	12	1,2	DC.. 0702	65.68	012	65.68	012
SDAC R/L 1414 M11	14	14	150	21	14	3,2	DC.. 11T3	65.68	014	65.68	014

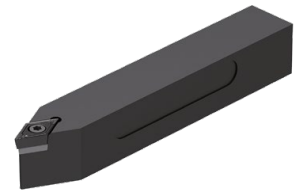
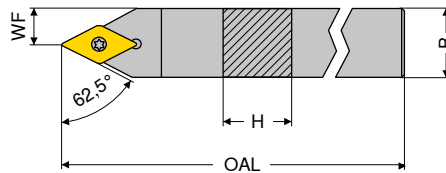
Spare parts

for Article no.

	Article no.	£	Article no.	£
70 788 008 / 70 789 008	T08	10.30	112	2.15
70 788 010 / 70 789 010	T08	10.30	112	2.15
70 788 012 / 70 789 012	T08	10.30	112	2.15
70 788 014 / 70 789 014	T15	12.26	113	2.85

Y7	2A
Key D	Clamping screw
Article no. 80 950 ...	Article no. 70 950 ...
£	£

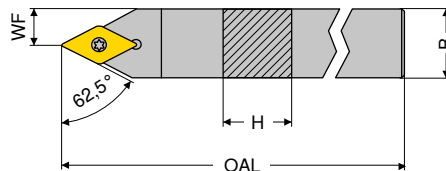
MaxiLock-S – SDNC 62.5° – Toolholder with screw clamping



ISO designation	H mm	B mm	OAL mm	WF mm	torque moment Nm	Insert	Neutral 2A/24	
							Article no. 70 680 ...	£
SDNC N 0808 D07	8	8	60	4.0	1,2	DC.. 0702	55.38	008
SDNC N 1010 E07	10	10	70	5.0	1,2	DC.. 0702	58.72	010
SDNC N 1212 F07	12	12	80	6.0	1,2	DC.. 0702	58.72	012
SDNC N 1616 H11	16	16	100	8.0	3,2	DC.. 11T3	72.73	016
SDNC N 2020 K11	20	20	125	10.0	3,2	DC.. 11T3	77.31	020
SDNC N 2525 M11	25	25	150	12.5	3,2	DC.. 11T3	79.97	025

Spare parts for Article no.	Y7		2A/28		2A		2A/28		2A/28	
	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
70 680 008	110	10.30			112	2.15				
70 680 010	110	10.30			112	2.15				
70 680 012	110	10.30			112	2.15				
70 680 016			398	7.53	113	2.85	106	6.81	171	4.22
70 680 020			398	7.53	113	2.85	106	6.81	171	4.22
70 680 025			398	7.53	113	2.85	106	6.81	171	4.22

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

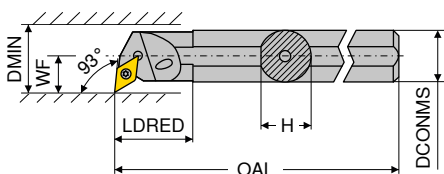


ISO designation	H mm	B mm	OAL mm	WF mm	torque moment Nm	Insert	Neutral 2A/24	
							Article no. 70 784 ...	£
SDNC N 0808 K07	8	8	125	4	1,2	DC.. 0702	55.38	008
SDNC N 1010 M07	10	10	150	5	1,2	DC.. 0702	58.72	010
SDNC N 1212 M07	12	12	150	6	1,2	DC.. 0702	65.68	012
SDNC N 1414 M11	14	14	150	7	3,2	DC.. 11T3	65.68	014

Spare parts for Article no.	Y7		2A			
	Article no. 80 950 ...	£	Article no. 70 950 ...	£		
70 784 008	T08	10.30	110	M2,5x6	2.15	112
70 784 010	T08	10.30	110	M2,5x6	2.15	112
70 784 012	T08	10.30	110	M2,5x6	2.15	112
70 784 014	T15	12.26	113	M3,5x11	2.85	113

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

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



Illustrations show right-hand versions

ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 737 ...	£	Article no. 70 736 ...	£
S12Q SDUC R/L 07	12	11.0	180		9	17	1,2	DC.. 0702	87.79	012	87.79	012
A12K SDUC R/L 07	12	11.5	125		9	16	1,2	DC.. 0702	87.79	212	87.79	212
A16M SDUC R/L 07	16	15.0	150	29	11	20	1,2	DC.. 0702	89.70	216	89.70	216
S16R SDUC R/L 07	16	15.0	200		11	21	1,2	DC.. 0702	89.70	016	89.70	016
A20Q SDUC R/L 07	20	18.5	180	32	13	25	1,2	DC.. 0702	111.82	220	111.82	220
S20S SDUC R 07	20	18.0	250		13	25	1,2	DC.. 0702			111.82	020
S20S SDUC R 11	20	18.0	250		13	25	3,2	DC.. 11T3			111.82	120
A20Q SDUC R/L 11	20	18.5	180	32	13	25	3,2	DC.. 11T3	111.82	320	111.82	320
A25R SDUC R/L 11	25	23.0	200	36	17	32	3,2	DC.. 11T3	128.55	325	128.55	325
S25T SDUC R/L 11	25	23.0	300		17	32	3,2	DC.. 11T3	128.55	125	128.55	125
A32S SDUC R/L 11	32	30.0	250	50	22	40	3,2	DC.. 11T3	176.73	332	176.73	332
S32U SDUC R 11	32	30.0	350		22	40	3,2	DC.. 11T3			176.73	132
A40T SDUC R/L 11	40	38.0	300	60	27	50	3,2	DC.. 11T3	212.18	340	212.18	340

i Tool holders with HSK-T or PSC interface can be found in → Chapter 16.

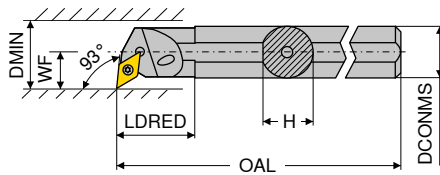
Spare parts

for Article no.

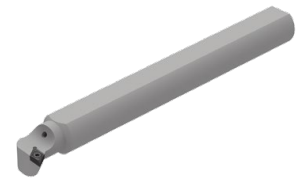
	Y7 Key D		2A/28 Combination Key		2A Clamping screw		2A/28 Solid Carbide Seat D		2A/28 Threaded sleeve	
	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
70 736 012 / 70 737 012	10.30	110			2.15	112				
70 736 212 / 70 737 212	10.30	110			2.15	112				
70 736 216 / 70 737 216	10.30	110			2.15	112				
70 736 016 / 70 737 016	10.30	110			2.15	112				
70 736 220 / 70 737 220	10.30	110			2.15	112				
70 736 020	10.30	110			2.15	112				
70 736 120	12.26	113			2.85	110				
70 736 320 / 70 737 320	12.26	113			2.85	110				
70 736 325 / 70 737 325	12.26	113			2.85	113				
70 736 125 / 70 737 125			7.53	398	2.85	113	6.81	106	4.22	171
70 736 332 / 70 737 332			7.53	398	2.85	113	6.81	106	4.22	171
70 736 132			7.53	398	2.85	113	6.81	106	4.22	171
70 736 340 / 70 737 340			7.53	398	2.85	113	6.81	106	4.22	171

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

▲ with carbide core



Illustrations show right-hand versions



ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A		Right-hand 2A	
									Article no. 70 739 ...	£	Article no. 70 738 ...	£
E-A10H SDUC R/L 07	10	9	100	28	8	13	1,2	DC.. 0702	163.09	210	163.09	210
E-A12K SDUC R/L 07	12	11	125	18	9	18	1,2	DC.. 0702	163.09	212	163.09	212
E-A16M SDUC R/L 07	16	15	150	30	11	22	1,2	DC.. 0702	259.27	216	259.27	216
E-A20Q SDUC R/L 07	20	18	180	38	13	26	1,2	DC.. 0702	325.09	220	325.09	220
E-A20Q SDUC R/L 11	20	18	180	38	13	26	3,2	DC.. 11T3	344.18	320	344.18	320
E-A25R SDUC R/L 11	25	23	200	38	17	34	3,2	DC.. 11T3	495.73	225	495.73	225
E-A32S SDUC R/L 11	32	30	250	43	22	39	3,2	DC.. 11T3	727.36	232	727.36	232

Y7		2A	
	Key D		Clamping screw
Article no. 80 950 ...	£	Article no. 70 950 ...	£
10.30	110	2.15	112
10.30	110	2.15	112
10.30	110	2.15	112
10.30	110	2.15	112
12.26	113	2.85	449
12.26	113	2.85	449
12.26	113	2.85	449

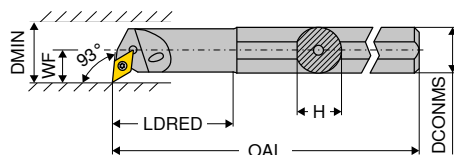
Spare parts

for Article no.

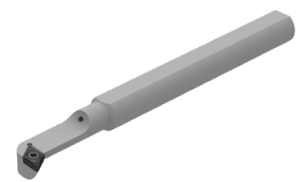
70 738 210 / 70 739 210	
70 738 212 / 70 739 212	
70 738 216 / 70 739 216	
70 738 220 / 70 739 220	
70 738 320 / 70 739 320	
70 738 225 / 70 739 225	
70 738 232 / 70 739 232	

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

▲ with carbide core



Illustrations show right-hand versions



ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A		Right-hand 2A	
									Article no. 70 739 ...	£	Article no. 70 738 ...	£
E-A0810H SDUC R/L 07	10	9	100	22	7	12.5	1,2	DC.. 0702	203.09	410	203.09	410
E-A1012K SDUC R/L 07	12	11	125	28	9	15.5	1,2	DC.. 0702	203.09	412	203.09	412
E-A1216M SDUC R/L 07	16	15	150	36	11	19.5	1,2	DC.. 0702	203.09	416	203.09	416

Y7		2A	
	Key D		Clamping screw
Article no. 80 950 ...	£	Article no. 70 950 ...	£
10.30	110	2.15	112
10.30	110	2.15	112
10.30	110	2.15	112

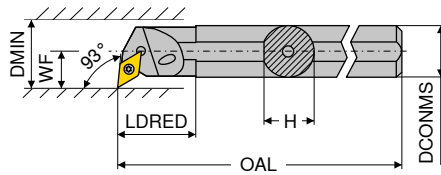
Spare parts

for Article no.

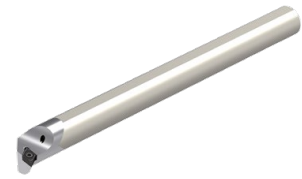
70 738 410 / 70 739 410	
70 738 412 / 70 739 412	
70 738 416 / 70 739 416	

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

▲ Type: Solid carbide



Illustrations show right-hand versions



ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 739 ...	Article no. 70 738 ...	Article no. 70 739 ...	Article no. 70 738 ...
E12Q SDUC R/L 07	12	11.5	180	26	9	16	1,2	DC.. 0702	302.91	012	302.91	012
E16R SDUC R/L 07	16	15.0	200	34	11	20	1,2	DC.. 0702	395.82	016	395.82	016
E20S SDUC R/L 11	20	18.5	250	38	13	25	3,2	DC.. 11T3	494.45	120	494.45	120
E25T SDUC R/L 11	25	23.0	300	43	17	32	3,2	DC.. 11T3	871.91	125	871.91	125

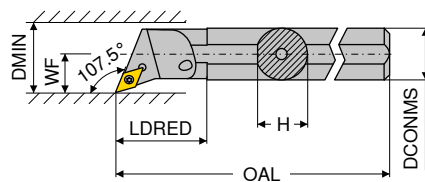
Y7		2A	
	Key D		Clamping screw
Article no. 80 950 ...	Article no. 70 950 ...	Article no. 80 950 ...	Article no. 70 950 ...
£	£	£	£
10.30	110	2.15	112
10.30	110	2.15	112
12.26	113	2.85	304
12.26	113	2.85	113

Spare parts

for Article no.

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

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



Illustrations show right-hand versions



ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A		Right-hand 2A	
									Article no. 70 741 ...	Article no. 70 740 ...	Article no. 70 741 ...	Article no. 70 740 ...
A10H SDQC R/L 07	10	9.0	100	22	7	12.5	1,2	DC.. 0702	87.79	210	87.79	210
A12K SDQC R/L 07	12	11.5	125	22	9	16.0	1,2	DC.. 0702	87.79	212	87.79	212
A16M SDQC R/L 07	16	15.0	150	29	11	20.0	1,2	DC.. 0702	89.70	216	89.70	216
A20Q SDQC R/L 07	20	18.5	180	32	13	25.0	1,2	DC.. 0702	111.82	220	111.82	220
A25R SDQC R/L 11	25	23.0	200	36	17	32.0	3,2	DC.. 11T3	128.55	225	128.55	225
A32S SDQC R/L 11	32	30.0	250	50	22	40.0	3,2	DC.. 11T3	176.73	232	176.73	232
A40T SDQC R/L 11	40	38.0	300	60	27	50.0	3,2	DC.. 11T3	212.18	240	212.18	240

Y7		2A/28		2A		2A/28		2A/28	
	Key D		Combination Key		Clamping screw		Solid Carbide Seat D		Threaded sleeve
Article no. 80 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...
£	£	£	£	£	£	£	£	£	£
10.30	110	2.15	112	2.15	112	2.15	112	2.15	112
10.30	110	2.15	112	2.15	112	2.15	112	2.15	112
10.30	110	2.15	112	2.15	112	2.15	112	2.15	112
10.30	110	2.15	112	2.15	112	2.15	112	2.15	112
		7.53	398	2.85	113	6.81	106	4.22	171
		7.53	398	2.85	113	6.81	106	4.22	171
		7.53	398	2.85	113	6.81	106	4.22	171

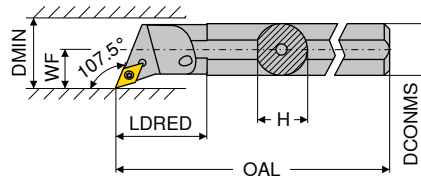
Spare parts

for Article no.

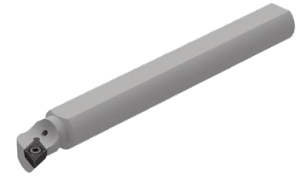
70 740 210 / 70 741 210
70 740 212 / 70 741 212
70 740 216 / 70 741 216
70 740 220 / 70 741 220
70 740 225 / 70 741 225
70 740 232 / 70 741 232
70 740 240 / 70 741 240

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

▲ with carbide core



Illustrations show right-hand versions



ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A		Right-hand 2A	
									Article no. 70 751 ...	Article no. 70 750 ...	Article no. 70 751 ...	Article no. 70 750 ...
E-A12K SDQC R/L 07	12	11	125	24	9	18	1,2	DC.. 0702	163.09	012	163.09	012
E-A16M SDQC R/L 07	16	15	150	30	11	22	1,2	DC.. 0702	278.36	016	278.36	016
E-A20Q SDQC R/L 07	20	18	180	38	13	26	1,2	DC.. 0702	325.09	020	325.09	020
E-A20Q SDQC R/L 11	20	18	180	38	13	26	3,2	DC.. 11T3	344.18	120	344.18	120
E-A25R SDQC R/L 11	25	23	200	38	17	34	3,2	DC.. 11T3	550.09	025	550.09	025
E-A32S SDQC R/L 11	32	30	250	43	22	39	3,2	DC.. 11T3	727.36	032	727.36	032

Y7		2A	
	Key D		Clamping screw
Article no. 80 950 ...	Article no. 70 950 ...	Article no. 80 950 ...	Article no. 70 950 ...
£	£	£	£
10.30	110	2.15	112
10.30	110	2.15	112
10.30	110	2.15	112
12.26	113	2.85	449
12.26	113	2.85	449
12.26	113	2.85	449

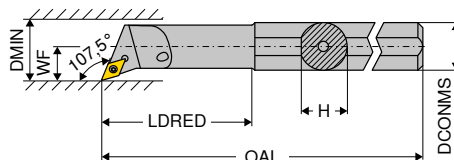
Spare parts

for Article no.

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

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

▲ with carbide core



Illustrations show right-hand versions



ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A		Right-hand 2A	
									Article no. 70 751 ...	Article no. 70 750 ...	Article no. 70 751 ...	Article no. 70 750 ...
E-A0810H SDQC R/L 07	10	9	100	22	7	12.5	1,2	DC.. 0702	203.09	210	203.09	210
E-A1012K SDQC R/L 07	12	11	125	28	9	15.5	1,2	DC.. 0702	203.09	212	203.09	212
E-A1216M SDQC R/L 07	16	15	150	36	11	19.5	1,2	DC.. 0702	203.09	216	203.09	216

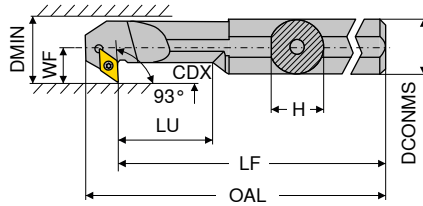
Y7		2A	
	Key D		Clamping screw
Article no. 80 950 ...	Article no. 70 950 ...	Article no. 80 950 ...	Article no. 70 950 ...
£	£	£	£
10.30	110	2.15	112
10.30	110	2.15	112
10.30	110	2.15	112

Spare parts

for Article no.

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

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



Illustrations show right-hand versions



ISO designation	DCONMS	H	LF	OAL	LU	WF	DMIN	CDX	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
											Article no. 70 733 ...	Article no. 70 732 ...	Article no. 70 733 ...	Article no. 70 732 ...
A12K SDXC R/L 07	12	11.5	125	137.0	24	9	16	4.5	1,2	DC.. 0702	£ 87.79	212	£ 87.79	212
A16M SDXC R/L 07	16	15.0	150	162.0	36	11	20	4.5	1,2	DC.. 0702	£ 89.70	216	£ 89.70	216
A20Q SDXC R/L 11	20	18.5	180	196.5	40	13	25	6.5	3,2	DC.. 11T3	£ 111.82	220	£ 111.82	220
A25R SDXC R/L 11	25	23.0	200	216.8	50	17	32	9.5	3,2	DC.. 11T3	£ 128.55	225	£ 128.55	225

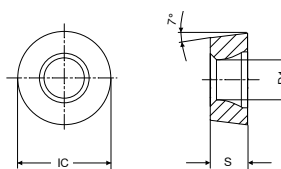
Spare parts

for Article no.	Y7		2A	
	Article no. 80 950 ...	Article no. 70 950 ...	Article no. 80 950 ...	Article no. 70 950 ...
70 733 212 / 70 732 212	£ 10.30	110	£ 2.15	112
70 733 216 / 70 732 216	£ 10.30	110	£ 2.15	112
70 733 220 / 70 732 220	£ 12.26	113	£ 2.85	304
70 733 225 / 70 732 225	£ 12.26	113	£ 2.85	304



RCMT / RCGT





Designation	S	D1	IC
	mm	mm	mm
RCGT 0602..	2.38	2.8	6
RCGT 0803..	3.18	3.4	8
RC.T 1003..	3.18	4.0	10
RCMT 1204..	4.76	4.9	12
RCMT 1606..	6.35	5.3	16
RCMT 2006..	6.35	6.5	20
RCMT 2507..	7.94	7.2	25



RCMT / RCGT

ISO	RE	-SMF CTCK110		-SM CTCP125		-SM CTCP135		-SM CTCP115		-SM CTCP125		-SM CTCP135		-27 H10T	
		Article no.	Price	Article no.	Price	Article no.	Price	Article no.	Price	Article no.	Price	Article no.	Price	Article no.	Price
0602MOEN	3.0	70 188 ...		76 262 ...	7.34	76 262 ...	7.34	76 264 ...							
0602MOFN	3.0													5.48	600
0803MOEN	4.0			8.17	512	8.17	712								
0803MOFN	4.0													6.12	602
1003MOFN	5.0													6.12	604
1003MOSN	5.0									7.07	514	7.07	714		
1204MOSN	6.0							8.38	328	8.38	526	8.38	726		
1606MOEN	8.0	16.48	038												
1606MOSN	8.0							16.48	340	16.48	538	16.48	738		
2006MOSN	10.0									22.68	550	22.68	750		
2507MOSN	12.5							36.53	36200	36.53	562	36.53	762		
Steel		●		●		●		●		●		●		●	
Stainless steel		○		○		○		○		○		○		○	
Cast iron		●		○		○		○		○		○		○	
Non ferrous metals														●	
Heat resistant alloys						○						○		○	

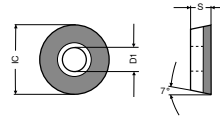
RCGT

-27 CWN15	-27 AMZ
-AL CWN15	-AL AMZ
	
	
M RCGT	M RCGT
1A	1A/90
Article no. 70 266 ...	Article no. 70 266 ...
£	£
7.30 300	7.15 502

ISO	RE	mm	£		£	
0602MOFN	3		7.30	300		
0803MOFN	4		7.30	302	7.15	502
Steel						○
Stainless steel						○
Cast iron						○
Non ferrous metals					●	●
Heat resistant alloys						

RCGT

Designation	S	D1	IC
	mm	mm	mm
RCGT 0602..	2.38	2.8	6
RCGT 10T3..	3.97	4.4	10



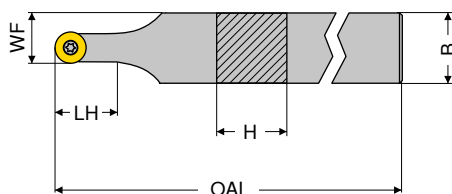
RCGT-F

RCGT

ISO	RE mm	LE mm	-F-CB1 CTDPD20		-F-CB1 CTDPS30		-F-CB2 CTDPS30	
			Article no. 71 315 ...	£	Article no. 71 315 ...	£	Article no. 71 316 ...	£
0602M0EN	3	6					223.02	202
0602M0FN	3	6	223.02	102	223.02	202		
10T3M0EN	5	10					293.17	204
10T3M0FN	5	10	293.17	104	293.17	204		

Material	-F-CB1 CTDPD20	-F-CB1 CTDPS30	-F-CB2 CTDPS30
Steel	○	○	○
Stainless steel	○	○	○
Cast iron	○	○	○
Non ferrous metals	●	●	●
Heat resistant alloys	○	○	○

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



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Neutral 2A/24	
								Article no. 70 708 ...	£
SRDC N 1212 F06	12	12	80	12.4	9.0	1,2	RC.. 0602 MO	66.91	012
SRDC N 1616 H06	16	16	100	12.4	11.0	1,2	RC.. 0602 MO	69.39	016
SRDC N 2020 K06	20	20	125	12.4	13.0	1,2	RC.. 0602 MO	77.31	020
SRDC N 2525 M06	25	25	150	12.4	15.5	1,2	RC.. 0602 MO	79.97	025
SRDC N 1616 H08	16	16	100	16.4	12.0	1,8	RC.. 0803 MO	69.39	116
SRDC N 2020 K08	20	20	125	16.4	14.0	1,8	RC.. 0803 MO	77.31	120
SRDC N 2525 M08	25	25	150	16.4	16.5	1,8	RC.. 0803 MO	79.97	125
SRDC N 1616 H10	16	16	100	20.3	13.0	3,2	RC.. 1003 MO	69.39	216
SRDC N 2020 K10	20	20	125	20.3	15.0	3,2	RC.. 1003 MO	77.31	220
SRDC N 2525 M10	25	25	150	20.3	17.5	3,2	RC.. 1003 MO	79.97	225

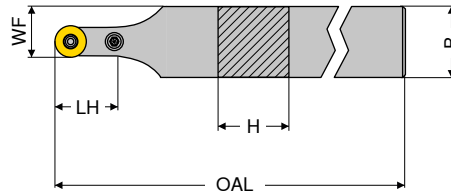
Spare parts

for Article no.

	Y7		2A/28		2A		2A/28		2A/28	
	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
70 708 012	10.30	110			2.15	112				
70 708 016	10.30	110			2.15	112				
70 708 020	10.30	110			2.15	112				
70 708 025	10.30	110			2.15	112				
70 708 116	10.30	110			2.34	115				
70 708 120	10.30	110			2.34	115				
70 708 125	10.30	110			2.34	115				
70 708 216			7.53	398	2.85	113	11.25	117	4.22	171
70 708 220			7.53	398	2.85	113	11.25	117	4.22	171
70 708 225			7.53	398	2.85	113	11.25	117	4.22	171



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

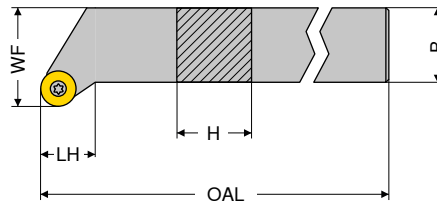


ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Neutral 2A/24	
								Article no. 70 544 ...	£
PRDC N 2525 M12	25	25	150	24	18.5	3	RCMT 1204	79.97	025
PRDC N 3225 P12	32	25	170	24	18.5	3	RCMT 1204	85.79	032
PRDC N 3225 P16	32	25	170	28	20.5	4	RCMT 1606	85.79	132
PRDC N 3225 P20	32	32	170	32	26.0	5	RCMT 2006	105.91	23200
PRDC N 4040 S25	40	40	250	42	32.5	6	RCMT 2507	131.73	04000

i Tool holders with HSK-T interface can be found in → **Chapter 16.**

Spare parts	2A/28		2A/28		2A/28		2A/28		2A/28		2A/28			
	Key I	Shim	Assembly pin	Lever	Clamping screw	Solid carbide support R	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£		
for Article no.														
70 544 025		SW2,5	2.23	175	1.60	197	1.11	191	14.11	178	2.90	208	6.45	215
70 544 032		SW2,5	2.23	175	1.60	197	1.11	191	14.11	178	2.90	208	6.45	215
70 544 132		SW3	2.23	176	1.25	196	1.11	192	14.60	387	3.18	390	11.45	384
70 544 23200		SW2	2.23	177	1.02	391	1.11	394	13.85	28100	3.13	28500	15.49	27400
70 544 04000		SW4	2.34	396	1.60	392	1.11	395	17.05	28400	6.80	28600	29.05	27500

MaxiLock-S – SRGC – Toolholder with screw clamping



Illustrations show right-hand versions

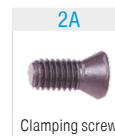


ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 713 ...	£	Article no. 70 712 ...	£
SRGC R/L 1212 F06	12	12	80	10.0	16	1,2	RC.. 0602 MO	66.91	012	66.91	012
SRGC R 1616 H06	16	16	100	10.0	20	1,2	RC.. 0602 MO			69.39	016
SRGC R/L 2020 K06	20	20	125	11.5	25	1,2	RC.. 0602 MO	77.31	020	77.31	020
SRGC R/L 2525 M06	25	25	150	15.0	32	1,2	RC.. 0602 MO	79.97	025	79.97	025
SRGC R/L 1616 H08	16	16	100	11.0	20	1,8	RC.. 0803 MO	69.39	116	69.39	116
SRGC R 2020 K08	20	20	125	13.0	25	1,8	RC.. 0803 MO			77.31	120
SRGC R/L 2525 M08	25	25	150	16.0	32	1,8	RC.. 0803 MO	79.97	125	79.97	125
SRGC R/L 1616 H10	16	16	100	12.0	20	3,2	RC.. 1003 MO	69.39	216	69.39	216
SRGC R/L 2020 K10	20	20	125	13.5	25	3,2	RC.. 1003 MO	77.31	220	77.31	220
SRGC R/L 2525 M10	25	25	150	17.0	32	3,2	RC.. 1003 MO	79.97	225	79.97	225

Spare parts

for Article no.

		Article no. 70 950 ...		Article no. 70 950 ...		Article no. 70 950 ...	
		£		£		£	
70 712 012 / 70 713 012	M2,5x6	2.15	112				
70 712 016	M2,5x6	2.15	112				
70 712 020 / 70 713 020	M2,5x6	2.15	112				
70 712 025 / 70 713 025	M2,5x6	2.15	112				
70 712 116 / 70 713 116	M3x7,3	2.34	115				
70 712 120	M3x7,3	2.34	115				
70 712 125 / 70 713 125	M3x7,3	2.34	115				
70 712 216 / 70 713 216	M3,5x11	2.85	113	11.25	117	M3,5	4.22 171
70 712 220 / 70 713 220	M3,5x11	2.85	113	11.25	117	M3,5	4.22 171
70 712 225 / 70 713 225	M3,5x11	2.85	113	11.25	117	M3,5	4.22 171



Clamping screw



Solid carbide support R

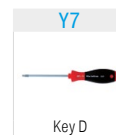


Threaded sleeve

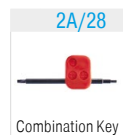
Spare parts

for Article no.

		Article no. 80 950 ...		Article no. 70 950 ...	
		£		£	
70 712 012 / 70 713 012	T08	10.30	110		
70 712 016	T08	10.30	110		
70 712 020 / 70 713 020	T08	10.30	110		
70 712 025 / 70 713 025	T08	10.30	110		
70 712 116 / 70 713 116	T08	10.30	110		
70 712 120	T08	10.30	110		
70 712 125 / 70 713 125	T08	10.30	110		
70 712 216 / 70 713 216				T15/SW	7.53 398
70 712 220 / 70 713 220				T15/SW	7.53 398
70 712 225 / 70 713 225				T15/SW	7.53 398



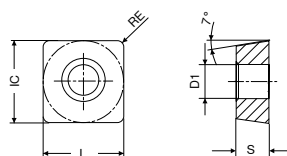
Key D



Combination Key

SCGT / SCMT / SCMX

Designation	L	S	D1	IC
	mm	mm	mm	mm
SC.T 09T3..	9.52	3.97	4.4	9.52
SC.. 1204..	12.70	4.76	5.5	12.70



SCGT / SCMT

		-CF05 CTEP110	-SF TCM10	-SF TCM407	-SF CTCP125	-CF55 CTEP110	-SMF CTCP115	-SMF CTCP135
		-PF14 DCC1110	-ZF CWC10	-ZF CWC407	-ZF HCX1125	-PF15 DCC1110	-SMF HCX1115	-SMF HCR1135
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F	F	F	F	F	F	F
		CERMET SCGT	CERMET SCGT	CERMET SCGT	SCMT	CERMET SCMT	SCMT	SCMT
		1A/78	1A/78	1A/78	1A/08	1A/78	1A/08	1A/08
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	76 261 ...	70 271 ...	70 271 ...	76 269 ...	76 260 ...	76 267 ...	76 267 ...
		£	£	£	£	£	£	£
09T304EN	0.4	13.73 004	12.60 902	12.60 852	8.82 504	8.80 004	8.82 304	
09T308EN	0.8	13.73 006	12.60 904		8.82 506	8.80 006	8.82 306	
120408EN	0.8				12.42 518			12.42 718
Steel		●	●	●	●	●	●	●
Stainless steel		○	○	○	○	○	○	○
Cast iron		○	○	○	○	○	○	○
Non ferrous metals								
Heat resistant alloys								○

SCMT / SCMX

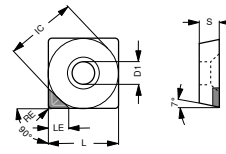
		-SM CTCK110	-SM CTCK120	-SM CTCP115	-SM CTCP125	-SM CTCP135	CTCP135	-SM CTC2135
		-ZM DCX3110	-ZM HCF3120	-ZM HCX1115	-ZM HCX1125	-ZM HCR1135	HCR1135	-ZM CWN2135
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		M	M	M	M	M	M	M
		SCMT	SCMT	SCMT	SCMT	SCMT	SCMX	SCMT
		1A/08	1A/08	1A/08	1A/08	1A/08	1A/08	1A/08
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	70 268 ...	70 268 ...	76 268 ...	76 268 ...	76 268 ...	76 182 ...	70 268 ...
		£	£	£	£	£	£	£
09T304EN	0.4	8.82 004	8.82 504	8.82 304	8.82 504	8.82 704		
09T308EN	0.8	8.82 006	8.82 506	8.82 306	8.82 506	8.82 706		8.80 442
120408EN	0.8	12.42 018	12.42 518	12.42 318	12.42 518	12.42 718	11.29 718	12.42 444
120412EN	1.2	12.42 020	12.42 520		12.42 520			
Steel		●	●	●	●	●	●	○
Stainless steel		○	○	○	○	○	○	●
Cast iron		●	●	○	○			
Non ferrous metals								
Heat resistant alloys						○	○	●

SCMT / SCGT

		-M55 CTPM125		-25P H210T		-25P AMZ		-27 H10T		-27 CWN15	
		-PF26 HCN2125		-25P CWK20		-25P AMZ		-AL CWK15		-AL CWN15	
		DRAGONSKIN									
		F		F		F		M		M	
		SCMT		SCGT		SCGT		SCGT		SCGT	
		1A/08		1A/90		1A/90		1A/90		1A	
		Article no. 75 216 ...		Article no. 70 283 ...		Article no. 70 283 ...		Article no. 70 270 ...		Article no. 70 270 ...	
ISO	RE	£		£		£		£		£	
	mm										
09T304FN	0.4							9.92	600	12.19	300
09T308EN	0.8	8.82	206								
09T308FN	0.8							9.92	602	12.19	302
120408EN	0.8	12.42	218								
120408FN	0.8			12.10	634	14.35	554	11.59	604	14.45	304
Steel			○				○				
Stainless steel			●				○				○
Cast iron					○		○		○		
Non ferrous metals					●		●		●		●
Heat resistant alloys					○				○		

SCGT

Designation	L	S	D1	IC
	mm	mm	mm	mm
SCGT 09T3..	9.52	3.97	4.4	9.52



SCGT-A

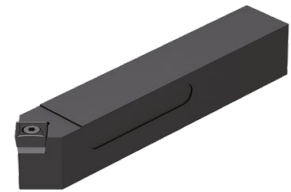
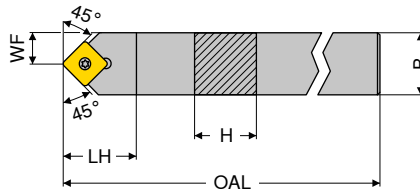
SCGT

-A-CB1 CTDPD20	-A-CB2 CTDPS30	-A-CB3 CTDPJ20
-CB1 PDC	-CB2 PDC-S	-CB3 PDC-S
F	M	R
DIAMOND SCGT	DIAMOND SCGT	DIAMOND SCGT
YO	NEW YO	YO
Article no. 71 320 ...	Article no. 71 321 ...	Article no. 71 322 ...
£	£	£
101.43 114	101.43 214	81.10 214
108.99 118	108.99 218	87.58 218

ISO	RE	LE
	mm	mm
09T304EN	0.4	4.4
09T304FN	0.4	4.4
09T308EN	0.8	4.3
09T308FN	0.8	4.3

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

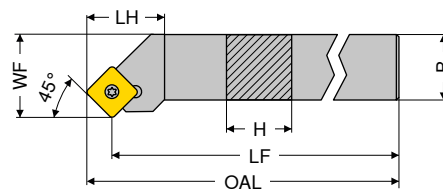
MaxiLock-S – SSDC 45° – Toolholder with screw clamping



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Neutral 2A/24	
								Article no. 70 656 ...	£
SSDC N 1212 F09	12	12	80	16	6.0	3,2	SC.. 09T3..	58.72	012
SSDC N 1616 H09	16	16	100	20	8.0	3,2	SC.. 09T3..	72.73	016
SSDC N 2020 K09	20	20	125	20	10.0	3,2	SC.. 09T3..	77.31	020
SSDC N 1616 H12	16	16	100	25	8.0	5	SC.. 1204..	72.73	116
SSDC N 2020 K12	20	20	125	25	10.0	5	SC.. 1204..	77.31	120
SSDC N 2525 M12	25	25	150	25	12.5	5	SC.. 1204..	79.97	125

Spare parts for Article no.	Y7		2A/28		2A/28		2A/28		2A/28	
	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
70 656 012	12.26	113			2.85	113				
70 656 016			7.53	398	2.85	113	8.79	167	4.22	171
70 656 020			7.53	398	2.85	113	8.79	167	4.22	171
70 656 116			7.53	398	2.34	114	11.25	168	4.22	170
70 656 120			7.53	398	2.34	114	11.25	168	4.22	170
70 656 125			7.53	398	2.34	114	11.25	168	4.22	170

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



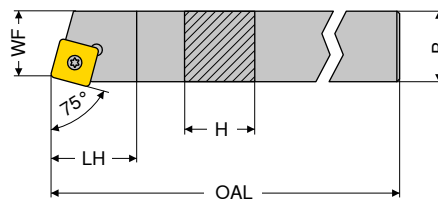
Illustrations show right-hand versions



ISO designation	H mm	B mm	LF mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 661 ...	£	Article no. 70 660 ...	£
SSSC R/L 1212 F09	12	12	80	86.40	18	16	3,2	SC.. 09T3..	58.72	012	58.72	012
SSSC R/L 1616 H09	16	16	100	106.40	20	20	3,2	SC.. 09T3..	72.73	016	72.73	016
SSSC R/L 2020 K09	20	20	125	131.40	20	25	3,2	SC.. 09T3..	77.31	020	77.31	020
SSSC R/L 1616 H12	16	16	100	108.63	25	20	5	SC.. 1204..	72.73	116	72.73	116
SSSC R/L 2020 K12	20	20	125	133.63	25	25	5	SC.. 1204..	77.31	120	77.31	120
SSSC R/L 2525 M12	25	25	150	158.63	25	32	5	SC.. 1204..	79.97	125	79.97	125
SSSC R 3225 P12	32	25	170	178.63	25	32	5	SC.. 1204..			83.13	132

Spare parts for Article no.	Y7		2A/28		2A/28		2A/28		2A/28	
	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
70 661 012 / 70 660 012	12.26	113			2.85	113				
70 661 016 / 70 660 016			7.53	398	2.85	113	8.79	167	4.22	171
70 661 020 / 70 660 020			7.53	398	2.85	113	8.79	167	4.22	171
70 661 116 / 70 660 116			7.53	398	2.34	114	11.25	168	4.22	170
70 661 120 / 70 660 120			7.53	398	2.34	114	11.25	168	4.22	170
70 661 125 / 70 660 125			7.53	398	2.34	114	11.25	168	4.22	170
70 660 132			7.53	398	2.34	114	11.25	168	4.22	170

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



Illustrations show right-hand versions

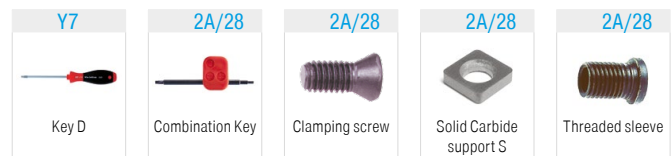


ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 665 ...	£	Article no. 70 664 ...	£
SSBC R/L 1616 H09	16	16	100	20	13	3,2	SC.. 09T3..	72.73	016	72.73	016
SSBC R 2020 K09	20	20	125	20	17	3,2	SC.. 09T3..	77.31	020	77.31	020
SSBC R/L 2020 K12	20	20	125	20	17	5	SC.. 1204..	77.31	120	77.31	120
SSBC R/L 2525 M12	25	25	150	20	22	5	SC.. 1204..	79.97	125	79.97	125

Spare parts

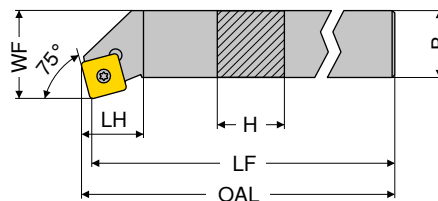
for Article no.

	£		£		£		£		£	
70 665 016 / 70 664 016	12.26	113	7.53	398	2.85	113	8.79	167	4.22	171
70 664 020	12.26	113	7.53	398	2.85	113	8.79	167	4.22	171
70 665 120 / 70 664 120	12.26	113	7.53	398	2.34	114	11.25	168	4.22	170
70 665 125 / 70 664 125	12.26	113	7.53	398	2.34	114	11.25	168	4.22	170



Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£
80 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	

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



Illustrations show right-hand versions

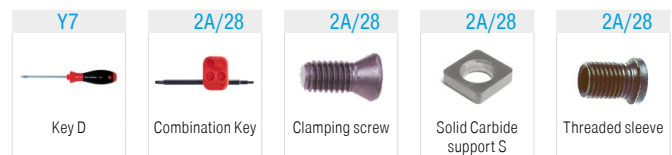


ISO designation	H mm	B mm	LF mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 669 ...	£	Article no. 70 668 ...	£
SSKC R/L 1616 H09	16	16	100	102.3	22	20	3,2	SC.. 09T3..	72.73	016	72.73	016
SSKC R/L 2020 K09	20	20	125	127.3	22	25	3,2	SC.. 09T3..	77.31	020	77.31	020
SSKC R 2020 K12	20	20	125	127.3	23	25	5	SC.. 1204..	77.31	120	77.31	120
SSKC R 2525 M12	25	25	150	153.3	23	32	5	SC.. 1204..	79.97	125	79.97	125

Spare parts

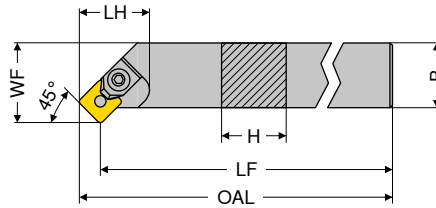
for Article no.

	£		£		£		£		£	
70 668 016 / 70 669 016	12.26	113	7.53	398	2.85	113	8.79	167	4.22	171
70 668 020 / 70 669 020	12.26	113	7.53	398	2.85	113	8.79	167	4.22	171
70 668 120	12.26	113	7.53	398	2.34	114	11.25	168	4.22	170
70 668 125	12.26	113	7.53	398	2.34	114	11.25	168	4.22	170



Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£
80 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	

MaxiLock-P – MSSC 45° – Toolholder with top clamping



Illustrations show right-hand versions



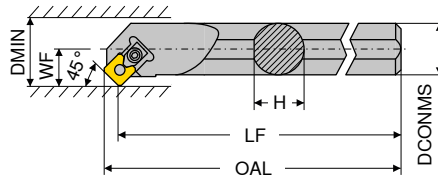
ISO designation	H mm	B mm	LF mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 589 ...	Article no. 70 588 ...	Article no. 70 589 ...	Article no. 70 588 ...
MSSC R/L 2020 K12	20	20	125	133.65	32	25	5	SCMX 1204	£ 83.97	020	£ 83.97	020
MSSC R/L 2525 M12	25	25	150	158.65	28	32	5	SCMX 1204	£ 87.03	025	£ 87.03	025
MSSC R/L 3225 P12	32	25	170	178.65	28	32	5	SCMX 1204	£ 89.70	032	£ 89.70	032

Spare parts

for Article no.		Article no. 80 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...
70 588 020 / 70 589 020	T20	£ 13.11 114	£ 3.72 153	£ 10.86 159	£ 6.81 150	£ 11.05 140
70 588 025 / 70 589 025	T20	£ 13.11 114	£ 3.72 153	£ 10.86 159	£ 6.81 150	£ 11.05 140
70 588 032 / 70 589 032	T20	£ 13.11 114	£ 3.72 153	£ 10.86 159	£ 6.81 150	£ 11.05 140



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



Illustrations show right-hand versions

ISO designation	DCONMS	H	LF	OAL	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 625 ...	£	Article no. 70 624 ...	£
S32S MSSC R/L 12	32	30	250	258	22	40	5	SCMX 1204	70 625 ...	£ 205.45	70 624 ...	£ 205.45

Spare parts

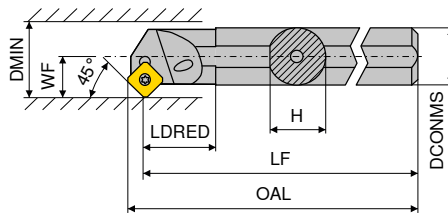
for Article no.

70 625 032 / 70 624 032

Y7	2A/28	2A/28	2A/28	2A/28
Key D	Dowel pin	Clamping Element	Wedge	Solid Carbide support S
Article no. 80 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...
£ 13.11	£ 4.57	£ 10.86	£ 6.81	£ 11.05
114	155	163	150	147

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

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



Illustrations show right-hand versions

ISO designation	DCONMS	H	LF	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
										Article no. 70 721 ...	£	Article no. 70 720 ...	£
S16R SSSC R 09	16	15.00	200	206.0	13.97	11	20	3,2	SC.. 09T3..	70 721 ...	£ 89.70	70 720 ...	£ 89.70
A16M SSSC R/L 09	16	15.25	150	156.0	29.00	11	20	3,2	SC.. 09T3..	216	89.70	216	89.70
A20Q SSSC R/L 09	20	19.00	180	186.0	32.00	13	25	3,2	SC.. 09T3..	220	111.82	220	111.82
A25R SSSC R/L 09	25	24.50	200	206.0	36.00	17	32	3,2	SC.. 09T3..	225	128.55	225	128.55
A32S SSSC R/L 12	32	31.00	250	258.3	50.00	22	40	5	SC.. 1204..	232	176.73	232	176.73
A40T SSSC R/L 12	40	39.00	300	308.1	60.00	27	50	5	SC.. 1204..	240	212.18	240	212.18

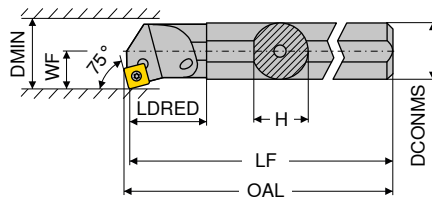
Spare parts

for Article no.

70 720 016
70 720 216 / 70 721 216
70 720 220 / 70 721 220
70 720 225 / 70 721 225
70 720 232 / 70 721 232
70 720 240 / 70 721 240

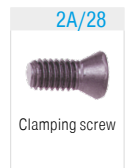
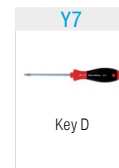
Y7	2A/28	2A/28	2A/28	2A/28
Key D	Combination Key	Clamping screw	Solid Carbide support S	Threaded sleeve
Article no. 80 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...
£ 12.26	£ 7.53	£ 2.85	£ 11.25	£ 4.22
113	398	110	168	170

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



Illustrations show right-hand versions

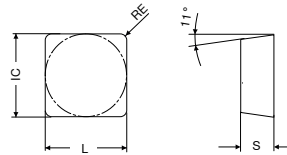
ISO designation	DCONMS	H	LF	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
										Article no. 70 725 ...	£	Article no. 70 724 ...	£
A16M SSKC R/L 09	16	15.0	150	152.4	29	11	20	3,2	SC.. 09T3..	89.70	216	89.70	216
A20Q SSKC R/L 09	20	18.5	180	182.4	32	13	25	3,2	SC.. 09T3..	111.82	220	111.82	220
A25R SSKC R/L 09	25	23.0	200	202.4	36	17	32	3,2	SC.. 09T3..	128.55	225	128.55	225



Spare parts		Article no. 80 950 ...		Article no. 70 950 ...	
for Article no.		£		£	
70 724 216 / 70 725 216	T15	12.26	113	2.85	110
70 724 220 / 70 725 220	T15	12.26	113	2.85	304
70 724 225 / 70 725 225	T15	12.26	113	2.85	304

SPMR / SPUN

Designation	L	S	IC
	mm	mm	mm
SPUN 0903..	9.52	3.18	9.52
SP.. 1203..	12.70	3.18	12.70



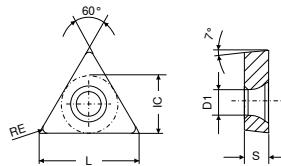
SPMR / SPUN

ISO	RE	M SPMR		M SPUN	
	mm	Article no.	Price (£)	Article no.	Price (£)
090304EN	0.4	76 208 ...	6.75	76 206 ...	
120304EN	0.4		9.79		
120308EN	0.8		9.79	718	8.17
120308ER	0.8		10.17	720	
Steel					
Stainless steel					
Cast iron					
Non ferrous metals					
Heat resistant alloys					

CTCP135	CTCP135
HCR1135	HCR1135
DRAGONSKIN	DRAGONSKIN
M	M
SPMR	SPUN
1A/11	1A/08
Article no.	Article no.
76 208 ...	76 206 ...
£	£
6.75	
704	
9.79	
9.79	8.17
716	718
718	
10.17	
720	

TCGT / TCMT

Designation	L	S	D1	IC
	mm	mm	mm	mm
TCMT 0902..	9.6	2.38	2.50	5.56
TC.T 1102..	11.0	2.38	2.80	6.35
TC.T 16T3..	16.5	3.97	4.40	9.52
TCMT 2204..	22.0	4.76	5.16	12.70



TCGT / TCMT

ISO	RE	-CF05 CTEP110		-SF TCM10		-SF CTCP125		-CF55 CTEP110		-SMF TCM10		-SMF CTCP115	
		-PF14 DCC1110		-ZF CWC10		-ZF HCX1125		-PF15 DCC1110		-SMF CWC10		-SMF HCX1115	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		F		F		F		F		F		F	
		CERMET TCGT		CERMET TCGT		TCMT		CERMET TCMT		CERMET TCMT		TCMT	
		1A/78		1A/78		1A/08		1A/78		1A/78		1A/08	
		Article no. 76 272 ...		Article no. 70 273 ...		Article no. 76 275 ...		Article no. 76 266 ...		Article no. 70 284 ...		Article no. 76 284 ...	
		£		£		£		£		£		£	
110202EN	0.2	12.31	014	11.39	900								
110204EN	0.4	12.31	016	11.39	902	6.95	516	7.02	016	6.62	902		
110208EN	0.8	12.31	018			6.95	518					6.95	318
16T304EN	0.4	15.60	028	14.45	906	10.04	528					10.04	328
16T308EN	0.8					10.04	530	9.73	030			10.04	330
Steel		●		●		●		●		●		●	
Stainless steel		○		○		○		○		○		○	
Cast iron		○		○		○		○		○		○	
Non ferrous metals													
Heat resistant alloys													

TCMT / TCGT

		-SMF CTCP135	-SM CTCP135	-SM CTCK110	-SM CTCK120	-SM CTCP115	-SM CTCP125	-SM CTCP135
		-SMF HCR1135	-ZM HCR1135	-ZM DCX3110	-ZM HCF3120	-ZM HCX1115	-ZM HCX1125	-ZM HCR1135
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F	M	M	M	M	M	M
		TCMT	TCGT	TCMT	TCMT	TCMT	TCMT	TCMT
		1A/08	1A/08	1A/08	1A/08	1A/08	1A/08	1A/08
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	£	£	£	£	£	£	£
090204EN	0.4	76 284 ...	76 270 ...	70 274 ...	70 274 ...	76 274 ...	76 274 ...	76 274 ...
						6.95 504	6.95 704	
110202EN	0.2		12.31 714					
110204EN	0.4			6.95 016	6.95 516	6.95 316	6.95 516	6.95 716
110208EN	0.8	6.95 718		6.95 018	6.95 518	6.95 318		6.95 718
16T304EN	0.4			10.04 028	10.04 528	10.04 328	10.04 528	10.04 728
16T308EN	0.8			10.04 030	10.04 530	10.04 330	10.04 530	10.04 730
16T312EN	1.2			10.04 032	10.04 532			
220408EN	0.8						14.45 542	14.45 742
Steel		●	●	●	●	●	●	●
Stainless steel		○	○	○	○	○	○	○
Cast iron				●	●	○	○	
Non ferrous metals								
Heat resistant alloys		○	○					○

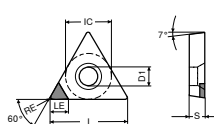
9

TCMT / TCGT

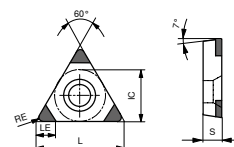
		-F43 CTC2135	-M25 CTPM125	-SM CTC2135	-M55 CTPM125	-27 H10T	-27 CWN15
		-F43 CWN2135	-PF23 HCN2125	-ZM CWN2135	-PF26 HCN2125	-AL CWK15	-AL CWN15
			DRAGONSKIN		DRAGONSKIN		
		F	F	M	F	M	M
		TCMT	TCMT	TCMT	TCMT	TCGT	TCGT
		1A/08	1A/08	1A/08	1A/08	1A/90	1A
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	£	£	£	£	£	£
090204EN	0.4	70 187 ...	75 217 ...	70 274 ...	75 218 ...	70 276 ...	70 276 ...
				6.85 398	6.95 204		
110202FN	0.2					9.92 600	12.19 300
110204EN	0.4	6.85 400	6.95 216	6.85 402	6.95 216	9.92 602	12.19 302
110204FN	0.4					9.92 604	14.45 304
16T302FN	0.2					11.69 606	14.45 306
16T304EN	0.4	9.55 402	10.04 228			11.69 608	14.45 308
16T304FN	0.4						
16T308EN	0.8	9.55 404	10.04 230	9.55 396	10.04 230		
16T308FN	0.8						
Steel		○	○	○	○		
Stainless steel		●	●	●	●		○
Cast iron						○	
Non ferrous metals						●	●
Heat resistant alloys		●		●		○	

TCGW

Designation	L	S	D1	IC
	mm	mm	mm	mm
TCGW 0902..	9.6	2.38	2.5	5.56
TCGW 1102..	11.0	2.38	2.8	6.35
TCGW 16T3..	16.5	3.97	4.4	9.52



TCGW-A



TCGW-C

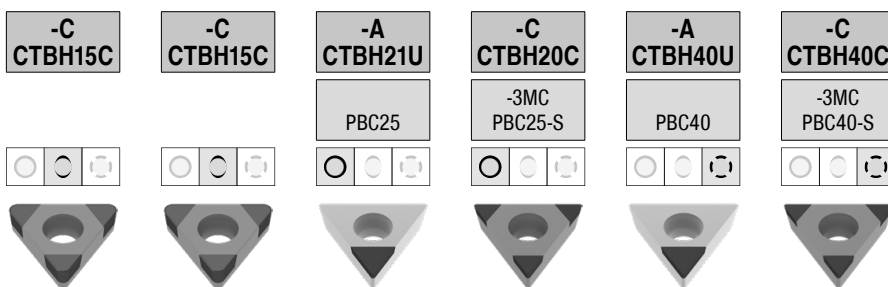
TCGW



ISO	RE	GB	BN	LE	-A CTBS10U		-C CTBS20C		-C CTBH15U		-C CTBH15U	
					PBC10	-3MC PBC15-S						
	mm	°	mm	mm	F CBN TCGW Y0	F CBN TCGW Y0	F CBN TCGW Y0	F CBN TCGW Y0	NEW Y0	NEW Y0		
					Article no. 71 140 ...	Article no. 71 164 ...	Article no. 71 028 ...	Article no. 71 029 ...				
					£	£	£	£				
090202SN	0.2	10	0.09	2.6		90.20 120						
090202SN	0.2	15	0.11	2.6		90.20 130						
090202TN	0.2	20	0.14	3.8	54.78 300							
090202TN	0.2	20	0.15	2.6		90.20 140						
090202SN	0.2	20	0.16	2.6		90.20 150						
090202EN	0.2			2.6							94.70 00200	
090204SN	0.4	10	0.09	2.2		90.20 121						
090204SN	0.4	15	0.11	2.2		90.20 131			94.70 30414			
090204TN	0.4	20	0.14	3.5	54.78 302							
090204SN	0.4	20	0.16	2.2		90.20 151						
090204TN	0.4	25	0.17	2.2		90.20 161						
090204FN	0.4			3.5	54.78 202							
090204EN	0.4			2.2		90.20 111			94.70 00400			
090208SN	0.8	10	0.09	1.8		90.20 122						
090208SN	0.8	15	0.11	1.8		90.20 132						
090208TN	0.8	20	0.15	1.8		90.20 142			94.70 30614			
090208TN	0.8	25	0.17	1.8		90.20 162						
090208EN	0.8			1.8					94.70 00600			
110202SN	0.2	10	0.09	2.9		90.20 123						
110202SN	0.2	15	0.11	2.9		90.20 133						
110202TN	0.2	20	0.14	3.8	52.75 306							
110202TN	0.2	20	0.15	2.9		90.20 143						
110202SN	0.2	20	0.16	2.9		90.20 153						
110202FN	0.2			3.8	52.75 206							
110204SN	0.4	10	0.09	2.5		90.20 124						
110204SN	0.4	15	0.11	2.5		90.20 134						
110204TN	0.4	20	0.14	3.5	52.75 308							
110204TN	0.4	20	0.15	2.5		90.20 144						
110204SN	0.4	20	0.16	2.5		90.20 154						
110204TN	0.4	25	0.17	2.5		90.20 164						
110204FN	0.4			3.5	52.75 208							
110204EN	0.4			2.5		90.20 114						
110208SN	0.8	10	0.09	2.1		90.20 125						
110208SN	0.8	15	0.11	2.1		90.20 135						
110208TN	0.8	20	0.14	3.0	52.75 310							
110208TN	0.8	20	0.15	2.1		90.20 145						
110208TN	0.8	25	0.17	2.1		90.20 165						
110208FN	0.8			3.0	52.75 210							
16T304SN	0.4	10	0.09	3.2		90.20 126						
16T304SN	0.4	15	0.11	3.2		90.20 136						
16T308SN	0.8	10	0.09	2.7		90.20 127						
16T308SN	0.8	15	0.11	2.7		90.20 137						
16T308SN	0.8	20	0.16	2.7		90.20 157						
16T308TN	0.8	25	0.17	2.7		90.20 167						
16T308EN	0.8			2.7		90.20 117						

Cast iron	•	•		
Sintered steels	•	•		
Heat resistant alloys	•	•		
hardened < 45 HRC			•	•
hardened 46–55 HRC			•	•
hardened 56–60 HRC			•	•
hardened 61–65 HRC				

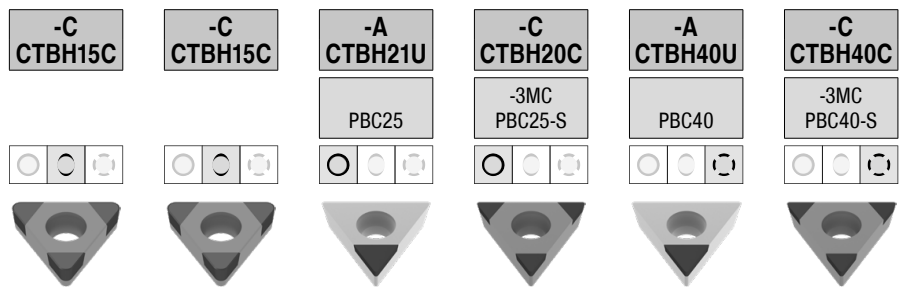
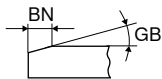
TCGW



ISO	RE mm	GB °	BN mm	LE mm	-C CTBH15C		-A CTBH21U		-C CTBH20C		-A CTBH40U		-C CTBH40C	
					NEW	YO	NEW	YO	YO	YO	YO	YO		
					Article no. 71 027 ...	Article no. 71 034 ...	Article no. 71 140 ...	Article no. 71 164 ...	Article no. 71 164 ...	Article no. 71 140 ...	Article no. 71 140 ...	Article no. 71 164 ...	Article no. 71 164 ...	Article no. 71 164 ...
					£	£	£	£	£	£	£	£	£	£
090202FN	0.2			2.6					90.20	210				
090202SN	0.2	15	0.11	2.6		92.45	30214							
090202SN	0.2	20	0.09	2.6					90.20	250			90.20	330
090202TN	0.2	20	0.09	2.6									90.20	320
090202TN	0.2	20	0.14	3.8			54.78	500						
090202TN	0.2	25	0.11	2.6									90.20	340
090202TN	0.2	25	0.12	3.8							54.78	900		
090202EN	0.2			2.6		92.45	00200		90.20	220				
090202FN	0.2			3.8			54.78	400						
090204SN	0.4	15	0.11	2.2	92.45	30414			90.20	241				
090204TN	0.4	20	0.09	2.2									90.20	321
090204TN	0.4	20	0.14	3.5			54.78	502						
090204SN	0.4	25	0.09	2.2									90.20	351
090204TN	0.4	25	0.11	2.2									90.20	341
090204TN	0.4	25	0.12	3.5							54.78	902		
090204EN	0.4			2.2	92.45	00400			90.20	221				
090204FN	0.4			3.5			54.78	402			54.78	802		
090204TN	0.4	25	0.14	2.2					90.20	261				
090204SN	0.4	25	0.15	2.2					90.20	271				
090204TN	0.4	30	0.14	2.2									90.20	361
090204SN	0.4	30	0.16	2.2									90.20	371
090208SN	0.8	10	0.09	1.8					90.20	232				
090208SN	0.8	15	0.11	1.8	92.45	30614			90.20	242				
090208SN	0.8	20	0.09	1.8					90.20	252				
090208TN	0.8	20	0.14	1.8									90.20	362
090208TN	0.8	20	0.14	3.0			54.78	504						
090208SN	0.8	25	0.09	1.8									90.20	352
090208TN	0.8	25	0.11	1.8									90.20	342
090208TN	0.8	25	0.12	3.0							54.78	904		
090208EN	0.8			1.8	92.45	00600							90.20	312
110202SN	0.2	15	0.11	2.9		92.45	31414							
110202SN	0.2	20	0.09	2.9					90.20	253			90.20	333
110202TN	0.2	20	0.09	2.9									90.20	323
110202TN	0.2	20	0.14	3.8			52.75	506						
110202TN	0.2	25	0.11	2.9									90.20	343
110202TN	0.2	25	0.12	3.8							52.75	906		
110202EN	0.2			2.9					90.20	223				
110202FN	0.2			2.9					90.20	213				
110202FN	0.2			3.8			52.75	406			52.75	806		
110202SN	0.2	25	0.13	2.9		92.45	31429							
110202TN	0.2	30	0.14	2.9									90.20	363
110204FN	0.4			2.5					90.20	214				
110204SN	0.4	10	0.09	2.5					90.20	234				
110204EN	0.4			2.5					90.20	224				

Cast iron														
Sintered steels														
Heat resistant alloys														
hardened < 45 HRC					•	•								
hardened 46–55 HRC					•	•	•	•	•	•	•	•	•	•
hardened 56–60 HRC					•	•	•	•	•	•	•	•	•	•
hardened 61–65 HRC														

TCGW

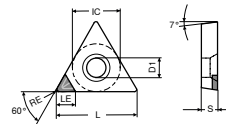


ISO	RE mm	GB °	BN mm	LE mm	-C CTBH15C		-A CTBH21U		-C CTBH20C		-A CTBH40U		-C CTBH40C	
					NEW Y0 Article no. 71 027 ... £	NEW Y0 Article no. 71 034 ... £	Y0 Article no. 71 140 ... £	Y0 Article no. 71 164 ... £	Y0 Article no. 71 140 ... £	Y0 Article no. 71 164 ... £				
110204SN	0.4	15	0.11	2.5					90.20	244				
110204TN	0.4	20	0.09	2.5									90.20	324
110204TN	0.4	20	0.14	3.5			52.75	508						
110204SN	0.4	25	0.09	2.5									90.20	354
110204TN	0.4	25	0.11	2.5									90.20	344
110204TN	0.4	25	0.12	3.5							52.75	908		
110204SN	0.4	25	0.13	2.5		92.45	31629			90.20				
110204TN	0.4	25	0.14	2.5										
110204FN	0.4			3.5							52.75	808		
110204SN	0.4	25	0.15	2.5					90.20	274				
110204TN	0.4	30	0.14	2.5									90.20	364
110204SN	0.4	30	0.16	2.5									90.20	374
110208SN	0.8	10	0.09	2.1					90.20	235				
110208SN	0.8	15	0.11	2.1	92.45	31814			90.20	245				
110208SN	0.8	20	0.09	2.1					90.20	255				
110208TN	0.8	20	0.09	2.1									90.20	325
110208TN	0.8	20	0.14	3.0			52.75	510						
110208SN	0.8	25	0.09	2.1									90.20	355
110208TN	0.8	25	0.12	3.0							52.75	910		
110208EN	0.8			2.1									90.20	315
110208SN	0.8	25	0.13	2.1	92.45	31829								
110208TN	0.8	25	0.14	2.1					90.20	265				
110208TN	0.8	30	0.14	2.1									90.20	365
110208SN	0.8	30	0.16	2.1									90.20	375
110208FN	0.8			3.0				52.75	410					
16T304SN	0.4	20	0.09	3.2					90.20	256			90.20	336
16T304SN	0.4	25	0.09	3.2									90.20	356
16T304TN	0.4	25	0.11	3.2									90.20	346
16T304SN	0.4	25	0.15	3.2					90.20	276				
16T304TN	0.4	30	0.14	3.2									90.20	366
16T304SN	0.4	35	0.17	3.2									90.20	386
16T304FN	0.4			3.2					90.20	216				
16T304EN	0.4			3.2					90.20	226				
16T308SN	0.8	15	0.11	2.7					90.20	247				
16T308SN	0.8	20	0.09	2.7									90.20	337
16T308SN	0.8	25	0.09	2.7									90.20	357
16T308TN	0.8	25	0.11	2.7									90.20	347
16T308TN	0.8	25	0.14	2.7					90.20	267				
16T308SN	0.8	25	0.15	2.7					90.20	277				
16T308TN	0.8	30	0.14	2.7									90.20	367
16T308SN	0.8	30	0.16	2.7									90.20	377
16T308SN	0.8	30	0.18	2.7					90.20	287				
16T308EN	0.8			2.7					90.20	227			90.20	317

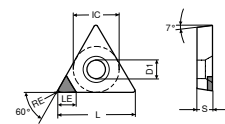
Cast iron														
Sintered steels														
Heat resistant alloys														
hardened < 45 HRC						•		•						
hardened 46–55 HRC						•		•		•		•		•
hardened 56–60 HRC						•		•		•		•		•
hardened 61–65 HRC												•		•

TCGW / TCGT

Designation	L	S	D1	IC
	mm	mm	mm	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



TCGT-A-CB



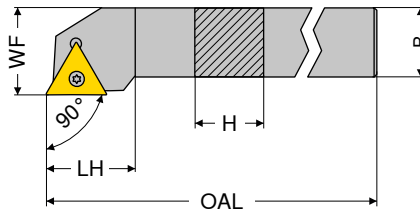
TCGW-A

TCGW / TCGT

ISO	RE	LE	-A CTDPD20		-A-CB1 CTDPD20		-A-CB2 CTDPS30		-A-CB3 CTDPU20	
			PDC	PDC	-CB1 PDC	-CB2 PDC-S	-CB3 PDC-S			
	mm	mm	F	F	M	R	F	F	M	R
			DIAMOND TCGW	DIAMOND TCGT	DIAMOND TCGT	DIAMOND TCGT	DIAMOND TCGW	DIAMOND TCGT	DIAMOND TCGT	DIAMOND TCGT
			YO	YO	YO	YO	YO	YO	YO	YO
			Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
			71 140 ...	71 325 ...	71 326 ...	71 327 ...	71 140 ...	71 325 ...	71 326 ...	71 327 ...
			£	£	£	£	£	£	£	£
090202FN	0.2	3.7	79.66	100	88.31	112		88.31	212	
090202EN	0.2	3.7								
090204FN	0.4	3.4	79.66	102	88.31	114		88.31	214	
090204EN	0.4	3.4								
090208FN	0.8	3.0	79.66	104						
110202FN	0.2	3.7	76.12	106	92.10	122		92.10	222	
110202EN	0.2	3.7								
110204FN	0.4	3.4	76.12	108	92.10	124		92.10	224	73.53
110204EN	0.4	3.4								
110208FN	0.8	3.0	76.12	110						
16T304FN	0.4	4.6	79.66	112	92.18	134		92.18	234	
16T304EN	0.4	4.6								
16T308FN	0.8	4.2	79.66	114						
16T308EN	0.8	4.2							77.85	238

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

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



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 677 ...	Article no. 70 676 ...	Article no. 70 677 ...	Article no. 70 676 ...
STGC R/L 1010 E09	10	10	70	12	12	1	TC.. 0902	£ 58.72	010	£ 58.72	010
STGC R/L 1212 F11	12	12	80	15	16	1,2	TC.. 1102	£ 58.72	012	£ 58.72	012
STGC R/L 1616 H16	16	16	100	22	20	3,2	TC.. 16T3	£ 72.73	016	£ 72.73	016
STGC R/L 2020 K16	20	20	125	22	25	3,2	TC.. 16T3	£ 77.31	020	£ 77.31	020
STGC R/L 2525 M16	25	25	150	22	32	3,2	TC.. 16T3	£ 79.97	025	£ 79.97	025

Spare parts

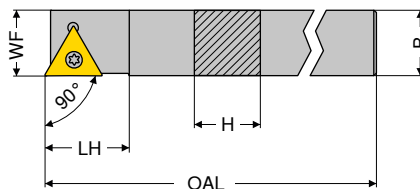
for Article no.

for Article no.	Article no. 80 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...
70 676 010 / 70 677 010	£ 10.30 109		£ 2.34 111		
70 676 012 / 70 677 012	£ 10.30 110		£ 2.15 112		
70 676 016 / 70 677 016		£ 7.53 398	£ 2.85 113	£ 7.05 169	£ 4.22 171
70 676 020 / 70 677 020		£ 7.53 398	£ 2.85 113	£ 7.05 169	£ 4.22 171
70 676 025 / 70 677 025		£ 7.53 398	£ 2.85 113	£ 7.05 169	£ 4.22 171

Y7	2A/28	2A/28	2A/28	2A/28
Key D	Combination Key	Clamping screw	Solid Carbide Seat T	Threaded sleeve
Article no. 80 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...

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

▲ for sliding head lathes



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 769 ...	Article no. 70 768 ...	Article no. 70 769 ...	Article no. 70 768 ...
STAC R/L 1010 K09	10	10	125	12	10	1	TC.. 0902	£ 58.72	010	£ 58.72	010
STAC R/L 1212 K11	12	12	125	15	12	1,2	TC.. 1102	£ 65.68	012	£ 65.68	012
STAC R 1414 K11	14	14	125	15	14	1,2	TC.. 1102			£ 65.68	014

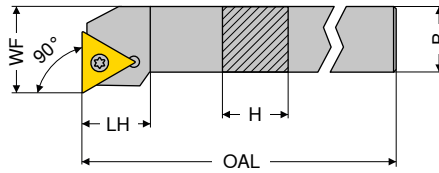
Spare parts

for Article no.

for Article no.	Article no. 80 950 ...	Article no. 70 950 ...	Article no. 70 950 ...
70 769 010 / 70 768 010	T07 £ 10.30 109	M2,2x5	£ 2.34 111
70 769 012 / 70 768 012	T08 £ 10.30 110	M2,5x6	£ 2.15 112
70 768 014	T08 £ 10.30 110	M2,5x6	£ 2.15 112

Y7	2A/28
Key D	Clamping screw
Article no. 80 950 ...	Article no. 70 950 ...

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



Illustrations show right-hand versions



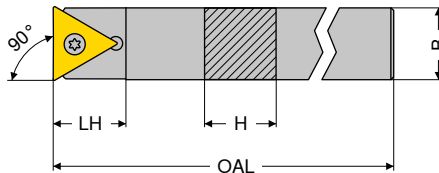
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 673 ...	£	Article no. 70 672 ...	£
STFC R/L 1212 F11	12	12	80	15	16	1,2	TC.. 1102	58.72	012	58.72	012
STFC R/L 1616 H16	16	16	100	20	20	3,2	TC.. 16T3	72.73	016	72.73	016
STFC R/L 2020 K16	20	20	125	20	25	3,2	TC.. 16T3	77.31	020	77.31	020
STFC R/L 2525 M16	25	25	150	20	32	3,2	TC.. 16T3	79.97	025	79.97	025

Spare parts

for Article no.

	Y7	2A/28	2A	2A/28	2A/28
	Article no. 80 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...	Article no. 70 950 ...
	£	£	£	£	£
70 673 012 / 70 672 012	10.30	110	2.15	112	
70 673 016 / 70 672 016		7.53	398	2.85	113
70 673 020 / 70 672 020		7.53	398	2.85	113
70 673 025 / 70 672 025		7.53	398	2.85	113

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



ISO designation	H mm	B mm	OAL mm	LH mm	torque moment Nm	Insert	Neutral 2A/24	
							Article no. 70 782 ...	£
STCC N 0808 K09	8	8	125	11	1	TC.. 0902	55.38	008
STCC N 1010 K11	10	10	125	15	1,2	TC.. 1102	58.72	010
STCC N 1212 K11	12	12	125	15	1,2	TC.. 1102	65.68	012
STCC N 1414 K11	14	14	125	21	1,2	TC.. 1102	65.68	014
STCC N 1616 K11	16	16	125	24	1,2	TC.. 1102	72.73	016

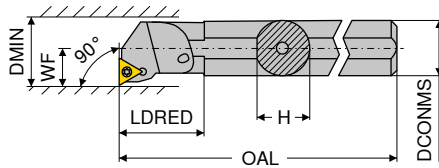
Spare parts

for Article no.

	Y7	2A/28
	Article no. 80 950 ...	Article no. 70 950 ...
	£	£
70 782 008	T07	10.30
70 782 010	T08	10.30
70 782 012	T08	10.30
70 782 014	T08	10.30
70 782 016	T08	10.30

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

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



Illustrations show right-hand versions



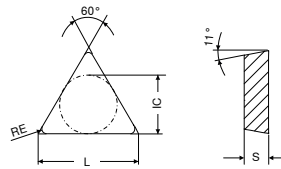
ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 729 ...	Article no. 70 728 ...	Article no. 70 729 ...	Article no. 70 728 ...
A10H STFC R/L 09	10	9.5	100	19	7	13	1	TC.. 0902	87.79	210	87.79	210
A12K STFC R/L 11	12	11.5	125	22	9	16	1,2	TC.. 1102	87.79	212	87.79	212
A16M STFC R/L 11	16	15.0	150	29	11	20	1,2	TC.. 1102	89.70	216	89.70	216
S16R STFC R 11	16	15.0	200		11	21	1,2	TC.. 1102			89.70	016
A20Q STFC R/L 11	20	18.5	180	32	13	25	1,2	TC.. 1102	111.82	220	111.82	220
S20S STFC R 11	20	18.0	250		13	25	1,2	TC.. 1102			111.82	020
A25R STFC R/L 16	25	24.0	200	36	17	32	3,2	TC.. 16T3	128.55	225	128.55	225
A32S STFC R/L 16	32	31.0	250	50	22	40	3,2	TC.. 16T3	176.73	232	176.73	232
A40T STFC R/L 16	40	39.0	300	60	27	50	3,2	TC.. 16T3	212.18	240	212.18	240

Spare parts for Article no.	2A/28 Clamping screw		2A/28 Solid Carbide Seat T		2A/28 Threaded sleeve	
	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
70 729 210 / 70 728 210	M2,2x5	2.34 111				
70 729 212 / 70 728 212	M2,5x6	2.15 112				
70 729 216 / 70 728 216	M2,5x6	2.15 112				
70 728 016	M2,5x6	2.15 112				
70 729 220 / 70 728 220	M2,5x6	2.15 112				
70 728 020	M2,5x6	2.15 112				
70 729 225 / 70 728 225	M3,5x11	2.85 113	7.05 169	M3,5	4.22 171	
70 729 232 / 70 728 232	M3,5x11	2.85 113	7.05 169	M3,5	4.22 171	
70 729 240 / 70 728 240	M3,5x11	2.85 113	7.05 169	M3,5	4.22 171	

Spare parts for Article no.	Y7 Key D		2A/28 Combination Key	
	Article no. 80 950 ...	£	Article no. 70 950 ...	£
70 729 210 / 70 728 210	T07	10.30 109		
70 729 212 / 70 728 212	T08	10.30 110		
70 729 216 / 70 728 216	T08	10.30 110		
70 728 016	T08	10.30 110		
70 729 220 / 70 728 220	T08	10.30 110		
70 728 020	T08	10.30 110		
70 729 225 / 70 728 225			T15/SW	7.53 398
70 729 232 / 70 728 232			T15/SW	7.53 398
70 729 240 / 70 728 240			T15/SW	7.53 398

TPMR / TPUN

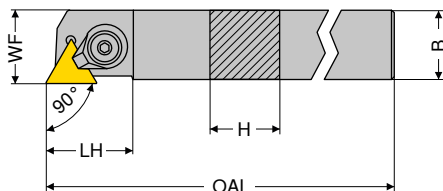
Designation	L	S	IC
	mm	mm	mm
TPMR 1103..	11.0	3.18	6.35
TPMR 1603..	16.5	3.18	9.52
TPUN 2204..	22.0	4.76	12.70



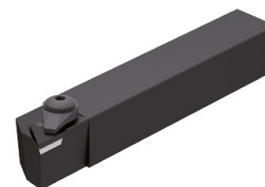
TPMR / TPUN

ISO	RE	mm	CTCK110		CTCP135		CTCP135		CTCP135	
			M	TPMR	M	TPMR	M	TPMR	M	TPUN
			Article no. 70 189 ...	Article no. 76 228 ...	Article no. 76 232 ...	Article no. 76 212 ...				
110304EL	0.4		£	£	£	£	706	702	702	
110304EN	0.4			6.47	9.44	5.15	702			
110304ER	0.4				9.44		704			
110308EN	0.8			6.47						
160304EL	0.4				12.00		714			
160304EN	0.4			8.45		6.75	706		720	
160304ER	0.4				12.00		712			
160308EL	0.8				12.00		718			
160308EN	0.8		8.45	008	8.45	6.75	708		722	
160308ER	0.8				12.00		716			
160312EN	1.2					6.75			724	
220408EN	0.8					12.09			742	
220412EN	1.2					12.09			744	
Steel			●	●	●	●				
Stainless steel			○	○	○	○				
Cast iron			●							
Non ferrous metals										
Heat resistant alloys							○	○	○	

Simplex – CTAP 90° – Toolholder with top clamping



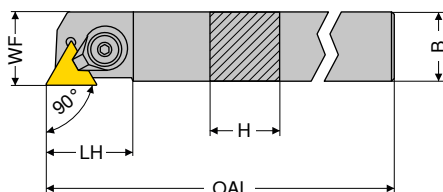
Illustrations show right-hand versions



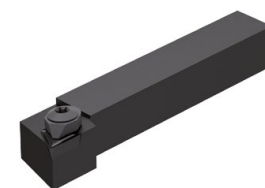
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/23		Right-hand 2A/23	
								Article no. 70 797 ...	£	Article no. 70 796 ...	£
CTAP R/L 2020 K16	20	20	125	30	20.5	10	TP.. 1603	82.07	020	82.07	020
CTAP R/L 2525 M16	25	25	150	30	20.5	10	TP.. 1603	84.36	025	84.36	025

Spare parts for Article no.	2A/28		2A/28		2A/28		2A/28		2A/28		2A/28			
	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£		
70 796 020 / 70 797 020	8.06	601	SW4	2.34	396	M8x20	4.70	604	1.00	603	9.03	602	1.00	605
70 796 025 / 70 797 025	8.06	601	SW4	2.34	396	M8x20	4.70	604	1.00	603	9.03	602	1.00	605

Simplex – CTGP 90° – Toolholder with top clamping



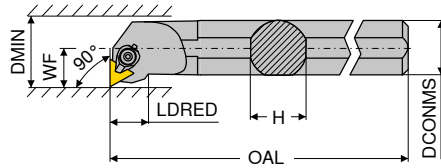
Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/23		Right-hand 2A/23	
								Article no. 70 797 ...	£	Article no. 70 796 ...	£
CTGP R 1010 E11	10	10	70	16.5	12	5	TP.. 1103	72.64	012	72.64	010
CTGP R/L 1212 F11	12	12	80	16.5	16	5	TP.. 1103	72.64	012	72.64	012

Spare parts for Article no.	2A/28		Y7		2A/28			
	Article no. 70 950 ...	£	Article no. 80 950 ...	£	Article no. 70 950 ...	£		
70 796 010	4.70	600	T15	12.26	113	M4x10	1.72	477
70 797 012 / 70 796 012	4.70	600	T15	12.26	113	M4x10	1.72	477

Simplex - CTFP 90° - Boring bar with top clamping



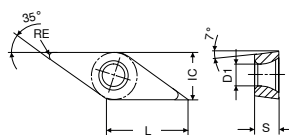
Illustrations show right-hand versions

ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/23		Right-hand 2A/23	
									Article no. 70 795 ...	£	Article no. 70 794 ...	£
S12Q CTFP R/L 11	12	11.0	180	15	9	16	5	TP.. 1103	97.27	012	97.27	012
S16R CTFP R/L 11	16	14.5	200	15	11	20	5	TP.. 1103	97.27	016	97.27	016
S20S CTFP R/L 11	20	18.0	250	15	13	25	5	TP.. 1103	118.73	020	118.73	020
S25T CTFP R/L 16	25	23.0	300	20	17	32	10	TP.. 1603	140.09	025	140.09	025
S32U CTFP R/L 16	32	30.0	350	20	22	40	10	TP.. 1603	190.00	032	190.00	032

Spare parts	2A/28		Y7		2A/28		2A/28		2A/28	
	Article no. 70 950 ...	£	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
for Article no.										
70 794 012 / 70 795 012	4.70	600	T15	12.26	113	M4x10	1.72	477		
70 794 016 / 70 795 016	4.70	600	T15	12.26	113	M4x10	1.72	477		
70 794 020 / 70 795 020	4.70	600	T15	12.26	113	M4x10	1.72	477		
70 794 025 / 70 795 025	7.93	606	T20	13.11	114	M6x16,2	4.70	596	1.00	603
70 794 032 / 70 795 032	7.93	606	T20	13.11	114	M6x16,2	4.70	596	1.00	603

VCGT / VCMT / VCXT / VCET

Designation	L	S	D1	IC
	mm	mm	mm	mm
VCET 1103..	11.1	3.18	2.8	6.35
VC.T 1103..	11.1	3.18	2.9	6.35
VC.T 1604..	16.6	4.76	4.4	9.52
VCGT 2205..	22.1	5.56	5.5	12.70



VCGT / VCMT

		-CF05 CTEP110	-SF TCM407	-SF TCM10	-SF CTCP115	-SF CTCP125	-SF CTCP135	-SF CTCP115
		-PF14 DCC1110	-ZF CWC407	-ZF CWC10	-ZF HCX1115	-ZF HCX1125	-ZF HCR1135	-ZF HCX1115
		DRAGONSKIN			DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F	F	F	F	F	F	F
		CERMET VCGT	CERMET VCGT	CERMET VCGT	VCGT	VCGT	VCGT	VCMT
		1A/78	1A/78	1A/78	1A/08	1A/08	1A/08	1A/08
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	76 276 ...	70 277 ...	70 277 ...	76 277 ...	76 277 ...	76 277 ...	76 279 ...
		£	£	£	£	£	£	£
110301EN	0.1			13.94 892				
110302EN	0.2	15.27 014	13.94 844	13.94 894	14.55 314	14.55 514	14.55 714	
110304EN	0.4	15.27 016	13.94 846	13.94 896	14.55 316	14.55 516	14.55 716	
110308EN	0.8				14.55 318	14.55 518	14.55 718	
160404EN	0.4	18.21 028	17.60 850	17.60 900				14.55 328
160408EN	0.8	18.21 030		17.60 902				14.55 330
Steel		●	●	●	●	●	●	●
Stainless steel		○			○	○	○	○
Cast iron		○	○	○	○	○	○	○
Non ferrous metals								
Heat resistant alloys							○	

VCMT / VCGT

		-SF CTCP125	-SF CTCP135	-CF55 CTEP110	-SMF TCM10	-SMF CTCP135	-SMF CTCP115	-SMF CTCP125
		-ZF HCX1125	-ZF HCR1135	-PF15 DCC1110	-SMF CWC10	-SMF HCR1135	-SMF HCX1115	-SMF HCX1125
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F	F	F	F	F	F	F
		VCMT	VCMT	CERMET VCMT	CERMET VCMT	VCGT	VCMT	VCMT
		1A/08	1A/08	1A/78	1A/78	1A/08	1A/08	1A/08
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	76 279 ...	76 279 ...	76 292 ...	70 288 ...	76 285 ...	76 288 ...	76 288 ...
		£	£	£	£	£	£	£
110302EN	0.2					14.55 714		
110304EN	0.4			11.85 016	11.19 896		12.51 316	12.51 516
160404EN	0.4	14.55 528	14.55 728	14.55 028	13.85 900		14.55 328	14.55 528
160408EN	0.8	14.55 530		14.55 030	13.85 902		14.55 330	14.55 530
Steel		●	●	●	●	●	●	●
Stainless steel		○	○	○	○	○	○	○
Cast iron		○		○	○		○	○
Non ferrous metals								
Heat resistant alloys			○				○	

VCMT / VCGT

		-SMF CTCP135	-SM CTCK110	-SM CTCK120	-SM CTCP115	-SM CTCP125	-SM CTCP135	-SF CTC2135
		-SMF HCR1135	-ZM DCX3110	-ZM HCF3120	-ZM HCX1115	-ZM HCX1125	-ZM HCR1135	-ZF CWN2135
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	
		F	M	M	M	M	M	F
		VCMT	VCMT	VCMT	VCMT	VCMT	VCMT	VCGT
		1A/08	1A/08	1A/08	1A/08	1A/08	1A/08	1A/08
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	76 288 ...	70 278 ...	70 278 ...	76 278 ...	76 278 ...	76 278 ...	70 277 ...
		£	£	£	£	£	£	£
110302EN	0.2							14.55 444
110304EN	0.4	12.51 716						14.55 446
160404EN	0.4	14.55 728	14.55 028	14.55 528	14.55 328	14.55 528	14.55 728	
160406EN	0.6				14.55 329			
160408EN	0.8	14.55 730	14.55 030	14.55 530	14.55 330	14.55 530	14.55 730	
160412EN	1.2		14.55 032	14.55 532	14.55 33200	14.55 53200	14.55 732	
Steel		●	●	●	●	●	●	○
Stainless steel		○	○		○	○	○	●
Cast iron			●	●	○	○		
Non ferrous metals								
Heat resistant alloys		○					○	●

VCMT / VCXT / VCGT

		-SF CTC2135	-M81 CWN2120	-M25 CTPM125	-SM CTC2135	-M55 CTPM125	-25P H210T	-25P AMZ
		-ZF CWN2135		-PF23 HCN2125	-ZM CWN2135	-PF26 HCN2125	-25P CWK20	-25P AMZ
				DRAGONSKIN		DRAGONSKIN		
		F	M	F	M	F	F	F
		VCMT	VCXT	VCMT	VCMT	VCMT	VCGT	VCGT
		1A/08	1A	1A/08	1A/08	1A/08	1A/90	1A/90
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	70 279 ...	70 280 ...	75 219 ...	70 278 ...	75 220 ...	70 282 ...	70 282 ...
		£	£	£	£	£	£	£
110302FN	0.2						13.73 638	15.76 538
110304FN	0.4						13.73 640	15.76 540
160404EN	0.4	14.55 440		14.55 228	14.55 440	14.55 228		
160404FN	0.4		13.86 112				16.78 642	19.54 562
160408EN	0.8				14.55 442	14.55 230		
160408FN	0.8		13.86 114				16.78 644	19.54 564
160412FN	1.2						16.78 646	19.54 566
220530FN	3.0						22.68 648	26.04 568
Steel		○		○	○	○		○
Stainless steel		●	●	●	●	●		○
Cast iron							○	○
Non ferrous metals			○				●	●
Heat resistant alloys		●			●		○	

VCGT / VCMT

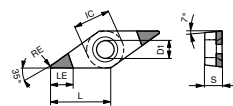
		-25Q H210T	-25Q AMZ	-27 H10T	-27 CWN15	-27 AMZ	-29 H216T	-29 AMZ
		-25Q CWK20	-25Q AMZ	-AL CWK15	-AL CWN15	-AL AMZ		
		M	M	M	M	M	M	M
		VCGT	VCGT	VCGT	VCGT	VCGT	VCMT	VCMT
		1A/90	1A	1A/90	1A	1A/90	NEW 1A/90	NEW 1A/90
ISO	RE	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.	Article no.
	mm	70 282 ...	70 282 ...	70 280 ...	70 280 ...	70 280 ...	70 247 ...	70 247 ...
		£	£	£	£	£	£	£
110302FN	0.2			13.11 606	15.43 306	15.36 456		
110304FL	0.4	15.27 670	18.58 620	13.11 608	15.43 308	15.36 458		
110304FN	0.4			13.11 610	15.43 310			
110304FR	0.4	15.27 680	18.58 630					
110308FN	0.8							
160404EN	0.4			15.97 612	18.18 312	18.62 462	12.31 62800	14.75 42800
160404FN	0.4							
160408EN	0.8			15.97 614	18.18 314	18.62 464	12.31 63000	14.75 43000
160408FN	0.8							
160412EN	1.2			15.97 616	18.18 316		12.31 63200	14.75 43200
160412FN	1.2							
220530FN	3.0			21.67 618				
Steel			○			○		○
Stainless steel			○		○	○		○
Cast iron		○	○	○	○	○	○	○
Non ferrous metals		●	●	●	●	●	●	●
Heat resistant alloys		○		○			○	

VCET / VCGT

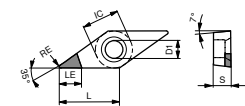
		-F05 CTPX710	-F23 CTP2120
			-F23 CCN2120
		F	F
		VCET	VCMT
		NEW 1H/17	1A/08
ISO	RE	Article no.	Article no.
	mm	76 255 ...	70 193 ...
		£	£
110300FN	0.00		14.55 600
1103015FN	0.15	21.17 11800	
110301FN	0.10	21.17 11600	14.55 602
113005FN	0.05	21.17 11400	
11302FN	0.20	21.17 12000	
11304FN	0.40	21.17 12200	
160401FN	0.10		18.62 606
Steel			●
Stainless steel			●
Cast iron			○
Non ferrous metals			○
Heat resistant alloys			●

VCGW

Designation	L	S	D1	IC
	mm	mm	mm	mm
VCGW 1103..	11.1	3.18	2.9	6.35
VCGW 1604..	16.6	4.76	4.4	9.52

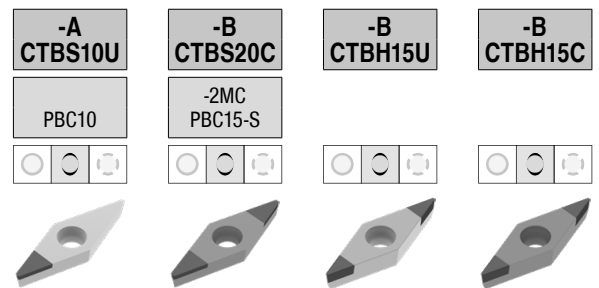


-B (-2MC)



-A

VCGW



F
CBN
VCGW

ISO	RE	GB	BN	LE	-A CTBS10U		-B CTBS20C		-B CTBH15U		-B CTBH15C	
					PBC10	-2MC PBC15-S	PBC10	-2MC PBC15-S	PBC10	-2MC PBC15-S	PBC10	-2MC PBC15-S
	mm	°	mm	mm	YO	YO	NEW YO	NEW YO	YO	YO	YO	YO
					Article no. 71 160 ...	Article no. 71 165 ...	Article no. 71 036 ...	Article no. 71 035 ...				
					£	£	£	£				
110302SN	0.2	15	0.11	3.4								
110302TN	0.2	20	0.14	4.7	69.43							
110302SN	0.2	25	0.13	3.4			82.40	32029	79.70	32029		
110302FN	0.2			4.7	69.43							
110302EN	0.2			3.4			82.40	02000	79.70	02000		
110304SN	0.4	10	0.09	3.1		73.32						
110304SN	0.4	15	0.11	3.1		73.32			82.40	32214	79.70	32214
110304TN	0.4	20	0.14	4.5	69.43							
110304TN	0.4	20	0.15	3.1		73.32						
110304SN	0.4	20	0.16	3.1		73.32						
110304SN	0.4	25	0.13	3.1					79.70	32229		
110304SN	0.4	25	0.18	3.1		73.32						
110304FN	0.4			4.5	69.43							
110304EN	0.4			3.1			82.40	02200	79.70	02200		
110308SN	0.8	10	0.09	2.5		73.32						
110308SN	0.8	15	0.11	2.5		73.32			82.40	32414	79.70	32414
110308TN	0.8	20	0.14	4.2	69.43							
110308SN	0.8	20	0.16	2.5		73.32						
110308SN	0.8	25	0.13	3.1					82.40	32229		
110308SN	0.8	25	0.13	2.5					82.40	32429	79.70	32429
110308TN	0.8	25	0.17	2.5		73.32						
110308SN	0.8	25	0.18	2.5		73.32						
110308FN	0.8			4.2	69.43							
110308EN	0.8			2.5		73.32			82.40	02400	79.70	02400
160402SN	0.2	15	0.11	3.4					82.40	33614	79.70	33614
160402TN	0.2	20	0.14	5.3	69.43							
160404SN	0.2	25	0.13	3.4					82.40	33629		
160402RN	0.2			3.4							79.70	23600
160402FN	0.2			5.3	69.43							
160402SN	0.2	25	0.13	3.4							79.70	33629
160404SN	0.4	10	0.09	3.1		73.32						
160404SN	0.4	15	0.11	3.1		73.32			82.40	33814	79.70	33814
160404TN	0.4	20	0.14	5.0	69.43							
160404TN	0.4	20	0.15	3.1		73.32						
160404SN	0.4	20	0.16	3.1		73.32						
160404RN	0.4			3.4					82.40	23600		
160404SN	0.4	25	0.13	3.1					82.40	33829	79.70	33829
160404SN	0.4	25	0.18	3.1		73.32						
160404FN	0.4			5.0	69.43							
160404RN	0.4			3.1					82.40	23800	79.70	23800

Cast iron	•	•
Sintered steels	•	•
Heat resistant alloys	•	•
hardened < 45 HRC		•
hardened 46–55 HRC		•
hardened 56–60 HRC		•
hardened 61–65 HRC		•

VCGW



-A CTBS10U	-B CTBS20C	-B CTBH15U	-B CTBH15C
PBC10	-2MC PBC15-S		
F CBN VCGW	F CBN VCGW	F CBN VCGW	F CBN VCGW
YO	YO	NEW YO	NEW YO
Article no. 71 160 ...	Article no. 71 165 ...	Article no. 71 036 ...	Article no. 71 035 ...
£	£	£	£

ISO	RE mm	GB °	BN mm	LE mm				
160408SN	0.8	10	0.09	2.5				
160408SN	0.8	15	0.11	2.5				
160408TN	0.8	20	0.14	4.4	69.43	308	73.32 126	79.70 34014
160408SN	0.8	20	0.16	2.5				
160408SN	0.8	25	0.13	2.5				
160408TN	0.8	25	0.17	2.5			73.32 166	79.70 34029
160408SN	0.8	25	0.18	2.5			73.32 176	
160408EN	0.8			2.5			73.32 116	
160408FN	0.8			4.4	69.43	208		
160408RN	0.8			2.5			82.40 24000	79.70 24000

Cast iron	•	•		
Sintered steels	•	•		
Heat resistant alloys	•	•		
hardened < 45 HRC				•
hardened 46–55 HRC				•
hardened 56–60 HRC				•
hardened 61–65 HRC				•

VCGW



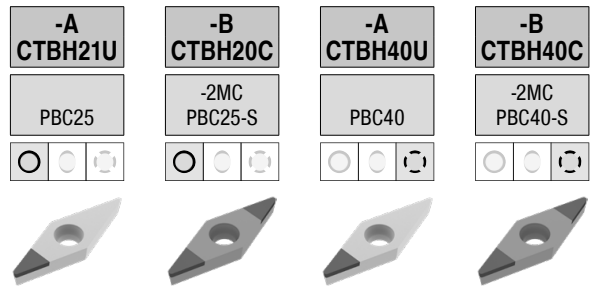
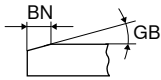
-A CTBH21U	-B CTBH20C	-A CTBH40U	-B CTBH40C
PBC25	-2MC PBC25-S	PBC40	-2MC PBC40-S
F CBN VCGW	F CBN VCGW	F CBN VCGW	F CBN VCGW
YO	YO	YO	YO
Article no. 71 160 ...	Article no. 71 165 ...	Article no. 71 160 ...	Article no. 71 165 ...
£	£	£	£

ISO	RE mm	GB °	BN mm	LE mm				
110302TN	0.2	20	0.14	4.7	69.43	500		
110302TN	0.2	25	0.12	4.7			69.43 900	
110302FN	0.2			4.7	69.43	400 ¹⁾	69.43 800	
110304FN	0.4			4.5	69.43	402 ¹⁾	69.43 802	
110304SN	0.4	20	0.09	3.1				73.32 331
110304TN	0.4	20	0.14	4.5	69.43	502	73.32 251	
110304SN	0.4	25	0.09	3.1				73.32 351
110304TN	0.4	25	0.11	3.1				73.32 341
110304TN	0.4	25	0.12	4.5			69.43 902	

Cast iron				
Sintered steels				
Heat resistant alloys				
hardened < 45 HRC				
hardened 46–55 HRC	•	•	•	•
hardened 56–60 HRC	•	•	•	•
hardened 61–65 HRC				

1) Machining to 60 HRC

VCGW



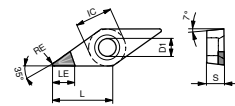
ISO	RE mm	GB °	BN mm	LE mm	-A CTBH21U		-B CTBH20C		-A CTBH40U		-B CTBH40C	
					PBC25	-2MC PBC25-S	PBC40	-2MC PBC40-S				
					F CBN VCGW YO	F CBN VCGW YO	F CBN VCGW YO	F CBN VCGW YO				
					Article no. 71 160 ...	Article no. 71 165 ...	Article no. 71 160 ...	Article no. 71 165 ...				
					£	£	£	£				
110304EN	0.4			3.1								
110304FN	0.4			3.1								
110304TN	0.4	25	0.14	3.1								
110304SN	0.4	25	0.15	3.1								
110304TN	0.4	30	0.14	3.1							73.32	361
110304SN	0.4	35	0.17	3.1							73.32	381
110308FN	0.8			4.2	69.43	404 ¹⁾			69.43	804		
110308SN	0.8	15	0.11	2.5				73.32	242			
110308SN	0.8	20	0.09	2.5				73.32	252			
110308TN	0.8	20	0.14	4.2	69.43	504					73.32	332
110308SN	0.8	25	0.09	2.5							73.32	352
110308TN	0.8	25	0.11	2.5							73.32	342
110308TN	0.8	25	0.14	2.5				73.32	262			
110308SN	0.8	25	0.15	2.5				73.32	272			
110308TN	0.8	30	0.14	2.5							73.32	362
110308SN	0.8	30	0.16	2.5							73.32	372
110308SN	0.8	30	0.18	2.5				73.32	282			
110308SN	0.8	35	0.17	2.5							73.32	382
110308EN	0.8			2.5				73.32	222		73.32	312
160402FN	0.2			5.3	69.43	405 ¹⁾			69.43	805		
160402TN	0.2	20	0.14	5.3	69.43	505				69.43	905	
160402TN	0.2	25	0.12	5.3								
160404FN	0.4			5.0	69.43	406 ¹⁾			69.43	806		
160404SN	0.4	20	0.09	3.1				73.32	255		73.32	335
160404TN	0.4	20	0.14	5.0	69.43	506						
160404SN	0.4	25	0.09	3.1							73.32	355
160404TN	0.4	25	0.11	3.1							73.32	345
160404TN	0.4	25	0.12	5.0				69.43	906			
160404FN	0.4			3.1				73.32	215			
160404EN	0.4			3.1				73.32	225			
160404TN	0.4	25	0.14	3.1				73.32	265			
160404TN	0.4	30	0.14	3.1							73.32	365
160404SN	0.4	35	0.17	3.1							73.32	385
160408FN	0.8			4.4	69.43	408 ¹⁾			69.43	808		
160408SN	0.8	15	0.11	2.5				73.32	246			
160408SN	0.8	20	0.09	2.5				73.32	256		73.32	336
160408TN	0.8	20	0.14	4.4	69.43	508						
160408SN	0.8	25	0.09	2.5							73.32	356
160408TN	0.8	25	0.11	2.5							73.32	346
160408TN	0.8	25	0.12	4.4								
160408TN	0.8	25	0.14	2.5				73.32	266	69.43	908	
160408SN	0.8	25	0.15	2.5				73.32	276			
160408TN	0.8	30	0.14	2.5							73.32	366
160408SN	0.8	30	0.16	2.5							73.32	376
160408SN	0.8	30	0.18	2.5				73.32	286			
160408SN	0.8	35	0.17	2.5							73.32	386
160408EN	0.8			2.5				73.32	226		73.32	316
160412TN	1.2	20	0.14	3.9	69.43	510						

Cast iron				
Sintered steels				
Heat resistant alloys				
hardened < 45 HRC				
hardened 46-55 HRC				
hardened 56-60 HRC	•	•	•	•
hardened 61-65 HRC	•	•	•	•

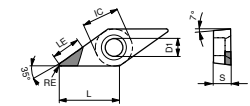
1) Machining to 60 HRC

VCGW / VCGT

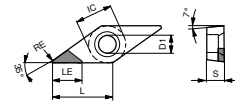
Designation	L	S	D1	IC
	mm	mm	mm	mm
VCG. 1103..	11.1	3.18	2.9	6.35
VCG. 1604..	16.6	4.76	4.4	9.52



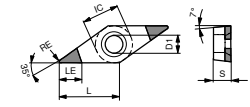
VCGT -A



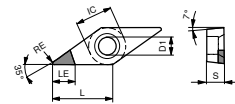
VCGT-L



VCGT-R



-B (-2MC)



VCGW -A

VCGW / VCGT

ISO	RE	LE	-A CTDMD05		-A CTDPD20		-A CTDPD20		-A CTDPD20		-A CTDPD20	
			MDC	PDC	PDC	PDC	PDC	PDC				
	mm	mm	YO	YO	YO	YO	YO	YO	YO	YO	YO	
Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£	
110302FN	0.2	3.0	420.55	050	88.03	100	91.24	100				
110302FN	0.2	4.6			88.03	102	91.24	102				
110304FN	0.4	3.0	420.55	052								
110304FN	0.4	3.9			88.03	102	91.24	102				
110304FRR	0.4	6.5						116.66	102			
110304FLL	0.4	6.5								116.66	102	
110308FN	0.8	3.3			91.24	104	91.24	104				
110308FRR	0.8	6.0						116.66	104			
110308FLL	0.8	6.0								116.66	104	
160402FN	0.2	5.9			92.93	105	99.80	105				
160404FN	0.4	5.5			94.78	106	99.80	106				
160404FRR	0.4	7.5						125.23	106			
160404FLL	0.4	7.5								125.23	106	
160408FN	0.8	5.0			99.80	108	99.80	108				
160408FRR	0.8	7.0						125.23	108			
160408FLL	0.8	7.0								125.23	108	
160412FN	1.2	4.5			108.09	110	114.91	110				
160412FRR	1.2	7.0						133.51	110			
160412FLL	1.2	7.0								133.51	110	

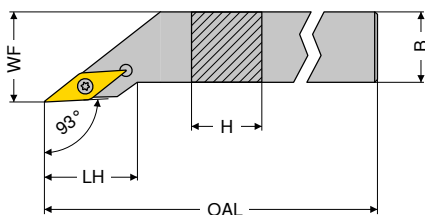
Steel	
Stainless steel	
Cast iron	
Non ferrous metals	•
Heat resistant alloys	○

VCGT

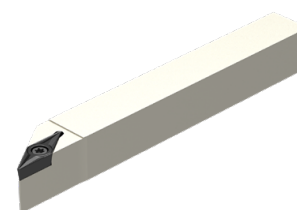
ISO	RE mm	LE mm	-A-CB1 CTDPD20		-A-CB1 CTDPS30		-A-CB2 CTDPS30		-A-CB3 CTDPU20		-A-CB1 CTDCD10		-A-CB2 CTDCD10	
			Article no. 71 330 ... £	Article no. 71 330 ... £	Article no. 71 331 ... £	Article no. 71 332 ... £	Article no. 71 330 ... £	Article no. 71 331 ... £	Article no. 71 330 ... £	Article no. 71 331 ... £				
110302FN	0.2	3.0												
110302EN	0.2	3.0												
110302EN	0.2	4.6												
110302FN	0.2	4.6	119.32											
110304FN	0.4	3.0												
110304EN	0.4	3.0												
110304EN	0.4	3.9												
110304FN	0.4	3.9	119.32	119.32										
160404EN	0.4	3.0												
160404EN	0.4	5.5												
160404FN	0.4	5.5	129.68	129.68										
160408EN	0.8	3.0												
160408EN	0.8	5.0												
160408FN	0.8	5.0	142.80	142.80										
160412EN	1.2	4.5												

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

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



Illustrations show right-hand versions

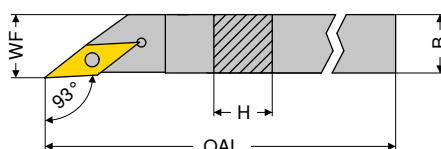


ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 697 ...	£	Article no. 70 696 ...	£
SVJC R/L 1212 F11	12	12	80	21.5	16	1,2	VC.. 1103	72.06	012	72.06	012
SVJC R/L 1616 H11	16	16	100	21.5	20	1,2	VC.. 1103	79.97	016	79.97	016
SVJC R/L 2020 K11	20	20	125	23.0	25	1,2	VC.. 1103	91.73	020	91.73	020
SVJC R/L 2525 M11	25	25	150	25.5	32	1,2	VC.. 1103	98.36	025	98.36	025
SVJC R/L 2020 K16	20	20	125	29.5	25	3,2	VC.. 1604	91.73	120	91.73	120
SVJC R/L 2525 M16	25	25	150	32.5	32	3,2	VC.. 1604	98.36	125	98.36	125
SVJC R/L 3225 P16	32	25	170	32.5	32	3,2	VC.. 1604	106.09	132	106.09	132

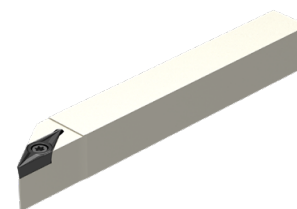
i Tool holders with HSK-T interface can be found in → **Chapter 16.**

Spare parts	Y7		2A/28		2A		2A/28		2A/28	
	Article no.	£	Article no.	£	Article no.	£	Article no.	£	Article no.	£
Key D	80 950 ...	10.30	70 950 ...	7.53	70 950 ...	2.15	70 950 ...	9.15	70 950 ...	4.22
Combination Key				398						
Clamping screw						112				
Solid Carbide Seat V						113				
Threaded sleeve										171

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



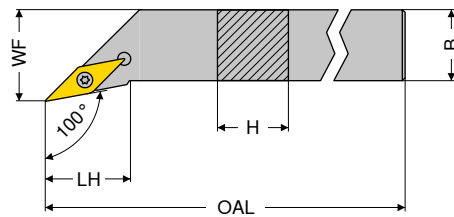
Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	WF mm	torque moment Nm	Insert	Left-hand X0		Right-hand X0	
							Article no. 70 697 ...	£	Article no. 70 696 ...	£
SVJC R/L 0808 H11	8	8	100	8	1,2	VC.. 1103	182.23	008	182.23	008
SVJC R/L 1010 H11	10	10	100	10	1,2	VC.. 1103	182.23	010	182.23	010
SVJC R/L 1212 H11	12	12	100	12	1,2	VC.. 1103	216.67	112	216.67	112
SVJC R/L 1616 K11	16	16	125	16	1,2	VC.. 1103	227.24	116	227.24	116

Spare parts	Y7		2A	
	Article no.	£	Article no.	£
Key D	80 950 ...	10.30	70 950 ...	2.15
Clamping screw				112

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



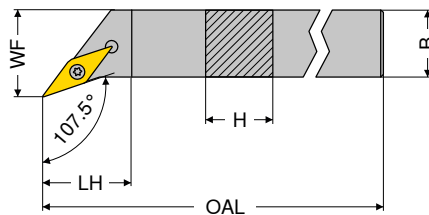
Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 701 ...	£	Article no. 70 700 ...	£
SVZC R/L 2525 M16	25	25	150	28.5	32	3,2	VC.. 1604	98.36	025	98.36	025

Spare parts for Article no.	2A/28 Combination Key		2A/28 Clamping screw		2A/28 Solid Carbide Seat V		2A/28 Threaded sleeve				
	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£			
70 701 025 / 70 700 025	T15/SW	7.53	398	M3,5x11	2.85	113	9.15	107	M3,5	4.22	171

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



Illustrations show right-hand versions



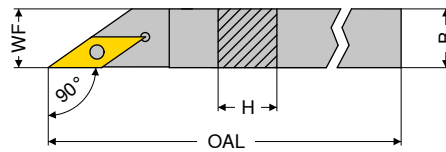
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
								Article no. 70 705 ...	£	Article no. 70 704 ...	£
SVHC R/L 1212 F11	12	12	80	11.4	16	1,2	VC.. 1103	72.06	012	72.06	012
SVHC R/L 1616 H11	16	16	100	11.4	20	1,2	VC.. 1103	79.97	016	79.97	016
SVHC R/L 2020 K11	20	20	125	14.6	25	1,2	VC.. 1103	91.73	020	91.73	020
SVHC R/L 2525 M11	25	25	150	20.9	32	1,2	VC.. 1103	98.36	025	98.36	025
SVHC R/L 2020 K16	20	20	125	13.2	25	3,2	VC.. 1604	91.73	120	91.73	120
SVHC R/L 2525 M16	25	25	150	19.6	32	3,2	VC.. 1604	98.36	125	98.36	125
SVHC R/L 3225 P16	32	25	170	19.6	32	3,2	VC.. 1604	106.09	132	106.09	132
SVHC R/L 2525 M22	25	25	150	19.6	32	5	VC.. 2205	98.36	225	98.36	225
SVHC R/L 3225 P22	32	25	170	19.6	32	5	VC.. 2205	106.09	232	106.09	232

i Tool holders with HSK-T interface can be found in → Chapter 16.

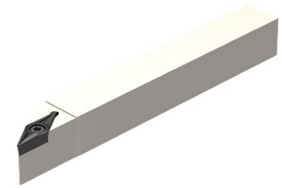
Spare parts for Article no.	Y7 Key D		2A/28 Combination Key		2A Clamping screw		2A/28 Solid Carbide Seat V		2A/28 Threaded sleeve	
	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
70 704 012 / 70 705 012	10.30	110			2.15	112				
70 704 016 / 70 705 016	10.30	110			2.15	112				
70 704 020 / 70 705 020	10.30	110			2.15	112				
70 704 025 / 70 705 025	10.30	110			2.15	112				
70 704 120 / 70 705 120			7.53	398	2.85	113	9.15	107	4.22	171
70 704 125 / 70 705 125			7.53	398	2.85	113	9.15	107	4.22	171
70 704 132 / 70 705 132			7.53	398	2.85	113	9.15	107	4.22	171
70 704 225 / 70 705 225			7.53	398	2.34	114	12.14	109	4.22	170
70 704 232 / 70 705 232			7.53	398	2.34	114	12.14	109	4.22	170

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

▲ for sliding head lathes



Illustrations show right-hand versions

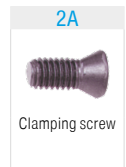
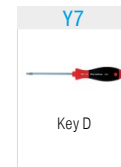


ISO designation	H mm	B mm	OAL mm	WF mm	torque moment Nm	Insert	Left-hand X0		Right-hand X0	
							Article no. 70 695 ...	£	Article no. 70 694 ...	£
SVAC R/L 0808 H11	8	8	100	8	1,2	VC.. 1103	182.23	008	182.23	008
SVAC R/L 1010 H11	10	10	100	10	1,2	VC.. 1103	182.23	010	182.23	010
SVAC R/L 1212 H11	12	12	100	12	1,2	VC.. 1103	216.67	012	216.67	012

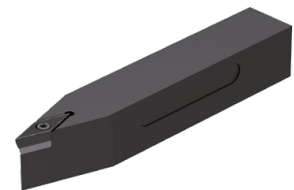
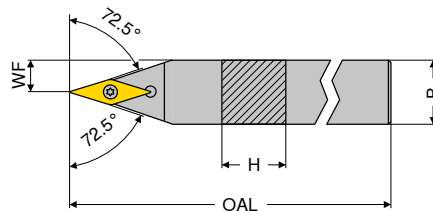
Spare parts

for Article no.

for Article no.	Article no. 80 950 ...	£	Article no. 70 950 ...	£
70 694 008 / 70 695 008	T08	10.30	110	2.15
70 694 010 / 70 695 010	T08	10.30	110	2.15
70 694 012 / 70 695 012	T08	10.30	110	2.15



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

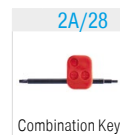
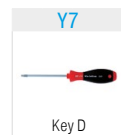


ISO designation	H mm	B mm	OAL mm	WF mm	torque moment Nm	Insert	Neutral 2A/24	
							Article no. 70 692 ...	£
SVVC N 1212 F11	12	12	80	6.0	1,2	VC.. 1103	72.06	012
SVVC N 1616 H11	16	16	100	8.0	1,2	VC.. 1103	79.97	016
SVVC N 2020 K11	20	20	125	10.0	1,2	VC.. 1103	91.73	020
SVVC N 2525 M11	25	25	150	12.5	1,2	VC.. 1103	98.36	025
SVVC N 2020 K16	20	20	125	10.0	3,2	VC.. 1604	91.73	120
SVVC N 2525 M16	25	25	150	12.5	3,2	VC.. 1604	98.36	125
SVVC N 3225 P16	32	25	170	12.5	3,2	VC.. 1604	106.09	132

Spare parts

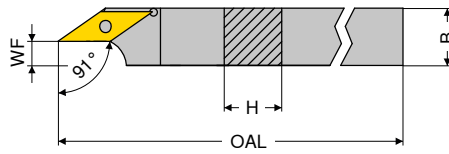
for Article no.

for Article no.	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
70 692 012		10.30	110		2.15	112				
70 692 016		10.30	110		2.15	112				
70 692 020		10.30	110		2.15	112				
70 692 025		10.30	110		2.15	112				
70 692 120				7.53	2.85	113	9.15	107	4.22	171
70 692 125				7.53	2.85	113	9.15	107	4.22	171
70 692 132				7.53	2.85	113	9.15	107	4.22	171

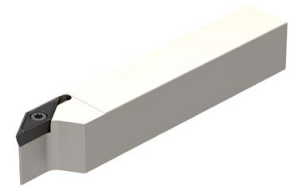


MaxiLock-S – SVXC 91° – Toolholder with screw clamping

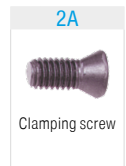
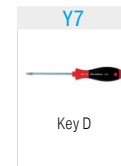
▲ for sliding head lathes



Illustrations show right-hand versions

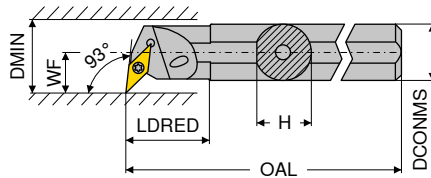


ISO designation	H mm	B mm	OAL mm	WF mm	torque moment Nm	Insert	Left-hand X0		Right-hand X0	
							Article no. 70 691 ...	£	Article no. 70 690 ...	£
SVXC R/L 1010 H11	10	10	100	3.4	1,2	VC.. 1103	182.23	010	182.23	010
SVXC R/L 1212 H11	12	12	100	5.4	1,2	VC.. 1103	216.67	012	216.67	012
SVXC R/L 1616 K11	16	16	125	8.9	1,2	VC.. 1103	227.24	016	240.60	016
SVXC R/L 2020 K16	20	20	125	10.4	3,2	VC.. 1604	261.91	020	261.91	020



Spare parts for Article no.	Article no. 80 950 ...	£	Article no. 70 950 ...	£		
					70 691 010 / 70 690 010	T08
70 691 012 / 70 690 012	T08	10.30	110	M2,5x6	2.15	112
70 691 016 / 70 690 016	T08	10.30	110	M2,5x6	2.15	112
70 691 020 / 70 690 020	T15	12.26	113	M3,5x11	2.85	113

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



Illustrations show right-hand versions



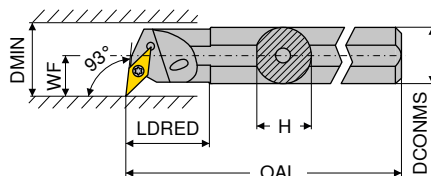
ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 745 ...	Article no. 70 744 ...	Article no. 70 745 ...	Article no. 70 744 ...
A16M SVUC R/L 11	16	15.0	150	29	11	20	1,2	VC.. 1103	£ 114.45	216	£ 114.45	216
A20Q SVUC R/L 11	20	18.5	180	32	13	25	1,2	VC.. 1103	£ 131.91	220	£ 131.91	220
A25R SVUC R/L 11	25	23.0	200	36	17	32	1,2	VC.. 1103	£ 161.64	225	£ 161.64	225
A32S SVUC R/L 16	32	30.0	250	50	22	40	3,2	VC.. 1604	£ 193.91	232	£ 193.91	232
A40T SVUC R/L 16	40	38.0	300	60	27	50	3,2	VC.. 1604	£ 225.00	240	£ 225.00	240

i Tool holders with HSK-T interface can be found in → Chapter 16.

Spare parts for Article no.	Y7		2A/28		2A		2A/28		2A/28	
	Article no. 80 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£	Article no. 70 950 ...	£
70 744 216 / 70 745 216	110	10.30			112	2.15				
70 744 220 / 70 745 220	110	10.30			112	2.15				
70 744 225 / 70 745 225	110	10.30			112	2.15				
70 744 232 / 70 745 232			398	7.53	113	2.85	107	9.15	171	4.22
70 744 240 / 70 745 240			398	7.53	113	2.85	107	9.15	171	4.22

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

▲ with carbide core



Illustrations show right-hand versions



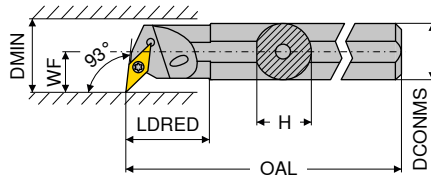
ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A		Right-hand 2A	
									Article no. 70 747 ...	Article no. 70 746 ...	Article no. 70 747 ...	Article no. 70 746 ...
E-A16M SVUC R/L 11	16	15	150	16.5	11	21	1,2	VC.. 1103	£ 296.45	216	£ 296.45	216
E-A20Q SVUC R/L 11	20	18	180	20.5	13	25	1,2	VC.. 1103	£ 422.27	220	£ 422.27	220
E-A25R SVUC R/L 11	25	23	200	25.5	17	31	1,2	VC.. 1103	£ 716.82	225	£ 716.82	225
E-A25R SVUC R/L 16	25	23	200	25.5	17	31	3,2	VC.. 1604	£ 716.82	325	£ 716.82	325
E-A32S SVUC R/L 16	32	30	250	32.5	22	39	3,2	VC.. 1604	£ 773.09	232	£ 773.09	232

Spare parts

for Article no.	Y7		2A	
	Article no. 80 950 ...	£	Article no. 70 950 ...	£
70 746 216 / 70 747 216	110	10.30	112	2.15
70 746 220 / 70 747 220	110	10.30	112	2.15
70 746 225 / 70 747 225	110	10.30	112	2.15
70 746 325 / 70 747 325	113	12.26	449	2.85
70 746 232 / 70 747 232	113	12.26	449	2.85

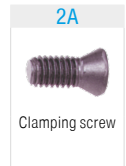
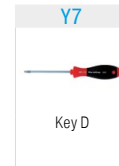
MaxiLock-S – SVUC 93° – Boring bar with screw clamping

▲ Type: Solid carbide



Illustrations show right-hand versions

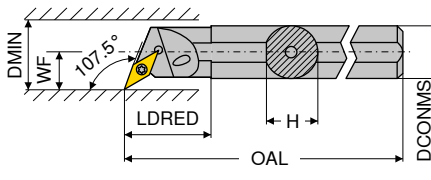
ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 747 ...	Article no. 70 746 ...	Article no. 70 747 ...	Article no. 70 746 ...
E16R SVUC R/L 11	16	15.0	200	34	11	20	1,2	VC.. 1103	£ 438.27	016	£ 438.27	016
E20S SVUC R/L 11	20	18.5	250	38	13	25	1,2	VC.. 1103	£ 519.82	020	£ 519.82	020
E25T SVUC R/L 11	25	23.0	300	43	17	32	1,2	VC.. 1103	£ 910.00	025	£ 910.00	025



Spare parts

for Article no.		Article no. 80 950 ...	Article no. 70 950 ...
70 746 016 / 70 747 016	T08	£ 10.30 110	M2,5x6 £ 2.15 112
70 746 020 / 70 747 020	T08	£ 10.30 110	M2,5x6 £ 2.15 112
70 746 025 / 70 747 025	T08	£ 10.30 110	M2,5x6 £ 2.15 112

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



Illustrations show right-hand versions

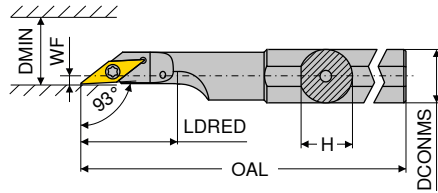
ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert	Left-hand 2A/24		Right-hand 2A/24	
									Article no. 70 749 ...	Article no. 70 748 ...	Article no. 70 749 ...	Article no. 70 748 ...
A16M SVQC R/L 11	16	15.0	150	29	11	20	1,2	VC.. 1103	£ 114.45	216	£ 114.45	216
A20Q SVQC R/L 11	20	18.5	180	32	13	25	1,2	VC.. 1103	£ 131.91	220	£ 131.91	220
A25R SVQC R/L 11	25	23.0	200	36	17	32	1,2	VC.. 1103	£ 161.64	225	£ 161.64	225
A32S SVQC R/L 16	32	30.0	250	50	22	40	3,2	VC.. 1604	£ 193.91	232	£ 193.91	232
A40T SVQC R/L 16	40	38.0	300	60	27	50	3,2	VC.. 1604	£ 225.00	240	£ 225.00	240

i Tool holders with HSK-T or PSC interface can be found in → Chapter 16.

Spare parts

for Article no.	Y7	2A/28	2A	2A/28	2A/28
70 748 216 / 70 749 216	£ 10.30 110		£ 2.15 112		
70 748 220 / 70 749 220	£ 10.30 110		£ 2.15 112		
70 748 225 / 70 749 225	£ 10.30 110		£ 2.15 112		
70 748 232 / 70 749 232		£ 7.53 398	£ 2.85 113	£ 9.15 107	£ 4.22 171
70 748 240 / 70 749 240		£ 7.53 398	£ 2.85 113	£ 9.15 107	£ 4.22 171

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



Illustrations show right-hand versions

ISO designation	DCONMS	H	OAL	LDRED	WF	DMIN	torque moment Nm	Insert
A16M SVJC R/L 11	16	15	150	30	2	22	1,2	VC.. 1103
A20M SVJC R/L 11	20	19	150	38	2	25	1,2	VC.. 1103
A25M SVJC R/L 16	25	24	150	44	2	28	3,2	VC.. 1604

Left-hand 2A		Right-hand 2A	
Article no. 70 727 ...		Article no. 70 726 ...	
£		£	
103.91	216	103.91	216
103.91	220	103.91	220
103.91	225	103.91	225

Spare parts

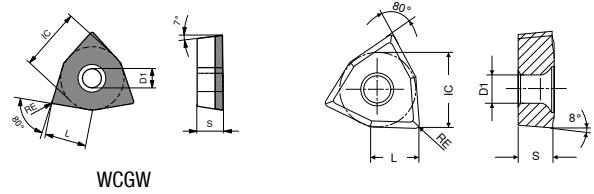
for Article no.

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

Y7		2A	
Key D		Clamping screw	
Article no. 80 950 ...		Article no. 70 950 ...	
£		£	
10.30	110	2.15	112
10.30	110	2.15	112
12.26	113	3.09	174

WCGT / WCGW

Designation	L	S	D1	IC
	mm	mm	mm	mm
WCGW 0201..	2.70	1.58	2.3	3.97
WCGT 0201..	2.71	1.59	2.1	3.97



WCGT

ISO	RE	-SF TCM10		-SF CTPP430		-SF H216T	
		-ZF CWC10		-ZF HCN2430		-ZF CWK26	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
		F		F		F	
		CERMET WCGT 1A/78		WCGT 1A/08		WCGT 1A/08	
		Article no. 70 287 ...		Article no. 70 287 ...		Article no. 70 287 ...	
		£		£		£	
020102EN	0.2	14.75	900	15.88	450	12.13	600
020104EN	0.4	14.75	902	15.88	452	12.13	602
Steel			●		●		
Stainless steel					●		
Cast iron			○		○		○
Non ferrous metals					○		●
Heat resistant alloys					●		○

WCGW



-F CTBS10U	-F CTBH15U	-F CTBH21U	-F CTBH40U
PBC10		PBC25	PBC40
F CBN WCGW Y0	F CBN WCGW Y0	F CBN WCGW Y0	F CBN WCGW Y0
Article no. 71 154 ...	Article no. 71 037 ...	Article no. 71 154 ...	Article no. 71 154 ...
£	£	£	£

ISO	RE	GB	BN	LE	Article no.	Price	Quantity	Article no.	Price	Quantity
	mm	°	mm	mm	71 154 ...	£		71 037 ...	£	
020102EN	0.2			2.7				00200		
020102SN	0.2	15	0.11	2.7			30214			
020102TN	0.2	20	0.14	2.7					200.91	500
020102TN	0.2	25	0.12	2.7					200.91	900
020102FN	0.2			2.7	200.91	200			200.91	400 ¹⁾
020104SN	0.4	15	0.11	2.7			30414			
020104TN	0.4	20	0.14	2.7					200.91	502 ¹⁾
020104FN	0.4			2.7					200.91	402 ¹⁾
020104EN	0.4			2.7			00400			
020104TN	0.4	25	0.12	2.7					200.91	902

Cast iron	•
Sintered steels	•
Heat resistant alloys	•
hardened < 45 HRC	•
hardened 46–55 HRC	•
hardened 56–60 HRC	•
hardened 61–65 HRC	•

1) Machining to 60 HRC

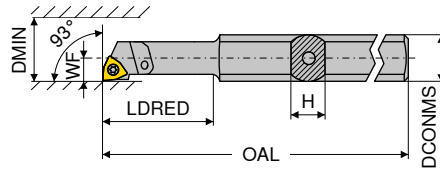
WCGW

-F CTDPD20
PDC
F DIAMOND WCGW Y0

ISO	RE	LE	Article no.	Price	Quantity
	mm	mm	71 154 ...	£	
020102FN	0.2	2.7		199.17	100
020104FN	0.4	2.7		199.17	102

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

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



Illustrations show right-hand versions



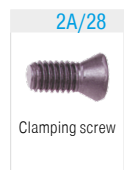
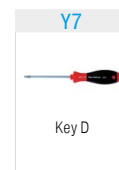
ISO designation	H mm	OAL mm	LDRED mm	WF mm	DCONMS mm	DMIN mm	torque moment Nm	Insert	Left-hand 2A		Right-hand 2A	
									Article no. 70 731 ...	£	Article no. 70 730 ...	£
A0508H SWUC R/L 02	7	100	24	2.9	8	5.8	0,4	WC.. 0201..	125.82	005	125.82	005
A0608H SWUC R/L 02	7	100	24	3.9	8	7.8	0,4	WC.. 0201..	125.82	006	125.82	006
SET							0,4	WC.. 0201..	227.82	999	227.82	999

i Set includes boring bars 70 731 005 and 70 731 006 or 70 730 005 and 70 730 006

Spare parts

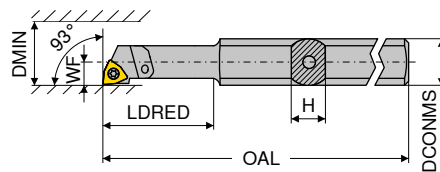
for Article no.

for Article no.		Article no. 80 950 ...	£	Article no. 70 950 ...	£
70 731 005 / 70 730 005	T06	80 950 108	11.15	M1,8x3,4	3.35 334
70 731 006 / 70 730 006	T06	80 950 108	11.15	M1,8x3,4	3.35 334



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

▲ with carbide core



Illustrations show right-hand versions



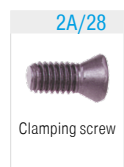
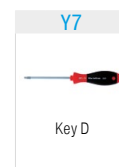
ISO designation	H mm	OAL mm	LDRED mm	WF mm	DCONMS mm	DMIN mm	torque moment Nm	Insert	Left-hand 2A		Right-hand 2A	
									Article no. 70 743 ...	£	Article no. 70 742 ...	£
E-A0508H SWUC R/L 02	7	100	24	2.9	8	5.8	0,4	WC.. 0201..	140.09	005	140.09	005
E-A0608H SWUC R/L 02	7	100	24	3.9	8	7.8	0,4	WC.. 0201..	140.09	006	140.09	006
SET							0,4	WC.. 0201..	278.36	999	278.36	999

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

Spare parts

for Article no.

for Article no.		Article no. 80 950 ...	£	Article no. 70 950 ...	£
70 743 005 / 70 742 005	T06	80 950 108	11.15	M1,8x3,4	3.35 334
70 743 006 / 70 742 006	T06	80 950 108	11.15	M1,8x3,4	3.35 334



Material examples referring to the cutting data tables

	Index	Material	Strength N/mm ² / HB / HRC	Material number	Material designation	Material number	Material designation	Material number	Material designation
P	1.1	General construction steel	< 800 N/mm ²	1.0402	EN3B				
	1.2	Free cutting steel	< 800 N/mm ²	1.0711	EN1A				
	1.3	Hardened steel, non alloyed	< 800 N/mm ²	1.0401	EN32C				
	1.4	Alloyed hardened steel	< 1000 N/mm ²	1.7325	25 CD4				
	1.5	Tempering steel, unalloyed	< 850 N/mm ²	1.5752	EN36	1.0535	EN9		
	1.6	Tempering steel, unalloyed	< 1000 N/mm ²	1.6582	EN24				
	1.7	Tempering steel, alloyed	< 800 N/mm ²	1.7225	EN19				
	1.8	Tempering steel, alloyed	< 1300 N/mm ²	1.8515	EN40B				
	1.9	Steel castings	< 850 N/mm ²	0.9650	G-X 260 Cr 27	1.6750	GS-20 NiCrMo 3.7	1.6582	GS-34 CrNiMo 6
	1.10	Nitriding steel	< 1000 N/mm ²	1.8509	EN41B				
	1.11	Nitriding steel	< 1200 N/mm ²	1.1186	EN8	1.1160	EN14A		
	1.12	Roller bearing steel	< 1200 N/mm ²	1.3505	534A99				
	1.13	Spring steel	< 1200 N/mm ²		EN45		EN47		EN43
	1.14	High-speed steel	< 1300 N/mm ²	1.3343	M2	1.3249	M34		
	1.15	Cold working tool steel	< 1300 N/mm ²	1.2379	D2	1.2311	P20		
	1.16	Hot working tool steel	< 1300 N/mm ²	1.2344	H13				
M	2.1	Cast steel and sulphured stainless steel	< 850 N/mm ²	1.4581	318				
	2.2	Stainless steel, ferritic	< 750 N/mm ²	1.4000	403				
	2.3	Stainless steel, martensitic	< 900 N/mm ²	1.4057	EN57				
	2.4	Stainless steel, ferritic / martensitic	< 1100 N/mm ²	1.4028	EN56B				
	2.5	Stainless steel, austenitic / ferritic	< 850 N/mm ²	1.4542	17-4PH				
	2.6	Stainless steel, austenitic	< 750 N/mm ²	1.4305	303	1.4401	316	1.4301	304
	2.7	Heat resistant steel	< 1100 N/mm ²	1.4876	Incoloy 800				
K	3.1	Grey cast iron with lamellar graphite	100–350 N/mm ²	0.6015	Grade 150	0.6020	Grade 220	0.6025	Grade 260
	3.2	Grey cast iron with lamellar graphite	300–500 N/mm ²	0.6030	Grade 300	0.6035	Grade 350	0.6040	Grade 400
	3.3	Gray cast iron with spheroidal graphite	300–500 N/mm ²	0.7040	SG 400-12	0.7043	SG 370-17	0.7050	SG 500-7
	3.4	Gray cast iron with spheroidal graphite	500–900 N/mm ²	0.7060	SG 600-3	0.7070	SG 700-2	0.7080	SG 800-2
	3.5	White malleable cast iron	270–450 N/mm ²	0.8035	GTW-35	0.8045	GTW-45		
	3.6	White malleable cast iron	500–650 N/mm ²	0.8055	GTW-55	0.8065	GTW-65		
	3.7	Black malleable cast iron	300–450 N/mm ²	0.8135	GTS-35	0.8145	GTS-45		
	3.8	Black malleable cast iron	500–800 N/mm ²	0.8155	GTS-55	0.8170	GTS-70		
N	4.1	Aluminium (non alloyed, low alloyed)	< 350 N/mm ²	3.0255	1050 A	3.0275	1070 A	3.0285	1080 A (A8)
	4.2	Aluminium alloys < 0.5 % Si	< 500 N/mm ²	3.1325	2017 A (AU4G)	3.4335	7005 (AZ5G)	3.4365	7075 (AZ5GU)
	4.3	Aluminium alloy 0.5–10 % Si	< 400 N/mm ²	3.2315	A-G S1	3.2373	A-S9 G	3.2151	A-S6 U4
	4.4	Aluminium alloys 10–15 % Si	< 400 N/mm ²	3.2581	A-S12	3.2583	A-S12 U		
	4.5	Aluminum alloys > 15 % Si	< 400 N/mm ²		A-S18		A-S17 U4		
	4.6	Copper (non alloyed, low alloyed)	< 350 N/mm ²	2.0040	Cu-c1	2.0060	Cu-a1	2.0090	Cu-b1
	4.7	Copper wrought alloys	< 700 N/mm ²	2.1247	Cub2 (Beryllium Copper)	2.0855	CuN2S (Nickel Copper)	2.1310	CU-Fe2P
	4.8	Special copper alloys	< 200 HB	2.0916	Cu-A5	2.1525	Cu-S3 M		Ampco 8 (Cu-A6Fe2)
	4.9	Special copper alloys	< 300 HB	2.0978	Cu-Ai11 Fe5 Ni5		Ampco 18 (Cu-A10 Fe3)		
	4.10	Special copper alloys	> 300 HB	2.1247	Cu Be2		Ampco M4		
	4.11	Short-chipping brass, bronze, red bronze	< 600 N/mm ²	2.0331	Cu Zn36 Pb1,5	2.0380	Cu Zn39 Pb2 (Ms 56)	2.0410	Cu Zn44 Pb2
	4.12	Long-chipping brass	< 600 N/mm ²	2.0335	Cu Zn 36 (Ms63)	2.1293	Cu Cr1 Zr		
	4.13	Thermoplastics			PE		PS		Plexiglas
	4.14	Duroplastics			PF		Bakelite		Pertinax
	4.15	Fibre-reinforced plastics			Carbon Fibre		Fibreglass		Aramid Fibre (Kevlar)
	4.16	Magnesium and magnesium alloys	< 850 N/mm ²	3.5812	Mg A7 Z1	3.5662	Mg A9	3.5105	Mg Tr3 Z2 Zn 1
	4.17	Graphite			R8500X		R8650		Technograph 15
	4.18	Tungsten and tungsten alloys			W-Ni Fe (Densimet)		W- Ni Cu (Inermet)		Denal
	4.19	Molybdenum and molybdenum alloys			TZM		MHO		Mo W
S	5.1	Pure nickel		2.4066	Ni99 (Nickel 200)	2.4068	Lc Ni99 (Nickel 201)		
	5.2	Nickel alloys		1.3912	Fe-Ni36 (Invar)	1.3917	Fe-Ni42 (N42)	1.3922	Fe-Ni48 (N48)
	5.3	Nickel alloys	< 850 N/mm ²	2.4375	Ni Cu30 Al (Monel K500)	2.4360	Ni Cu30Fe (Monel 400)	2.4668	
	5.4	Nickel molybdenum alloys		2.4600	Ni Mo30Cr2 (Hastelloy B4)	2.4617	Ni Mo28 (Hastelloy B2)	2.4819	Ni Mo16Cr16 Hastell. C276
	5.5	Nickel-chromium alloys	< 1300 N/mm ²	2.4951	Ni Cr20TiAl (Nimonic 80A)	2.4858	Ni Cr21Mo (Inconel 825)	2.4856	Ni Cr22Mo9Nb Inconel 625
	5.6	Cobalt Chrome Alloys	< 1300 N/mm ²	2.4964	Co Cr20 W15 Ni10		Co Cr20 Ni16 Mo7		Co Cr28 Mo 6
	5.7	Heat resistant alloys	< 1300 N/mm ²	1.4718	Z45 C S 9-3	1.4747	Z80 CSN 20-02	1.4845	Z12 CN 25-20
	5.8	Nickel-cobalt-chromium alloys	< 1400 N/mm ²	2.4851	Ni Cr23Fe (Inconel 601)	2.4668	Ni Cr19NbMo (Inconel 718)	2.4602	Ni Cr21Mo14 Hastelloy C22
	5.9	Pure titanium	< 900 N/mm ²	3.7025	T35 (Titanium Grade 1)	3.7034	T40 (Titanium Grade 2)	3.7064	T60 (Titanium Grade 4)
	5.10	Titanium alloys	< 700 N/mm ²		T-A6-Nb7 (367)		T-A5-Sn2-Mo4-Cr4 (Ti17)		T-A3-V2,5 (Gr18)
	5.11	Titanium alloys	< 1200 N/mm ²	3.7165	T-A6-V4 (Ta6V)		T-A4-3V-Mo2-Fe2 (SP700)		T-A5-Sn1-Zr1-V1-Mo (Gr32)
H	6.1		< 45 HRC						
	6.2		46–55 HRC						
	6.3	Tempered steel	56–60 HRC						
	6.4		61–65 HRC						
	6.5		65–70 HRC						

Cutting data values for fine machining (F)

Chip breaker: **-CF -F32 -CF20 -F30 -F40 // -F23 -M25 -F43 -SF -SMF -CF05 -CF55**
 Chip breaker: (-CF) (-F32) (-NF12) (-NF23) (-F40) // (-F23) (-PF23) (-F43) (-ZF) (-SMF) (-PF14) (-PF15)

	DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
	CTEP110 (DCC1110)	TCM407 (CWC407)	TCM10 (CWC10)	CTCK110 (DCX3110)	CTCK120 (HCF3120)	CTCP115 (HCX1115)	CTCP125 (HCX1125)	CTCP135 (HCR1135)	CTPM125 (HCN2125)	CTPX710 (CTPX710)	CTP2120 (CCN2120)	CTC2135 (CWN2135)
Index	v _c in m/min											
1.1	300-370	290-340	230-270	270-340	230-280	260-350	200-270	180-220	120-260	120-170		170-220
1.2	400-520	340-430	280-350	270-350	230-310	280-360	230-280	190-240	130-220	140-200		190-230
1.3	350-400	300-370	280-350	250-340	210-280	220-350	240-290	170-210	130-250	110-160		160-200
1.4	300-370	240-310	170-330	250-330	210-270	240-320	200-270	180-220	130-220	90-150		170-230
1.5	400-440	230-280	180-340	240-320	200-260	230-300	220-260	160-210	100-180	90-150		150-200
1.6	350-410	230-270	170-320	230-310	190-270	210-270	210-250	170-230	100-180	100-130		160-220
1.7	250-300	250-310	180-280	200-280	160-230	240-320	210-280	170-210	60-180	80-140		150-200
1.8	300-360	230-290	160-250	210-270	170-220	200-280	190-240	150-190	60-180	80-130		140-180
1.9	200-320			230-310	190-260	200-300	170-240	170-200	80-180	80-120		170-200
1.10	250-320	250-310	180-270	230-290	190-240	220-280	180-240	150-200	100-180	80-120		140-170
1.11	240-310	230-290	170-250	220-290	180-240	200-270	170-240	140-180	100-180	80-140		140-180
1.12	240-310	270-320	190-270	250-310	210-260	210-300	200-270	160-200	80-180	130-220		160-200
1.13				210-270	170-220	180-270	170-240	140-190	60-180	80-120		130-180
1.14				220-280	180-230	180-250	180-230	130-180	80-180	70-130		130-180
1.15	260-310	210-250	170-250	200-290	170-240	160-250	150-230	120-160	80-150	70-130		120-160
1.16	260-310	210-250	170-250	200-280	170-230	150-240	140-220	120-170	80-150	70-100		110-160
2.1	250-320			190-310		200-280	200-280	160-210	200-280	90-260	190-260	160-240
2.2	250-320			190-320		200-280	200-280	160-210	200-280	80-240	200-250	180-250
2.3	300-350			180-300		190-260	190-260	130-200	190-260	70-240	190-240	150-240
2.4	210-250			200-300		190-240	190-240	120-200	190-240	40-220	140-210	160-230
2.5								100-150	100-220	60-230	110-190	150-230
2.6	210-250							60-80	100-220	40-170	80-160	120-170
2.7	210-250							60-80	40-100	40-160	80-140	120-160
3.1	340-480			260-310	220-260	220-280	200-260			140-240	140-180	
3.2	260-360			260-330	230-280	200-270	190-250			100-190	110-170	
3.3	360-520	280-430	220-300	330-450	320-410	180-250	170-240			130-260	130-180	
3.4	300-400	250-380	180-250	350-460	340-420	180-260	140-190			100-250	160-240	
3.5	330-500	250-400	250-350	380-460	360-420	260-320	240-290			160-240	160-230	
3.6	180-320	180-320	160-250	270-370	250-330	200-320	170-290			130-200	130-190	
3.7	330-500	250-400	250-350	350-430	320-390	240-320	240-290			150-240	150-220	
3.8	180-320	180-320	160-250	260-350	240-310	210-320	170-290			140-210	140-180	
4.1										300-3200	100-600	
4.2										200-2800	100-600	
4.3										400-2000	100-400	
4.4										40-2000	100-400	
4.5										200-1200	100-400	
4.6										250-1000	100-400	
4.7										200-1000	100-400	
4.8										200-1000	100-400	
4.9										200-1000	100-400	
4.10										200-1000	100-400	
4.11										150-800		
4.12										150-500		
4.13										100-250		
4.14										80-200		
4.15										80-220		
4.16												
4.17												
4.18										80-120		
4.19										100-140		
5.1								20-40		30-140	15-30	20-40
5.2								20-40		30-110	15-40	20-40
5.3								8-25		30-110	20-35	15-35
5.4								8-25		30-110	13-30	15-35
5.5								4-15		30-110	15-35	8-25
5.6								4-15		30-110	15-35	4-15
5.7								4-15		30-110	60-100	4-15
5.8								4-12		30-110	20-40	4-15
5.9								80-130		30-140	80-140	80-130
5.10								15-35		30-140	25-45	15-35
5.11								15-35		30-120	25-45	15-35
6.1	<p>i The cutting data depends extremely on the external conditions, e.g. stability of the tool and tool clamping, material and machine type. The indicated values are possible cutting data which have to be increased or reduced according to the application conditions.</p>											
6.2												
6.3												
6.4												
6.5												

Cutting data values for medium machining (M)

Chip breaker: -M30 -M36 -M50 -M60 -M34 -M40 -42 -M42 -M52 -M70 // -M55 -SM -SMQ -M81
 Chip breaker:(-NM23) (-XU) (-NM15)(-NM26) (-M34) (-M40) (-42) (-M42) (-M52) (-NM19)// (-PF26) (-ZM) (-SMQ) (-M81)

	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN		DRAGONSKIN	DRAGONSKIN		
	CTCK110 (DCX3110)	CTCK120 (HCF3120)	CTCP115 (HCX1115)	CTCP125 (HCX1125)	CTCP135 (HCR1135)	CTPM125 (HCN2125)	CTP2120 (CCN2120)	CTC2135 (CWN2135)	CWN2120 (CWN2120)	CTP5110 (HCN5110)	CTP5115 (HCN5115)
Index	v _c in m/min										
1.1	260-330	220-270	250-340	200-260	170-210	120-250		170-210			
1.2	260-340	220-300	270-350	230-280	180-230	120-220		180-230			
1.3	230-320	190-260	220-350	240-290	160-200	120-250		150-220			
1.4	240-310	200-250	240-310	200-250	170-210	130-200		170-210			
1.5	230-310	190-250	230-300	210-250	150-200	100-170		150-200			
1.6	220-300	180-260	210-270	190-240	160-220	100-170		150-210			
1.7	190-270	150-210	240-300	200-270	160-200	50-160		150-200			
1.8	190-250	150-200	190-270	180-230	140-180	50-160		130-170			
1.9	210-290	170-240	190-280	160-220	160-190	60-160		160-190			
1.10	210-270	170-220	200-260	180-230	140-190	100-180		130-170			
1.11	210-280	170-230	180-260	170-240	130-170	80-180		130-170			
1.12	230-290	190-240	200-280	190-260	150-200	70-170		150-190			
1.13	190-260	150-210	180-250	170-230	130-180	60-170		120-180			
1.14	210-270	170-220	170-230	170-210	120-160	70-160		120-170			
1.15	180-270	150-220	150-240	130-220	110-150	60-120		100-150			
1.16	180-260	150-210	130-220	130-220	110-150	60-120		100-150			
2.1	150-270		200-280	200-280	150-210	120-280	180-240	150-230	130-200	180-260	180-260
2.2	150-260		200-280	200-280	150-200	120-280	180-230	170-250	120-220	170-240	170-240
2.3	140-250		190-260	190-260	120-200	120-260	170-220	140-220	100-160	170-220	170-220
2.4	160-260		190-240	190-240	110-190	120-240	130-210	140-210	80-180	130-220	130-220
2.5					90-150	100-220	100-180	120-210	90-140	100-170	100-170
2.6					60-80	100-220	70-140	100-140	80-150	80-150	80-150
2.7					60-80	40-100	70-110	100-140	80-120	80-150	80-150
3.1	220-280	170-240	140-240	120-210			120-170				
3.2	210-270	170-230	160-250	160-200			100-150				
3.3	300-350	260-310	150-220	150-200			120-170				
3.4	270-330	230-320	140-200	130-190			150-240				
3.5	290-370	250-330	200-260	160-230			150-220				
3.6	250-310	210-270	180-240	150-210			110-170				
3.7	290-370	250-330	180-280	160-230			140-220				
3.8	250-370	210-330	160-260	150-210			120-170				
4.1							100-600		400-2000		
4.2							100-600		400-2000		
4.3							100-400		400-2000		
4.4							100-400		200-1200		
4.5							100-400		200-1000		
4.6							100-400		250-1000		
4.7							100-400		250-1000		
4.8							100-400		250-1000		
4.9							100-400		250-1000		
4.10							100-400		250-1000		
4.11									150-800		
4.12									150-800		
4.13											
4.14											
4.15											
4.16											
4.17											
4.18											
4.19											
5.1					20-40		15-30	20-40		30-120	
5.2					20-40		15-40	20-40			30-90
5.3					8-25		20-35	15-35			30-90
5.4					8-25		13-30	15-35			30-90
5.5					4-15		15-35	8-25			30-90
5.6					4-15		15-35	4-15			30-90
5.7					4-15		60-100	4-15			30-90
5.8					4-12		20-40	4-15		30-120	
5.9					80-130	80-130	80-140	80-130		30-120	
5.10					15-35	25-45	25-45	15-35		30-120	
5.11					15-35		25-45	15-35		30-120	

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

Cutting data values for rough machining (R)

Chip breaker: .NMA -R28 -R58 -R88
Chip breaker: (.NMA) (-NR14) (-NR17) (-NR19)

Index	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
	CTCK110 (DCX3110)	CTCK120 (HCF3120)	CTCP115 (HCX1115)	CTCP125 (HCX1125)	CTCP135 (HCR1135)
	v _c in m/min				
1.1			220-320	180-240	160-200
1.2			270-350	230-280	170-220
1.3			220-350	240-290	150-190
1.4			240-310	180-250	160-200
1.5			230-300	200-240	140-190
1.6			210-270	190-240	150-210
1.7			240-300	180-260	150-190
1.8			190-270	150-210	130-170
1.9			190-280	140-200	150-180
1.10			200-260	170-220	130-180
1.11			180-260	160-220	120-160
1.12			200-280	170-240	140-190
1.13			180-250	160-230	120-170
1.14			170-230	150-190	110-150
1.15			150-240	150-210	100-140
1.16			130-220	150-190	100-140
2.1			200-280	200-280	140-200
2.2			200-280	200-280	140-190
2.3			190-260	190-260	110-190
2.4			190-240	190-240	100-180
2.5					80-150
2.6					55-75
2.7					55-75
3.1	220-280	170-240	140-220	130-180	
3.2	210-270	170-230	160-230	120-170	
3.3	300-350	260-310	150-200	130-180	
3.4	270-330	230-320	140-180	100-160	
3.5	290-370	250-330	200-240	150-200	
3.6	250-310	210-270	180-220	130-180	
3.7	290-370	250-330	180-260	150-200	
3.8	250-370	210-330	160-240	130-180	
4.1					
4.2					
4.3					
4.4					
4.5					
4.6					
4.7					
4.8					
4.9					
4.10					
4.11					
4.12					
4.13					
4.14					
4.15					
4.16					
4.17					
4.18					
4.19					
5.1					20-40
5.2					20-40
5.3					8-25
5.4					8-25
5.5					4-15
5.6					4-15
5.7					4-15
5.8					4-12
5.9					80-130
5.10					15-35
5.11					15-35
6.1					
6.2					
6.3					
6.4					
6.5					

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

Cutting data values for aluminum-chip breakers

Chip breaker: **-23P** **-25P** **-25Q** **-27** **-29**
 Chip breaker: (-23P) (-25P) (-25Q) (-AL) (-29)

	H10T (CWK15)	H210T (CWK20)	H216T (CWK26)	AMZ (AMZ)	CWN15 (CWN15)
Index	v _c in m/min				
1.1				90-140	
1.2				110-160	
1.3				90-130	
1.4				80-120	
1.5				80-120	
1.6				90-110	
1.7				90-110	
1.8				70-90	
1.9				90-110	
1.10				70-90	
1.11				70-90	
1.12				70-110	
1.13				150-200	
1.14					
1.15				70-110	
1.16				70-110	
2.1				100-150	80-140
2.2					80-140
2.3					70-120
2.4					40-60
2.5					60-100
2.6				90-140	40-60
2.7					40-60
3.1	120-160	140-200	120-160	180-220	
3.2	90-140	100-160	90-140	140-180	
3.3	130-170	160-200	130-170	160-220	
3.4	90-130	110-150	90-130	120-180	
3.5	140-200	160-220	140-200	180-240	
3.6	120-160	140-180	120-160	160-200	
3.7	140-200	160-220	140-200	180-240	
3.8	120-160	140-180	120-160	160-200	
4.1	300-2500	300-3200	300-2500	300-3200	300-3200
4.2	200-2500	400-1500	200-2000	200-2800	200-2800
4.3	400-2000	300-1000	400-1500	400-2000	400-2000
4.4	400-1800	200-500	400-1500	40-2000	40-2000
4.5	200-1000	200-500	200-800	200-1200	200-1200
4.6	150-300	150-400	150-300	250-1000	250-1000
4.7	250-600	250-800	150-400	200-1000	200-1000
4.8	150-400	250-800	150-400	200-1000	200-1000
4.9	150-400	250-800	150-400	200-1000	200-1000
4.10	150-400	250-800	150-400	200-1000	200-1000
4.11	150-300	200-800	200-600	150-800	150-800
4.12	130-350	150-400	150-400	150-500	150-500
4.13	100-200	80-320	100-200	100-250	100-250
4.14	80-180	80-320	80-180	80-200	80-200
4.15	60-150	80-200	60-150	80-220	80-220
4.16					
4.17					
4.18	60-140				
4.19		100-140	100-140		
5.1		25-40	30-45		
5.2		25-40	20-35		
5.3		25-40	20-35		
5.4		20-30	15-25		
5.5		25-40	15-25		
5.6		20-30	15-25		
5.7		20-30	15-25		
5.8		15-25	15-25		
5.9	60-120	80-140	60-120		
5.10	30-80	40-100	30-80		
5.11	30-80	40-100	30-80		
6.1					
6.2					
6.3					
6.4					
6.5					

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

Cutting data for machining non ferrous metals with carbide inserts

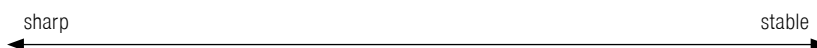
	Material group	Material examples		Machinability of aluminium alloys	Comments	Cutting speed v_c in m/min	
				*			
N	Pure aluminium	non hardenable	Al 99,5	W7	5	<ul style="list-style-type: none"> ▲ Snarl chips ▲ Possibly bad surface ▲ Excessive built-up edge ▲ Long tool life ▲ Use coolant emulsion 	300-3200
			Al 99,5	F13	4		
			Al 99	W8	5		
			Al 99	F14	4		
	Aluminium wrought alloys	non hardenable	Al Mn	W10	5	<ul style="list-style-type: none"> ▲ Snarl, continuous or fragmented chip ▲ Large feed rates necessary for good swarf control ▲ Built-up edge ▲ Long tool life ▲ Emulsion coolant is advantageous 	300-2500
			Al Mn	F16	4		
			Al Mg 1	W10	5		
			Al Mg 1	F19	4		
			Al Mg 3	W18	4		
			Al Mg 3	F25	3		
			Al Mg 5	W25	4		
			AL Mg 5	F28	2		
			Al Mg 4,5 Mn	W27	4		
		Al Mg 4,5 Mn	G35	3			
		hardenable	Al Mg Si 0,5	W	4	<ul style="list-style-type: none"> ▲ Good swarf control with higher feed rates ▲ Very good swarf control ▲ No built up edge ▲ Very good surface quality ▲ Good swarf control ▲ Good surface quality ▲ Little built-up edge 	200-2000
			Al Mg Si 0,5	F13-25	3		
			Al Mg Si 1	W	4		
			Al Mg Si 1	F21-30	3		
			Al Mg Si Pb	F20-28	2		
			Al Cu Si Pb	F28-37	1		
			Al Cu Mg Pb	F34-37	1		
			Al Cu Mg 1	W	3		
	Al Cu Mg 1		F33-40	2			
	Al Cu Mg 2	W	3				
	Al Cu Mg 2	F40-47	2				
	Al Cu Si Mn	W	3				
	Al Cu Si Mn	F43-46	2				
	Al Zn Mg Cu 1,5	F50-52	2				
	Al Sn 6 Cu		1				
	Cast Aluminium Alloys	non hardenable	G-Al Si 12		3	<ul style="list-style-type: none"> ▲ Good swarf control ▲ Built-up edge ▲ Higher Si content results in lower tool life ▲ High wear of the carbide ▲ Good swarf control ▲ Good surface quality ▲ Long tool life 	Si content < 12 % 400-1500
			G-Al Si 10 Mg		3		Si content ~ 12.5 % 300-1000
			G-Al Si 5 Mg		2		Si content > 13 % 200-500
			G-Al Si 7 Mg (9 Mg)		2		
			G-Al Si Cu 3		2		
			G-Al Si 6 Cu 4		2		
			G-Al Mg 3 (Mg 5)		2		
			G-Al Mg 9		2		
			G-Al Mg 10		2		
			G-Al Mg 3 Si (5 Si)		2		
			G-Al Cu 4 Ti (Mg)		2		
G-Al Si 12 Cu Mg Ni		2					
Copper wrought alloys		Cu Ag				300-1200	
		Cu As					
		Cu Cd					
		Cu Cd Sn					
		Cu Mg					
		Cu Mn					
	brass	Cu Zn Al					300-1000
		bronze	Cu Sn				300-800
			Cu Sn Zn				
			Cu Ni				
Cu Ni Fe							
Non metal materials	Duroplastics					80-320	
	Fibre-reinforced plastics						
	hard rubber						

* 1 = good machinability, 5 = bad machinability

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

Cutting data standard values for negative inserts

Designation	-NF12 (Cermet)						-F50 (-NF15)					
	f			a _p			f			a _p		
	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.
mm/rev.			mm			mm/rev.			mm			
CN.. 090304							0,06	0,15	0,25	0,2	0,5	1,5
CN.. 090308							0,10	0,20	0,30	0,4	1,0	2,0
CN.. 120404	0,05	0,15	0,25	0,3	0,5	1,5	0,06	0,15	0,25	0,2	0,6	1,5
CN.. 120408	0,07	0,15	0,25	0,3	0,5	1,5	0,10	0,20	0,30	0,4	1,0	2,0
CN.. 120412							0,14	0,25	0,35	0,6	1,4	2,6
CN.. 120416												
CN.. 160608												
CN.. 160612												
CN.. 160616												
CN.. 160624												
CN.. 190608												
CN.. 190612												
CN.. 190616												
CN.. 190624												
CN.. 250924												
DN.. 110402							0,04	0,10	0,20	0,1	0,4	2,3
DN.. 110404	0,05	0,15	0,25	0,3	0,5	1,5	0,06	0,15	0,25	0,2	0,6	1,5
DN.. 110408	0,07	0,15	0,25	0,3	0,5	1,5	0,10	0,20	0,30	0,4	1,0	2,0
DN.. 110412							0,14	0,25	0,35	0,6	1,4	2,6
DN.. 150404							0,06	0,15	0,25	0,2	0,6	1,5
DN.. 150408							0,10	0,20	0,30	0,4	1,0	2,0
DN.. 150412							0,14	0,25	0,35	0,6	1,4	2,6
DN.. 150416												
DN.. 150604	0,05	0,15	0,25	0,3	0,5	1,5	0,06	0,15	0,25	0,2	0,6	1,5
DN.. 150608	0,07	0,15	0,25	0,3	0,5	1,5	0,10	0,20	0,30	0,4	1,0	2,0
DN.. 150612	0,10	0,20	0,30	0,5	0,7	1,5	0,14	0,25	0,35	0,6	1,4	2,6
DN.. 150616												
SN.. 090308							0,10	0,20	0,30	0,4	1,0	2,0
SN.. 120404							0,06	0,15	0,25	0,2	0,6	1,5
SN.. 120408							0,10	0,20	0,30	0,4	1,0	2,0
SN.. 120412							0,14	0,25	0,35	0,6	1,4	2,6
SN.. 120416												
SN.. 150608												
SN.. 150612												
SN.. 150616												
SN.. 190612												
SN.. 190616												
SN.. 190624												
SN.. 250724												
SN.. 250924												
TN.. 110304							0,06	0,15	0,25	0,2	0,6	1,5
TN.. 110308							0,10	0,20	0,30	0,4	1,0	2,0
TN.. 160404	0,05	0,15	0,25	0,3	0,5	1,5	0,06	0,15	0,25	0,2	0,6	1,5
TN.. 160408	0,07	0,15	0,25	0,3	0,5	1,5	0,10	0,20	0,30	0,4	1,0	2,0
TN.. 160412	0,10	0,20	0,30	0,5	0,7	1,5	0,14	0,25	0,35	0,6	1,4	2,6
TN.. 220404												
TN.. 220408												
TN.. 220412												
TN.. 220416												
VN.. 160404							0,06	0,15	0,25	0,2	0,6	1,5
VN.. 160408							0,10	0,20	0,30	0,4	1,0	2,0
VN.. 160412												
WN.. 060404	0,05	0,15	0,25	0,3	0,5	1,5	0,06	0,15	0,25	0,2	0,6	1,5
WN.. 060408	0,07	0,15	0,25	0,3	0,5	1,5	0,10	0,20	0,30	0,4	1,0	2,0
WN.. 060412												
WN.. 080404							0,06	0,15	0,25	0,2	0,6	1,5
WN.. 080408	0,07	0,15	0,25	0,3	0,5	1,5	0,10	0,20	0,30	0,4	1,0	2,0
WN.. 080412							0,14	0,25	0,35	0,6	1,4	2,6
WN.. 080416												



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

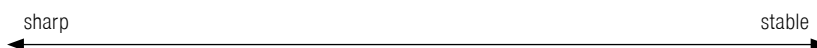
Designation	-TFQ (-TFQ)						-XU (-XU)						-M50 (-NM15)					
	f			a _p			f			a _p			f			a _p		
	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.
	mm/rev.			mm			mm/rev.			mm			mm/rev.			mm		
CN.. 090304																		
CN.. 090308																		
CN.. 120404	0,10	0,15	0,35	0,4	1,0	3,0	0,08	0,15	0,25	0,3	1,5	2,5	0,10	0,20	0,30	0,4	2,0	5,0
CN.. 120408	0,10	0,25	0,50	0,5	1,5	4,0	0,13	0,25	0,35	0,6	2,0	3,0	0,15	0,25	0,40	0,6	2,0	5,0
CN.. 120412	0,15	0,30	0,70	0,8	2,0	5,0	0,15	0,30	0,45	0,9	2,0	3,5	0,20	0,30	0,50	1,0	2,0	5,0
CN.. 120416													0,25	0,40	0,60	1,4	2,0	5,0
CN.. 160608													0,15	0,25	0,40	0,6	3,0	8,0
CN.. 160612													0,20	0,30	0,50	1,0	3,0	8,0
CN.. 160616													0,25	0,40	0,60	1,4	3,0	8,0
CN.. 160624																		
CN.. 190608																		
CN.. 190612																		
CN.. 190616																		
CN.. 190624																		
CN.. 250924																		
DN.. 110402																		
DN.. 110404													0,10	0,20	0,30	0,4	1,5	4,0
DN.. 110408													0,15	0,25	0,40	0,6	1,5	4,0
DN.. 110412													0,20	0,30	0,50	1,0	1,5	4,0
DN.. 150404													0,10	0,20	0,30	0,4	2,0	5,0
DN.. 150408													0,15	0,25	0,40	0,6	2,0	5,0
DN.. 150412													0,20	0,30	0,50	1,0	2,0	5,0
DN.. 150416													0,25	0,40	0,60	1,4	2,0	5,0
DN.. 150604	0,10	0,15	0,30	0,4	1,0	3,0	0,08	0,15	0,25	0,3	1,5	2,5	0,10	0,20	0,30	0,4	2,0	5,0
DN.. 150608	0,10	0,25	0,40	0,5	1,5	4,0	0,13	0,25	0,35	0,6	2,0	3,0	0,15	0,25	0,40	0,6	2,0	5,0
DN.. 150612							0,15	0,25	0,40	0,9	2,0	3,5	0,20	0,30	0,50	1,0	2,0	5,0
DN.. 150616													0,25	0,40	0,60	1,4	2,0	5,0
SN.. 090308																		
SN.. 120404																		
SN.. 120408													0,15	0,25	0,40	0,6	2,0	5,0
SN.. 120412													0,20	0,30	0,50	1,0	2,0	5,0
SN.. 120416													0,25	0,40	0,60	1,4	2,0	5,0
SN.. 150608													0,15	0,25	0,40	0,6	3,0	8,0
SN.. 150612													0,20	0,30	0,50	1,0	3,0	8,0
SN.. 150616													0,25	0,40	0,60	1,4	3,0	8,0
SN.. 190612																		
SN.. 190616																		
SN.. 190624																		
SN.. 250724																		
SN.. 250924																		
TN.. 110304																		
TN.. 110308																		
TN.. 160404													0,10	0,20	0,30	0,4	2,0	5,0
TN.. 160408													0,15	0,25	0,40	0,6	2,0	5,0
TN.. 160412													0,20	0,30	0,50	1,0	2,0	5,0
TN.. 220404																		
TN.. 220408													0,15	0,25	0,40	0,6	3,0	8,0
TN.. 220412													0,20	0,30	0,50	1,0	3,0	8,0
TN.. 220416																		
VN.. 160404							0,08	0,15	0,20	0,3	1,0	1,8	0,10	0,20	0,30	0,4	1,0	4,0
VN.. 160408							0,13	0,20	0,30	0,6	1,5	2,5	0,15	0,25	0,40	0,6	1,0	4,0
VN.. 160412													0,20	0,30	0,50	1,0	1,0	4,0
WN.. 060404	0,10	0,18	0,35	0,4	0,8	3,0							0,10	0,20	0,30	0,4	1,0	3,0
WN.. 060408	0,10	0,20	0,50	0,5	1,5	3,0							0,15	0,25	0,40	0,6	1,0	3,0
WN.. 060412													0,20	0,30	0,50	1,0	1,0	3,0
WN.. 080404							0,08	0,15	0,25	0,3	1,5	2,5	0,10	0,20	0,30	0,4	1,5	4,0
WN.. 080408	0,10	0,25	0,50	0,5	1,5	4,0	0,13	0,22	0,35	0,6	2,0	3,0	0,15	0,25	0,40	0,6	1,5	4,0
WN.. 080412	0,15	0,30	0,70	0,8	2,0	5,0	0,15	0,25	0,45	0,9	2,0	3,5	0,20	0,30	0,50	1,0	1,5	4,0
WN.. 080416													0,25	0,40	0,60	1,4	1,5	4,0



i Information on the cutting data of chip breakers not included in this overview, can be found on → Page 168–175

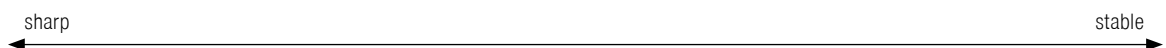
Cutting data standard values for negative inserts

Designation	-TMQ (-TMQ)						-M70 (-NM19)					
	f			a _p			f			a _p		
	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.
mm/rev.			mm			mm/rev.			mm			
CN.. 090304												
CN.. 090308												
CN.. 120404												
CN.. 120408	0,20	0,40	0,65	0,8	3,0	5,0	0,20	0,30	0,45	0,8	3,0	6,0
CN.. 120412	0,25	0,50	0,85	1,0	3,0	6,0	0,25	0,40	0,60	1,2	3,0	6,0
CN.. 120416							0,30	0,45	0,70	1,6	3,0	6,0
CN.. 160608							0,20	0,30	0,45	0,8	4,0	8,0
CN.. 160612							0,25	0,40	0,60	1,2	4,0	8,0
CN.. 160616							0,30	0,45	0,70	1,6	4,0	8,0
CN.. 160624							0,40	0,70	1,20	2,4	4,0	8,0
CN.. 190608							0,20	0,30	0,45	0,8	4,5	9,0
CN.. 190612							0,25	0,40	0,60	1,2	4,5	9,0
CN.. 190616							0,30	0,45	0,70	1,6	4,5	9,0
CN.. 190624							0,40	0,70	1,20	2,4	4,5	9,0
CN.. 250924							0,40	0,70	1,20	2,4	6,0	13,0
DN.. 110402												
DN.. 110404												
DN.. 110408							0,20	0,25	0,45	0,8	2,0	5,0
DN.. 110412							0,25	0,35	0,60	1,2	2,0	5,0
DN.. 150404												
DN.. 150408							0,20	0,25	0,45	0,8	2,5	6,0
DN.. 150412							0,25	0,35	0,60	1,2	2,5	6,0
DN.. 150416							0,30	0,40	0,70	1,6	2,5	6,0
DN.. 150604												
DN.. 150608	0,15	0,30	0,50	0,8	2,5	5,0	0,20	0,25	0,45	0,8	2,5	6,0
DN.. 150612	0,20	0,40	0,60	1,0	3,0	5,0	0,25	0,35	0,60	1,2	2,5	6,0
DN.. 150616							0,30	0,40	0,70	1,6	2,5	6,0
SN.. 090308												
SN.. 120404												
SN.. 120408							0,20	0,30	0,50	0,8	3,0	6,0
SN.. 120412							0,25	0,40	0,65	1,2	3,0	6,0
SN.. 120416							0,30	0,45	0,70	1,6	3,0	6,0
SN.. 150608												
SN.. 150612							0,25	0,40	0,65	1,2	4,0	8,0
SN.. 150616							0,30	0,45	0,75	1,6	4,0	8,0
SN.. 190612							0,25	0,40	0,65	1,2	4,5	9,0
SN.. 190616							0,30	0,45	0,75	1,6	4,5	9,0
SN.. 190624							0,40	0,70	1,20	2,4	4,5	9,0
SN.. 250724												
SN.. 250924							0,40	0,70	1,20	2,4	6,0	13,0
TN.. 110304												
TN.. 110308												
TN.. 160404												
TN.. 160408							0,20	0,25	0,45	0,8	2,5	6,0
TN.. 160412							0,25	0,35	0,60	1,2	2,5	6,0
TN.. 220404							0,15	0,20	0,30	0,4	3,0	7,0
TN.. 220408							0,20	0,25	0,45	0,8	3,0	7,0
TN.. 220412							0,25	0,35	0,60	1,2	3,0	7,0
TN.. 220416							0,30	0,40	0,70	1,6	3,0	7,0
VN.. 160404												
VN.. 160408												
VN.. 160412												
WN.. 060404												
WN.. 060408							0,20	0,30	0,45	0,8	2,0	4,0
WN.. 060412							0,25	0,40	0,60	1,2	2,0	4,0
WN.. 080404												
WN.. 080408	0,20	0,30	0,65	0,8	3,0	5,0	0,20	0,30	0,45	0,8	2,5	5,0
WN.. 080412	0,25	0,40	0,85	1,0	3,0	6,0	0,25	0,40	0,60	1,2	2,5	5,0
WN.. 080416							0,30	0,45	0,70	1,6	2,5	5,0



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

Designation	-R28 (-NR14)						-R58 (-NR17)						-R88 (-NR19)					
	f			a _p			f			a _p			f			a _p		
	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.
mm/rev.			mm			mm/rev.			mm			mm/rev.			mm			
CN.. 090304																		
CN.. 090308																		
CN.. 120404																		
CN.. 120408	0,25	0,35	0,55	0,8	3,0	7,0	0,25	0,45	0,70	1,0	3,0	7,0						
CN.. 120412	0,30	0,45	0,70	1,0	3,0	7,0	0,30	0,55	0,85	1,5	3,0	7,0						
CN.. 120416	0,30	0,60	0,90	1,5	3,0	7,0	0,35	0,65	1,00	2,0	3,0	7,0						
CN.. 160608																		
CN.. 160612	0,30	0,45	0,70	1,0	4,0	9,0	0,30	0,55	0,85	1,5	4,0	9,0						
CN.. 160616	0,35	0,60	0,90	1,5	4,0	9,0	0,35	0,65	1,00	2,0	4,0	9,0						
CN.. 160624							0,40	0,75	1,20	2,5	4,0	9,0	0,40	0,70	1,20	2,0	5,0	9,0
CN.. 190608																		
CN.. 190612	0,30	0,45	0,70	1,0	5,5	12,0	0,35	0,55	0,85	1,5	5,5	12,0						
CN.. 190616	0,35	0,60	0,90	1,5	5,5	12,0	0,40	0,65	1,00	2,0	5,5	12,0	0,40	0,70	1,00	2,0	5,0	12,0
CN.. 190624	0,35	0,65	1,00	2,0	5,5	12,0	0,40	0,75	1,20	2,5	5,5	12,0	0,40	0,70	1,20	2,0	5,0	12,0
CN.. 250924							0,45	0,80	1,30	2,5	8,0	16,0	0,60	1,00	1,50	3,5	10,0	18,0
DN.. 110402																		
DN.. 110404																		
DN.. 110408																		
DN.. 110412																		
DN.. 150404																		
DN.. 150408																		
DN.. 150412																		
DN.. 150416																		
DN.. 150604																		
DN.. 150608																		
DN.. 150612	0,25	0,45	0,70	1,0	2,5	6,0	0,30	0,50	0,80	1,5	2,5	6,0						
DN.. 150616	0,30	0,60	0,85	1,5	2,5	6,0	0,35	0,60	0,90	2,0	2,5	6,0						
SN.. 090308																		
SN.. 120404																		
SN.. 120408							0,25	0,45	0,70	1,0	3,0	7,0						
SN.. 120412							0,30	0,55	0,85	1,5	3,0	7,0						
SN.. 120416																		
SN.. 150608																		
SN.. 150612	0,30	0,35	0,70	1,0	4,0	9,0	0,30	0,55	0,85	1,5	4,0	9,0						
SN.. 150616	0,35	0,60	0,90	1,5	4,0	9,0	0,35	0,65	1,00	2,0	4,0	9,0						
SN.. 190612							0,35	0,55	0,85	1,5	5,5	12,0						
SN.. 190616	0,35	0,60	0,90	1,5	5,5	12,0	0,40	0,65	1,00	2,0	5,5	12,0	0,40	0,70	1,00	2,0	5,0	12,0
SN.. 190624							0,40	0,75	1,20	2,0	5,5	12,0	0,40	0,70	1,20	2,0	5,0	12,0
SN.. 250724	0,35	0,65	1,00	2,0	7,0	16,0	0,45	0,80	1,30	2,5	8,0	16,0	0,60	1,00	1,50	3,5	10,0	18,0
SN.. 250924	0,35	0,65	1,00	2,0	7,0	16,0	0,45	0,80	1,30	2,5	8,0	16,0	0,60	1,00	1,50	3,5	10,0	18,0
TN.. 110304																		
TN.. 110308																		
TN.. 160404																		
TN.. 160408																		
TN.. 160412																		
TN.. 220404																		
TN.. 220408																		
TN.. 220412							0,30	0,50	0,80	1,5	3,0	7,0						
TN.. 220416	0,30	0,55	0,85	1,5	3,0	7,0												
VN.. 160404																		
VN.. 160408																		
VN.. 160412																		
WN.. 060404																		
WN.. 060408																		
WN.. 060412																		
WN.. 080404																		
WN.. 080408																		
WN.. 080412																		
WN.. 080416																		



i Information on the cutting data of chip breakers not included in this overview, can be found on → Page 168–175

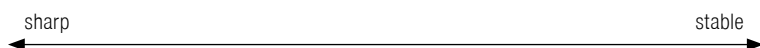
Cutting data standard values for negative inserts

Designation	-F30 (-NF23)						-M30 (-NM23)					
	f			a _p			f			a _p		
	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.
	mm/rev.			mm			mm/rev.			mm		
CN.. 090304												
CN.. 090308												
CN.. 120404	0,05	0,15	0,25	0,4	1,0	2,0						
CN.. 120408	0,10	0,22	0,35	0,8	1,5	2,5	0,15	0,25	0,40	1,0	2,0	4,5
CN.. 120412							0,20	0,30	0,50	1,2	2,5	5,0
CN.. 120416							0,25	0,35	0,55	1,6	2,5	5,0
CN.. 160608												
CN.. 160612												
CN.. 160616												
CN.. 160624												
CN.. 190608												
CN.. 190612												
CN.. 190616												
CN.. 190624												
CN.. 250924												
DN.. 110402												
DN.. 110404	0,05	0,15	0,25	0,4	1,0	2,0						
DN.. 110408	0,10	0,20	0,35	0,8	1,5	2,5	0,15	0,25	0,40	1,0	2,0	4,5
DN.. 110412							0,20	0,30	0,50	1,2	2,0	4,5
DN.. 150404												
DN.. 150408												
DN.. 150412												
DN.. 150416												
DN.. 150604	0,05	0,15	0,25	0,4	1,0	2,0						
DN.. 150608	0,10	0,20	0,35	0,8	1,5	2,5	0,15	0,25	0,40	1,0	2,0	5,5
DN.. 150612							0,20	0,30	0,50	1,2	2,0	5,5
DN.. 150616												
SN.. 090308												
SN.. 120404	0,10	0,15	0,30	0,4	1,0	2,0						
SN.. 120408	0,15	0,20	0,40	0,8	1,5	2,5	0,20	0,25	0,45	1,0	2,0	4,5
SN.. 120412	0,15	0,20	0,40	1,2	1,8	2,5	0,25	0,30	0,50	1,2	2,0	5,0
SN.. 120416												
SN.. 150608												
SN.. 150612												
SN.. 150616												
SN.. 190612												
SN.. 190616												
SN.. 190624												
SN.. 250724												
SN.. 250924												
TN.. 110304												
TN.. 110308												
TN.. 160404	0,05	0,15	0,25	0,4	1,0	2,0						
TN.. 160408	0,10	0,15	0,35	0,8	1,5	2,5	0,15	0,25	0,40	1,0	2,0	4,5
TN.. 160412							0,20	0,30	0,50	1,2	2,0	4,5
TN.. 220404												
TN.. 220408												
TN.. 220412												
TN.. 220416												
VN.. 160404	0,08	0,10	0,20	0,4	1,0	2,0						
VN.. 160408	0,10	0,15	0,30	0,8	1,5	2,5	0,15	0,25	0,40	1,0	1,5	4,0
VN.. 160412												
WN.. 060404	0,05	0,15	0,25	0,4	1,0	2,0						
WN.. 060408	0,10	0,20	0,30	0,8	1,5	2,5	0,15	0,25	0,40	1,0	1,5	3,5
WN.. 060412							0,20	0,30	0,45	1,2	1,5	4,0
WN.. 080404	0,05	0,15	0,25	0,4	1,0	2,0						
WN.. 080408	0,10	0,20	0,35	0,8	1,5	2,5	0,15	0,25	0,40	1,0	2,0	4,5
WN.. 080412							0,20	0,30	0,50	1,2	2,0	5,0
WN.. 080416												

sharp ←————→ stable

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

Designation	-M60 (-NM26)						-M34 (-M34)					
	f			a _p			f			a _p		
	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.
mm/rev.			mm			mm/rev.			mm			
CN.. 090304												
CN.. 090308												
CN.. 120404							0,08	0,12	0,18	1,0	1,5	3,0
CN.. 120408	0,25	0,30	0,50	1,5	2,5	6,0	0,10	0,15	0,35	1,0	1,8	3,5
CN.. 120412	0,30	0,35	0,55	2,0	3,0	6,0	0,13	0,20	0,40	1,5	2,0	4,0
CN.. 120416	0,30	0,40	0,60	2,0	3,0	6,0	0,15	0,25	0,45	2,0	3,0	4,5
CN.. 160608												
CN.. 160612	0,30	0,35	0,55	2,0	3,0	8,0						
CN.. 160616												
CN.. 160624												
CN.. 190608												
CN.. 190612												
CN.. 190616												
CN.. 190624												
CN.. 250924												
DN.. 110402												
DN.. 110404												
DN.. 110408												
DN.. 110412												
DN.. 150404							0,08	0,12	0,18	0,8	1,2	2,5
DN.. 150408							0,10	0,15	0,30	1,0	1,8	3,5
DN.. 150412							0,13	0,20	0,38	1,5	2,0	4,0
DN.. 150416												
DN.. 150604												
DN.. 150608	0,25	0,30	0,45	1,5	2,5	6,0	0,10	0,15	0,30	1,0	1,8	3,5
DN.. 150612	0,30	0,40	0,55	1,5	2,5	6,0	0,13	0,20	0,38	1,5	2,0	4,0
DN.. 150616												
SN.. 090308												
SN.. 120404												
SN.. 120408	0,30	0,35	0,50	1,5	2,0	6,0	0,15	0,25	0,40	1,0	2,0	4,0
SN.. 120412	0,30	0,40	0,55	2,0	2,5	6,0	0,15	0,25	0,45	1,5	2,5	4,5
SN.. 120416	0,30	0,40	0,60	2,0	2,5	6,0						
SN.. 150608												
SN.. 150612												
SN.. 150616												
SN.. 190612												
SN.. 190616												
SN.. 190624												
SN.. 250724												
SN.. 250924												
TN.. 110304												
TN.. 110308												
TN.. 160404												
TN.. 160408	0,25	0,25	0,45	1,5	2,5	5,0	0,10	0,15	0,35	1,0	2,0	4,0
TN.. 160412	0,30	0,30	0,55	2,0	2,5	5,5						
TN.. 220404							0,10	0,15	0,35	1,0	2,0	4,0
TN.. 220408							0,13	0,20	0,40	1,5	2,5	4,0
TN.. 220412												
TN.. 220416							0,15	0,25	0,45	2,0	2,5	4,5
VN.. 160404							0,07	0,10	0,18	0,8	1,2	2,0
VN.. 160408							0,10	0,15	0,20	1,0	1,5	2,5
VN.. 160412							0,13	0,18	0,25	1,5	1,8	3,0
WN.. 060404												
WN.. 060408	0,25	0,30	0,45	1,5	2,0	4,0						
WN.. 060412	0,30	0,35	0,50	2,0	2,5	4,5						
WN.. 080404												
WN.. 080408	0,25	0,30	0,50	1,5	2,0	5,0	0,10	0,15	0,35	1,0	2,0	4,0
WN.. 080412	0,30	0,35	0,55	2,0	2,5	5,5	0,13	0,20	0,40	1,5	2,0	4,0
WN.. 080416												



i Information on the cutting data of chip breakers not included in this overview, can be found on → Page 168–175

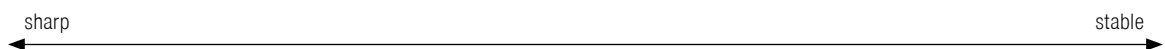
Cutting data values for positive inserts

Designation	-CF05 (-PF14)						-SF (-ZF)					
	f			a _p			f			a _p		
	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.
	mm/rev.			mm			mm/rev.			mm		
CC.. 060200							0,02	0,035	0,05	0,1	0,4	1,5
CC.. 060201							0,02	0,035	0,05	0,2	0,4	1,5
CC.. 060202	0,03	0,08	0,12	0,1	0,3	1,3	0,03	0,1	0,15	0,2	0,4	1,5
CC.. 060204	0,05	0,10	0,12	0,1	0,3	1,3	0,05	0,1	0,2	0,2	0,6	1,5
CC.. 060208							0,05	0,125	0,2	0,2	1	1,5
CC.. 09T300							0,02	0,035	0,05	0,2	0,75	2
CC.. 09T301							0,02	0,035	0,05	0,2	0,75	2
CC.. 09T302	0,03	0,08	0,12	0,1	0,3	1,3	0,05	0,075	0,1	0,2	0,75	2
CC.. 09T304	0,05	0,10	0,22	0,2	0,4	1,3	0,05	0,12	0,2	0,2	0,75	2
CC.. 09T308	0,06	0,13	0,25	0,2	0,4	1,3	0,05	0,125	0,25	0,4	1	2
CC.. 09T312												
CC.. 120402							0,05	0,075	0,1	0,2	0,8	2,5
CC.. 120404							0,05	0,12	0,2	0,2	1	2,5
CC.. 120408							0,08	0,15	0,25	0,4	1	2,5
CC.. 120412							0,08	0,15	0,25	0,4	1,5	2,5
DC.. 0702005												
DC.. 070201												
DC.. 0702015												
DC.. 070202	0,03	0,08	0,12	0,1	0,3	1,3	0,03	0,1	0,15	0,1	0,4	1,5
DC.. 070204	0,05	0,10	0,22	0,2	0,4	1,3	0,05	0,12	0,2	0,2	0,6	1,5
DC.. 070208												
DC.. 11T3005												
DC.. 11T301												
DC.. 11T3015												
DC.. 11T302	0,03	0,08	0,12	0,1	0,3	1,3						
DC.. 11T304	0,05	0,10	0,22	0,2	0,4	1,3	0,05	0,12	0,2	0,2	0,7	2
DC.. 11T308	0,06	0,13	0,25	0,2	0,4	1,3	0,08	0,15	0,25	0,4	1	2
DC.. 11T312												
RC.. 0602M0												
RC.. 0803M0												
RC.. 1003M0												
RC.. 1204M0												
RC.. 1606M0												
RC.. 2006M0												
RC.. 2507M0												
SC.. 09T304	0,05	0,10	0,22	0,2	0,4	1,3	0,05	0,12	0,2	0,2	0,7	2
SC.. 09T308	0,06	0,13	0,25	0,2	0,4	1,3	0,08	0,15	0,25	0,4	1	2
SC.. 120408							0,08	0,15	0,25	0,4	1	2,5
SC.. 120412												
TC.. 090204												
TC.. 110202	0,03	0,08	0,12	0,1	0,3	1,3						
TC.. 110204	0,05	0,10	0,22	0,2	0,4	1,3	0,05	0,12	0,2	0,2	0,7	2
TC.. 110208	0,06	0,13	0,25	0,2	0,4	1,3	0,08	0,15	0,25	0,4	1	2
TC.. 16T302												
TC.. 16T304	0,05	0,10	0,22	0,2	0,4	1,3	0,05	0,12	0,2	0,2	0,8	2,5
TC.. 16T308							0,08	0,15	0,25	0,4	1	2,5
TC.. 16T312												
TC.. 220408												
VC.. 1103005												
VC.. 110301												
VC.. 1103015												
VC.. 110302	0,03	0,06	0,12	0,1	0,3	1,3	0,02	0,08	0,15	0,1	0,4	1,5
VC.. 110304	0,05	0,08	0,22	0,2	0,4	1,3	0,05	0,1	0,2	0,2	0,6	1,5
VC.. 110308							0,08	0,12	0,22	0,4	1	1,5
VC.. 160402												
VC.. 160404	0,05	0,08	0,22	0,2	0,4	1,3	0,05	0,1	0,2	0,2	0,7	2
VC.. 160408	0,06	0,10	0,22	0,2	0,4	1,3	0,08	0,12	0,22	0,4	1	2
VC.. 160412												
VC.. 220530												
WC.. 020102							0,02	0,075	0,1	0,1	0,4	1
WC.. 020104							0,02	0,1	0,2	0,1	0,6	1,5

sharp ← → stable

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

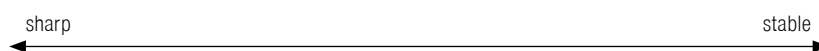
Designation	-CF55 (-PF15)						-SMF (-SMF)						-SM (-ZM)					
	f			a _p			f			a _p			f			a _p		
	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.
	mm/rev.			mm			mm/rev.			mm			mm/rev.			mm		
CC.. 060200																		
CC.. 060201																		
CC.. 060202													0,04	0,12	0,2	0,2	0,6	2,5
CC.. 060204	0,05	0,12	0,22	0,2	0,5	1,3	0,07	0,15	0,25	0,3	0,7	2	0,08	0,17	0,3	0,4	0,8	2,5
CC.. 060208							0,1	0,17	0,27	0,6	1	2	0,12	0,2	0,35	0,8	1	2,5
CC.. 09T300																		
CC.. 09T301																		
CC.. 09T302																		
CC.. 09T304	0,05	0,12	0,22	0,2	0,5	1,3	0,07	0,15	0,25	0,3	0,8	2,5	0,08	0,17	0,3	0,4	1	3
CC.. 09T308	0,06	0,15	0,25	0,2	0,5	1,3	0,1	0,17	0,27	0,6	1	2,5	0,12	0,2	0,35	0,8	1,2	3
CC.. 09T312													0,15	0,22	0,4	1,2	1,5	3
CC.. 120402																		
CC.. 120404	0,05	0,12	0,22	0,2	0,5	1,3	0,07	0,15	0,25	0,3	1	3	0,08	0,17	0,3	0,4	1,2	3,5
CC.. 120408							0,1	0,17	0,27	0,6	1,2	3	0,12	0,2	0,35	0,8	1,5	3,5
CC.. 120412													0,15	0,22	0,4	1,2	2	3,5
DC.. 0702005																		
DC.. 070201																		
DC.. 0702015																		
DC.. 070202	0,03	0,10	0,12	0,1	0,4	1,3							0,04	0,12	0,2	0,2	0,6	2,5
DC.. 070204	0,05	0,12	0,22	0,2	0,5	1,3	0,07	0,15	0,25	0,3	0,7	2	0,08	0,17	0,3	0,4	0,8	2,5
DC.. 070208							0,1	0,17	0,27	0,6	1	2	0,12	0,2	0,3	0,8	1	2,5
DC.. 11T3005																		
DC.. 11T301																		
DC.. 11T3015																		
DC.. 11T302																		
DC.. 11T304	0,05	0,12	0,22	0,2	0,5	1,3	0,07	0,15	0,25	0,3	0,8	2,5	0,8	0,17	0,3	0,4	1	3
DC.. 11T308	0,06	0,15	0,25	0,2	0,5	1,3	0,1	0,17	0,27	0,6	1,2	2,5	0,12	0,2	0,35	0,8	1,2	3
DC.. 11T312													0,15	0,22	0,4	1,2	1,7	3
RC.. 0602M0													0,2	0,3	0,5	0,2	0,5	1,5
RC.. 0803M0													0,2	0,3	0,6	0,2	0,6	2
RC.. 1003M0													0,25	0,4	0,7	0,2	0,7	2,5
RC.. 1204M0													0,3	0,5	0,8	0,2	0,8	3
RC.. 1606M0							0,15	0,3	0,6	0,25	2	3,5	0,4	0,6	1	0,3	1	3,5
RC.. 2006M0													0,5	0,8	1,2	0,4	1,2	4
RC.. 2507M0													0,6	0,9	1,4	0,6	2	5
SC.. 09T304	0,05	0,12	0,22	0,2	0,5	1,3	0,07	0,15	0,25	0,3	0,8	2,5	0,08	0,17	0,3	0,4	1	3
SC.. 09T308	0,06	0,15	0,25	0,2	0,5	1,3	0,1	0,17	0,27	0,6	1	2,5	0,12	0,2	0,35	0,8	1,2	3
SC.. 120408							0,1	0,17	0,27	0,6	1,2	3	0,12	0,2	0,35	0,8	1,5	3,5
SC.. 120412													0,15	0,22	0,4	1,2	2	3,5
TC.. 090204													0,08	0,12	0,2	0,4	0,8	2
TC.. 110202													0,08	0,1	0,2	0,4	0,6	3
TC.. 110204	0,05	0,12	0,22	0,2	0,5	1,3							0,12	0,2	0,35	0,8	1,2	3
TC.. 110208							0,1	0,17	0,27	0,6	1	2,5	0,12	0,2	0,35	0,8	1,2	3
TC.. 16T302																		
TC.. 16T304							0,07	0,15	0,25	0,3	1	3	0,08	0,17	0,3	0,4	1,2	3,5
TC.. 16T308	0,06	0,15	0,25	0,2	0,5	1,3	0,1	0,17	0,27	0,6	1,2	3	0,12	0,2	0,35	0,8	1,5	3,5
TC.. 16T312													0,15	0,22	0,4	1,2	1,7	3,5
TC.. 220408													0,12	0,2	0,35	0,8	2,5	6
VC.. 1103005																		
VC.. 110301																		
VC.. 1103015																		
VC.. 110302							0,05	0,1	0,18	0,2	0,5	2						
VC.. 110304	0,05	0,10	0,22	0,2	0,5	1,3	0,07	0,15	0,23	0,3	0,7	2						
VC.. 110308																		
VC.. 160402																		
VC.. 160404	0,05	0,10	0,22	0,2	0,5	1,3	0,07	0,15	0,23	0,3	0,8	2,5	0,08	0,17	0,25	0,4	1	3
VC.. 160408	0,06	0,12	0,22	0,2	0,5	1,3	0,1	0,17	0,27	0,6	1	2,5	0,12	0,2	0,3	0,8	1,2	3
VC.. 160412													0,15	0,22	0,32	1,2	1,5	3
VC.. 220530																		
WC.. 020102																		
WC.. 020104																		



i Information on the cutting data of chip breakers not included in this overview, can be found on → Page 168–175

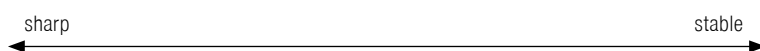
Cutting data values for positive inserts

Designation	-SMQ (-SMQ)						-M25 (-PF23)					
	f			a _p			f			a _p		
	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.
mm/rev.			mm			mm/rev.			mm			
CC.. 060200												
CC.. 060201												
CC.. 060202												
CC.. 060204							0,06	0,13	0,20	0,2	1,1	2,0
CC.. 060208												
CC.. 09T300												
CC.. 09T301												
CC.. 09T302												
CC.. 09T304	0,10	0,25	0,4	0,4	2	4	0,06	0,14	0,22	0,2	1,2	2,2
CC.. 09T308	0,15	0,30	0,5	0,8	2	4	0,10	0,20	0,30	0,4	1,8	3,2
CC.. 09T312												
CC.. 120402												
CC.. 120404	0,10	0,25	0,4	0,4	2	4						
CC.. 120408	0,15	0,30	0,5	0,8	2	4						
CC.. 120412												
DC.. 0702005												
DC.. 070201												
DC.. 0702015												
DC.. 070202							0,04	0,09	0,13	0,1	0,9	1,6
DC.. 070204	0,10	0,18	0,25	0,4	1,5	3	0,06	0,12	0,18	0,2	1,1	2,0
DC.. 070208												
DC.. 11T3005												
DC.. 11T301												
DC.. 11T3015												
DC.. 11T302							0,04	0,10	0,16	0,1	1,1	2,0
DC.. 11T304	0,10	0,25	0,4	0,4	2	4	0,06	0,14	0,22	0,2	1,2	2,2
DC.. 11T308	0,15	0,30	0,5	0,8	2	4	0,10	0,20	0,30	0,4	1,8	3,2
DC.. 11T312												
RC.. 0602M0												
RC.. 0803M0												
RC.. 1003M0												
RC.. 1204M0												
RC.. 1606M0												
RC.. 2006M0												
RC.. 2507M0												
SC.. 09T304												
SC.. 09T308												
SC.. 120408												
SC.. 120412												
TC.. 090204												
TC.. 110202												
TC.. 110204							0,06	0,13	0,20	0,2	1,2	2,2
TC.. 110208												
TC.. 16T302												
TC.. 16T304							0,06	0,14	0,22	0,2	1,6	3,0
TC.. 16T308							0,10	0,20	0,30	0,4	1,9	3,4
TC.. 16T312												
TC.. 220408												
VC.. 1103005												
VC.. 110301												
VC.. 1103015												
VC.. 110302												
VC.. 110304												
VC.. 110308												
VC.. 160402												
VC.. 160404							0,06	0,13	0,20	0,2	1,2	2,2
VC.. 160408							0,10	0,15	0,25	0,4	1,4	3,0
VC.. 160412												
VC.. 220530												
WC.. 020102												
WC.. 020104												


















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

Designation	-M55 (-PF26)						-F05					
	f			a _p			f			a _p		
	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.	min.	Recom- mended	max.
	mm/rev.			mm			mm/rev.			mm		
CC.. 060200												
CC.. 060201												
CC.. 060202												
CC.. 060204	0,06	0,13	0,20	0,4	1,5	2,6						
CC.. 060208												
CC.. 09T300												
CC.. 09T301												
CC.. 09T302												
CC.. 09T304	0,08	0,16	0,24	0,4	1,7	3,0						
CC.. 09T308	0,12	0,24	0,35	0,8	2,4	4,0						
CC.. 09T312												
CC.. 120402												
CC.. 120404	0,08	0,18	0,28	0,4	2,2	4,0						
CC.. 120408	0,12	0,26	0,40	0,8	2,8	4,8						
CC.. 120412												
DC.. 0702005							0,02	0,025	0,04	0,1	1	2
DC.. 070201							0,02	0,03	0,05	0,1	1	2
DC.. 0702015							0,02	0,04	0,075	0,1	1	2
DC.. 070202							0,02	0,05	0,1	0,1	1	2
DC.. 070204	0,06	0,14	0,22	0,4	1,3	2,2						
DC.. 070208	0,08	0,16	0,24	0,8	1,6	2,4						
DC.. 11T3005							0,02	0,025	0,04	0,1	1,25	2,5
DC.. 11T301							0,02	0,03	0,05	0,1	1,25	2,5
DC.. 11T3015							0,02	0,04	0,075	0,1	1,25	2,5
DC.. 11T302							0,02	0,075	0,1	0,1	1,25	2,5
DC.. 11T304	0,08	0,16	0,24	0,4	1,7	3,0	0,02	0,1	0,25	0,1	1,25	2,5
DC.. 11T308	0,12	0,24	0,35	0,8	2,4	4,0						
DC.. 11T312												
RC.. 0602M0												
RC.. 0803M0												
RC.. 1003M0												
RC.. 1204M0												
RC.. 1606M0												
RC.. 2006M0												
RC.. 2507M0												
SC.. 09T304	0,12	0,24	0,35	0,8	2,4	4,0						
SC.. 09T308	0,12	0,26	0,40	0,8	2,8	4,8						
SC.. 120408												
SC.. 120412												
TC.. 090204	0,06	0,12	0,18	0,4	1,3	2,2						
TC.. 110202												
TC.. 110204	0,06	0,14	0,22	0,4	1,4	2,4						
TC.. 110208												
TC.. 16T302												
TC.. 16T304												
TC.. 16T308	0,12	0,24	0,35	0,8	2,6	4,4						
TC.. 16T312												
TC.. 220408												
VC.. 1103005							0,02	0,025	0,04	0,1	1,25	2,5
VC.. 110301							0,02	0,03	0,05	0,1	1,25	2,5
VC.. 1103015							0,02	0,04	0,075	0,1	1,25	2,5
VC.. 110302							0,02	0,075	0,1	0,1	1,25	2,5
VC.. 110304							0,02	0,15	0,25	0,1	1,25	2,5
VC.. 110308												
VC.. 160402												
VC.. 160404	0,08	0,14	0,20	0,4	1,7	3,0						
VC.. 160408	0,12	0,21	0,30	0,8	2,1	3,4						
VC.. 160412												
VC.. 220530												
WC.. 020102												
WC.. 020104												



i Information on the cutting data of chip breakers not included in this overview, can be found on → Page 168–175

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

Material group		$a_p = 0,04-0,4 \text{ mm}$		$a_p = 0,4-1,0 \text{ mm}$		$a_p = 0,4-2,5 \text{ mm}$	
		Surface roughness R_z in μm		Surface roughness R_z in μm		Surface roughness R_z in μm	
		2,5-5,0	5,0-10	2,5-5,0	5,0-10	2,5-5,0	5,0-10
		CTD ...	CTD ...	CTD ...	CTD ...	CTD ...	CTD ...
Aluminium wrought alloys without Si $f=0.05-0.5 \text{ mm/rev.}$	 Grade	PD20 / PU20 / CD10	PD20 / PU20 / CD10	PD20 / PU20 / CD10	PD20 / PU20 / CD10	PD20 / PU20 / CD10	PD20 / PU20 / CD10
	v_c in m/min	400-2500	400-2500	400-2000	400-2000	400-1600	400-1600
	 Grade		PD20 / CD10		PD20 / CD10		PD20 / CD10
v_c in m/min		400-2500		400-2000		400-1600	
 Grade	PD20 / PU20	PD20 / PU20	PD20 / PU20	PD20 / PU20	PD20 / PU20	PD20 / PU20	
v_c in m/min	400-2500	400-2500	400-2000	400-2000	400-1600	400-1600	
Aluminium cast alloys Si=2-12 % $f=0.05-0.5 \text{ mm/rev.}$	 Grade	PS30 / PU20 / CD10	PS30 / PU20 / CD10	PS30 / PU20 / CD10	PS30 / PU20 / CD10	PS30 / PU20 / CD10	PS30 / PU20 / CD10
	v_c in m/min	600-2000	600-2200	600-1800	600-2000	600-1500	600-1800
	 Grade	PD20 / PU20 / CD10	PD20 / PU20 / CD10	PD20 / PU20 / CD10	PS30 / PU20 / CD10	PS30 / PU20 / CD10	PS30 / PU20 / CD10
v_c in m/min	400-2000	400-2200	400-1800	600-2000	400-1500	400-1800	
 Grade	PS30	PS30	PS30	PS30	PS30		
v_c in m/min	600-2000	600-2200	600-1800	600-2000	600-1500		
Aluminium cast alloys Si=12-20 % $f=0.05-0.5 \text{ mm/rev.}$	 Grade	PU20 / CD10	PU20 / CD10	PU20 / CD10	PU20 / CD10	PU20 / CD10	PU20 / CD10
	v_c in m/min	800-1200	400-1800	700-1000	400-1500	600-900	400-1200
	 Grade		PU20 / CD10		PU20 / CD10		PU20 / CD10
v_c in m/min		600-1800		600-1500		600-1200	
 Grade		PU20		PU20			
v_c in m/min		600-1800		600-1500			
Copper and copper wrought alloys $f=0.05-0.5 \text{ mm/rev.}$	 Grade	PD20 / PU20 / CD10	PD20 / PU20 / CD10	PD20 / PU20 / CD10	PS30 / PU20 / CD10	PD20 / PU20 / CD10	PD20 / PU20 / CD10
	v_c in m/min	400-1800	300-1600	400-1600	300-1600	400-1400	400-1500
	 Grade	PU20 / CD10	PD20 / PU20 / CD10	PD20 / PU20 / CD10	PS30 / PU20 / CD10	PD20 / PU20 / CD10	PD20 / PU20 / CD10
v_c in m/min	300-1500	300-1500	400-1600	300-1500	400-1500	300-1400	
 Grade		PD20 / PU20		PS30 / PU20	PD20 / PU20	PS30 / PU20	
v_c in m/min		300-1800		300-1700	300-1600	200-1300	
Plastic materials without reinforcement (acrylic glass) $f=0.05-0.7 \text{ mm/rev.}$	 Grade		PD20 / CD10		PD20 / CD10		PD20 / CD10
	v_c in m/min		400-1200		300-1000		200-1000
	 Grade		PD20 / CD10		PD20 / CD10		PS30 / CD10
v_c in m/min		300-1200		200-1000		200-900	
 Grade		PD20 / CD10		PD20 / CD10		PD20 / CD10	
v_c in m/min		400-1200		300-1000		200-1000	
Plastic materials with reinforcement (glass-fibre, carbon-fibre reinforced) $f=0.05-0.7 \text{ mm/rev.}$	 Grade	PS30 / PU20 / CD10		PS30 / PU20 / CD10	PS30 / PU20 / CD10	PS30 / PU20 / CD10	PS30 / PU20 / CD10
	v_c in m/min	500-1000		400-900	300-900	300-800	200-1200
	 Grade	PS30 / PU20 / CD10		PS30 / PU20 / CD10	PS30 / PU20 / CD10	PS30 / PU20 / CD10	PS30 / PU20 / CD10
v_c in m/min	400-900		300-800	200-900	200-800	200-1400	
 Grade	PU20		PU20	PU20	PU20		
v_c in m/min	500-1000		400-800	300-1000	300-800		

 Smooth cut	 Irregular cutting depth	 Interrupted cut
---	--	--

Application range of CBN grades

Cutting material grade	Cutting material designation				Application range	Interrupted cut	Material suitability/ ISO hardness			
	Properties		Main binder				K	S	H	Sintered steels
	New	Old	PcBN content							
High PcBN content	CTB S10U	PBC 10	95 %		Grey cast iron, sintered steels, super alloys	Smooth to medium interrupted cut	10	10	10	
	CTB S20C	PBC 15-S	90 %		Spheroidal graphite cast iron, sintered steels, super alloys		20	20	20	
Low PcBN content	CTB H15C	-	40 %	TiN	32 HRC and above	Smooth cut			15	
	CTB H15U	-	40 %	TiN					15	
	CTB H20C	PBC 25-S	65 %	TiCN	48-62 HRC	Smooth to slightly interrupted cut			20	
	CTB H21U	PBC 25	65 %	TiCN	52-65 HRC				20	
	CTB H40C	PBC 40-S	55 %	TiN	48-65 HRC	Interrupted cut			40	
	CTB H40U	PBC 40	65 %	TiN	54-65 HRC				40	

CBN – The Next Generation

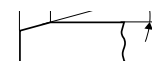
The 'Sandwich' Technology

The singular system (patent), to apply CBN segments on a tungsten carbide base in a single process reduces the edge price significantly and opens up the possibility for the development of different CBN grades.

Specialized edge preparations! To achieve the highest efficiency for each application, the new CBN sandwich inserts are available with up to 8 edge preparations.

CBN Test Insert

The type CNGA test insert was specifically used, in order to identify the **quickest and most effective** type. The insert is manufactured with four edge preparations for trial. The cutting edge with highest performance gives the correct chamfer style.



Article No.	Designation	Chamfers (BN x GB)				Price / £
71 499 ...						
290	CNGA 120408-X- CTB S20C	A F (sharp)	B 009B (0,09mm x 10°)	C 009C (0,09mm x 15°)	E 009D (0,09mm x 20°)	81.45
292	CNGA 120408-X- CTB H20C	B 009C (0,09mm x 15°)	C 009D (0,09mm x 20°)	E 011E (0,11mm x 25°)	G 014F (0,14mm x 30°)	81.45
294	CNGA 120408-X- CTB H40C	C 009D (0,09mm x 20°)	E 011E (0,11mm x 25°)	G 014F (0,14mm x 30°)	H 014G (0,14mm x 35°)	81.45

Cutting data values for CBN inserts

			CTB S10U (PBC 10)					
			EN (A)			F		
			EN (A)			TN-D (F)		
Index	Material	Strength	v _c	f	a _p	v _c	f	a _p
	Sintered steels (< HV300)		150-350	0,02-0,25	0,02-0,4	100-220	0,08-0,35	0,1-0,4
	General sintered steel (> HV300)		250-750	0,02-0,25	0,02-0,4	210-550	0,08-0,35	0,1-0,4
	High density sintered steel (> HV600)		200-700	0,02-0,25	0,02-0,4	150-400	0,08-0,35	0,1-0,4
3.1	Grey cast iron with lamellar graphite	100-350 N/mm ²	900-1600	0,02-0,25	0,05-0,25	700-1200	0,08-0,35	0,08-0,4
3.2	Grey cast iron with lamellar graphite	300-500 N/mm ²	900-1600	0,02-0,25	0,05-0,25	700-1200	0,08-0,35	0,08-0,4
3.3	Cast iron with spheroidal graphite	300-500 N/mm ²	1000-1750	0,02-0,25	0,02-0,25	800-1250	0,08-0,35	0,08-0,4
3.4	Cast iron with spheroidal graphite	500-900 N/mm ²	1000-1750	0,02-0,25	0,02-0,25	800-1250	0,08-0,35	0,08-0,4
3.5	White malleable cast iron	270-450 N/mm ²						
3.6	White malleable cast iron	500-650 N/mm ²						
3.7	Black malleable cast iron	300-450 N/mm ²						
3.8	Black malleable cast iron	500-800 N/mm ²						
5.1	Pure nickel							
5.2	Nickel alloys							
5.3	Nickel alloys	< 850 N/mm ²						
5.4	Nickel molybdenum alloys		300-700	0,02-0,25	0,02-0,4	250-400	0,08-0,35	0,08-0,4
5.5	Nickel-chromium alloys	< 1300 N/mm ²	300-700	0,02-0,25	0,02-0,4	250-400	0,08-0,35	0,08-0,4
5.6	Cobalt Chrome Alloys	< 1300 N/mm ²	300-700	0,02-0,25	0,02-0,4	250-400	0,08-0,35	0,08-0,4
5.7	Heat resistant alloys	< 1300 N/mm ²	300-700	0,02-0,25	0,02-0,4	250-400	0,08-0,35	0,08-0,4
5.8	Nickel-cobalt-chromium alloys	< 1400 N/mm ²	300-700	0,02-0,25	0,02-0,4	250-400	0,08-0,35	0,08-0,4
5.9	Pure titanium	< 900 N/mm ²						
5.10	Titanium alloys	< 700 N/mm ²						
5.11	Titanium alloys	< 1200 N/mm ²						

			CTB S20C (PBC 15S)					
			SN-C (D)			SN-D (E)		
			TN-D			SN-D		
Index	Material	Strength	v _c	f	a _p	v _c	f	a _p
	Sintered steels (< HV300)		130-300	0,05-0,35	0,06-0,4	120-250	0,06-0,35	0,08-0,4
	General sintered steel (> HV300)		250-600	0,05-0,35	0,06-0,4	220-580	0,06-0,35	0,08-0,4
	High density sintered steel (> HV600)		180-550	0,05-0,35	0,06-0,4	170-510	0,06-0,35	0,08-0,4
3.1	Grey cast iron with lamellar graphite	100-350 N/mm ²	650-1100	0,05-0,35	0,06-0,4	600-1000	0,06-0,35	0,08-0,5
3.2	Grey cast iron with lamellar graphite	300-500 N/mm ²	650-1100	0,05-0,35	0,06-0,4	600-1000	0,06-0,35	0,08-0,5
3.3	Cast iron with spheroidal graphite	300-500 N/mm ²	750-1300	0,05-0,35	0,06-0,4	700-1250	0,06-0,35	0,08-0,5
3.4	Cast iron with spheroidal graphite	500-900 N/mm ²	750-1300	0,05-0,35	0,06-0,4	700-1250	0,06-0,35	0,08-0,5
3.5	White malleable cast iron	270-450 N/mm ²						
3.6	White malleable cast iron	500-650 N/mm ²						
3.7	Black malleable cast iron	300-450 N/mm ²						
3.8	Black malleable cast iron	500-800 N/mm ²						
5.1	Pure nickel							
5.2	Nickel alloys							
5.3	Nickel alloys	< 850 N/mm ²						
5.4	Nickel molybdenum alloys		180-500	0,05-0,4	0,06-0,4	180-450	0,06-0,5	0,08-0,5
5.5	Nickel-chromium alloys	< 1300 N/mm ²	180-500	0,05-0,4	0,06-0,4	180-450	0,06-0,5	0,08-0,5
5.6	Cobalt Chrome Alloys	< 1300 N/mm ²	180-500	0,05-0,4	0,06-0,4	180-450	0,06-0,5	0,08-0,5
5.7	Heat resistant alloys	< 1300 N/mm ²	180-500	0,05-0,4	0,06-0,4	180-450	0,06-0,5	0,08-0,5
5.8	Nickel-cobalt-chromium alloys	< 1400 N/mm ²	180-500	0,05-0,4	0,06-0,4	180-450	0,06-0,5	0,08-0,5
5.9	Pure titanium	< 900 N/mm ²						
5.10	Titanium alloys	< 700 N/mm ²						
5.11	Titanium alloys	< 1200 N/mm ²						

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

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

Cutting data values for CBN inserts



CTB S20C (PBC 15S)								
EN (A)			SN-B (B)			SN-C (C)		
EN (A)			SN-B (B)			SN-C (C)		
v _c	f	a _p	v _c	f	a _p	v _c	f	a _p
150-350	0,02-0,25	0,02-0,4	150-350	0,04-0,25	0,03-0,4	150-350	0,05-0,25	0,06-0,4
250-750	0,02-0,25	0,02-0,4	250-700	0,04-0,25	0,03-0,4	250-650	0,05-0,25	0,06-0,4
200-700	0,02-0,25	0,02-0,4	200-700	0,04-0,25	0,03-0,4	200-600	0,05-0,25	0,06-0,4
800-1450	0,02-0,25	0,05-0,25	700-1400	0,04-0,25	0,05-0,25	650-1300	0,05-0,25	0,06-0,4
800-1450	0,02-0,25	0,05-0,25	700-1400	0,04-0,25	0,05-0,25	650-1300	0,05-0,25	0,06-0,4
900-1600	0,02-0,25	0,05-0,25	800-1600	0,04-0,25	0,05-0,25	780-1400	0,05-0,25	0,06-0,4
900-1600	0,02-0,25	0,05-0,25	800-1600	0,04-0,25	0,05-0,25	780-1400	0,05-0,25	0,06-0,4
200-600	0,02-0,25	0,02-0,4	200-550	0,04-0,25	0,03-0,4	200-550	0,05-0,25	0,06-0,4
200-600	0,02-0,25	0,02-0,4	200-550	0,04-0,25	0,03-0,4	200-550	0,05-0,25	0,06-0,4
200-600	0,02-0,25	0,02-0,4	200-550	0,04-0,25	0,03-0,4	200-550	0,05-0,25	0,06-0,4
200-600	0,02-0,25	0,02-0,4	200-550	0,04-0,25	0,03-0,4	200-550	0,05-0,25	0,06-0,4
200-600	0,02-0,25	0,02-0,4	200-550	0,04-0,25	0,03-0,4	200-550	0,05-0,25	0,06-0,4



CTB S20C (PBC 15S)								
SN-D (F)			SN-E (G)			SN-F (H)		
TN-E			SN-E			SN-F		
v _c	f	a _p	v _c	f	a _p	v _c	f	a _p
100-220	0,08-0,35	0,1-0,4	100-200	0,1-0,35	0,1-0,4	80-150	0,12-0,35	0,12-0,4
210-550	0,08-0,35	0,1-0,4	200-520	0,1-0,35	0,1-0,4	180-480	0,12-0,35	0,12-0,4
150-400	0,08-0,35	0,1-0,4	130-350	0,1-0,35	0,1-0,4	80-250	0,12-0,35	0,12-0,4
550-1000	0,08-0,35	0,08-0,4	550-950	0,1-0,35	0,1-0,4	500-850	0,12-0,35	0,12-0,4
550-1000	0,08-0,35	0,08-0,4	550-950	0,1-0,35	0,1-0,4	500-850	0,12-0,35	0,12-0,4
700-1200	0,08-0,35	0,08-0,4	700-1100	0,1-0,35	0,1-0,4	650-1000	0,12-0,35	0,12-0,4
700-1200	0,08-0,35	0,08-0,4	700-1100	0,1-0,35	0,1-0,4	650-1000	0,12-0,35	0,12-0,4
150-350	0,08-0,35	0,08-0,4	150-320	0,1-0,35	0,1-0,4	130-300	0,12-0,35	0,12-0,4
150-350	0,08-0,35	0,08-0,4	150-320	0,1-0,35	0,1-0,4	130-300	0,12-0,35	0,12-0,4
150-350	0,08-0,35	0,08-0,4	150-320	0,1-0,35	0,1-0,4	130-300	0,12-0,35	0,12-0,4
150-350	0,08-0,35	0,08-0,4	150-320	0,1-0,35	0,1-0,4	130-300	0,12-0,35	0,12-0,4
150-350	0,08-0,35	0,08-0,4	150-320	0,1-0,35	0,1-0,4	130-300	0,12-0,35	0,12-0,4



CCGW 120404 FN... **CTB H15U / CT**
FN (A) / FN (A)
FN (A) / FN (A)
 1,6-6,4



v _c	f	a _p
0-240	0,03-0,15	0,06
240	0,03-0,15	0,06
	0,03-0,15	



Cutting data values for CBN inserts

					CTB H15U / CTB H15C (BHT02RU / BHT02R)					
					FN (A) / FN (A)			EN (B) / EN (B)		
					FN (A) / FN (A)			EN (B) / EN (B)		
					Ra (theo.)			1,0 - 3,2		
Index	Material	Strength			v_c	f	a_p	v_c	f	a_p
6.1		< 45 HRC	x		160-240	0,03-0,15	0,06-0,3	160-240	0,03-0,15	0,06-0,3
6.2		46-55 HRC	x		160-240	0,03-0,15	0,06-0,3	160-240	0,03-0,15	0,06-0,3
6.3	Tempered steel	56-60 HRC	x		160-240	0,03-0,15	0,06-0,3	160-240	0,03-0,15	0,06-0,3
6.4		61-65 HRC								
6.5		65-70 HRC								


					CTB H21U / CTB H20C (PBC 25 / PBC 25S)					
					FN (A) / FN (A)			TN-C (B)		
					EN (A) / FN (A)			EN (B)		
					Ra (theo.)			1,0 - 4,5		
Index	Material	Strength			v_c	f	a_p	v_c	f	a_p
6.1		< 45 HRC								
6.2		46-55 HRC	x		300-380	0,04-0,25	0,05-0,5	280-350	0,04-0,15	0,05-0,5
6.3	Tempered steel	56-60 HRC	x		300-380	0,04-0,25	0,05-0,5	280-350	0,04-0,15	0,05-0,5
6.4		61-65 HRC								
6.5		65-70 HRC								

					CTB H21U / CTB H20C (PBC 25 / PBC 25S)					
					TN-E (F) / SN-E (F)			SN-F (G)		
					TN-E (F)			SN-E (G)		
					Ra (theo.)			0,2 - 0,8		
Index	Material	Strength			v_c	f	a_p	v_c	f	a_p
6.1		< 45 HRC								
6.2		46-55 HRC	x		210-260	0,05-0,15	0,1-0,5	180-230	0,06-0,20	0,1-0,5
6.3	Tempered steel	56-60 HRC	x		210-260	0,05-0,15	0,1-0,5	180-230	0,06-0,20	0,1-0,5
6.4		61-65 HRC								
6.5		65-70 HRC								

					CTB H40U / CTB H40C (PBC 40 / PBC 40S)					
					FN (A) / EN (A)			SN-C (B)		
					FN (A) / EN (A)			TN-D (B)		
					Ra (theo.)			0,8 - 3,0		
Index	Material	Strength			v_c	f	a_p	v_c	f	a_p
6.1		< 45 HRC								
6.2		46-55 HRC	x		190-250	0,03-0,15	0,03-0,5	180-240	0,04-0,15	0,03-0,5
6.3	Tempered steel	56-60 HRC	x		190-250	0,03-0,15	0,03-0,5	180-240	0,04-0,15	0,03-0,5
6.4		61-65 HRC	x		190-250	0,03-0,15	0,03-0,5	180-240	0,04-0,15	0,03-0,5
6.5		65-70 HRC								

					CTB H40U / CTB H40C (PBC 40 / PBC 40S)					
					SN-E (F)			SN-F (G)		
					TN-F (F)			SN-F (G)		
					Ra (theo.)			0,2 - 0,8		
Index	Material	Strength			v_c	f	a_p	v_c	f	a_p
6.1		< 45 HRC								
6.2		46-55 HRC	x		180-230	0,05-0,25	0,1-0,5	130-200	0,04-0,15	0,1-0,5
6.3	Tempered steel	56-60 HRC	x		180-230	0,05-0,25	0,1-0,5	130-200	0,04-0,15	0,1-0,5
6.4		61-65 HRC	x		180-230	0,05-0,25	0,1-0,5	130-200	0,04-0,15	0,1-0,5
6.5		65-70 HRC								

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

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

Cutting data values for CBN inserts

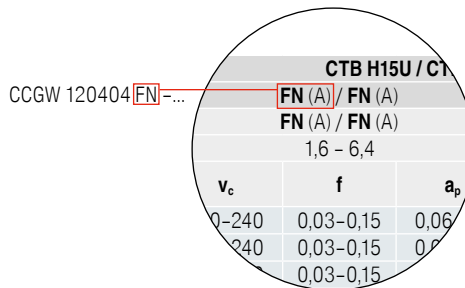
CTB H15U / CTB H15C (BHT02RU / BHT02R)								
SN-C (D) / SN-C (D)			SN-E (F) / SN-E (F)			RN / RN (Rounded chamfer)		
SN-C (D) / SN-C (D)			SN-E (F) / SN-E (F)			RN / RN (Rounded chamfer)		
0,5 - 1,6			0,1 - 0,8			0,1 - 0,8		
v_c	f	a_p	v_c	f	a_p	v_c	f	a_p
140-200	0,06-0,2	0,08-0,3	120-180	0,06-0,25	0,1-0,4	130-210	0,06-0,2	0,08-0,3
140-200	0,06-0,2	0,08-0,3	120-180	0,06-0,25	0,1-0,4	130-210	0,06-0,2	0,08-0,3
140-200	0,06-0,2	0,08-0,3	120-180	0,06-0,25	0,1-0,4	130-210	0,06-0,2	0,08-0,3

CTB H21U / CTB H20C (PBC 25 / PBC 25S)								
TN-D (C)			TN-D (D) / SN-D (D)			TN-E (E)		
SN-B (C)			TN-D (D) / SN-C (D)			SN-D (E)		
0,8 - 3,0			0,5 - 2,0			0,35 - 2,5		
v_c	f	a_p	v_c	f	a_p	v_c	f	a_p
270-330	0,06-0,25	0,05-0,5	250-320	0,06-0,25	0,08-1,0	220-290	0,05-0,15	0,08-0,5
270-330	0,06-0,25	0,05-0,5	250-320	0,06-0,25	0,08-1,0	220-290	0,05-0,15	0,08-0,5

CTB H21U / CTB H20C (PBC 25 / PBC 25S)		
SN-G (H)		
SN-F (H)		
0,1 - 0,5		
v_c	f	a_p
160-200	0,05-0,12	0,1-0,5
160-200	0,05-0,12	0,1-0,5

CTB H40U / CTB H40C (PBC 40 / PBC 40S)								
SN-D (C)			SN-D (D)			EN-T (E) / SN-E (E)		
SN-D (C)			TN-D (D)			EN-T (E) / SN-E (E)		
0,8 - 2,0			0,5 - 1,6			0,5 - 1,6		
v_c	f	a_p	v_c	f	a_p	v_c	f	a_p
160-220	0,04-0,15	0,03-0,5	150-210	0,04-0,25	0,08-0,5	140-200	0,05-0,15	0,08-0,5
160-220	0,04-0,15	0,03-0,5	150-210	0,04-0,25	0,08-0,5	140-200	0,05-0,15	0,08-0,5
160-220	0,04-0,15	0,03-0,5	150-210	0,04-0,25	0,08-0,5	140-200	0,05-0,15	0,08-0,5

CTB H40U / CTB H40C (PBC 40 / PBC 40S)		
SN-G (H)		
SN-G (H)		
0,1 - 0,5		
v_c	f	a_p
120-190	0,04-0,12	0,1-0,5
120-190	0,04-0,12	0,1-0,5
120-190	0,04-0,12	0,1-0,5



Diamond as a cutting material



Ensures

- ▲ optimal surface quality
- ▲ burr-free workpieces
- ▲ high service lives
- ▲ lowest cutting forces
- ▲ high Process Security

Complete programme of roughing, finishing and wiper inserts for machining aluminium, non ferrous metals, plastics, ...

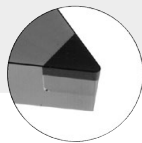
The cutting materials

	CTD CD10 (CVD) Fine grain Size (N10)	CTD PD20 (PKD) Fine grain grade (N20)	CTD PU20 (PKD) Coarse grain grade (N20)	CTD CD10 (CVD) Coarse grain Size (N30)
Properties	<ul style="list-style-type: none"> ▲ perfect sharp edges ▲ no cutting pressure ▲ very close tolerances ▲ highest abrasion resistance with highest toughness ▲ very high heat conductivity 	<ul style="list-style-type: none"> ▲ high sharpness ▲ lower cutting pressure than PDC-S ▲ close tolerance ▲ lower abrasion resistance with increased toughness 	<ul style="list-style-type: none"> ▲ very sharp cutting edge ▲ reduced cutting pressure ▲ tight tolerances ▲ very high level of wear resistance and toughness 	<ul style="list-style-type: none"> ▲ high sharpness ▲ lower cutting pressure ▲ close tolerance ▲ lower abrasion resistance than with the PDC, with increased toughness
Material	suitable for superfinishing and semi-finishing of all non ferrous metals and NE-composite materials with small to high levels of abrasiveness	suitable for fine machining of all NE materials with low abrasiveness	suitable for finishing to roughing non-ferrous metals and non-ferrous materials with highly abrasive alloying element. High chip removal on fibre-reinforced plastics such as CFRP and GFRP.	suitable for fine machining of all NE-materials and non-ferrous metals with low to very high levels of abrasiveness

Cutting Geometries

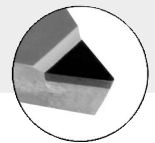
Neutral rake angle:

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



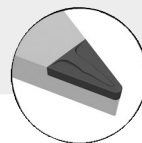
Positive rake angle:

- ▲ 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

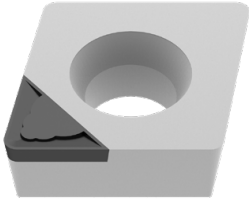


Notes on diamond usage

- ▲ 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.

Cutting data standard values for the CB chip breaker geometries

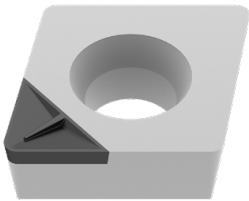
-CB1



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

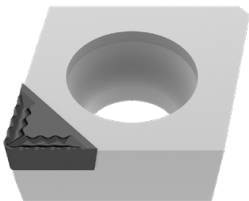
-CB2



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





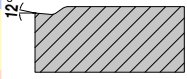

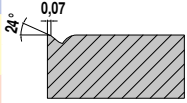

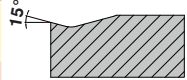

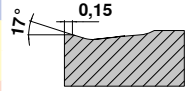

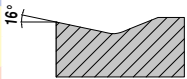
-CB3







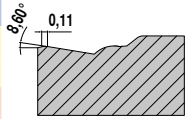

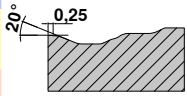

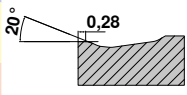

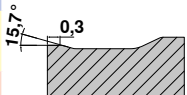

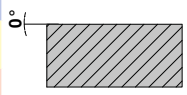
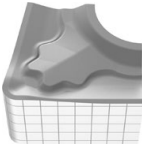
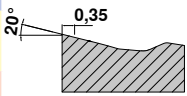
3D-Chip Breaker -CB3				
Corner Radius	a _p in mm		f _z in mm/rev.	
	min.	max.	min.	max.
0,4 mm	1,00	3,00	0,10	0,20
0,8 mm	1,00	3,00	0,15	0,35

- ▲ 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

Standard chip breakers / application notes




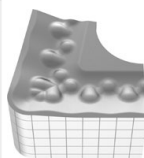
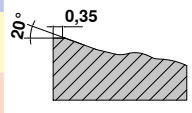
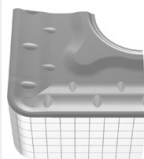
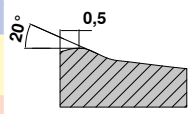
Negative	Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration		Geometry																																
					a_p mm	f mm																																	
<p>-CF / -CF20 (-CF / -NF12)</p> <ul style="list-style-type: none"> ▲ Fine finishing ▲ Sharp cutting edge for low cutting forces ▲ Good chip control even at small depths of cut  <p>F</p>	<p>CTEP110 / TCM10 (DCC1110 / CWC10)</p> <p>CTEP110 / TCM10 (DCC1110 / CWC10)</p> <p>CTEP110 / TCM10 (DCC1110 / CWC10)</p>	<p>CTEP110 / TCM10 (DCC1110 / CWC10)</p>	<p>CTEP110 / TCM10 (DCC1110 / CWC10)</p>		<p>0,30-1,50</p>	<p>0,07-0,25</p>	<p>CN.. DN.. TN.. WN..</p>																																
								<p>-F40 (-F40)</p> <ul style="list-style-type: none"> ▲ Fine turning chip breaker for machining steels ▲ Good chip control ▲ Ideal for copy turning work  <p>F</p>	<p>CTCP125 (HCX1125)</p> <p>CTCP125 (HCX1125)</p> <p>CTCP125 (HCX1125)</p>	<p>CTCP125 (HCX1125)</p> <p>CTCP125 (HCX1125)</p>	<p>CTCP125 (HCX1125)</p> <p>CTCP125 (HCX1125)</p>		<p>0,50-2,00</p>	<p>0,10-0,30</p>	<p>VN..</p>																								
																<p>-F50 (-NF15)</p> <ul style="list-style-type: none"> ▲ Fine turning chip breaker for fine machining ▲ Steel and stainless steels ▲ Excellent chip control ▲ High surface quality  <p>F</p>	<p>CTCP125 (HCX1125)</p> <p>CTCP115 / CTCP125 (HCX115 / HCX1125)</p>	<p>CTCP115 / CTCP125 / CTCP135 (HCX1115 / HCX1125 / HCX1135)</p> <p>CTCP125 / CTCP135 (HCX1125 / HCX1135)</p>	<p>CTCP135 (HCX1135)</p> <p>CTCP135 (HCX1135)</p>		<p>0,10-2,60</p>	<p>0,06-0,35</p>	<p>CN.. DN.. SN.. TN.. VN.. WN..</p>																
																								<p>-TFQ (-TFQ)</p> <ul style="list-style-type: none"> ▲ Wiper geometry ▲ Finishing to medium machining ▲ Very high feedrate ▲ High surface quality  <p>F</p>	<p>CTEP110 / CTCP115 (DCC1110 / HCX1115)</p> <p>CTEP110 / CTCP115 (DCC1110 / HCX1115)</p> <p>CTEP110 / CTCP115 (DCC1110 / HCX1115)</p>	<p>CTCP115 / CTCP125 (HCX1115 / HCX1125)</p> <p>CTCP115 / CTCP125 (HCX1115 / HCX1125)</p> <p>CTCP115 / CTCP125 (HCX1115 / HCX1125)</p>	<p>CTCP115 / CTCP125 (HCX1115 / HCX1125)</p> <p>CTCP115 / CTCP125 (HCX1115 / HCX1125)</p>		<p>0,50-5,00</p>	<p>0,10-0,60</p>	<p>CN.. DN.. WN..</p>								
																																<p>-42 (-42)</p> <ul style="list-style-type: none"> ▲ Extremely soft-cutting chip breaker ▲ For small and medium widths of cut ▲ Suitable for thin-walled parts  <p>F M</p>	<p>CTC2135 (CWN2135)</p> <p>CTC2135 (CWN2135)</p>	<p>CTC2135 (CWN2135)</p> <p>CTC2135 (CWN2135)</p>	<p>CTC2135 (CWN2135)</p> <p>CTC2135 (CWN2135)</p>		<p>0,50-4,50</p>	<p>0,05-0,35</p>	<p>CN..</p>

Standard chip breakers / application notes

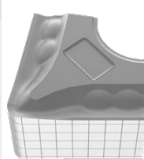
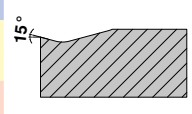
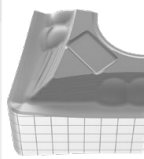
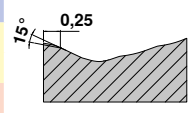
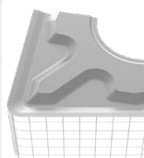
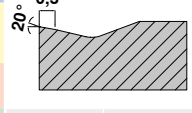
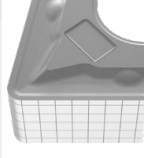
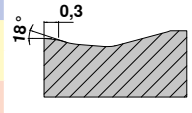
Negative	Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration		Geometry
					a _p mm	f mm	
-M40 (-M40) ▲ Stable geometry ▲ Medium feed rates ▲ Can be used for any application ▲ Good chip control	 M	CTCP125 (HCX1125)	CTCP125 (HCX1125)		 0,50-3,00 0,10-0,35	VN..	
		CTCP125 (HCX1125)	CTCP125 (HCX1125)				
		CTCP125 (HCX1125)	CTCP125 (HCX1125)				
-M50 (-NM15) ▲ Medium machining ▲ First choice for steel machining ▲ Universal application ▲ Wide range of applications	 M	CTCP115 / CTCP125 / CTCK110 / CTCK120 (HCX1115 / HCX1125 / DCX3110 / HCF3120)	CTCP115 / CTCP125 (HCX1115 / HCX1125)	CTCP125 (HCX1125)	 0,50-5,00 0,12-0,40	CN.. DN.. SN.. VN.. WN..	
		CTCP125 (HCX1125)	CTCP125 (HCX1125)				
		CTCP115 / CTCP125 / CTCK110 / CTCK120 (HCX1115 / HCX1125 / DCX3110 / HCF3120)	CTCP115 / CTCP125 / CTCK110 / CTCK120 (HCX1115 / HCX1125 / DCX3110 / HCF3120)	CTCP125 / CTCK120 (HCX1125 / HCF3120)			
-TMQ (-TMQ) ▲ Wiper geometry ▲ Light to medium rough machining ▲ Very high feedrate ▲ High surface quality	 M	CTCP115 (HCX1115)	CTCP125 (HCX1125)		 0,80-6,00 0,20-0,85	CN.. DN.. WN..	
		CTCP125 (HCX1125)	CTCP125 (HCX1125)				
		CTCP125 (HCX1125)	CTCP125 (HCX1125)				
-M70 (-NM19) ▲ Light to medium rough machining ▲ Cast crust and forging skin ▲ Stable cutting edge ▲ Interrupted cut ▲ Raw materials and forgings	 M R	CTCK110 / CTCK120 / CTCP115 (DCX3110 / HCF3120 / HCX1115)	CTCP115 / CTCP125 (HCX1115 / HXC1125)	CTCP125 / CTCP135 (HCX1125 / HCR1135)	 1,50-4,50 0,20-0,80	CN.. DN.. SN.. TN.. WN..	
		CTCP125 / CTC2135 (HCX1125 / CWN2135)	CTC2135 / CTCP135 CWN2135 / HCR1135	CTCP135 / CTC2135 HCR1135 / CWN2135			
		CTCK110 / CTCK120 / CTCP115 / CTCP125 (DCX3110 / HCF3120 / HCX1115 / HCX1125)	CTCK120 / CTCP125 (HCF3120 / HCX1125)	CTCP125 / CTCK120 (HCX1125 / HCF3120)			
		CTC2135 / CTCP125 (CWN2135 / HCX1125)	CTC2135 / CTCP125 (CWN2135 / HCX1125)				
.NMA ▲ Rough machining ▲ Stable cutting edge ▲ For short-chipping materials ▲ First choice for grey cast iron	 R				 1,50-4,50 0,20-0,80	CN.. DN.. SN.. TN.. WN..	
		CTCK110 (DCX3110)	CTCK110 / CTCK120 (DCX3110 / HFC3120)	CTCK120 HFC3120			
-R28 (-NR14) ▲ Single sided roughing geometry ▲ Longitudinal, face and copy turning ▲ Varying depths of cut ▲ Steels with low tensile strength (800 N/mm ²) ▲ Good chip control	 R	CTCP115 / CTCP125 (HCX1115 / HCX1125)	CTCP115 / CTCP135 / CTCP125 (HCX1115 / HCR1135 / HCX1125)	CTCP135 (HCR1135)	 1,00-12,00 0,25-0,80	CN.. DN.. SN..	
		CTCP115 / CTCP125 (HCX1115 / HCX1125)	CTCP125 / CTCP135 (HCX1125 / HCR1135)	CTCP135 (HCR1135)			
		CTCP115 (HCX1115)	CTCP115 / CTCP125 (HCX1115 / HCX1125)	CTCP125 (HCX1125)			
		CTCP125 / CTCP135 (HCX1125 / HCR1135)	CTCP135 (HCR1135)	CTCP135 (HCR1135)			

Main application steel and cast iron, secondary application stainless steels

Standard chip breakers / application notes





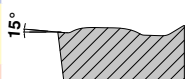

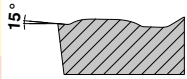

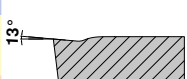
Negative		Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration		Geometry		
						a _p mm	f mm			
Main application steel and cast iron, secondary application stainless steels	-R58 (-NR17)	 R	CTCP115 / CTCP125 (HCX1115 / HCX1125)	CTCP115 / CTCP135 / CTCP125 (HCX1115 / HCR1135 / HCX1125)	CTCP135 (HCR1135)		1,50-12,00	0,30-1,20	CN.. DN.. SN.. TN..	
	<ul style="list-style-type: none"> ▲ Single sided roughing geometry ▲ Longitudinal and face turning ▲ Light interrupted cut ▲ Low cutting forces ▲ Unstable machines 		CTCP115 / CTCP125 (HCX1115 / HCX1125)	CTCP125 / CTCP135 (HCX1125 / HCR1135)	CTCP135 (HCR1135)					
			CTCP115 (HCX1115)	CTCP115 / CTCP125 (HCX1115 / HCX1125)	CTCP125 (HCX1125)					
			CTCP125 / CTCP135 (HCX1125 / HCR1135)	CTCP135 (HCR1135)	CTCP135 (HCR1135)					
		-R88 (-NR19)	 R	CTCP115 / CTCP125 (HCX1115 / HCX1125)	CTCP115 / CTCP125 / CTCP135 (HCX1115 / HCX1125 / HCR1135)	CTCP135 (HCR1135)		3,50-16,00	0,50-1,50	SN..
	<ul style="list-style-type: none"> ▲ Single sided roughing geometry ▲ Longitudinal and face turning ▲ High feedrate ▲ Large depths of cut ▲ Heavily interrupted cut 	CTCP115 / CTCP125 (HCX1115 / HCX1125)		CTCP115 / CTCP125 (HCX1115 / HCX1125)	CTCP135 (HCR1135)					
		CTCP115 (HCX1115)		CTCP115 / CTCP125 (HCX1115 / HCX1125)	CTCP125 (HCX1125)					
		CTCP125 / CTCP135 (HCX1125 / HCR1135)		CTCP135 (HCR1135)	CTCP135 (HCR1135)					

Negative





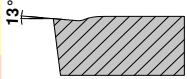

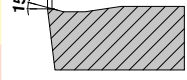
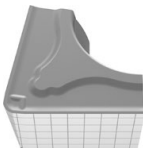
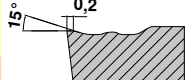
Main application stainless steels, secondary application steel and super alloys	-F30 (-NF23)	 F	CTPM125 (HCN2125)	CTPM125 (HCN2125)			0,08-2,5	0,10-0,35	CN.. DN.. SN.. TN.. VN.. WN..	
	<ul style="list-style-type: none"> ▲ Finishing of stainless steels ▲ Continuous cut ▲ High surface quality ▲ Good swarf control 		CTPM125 (HCN2125)	CTPM125 (HCN2125)						
		-M30 (-NM23)	 F M	CTPM125 (HCN2125)	CTPM125 (HCN2125)	CTPM125 (HCN2125)		1,00-4,50	0,15-0,40	CN.. DN.. SN.. TN.. VN.. WN..
	<ul style="list-style-type: none"> ▲ Option for stainless steel machining ▲ Good swarf control ▲ Little edge build up ▲ Low cutting forces ▲ Little built-up edge ▲ Applicable on unstable machines 	CTPM125 (HCN2125)		CTPM125 (HCN2125)	CTPM125 (HCN2125)					
	-M42 (-M42)	 M	CTP2120 / CTC2135 (CCN2120 / CWN2135)	CTP2120 / CTC2135 (CCN2120 / CWN2135)	CTC2135 (CWN2135)		1,00-4,00	0,20-0,40	CN.. DN.. SN.. TN.. VN.. WN..	
<ul style="list-style-type: none"> ▲ For medium machining of stainless steels ▲ Also by application on general steels and superalloys 	CTP2120 / CTC2135 (CCN2120 / CWN2135)		CTP2120 / CTC2135 (CCN2120 / CWN2135)	CTC2135 (CWN2135)						
	-M60 (-NM26)	 M R	CTPM125 (HCN2125)	CTPM125 (HCN2125)	CTPM125 (HCN2125)		1,50-6,00	0,25-0,50	CN.. DN.. SN.. TN.. VN.. WN..	
<ul style="list-style-type: none"> ▲ Light to medium roughing ▲ Stable cutting edge ▲ Interrupted cut ▲ Forged skin and cast crust 	CTPM125 (HCN2125)		CTPM125 (HCN2125)	CTPM125 (HCN2125)						
			CTPM125 (HCN2125)	CTPM125 (HCN2125)						

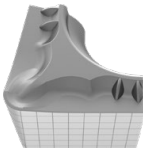
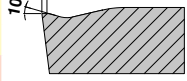

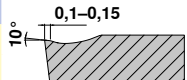

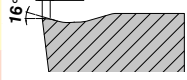
Standard chip breakers / application notes

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	-F32 (-F32)	 F	CTP2120 (CCN2120)	CTP2120 (CCN2120)			10,8°	CN.. DN.. VN..
	<ul style="list-style-type: none"> Streamlined geometry for finishing superalloys For finishing stainless steels 		CTP2120 (CCN2120)	CTP2120 (CCN2120)				
			CTP2120 (CCN2120)	CTP2120 (CCN2120)				
				0,05-4,0	0,05-0,25			
	-M34 (-M34)	 M	CTP5110 / CTP5115 (HCN5110 / HCN5115)	CTP5110 / CTP5115 (HCN5110 / HCN5115)			15°	CN.. DN.. SN.. VN.. WN..
	<ul style="list-style-type: none"> First choice for superalloys Light cutting geometry Little built-up edge Low cutting forces 		CTP5110 / CTP5115 (HCN5110 / HCN5115)	CTP5110 / CTP5115 (HCN5110 / HCN5115)				
			CTP5110 / CTP5115 (HCN5110 / HCN5115)	CTP5110 / CTP5115 (HCN5110 / HCN5115)				
				0,80-3,0	0,10-0,30			
	-M52 (-M52)	 M	CTP2120 (CCN2120)	CTP2120 (CCN2120)			13°	CN.. DN.. SN.. TN.. WN..
<ul style="list-style-type: none"> Universal geometry for machining superalloys and stainless steels 	CTP2120 (CCN2120)		CTP2120 (CCN2120)					
	CTP2120 (CCN2120)		CTP2120 (CCN2120)					
			1,50-4,00	0,20-0,38				





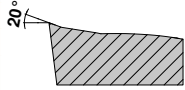
Positive		Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration		Geometry
						a _p mm	f mm	
Main application steel and cast iron, secondary application stainless steels and super alloys	-CF05 (-PF14)	 F	CTEP110 / TCM407 (DCC1110 / CWC407)	TCM10 / TCM407 (CWC10 / CWC407)			15°	CC.. DC.. SC.. TC.. VC..
	<ul style="list-style-type: none"> Fine finishing For all common steel materials, stainless steels and GGG Good swarf control High surface quality 		CTEP110 (DCC1110)					
			CTEP110 (DCC1110)	TCM10 / TCM407 (CWC10 / CWC407)				
				0,20-1,30	0,06-0,25			
	-SF (-ZF)	 F	CTC2135 / CTC115 (CWN2135 / HCX1125)	CTCP125 (HCX1125)	CTCP125 / CTC135 (HCX1125 / HCR1135)		15°	CC.. DC.. SC.. TC.. VC.. WC..
	<ul style="list-style-type: none"> Finishing / contour turning Good swarf control High surface quality Low cutting forces 		CTC2135 / CTC125 (CWN2135 / HCX1125)	CTCP125 / CTC2135 (HCX1125 / CWN2135)	CTC2135 (CWN2135)			
			CTCP125 (HCX1125)	CTCP125 (HCX1125)				
				0,05-2,50	0,05-0,25			
	-CF55 (-PF15)	 F M	CTEP110 (DCC1110)	TCM10 / CTEP110 (CWC10 / DCC1110)			13°	CC.. DC.. SC.. TC.. VC..
<ul style="list-style-type: none"> Finishing to medium machining Suitable for general and stainless steels Low cutting forces Good swarf control High surface quality 	CTEP110 (DCC1110)		CTEP110 (DCC1110)					
	CTEP110 (DCC1110)		CTEP110 (DCC1110)					
			0,20-1,30	0,06-0,25				





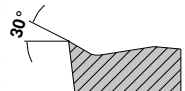
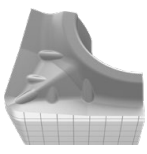
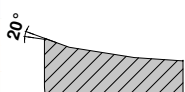
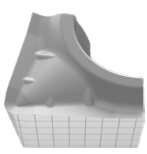
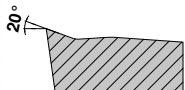
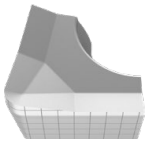
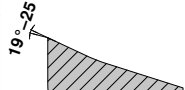
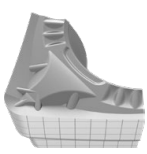
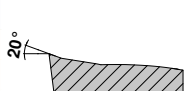
Standard chip breakers / application notes

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 (-SMF)	 F M	CTEP110 / CTCP115 (DCC1110 / HCX1115)	TCM10 / CTCP125 / CTCP115 (CWC10 / HCX1125 / HCX1115)	CTCP135 HCR1135		0,20-1,30	0,06-0,25	CC.. DC.. SC.. TC.. VC..
	▲ Finishing to medium machining ▲ Low cutting forces ▲ Good swarf control ▲ High surface quality		CTCP115 / CTCP125 / CTEP110 (HCX1115 / HCX1125 / DCC1110)	CTCP125 / CTCP135 (HCX1125 / HCR1135)	CTCP135 HCR1135				
			CTCP115 / CTCP135 (HCX1115 / HCR1135)	CTCP135 HCR1135					
Main application steel and cast iron, secondary application stainless steels and super alloys	-SM (-ZM)	 M	CTCP115 / CTCP125 (HCX1115 / HCX1125)	CTCP125 / CTCP135 / CTCP115 (HCX1125 / HCR1135 / HCX1115)	CTCP125 / CTCP135 (HCX1125 / HCR1135)		0,05-5,00	0,15-0,45	CC.. DC.. RC.. SC.. TC.. VC..
	▲ Medium machining ▲ Universal application ▲ Stable cutting edge ▲ Varying depths of cut ▲ Wide range of applications		CTCP125 (HCX1125)	CTCP125 / CTCP135 (HCX1125 / HCR1135)	CTCP135 (HCR1135)				
			CTCP115 / CTCK110 / CTCK120 (HCX1115 / DCX3110 / HCF3120)	CTCP125 / CTCK110 / CTCK120 (HCX1125 / DCX3110 / HCF3120)	CTCK120 / CTCP125 HCF3120 / HCX1125				
Main application steel and cast iron, secondary application stainless steels and super alloys	-SMQ (-SMQ)	 M	CTCP115 (HCX1115)	CTCP125 (HCX1125)	CTCP125 (HCX1125)		1,00-4,00	0,15-0,45	CC.. DC..
	▲ Positive wiper geometry ▲ Finishing to medium machining ▲ Very high feedrate ▲ High surface quality		CTCP115 (HCX1115)	CTCP125 (HCX1125)					
			CTCP125 / CTCP115 (HCX1125 / HCX1115)	CTCP125 (HCX1125)	CTCP125 (HCX1125)				




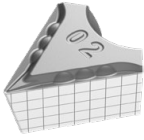
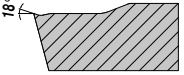

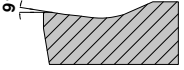
Positive									
Main application stainless steels	-F43 (-F43)	 F	CTC2135 (CWN2135)	CTC2135 (CWN2135)	CTC2135 (CWN2135)		0,50-2,50	0,05-0,25	CC.. DC.. TC..
	▲ For the light to medium machining of all stainless steels, general steels and superalloys		CTC2135 (CWN2135)	CTC2135 (CWN2135)	CTC2135 (CWN2135)				
			CTC2135 (CWN2135)	CTC2135 (CWN2135)					
Main application stainless steels	-M25 (-PF23)	 F M	CTPM125 (HCN2125)	CTPM125 (HCN2125)			0,40-3,20	0,10-0,30	CC.. DC.. TC.. VC..
	▲ First choice for medium machining of stainless steels ▲ High surface quality ▲ Little built-up edge		CTPM125 (HCN2125)	CTPM125 (HCN2125)					
Main application stainless steels	-M55 (-PF26)	 M	CTPM125 (HCN2125)	CTPM125 (HCN2125)	CTPM125 (HCN2125)		0,40-4,80	0,06-0,35	CC.. DC.. SC.. TC.. VC..
	▲ First choice for medium machining to roughing of stainless steels ▲ Smooth to lightly interrupted cut ▲ Good swarf control ▲ Stable cutting edge		CTPM125 (HCN2125)	CTPM125 (HCN2125)	CTPM125 (HCN2125)				
			CTPM125 (HCN2125)	CTPM125 (HCN2125)					

Standard chip breakers / application notes



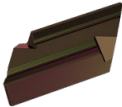


Positive		Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration		Geometry	
						a _p mm	f mm		
Main application stainless steels	-M81 (-M81)	 M	CWN2120 (CWN2120)				1,00-6,00	0,25-0,60	CC.. DC.. VC..
	<ul style="list-style-type: none"> ▲ Directly pressed insert ▲ Positive rake angle ▲ Good swarf control ▲ For medium to rough machining 								
	CWN2120 (CWN2120)		CWN2120 (CWN2120)	CWN2120 (CWN2120)					

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 (-23P)	 F					0,2-4,0	0,05-0,3	CC.. DC..
	<ul style="list-style-type: none"> ▲ Low adhesion ▲ Good chip control with soft aluminium alloys 		H216T (CWK26)	H216T (CWK26)					
			H216T (CWK26)	H216T (CWK26)	H216T (CWK26)				
			H216T (CWK26)	H216T (CWK26)					
	-25P (-25P)	 F M	AMZ (AMZ)	AMZ (AMZ)			0,50-4,50	0,05-0,60	CC.. DC.. SC.. VC..
	<ul style="list-style-type: none"> ▲ Sharp cutting edge ▲ Good swarf control on soft aluminium alloys ▲ Low adhesion 		AMZ (AMZ)	AMZ (AMZ)					
			AMZ (AMZ)	AMZ (AMZ)	AMZ (AMZ)				
			H216T (CWK26)	H216T (CWK26)	H216T (CWK26)				
	-25Q (-25Q)	 M	H210T / AMZ (CWK20 / AMZ)	H210T / AMZ (CWK20 / AMZ)			0,05-6,50	0,05-0,60	CC.. DC.. VC..
	<ul style="list-style-type: none"> ▲ Wiper geometry ▲ High feed rates ▲ High surface quality ▲ Good swarf control on soft aluminium alloys ▲ Low adhesion 		H210T / AMZ (CWK20 / AMZ)	H210T / AMZ (CWK20 / AMZ)					
	H210T / AMZ (CWK20 / AMZ)		H210T / AMZ (CWK20 / AMZ)	H210T / AMZ (CWK20 / AMZ)					
	H210T / AMZ (CWK20 / AMZ)		H210T / AMZ (CWK20 / AMZ)						
-27 (-27)	 M R	AMZ (AMZ)	AMZ (AMZ)			1,00-10,00	0,10-0,75	CC.. DC.. RC.. SC.. TC.. VC..	
<ul style="list-style-type: none"> ▲ The universal Alu geometry ▲ Sharp cutting edge ▲ Extremely positive rake angle ▲ Low adhesion ▲ High feed rates 		AMZ (AMZ)	AMZ (AMZ)						
		AMZ (AMZ)	AMZ (AMZ)	H216T (CWK26)					
		H10T (CWK15)	H10T (CWK15)	H10T (CWK15)					
-29 (-29)	 F R	AMZ (AMZ)	AMZ (AMZ)			1,00-6,00	0,25-0,60	CC.. DC.. VC..	
<ul style="list-style-type: none"> ▲ Direct sintered aluminium geometry ▲ Positive rake angle ▲ Good chip control ▲ For medium to rough machining 		AMZ (AMZ)	AMZ (AMZ)						
		AMZ (AMZ)	AMZ (AMZ)	H216T (CWK26)					
		H216T / AMZ (CWK26 / AMZ)	H216T / AMZ (CWK26 / AMZ)	H216T (CWK26)					

Standard chip breakers / application notes

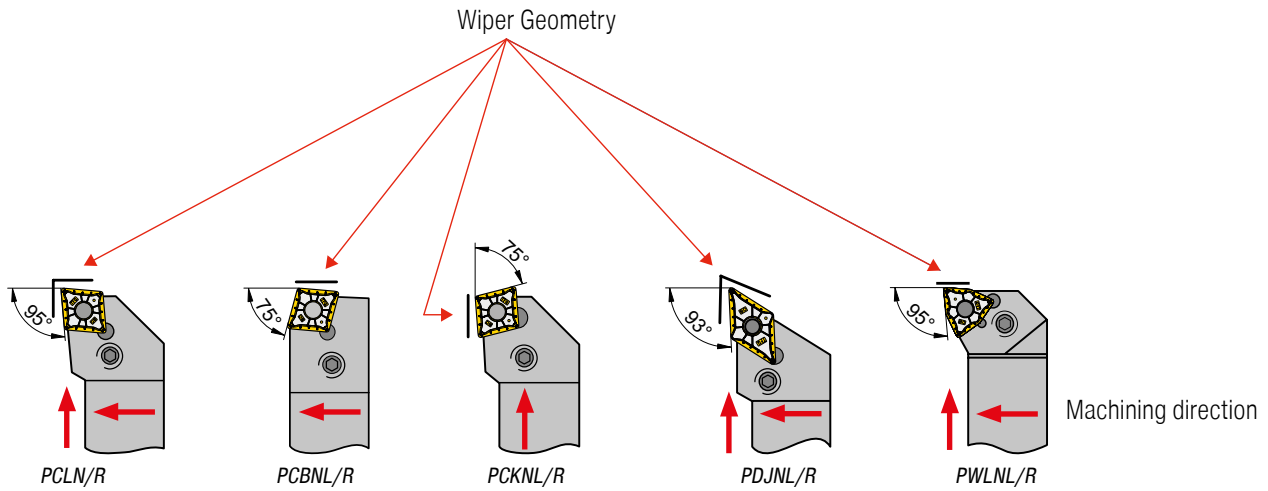
	Positive	Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration		Geometry	
						a_p mm	f mm		
Main application super alloys and stainless steels, secondary application steels and non-ferrous metals	-F05 (-F05) ▲ Maximum tolerance class ▲ Outstanding chip control, even with the smallest cutting depths ▲ Very low cutting forces	 F	CTPX710			 18°	0,10-2,50 0,02-0,25	DC.. VC..	
			CTPX710						
			CTPX710						
			CTPX710						
			CTPX710						
	-F23 (-F23) ▲ Fine finishing (ground edge) ▲ Very high surface quality ▲ High repeatability ▲ Low depths of cut	 F		CTP2120 (CCN2120)	CTP2120 (CCN2120)		 8°	0,10-2,00 0,06-0,13	CC.. DC.. VC..
			CTP2120 (CCN2120)						
			CTP2120 (CCN2120)						
			CTP2120 (CCN2120)						
			CTP2120 (CCN2120)						

Supplementary chip breakers / application notes

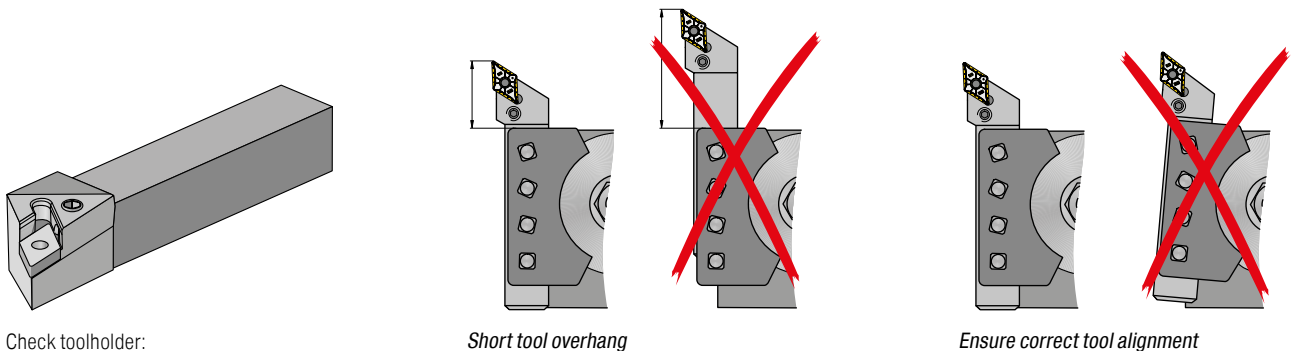
Negative	Model	Smooth cut	Irregular cutting depth	Interrupted cut
				
<p>-11 (-11)</p> <ul style="list-style-type: none"> ▲ For copy machining in finishing operations ▲ On general steels, stainless steels and cast iron ▲ Can be used on less powerful machines 	 <p>F</p>		<p>CTCP125 (HCX1125)</p>	<p>CTCP135 (HCR1135)</p>
<p>-12 (-12)</p> <ul style="list-style-type: none"> ▲ For copy machining in the medium machining range ▲ On general steels, stainless steels and cast iron 	 <p>M</p>		<p>CTCP125 (HCX1125)</p>	<p>CTCP135 (HCR1135)</p>
<p>-EN (-EN)</p> <ul style="list-style-type: none"> ▲ Universal chip breaker for general steels 	 <p>M</p>	<p>CTCP115 HCX1115</p>	<p>CTCP125 (HCX1125)</p>	<p>CTCP135 (HCR1135)</p>
		<p>CTCP125 (HCX1125)</p>	<p>CTCP135 (HCR1135)</p>	<p>CTCP135 (HCR1135)</p>
		<p>CTCK110 DCX3110</p>	<p>CTCK120 HCF3120</p>	<p>CTCP125 (HCX1125)</p>
<p>-ER EL (-ER EL)</p> <ul style="list-style-type: none"> ▲ 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 	 <p>M</p>		<p>CTCP125 (HCX1125)</p>	<p>CTCP135 (HCR1135)</p>

Masterfinish – wiper geometry – notes

Through the use of indexable inserts with wiper edge (-TFQ; -TMQ; -SMQ; -25Q) high quality surfaces can be produced economically.



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



Check toolholder:

- ▲ Insert seat
- ▲ Shim
- ▲ Clamping Lever

Feed rate guide values for surface finish quality

Roughness range R_z in μm	$R_{t\text{max}}$	Corresponds to R_a	Roughness index	ISO 1302	Corner radius r_e in mm and feed rate f in mm/rev.			
					$r_e = 0,4$	$r_e = 0,8$	$r_e = 1,2$	$r_e = 1,6$
63-100	$\sqrt{R_t 100}$	12,5-25	N11	$\frac{25}{\nabla}$		0,51	0,69	0,88
40-63	$\sqrt{R_t 63}$	6,3-25	N10	$\frac{12,5}{\nabla}$	0,27	0,43	0,56	0,68
31,5-40	$\sqrt{R_t 40}$	4,9-6,3	N9	$\frac{6,3}{\nabla}$	0,25	0,37	0,49	0,57
25-31,5	$\sqrt{R_t 31,5}$	4,0-4,9			0,22	0,32	0,41	0,47
16-25	$\sqrt{R_t 25}$	2,5-4,0	N8	$\frac{3,2}{\nabla}$	0,20	0,28	0,36	0,39
10-16	$\sqrt{R_t 16}$	1,6-2,5			0,15	0,22	0,29	0,31
6,3-10	$\sqrt{R_t 10}$	1,0-1,6	N7	$\frac{1,6}{\nabla}$	0,10	0,13	0,18	0,20

Masterfinish – wiper geometry – functional principle

Relationship of feed rate to surface roughness

Improved Surface Quality

With the same feed rate an insert with wiper cutting edge reaches a roughness value R_t which is many times better than a conventional insert.



Shorter machining time

To achieve the same R_t -value as with a standard insert, double the feed rate can be applied for the insert with wiper cutting edge (= shorter production time per component!)



9

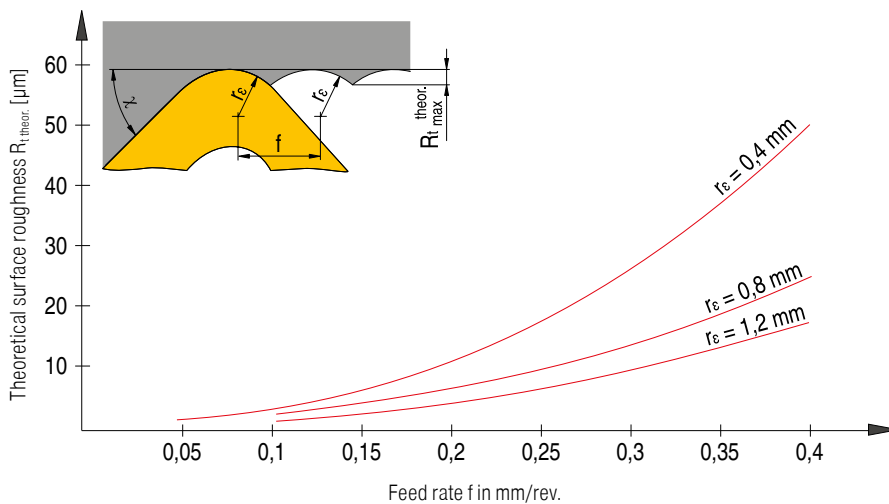
Theoretical Surface Quality

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

or approximately:

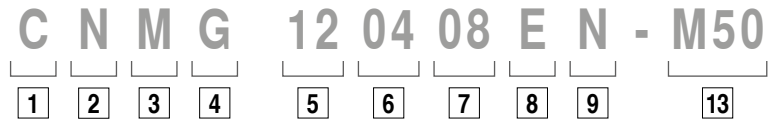
$$R_{t,theor.} = \left(r_\epsilon - \sqrt{r_\epsilon^2 - \frac{f^2}{4}} \right) \cdot 1000$$

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

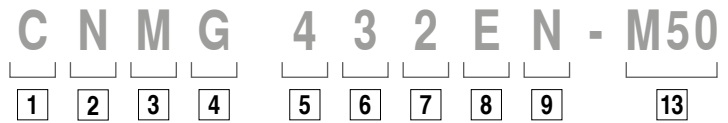


ISO designation system for inserts

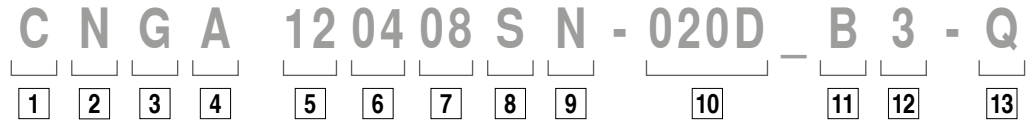
Indexable inserts – metric



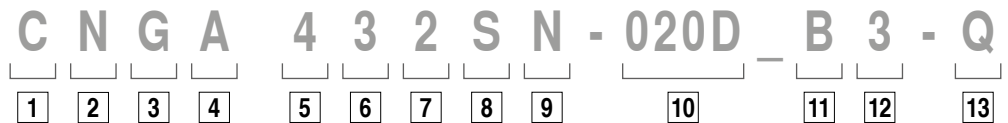
Indexable inserts – inch



Indexable inserts, CBN, ceramic – metric



Indexable inserts, CBN, ceramic – inch



1

Insert shape

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

2

Clearance angle

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

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

3

Tolerances

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

* Depends on insert size

6

Insert thickness

mm		inch		Code	
1,59	1/16	01	1		
2,38	3/32	02			
3,18	1/8	03	2		
3,97	5/32	T3			
4,76	3/16	04	3		
5,56	7/32	05			
6,35	1/4	06	4		
7,94	5/16	07	5		
9,52	3/8	09	6		

7

Corner radius

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

8

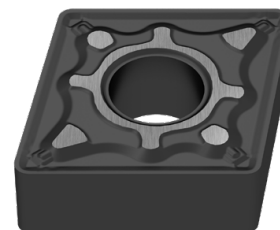
Cutting edge

F	Sharp
E	Honed
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
	06	2	6,4	.250	6,35	.250
	09	3	9,7	.382	9,525	.375
	12	4	12,9	.508	12,70	.500
	16	5	16,1	.634	15,875	.625
	19	6	19,3	.760	19,05	.750
	25	8	25,8	1.016	25,4	1.000
	32	12	35,24	1.269	31,75	1.250
	06	2	6,35	.250	6,35	.250
	09	3	9,525	.375	9,525	.375
	12	4	12,7	.500	12,7	.500
	15	5	15,875	.625	15,875	.625
	19	6	19,05	.750	19,05	.750
	25	8	25,4	1.000	25,4	1.000
	31	10	31,75	1.250	31,75	1.250
	07	2	7,7	.303	6,35	.250
	11	3	11,6	.457	9,525	.375
	15	4	15,5	.610	12,70	.500
	11	2	11,1	.437	6,35	.250
	16	3	16,6	.653	9,525	.375
	22	4	22,10	.870	12,70	.500

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

* inch version

10

Chamfer type

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

1) Two letters are assigned for double-chamfered cutting edges e.g. BE = chamfer angle 1 (y_1) = 10° chamfer angle 2 (y_2) = 25°

11

Number of cutting edges

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

12

Segment length

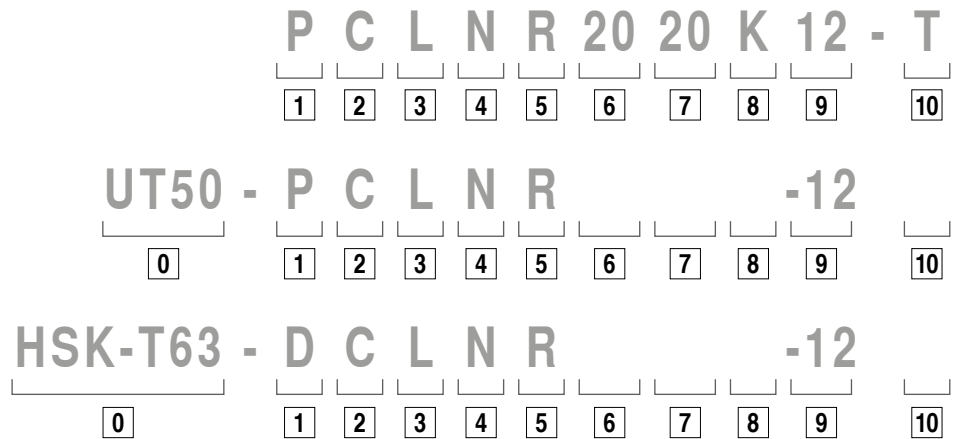
Approx. specification in mm

13

Chip breaker designation

You can find a comprehensive chip breaker overview on → **page 168-175**

ISO designation system for tool holders



0

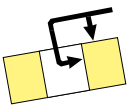
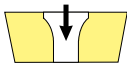
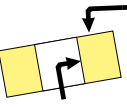
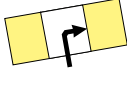

System/size

UT = UTS
according to ISO 26622
UT40 = UTS 40 mm
UT50 = UTS 50 mm
UT63 = UTS 63 mm

HSK-T
according to ISO 12164
HSK-T63 = 63 mm
HSK-T100 = 100 mm

1

Tool holder

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


2

Insert shape

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

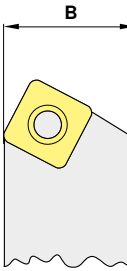
6

Shank height



7

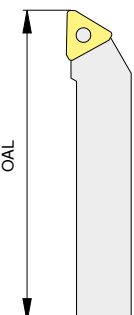
Shank width

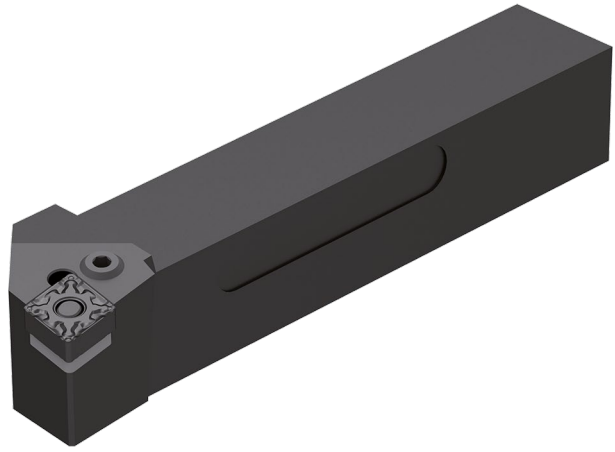


8

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

A 90°	B 75°	C 90°	D 45°	E 60°
F 90°	G 90°	H 107,5°	J 93°	K 75°
L 95°	M 50°	N 63°	P 117,5°	R 75°
S 45°	T 60°	U 93°	V 72,5°	W 60°
				Y 85°

4

Clearance angle

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

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

5

Direction of cut

9

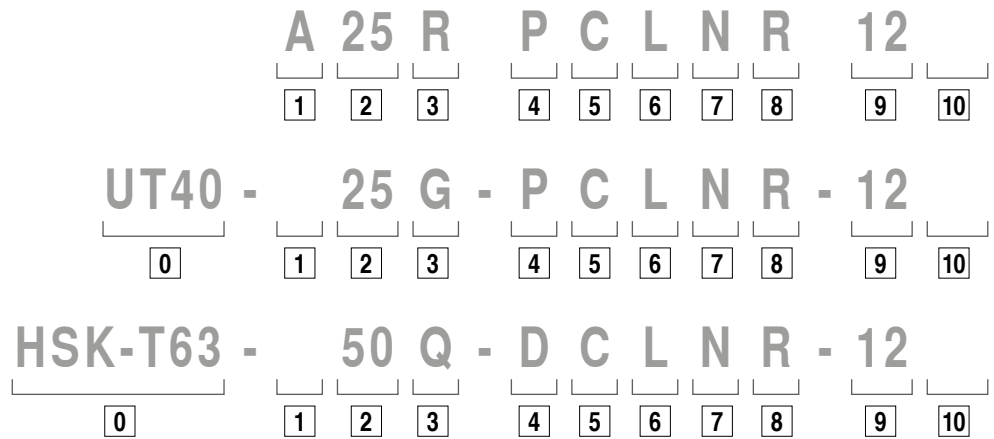
Cutting length

10

Manufacturer specification

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

ISO designation system for boring bars



0

System/size

UT = UTS
according to ISO 26622
UT40 = UTS 40 mm
UT50 = UTS 50 mm
UT63 = UTS 63 mm

HSK-T
according to ISO 12164
HSK-T63 = 63 mm
HSK-T100 = 100 mm



1

Shank type

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

5

Insert shape

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

6


Style

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	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.	



2

Shank diameter

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

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

3

Tool length

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

4

Clamping method

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

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.

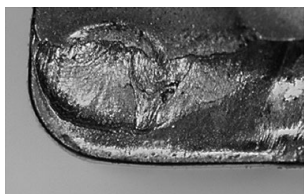
Cause

- ▲ 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.

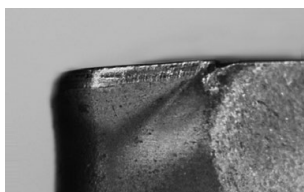
Cause

- ▲ 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.

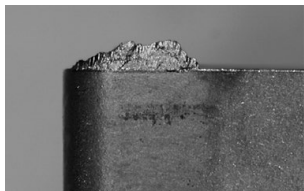
Cause

- ▲ 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.

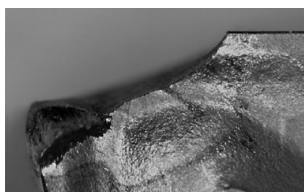
Cause

- ▲ 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

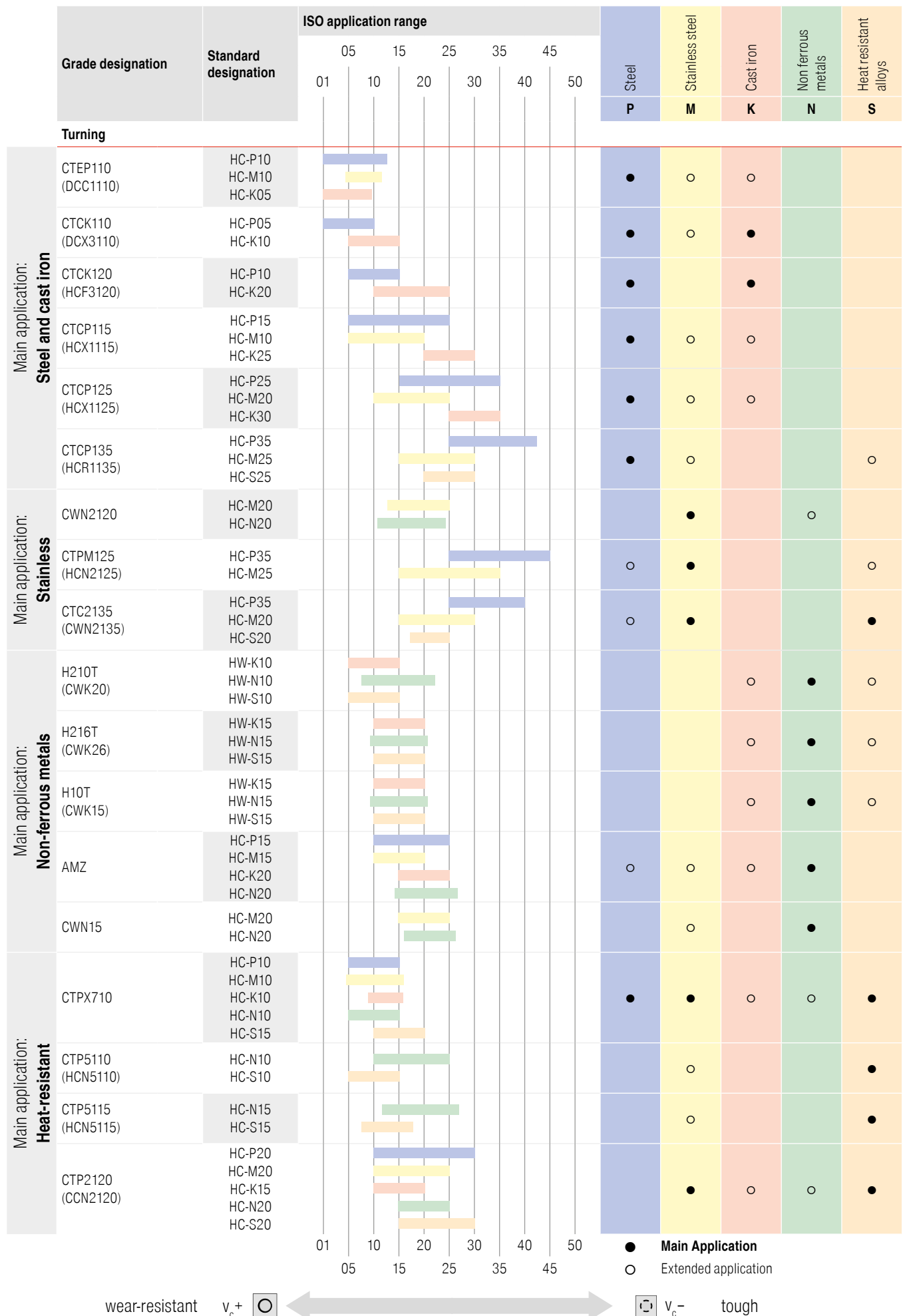
Type of problem																
Type of wear						Work piece problems				Swarf control						
Wear on clearance face	Cratering	Edge chipping	Plastic deformation	Insert breakage	Built-up edge	Vibration	Formation of pits and burrs	Chattered surface	Surface quality	Chip too long (snarl chip)	Chip too short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

raise, increase large influence
 raise, increase small influence

avoid, reduce large influence
 avoid, reduce small influence

check, optimise
 use

Grades Overview



Grade description

TCM407	<ul style="list-style-type: none"> ▲ Cermet, uncoated ▲ ISO P10 M05 K05 ▲ The uncoated cermet grade for super-fine finishing steel materials 	CTCK110	<ul style="list-style-type: none"> ▲ Carbide, TiCN-Al₂O₃-coated ▲ ISO P05 K10 ▲ The wear-resistant grade for machining cast iron materials at high cutting speeds in a continuous cut
CWC407		DCX3110	
CTEP110	<ul style="list-style-type: none"> ▲ Cermet, TiCN-Al₂O₃-coated ▲ ISO P10 M10 K05 ▲ The cermet grade with reserves of toughness for finish machining at high cutting speeds 	CTCK120	<ul style="list-style-type: none"> ▲ Carbide, TiCN-Al₂O₃-coated ▲ ISO P10 K20 ▲ The grade for cast iron machining, with high toughness reserves for difficult conditions and interrupted cuts
DCC1110		HCF3120	
TCM10	<ul style="list-style-type: none"> ▲ Cermet, uncoated ▲ ISO P15 M10 K10 ▲ The uncoated cermet grade for finish machining stainless and hardened steel ▲ Particularly wear resistant thanks to high heat resistance 	H10T	<ul style="list-style-type: none"> ▲ Carbide, uncoated ▲ ISO K15 N15 ▲ The uncoated carbide grade for machining aluminium and other non-ferrous metals
CWC10		CWK15	
CTCP115	<ul style="list-style-type: none"> ▲ Carbide, TiCN-Al₂O₃-coated ▲ ISO P15 M10 K25 ▲ The wear-resistant high-performance grade for stable conditions and a continuous cut 	H210T	<ul style="list-style-type: none"> ▲ Carbide, uncoated ▲ ISO N10 S10 K10 ▲ The wear-resistant carbide grade for machining aluminium and other non-ferrous metals
HXC1115		CWK20	
CTCP125	<ul style="list-style-type: none"> ▲ Carbide, TiCN-Al₂O₃-coated ▲ ISO P25 M20 K30 ▲ The first choice for universal machining of steels 	H216T	<ul style="list-style-type: none"> ▲ Carbide, uncoated ▲ ISO K15 N15 ▲ The uncoated carbide grade for machining aluminium and other non-ferrous metals ▲ Also highly suitable for HSC machining
HXC1125		CWK26	
CTCP135	<ul style="list-style-type: none"> ▲ Carbide, TiCN-Al₂O₃-coated ▲ ISO P35 M25 S25 ▲ The tough alternative for heavily interrupted cut and unstable conditions 	CWN15	<ul style="list-style-type: none"> ▲ Carbide, TiN-coated ▲ ISO K15 ▲ Special carbide grade for abrasive aluminium alloys
HCR1135		CWN15	
CTP2120	<ul style="list-style-type: none"> ▲ Carbide, TiAlN-coated ▲ ISO M20 K20 N20 S20 ▲ The universal carbide grade for stainless steel and super alloys 	AMZ	<ul style="list-style-type: none"> ▲ Carbide, TiAlN-coated ▲ ISO P10 K10 N10 S10 ▲ The coated carbide grade for aluminium machining
CCN2120		AMZ	
CWN2120	<ul style="list-style-type: none"> ▲ Carbide, TiN-coated ▲ ISO M20 K20 N20 ▲ The universal carbide grade for machining stainless steel 	CTP5110	<ul style="list-style-type: none"> ▲ Carbide, TiAlN-coated ▲ ISO M15 S15 ▲ The alternative for machining heat-resistant materials
CWN2120		HCN5110	
CTPM125	<ul style="list-style-type: none"> ▲ ISO P35 M25 S25 ▲ The universal carbide grade with maximum toughness, without affecting the necessary hot hardness and wear resistance for stainless machining 	CTP5115	<ul style="list-style-type: none"> ▲ Carbide, TiAlN-TiN-coated ▲ ISO M15 S15 ▲ The first choice for machining heat-resistant materials
HCN2125		HCN5115	
CTC2135	<ul style="list-style-type: none"> ▲ Carbide, TiCN-TiNB-coated ▲ ISO P35 M30 S35 ▲ The turning grade for general stainless machining 	CTPX710	<ul style="list-style-type: none"> ▲ Carbide, AlTiN-coated ▲ ISO P10 M10 K10 N10 S15 ▲ Universal multi-material grade from the X7 line for highest machining requirements
CWN2135			

Grade description

C	T	C	P	1	2	5	(Example)
H	C	X	1	1	2	5	

Main application – material

1 P	Steel
2 M	Stainless steel
3 K	Cast iron
4 N	Light and non ferrous metals
5 S	Super alloys, titanium
6 H	Hard materials
7 X	Universal application

Application

1	Turning
2	Milling
3	Grooving
4	Drilling
5	Thread turning
6	Others
7	Several processes

Degree of hardness

05	ISO 05
10	ISO 10
15	ISO 15
	...