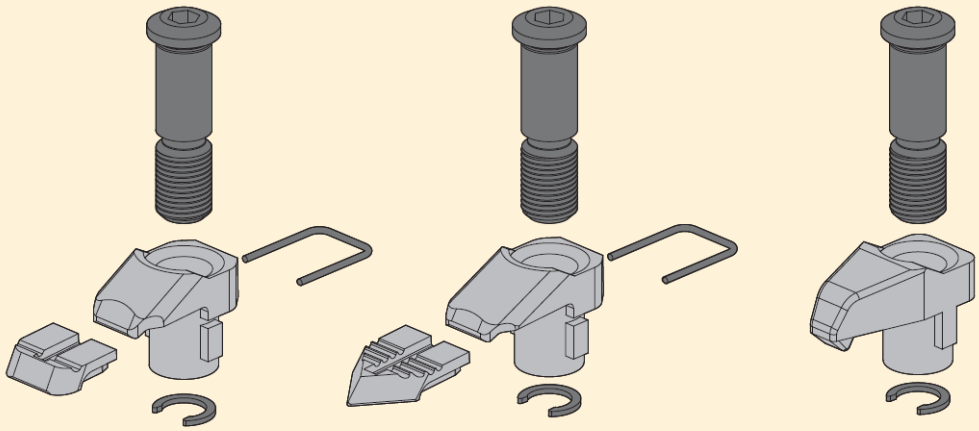
Aydosa®

sinds 1968

Keramiek / boorbaren / draadsnijden 2017

Selecting the clamping system for ceramic tool holders
Wählen des Klemmsystems für Keramik Halter



Clamping element
with thrust plate
Klemmelement mit Druckplatte

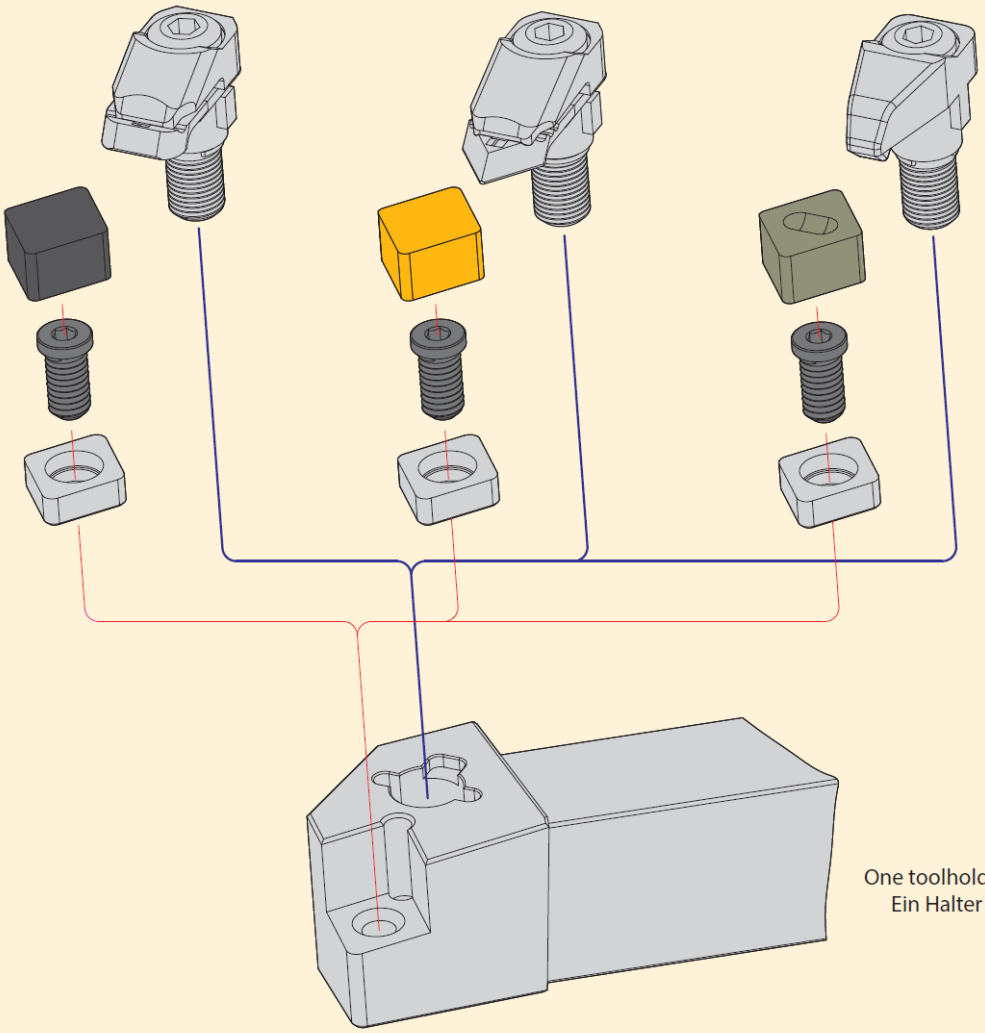
Clamping element
with chip breaker
Klemmelement mit
Spanformer

Notch clamping
Muldenklemmung

ID

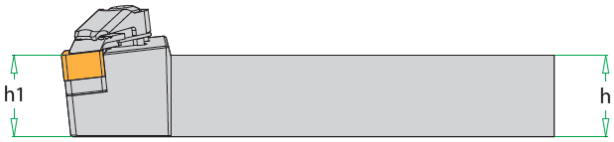
IC

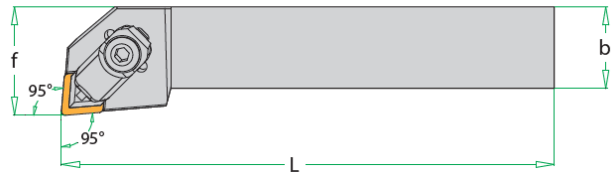
IX

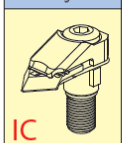
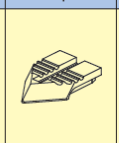
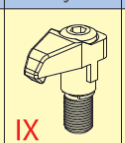
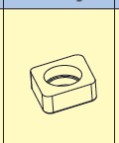
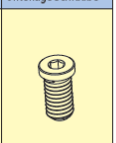


One toolholder 3 clamping systems
Ein Halter mit 3 Klemmsystemen

CCLNR

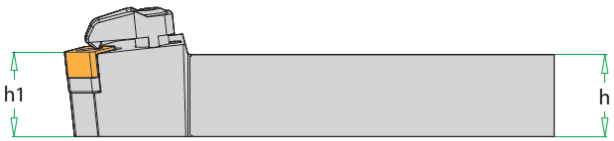


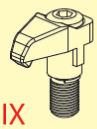


Clamp set IC Klemmfingerset IC	Thrust Plate Druckplatte	Clamp set IX Klemmfingerset IX	Shim Unterlage	Shim Screw Unterlage Schraube
				
PB.30-SET	TK.01	-	AL.63	CV.40
-	-	PB.31-SET	AL.63	CV.40

Code No	h	b	L	h1	f	Inserts Platten
CCLNR-L 2525M 12-IC	25	25	150	25	32	CNGN 1207..
CCLNR-L 2525M 12-IX	25	25	150	25	32	CNGX 1207..

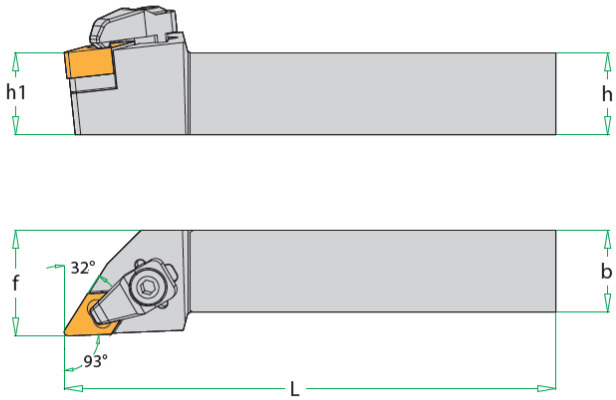
CCSNR



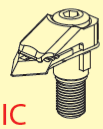
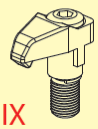
Clamp set IX Klemmfingerset IX	Shim Unterlage	Shim Screw Unterlage Schraube
		
PB.31-SET	AL.63	CV.40

Code No	h	b	L	h1	f	Inserts Platten
CCSNR-L 2525M 12-IX	25	25	150	25	32	CN.. 1207..

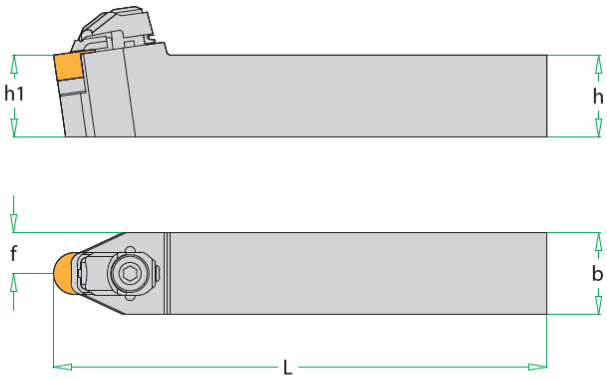
CDJNR



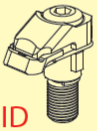
Code No	h	b	L	h1	f	Inserts Platten
CDJNR-L 2525M 15-IC	25	25	150	25	32	DNGN 1507..
CDJNR-L 2525M 15-IX	25	25	150	25	32	DNGX 1507..

Clamp set IC Klemmfingerset IC	Thrust Plate Druckplatte	Clamp set IX Klemmfingerset IX	Shim Unterlage	Shim Screw Unterlage Schraube
 IC		 IX		
PB.30-SET	TK.01	-	AL.64	CV.40
-	-	PB.31-SET	AL.64	CV.40

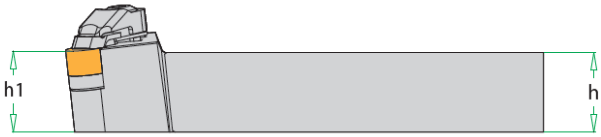
CRDNN

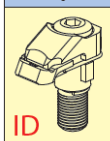


Code No	h	b	L	h1	f	Inserts Platten
CRDNN 2525M 12-ID	25	25	150	25	12,5	RNGN 1207..

Clamp set ID Klemmfingerset ID	Thrust Plate Druckplatte	Shim Unterlage	Shim Screw Unterlage Schraube
 ID			
PB.29-SET	TK.02	AL.57	AP.18

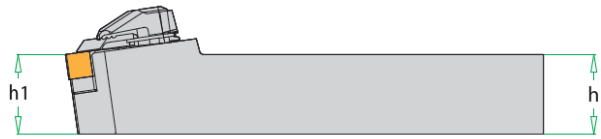
CRSNR

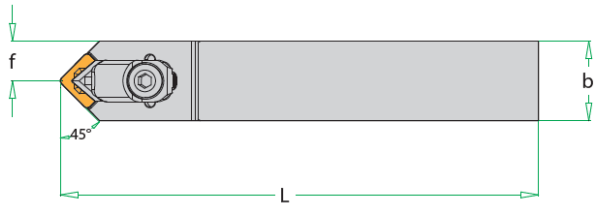


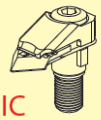
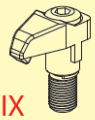
Clamp set ID Klemmfingerset ID	Thrust Plate Druckplatte	Shim Unterlage	Shim Screw Unterlage Schraube
 ID			
PB.29-SET	TK.02	AL.57	AP.18

Code No	h	b	L	h1	f	Inserts Platten
CRSNR-L 2525M 12-ID	25	25	150	25	32	RN.. 1207..

CSDNN

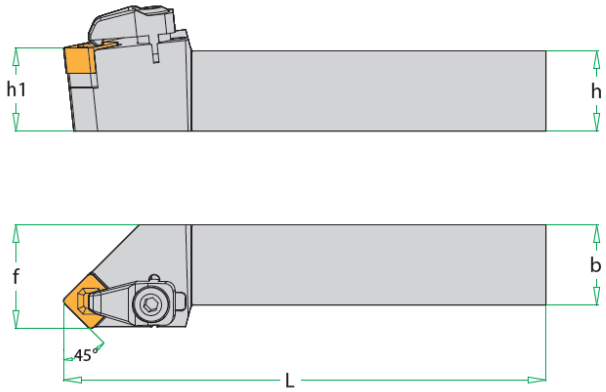




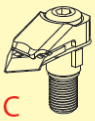
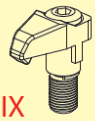
Clamp set IC Klemmfingerset IC	Thrust Plate Druckplatte	Clamp set IX Klemmfingerset IX	Shim Unterlage	Shim Screw Unterlage Schraube
 IC		 IX		
PB.30-SET	TK.01	-	AL.65	CV.40
-	-	PB.31-SET	AL.65	CV.40

Code No	h	b	L	h1	f	Inserts Platten
CSDNN 2525M 12-IC	25	25	150	25	12,5	SNGN 1207..
CSDNN 2525M 12-IX	25	25	150	25	12,5	SNGX 1207..

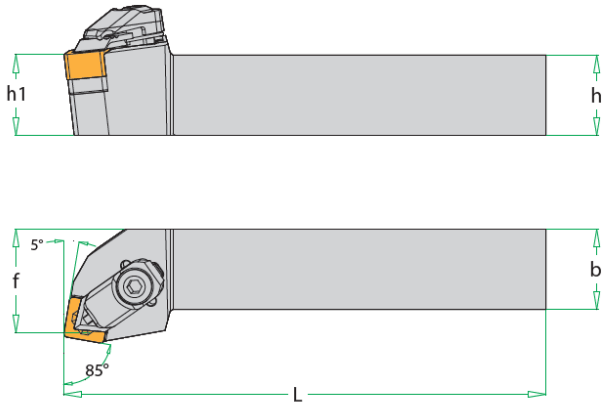
CSSNR



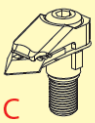
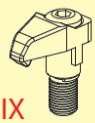
Code No	h	b	L	h1	f	Inserts Platten
CSSNR-L 2525M 12-IC	25	25	150	25	32	SNGN 1207..
CSSNR-L 2525M 12-IX	25	25	150	25	32	SNGX 1207..

Clamp set IC Klemmfingerset IC	Thrust Plate Druckplatte	Clamp set IX Klemmfingerset IX	Shim Unterlage	Shim Screw Unterlage Schraube
 IC		 IX		
PB.30-SET	TK.01	-	AL.65	CV.40
-	-	PB.31-SET	AL.65	CV.40

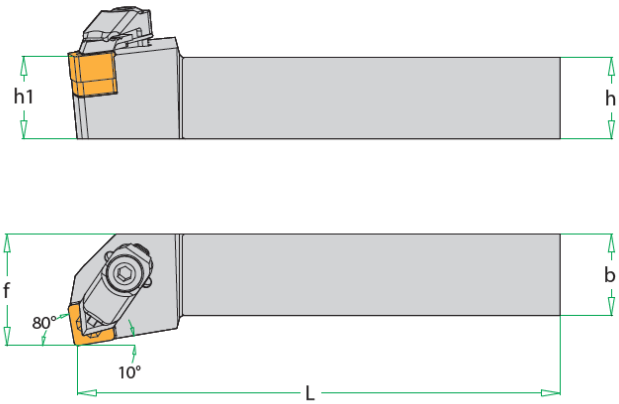
CSXNR



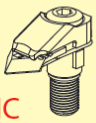
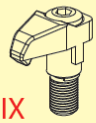
Code No	h	b	L	h1	f	Inserts Platten
CSXNR-L 2525M 12-IC	25	25	150	25	32	SNGN 1207..
CSXNR-L 2525M 12-IX	25	25	150	25	32	SNGX 1207..

Clamp set IC Klemmfingerset IC	Thrust Plate Druckplatte	Clamp set IX Klemmfingerset IX	Shim Unterlage	Shim Screw Unterlage Schraube
 IC		 IX		
PB.30-SET	TK.01	-	AL.65	CV.40
-	-	PB.31-SET	AL.65	CV.40

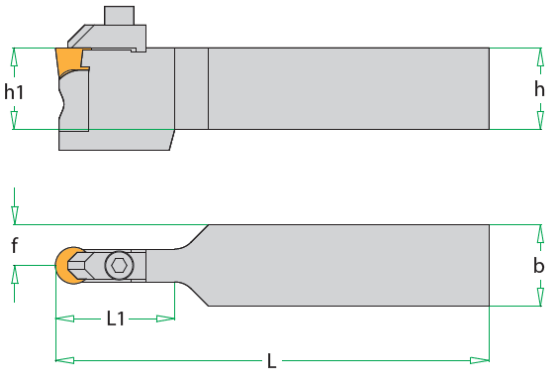
CSYNR



Code No	h	b	L	h1	f	Inserts Platten
CSYNR-L 2525M 12-IC	25	25	150	25	32	SNGN 1207..
CSYNR-L 2525M 12-IX	25	25	150	25	32	SNGX 1207..

Clamp set IC Klemmfingerset IC	Thrust Plate Druckplatte	Clamp set IX Klemmfingerset IX	Shim Unterlage	Shim Screw Unterlage Schraube
 IC		 IX		
PB.30-SET	TK.01	-	AL.65	CV.40
-	-	PB.31-SET	AL.65	CV.40

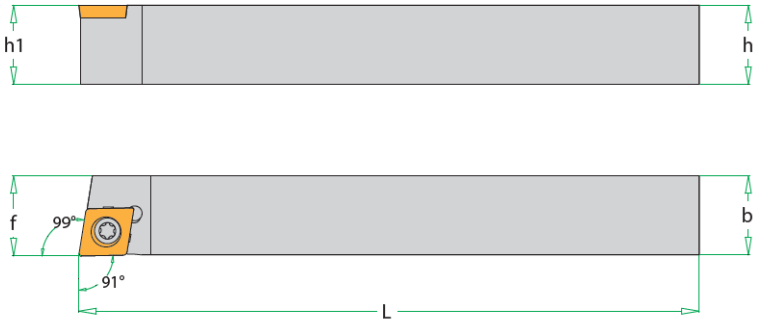
CRDCN



Code No	h	b	L	L1	h1	f	Inserts Platten
CRDCN 3232P 06	32	32	170	19.5	32	16	RCGX 0606..
CRDCN 3232P 09	32	32	170	31.5	32	16	RCGX 0907..
CRDCN 3232P 12	32	32	170	38.5	32	16	RCGX 1207..
CRDCN 3232P 15	32	32	170	41	32	16	RCGX 1510..

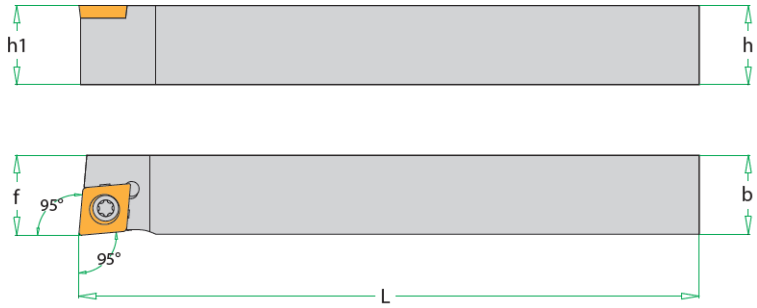
Shim Unterlage	Clamp Pratze	Clamp screw Schraube	Shim Screw Unterlage Schraube
AL.49	PB.26	CV.28	AP.22
AL.50	PB.27	CV.29	AP.23
AL.51	PB.28	CV.30	CV.29
AL.52	PB.28	CV.30	CV.29

SCACR



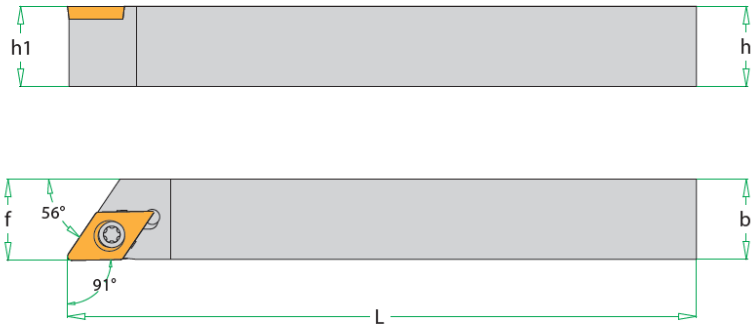
	Code No	h	b	L	h1	f	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
NEW-NEU	SCACR-L 1010K 06	10	10	125	10	10	CCMT 0602..	-	-	CV.20
NEW-NEU	SCACR-L 1212K 06	12	12	125	12	12	CCMT 0602..	-	-	CV.20
NEW-NEU	SCACR-L 1212K 09	12	12	125	12	12	CCMT 09T3..	-	-	CV.18
NEW-NEU	SCACR-L 1616K 09	16	16	125	16	16	CCMT 09T3..	-	-	CV.18

SCLCR



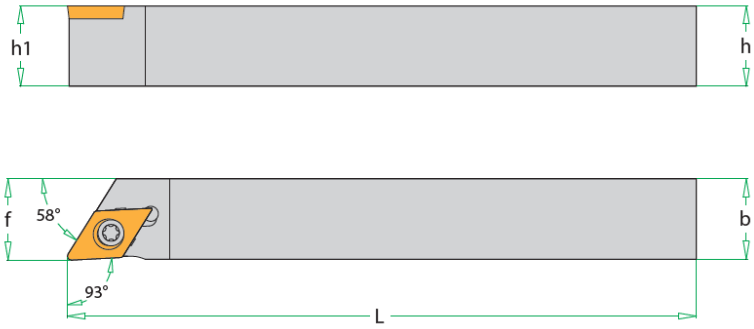
	Code No	h	b	L	h1	f	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
NEW-NEU	SCLCR-L 1010K 06	10	10	125	10	10	CCMT 0602..	-	-	CV.20
NEW-NEU	SCLCR-L 1212K 06	12	12	125	12	12	CCMT 0602..	-	-	CV.20
NEW-NEU	SCLCR-L 1212K 09	12	12	125	12	12	CCMT 09T3..	-	-	CV.18
NEW-NEU	SCLCR-L 1616K 09	16	16	125	16	16	CCMT 09T3..	-	-	CV.18

SDACR



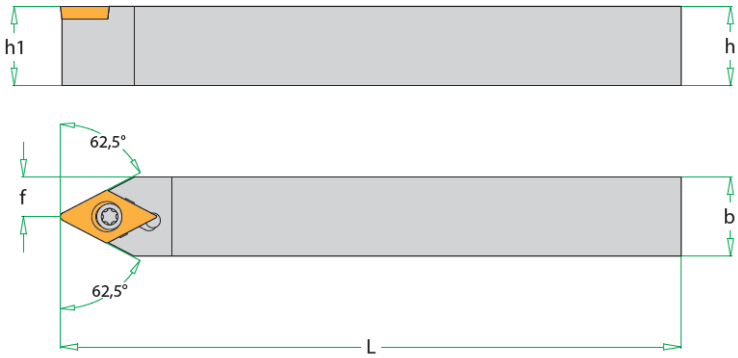
	Code No	h	b	L	h1	f	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
NEW-NEU	SDACR-L 1010K 07	10	10	125	10	10	DCMT 0702..	-	-	CV.20
NEW-NEU	SDACR-L 1212K 11	12	12	125	12	12	DCMT 11T3..	-	-	CV.18
NEW-NEU	SDACR-L 1616K 11	16	16	125	16	16	DCMT 11T3..	-	-	CV.18

SDJCR



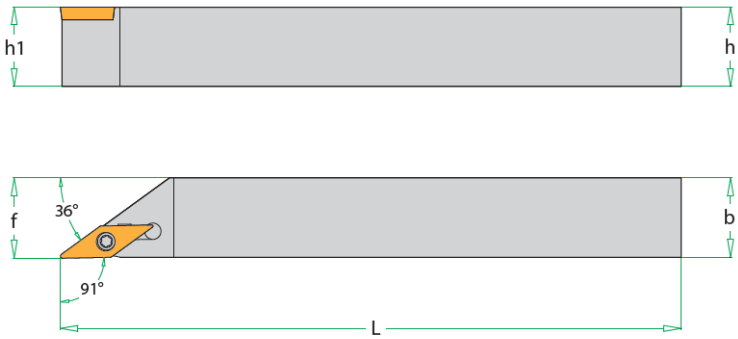
	Code No	h	b	L	h1	f	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
NEW-NEU	SDJCR-L 1212K 11	12	12	125	12	12	DCMT 11T3..	-	-	CV.18
NEW-NEU	SDJCR-L 1616K 11	16	16	125	16	16	DCMT 11T3..	-	-	CV.18

SDNCN



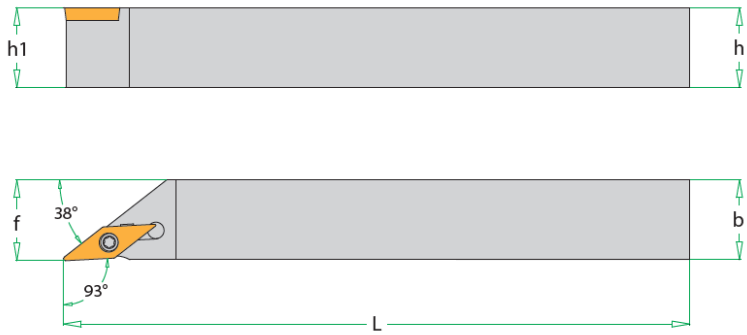
	Code No	h	b	L	h1	f	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
NEW-NEU	SDNCN 1010K 07	10	10	125	10	5	DCMT 0702..	-	-	CV.20
NEW-NEU	SDNCN 1212K 11	12	12	125	12	6	DCMT 11T3..	-	-	CV.18
NEW-NEU	SDNCN 1616K 11	16	16	125	16	8	DCMT 11T3..	-	-	CV.18

SVABR



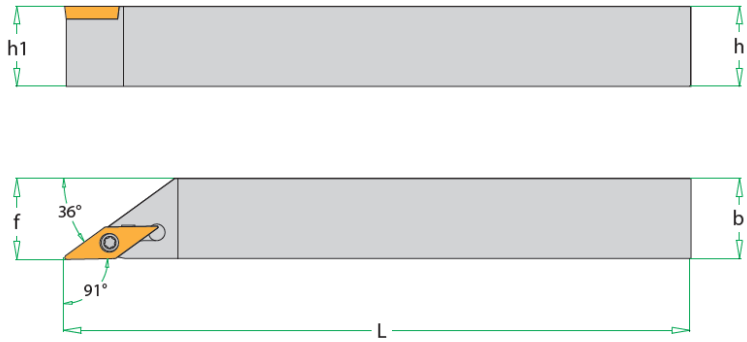
	Code No	h	b	L	h1	f	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
NEW-NEU	SVABR-L 1010K 11	10	10	125	10	10	VBMT 1103..	-	-	CV.20
NEW-NEU	SVABR-L 1212K 11	12	12	125	12	12	VBMT 1103..	-	-	CV.20
NEW-NEU	SVABR-L 1616K 11	16	16	125	16	16	VBMT 1103..	-	-	CV.20

SVJBR



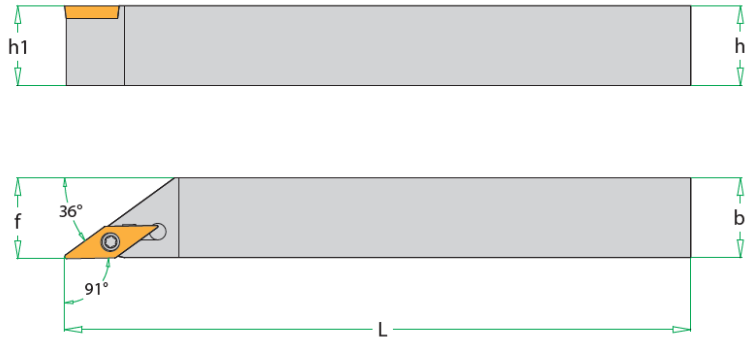
	Code No	h	b	L	h1	f	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
NEW-NEU	SVJBR-L 1010K 11	10	10	125	10	10	VBMT 1103..	-	-	CV.20
NEW-NEU	SVJBR-L 1212K 11	12	12	125	12	12	VBMT 1103..	-	-	CV.20
NEW-NEU	SVJBR-L 1616K 11	16	16	125	16	16	VBMT 1103..	-	-	CV.20

SVACR



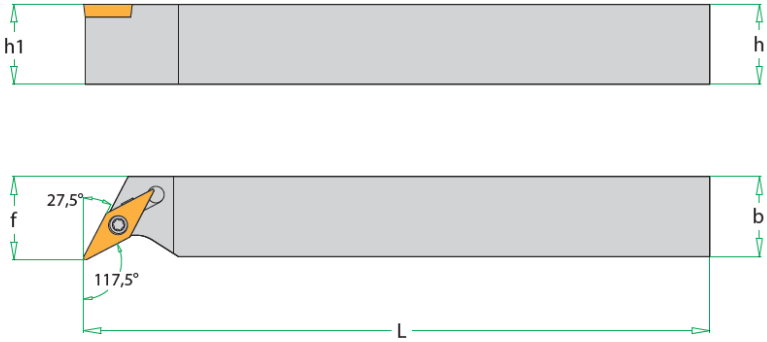
	Code No	h	b	L	h1	f	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
NEW-NEU	SVACR-L 1010K 11	10	10	125	10	10	VCMT 1103..	-	-	CV.20
NEW-NEU	SVACR-L 1212K 11	12	12	125	12	12	VCMT 1103..	-	-	CV.20
NEW-NEU	SVACR-L 1616K 11	16	16	125	16	16	VCMT 1103..	-	-	CV.20

SVJCR



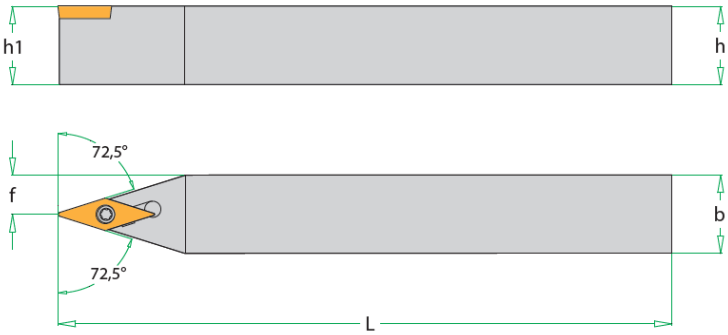
	Code No	h	b	L	h1	f	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
NEW-NEU	SVJCR-L 1010K 11	10	10	125	10	10	VCMT 1103..	-	-	CV.20
NEW-NEU	SVJCR-L 1212K 11	12	12	125	12	12	VCMT 1103..	-	-	CV.20
NEW-NEU	SVJCR-L 1616K 11	16	16	125	16	16	VCMT 1103..	-	-	CV.20

SVPCR



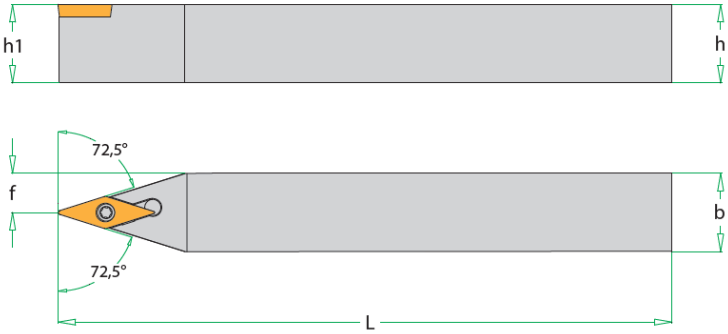
	Code No	h	b	L	h1	f	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
NEW-NEU	SVPCR-L 1010K 11	10	10	125	10	10,6	VCMT 1103..	-	-	CV.20
NEW-NEU	SVPCR-L 1212K 11	12	12	125	12	12,6	VCMT 1103..	-	-	CV.20
NEW-NEU	SVPCR-L 1616K 11	16	16	125	16	16,6	VCMT 1103..	-	-	CV.20

SVVBN



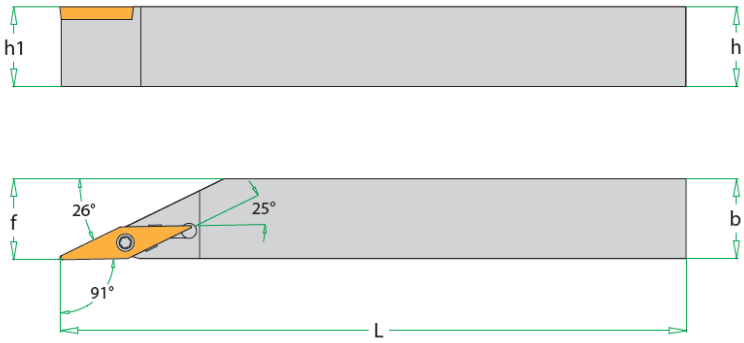
	Code No	h	b	L	h1	f	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
NEW-NEU	SVVBN 1010K 11	10	10	125	10	5	VBMT 1103..	-	-	CV.20
NEW-NEU	SVVBN 1212K 11	12	12	125	12	6	VBMT 1103..	-	-	CV.20
NEW-NEU	SVVBN 1616K 11	16	16	125	16	8	VBMT 1103..	-	-	CV.20

SVVCN



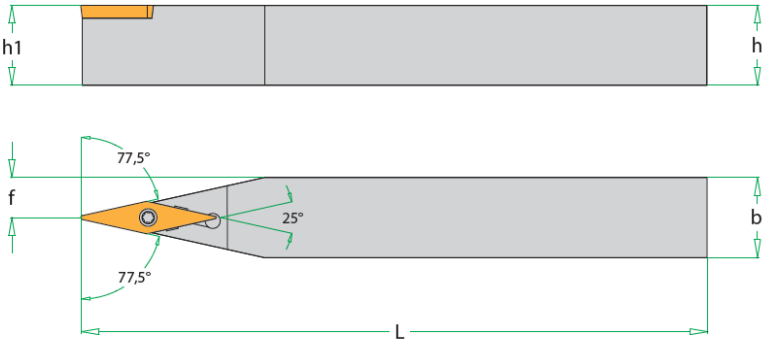
	Code No	h	b	L	h1	f	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
NEW-NEU	SVVCN 1010K 11	10	10	125	10	5	VCMT 1103..	-	-	CV.20
NEW-NEU	SVVCN 1212K 11	12	12	125	12	6	VCMT 1103..	-	-	CV.20
NEW-NEU	SVVCN 1616K 11	16	16	125	16	8	VCMT 1103..	-	-	CV.20

SXACR



	Code No	h	b	L	h1	f	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
NEW-NEU	SXACR-L 1010K 15	10	10	125	10	10	XCMT 1503..	-	-	CV.20
NEW-NEU	SXACR-L 1212K 15	12	12	125	12	12	XCMT 1503..	-	-	CV.20
NEW-NEU	SXACR-L 1616K 15	16	16	125	16	16	XCMT 1503..	-	-	CV.20

SXVCN



	Code No	h	b	L	h1	f	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
NEW-NEU	SXVCN 1010K 15	10	10	125	10	5	XCMT 1503..	-	-	CV.20
NEW-NEU	SXVCN 1212K 15	12	12	125	12	6	XCMT 1503..	-	-	CV.20
NEW-NEU	SXVCN 1616K 15	16	16	125	16	8	XCMT 1503..	-	-	CV.20

Internal Turning Code Key - Innendrehen Code-Schlüssel

Extract from ISO - Extrakte von ISO

S	25	T	D	W	L	N	R	08
1	2	3	4	5	6	7	8	9

1 Clamping System Klemmsystem

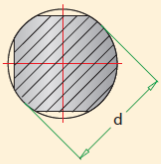
A : Steel bar with internal coolant supply

C : Carbide Shank Bar

E : Coolant Through Carbide Shank

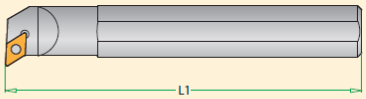
S : Steel Shank

2 Shank Diameter mm Schaftdurchmesser mm



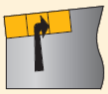
8 = 08	25 = 25
10 = 10	32 = 32
12 = 12	40 = 40
16 = 16	50 = 50
20 = 20	60 = 60

3 Tool Length - Werkzeug Gesamtlänge L mm



F = 80	M = 150	R = 200	V = 400
H = 100	N = 160	S = 250	W = 450
K = 125	P = 170	T = 300	Y = 500
L = 140	Q = 180	U = 350	X = Special

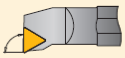
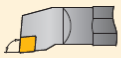
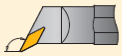
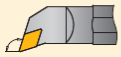
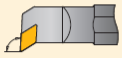
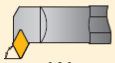
4 Clamping System - Klemmsystem

Top clamping Spannhebel Klemmung C	Top and hole clamping Doppel Klemmsystem D	Wedge clamping Doppel Pratzenklemmung M
Lever clamping Kniehebel Spannung  P	Screw clamping Schrauben Klemmsystem S	

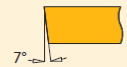
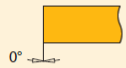
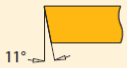
5 Insert Shape - Plattenform

C	D
K	R
S	T
V	W

6 Approach Angle - Anstellwinkel Halter

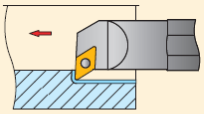
90°  F	95°  L
117,5°  P	107,5°  Q
93°  U	62,5°  W

7 Insert Clearance Angle - WSP Freiwinkel

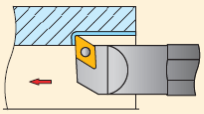
A	B	C 
D	E	F
G	N 	P 

8 Hand of Tool-Vorschubrichtung

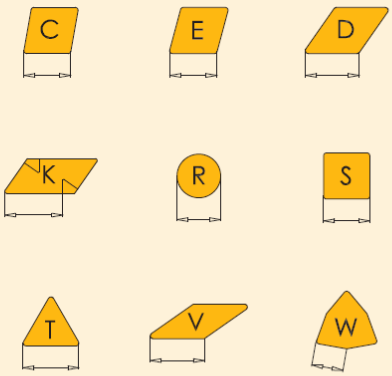
R



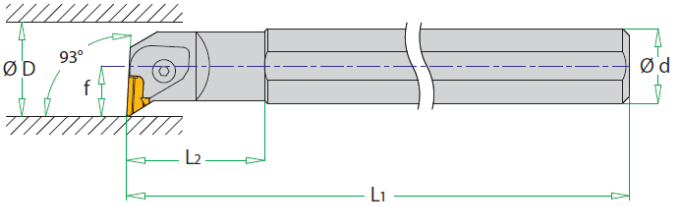
L



9 Cutting Edge Length WSP Schneidkantenlänge in mm

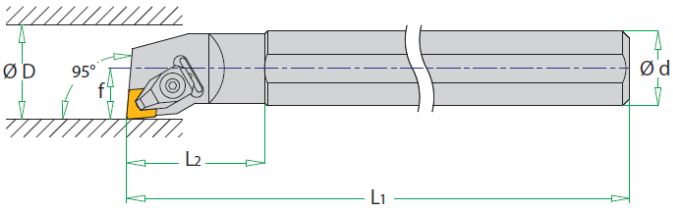


CKUNR



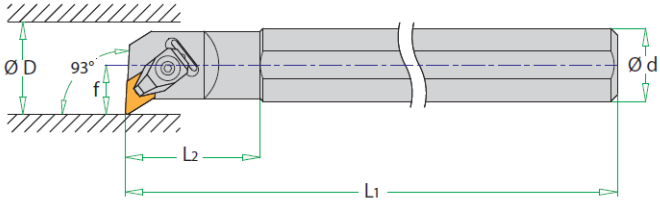
Code No	d	L1	L2	f	D	Inserts Platten	Shim Unterlage	Clamp Pratze	Screw Schraube	Spring Feder	Shim Pin Rohrstift	Clamping Stud Passstift
S32S CKUNR 16	32	250	60	22	44	KNUX 1604..	AL.10L	PB.10L	CV.10	YY.10	AP.10	YP.10A
S40T CKUNR 16	40	300	70	27	48	KNUX 1604..	AL.10L	PB.10L	CV.10	YY.10	AP.10	YP.10A

DCLNR



Code No	d	L1	L2	f	D	Inserts Platten	Shim Unterlage	Clamp Pratze	Screw Schraube	Spring Feder	Shim Screw Passstift
S25R DCLNR-L 12	25	200	55	17	32	CNMG 1204..	AL.34	PB.20	CV.15	YY.13	AP.18
S32S DCLNR-L 12	32	250	60	22	40	CNMG 1204..	AL.34	PB.20	CV.15	YY.13	AP.18
S40T DCLNR-L 12	40	300	65	27	50	CNMG 1204..	AL.34	PB.20	CV.15	YY.13	AP.18
S40T DCLNR-L 16	40	300	65	27	50	CNMG 1606..	AL.35	PB.21	CV.15	YY.13	AP.20

DDUNR

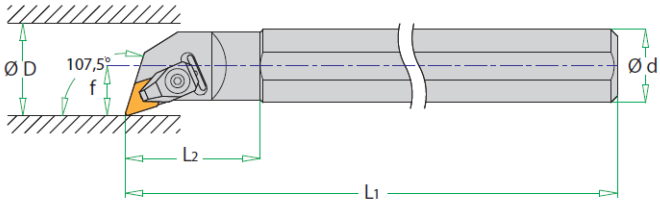


	Code No	d	L1	L2	f	D	Inserts Platten	Shim Unterlage	Clamp Pratze	Screw Schraube	Spring Feder	Shim Screw Passstift
	S20Q DDUNR-L 11	20	180	45	14	27	DNMG 1104..	-	PB.19A	CV.27A	YY.12	-
	S25R DDUNR-L 11	25	200	55	17	32	DNMG 1104..	AL.42	PB.19A	CV.27A	YY.12	AP.17
	S32S DDUNR-L 11	32	250	55	22	40	DNMG 1104..	AL.42	PB.19A	CV.27A	YY.12	AP.17
*	S32S DDUNR-L 15	32	250	55	22	40	DNMG 1506..	AL.40	PB.20	CV.15	YY.13	AP.17
*	S40T DDUNR-L 15	40	300	65	27	50	DNMG 1506..	AL.40	PB.20	CV.15	YY.13	AP.17

* If you change the shim and use AL-45 on the marked toolholders you can mount also coded insert DNMG 1504..

* Wenn Sie die Unterlage wechseln und AL-45 auf den markierten Werkzeughalter verwenden, können Sie auch die DNMG 1504.. codierte WSP montieren

DDQNR

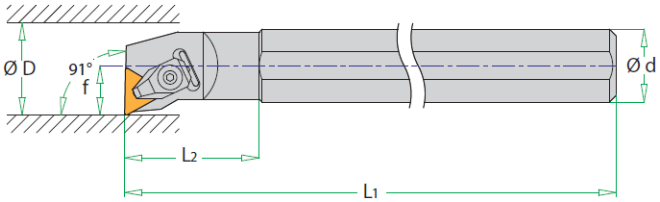


	Code No	d	L1	L2	f	D	Inserts Platten	Shim Unterlage	Clamp Pratze	Screw Schraube	Spring Feder	Shim Screw Passstift
	S20Q DDQNR-L 11	20	180	45	13	25	DNMG 1104..	-	PB.19A	CV.27A	YY.12	-
	S25R DDQNR-L 11	25	200	55	17	32	DNMG 1104..	AL.42	PB.19A	CV.27A	YY.12	AP.17
	S32S DDQNR-L 11	32	250	55	22	40	DNMG 1104..	AL.42	PB.19A	CV.27A	YY.12	AP.17
*	S32S DDQNR-L 15	32	250	55	22	40	DNMG 1506..	AL.40	PB.20	CV.15	YY.13	AP.17
*	S40T DDQNR-L 15	40	300	65	27	50	DNMG 1506..	AL.40	PB.20	CV.15	YY.13	AP.17

* If you change the shim and use AL-45 on the marked toolholders you can mount also coded insert DNMG 1504..

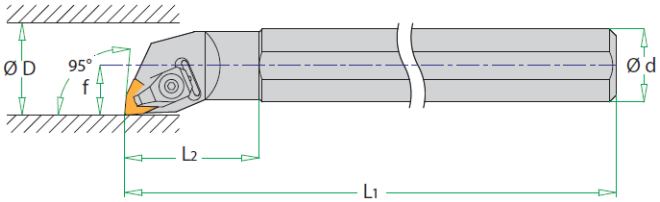
* Wenn Sie die Unterlage wechseln und AL-45 auf den markierten Werkzeughalter verwenden, können Sie auch die DNMG 1504.. codierte WSP montieren

DTFNR



Code No	d	L1	L2	f	D	Inserts Platten	Shim Unterlage	Clamp Pratze	Screw Schraube	Spring Feder	Shim Screw Passstift
S25R DTFNR-L 16	25	200	55	17	32	TNMG 1604..	AL.22	PB.19A	CV.27A	YY.12	AP.17
S32S DTFNR-L 16	32	250	60	22	40	TNMG 1604..	AL.22	PB.19	CV.27	YY.12	AP.17
S40T DTFNR-L 16	40	300	65	27	50	TNMG 1604..	AL.22	PB.19	CV.27	YY.12	AP.17
S32S DTFNR-L 22	32	250	60	22	40	TNMG 2204..	AL.38	PB.20	CV.15	YY.13	AP.19
S40T DTFNR-L 22	40	300	65	27	50	TNMG 2204..	AL.38	PB.20	CV.15	YY.13	AP.19

DWLNR

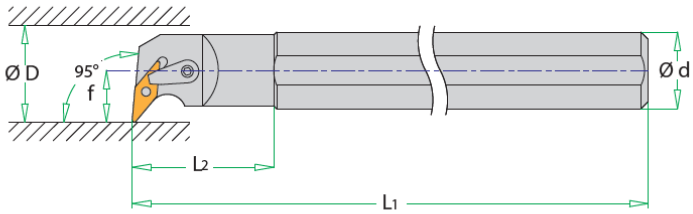


	Code No	d	L1	L2	f	D	Inserts Platten	Shim Unterlage	Clamp Pratze	Screw Schraube	Spring Feder	Shim Screw Passstift
	S20Q DWLNR-L 06-T3	20	180	45	13	26	WNMG 06T3..	AL.43	PB.19A	CV.27A	YY.12	AP.17
	S20Q DWLNR-L 06	20	180	45	13	26	WNMG 0604..	-	PB.19A	CV.27A	YY.12	-
*	S25R DWLNR-L 06	25	200	50	17	32	WNMG 0604..	AL.43	PB.19A	CV.27A	YY.12	AP.17
*	S32S DWLNR-L 06	32	250	55	22	40	WNMG 0604..	AL.43	PB.19	CV.27	YY.12	AP.17
	S25R DWLNR-L 08	25	200	55	17	32	WNMG 0804..	AL.33	PB.20	CV.15	YY.13	AP.18
	S32S DWLNR-L 08	32	250	60	22	40	WNMG 0804..	AL.33	PB.20	CV.15	YY.13	AP.18
	S40T DWLNR-L 08	40	300	65	27	50	WNMG 0804..	AL.33	PB.20	CV.15	YY.13	AP.18

* If you change the shim and use AL-44 on the marked toolholders you can mount also coded insert WNMG 06T3..

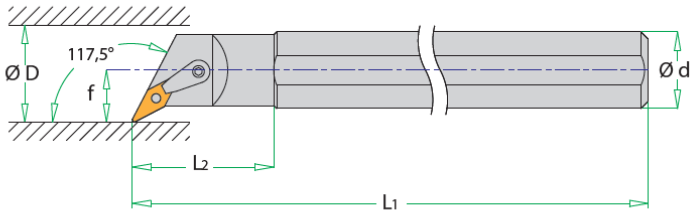
* Wenn Sie die Unterlage wechseln und AL-44 auf den markierten Werkzeughalter verwenden, können Sie auch die WNMG 06T3.. codierte WSP montieren

MVLNR



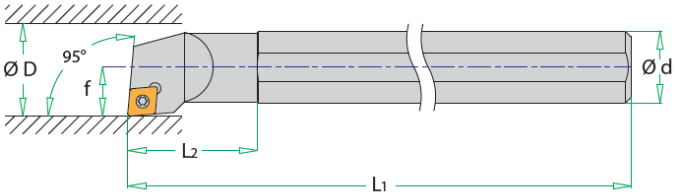
Code No	d	L1	L2	f	D	Inserts Platten	Shim Unterlage	Clamp Pratze	Clamp screw Schraube	Shim Screw Passstift
S25R MVLNR-L 16	25	200	50	17	32	VNMG 1604..	AL.41	PB.23	CV.25	AP.15
S32S MVLNR-L 16	32	250	55	22	40	VNMG 1604..	AL.41	PB.23	CV.25	AP.15
S40T MVLNR-L 16	40	300	60	27	50	VNMG 1604..	AL.41	PB.23	CV.25	AP.15

MVPNR



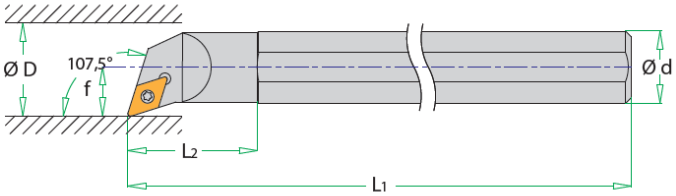
Code No	d	L1	L2	f	D	Inserts Platten	Shim Unterlage	Clamp Pratze	Clamp screw Schraube	Shim Screw Passstift
S25R MVPNR-L 16	25	200	50	17	32	VNMG 1604..	AL.41	PB.23	CV.25	AP.15
S32S MVPNR-L 16	32	250	55	22	40	VNMG 1604..	AL.41	PB.23	CV.25	AP.15
S40T MVPNR-L 16	40	300	60	27	50	VNMG 1604..	AL.41	PB.23	CV.25	AP.15

SCLCR



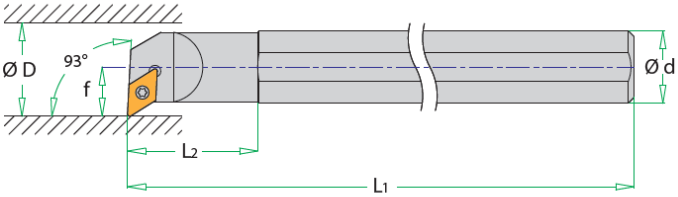
Code No	d	L1	L2	f	D	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
S08F SCLCR-L 06	8	80	22	6	11	CCMT 0602..	-	-	CV.20A
S10H SCLCR-L 06	10	100	24	7	13	CCMT 0602..	-	-	CV.20
S12K SCLCR-L 06	12	125	27	9	16	CCMT 0602..	-	-	CV.20
S16M SCLCR-L 06	16	150	32	11	20	CCMT 0602..	-	-	CV.20
S16M SCLCR-L 09	16	150	32	11	20	CCMT 09T3..	-	-	CV.23
S20Q SCLCR-L 09	20	180	40	13	25	CCMT 09T3..	-	-	CV.18
S25R SCLCR-L 09	25	200	45	17	32	CCMT 09T3..	-	-	CV.18
S25R SCLCR-L 12	25	200	45	17	32	CCMT 1204..	-	-	CV.17

SDQCR



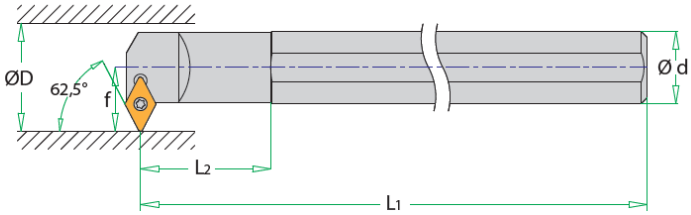
Code No	d	L1	L2	f	D	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
S10H SDQCR-L 07	10	100	24	7	13	DCMT 0702..	-	-	CV.20
S12K SDQCR-L 07	12	125	27	9	16	DCMT 0702..	-	-	CV.20
S16M SDQCR-L 07	16	150	32	11	20	DCMT 0702..	-	-	CV.20
S16M SDQCR-L 11	16	150	32	11	20	DCMT 11T3..	-	-	CV.23
S20Q SDQCR-L 11	20	180	40	13	25	DCMT 11T3..	-	-	CV.18
S25R SDQCR-L 11	25	200	45	17	32	DCMT 11T3..	-	-	CV.18

SDUCR



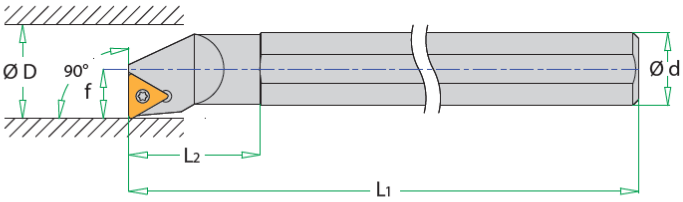
Code No	d	L1	L2	f	D	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
S10H SDUCR-L 07	10	100	24	7	13	DCMT 0702..	-	-	CV.20
S12K SDUCR-L 07	12	125	27	9	16	DCMT 0702..	-	-	CV.20
S16M SDUCR-L 07	16	150	32	11	20	DCMT 0702..	-	-	CV.20
S16M SDUCR-L 11	16	150	32	11	20	DCMT 11T3..	-	-	CV.23
S20Q SDUCR-L 11	20	180	40	13	25	DCMT 11T3..	-	-	CV.18
S25R SDUCR-L 11	25	200	45	17	32	DCMT 11T3..	-	-	CV.18

SDWCR



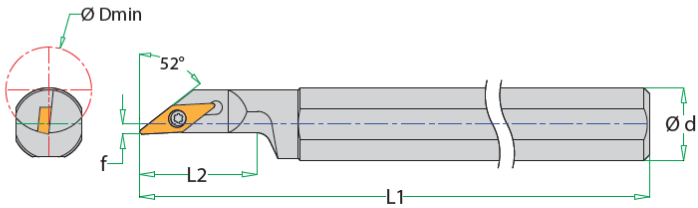
Code No	d	L1	L2	f	D	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
S12K SDWCR 07	12	125	27	11	19	DCMT 0702..	-	-	CV.20
S16M SDWCR 07	16	150	32	13	23	DCMT 0702..	-	-	CV.20
S20Q SDWCR 11	20	180	40	17	29	DCMT 11T3..	-	-	CV.18
S25R SDWCR 11	25	200	45	22	37	DCMT 11T3..	-	-	CV.18

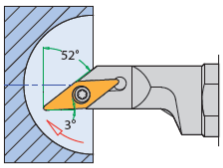
STFCR



Code No	d	L1	L2	f	D	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
S10H STFCR-L 11	10	100	24	7	13	TCMT 1102..	-	-	CV.20
S12K STFCR-L 11	12	125	27	9	16	TCMT 1102..	-	-	CV.20
S16M STFCR-L 11	16	150	32	11	20	TCMT 1102..	-	-	CV.20
S20Q STFCR-L 16	20	180	40	13	25	TCMT 16T3..	-	-	CV.18
S25R STFCR-L 16	25	200	45	17	32	TCMT 16T3..	-	-	CV.18

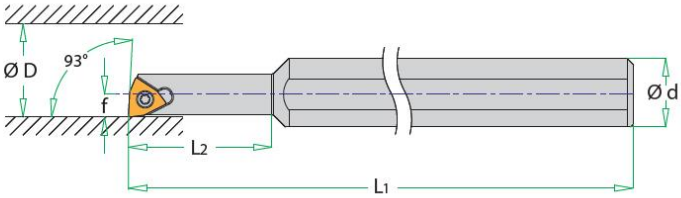
SVJCR



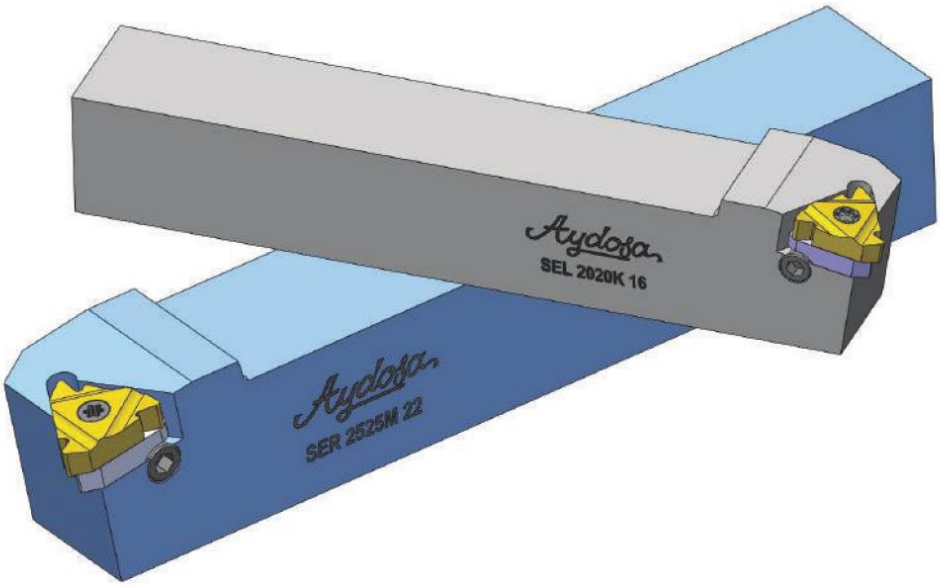


Code No	d	L1	L2	f	ØD	Inserts Platten	Screw Schraube	Shim Unterlage	Shim Screw Unterlage Schraube
S16M SVJCR 11	16	150	35	2	20	VCMT 1103..	CV.20	-	-
S20Q SVJCR 11	20	180	42.5	2	25	VCMT 1103..	CV.20	-	-
S25R SVJCR 16	25	200	45	3	30	VCMT 1604..	CV.18	-	-

SWUBR

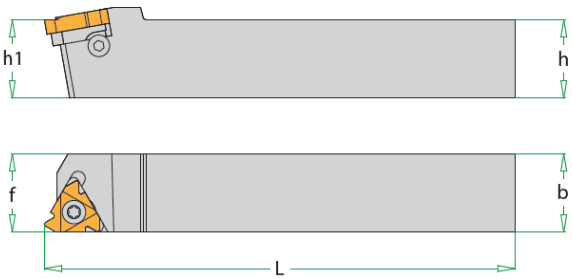


Code No	d	L1	L2	f	D	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
S0610H SWUBR-L 06	10	100	20	3	6	WBMT 0602..	-	-	CV.41
S0710H SWUBR-L 06	10	100	24	3,5	7	WBMT 0602..	-	-	CV.41
S0810H SWUBR-L 06	10	100	32	4	8	WBMT 0602..	-	-	CV.41



SER

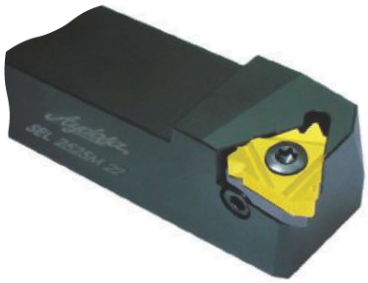
AYDOSA toolholders are manufactured with 1,5° helix angle
AYDOSA Werkzeugehalter werden mit 1,5° Steigungswinkel hergestellt

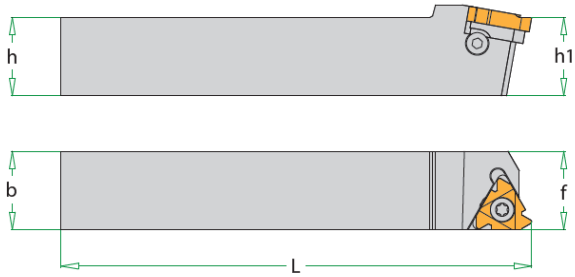


Code No	h	b	L	h1	f	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
SER 1212F 11	12	12	80	12	12	11 ER..	-	-	CV.20
SER 1616H 11	16	16	100	16	16	11 ER..	-	-	CV.20
SER 1212H 16	12	12	100	12	12	16 ER..	AL.53	CV.32	CV.34
SER 1616H 16	16	16	100	16	16	16 ER..	AL.53	CV.32	CV.34
SER 2020K 16	20	20	125	20	20	16 ER..	AL.53	CV.32	CV.34
SER 2525M 16	25	25	150	25	25	16 ER..	AL.53	CV.32	CV.34
SER 2525M 22	25	25	150	25	25	22 ER..	AL.55	CV.33	CV.35
SER 3232P 22	32	32	170	32	32	22 ER..	AL.55	CV.33	CV.35

SEL

AYDOSA toolholders are manufactured with 1,5° helix angle
AYDOSA Werkzeugehalter werden mit 1,5° Steigungswinkel hergestellt

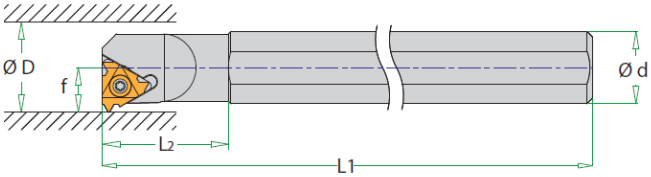




Code No	h	b	L	h1	f	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
SEL 1212F 11	12	12	80	12	12	11 EL..	-	-	CV.20
SEL 1616H 11	16	16	100	16	16	11 EL..	-	-	CV.20
SEL 1212H 16	12	12	100	12	12	16 EL..	AL.54	CV.32	CV.34
SEL 1616H 16	16	16	100	16	16	16 EL..	AL.54	CV.32	CV.34
SEL 2020K 16	20	20	125	20	20	16 EL..	AL.54	CV.32	CV.34
SEL 2525M 16	25	25	150	25	25	16 EL..	AL.54	CV.32	CV.34
SEL 2525M 22	25	25	150	25	25	22 EL..	AL.56	CV.33	CV.35
SEL 3232P 22	32	32	170	32	32	22 EL..	AL.56	CV.33	CV.35

SIR

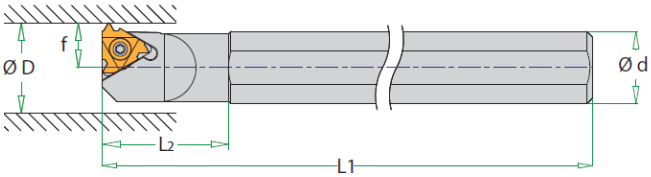
AYDOSA toolholders are manufactured with 1,5° helix angle
AYDOSA Werkzeugehalter werden mit 1,5° Steigungswinkel hergestellt



Code No	d	L1	L2	f	D	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
S10H SIR 11	10	100	25	7,4	13	11 IR..	-	-	CV.20
S12K SIR 11	12	125	28	8,2	14	11 IR..	-	-	CV.20
S16M SIR 11	16	150	32	10	18	11 IR..	-	-	CV.20
S16M SIR 16	16	150	35	11,5	19	16 IR..	-	-	CV.18
S20Q SIR 16	20	180	42	15	25	16 IR..	AL.54	CV.32	CV.34
S25R SIR 16	25	200	50	18	30	16 IR..	AL.54	CV.32	CV.34
S32S SIR 16	32	250	52	21,5	38	16 IR..	AL.54	CV.32	CV.34
S20Q SIR 22	20	180	42	15,6	25	22 IR..	-	-	CV.35
S25R SIR 22	25	200	45	18,1	30	22 IR..	AL.56	CV.33	CV.35
S32S SIR 22	32	250	52	21,6	38	22 IR..	AL.56	CV.33	CV.35
S40T SIR 22	40	300	60	25,8	46	22 IR..	AL.56	CV.33	CV.35

SIL

AYDOSA toolholders are manufactured with 1,5° helix angle
AYDOSA Werkzeugehalter werden mit 1,5° Steigungswinkel hergestellt



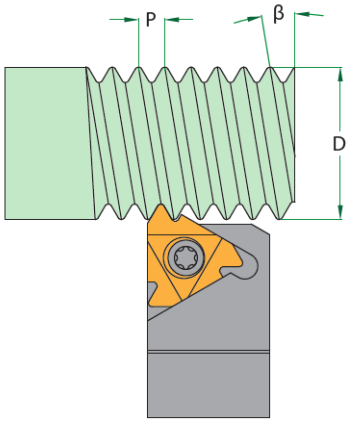
Code No	d	L1	L2	f	D	Inserts Platten	Shim Unterlage	Shim Screw Unterlage Schraube	Screw Schraube
S10H SIL 11	10	100	25	7,4	13	11 IL..	-	-	CV.20
S12K SIL 11	12	125	28	8,2	14	11 IL..	-	-	CV.20
S16M SIL 11	16	150	32	10	18	11 IL..	-	-	CV.20
S16M SIL 16	16	150	35	11,5	19	16 IL..	-	-	CV.18
S20Q SIL 16	20	180	42	15	25	16 IL..	AL.53	CV.32	CV.34
S25R SIL 16	25	200	50	18	30	16 IL..	AL.53	CV.32	CV.34
S32S SIL 16	32	250	52	21,5	38	16 IL..	AL.53	CV.32	CV.34
S20Q SIL 22	20	180	42	15,6	25	22 IL..	-	-	CV.35
S25R SIL 22	25	200	45	18,1	30	22 IL..	AL.55	CV.33	CV.35
S32S SIL 22	32	250	52	21,6	38	22 IL..	AL.55	CV.33	CV.35
S40T SIL 22	40	300	60	25,8	46	22 IL..	AL.55	CV.33	CV.35

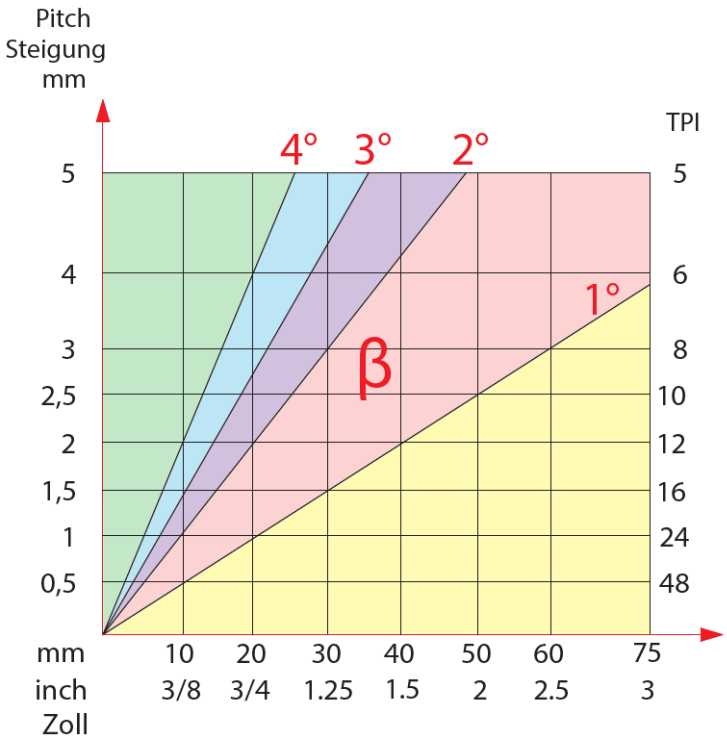
Thread helix angle and anvil selection
Gewinde Steigungswinkel und Unterlagen Auswahl

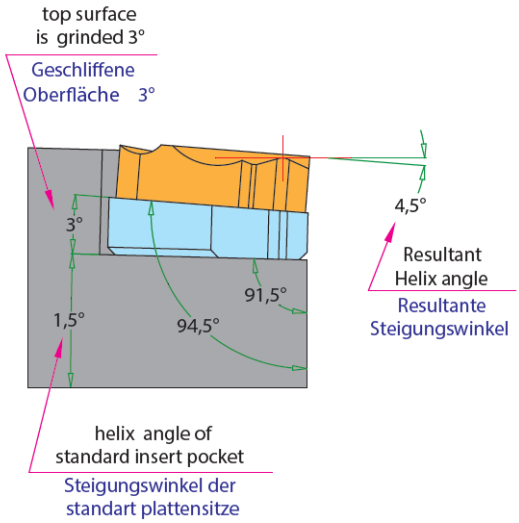
β : Helix angle - Steigungswinkel (°)
P : Pitch - Steigung.....(mm)
D : Diameter of thread.....(mm)
Gewinde Durchmesser.....(mm)

$$\tan \beta = \frac{1 \times P}{3{,}14 \times D}$$

$$\beta° = \frac{20 \times P}{D}$$







AYDOSA toolholders are manufactured with 1,5° helix angle
AYDOSA Werkzeugehalter werden mit 1,5° Steigungswinkel hergestellt

Resultant Helix angle Resultante Steigungs Winkel	4,5°	4°	3,5°	3°	2,5°	2°	1,5° Standart shim Standard Unterlage

Insert Size Wendeplattengröße IC	L	Holder Type Halter Ausführung	3° Angle shim Unterlage gewinkelt	2,5° Angle shim Unterlage gewinkelt	2° Angle shim Unterlage gewinkelt	1,5° Angle shim Unterlage gewinkelt	1° Angle shim Unterlage gewinkelt	0,5° Angle shim Unterlage gewinkelt	0° Angle shim Unterlage gewinkelt
3/8''	16	ER-IL	AL53A+3°	AL53A+2,5°	AL53A+2°	AL53A+1,5°	AL53A+1°	AL53A+0,5°	AL53
3/8''	16	EL-IR	AL54A+3°	AL54A+2,5°	AL54A+2°	AL54A+1,5°	AL54A+1°	AL54A+0,5°	AL54

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