Catalogue 2013

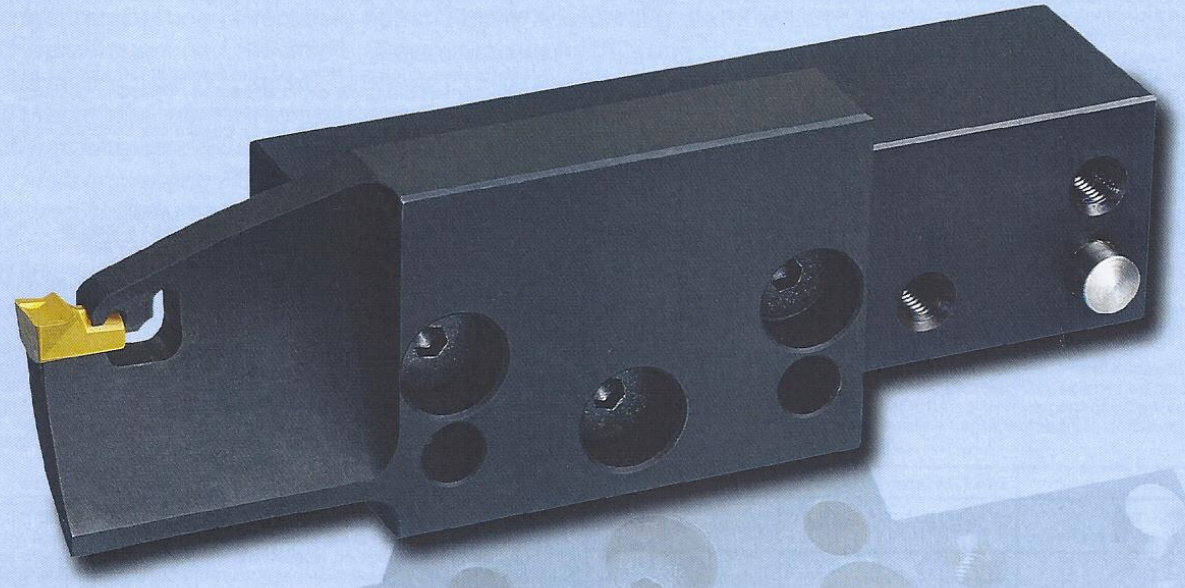
Part 3

Tools for heavy duty machining

Base holders with VDI and square shank

Toolholders for groove turning

Self and screw clamp system



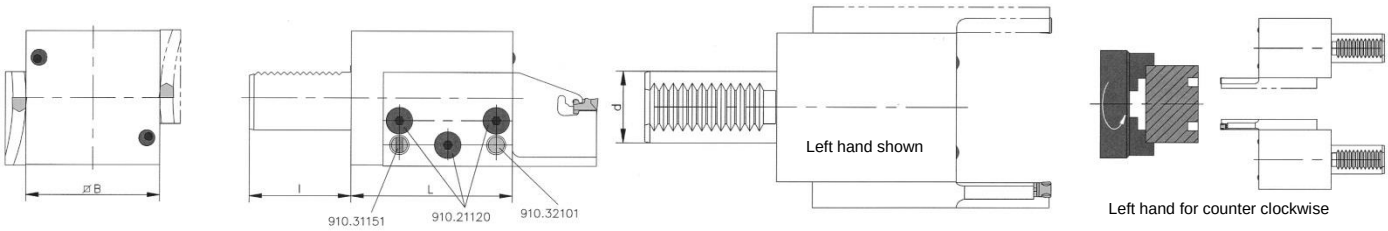
Grooving depth axial 50, 60, 70, 80 and 100 mm

Grooving depth radial up to 250 mm

THE COMPLETE GROOVING SYSTEM

Base holder axial

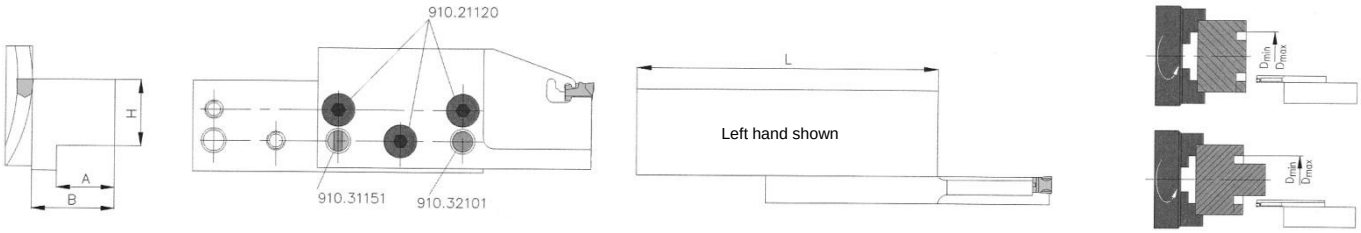
VDI 40 / 50 DIN 3425



Left hand for counter clockwise [M03] machining. Before and behind centerline

Article-No.	Base holder right hand	d	B	L	l	Axial cutting blade	Grooving depth	Grooving width
102.40208	VDI-RLVHM-20-40/A	40	83	100	63	MPUK….0R	50 / 60 / 70	8 / 10 / 12
102.50208	VDI-RLVHM-25-50/A	50	98	100	78	MPUK….0R	50 / 60 / 70	8 / 10 / 12
	Base holder left hand							
102.40209	VDI-RLVHM-20-40/A	40	83	100	63	MPUK….0L	50 / 60 / 70	8 / 10 / 12
102.50209	VDI-RLVHM-25-50/A	50	98	100	78	MPUK….0L	50 / 60 / 70	8 / 10 / 12

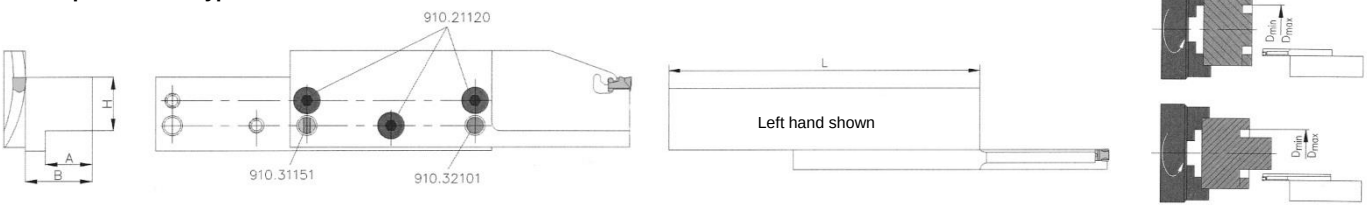
MG square shank type 25 / 32 / 40 x 140



Left hand for counter clockwise [M03]

Article-No.	Base holder neutral	H	A	B	L	Axial cutting blade	Grooving depth	Grooving width
203.25200	MG-25-2000	25	18	30	140	MPUK….0R/0L	50 / 60 / 70	8 / 10 / 12
203.32200	MG-32-2000	32	28	40	140	MPUK….0R/0L	50 / 60 / 70	8 / 10 / 12
203.40200	MG-40-2000	40	--	40	140	MPUK….0R/0L	50 / 60 / 70	8 / 10 / 12

SG square shank type 25 / 32 / 40 x 220



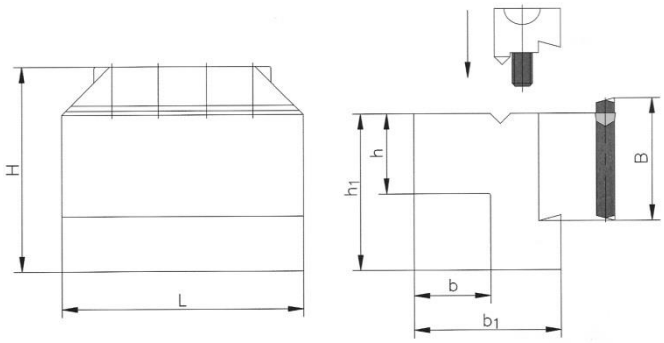
Left hand fü\or counter clockwise [M03] machining

Article-No.	Base holder neutral	H	A	B	L	Axial cutting blade	Grooving depth	Grooving width
204.25220	SG-25-220	25	25	37	220	SPUK….0R/0L	80 / 100	8 / 10 / 12
204.32220	SG-32-220	32	32	44	220	SPUK….0R/0L	80 / 100	8 / 10 / 12
204.40220	SG-40-220	40	38	50	220	SPUK….0R/0L	80 / 100	8 / 10 / 12

Base holder radial

CCN - KL square shank type 25 / 32 / 40 / 50 x 120

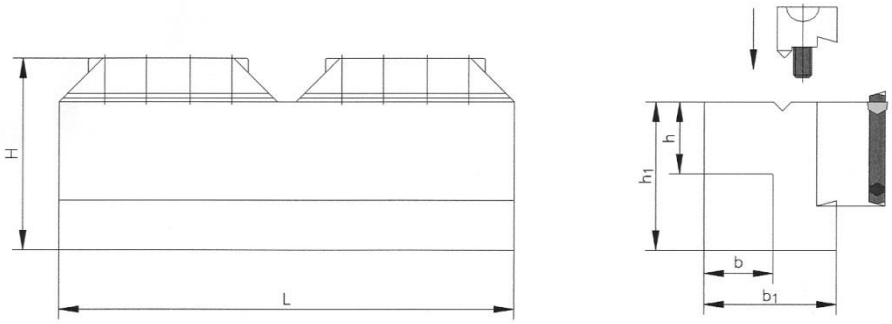
Spare part screws: 910.21041



Article-No.	Base holder neutral	H	b	L	h1	b1	H	Radial cutting blade	Cutting depth	Cutting width
205.25600	CCN-25/60-KL	25	23	120	78	58	102	ZUK / ZTC>nur 8 mm	110 / 70	8 / 10 / 12
205.32600	CCN-32/60-KL	32	30	120	78	65	102	ZUK / ZTC>nur 8 mm	110	8 / 10 / 12
205.40600	CCN-40/60-KL	40	38	120	78	73	102	ZUK / ZTC>nur 8 mm	110	8 / 10 / 12
205.50600	CCN-50/60-KL	50	43	120	78	78	102	ZUK / ZTC>nur 8 mm	110	8 / 10 / 12

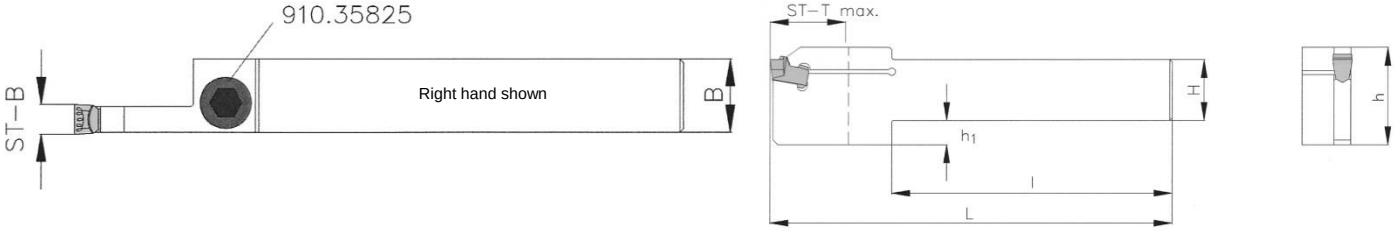
CCN - KL square shank type
40 / 50 x 250

Spare part screws: 910.21041



Article-No.	Base holder neutral	H	b	L	h1	b1	H	Radial cutting blade	Grooving depth	Grooving width
205.40600	CCN-40/60-KL	40	38	120	78	73	102	VUK	250	8 / 10 / 12
205.50600	CCN-50/60-KL	50	43	120	78	78	102	VUK	250	8 / 10 / 12

Toolholder square shank type 25 / 32 radial grooving

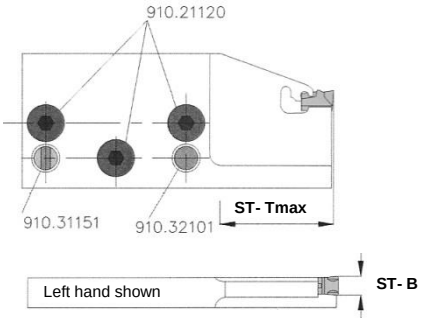


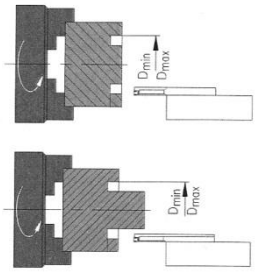
Article-No.	Tool holder right hand	H	B	L	l	h	h1	ST-B	ST-Tmax	Insert
260.25801	KLRC-25/R-8.0	25	20	165	115	40	10	8.0	31	693.08…
260.32801	KLRC-32/R-8.0	32	32	175	115	40	3	8.0	41	693.08…
	Tool holder left hand									
260.25802	KLRC-25/L-8.0	25	20	165	115	40	10	8.0	31	693.08…
260.25802	KLRC-25/L-8.0	32	32	175	115	40	3	8.0	41	693.08…

Cutting blade MPUK axial

Wrench 920.1400, please order separate

Clamping set 950.00023 for extended machining releave, please order separate

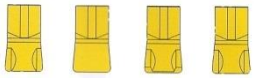




Left hand for counter clockwise [M03] machining

Extended machining releave

[Due to workpiece shape]



Type MPUK 0R / 0L [251…. = RH / 252…. = LH] Grooving depth 50 mm

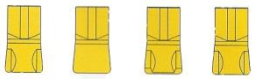
Artikel-Nr.	Type [+ D at the end = extended machining]	ST-B	ST-Tmax	Dmin/Dmax	
251/2.08060	MPUK-8-50-0R/0L-DB60-80	8	50	60-80	685.8000.
251/2.08080	MPUK-8-50-0R/0L-DB80-100	8	50	80-100	
251/2.08100	MPUK-8-50-0R/0L-DB100-130	8	50	100-130	
251/2.08130	MPUK-8-50-0R/0L-DB130-160	8	50	130-160	
251/2.08160	MPUK-8-50-0R/0L-DB160-200	8	50	160-200	
251/2.08200	MPUK-8-50-0R/0L-DB200-250	8	50	200-250	
251/2.08250	MPUK-8-50-0R/0L-DB250-350	8	50	250-350	
251/2.08350	MPUK-8-50-0R/0L-DB350-	8	50	350-h	
251/2.10060	MPUK-10-50-0R/0L-DB60-80	10	50	60-80	685.1000.
251/2.10080	MPUK-10-50-0R/0L-DB80-100	10	50	80-100	
251/2.10100	MPUK-10-50-0R/0L-DB100-130	10	50	100-130	
251/2.10130	MPUK-10-50-0R/0L-DB130-160	10	50	130-160	
251/2.10160	MPUK-10-50-0R/0L-DB160-200	10	50	160-200	
251/2.10200	MPUK-10-50-0R/0L-DB200-250	10	50	200-250	
251/2.10250	MPUK-10-50-0R/0L-DB250-350	10	50	250-350	
251/2.10350	MPUK-10-50-0R/0L-DB350-	10	50	350-h	
251/2.12060	MPUK-12-50-0R/0L-DB60-80	12	50	60-80	685.1200.
251/2.12080	MPUK-12-50-0R/0L-DB80-100	12	50	80-100	
251/2.12100	MPUK-12-50-0R/0L-DB100-130	12	50	100-130	
251/2.12130	MPUK-12-50-0R/0L-DB130-160	12	50	130-160	
251/2.12160	MPUK-12-50-0R/0L-DB160-200	12	50	160-200	
251/2.12200	MPUK-12-50-0R/0L-DB200-250	12	50	200-250	
251/2.12250	MPUK-12-50-0R/0L-DB250-350	12	50	250-350	
251/2.12350	MPUK-12-50-0R/0L-DB350-	12	50	350-h	

Type MPUK 0R / 0L [264…. = RH / 265…. = LH] Grooving depth 60 mm

264/5.08060	MPUK-08-60-0R/0L-DB60-80	8	60	60-80	685.8000.
264/5.08080	MPUK-08-60-0R/0L-DB80-100	8	60	80-100	
264/5.08100	MPUK-08-60-0R/0l-DB100-130	8	60	100-130	
264/5.08130	MPUK-08-60-0R/0L-DB130-160	8	60	130-160	
264/5.08160	MPUK-08-60-0R/0L-DB160-200	8	60	160-200	
264/5.08200	MPUK-08-60-0R/0L-DB200-250	8	60	200-250	
264/5.08250	MPUK-08-60-0R/0L-DB250-350	8	60	250-350	
264/5.08350	MPUK-08-60-0R/0L-DB350-	8	60	350-h	
264/5.10060	MPUK-10-60-0R/0L-DB60-80	10	60	60-80	685.1000.
264/5.10080	MPUK-10-60-0R/0L-DB80-100	10	60	80-100	
264/5.10100	MPUK-10-60-0R/0L-DB100-130	10	60	100-130	
264/5.10130	MPUK-10-60-0R/0L-DB130-160	10	60	130-160	
264/5.10160	MPUK-10-60-0R/0L-DB160-200	10	60	160-200	
264/5.10200	MPUK-10-60-0R/0L-DB200-250	10	60	200-250	
264/5.10250	MPUK-10-60-0R/0L-DB250-350	10	60	250-350	
264/5.10350	MPUK-10-60-0R/0L-DB350-	10	60	350-h	
264/5.12060	MPUK-12-60-0R/0L-DB60-80	12	60	60-80	685.1200.
264/5.12080	MPUK-12-60-0R/0L-DB80-100	12	60	80-100	
264/5.12100	MPUK-12-60-0R/0L-DB100-130	12	60	100-130	
264/5.12130	MPUK-12-60-0R/0L-DB130-160	12	60	130-160	
264/5.12160	MPUK-12-60-0R/0L-DB160-200	12	60	160-200	
264/5.12200	MPUK-12-60-0R/0L-DB200-250	12	60	200-250	
264/5.12250	MPUK-12-60-0R/0L-DB250-350	12	60	250-350	
264/5.12350	MPUK-12-60-0R/0L-DB350-	12	60	350-h	

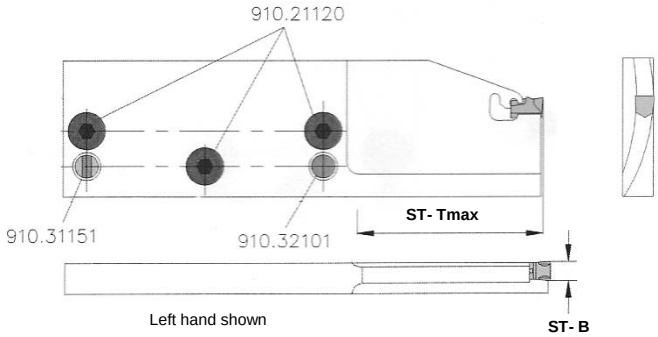
Cutting blade MPUK axial

Type MPUK 0R / 0L [266…. = RH / 267…. = LH] Grooving depth 70 mm

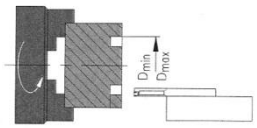


Article-No.	Type [+ D at the end = extended machining]	ST-B	ST-Tmax	Dmin/Dmax	
266/7.08100	MPUK-8-70-0R/0L-DB100-130	8	70	100-130	685.8000.
266/7.08130	MPUK-8-70-0R/0L-DB130-160	8	70	130-160	
266/7.08160	MPUK-8-70-0R/0L-DB160-200	8	70	160-200	
266/7.08200	MPUK-8-70-0R/0L-DB200-250	8	70	200-250	
266/7.08250	MPUK-8-70-0R/0L-DB250-350	8	70	250-350	
266/7.08350	MPUK-8-70-0R/0L-DB350-	8	70	350-h	
266/7.10100	MPUK-10-70-0R/0L-DB100-130	10	70	100-130	685.1000.
266/7.10130	MPUK-10-70-0R/0L-DB130-160	10	70	130-160	
266/7.10160	MPUK-10-70-0R/0L-DB160-200	10	70	160-200	
266/7.10200	MPUK-10-70-0R/0L-DB200-250	10	70	200-250	
266/7.10250	MPUK-10-70-0R/0L-DB250-350	10	70	250-350	
266/7.10350	MPUK-10-70-0R/0L-DB350-	10	70	350-h	
266/7.12100	MPUK-12-70-0R/0L-DB100-130	12	70	100-130	685.1200.
266/7.12130	MPUK-12-70-0R/0L-DB130-160	12	70	130-160	
266/7.12160	MPUK-12-70-0R/0L-DB160-200	12	70	160-200	
266/7.12200	MPUK-12-70-0R/0L-DB200-250	12	70	200-250	
266/7.12250	MPUK-12-70-0R/0L-DB250-350	12	70	250-350	
266/7.12350	MPUK-12-70-0R/0L-DB350-	12	70	350-h	

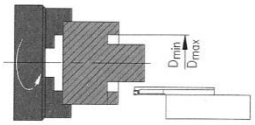
Cutting blade SPUK axial



Left hand shown



Left hand for counter clockwise [M03] machining



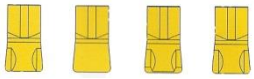
Extended machining releave

[due to workpiece shape]

Wrench 920.1400, please order separate

Clamping set 950.00023 for extended machining releave, please order separate

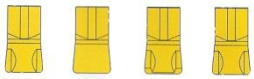
Type MPUK 0R / 0L [273…. = RH / 274…. = LH] Grooving depth 80 mm



Article-No.	Type [+ D at the end = extended machining]	ST-B	ST-Tmax	Dmin/Dmax	
273/4.08100	MPUK-8-80-0R/0L-DB100-130	8	80	100-130	685.8000.
273/4.08130	MPUK-8-80-0R/0L-DB130-160	8	80	130-160	
273/4.08160	MPUK-8-80-0R/0L-DB160-200	8	80	160-200	
273/4.08200	MPUK-8-80-0R/0L-DB200-250	8	80	200-250	
273/4.08250	MPUK-8-80-0R/0L-DB250-350	8	80	250-350	
273/4.08350	MPUK-8-80-0R/0L-DB350-	8	80	350-h	
273/4.10100	MPUK-10-80-0R/0L-DB100-130	10	80	100-130	685.1000.
273/4.10130	MPUK-10-80-0R/0L-DB130-160	10	80	130-160	
273/4.10160	MPUK-10-80-0R/0L-DB160-200	10	80	160-200	
273/4.10200	MPUK-10-80-0R/0L-DB200-250	10	80	200-250	
273/4.10250	MPUK-10-80-0R/0L-DB250-350	10	80	250-350	
273/4.10350	MPUK-10-80-0R/0L-DB350-	10	80	350-h	
273/4.12100	MPUK-12-80-0R/0L-DB100-130	12	80	100-130	685.1200.
273/4.12130	MPUK-12-80-0R/0L-DB130-160	12	80	130-160	
273/4.12160	MPUK-12-80-0R/0L-DB160-200	12	80	160-200	
273/4.12200	MPUK-12-80-0R/0L-DB200-250	12	80	200-250	
273/4.12250	MPUK-12-80-0R/0L-DB250-350	12	80	250-350	
273/4.12350	MPUK-12-80-0R/0L-DB350-	12	80	350-h	

Cutting blade SPUK axial

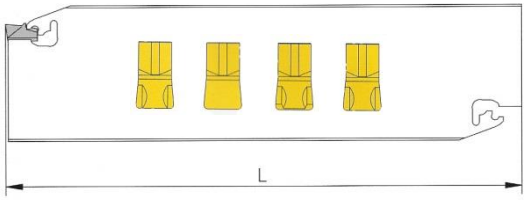
Type MPUK 0R / 0L [275…. = RH / 276…. = LH] Grooving depth 100 mm

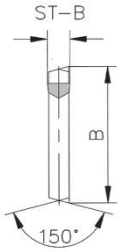


Article-No.	Type [+ D at the end = extended machining]	ST-B	ST-Tmax	Dmin/Dmax	
273/4.08130	MPUK-8-100-0R/0L-DB130-160	8	100	130-160	
273/4.08160	MPUK-8-100-0R/0L-DB160-200	8	100	160-200	
273/4.08200	MPUK-8-100-0R/0L-DB200-250	8	100	200-250	
273/4.08250	MPUK-8-100-0R/0L-DB250-350	8	100	250-350	
273/4.08350	MPUK-8-100-0R/0L-DB350-	8	100	350-h	
273/4.10130	MPUK-10-100-0R/0L-DB130-160	10	100	130-160	685.1000.
273/4.10160	MPUK-10-100-0R/0L-DB160-200	10	100	160-200	
273/4.10200	MPUK-10-100-0R/0L-DB200-250	10	100	200-250	
273/4.10250	MPUK-10-100-0R/0L-DB250-350	10	100	250-350	
273/4.10350	MPUK-10-100-0R/0L-DB350-	10	100	350-h	
273/4.12130	MPUK-12-100-0R/0L-DB130-160	12	100	130-160	685.1200.
273/4.12160	MPUK-12-100-0R/0L-DB160-200	12	100	160-200	
273/4.12200	MPUK-12-100-0R/0L-DB200-250	12	100	200-250	
273/4.12250	MPUK-12-100-0R/0L-DB250-350	12	100	250-350	
273/4.12350	MPUK-12-100-0R/0L-DB350-	12	100	350-h	

Cutting blade ZUK radial; Grooving depth 110 mm

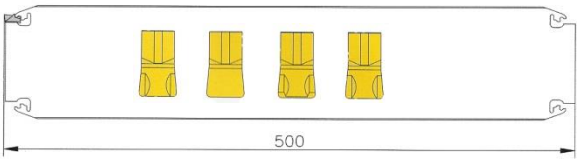
Article-No.	Type	ST-B	ST-Tmax	B	L	Wrench	Insert
215.80600	ZUK- 8-60-0	8	110	60	230	920.14001	685.8000.
215.10600	ZUK-10-60-0	10	110	60	230	920.14001	685.1000.
215.12600	ZUK-12-60-0	12	110	60	230	920.14001	685.1200.

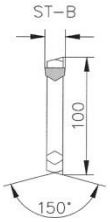




Cutting blade VUK radial; Grooving depth 250 mm

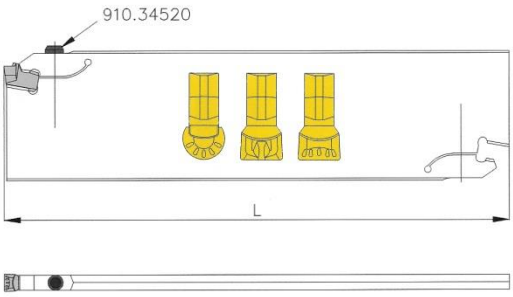
Article-No.	Type	ST-B	ST-Tmax	Dmax	Wrench	Insert
215.80100	ZUK- 8-60-0	8	250	500	920.14001	685.8000.
215.10100	ZUK-10-60-0	10	250	500	920.14001	685.1000.
215.12100	ZUK-12-60-0	12	250	500	920.14001	685.1200.

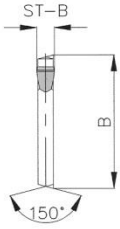




Cutting blade ZTC radial; Grooving depth 230 mm

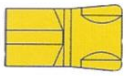
Article-No.	Type	ST-B	ST-Tmax	B	Wrench	Insert
311.80601	ZTC- 8-60-10	8	70	60	940.44161	693.08...





Inserts

Type: SHM main-cutting edge neutral

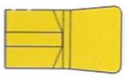


Article-No.	Type	Grooving width	Ra	P20 - 12	Zg30 - 07	X-Bl - 144	A-Sp - 145	Zs40 - 99
685.80001	SHM-8.0	8.0	0.8	O	O			
685.10001	SHM-10.0	10.0	0.8	O	O			
685.12001	SHM-12.0	12.0	0.8	O	O			

Type: SHM - F main-cutting edge neutral

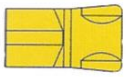
Article-No.	Type	Grooving width	Ra	P20 - 12	Zg30 - 07	X-Bl - 144	A-Sp - 145	Zs40 - 99
685.80000	SHM-8.0-F	8.0	0.8	O	O			
685.10000	SHM-10.0-F	10.0	0.8	O	O			
685.12000	SHM-12.0-F	12.0	0.8	O	O			

Type: SHM - R main-cutting edge neutral



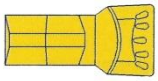
Article-No.	Type	Grooving width	Ra	P20 - 12	Zg30 - 07	X-Bl - 144	A-Sp - 145	Zs40 - 99
685.80002	SHM-8.0-R	8.0	0.8		O			
685.10002	SHM-10.0-R	10.0	0.8					
685.12002	SHM-12.0-R	12.0	0.8					

Type: SHM - J main-cutting edge neutral



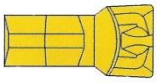
Article-No.	Type	Grooving width	Ra	P20 - 12	Zg30 - 07	X-Bl - 144	A-Sp - 145	Zs4 - 99
685.80003	SHM-8.0-J	8.0	0.8	O	O			

Type: MTE - KXD main-cutting edge neutral



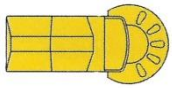
Article-No.	Type	Grooving width	Ra	P20 - 12	Zg30 - 07	X-bl - 144	A-Sp - 145	Zs4 - 99
693.08000	MTE-8.0-KXD-10	8.0	0.4					O

Typ: MTE - KXG main-cutting edge neutral



Article-No.	Type	Grooving width	Ra	P20 - 12	Zg30 - 07	X-Bl - 144	A-Sp - 145	Zs4 - 99
693.08300	MTE-8.0-KXG-10	8.0	0.4					O

Type: MTE - KXD… RA main-cutting edge neutral



Article-No.	Type	Grooving width	Ra	P20 - 12	Zg30 - 07	X-Bl - 144	A-Sp - 145	Zs4 - 99
693.08040	MTE-8.0-KXD-10-RA4.0	8.0	4.0					O

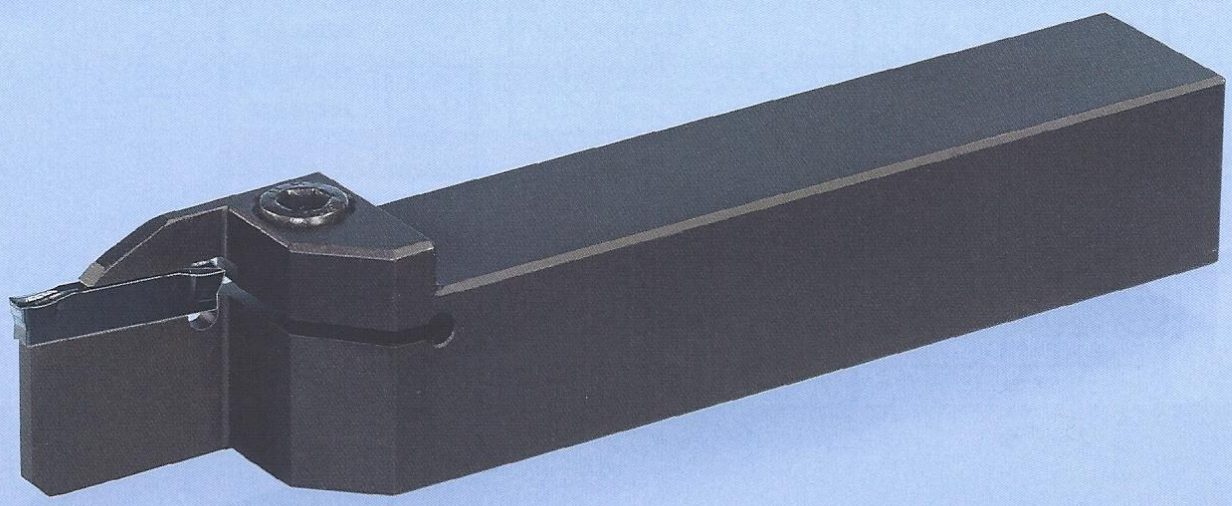
Insert tipped tooling for turn, mill, drill and boring operations

Taps, dies and thread milling tools

Adapters

Mini tools for Swiss machines

Special tools according to customer specifications



AMW
Advanced Metal Working

Gross EU-Pricelist **2013**

Article number	€/St.	Article number	€/St.	Article number	€/St.	Article number	€/St.
102.40208	430.00	251/2.10160D	385.00	264/5.10100D	490.00	266/7.10250	440.00
102.50208	450.00	251/2.10200	285.00	264/5.10130	410.00	266/7.10250D	520.00
102.40209	430.00	251/2.10200D	385.00	264/5.10130D	490.00	266/7.10350	440.00
102.50209	450.00	251/2.10250	285.00	264/5.10160	410.00	266/7.10350D	520.00
203.25200	250.00	251/2.10250D	385.00	264/5.10160D	490.00	266/7.12100	440.00
203.32200	250.00	251/2.10350	285.00	264/5.10200	410.00	266/7.12100D	525.00
203.40200	250.00	251/2.10350D	385.00	264/5.10200D	490.00	266/7.12130	440.00
204.25220	260.00	251/2.12060	290.00	264/5.10250	410.00	266/7.12130D	525.00
204.32220	260.00	251/2.12060D	390.00	264/5.10250D	490.00	266/7.12160	440.00
204.40220	260.00	251/2.12080	290.00	264/5.10350	410.00	26/7.12160D	525.00
205.25600	340.00	251/2.12080D	390.00	264/5.10350D	490.00	266/7.12200	440.00
205.32600	340.00	251/2.12100	290.00	264/5.12080	420.00	266/7.12200D	525.00
205.40600	370.00	251/2.12100D	430.00	264/5.12080D	490.00	266/7.12250	440.00
205.50600	440.00	251/2.12130	290.00	264/5.12100	420.00	266/7.12250D	525.00
205.40100	1.260.00	251/2.12130D	390.00	264/5.12100D	490.00	266/7.12350	440.00
205.50100	1.260.00	251/2.12160	290.00	264/5.12130	420.00	266/7.12350D	525.00
260.25801	120.00	251/2.12160D	390.00	264/5.12130D	490.00	273/4.08100	410.00
260.32801	130.00	251/2.12200	290.00	264/5.12160	420.00	273/4.08100D	510.00
260.25802	120.00	251/2.12200D	390.00	264/5.12160D	490.00	273/4.08130	410.00
260.32802	125.00	251/2.12250	290.00	264/5.12200	420.00	273/4.08130D	510.00
251/2.08060	265.00	251/2.12250D	390.00	264/5.12200D	490.00	273/4.08160	410.00
251/2.08060D	355.00	251/2.12350	290.00	264/5.12250	420.00	273/4.08160D	510.00
251/2.08080	265.00	251/2.12350D	390.00	264/5.12250D	490.00	273/4.08200	410.00
251/2.08080D	355.00	264/5.08060	375.00	264/5.12350	420.00	273/4.08200D	510.00
251/2.08100	265.00	264/5.08060D	445.00	264/5.12350D	490.00	273/4.08250	410.00
251/2.08100D	355.00	264/5.08080	375.00	266/7.08100	400.00	273/4.08250D	510.00
251/2.08130	265.00	264/5.08080D	445.00	266/7.08100D	475.00	273/4.08350	410.00
251/2.08130D	355.00	264/5.08100	375.00	266/7.08130	400.00	273/4.08350D	510.00
251/2.08160	265.00	264/5.08100D	445.00	266/7.08130D	475.00	273/4.10100	450.00
251/2.08160D	355.00	264/5.08130	375.00	266/7.08160	400.00	273/4.10100D	550.00
251/2.08200	265.00	264/5.08130D	445.00	266/7.08160D	475.00	273/4.10130	450.00
251/2.08200D	355.00	264/5.08160	375.00	266/7.08200	400.00	273/4.10130D	550.00
251/2.08250	265.00	264/5.08160D	445.00	266/7.08200D	475.00	273/4.10160	450.00
251/2.08250D	355.00	264/5.08200	375.00	266/7.08250	400.00	273/4.10160D	550.00
251/2.08350	265.00	264/5.08200D	445.00	266/7.08250D	475.00	273/4.10200	450.00
251/2.08350D	355.00	264/5.08250	375.00	266/7.08350	400.00	273/4.10200D	550.00
251/2.10060	290.00	264/5.08250D	445.00	266/7.08350D	475.00	273/4.10250	450.00
251/2.10060D	385.00	264/5.08350	375.00	266/7.10100	440.00	273/4.10250D	550.00
251/2.10080	290.00	264/5.08350D	445.00	266/7.10100D	510.00	273/4.10350	450.00
251/2.10080D	385.00	264/5.10060	410.00	266/7.10130	440.00	273/4.10350D	550.00
251/2.10100	285.00	264/5.10060D	490.00	266/7.10130D	520.00	273/4.12100	460.00
251/2.10100D	385.00	264/5.10080	410.00	266/7.10160	440.00	273/4.12100D	550.00
251/2.10130	285.00	264/5.10080D	490.00	266/7.10160D	520.00	273/4.12130	460.00
251/2.10130D	385.00	264/5.10100	410.00	266/7.10200	440.00	273/4.12130D	550.00
251/2.10160	285.00	271.23030	145.00	266/7.10200D	520.00	273/4.12160	460.00

Gross EU-Pricelist **2013**

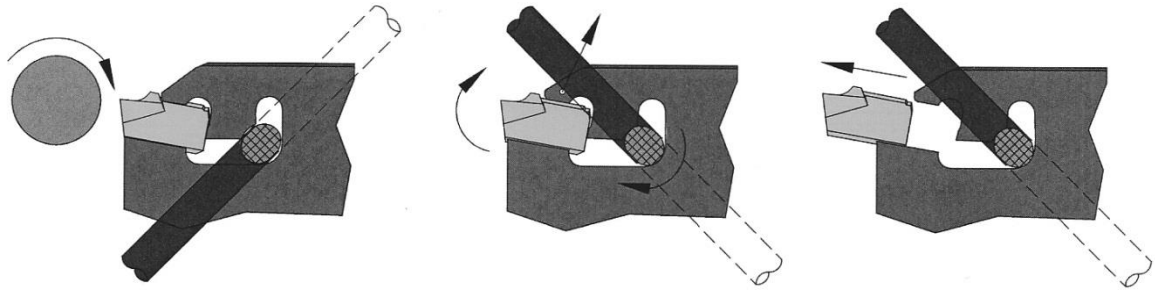
Article number	€/St.	Article number	€/St.	Article number	€/St.	Article number	€/St.
273/4.12160D	550.00	275/6.10200	500.00	215.12100	890.00	685.12000 -144	21.00
273/4.12200	460.00	275/6.10200D	590.00	311.80601	op aanvraag	685.12000 -146	20.00
273/4.12200D	550.00	275/6.10250	500.00	685.80000 -07	18.10	685.12001 -07	19.30
273/4.12250	460.00	275/6.10250D	590.00	685.80000 -12	14.90	685.12001 -12	16.50
273/4.12250D	550.00	275/6.10350	500.00	685.80000 -144	21.00	685.12001 -144	21.00
273/4.12350	460.00	275/6.10350D	590.00	685.80001 -04	14.90	685.12001 -146	20.00
273/4.12350D	550.00	275/6.12130	510.00	685.80001 -07	18.10	685.12002 -07	21.00
275/6.08130	460.00	275/6.12130D	600.00	685.80001 -12	14.90	693.08000	op aanvraag
275/6.08130D	550.00	275/6.12160	510.00	685.80001 -144	21.00	693.08300	op aanvraag
275/6.08160	460.00	275/6.12160D	600.00	685.80002 -07	20.50	693.08040	op aanvraag
275/6.08160D	550.00	275/6.12200	510.00	685.80002 -12	16.50	920.14001	6.60
275/6.08200	460.00	275/6.12200D	600.00	685.80002 -145	22.00	940.44161	3.30
275/6.08200D	550.00	275/6.12250	510.00	685.80003 -07	20.50	910.21041	1.65
275/6.08250	460.00	275/6.12250D	600.00	685.80003 -12	17.10		
275/6.08250D	550.00	275/6.12350	510.00	685.80003 -144	22.00		
275/6.08350	460.00	275/6.12350D	600.00	685.10000 -07	18.70		
275/6.08350D	550.00	215.80600	155.00	685.10000 -12	14.90		
275/6.10130	500.00	215.10600	165.00	685.10000 -144	20.50		
275/6.10130D	590.00	215.12600	195.00	685.10000 -146	18.70		
275/6.10160	500.00	215.80100	770.00	685.10001 -07	18.70		
275/6.10160D	590.00	215.10100	790.00	685.10001 -12	14.90		

Overvieuw grades and application aerea

P20 – 12	P20	Carbide uncoated Low alloy steel [< 800 N/mm²] Casting like GTW and GTS
Zg30 – 07	P35, M25	Carbide coated [CVD / TiN - TiCN - TiN] Low and high alloy steel [<1000N/mm²]
Zs40 – 99	P40, M30, K35	Carbide coated [PVD / TiALN] High temperature resistant and stainless steel [<1000N/mm²]. Titanium and Titanium alloys Castings like GTW, GTS, GG and GGG NF-Metals, aluminium pure, aluminium alloys, synthetics
X-Bl – 144	P30 - 45	Carbide multi-purpose-grade - Supernitrite coated Heat resistant and stainless steels [<1000N/mm²] Titanium and Titanium alloys Castings like GTW, GTS, GG and GGG NF-Metals, aluminium, aluminium alloys, synthetics
A-Sp – 145	K05 - 15	Carbide coated Aluminium and copper Titanium and titanium alloys

Unclamp and clamp the inserts

Changing the insert always clean the pocketseat and the new cutting edge must be placed correctly in order to duplicate the stop in the pocketseat of the toolholder.
When changing the insert always utilize the original wrench and no other handtools!



Locking clamping screws with a torque wrench is preferable.

General indications

The toolholder should be mounted exact 90° towards the centerline of the workpiece.

A rigid mounting of the toolholder into the machine garantees a better performance in machining operations [like preventing vibrations].

Reaching the releave wear Vb = 0.2 mm [width] means changing the insert in order to avoid fatal tool breakage.

Locking clamping screws without a torgue wrench never use extensions; like a tube.

Give attention to sufficient and continuos coolant supply during cutting, because this effects in a positive way the toollive of the cutting edges.

Indications for axial grooving

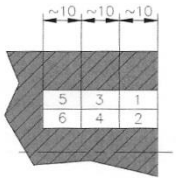
The correct choice in attack diameter "DB" using axial grooving blades.
The ID of the thirst grooving is determinating the correct following order. Meaning; the first cut must be made inside the given diameter range "DB". Example: DB 75 - 100. Attacking the workpiece at the range Ø 75 – 100 mm should be done with <u>THAT</u> part of the cuttting edge determining the smallest ID or the biggest ID. After making the first groove, every next one can be machined with a maximum of 2/3 from the cutting edge width [ST-B]. In direction of the centerline or the opposite.

Tool position.
During axial grooving is a top side down tool position beneficial. Because, the gravitation supports a moore smooth chipreleave / flow from the slot in the workpiece towards the chip reservoir.

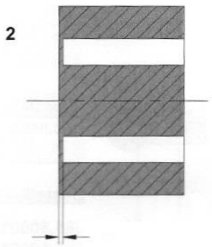
Widening / extending the slot [With several attacks / see picture 1].
During this method in machining the first attack should be executed at the biggest Ø of the slot [depending on the range of the axial cutting blade]; then proceed to the second slot - with 2/3 adjustment of the cutting width - in direction of the centerline, a.s.o.
This procedure is preferable also in deep slot machining.

Parting off producing discs and piths [See picture 2].
Machining in producing these remains should not to be done, always keep a connection to the workpiece - never part off completely!
The disc or pith must be removed separately by other means next the machining procedure.

1



2



Workpiece material groups, cutting materials and cutting data

Cutting speed Vc in m / min

Workpiece material group	P20 12	Zg30 07	Zs40 99	X-Bl 144	A-Sp 145
Workpiece material group P					
St37 / C15 / 9SMnPb28	90-200	90-200	100-250	75-280	
St50 / C50	90-180	90-180	100-180	75-220	
16MnCr5	70-160	70-160	100-160	75-200	
42CrMo4 / 50CrV4	70-140	70-140	100-160	75-200	
100Cr6 / 90 MnCrV8	50-130	50-130	100-140	75-160	
Workpiece material group M					
X5CrNi18 9	40-60	60-80	90-140	70-170	
X5CrNiMo18 10	40-60	60-85	100-150	75-180	
X2CrNiMoN22-5-3	30-50	30-50	45-100	60-140	
Workpiece material group K					
GG20 / GGG40	50-120	50-140	100-140	70-140	
GG40 / GGG60	40-100	40-120	90-140	70-120	
Workpiece material group N					
AlMg1					250-2000
G-AlSi12					200-800
Workpiece material group S					
Inconel, Rene, Hastelloy					20-50
Titanium based alloys					15-55
Cobalt based alloys					20-60

Feed rate fn in mm / rev. and cutting width

Workpiece material group	8.0	10.0	12.0
Workpiece material group P			
St37 / C15 / 9SMnPb28	0.10-0.35	0.10-0.40	0.10-0.45
St50 / C50	0.10-0.25	0.10-0.30	0.10-0.35
16MnCr5	0.10-0.25	0.10-0.30	0.10-0.35
42CrMo4 / 50CrV4	0.10-0.25	0.10-0.30	0.10-0.35
100Cr6 / 90 MnCrV8	0.10-0.25	0.10-0.30	0.10-0.35
Workpiece material group M			
X5CrNi18 9	0.10-0.15	0.10-0.15	0.10-0.18
X5CrNiMo18 10	0.10-0.15	0.10-0.15	0.10-0.18
X2CrNiMoN22-5-3	0.08-0.12	0.10-0.12	0.10-0.15
Workpiece material group K			
GG20 / GGG40	0.10-0.35	0.10-0.40	0.10-0.45
GG40 / GGG60	0.10-0.35	0.10-0.40	0.10-0.45
Workpiece material group N			
AlMg1	0.10-0.35	0.10-0.40	0.10-0.45
G-AlSi12	0.10-0.35	0.10-0.40	0.10-0.45
Workpiece material group S			
Inconel, Rene, Hastelloy	0.10-0.12	0.10-0.15	0.10-0.20
Titan based alloys	0.10-0.12	0.10-0.15	0.10-0.20
Cobalt based alloys	0.10-0.12	0.10-0.15	0.10-0.20