



AUTOMOTIVE INDUSTRY



AEROSPACE



GEARS + BEARINGS



MECHANICAL ENGINEERING



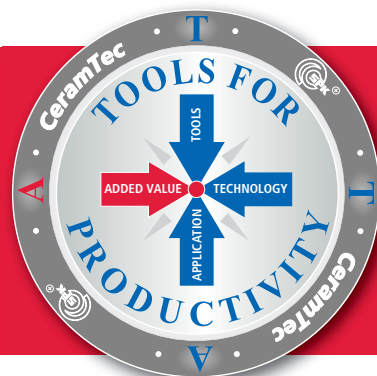
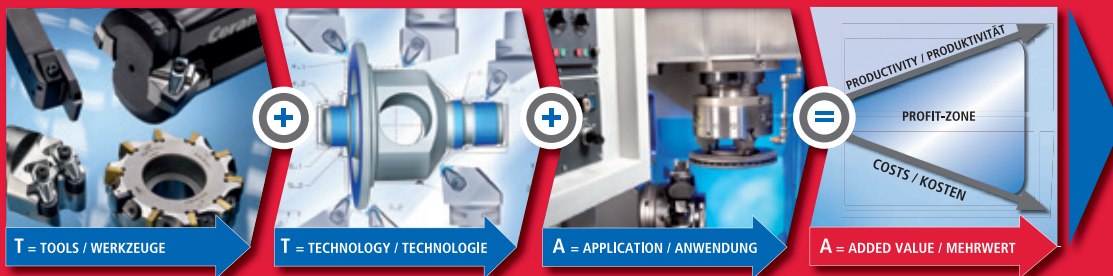
WIND ENERGY



RAG

STECHDREHEN MIT SEITLICHEM VERFAHREN

GROOVING WITH LATERAL MOVEMENT



TOOLS FOR PRODUCTIVITY

Die optimale spanende Bearbeitung eines Werkstücks lässt sich längst nicht mehr auf den Schneidprozess beschränken. Steigende technologische und wirtschaftliche Herausforderungen verlangen nach hoch effizient ablaufenden Zerspanprozessen. Zu diesem Zweck haben wir das Programm SPK⁺ - The Productivity Experts mit der Formel: **Werkzeug + Technologie + Anwendung = mehr Produktivität bei geringeren Kosten**, entwickelt. Schon heute belegt eine Vielzahl konkreter Anwendungsfälle, dass die Formel ein großes Plus an Produktivität für unsere Kunden bedeutet. Daher versehen wir unsere Produkte in Zukunft

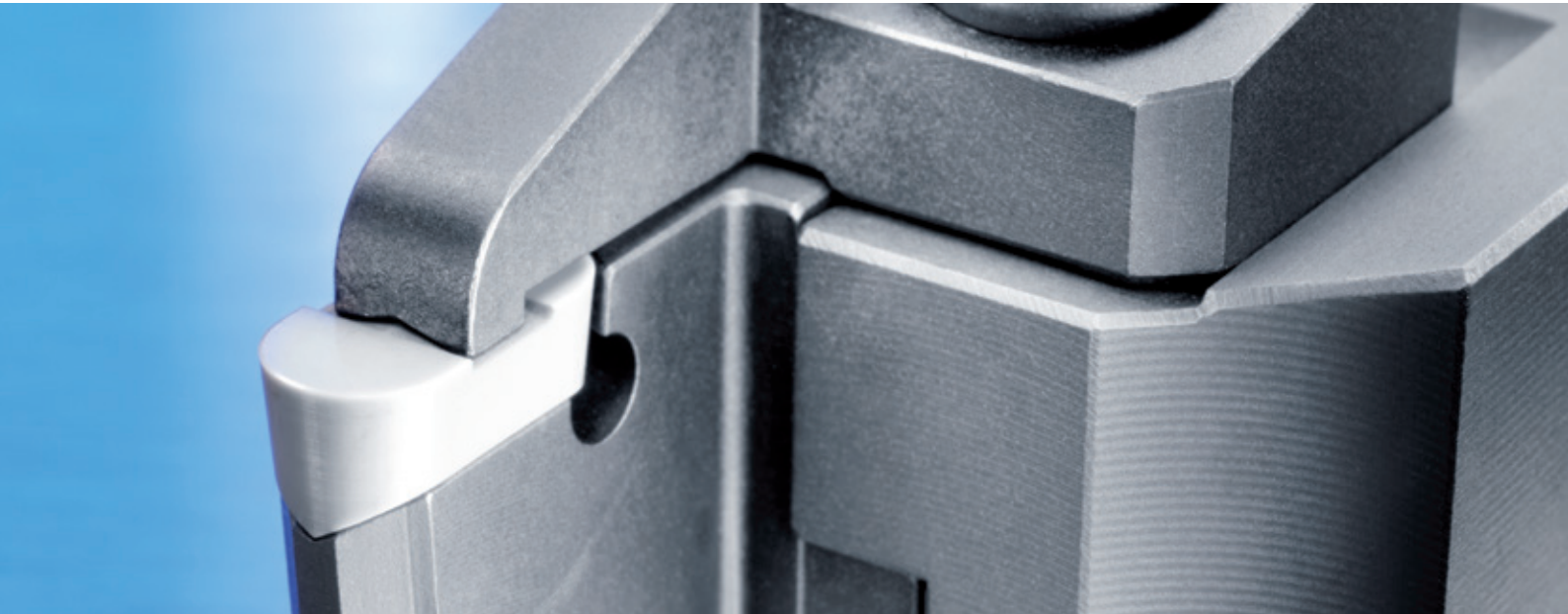
*Achieving the optimal machining of a workpiece is no longer solely dependent on the cutting process. Increasing technological and economical challenges require highly efficient machining processes. To this end, we have developed the program "SPK⁺ - The Productivity Experts" with the formula: **tool + technology + application = increased productivity with lower costs**. It has already been shown that the formula means a boost in productivity for our customers in many applications. In the future, we will draw attention to this by launching a "productivity compass"*

als äußeres Zeichen mit dem Qualitätssiegel „**Produktivitätskompass**“, das für unsere Tools for Productivity steht. Überall dort, wo Sie unserem Produktivitätskompass begegnen, zeigt er Ihnen, dass der maximale Produktivitätsbeitrag beim Zerspanen im Vordergrund steht. Ob auf unseren Schneidplatten, Werkzeugträgern oder gar auf Bearbeitungsmaschinen, wenn der Zerspanprozess vor Ort durch unser Engineering optimiert wurde. Dabei arbeiten wir von Anfang an gemeinsam mit unseren Kunden. Dafür stellen wir hoch spezialisierte Fachleute in den wesentlichen Märkten der Welt zur Verfügung. Auf diese Weise garantieren

as a visible sign and seal of quality. The compass stands for our Tools for Productivity. Wherever you find our productivity compass, it will show you that the maximum contribution to productivity is the focus in machining. Whether on our inserts, tools or even on processing machines, whenever the machining process has been optimised by our engineering on location. We work together with our customers from the beginning and provide them with highly specialised experts in the world's most important markets. In this way, we can guarantee that using our

wir, dass der Einsatz unserer Tools for Productivity - **Werkzeug + Technologie + Anwendung** - zielsicher und punktgenau zu einem perfektionierten Zerspanen und damit zu höchst möglicher Produktivität führt. Auf die daraus resultierenden Anforderungen sind wir mit unseren Hochleistungsschneidstoffen, Präzisionswerkzeugsystemen und unserem umfangreichen Serviceleistungsspektrum perfekt ausgerichtet. Unser Produktivitätskompass ist das Produktivitätssiegel, dem Sie vertrauen können. Mehr Informationen hierzu finden Sie unter **www.tools-for-productivity.com**

*Tools for Productivity – **tool + technology + application** – will guide you directly to your goal of perfected machining and highest possible productivity. Our high performance cutting materials, precision tooling systems and our extensive range of services are perfectly tailored to meet the demands resulting from higher productivity. Our productivity compass is the productivity seal you can trust. More information can be found at: **www.tools-for-productivity.com***



Das Stechsystem RAG / <i>The RAG Grooving System</i>	4 - 5
Bearbeitungsbeispiele / <i>Machining Examples</i>	6 - 7
SPK Bezeichnungssystem für RAG / <i>SPK Designation System for RAG</i>	8 - 11
Schnittdatenempfehlung für seitliches Verfahren / <i>Cutting Data Recommendations for Lateral Movement</i>	12
Schneidplatten für RAG Stechsystem / <i>Inserts for RAG Grooving System</i>	13 - 15
Schaftwerkzeuge für RAG Stechsystem / <i>Shank Tools for RAG Grooving System</i>	17 - 49
CMS-Schneidköpfe für RAG Stechsystem / <i>CMS Cutting Heads for RAG Grooving System</i>	51 - 67
Notizen / <i>Notice</i>	68 - 69
Allgemeine Bedingungen / <i>General terms</i>	70

Das Stechsystem RAG - Radial- und Axialstechen mit seitlichem Verfahren The RAG Grooving System - Radial and axial grooving with lateral movement

Das Stechsystem wurde speziell für das prozesssichere radiale und axiale Stechen in GJL (GG)- und GJS (GGG)-Werkstoffe und zum seitlichen Verfahren konzipiert. Die neue Doppelprisma-Klemmtechnologie nimmt Querkräfte sicher auf und hält die Stechplatte positionsgenau im Plattensitz. Damit lassen sich auch seitliche Vorschubbewegungen prozesssicher realisieren. Je nach Auslegung der Werkzeuge, können beim seitlichen Verfahren Stechtiefen bis 3 mm bei Vorschüben bis 0,25 mm und

The grooving system is designed specifically for radial and axial grooving in GJL (grey cast iron) and GJS (ductile cast iron) materials and for lateral movement, and ensures complete process reliability. The new double prism clamping technology is able to securely absorb transverse forces while holding the grooving insert in position in the insert seating. It also facilitates lateral feed movements with process reliability. Depending on the tool design, grooving depth of up to 3 mm with feed rates up to 0.25 mm

Schnittgeschwindigkeit bis zu 800 m/min gefahren werden. Das Stechschwert und die Klemmelemente überzeugen als extrem stabiles Gesamtsystem. Das System ist modular aufgebaut, Stechschwert und Klemmfinger sind einfach und schnell austauschbar und aus hochwarmfestem Material gefertigt.

Es sind Stechbreiten von 4 bis 8 Millimeter erhältlich. Wird der Grundhalter mit entsprechendem Stechschwert ausgerüstet, sind Stechtiefen bis zu 30 Millimeter mög-

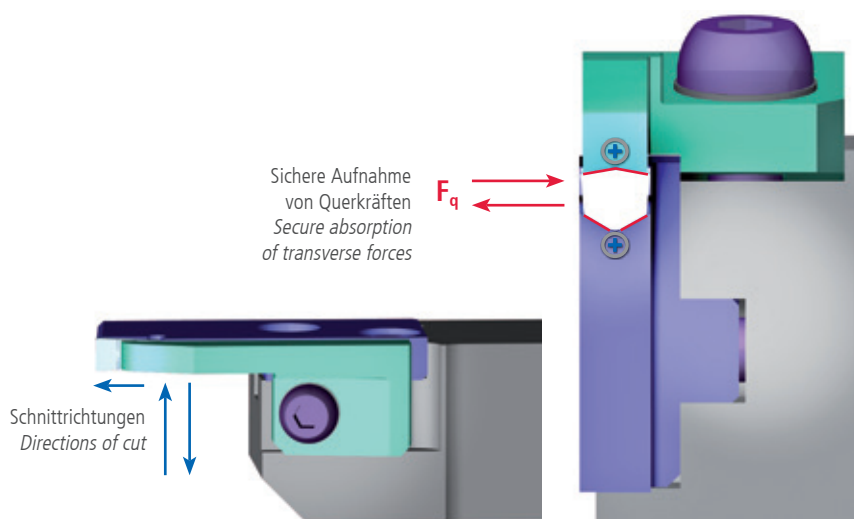
and cutting speeds of up to 800 m/min can be attained with lateral movement. The grooving blade and clamping elements together form an extremely stable complete system. The system is modular and features a grooving blade and clamping element that are made from high temperature-resistant material and are quick and easy to replace.

It is available for grooving widths between 4 mm and 12 mm. If the tool holder is equipped with the appropriate grooving

lich. Durch das Stechdrehen mit seitlichem Verfahren lassen sich mehrere Bearbeitungsschritte mit nur einem Werkzeugsystem abdecken. Das spart weitere Werkzeuge und damit auch Werkzeugplätze auf dem Revolver. In Kombination mit unseren Hochleistungsschneidstoffen steigert das Stechsystem RAG die Prozessflexibilität und gleichzeitig die Produktivität für eine schnellere und kostengünstigere Produktion.

blade, grooving depths of up to 30 mm are attainable. Grooving with lateral movement means that several machining steps can be performed by a single tool system. This means that additional tools are not required, which saves space on the tool turret. When further combined with our high-performance cutting materials, the RAG grooving system increases both process flexibility and productivity, ensuring a faster and more cost-efficient production process.

EASY CHANGE TECHNOLOGIE



Durch die EASY Change Technologie wird auch ein einfacher Wechsel von keramischen Schneidplatten und CBN-Schneidplatten ermöglicht, ohne den Klemmfinger oder das Schwert auszutauschen.

EASY Change Technology also allows easy exchangeability of ceramic inserts and CBN inserts without the need to replace the clamping finger or the grooving blade.

Das Stechsystem RAG - Radial- und Axialstechen mit seitlichem Verfahren

The RAG Grooving System - Radial and axial grooving with lateral movement


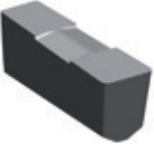
RAG Stechbreiten und Stechtiefen

RAG grooving widths and depths

Stechbreite Grooving width	Stechtiefe / Grooving depth			
	12 mm	18 mm	24 mm	30 mm
4 mm	●	●		
5 mm	●	●	●	
6 mm	●	●	●	●
7 mm	●	●	●	●
8 mm		●	●	●

Grundgeometrien Schneidplatten

Basic insert geometries

		Typ Type
	Zweischneidige Schneidplatten für kleine Stechtiefen und Formeinstiche Inserts with two cutting edges for smaller grooving depths and different shaped groovings	L
	Einschneidige Schneidplatten für große Stechtiefen Inserts with one cutting edge for large grooving depths	G

i Schneidstoffsorten

Types of cutting material

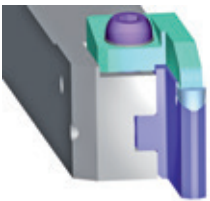
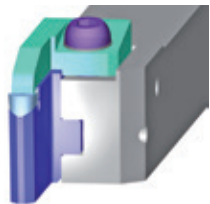
SiALON SL608
SiALON SL608
Oxid-Keramik SN60
Oxide ceramic SN60

RAG AUSFÜHRUNGSVARIANTEN

RAG VERSIONS

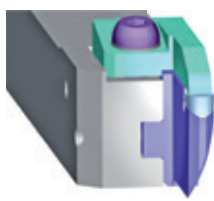
Radialstechen

Radial grooving



Axialstechen

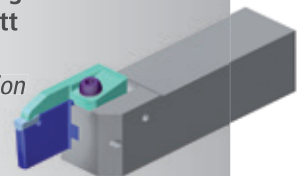
Axial grooving



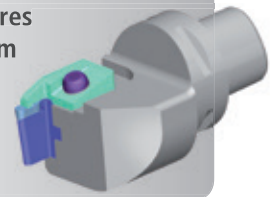
i Basishalter

Basic tool holder

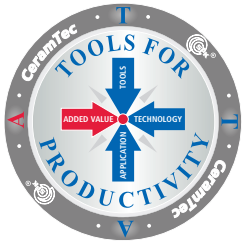
Schaftwerkzeuge mit Querschnitt
Shank tools with cross section
25 x 25
32 x 25



CMS5 - Modulares Werkzeugsystem
CMS5 - Modular tool system



Stechschwerter und Spannfinger aus hochwarmfestem Material
Grooving blade and clamping element made from high temperature-resistant material



BEARBEITUNGSZEIT UM 31 % VERRINGERT
PROCESSING TIME DECREASED BY 31 %
STECHDREHEN EINER RIEMENSCHLEIBE
GROOVING OF A PULLEY

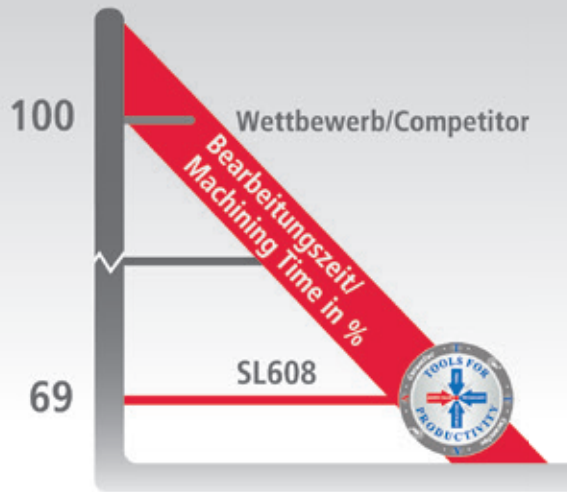
ANFORDERUNGEN:
REQUIREMENTS:

- BEARBEITUNGSZEIT REDUZIEREN
- REDUCTION OF MACHINING TIME
- KEINE GRATBILDUNG
- NO BURRS

BEDINGUNGEN:
CONDITIONS:

- GLATTER SCHNITT
- CONTINUOUS CUT
- TROCKENBEARBEITUNG
- DRY CUTTING
- WERKSTOFF GJL 300
- MATERIAL GJL 300

SiAlON SL608



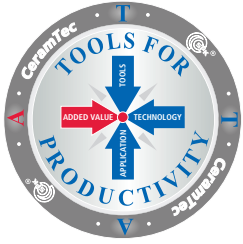
SPK-ENGINEERING ZUR STEIGERUNG DER WIRTSCHAFTLICHKEIT DURCH
SPK ENGINEERING FOR INCREASING EFFICIENCY THROUGH

- ABSTIMMUNG WERKSTOFF-/SCHNEIDSTOFF PAARUNG
- HARMONIZING OF WORKPIECE- AND CUTTING MATERIALS
- DEFINITION DER BEARBEITUNGSSTRATEGIE
- DEFINITION OF MACHINING STRATEGY
- FESTLEGUNG DER SCHNITTPARAMETER
- DEFINITION OF CUTTING DATA

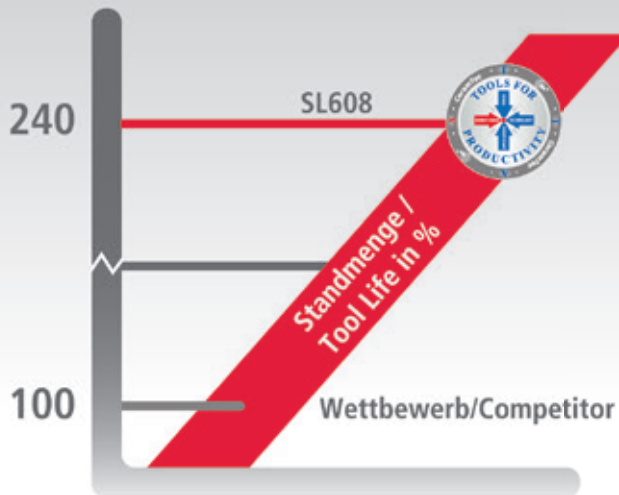
Bearbeitung: Längs- und Plandrehen einer Riemenschleibe
Machining of a Pulley: Grooving and facing

	Wettbewerb Competitor	SPK
Schneidstoff Cutting material:	Hartmetall Carbide	SL608
Schneidplattentyp Insert type:	-	GBMP 12A0800
Schnittgeschwindigkeit v_c : Cutting speed v_c :	250 m/min	800 m/min
Vorschub f : Feed rate f :	0,12 mm	0,10 mm
Schnitttiefe a_p : Depth of cut a_p :	1,5 mm	1,5 mm
Bearbeitungszeit: Machining time:	15,3 min	4,8 min
Standmenge: Tool life quantity:	30 St. / pcs.	30 St./ pcs.





STANDMENGE AUF 240 % ERHÖHT
TOOL LIFE QUANTITY INCREASED BY 240 %
STECHDREHEN EINER POLY-V SCHEIBE
SEMI FINISHING OF A POLY-V DISC



ANFORDERUNGEN:
REQUIREMENTS:

- STANDMENGE ERHÖHEN
- INCREASE TOOL LIFE QUANTITY
- PROZESSSICHERHEIT
- PROCESS RELIABILITY

BEDINGUNGEN:

- GLATTER SCHNITT
- CONTINUOUS CUT
- TROCKENBEARBEITUNG
- DRY CUTTING

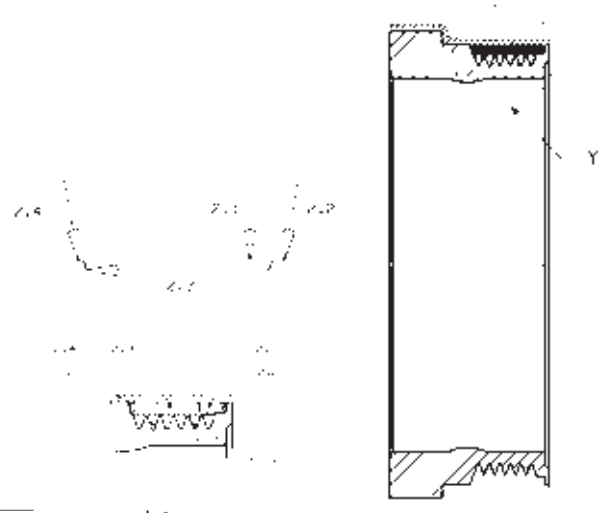
SiALON SL608

SPK-ENGINEERING ZUR STEIGERUNG DER WIRTSCHAFTLICHKEIT DURCH
SPK ENGINEERING FOR INCREASING EFFICIENCY THROUGH

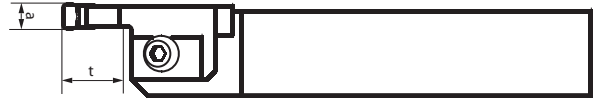
- DEFINITION DER BEARBEITUNGSSTRATEGIE
- DEFINITION OF MACHINING STRATEGY
- FESTLEGUNG DER SCHNITTPARAMETER
- DEFINITION OF CUTTING DATA

Schrupp-Schichten einer Poly-V Scheibe
Semi finishing of a Poly-V Disc

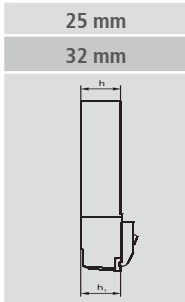
	Wettbewerb Competitor	SPK
Schneidstoff Cutting material:	Hartmetall Carbide	SL608
Schneidplattentyp Insert type:	-	GBMP 12A0600T
Schnittgeschwindigkeit v_c : Cutting speed v_c :	230 m/min	600 m/min
Vorschub f : Feed rate f :	0,20 mm	0,10 mm
Schnitttiefe a_p : Depth of cut a_p :	2,0 mm	2,0 mm
Standmenge: Tool life quantity:	100 %	240 %



RAG Schaftklemmhalter
 RAG shank tool



RAG = Radial
 Axial
 Stechen
 (Grooving)



- B4 = 4 mm
- B5 = 5 mm
- B6 = 6 mm
- B7 = 7 mm
- B8 = 8 mm

H = 5 mm

- Gerade
Straight
- Links
Left
- Rechts
Right

Bezeichnung
 Stechsystem
 Designation
 grooving system

Werkzeughöhe h
 Tool height h

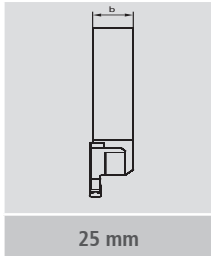
Stechbreite a
 Grooving width a

Schneidplatten-
 höhe
 Insert height

Ausführung
 Stechschwert
 Grooving blade version

RAG - 25 25 - B4 T18 H5 - L G 100

Schaftbreite b
 Shank width b



Stechtiefe t
 Grooving depth t

- T12 = 12 mm
- T18 = 18 mm
- T24 = 24 mm
- T30 = 30 mm

Ausführung
 Version

- links
Left
- rechts
Right

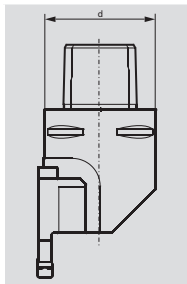
D_{min} Axial
 D_{min} Axial

D_{min} = 100 mm

RAG CMS Klemmhalter
 RAG CMS tool holder

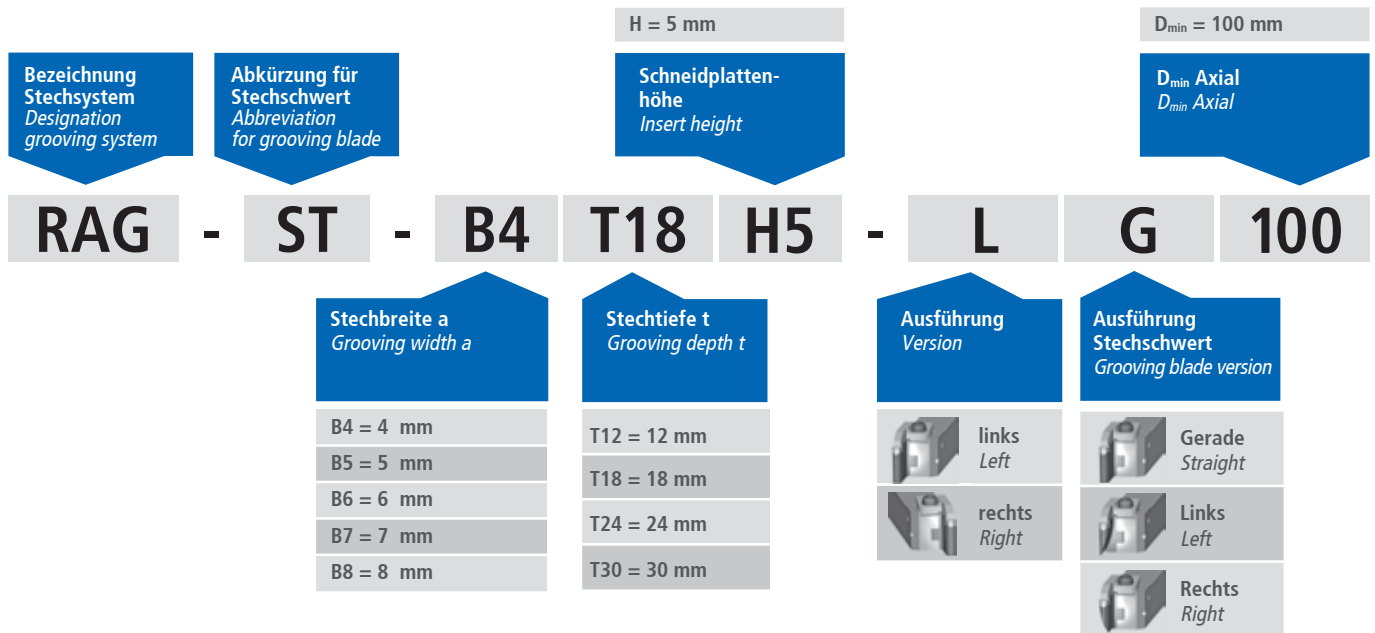
RAG - CMS5 - B4 T18 H5 - L G 100

Werkzeuggröße
 Tool size
 d = 50 mm

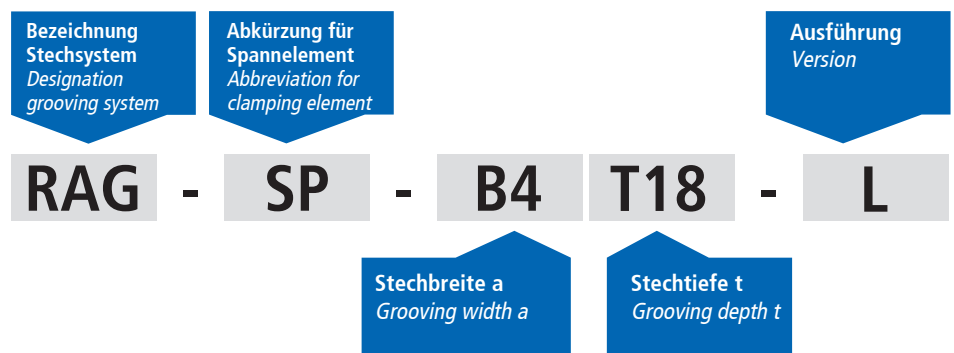


SPK Bezeichnungssystem für RAG SPK Designation System for RAG

RAG Stechschwerter RAG grooving blade

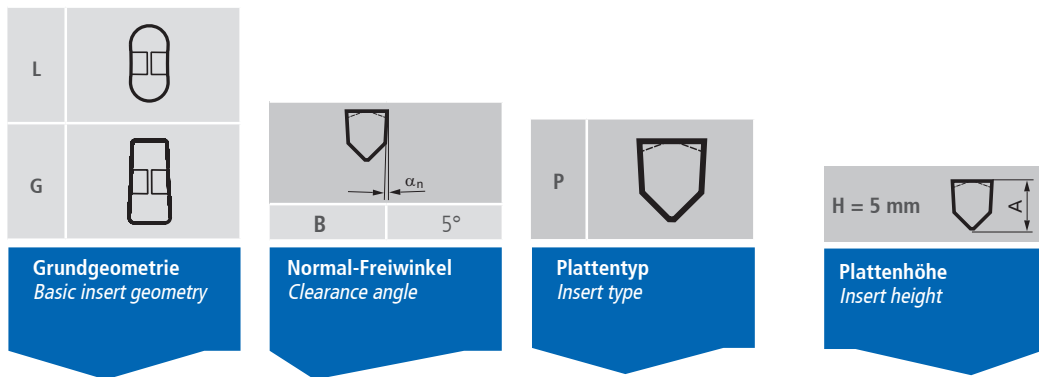


RAG Spannelemente RAG clamping elements

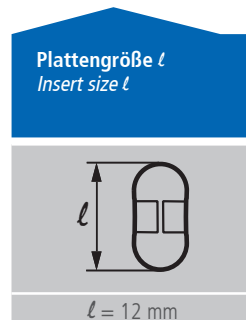
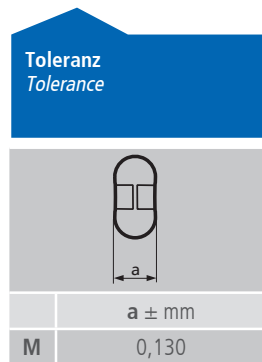


SPK Bezeichnungssystem für RAG Schneidplatten

SPK Designation System for RAG Inserts



G **B** **M** **P** **12** **A**



SPK Bezeichnungssystem für RAG Schneidplatten

SPK Designation System for RAG Inserts

	<p>E</p> <p>Gerundet</p>	<p>GBMP</p>	<p>Oxidkeramik SN60</p> <p>SiAlON SL608</p>												
<p>0400 = 4 mm</p> <p>0500 = 5 mm</p> <p>0600 = 6 mm</p> <p>0700 = 7 mm</p> <p>0800 = 8 mm</p>	<p>T</p> <p>Gefast</p>	<table border="1"> <tr> <th>L</th> <th>R</th> </tr> <tr> <td>0.5 mm</td> <td>0.5 mm</td> </tr> <tr> <td>0.8 mm</td> <td>0.8 mm</td> </tr> </table>	L	R	0.5 mm	0.5 mm	0.8 mm	0.8 mm	<p>Sorte Cutting material</p>						
L	R														
0.5 mm	0.5 mm														
0.8 mm	0.8 mm														
<p>Stechbreite a Grooving width a</p>	<p>Schneidenausführung Cutting edge version</p>	<p>LBMP</p>	<p>Radi r Radius r</p>												
<table border="1"> <tr> <th>L</th> <th>R</th> </tr> <tr> <td>2 mm</td> <td>2 mm</td> </tr> <tr> <td>2.5 mm</td> <td>2.5 mm</td> </tr> <tr> <td>3 mm</td> <td>3 mm</td> </tr> <tr> <td>3.5 mm</td> <td>3.5 mm</td> </tr> <tr> <td>4 mm</td> <td>4 mm</td> </tr> </table>	L	R	2 mm	2 mm	2.5 mm	2.5 mm	3 mm	3 mm	3.5 mm	3.5 mm	4 mm	4 mm	<p>0400 T - N L1R1 - RAG SL608</p>	<p>Sorte Cutting material</p>	<p>Bezeichnung Stechsystem Designation grooving system</p>
L	R														
2 mm	2 mm														
2.5 mm	2.5 mm														
3 mm	3 mm														
3.5 mm	3.5 mm														
4 mm	4 mm														
<p>Schneidrichtung S Cutting direction S</p>	<p>N neutral</p>	<p>Sorte Cutting material</p>	<p>Bezeichnung Stechsystem Designation grooving system</p>												

Schnittdatenempfehlung für seitliches Verfahren in Gusseisen GJL und GJS

Cutting Data recommendations for lateral movement in GJL and GJS cast iron

Eingriffstiefe a_p (mm)

in Abhängigkeit von Stechbreite a und maximaler Stechtiefe t_{max}

Cutting depth a_p (mm)

Depending on grooving width a and maximum grooving depth t_{max}

Vorschub f (mm)

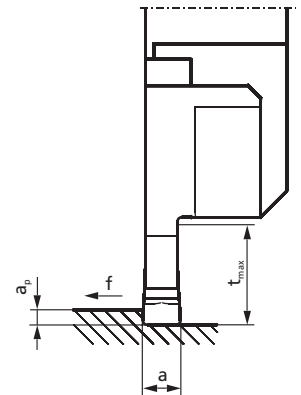
in Abhängigkeit von Stechbreite a und maximaler Stechtiefe t_{max}

Feed rate f (mm)

Depending on grooving width a and maximum grooving depth t_{max}

t_{max}	12 mm	18 mm	24 mm	30 mm
STECHBREITE a <i>GROOVING WIDTH</i>				
4 mm	2,0	1,5	-	-
5 mm	2,5	2,5	2,0	-
6 mm	3,0	2,5	2,0	-
7 mm	3,0	2,5	2,0	2,0
8 mm	-	3,0	2,5	2,0

t_{max}	12 mm	18 mm	24 mm	30 mm
STECHBREITE a <i>GROOVING WIDTH</i>				
4 mm	0,20	0,15	-	-
5 mm	0,20	0,20	0,15	-
6 mm	0,25	0,20	0,15	-
7 mm	0,25	0,20	0,20	0,15
8 mm	-	0,25	0,20	0,15



Schnittgeschwindigkeit v_c (m/min)

Cutting speed v_c (m/min)

Glatter Schnitt <i>Continuous cut</i>	Richtwerte <i>Recommended values</i>	
	SL608	SN60
Schlichten <i>Finishing</i>		
GJL Werkstoffe <i>GJL materials</i>	800 m/min	600 m/min
GJS Werkstoffe <i>GJS materials</i>	600 m/min	500 m/min
Schruppen <i>Roughing</i>		
GJL Werkstoffe <i>GJL materials</i>	600 m/min	400 m/min
GJS Werkstoffe <i>GJS materials</i>	500 m/min	400 m/min

Unterbrochener Schnitt <i>Interrupted cut</i>	Richtwerte <i>Recommended values</i>	
	SL608	
Schlichten <i>Finishing</i>		
GJL Werkstoffe <i>GJL materials</i>	800 m/min	
GJS Werkstoffe <i>GJS materials</i>	700 m/min	
Schruppen <i>Roughing</i>		
GJL Werkstoffe <i>GJL materials</i>	700 m/min	
GJS Werkstoffe <i>GJS materials</i>	600 m/min	

Schneidplatten für Stechsystem RAG
Inserts for RAG Grooving System



Schneidplatten RAG Stechsystem

Inserts for RAG Grooving System

GBMP

Stechbreite a Grooving width a	SPK-Bezeichnung SPK designation	Sorte Grade	Best.-Nr. Ref. no.	Form Shape	Abmessungen (mm) Dimensions (mm)					
					Radi r		h	ℓ	Fase Chamfer	S
					L	R				
a = 4 mm	GBMP 12A0400 T-N L0.5R0.5-RAG SL608	SL 608	19.23.505.03.3		0.5	0.5	5	12	T 00520	N
	GBMP 12A0400 T-N L0.5R0.5-RAG SN60	SN 60	36.23.505.03.5		0.5	0.5	5	12	T 00520	N
a = 5 mm	GBMP 12A0500 T-N L0.8R0.8-RAG SL608	SL 608	19.23.506.03.3		0.8	0.8	5	12	T 00520	N
	GBMP 12A0500 T-N L0.8R0.8-RAG SN60	SN 60	36.23.506.03.5		0.8	0.8	5	12	T 00520	N
a = 6 mm	GBMP 12A0600 T-N L0.8R0.8-RAG SL608	SL 608	19.23.507.03.3		0.8	0.8	5	12	T 00520	N
	GBMP 12A0600 T-N L0.8R0.8-RAG SN60	SN 60	36.23.507.03.5		0.8	0.8	5	12	T 00520	N
a = 7 mm	GBMP 12A0700 T-N L0.8R0.8-RAG SL608	SL 608	19.23.508.03.3		0.8	0.8	5	12	T 00520	N
	GBMP 12A0700 T-N L0.8R0.8-RAG SN60	SN 60	36.23.508.03.5		0.8	0.8	5	12	T 00520	N
a = 8 mm	GBMP 12A0800 T-N L0.8R0.8-RAG SL608	SL 608	19.23.509.03.3		0.8	0.8	5	12	T 00520	N
	GBMP 12A0800 T-N L0.8R0.8-RAG SN60	SN 60	36.23.509.03.5		0.8	0.8	5	12	T 00520	N

Schneidplatten RAG Stechsystem

Inserts for RAG Grooving System

LBMP

Stechbreite a Grooving width a	SPK-Bezeichnung SPK designation	Sorte Grade	Best.-Nr. Ref. no.	Form Shape	Abmessungen (mm) Dimensions (mm)					
					Radi r		h	ℓ	Fase Chamfer	S
					L	R				
a = 4 mm	LBMP 12A0400 T-N L2R2-RAG SL608	SL 608	19.23.500.03.3		2	2	5	12	T 00520	N
	LBMP 12A0400 T-N L2R2-RAG SN60	SN 60	36.23.500.03.5		2	2	5	12	T 00520	N
a = 5 mm	LBMP 12A0500 T-N L2.5R2.5-RAG SL608	SL 608	19.23.501.03.3		2.5	2.5	5	12	T 00520	N
	LBMP 12A0500 T-N L2.5R2.5-RAG SN60	SN 60	36.23.501.03.5		2.5	2.5	5	12	T 00520	N
a = 6 mm	LBMP 12A0600 T-N L3R3-RAG SL608	SL 608	19.23.502.03.3		3	3	5	12	T 00520	N
	LBMP 12A0600 T-N L3R3-RAG SN60	SN 60	36.23.502.03.5		3	3	5	12	T 00520	N
a = 7 mm	LBMP 12A0700 T-N L3.5R3.5-RAG SL608	SL 608	19.23.503.03.3		3.5	3.5	5	12	T 00520	N
	LBMP 12A0700 T-N L3.5R3.5-RAG SN60	SN 60	36.23.503.03.5		3.5	3.5	5	12	T 00520	N
a = 8 mm	LBMP 12A0800 T-N L4R4-RAG SL608	SL 608	19.23.504.03.3		4	4	5	12	T 00520	N
	LBMP 12A0800 T-N L4R4-RAG SN60	SN 60	36.23.504.03.5		4	4	5	12	T 00520	N



Schaftwerkzeuge für RAG Stechsystem
Shank Tools RAG Grooving System

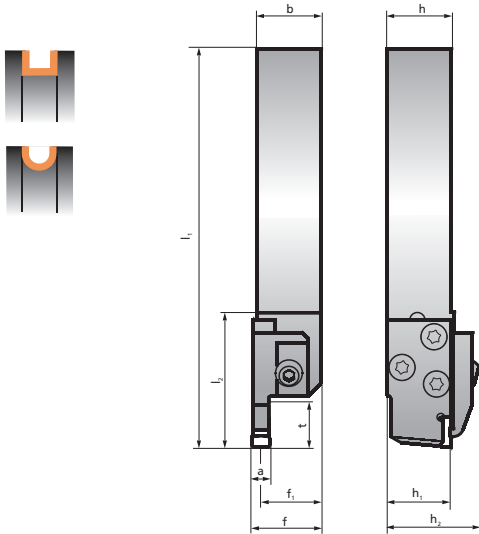


RAG Stechsystem

RAG Grooving System







STECHBREITE GROOVING WIDTH 4 MM
 STECHTIEFE GROOVING DEPTH 12 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
 2525



Schaft Shank	Abmessungen Dimensions (mm)								
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂
2525	25	25	150	47	12	4	23,5	$f_1 + \frac{a}{2}$	36
3225	32	25	170	47	12	4	23,5	$f_1 + \frac{a}{2}$	43

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 4 mm t = 12 mm	 RAG-2525-B4T12H5-LG	719.78.010.01	RAG-ST-B4T12H5-LG	70.91.22.548.0	RAG-SP-B4T12-L	70.91.11.916.0
	 RAG-2525-B4T12H5-LR100	719.78.010.02	RAG-ST-B4T12H5-LR100	70.91.22.549.0	RAG-SP-B4T12-L	70.91.11.916.0
	 RAG-2525-B4T12H5-LL100	719.78.010.03	RAG-ST-B4T12H5-LL100	70.91.22.550.0	RAG-SP-B4T12-L	70.91.11.916.0
Rechts Right a = 4 mm t = 12 mm	 RAG-2525-B4T12H5-RG	719.77.010.01	RAG-ST-B4T12H5-RG	70.91.22.500.0	RAG-SP-B4T12-R	70.91.11.900.0
	 RAG-2525-B4T12H5-RL100	719.77.010.02	RAG-ST-B4T12H5-RL100	70.91.22.501.0	RAG-SP-B4T12-R	70.91.11.900.0
	 RAG-2525-B4T12H5-RR100	719.77.010.03	RAG-ST-B4T12H5-RR100	70.91.22.502.0	RAG-SP-B4T12-R	70.91.11.900.0









33.60.09.11.004.0



70.91.55.224.0

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 4 MM
STECHTIEFE GROOVING DEPTH 12 MM

Stechbreite a Stechtiefe t <i>Grooving width a Grooving depth t</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Stechschwert <i>Grooving blade</i>		Spannelement <i>Clamping element</i>	
		3225	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>
Links <i>Left</i> a = 4 mm t = 12 mm	 RAG-3225-B4T12H5-LG	719.78.011.01	RAG-ST-B4T12H5-LG	70.91.22.548.0	RAG-SP-B4T12-L	70.91.11.916.0
	 RAG-3225-B4T12H5-LR100	719.78.011.02	RAG-ST-B4T12H5-LR100	70.91.22.549.0	RAG-SP-B4T12-L	70.91.11.916.0
	 RAG-3225-B4T12H5-LL100	719.78.011.03	RAG-ST-B4T12H5-LL100	70.91.22.550.0	RAG-SP-B4T12-L	70.91.11.916.0
Rechts <i>Right</i> a = 4 mm t = 12 mm	 RAG-3225-B4T12H5-RG	719.77.011.01	RAG-ST-B4T12H5-RG	70.91.22.500.0	RAG-SP-B4T12-R	70.91.11.900.0
	 RAG-3225-B4T12H5-RL100	719.77.011.02	RAG-ST-B4T12H5-RL100	70.91.22.501.0	RAG-SP-B4T12-R	70.91.11.900.0
	 RAG-3225-B4T12H5-RR100	719.77.011.03	RAG-ST-B4T12H5-RR100	70.91.22.502.0	RAG-SP-B4T12-R	70.91.11.900.0



33.60.09.11.004.0



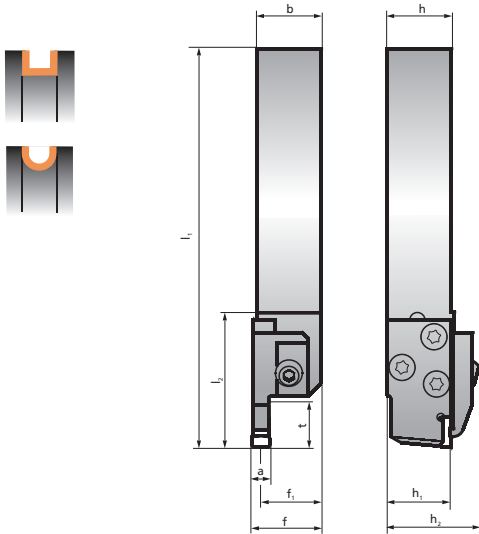
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RAG Stechsystem

RAG Grooving System

STECHBREITE GROOVING WIDTH 4 MM
 STECHTIEFE GROOVING DEPTH 18 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
 2525



Schaft Shank	Abmessungen Dimensions (mm)								
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂
2525	25	25	156	47	18	4	23,5	$f_1 + \frac{a}{2}$	36
3225	32	25	176	47	18	4	23,5	$f_1 + \frac{a}{2}$	43

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 4 mm t = 18 mm	RAG-2525-B4T18H5-LG	719.78.010.04	RAG-ST-B4T18H5-LG	70.91.22.551.0	RAG-SP-B4T18-L	70.91.11.917.0
	RAG-2525-B4T18H5-LR100	719.78.010.05	RAG-ST-B4T18H5-LR100	70.91.22.552.0	RAG-SP-B4T18-L	70.91.11.917.0
	RAG-2525-B4T18H5-LL100	719.78.010.06	RAG-ST-B4T18H5-LL100	70.91.22.553.0	RAG-SP-B4T18-L	70.91.11.917.0
Rechts Right a = 4 mm t = 18 mm	RAG-2525-B4T18H5-RG	719.77.010.04	RAG-ST-B4T18H5-RG	70.91.22.503.0	RAG-SP-B4T18-R	70.91.11.901.0
	RAG-2525-B4T18H5-RL100	719.77.010.05	RAG-ST-B4T18H5-RL100	70.91.22.504.0	RAG-SP-B4T18-R	70.91.11.901.0
	RAG-2525-B4T18H5-RR100	719.77.010.06	RAG-ST-B4T18H5-RR100	70.91.22.505.0	RAG-SP-B4T18-R	70.91.11.901.0









33.60.09.11.004.0



70.91.55.224.0

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 4 MM
STECHTIEFE GROOVING DEPTH 18 MM

Stechbreite a Stechtiefe t <i>Grooving width a Grooving depth t</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Stechschwert <i>Grooving blade</i>		Spannelement <i>Clamping element</i>	
		3225	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>
Links <i>Left</i> a = 4 mm t = 18 mm	 RAG-3225-B4T18H5-LG	719.78.011.04	RAG-ST-B4T18H5-LG	70.91.22.551.0	RAG-SP-B4T18-L	70.91.11.917.0
	 RAG-3225-B4T18H5-LR100	719.78.011.05	RAG-ST-B4T18H5-LR100	70.91.22.552.0	RAG-SP-B4T18-L	70.91.11.917.0
	 RAG-3225-B4T18H5-LL100	719.78.011.06	RAG-ST-B4T18H5-LL100	70.91.22.553.0	RAG-SP-B4T18-L	70.91.11.917.0
Rechts <i>Right</i> a = 4 mm t = 18 mm	 RAG-3225-B4T18H5-RG	719.77.011.04	RAG-ST-B4T18H5-RG	70.91.22.503.0	RAG-SP-B4T18-R	70.91.11.901.0
	 RAG-3225-B4T18H5-RL100	719.77.011.05	RAG-ST-B4T18H5-RL100	70.91.22.504.0	RAG-SP-B4T18-R	70.91.11.901.0
	 RAG-3225-B4T18H5-RR100	719.77.011.06	RAG-ST-B4T18H5-RR100	70.91.22.505.0	RAG-SP-B4T18-R	70.91.11.901.0



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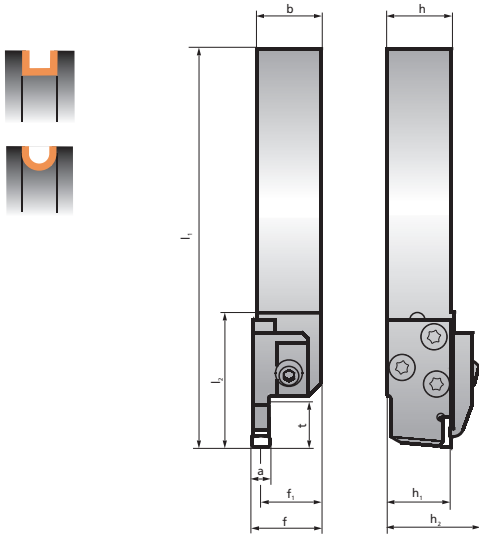
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RAG Stechsystem

RAG Grooving System







STECHBREITE GROOVING WIDTH 5 MM
 STECHTIEFE GROOVING DEPTH 12 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
 2525



Schaft Shank	Abmessungen Dimensions (mm)								
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂
2525	25	25	150	47	12	5	23,5	$f_1 + \frac{a}{2}$	36
3225	32	25	170	47	12	5	23,5	$f_1 + \frac{a}{2}$	43

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 5 mm t = 12 mm	 RAG-2525-B5T12H5-LG	719.78.010.07	RAG-ST-B5T12H5-LG	70.91.22.554.0	RAG-SP-B5T12-L	70.91.11.918.0
	 RAG-2525-B5T12H5-LR100	719.78.010.08	RAG-ST-B5T12H5-LR100	70.91.22.555.0	RAG-SP-B5T12-L	70.91.11.918.0
	 RAG-2525-B5T12H5-LL100	719.78.010.09	RAG-ST-B5T12H5-LL100	70.91.22.556.0	RAG-SP-B5T12-L	70.91.11.918.0
Rechts Right a = 5 mm t = 12 mm	 RAG-2525-B5T12H5-RG	719.77.010.07	RAG-ST-B5T12H5-RG	70.91.22.506.0	RAG-SP-B5T12-R	70.91.11.902
	 RAG-2525-B5T12H5-RL100	719.77.010.08	RAG-ST-B5T12H5-RL100	70.91.22.507.0	RAG-SP-B5T12-R	70.91.11.902.0
	 RAG-2525-B5T12H5-RR100	719.77.010.09	RAG-ST-B5T12H5-RR100	70.91.22.508.0	RAG-SP-B5T12-R	70.91.11.902.0









33.60.09.11.004.0



70.91.55.224.0

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 5 MM
STECHTIEFE GROOVING DEPTH 12 MM

Stechbreite a Stechtiefe t <i>Grooving width a Grooving depth t</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Stechschwert <i>Grooving blade</i>		Spannelement <i>Clamping element</i>	
		3225	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>
Links <i>Left</i> a = 5 mm t = 12 mm	 RAG-3225-B5T12H5-LG	719.78.011.07	RAG-ST-B5T12H5-LG	70.91.22.554.0	RAG-SP-B5T12-L	70.91.11.918
	 RAG-3225-B5T12H5-LR100	719.78.011.08	RAG-ST-B5T12H5-LR100	70.91.22.555.0	RAG-SP-B5T12-L	70.91.11.918.0
	 RAG-3225-B5T12H5-LL100	719.78.011.09	RAG-ST-B5T12H5-LL100	70.91.22.556.0	RAG-SP-B5T12-L	70.91.11.918.0
Rechts <i>Right</i> a = 5 mm t = 12 mm	 RAG-3225-B5T12H5-RG	719.77.011.07	RAG-ST-B5T12H5-RG	70.91.22.506.0	RAG-SP-B5T12-R	70.91.11.902.0
	 RAG-3225-B5T12H5-RL100	719.77.011.08	RAG-ST-B5T12H5-RL100	70.91.22.507.0	RAG-SP-B5T12-R	70.91.11.902.0
	 RAG-3225-B5T12H5-RR100	719.77.011.09	RAG-ST-B5T12H5-RR100	70.91.22.508.0	RAG-SP-B5T12-R	70.91.11.902.0



33.60.09.11.004.0



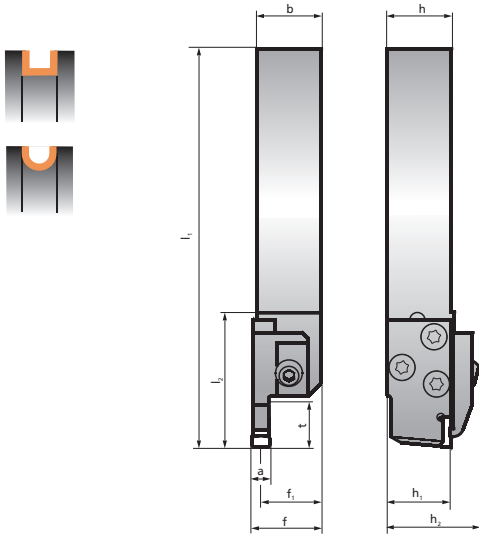
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RAG Stechsystem

RAG Grooving System

STECHBREITE GROOVING WIDTH 5 MM
 STECHTIEFE GROOVING DEPTH 18 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
 2525



Schaft Shank	Abmessungen Dimensions (mm)								
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂
2525	25	25	156	47	18	5	23,5	$f_1 + \frac{a}{2}$	36
3225	32	25	176	47	18	5	23,5	$f_1 + \frac{a}{2}$	43

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°







Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element		
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 5 mm t = 18 mm		RAG-2525-B5T18H5-LG	719.78.010.10	RAG-ST-B5T18H5-LG	70.91.22.557.0	RAG-SP-B5T18-L	70.91.11.919.0
		RAG-2525-B5T18H5-LR100	719.78.010.11	RAG-ST-B5T18H5-LR100	70.91.22.558.0	RAG-SP-B5T18-L	70.91.11.919.0
		RAG-2525-B5T18H5-LL100	719.78.010.12	RAG-ST-B5T18H5-LL100	70.91.22.559.0	RAG-SP-B5T18-L	70.91.11.919.0
Rechts Right a = 5 mm t = 18 mm		RAG-2525-B5T18H5-RG	719.77.010.10	RAG-ST-B5T18H5-RG	70.91.22.509.0	RAG-SP-B5T18-R	70.91.11.903.0
		RAG-2525-B5T18H5-RL100	719.77.010.11	RAG-ST-B5T18H5-RL100	70.91.22.510.0	RAG-SP-B5T18-R	70.91.11.903.0
		RAG-2525-B5T18H5-RR100	719.77.010.12	RAG-ST-B5T18H5-RR100	70.91.22.511.0	RAG-SP-B5T18-R	70.91.11.903.0



33.60.09.11.004.0



70.91.55.224.0

Stechbreite a Stechtiefe t <i>Grooving width a Grooving depth t</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Stechschwert <i>Grooving blade</i>		Spannelement <i>Clamping element</i>	
		3225	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>
Links <i>Left</i> a = 5 mm t = 18 mm	 RAG-3225-B5T18H5-LG	719.78.011.10	RAG-ST-B5T18H5-LG	70.91.22.557.0	RAG-SP-B5T18-L	70.91.11.919.0
	 RAG-3225-B5T18H5-LR100	719.78.011.11	RAG-ST-B5T18H5-LR100	70.91.22.558.0	RAG-SP-B5T18-L	70.91.11.919.0
	 RAG-3225-B5T18H5-LL100	719.78.011.12	RAG-ST-B5T18H5-LL100	70.91.22.559.0	RAG-SP-B5T18-L	70.91.11.919.0
Rechts <i>Right</i> a = 5 mm t = 18 mm	 RAG-3225-B5T18H5-RG	719.77.011.10	RAG-ST-B5T18H5-RG	70.91.22.509.0	RAG-SP-B5T18-R	70.91.11.903.0
	 RAG-3225-B5T18H5-RL100	719.77.011.11	RAG-ST-B5T18H5-RL100	70.91.22.510.0	RAG-SP-B5T18-R	70.91.11.903.0
	 RAG-3225-B5T18H5-RR100	719.77.011.12	RAG-ST-B5T18H5-RR100	70.91.22.511.0	RAG-SP-B5T18-R	70.91.11.903.0



33.60.09.11.004.0



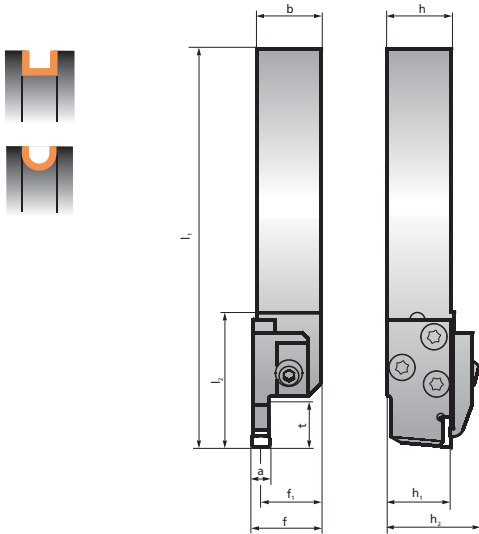
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RAG Stechsystem

RAG Grooving System







STECHBREITE GROOVING WIDTH 5 MM
 STECHTIEFE GROOVING DEPTH 24 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
 2525



Schaft Shank	Abmessungen Dimensions (mm)								
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂
2525	25	25	162	47	24	5	23,5	$f_1 + \frac{a}{2}$	36
3225	32	25	182	47	24	5	23,5	$f_1 + \frac{a}{2}$	43

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 5 mm t = 24 mm	 RAG-2525-B5T24H5-LG	719.78.010.13	RAG-ST-B5T24H5-LG	70.91.22.560.0	RAG-SP-B5T24-L	70.91.11.920.0
	 RAG-2525-B5T24H5-LR100	719.78.010.14	RAG-ST-B5T24H5-LR100	70.91.22.561.0	RAG-SP-B5T24-L	70.91.11.920.0
	 RAG-2525-B5T24H5-LL100	719.78.010.15	RAG-ST-B5T24H5-LL100	70.91.22.562.0	RAG-SP-B5T24-L	70.91.11.920.0
Rechts Right a = 5 mm t = 24 mm	 RAG-2525-B5T24H5-RG	719.77.010.13	RAG-ST-B5T24H5-RG	70.91.22.512.0	RAG-SP-B5T24-R	70.91.11.904.0
	 RAG-2525-B5T24H5-RL100	719.77.010.14	RAG-ST-B5T24H5-RL100	70.91.22.513.0	RAG-SP-B5T24-R	70.91.11.904.0
	 RAG-2525-B5T24H5-RR100	719.77.010.15	RAG-ST-B5T24H5-RR100	70.91.22.514.0	RAG-SP-B5T24-R	70.91.11.904.0









33.60.09.11.004.0



70.91.55.224.0

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 5 MM
STECHTIEFE GROOVING DEPTH 24 MM

Stechbreite a Stechtiefe t <i>Grooving width a Grooving depth t</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Stechschwert <i>Grooving blade</i>		Spannelement <i>Clamping element</i>	
		3225	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>
Links <i>Left</i> a = 5 mm t = 24 mm	 RAG-3225-B5T24H5-LG	719.78.011.13	RAG-ST-B5T24H5-LG	70.91.22.560.0	RAG-SP-B5T24-L	70.91.11.920.0
	 RAG-3225-B5T24H5-LR100	719.78.011.14	RAG-ST-B5T24H5-LR100	70.91.22.561.0	RAG-SP-B5T24-L	70.91.11.920.0
	 RAG-3225-B5T24H5-LL100	719.78.011.15	RAG-ST-B5T24H5-LL100	70.91.22.562.0	RAG-SP-B5T24-L	70.91.11.920.0
Rechts <i>Right</i> a = 5 mm t = 24 mm	 RAG-3225-B5T24H5-RG	719.77.011.13	RAG-ST-B5T24H5-RG	70.91.22.512.0	RAG-SP-B5T24-R	70.91.11.904.0
	 RAG-3225-B5T24H5-RL100	719.77.011.14	RAG-ST-B5T24H5-RL100	70.91.22.513.0	RAG-SP-B5T24-R	70.91.11.904.0
	 RAG-3225-B5T24H5-RR100	719.77.011.15	RAG-ST-B5T24H5-RR100	70.91.22.514.0	RAG-SP-B5T24-R	70.91.11.904.0



33.60.09.11.004.0



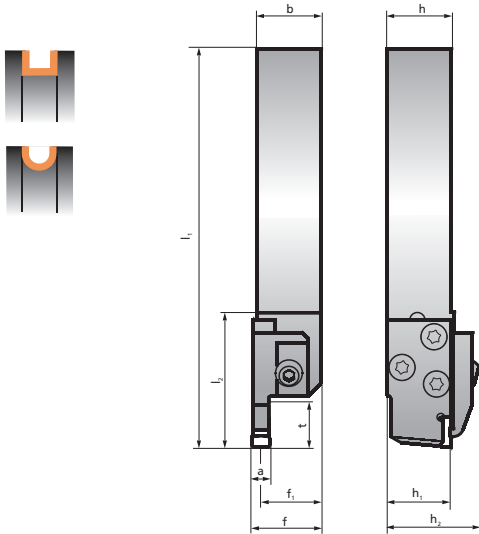
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RAG Stechsystem

RAG Grooving System

STECHBREITE GROOVING WIDTH 6 MM
 STECHTIEFE GROOVING DEPTH 12 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
 2525



Schaft Shank	Abmessungen Dimensions (mm)								
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂
2525	25	25	150	47	12	6	23,5	$f_1 + \frac{a}{2}$	36
3225	32	25	170	47	12	6	23,5	$f_1 + \frac{a}{2}$	43

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 6 mm t = 12 mm	RAG-2525-B6T12H5-LG	719.78.010.16	RAG-ST-B6T12H5-LG	70.91.22.563.0	RAG-SP-B6T12-L	70.91.11.921.0
	RAG-2525-B6T12H5-LR100	719.78.010.17	RAG-ST-B6T12H5-LR100	70.91.22.564.0	RAG-SP-B6T12-L	70.91.11.921.0
	RAG-2525-B6T12H5-LL100	719.78.010.18	RAG-ST-B6T12H5-LL100	70.91.22.565.0	RAG-SP-B6T12-L	70.91.11.921.0
Rechts Right a = 6 mm t = 12 mm	RAG-2525-B6T12H5-RG	719.77.010.16	RAG-ST-B6T12H5-RG	70.91.22.515.0	RAG-SP-B6T12-R	70.91.11.905.0
	RAG-2525-B6T12H5-RL100	719.77.010.17	RAG-ST-B6T12H5-RL100	70.91.22.516.0	RAG-SP-B6T12-R	70.91.11.905.0
	RAG-2525-B6T12H5-RR100	719.77.010.18	RAG-ST-B6T12H5-RR100	70.91.22.517.0	RAG-SP-B6T12-R	70.91.11.905.0









33.60.09.11.004.0



70.91.55.224.0

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 6 MM
STECHTIEFE GROOVING DEPTH 12 MM

Stechbreite a Stechtiefe t <i>Grooving width a Grooving depth t</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Stechschwert <i>Grooving blade</i>		Spannelement <i>Clamping element</i>	
		3225	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>
Links <i>Left</i> a = 6 mm t = 12 mm	 RAG-3225-B6T12H5-LG	719.78.011.16	RAG-ST-B6T12H5-LG	70.91.22.563.0	RAG-SP-B6T12-L	70.91.11.921.0
	 RAG-3225-B6T12H5-LR100	719.78.011.17	RAG-ST-B6T12H5-LR100	70.91.22.564.0	RAG-SP-B6T12-L	70.91.11.921.0
	 RAG-3225-B6T12H5-LL100	719.78.011.18	RAG-ST-B6T12H5-LL100	70.91.22.565.0	RAG-SP-B6T12-L	70.91.11.921.0
Rechts <i>Right</i> a = 6 mm t = 12 mm	 RAG-3225-B6T12H5-RG	719.77.011.16	RAG-ST-B6T12H5-RG	70.91.22.515.0	RAG-SP-B6T12-R	70.91.11.905.0
	 RAG-3225-B6T12H5-RL100	719.77.011.17	RAG-ST-B6T12H5-RL100	70.91.22.516.0	RAG-SP-B6T12-R	70.91.11.905.0
	 RAG-3225-B6T12H5-RR100	719.77.011.18	RAG-ST-B6T12H5-RR100	70.91.22.517.0	RAG-SP-B6T12-R	70.91.11.905.0



33.60.09.11.004.0



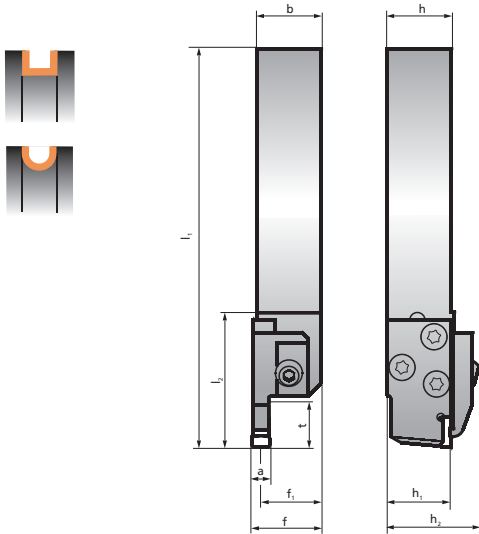
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RAG Stechsystem

RAG Grooving System







STECHBREITE GROOVING WIDTH 6 MM
 STECHTIEFE GROOVING DEPTH 18 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
 2525



Schaft Shank	Abmessungen Dimensions (mm)								
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂
2525	25	25	156	47	18	6	23,5	$f_1 + \frac{a}{2}$	36
3225	32	25	176	47	18	6	23,5	$f_1 + \frac{a}{2}$	43

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°







Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 6 mm t = 18 mm	 RAG-2525-B6T18H5-LG	719.78.010.19	RAG-ST-B6T18H5-LG	70.91.22.566.0	RAG-SP-B6T18-L	70.91.11.922.0
	 RAG-2525-B6T18H5-LR100	719.78.010.20	RAG-ST-B6T18H5-LR100	70.91.22.567.0	RAG-SP-B6T18-L	70.91.11.922.0
	 RAG-2525-B6T18H5-LL100	719.78.010.21	RAG-ST-B6T18H5-LL100	70.91.22.568.0	RAG-SP-B6T18-L	70.91.11.922.0
Rechts Right a = 6 mm t = 18 mm	 RAG-2525-B6T18H5-RG	719.77.010.19	RAG-ST-B6T18H5-RG	70.91.22.518.0	RAG-SP-B6T18-R	70.91.11.906.0
	 RAG-2525-B6T18H5-RL100	719.77.010.20	RAG-ST-B6T18H5-RL100	70.91.22.519.0	RAG-SP-B6T18-R	70.91.11.906.0
	 RAG-2525-B6T18H5-RR100	719.77.010.21	RAG-ST-B6T18H5-RR100	70.91.22.520.0	RAG-SP-B6T18-R	70.91.11.906.0



33.60.09.11.004.0



70.91.55.224.0

Stechbreite a Stechtiefe t <i>Grooving width a Grooving depth t</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Stechschwert <i>Grooving blade</i>		Spannelement <i>Clamping element</i>	
		3225	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>
Links <i>Left</i> a = 6 mm t = 18 mm	 RAG-3225-B6T18H5-LG	719.78.011.19	RAG-ST-B6T18H5-LG	70.91.22.566.0	RAG-SP-B6T18-L	70.91.11.922.0
	 RAG-3225-B6T18H5-LR100	719.78.011.20	RAG-ST-B6T18H5-LR100	70.91.22.567.0	RAG-SP-B6T18-L	70.91.11.922.0
	 RAG-3225-B6T18H5-LL100	719.78.011.21	RAG-ST-B6T18H5-LL100	70.91.22.568.0	RAG-SP-B6T18-L	70.91.11.922.0
Rechts <i>Right</i> a = 6 mm t = 18 mm	 RAG-3225-B6T18H5-RG	719.77.011.19	RAG-ST-B6T18H5-RG	70.91.22.518.0	RAG-SP-B6T18-R	70.91.11.906.0
	 RAG-3225-B6T18H5-RL100	719.77.011.20	RAG-ST-B6T18H5-RL100	70.91.22.519.0	RAG-SP-B6T18-R	70.91.11.906.0
	 RAG-3225-B6T18H5-RR100	719.77.011.21	RAG-ST-B6T18H5-RR100	70.91.22.520.0	RAG-SP-B6T18-R	70.91.11.906.0



33.60.09.11.004.0



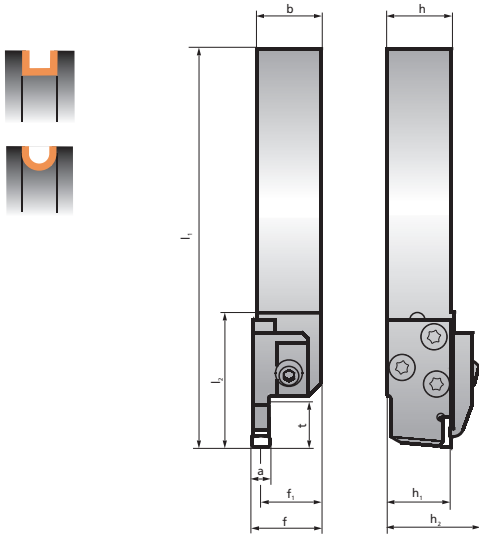
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RAG Stechsystem

RAG Grooving System







STECHBREITE GROOVING WIDTH 6 MM
 STECHTIEFE GROOVING DEPTH 24 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
 2525



Schaft Shank	Abmessungen Dimensions (mm)								
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂
2525	25	25	162	47	24	6	23,5	$f_1 + \frac{a}{2}$	36
3225	32	25	182	47	24	6	23,5	$f_1 + \frac{a}{2}$	43

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 6 mm t = 24 mm	 RAG-2525-B6T24H5-LG	719.78.010.22	RAG-ST-B6T24H5-LG	70.91.22.569.0	RAG-SP-B6T24-L	70.91.11.923.0
	 RAG-2525-B6T24H5-LR100	719.78.010.23	RAG-ST-B6T24H5-LR100	70.91.22.570.0	RAG-SP-B6T24-L	70.91.11.923.0
	 RAG-2525-B6T24H5-LL100	719.78.010.24	RAG-ST-B6T24H5-LL100	70.91.22.571.0	RAG-SP-B6T24-L	70.91.11.923.0
Rechts Right a = 6 mm t = 24 mm	 RAG-2525-B6T24H5-RG	719.77.010.22	RAG-ST-B6T24H5-RG	70.91.22.521.0	RAG-SP-B6T24-R	70.91.11.907.0
	 RAG-2525-B6T24H5-RL100	719.77.010.23	RAG-ST-B6T24H5-RL100	70.91.22.522.0	RAG-SP-B6T24-R	70.91.11.907.0
	 RAG-2525-B6T24H5-RR100	719.77.010.24	RAG-ST-B6T24H5-RR100	70.91.22.523.0	RAG-SP-B6T24-R	70.91.11.907.0









33.60.09.11.004.0



70.91.55.224.0

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 6 MM
STECHTIEFE GROOVING DEPTH 24 MM

Stechbreite a Stechtiefe t <i>Grooving width a Grooving depth t</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Stechschwert <i>Grooving blade</i>		Spannelement <i>Clamping element</i>	
		3225	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>
Links <i>Left</i> a = 6 mm t = 24 mm	 RAG-3225-B6T24H5-LG	719.78.011.22	RAG-ST-B6T24H5-LG	70.91.22.569.0	RAG-SP-B6T24-L	70.91.11.923.0
	 RAG-3225-B6T24H5-LR100	719.78.011.23	RAG-ST-B6T24H5-LR100	70.91.22.570.0	RAG-SP-B6T24-L	70.91.11.923.0
	 RAG-3225-B6T24H5-LL100	719.78.011.24	RAG-ST-B6T24H5-LL100	70.91.22.571.0	RAG-SP-B6T24-L	70.91.11.923.0
Rechts <i>Right</i> a = 6 mm t = 24 mm	 RAG-3225-B6T24H5-RG	719.77.011.22	RAG-ST-B6T24H5-RG	70.91.22.521.0	RAG-SP-B6T24-R	70.91.11.907.0
	 RAG-3225-B6T24H5-RL100	719.77.011.23	RAG-ST-B6T24H5-RL100	70.91.22.522.0	RAG-SP-B6T24-R	70.91.11.907.0
	 RAG-3225-B6T24H5-RR100	719.77.011.24	RAG-ST-B6T24H5-RR100	70.91.22.523.0	RAG-SP-B6T24-R	70.91.11.907.0



33.60.09.11.004.0



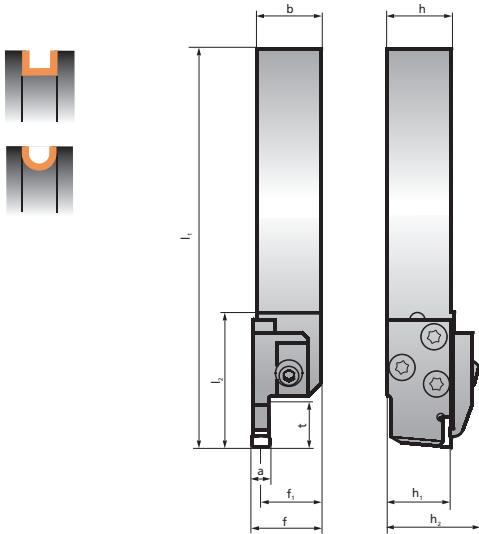
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RAG Stechsystem

RAG Grooving System

STECHBREITE GROOVING WIDTH 6 MM
 STECHTIEFE GROOVING DEPTH 30 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
 2525



Schaft Shank	Abmessungen Dimensions (mm)								
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂
2525	25	25	168	47	30	6	23,5	$f_1 + \frac{a}{2}$	36
3225	32	25	188	47	30	6	23,5	$f_1 + \frac{a}{2}$	43

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 6 mm t = 30 mm	RAG-2525-B6T30H5-LG	719.78.010.25	RAG-ST-B6T30H5-LG	70.91.22.572.0	RAG-SP-B6T30-L	70.91.11.924.0
	RAG-2525-B6T30H5-LR100	719.78.010.26	RAG-ST-B6T30H5-LR100	70.91.22.573.0	RAG-SP-B6T30-L	70.91.11.924.0
	RAG-2525-B6T30H5-LL100	719.78.010.27	RAG-ST-B6T30H5-LL100	70.91.22.574.0	RAG-SP-B6T30-L	70.91.11.924.0
Rechts Right a = 6 mm t = 30 mm	RAG-2525-B6T30H5-RG	719.77.010.25	RAG-ST-B6T30H5-RG	70.91.22.524.0	RAG-SP-B6T30-R	70.91.11.908.0
	RAG-2525-B6T30H5-RL100	719.77.010.26	RAG-ST-B6T30H5-RL100	70.91.22.525.0	RAG-SP-B6T30-R	70.91.11.908.0
	RAG-2525-B6T30H5-RR100	719.77.010.27	RAG-ST-B6T30H5-RR100	70.91.22.526.0	RAG-SP-B6T30-R	70.91.11.908.0









33.60.09.11.004.0



70.91.55.224.0

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 6 MM
STECHTIEFE GROOVING DEPTH 30 MM

Stechbreite a Stechtiefe t <i>Grooving width a Grooving depth t</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Stechschwert <i>Grooving blade</i>		Spannelement <i>Clamping element</i>	
		3225	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>
Links <i>Left</i> a = 6 mm t = 30 mm	 RAG-3225-B6T30H5-LG	719.78.011.25	RAG-ST-B6T30H5-LG	70.91.22.572.0	RAG-SP-B6T30-L	70.91.11.924.0
	 RAG-3225-B6T30H5-LR100	719.78.011.26	RAG-ST-B6T30H5-LR100	70.91.22.573.0	RAG-SP-B6T30-L	70.91.11.924.0
	 RAG-3225-B6T30H5-LL100	719.78.011.27	RAG-ST-B6T30H5-LL100	70.91.22.574.0	RAG-SP-B6T30-L	70.91.11.924.0
Rechts <i>Right</i> a = 6 mm t = 30 mm	 RAG-3225-B6T30H5-RG	719.77.011.25	RAG-ST-B6T30H5-RG	70.91.22.524.0	RAG-SP-B6T30-R	70.91.11.908.0
	 RAG-3225-B6T30H5-RL100	719.77.011.26	RAG-ST-B6T30H5-RL100	70.91.22.525.0	RAG-SP-B6T30-R	70.91.11.908.0
	 RAG-3225-B6T30H5-RR100	719.77.011.27	RAG-ST-B6T30H5-RR100	70.91.22.526.0	RAG-SP-B6T30-R	70.91.11.908.0



33.60.09.11.004.0



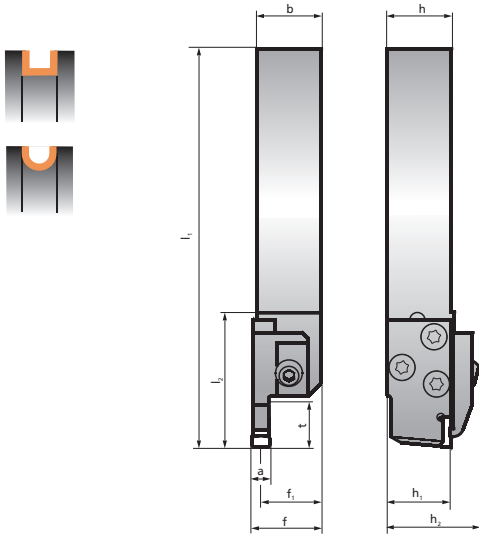
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RAG Stechsystem

RAG Grooving System

STECHBREITE GROOVING WIDTH 7 MM
 STECHTIEFE GROOVING DEPTH 12 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
 2525



Schaft Shank	Abmessungen Dimensions (mm)								
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂
2525	25	25	150	47	12	7	23,5	$f_1 + \frac{a}{2}$	36
3225	32	25	170	47	12	7	23,5	$f_1 + \frac{a}{2}$	43

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 7 mm t = 12 mm	RAG-2525-B7T12H5-LG	719.78.010.28	RAG-ST-B7T12H5-LG	70.91.22.575.0	RAG-SP-B7T12-L	70.91.11.925.0
	RAG-2525-B7T12H5-LR100	719.78.010.29	RAG-ST-B7T12H5-LR100	70.91.22.576.0	RAG-SP-B7T12-L	70.91.11.925.0
	RAG-2525-B7T12H5-LL100	719.78.010.30	RAG-ST-B7T12H5-LL100	70.91.22.577.0	RAG-SP-B7T12-L	70.91.11.925.0
Rechts Right a = 7 mm t = 12 mm	RAG-2525-B7T12H5-RG	719.77.010.28	RAG-ST-B7T12H5-RG	70.91.22.527.0	RAG-SP-B7T12-R	70.91.11.909.0
	RAG-2525-B7T12H5-RL100	719.77.010.29	RAG-ST-B7T12H5-RL100	70.91.22.528.0	RAG-SP-B7T12-R	70.91.11.909.0
	RAG-2525-B7T12H5-RR100	719.77.010.30	RAG-ST-B7T12H5-RR100	70.91.22.529.0	RAG-SP-B7T12-R	70.91.11.909.0









33.60.09.11.004.0



70.91.55.224.0

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 7 MM
STECHTIEFE GROOVING DEPTH 12 MM

Stechbreite a Stechtiefe t <i>Grooving width a Grooving depth t</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Stechschwert <i>Grooving blade</i>		Spannelement <i>Clamping element</i>	
		3225	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>
Links <i>Left</i> a = 7 mm t = 12 mm	 RAG-3225-B7T12H5-LG	719.78.011.28	RAG-ST-B7T12H5-LG	70.91.22.575.0	RAG-SP-B7T12-L	70.91.11.925.0
	 RAG-3225-B7T12H5-LR100	719.78.011.29	RAG-ST-B7T12H5-LR100	70.91.22.576.0	RAG-SP-B7T12-L	70.91.11.925.0
	 RAG-3225-B7T12H5-LL100	719.78.011.30	RAG-ST-B7T12H5-LL100	70.91.22.577.0	RAG-SP-B7T12-L	70.91.11.925.0
Rechts <i>Right</i> a = 7 mm t = 12 mm	 RAG-3225-B7T12H5-RG	719.77.011.28	RAG-ST-B7T12H5-RG	70.91.22.527.0	RAG-SP-B7T12-R	70.91.11.909.0
	 RAG-3225-B7T12H5-RL100	719.77.011.29	RAG-ST-B7T12H5-RL100	70.91.22.528.0	RAG-SP-B7T12-R	70.91.11.909.0
	 RAG-3225-B7T12H5-RR100	719.77.011.30	RAG-ST-B7T12H5-RR100	70.91.22.529.0	RAG-SP-B7T12-R	70.91.11.909.0



33.60.09.11.004.0



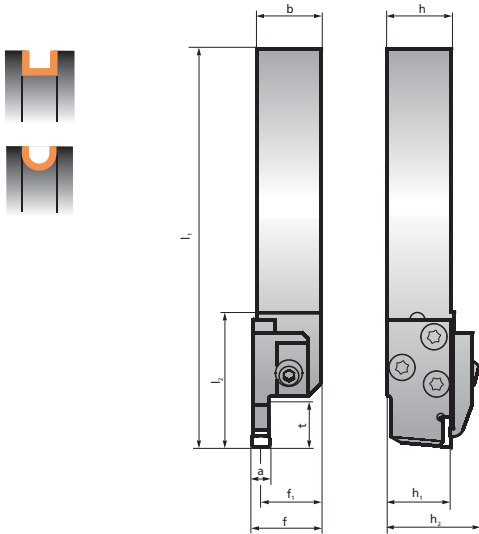
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RAG Stechsystem

RAG Grooving System







STECHBREITE GROOVING WIDTH 7 MM
 STECHTIEFE GROOVING DEPTH 18 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
 2525



Schaft Shank	Abmessungen Dimensions (mm)								
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂
2525	25	25	156	47	18	7	23,5	$f_1 + \frac{a}{2}$	36
3225	32	25	176	47	18	7	23,5	$f_1 + \frac{a}{2}$	43

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°







Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 7 mm t = 18 mm	 RAG-2525-B7T18H5-LG	719.78.010.31	RAG-ST-B7T18H5-LG	70.91.22.578.0	RAG-SP-B7T18-L	70.91.11.926.0
	 RAG-2525-B7T18H5-LR100	719.78.010.32	RAG-ST-B7T18H5-LR100	70.91.22.579.0	RAG-SP-B7T18-L	70.91.11.926.0
	 RAG-2525-B7T18H5-LL100	719.78.010.33	RAG-ST-B7T18H5-LL100	70.91.22.580.0	RAG-SP-B7T18-L	70.91.11.926.0
Rechts Right a = 7 mm t = 18 mm	 RAG-2525-B7T18H5-RG	719.77.010.31	RAG-ST-B7T18H5-RG	70.91.22.530.0	RAG-SP-B7T18-R	70.91.11.910.0
	 RAG-2525-B7T18H5-RL100	719.77.010.32	RAG-ST-B7T18H5-RL100	70.91.22.531.0	RAG-SP-B7T18-R	70.91.11.910.0
	 RAG-2525-B7T18H5-RR100	719.77.010.33	RAG-ST-B7T18H5-RR100	70.91.22.532.0	RAG-SP-B7T18-R	70.91.11.910.0



33.60.09.11.004.0



70.91.55.224.0

Stechbreite a Stechtiefe t <i>Grooving width a Grooving depth t</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Stechschwert <i>Grooving blade</i>		Spannelement <i>Clamping element</i>	
		3225	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>
Links <i>Left</i> a = 7 mm t = 18 mm	 RAG-3225-B7T18H5-LG	719.78.011.31	RAG-ST-B7T18H5-LG	70.91.22.578.0	RAG-SP-B7T18-L	70.91.11.926.0
	 RAG-3225-B7T18H5-LR100	719.78.011.32	RAG-ST-B7T18H5-LR100	70.91.22.579.0	RAG-SP-B7T18-L	70.91.11.926.0
	 RAG-3225-B7T18H5-LL100	719.78.011.33	RAG-ST-B7T18H5-LL100	70.91.22.580.0	RAG-SP-B7T18-L	70.91.11.926.0
Rechts <i>Right</i> a = 7 mm t = 18 mm	 RAG-3225-B7T18H5-RG	719.77.011.31	RAG-ST-B7T18H5-RG	70.91.22.530.0	RAG-SP-B7T18-R	70.91.11.910.0
	 RAG-3225-B7T18H5-RL100	719.77.011.32	RAG-ST-B7T18H5-RL100	70.91.22.531.0	RAG-SP-B7T18-R	70.91.11.910.0
	 RAG-3225-B7T18H5-RR100	719.77.011.33	RAG-ST-B7T18H5-RR100	70.91.22.532.0	RAG-SP-B7T18-R	70.91.11.910.0



33.60.09.11.004.0



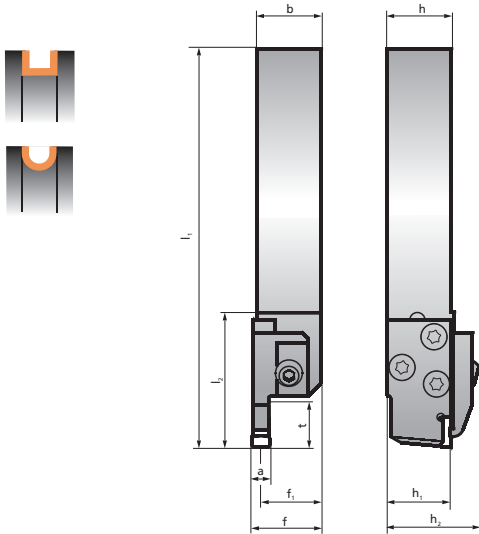
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RAG Stechsystem

RAG Grooving System

STECHBREITE GROOVING WIDTH 7 MM
 STECHTIEFE GROOVING DEPTH 24 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
 2525



Schaft Shank	Abmessungen Dimensions (mm)								
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂
2525	25	25	162	47	24	7	23,5	$f_1 + \frac{a}{2}$	36
3225	32	25	182	47	24	7	23,5	$f_1 + \frac{a}{2}$	43

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 7 mm t = 24 mm	RAG-2525-B7T24H5-LG	719.78.010.34	RAG-ST-B7T24H5-LG	70.91.22.581.0	RAG-SP-B7T24-L	70.91.11.927.0
	RAG-2525-B7T24H5-LR100	719.78.010.35	RAG-ST-B7T24H5-LR100	70.91.22.582.0	RAG-SP-B7T24-L	70.91.11.927.0
	RAG-2525-B7T24H5-LL100	719.78.010.36	RAG-ST-B7T24H5-LL100	70.91.22.583.0	RAG-SP-B7T24-L	70.91.11.927.0
Rechts Right a = 7 mm t = 24 mm	RAG-2525-B7T24H5-RG	719.77.010.34	RAG-ST-B7T24H5-RG	70.91.22.533.0	RAG-SP-B7T24-R	70.91.11.911.0
	RAG-2525-B7T24H5-RL100	719.77.010.35	RAG-ST-B7T24H5-RL100	70.91.22.534.0	RAG-SP-B7T24-R	70.91.11.911.0
	RAG-2525-B7T24H5-RR100	719.77.010.36	RAG-ST-B7T24H5-RR100	70.91.22.535.0	RAG-SP-B7T24-R	70.91.11.911.0









33.60.09.11.004.0



70.91.55.224.0

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 7 MM
STECHTIEFE GROOVING DEPTH 24 MM

Stechbreite a Stechtiefe t <i>Grooving width a Grooving depth t</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Stechschwert <i>Grooving blade</i>		Spannelement <i>Clamping element</i>	
		3225	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>
Links <i>Left</i> a = 7 mm t = 24 mm	 RAG-3225-B7T24H5-LG	719.78.011.34	RAG-ST-B7T24H5-LG	70.91.22.581.0	RAG-SP-B7T24-L	70.91.11.927.0
	 RAG-3225-B7T24H5-LR100	719.78.011.35	RAG-ST-B7T24H5-LR100	70.91.22.582.0	RAG-SP-B7T24-L	70.91.11.927.0
	 RAG-3225-B7T24H5-LL100	719.78.011.36	RAG-ST-B7T24H5-LL100	70.91.22.583.0	RAG-SP-B7T24-L	70.91.11.927.0
Rechts <i>Right</i> a = 7 mm t = 24 mm	 RAG-3225-B7T24H5-RG	719.77.011.34	RAG-ST-B7T24H5-RG	70.91.22.533.0	RAG-SP-B7T24-R	70.91.11.911.0
	 RAG-3225-B7T24H5-RL100	719.77.011.35	RAG-ST-B7T24H5-RL100	70.91.22.534.0	RAG-SP-B7T24-R	70.91.11.911.0
	 RAG-3225-B7T24H5-RR100	719.77.011.36	RAG-ST-B7T24H5-RR100	70.91.22.535.0	RAG-SP-B7T24-R	70.91.11.911.0



33.60.09.11.004.0

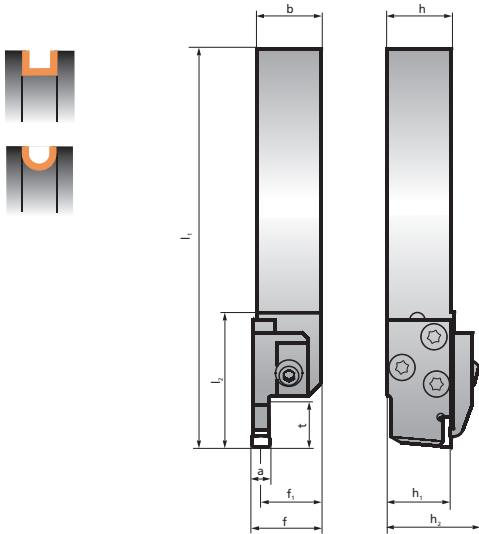


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RAG Stechsystem RAG Grooving System







STECHBREITE GROOVING WIDTH 7 MM
STECHTIEFE GROOVING DEPTH 30 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
2525



Schaft Shank	Abmessungen Dimensions (mm)								
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂
2525	25	25	168	47	30	7	23,5	$f_1 + \frac{a}{2}$	36
3225	32	25	188	47	30	7	23,5	$f_1 + \frac{a}{2}$	43

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 7 mm t = 30 mm	 RAG-2525-B7T30H5-LG	719.78.010.37	RAG-ST-B7T30H5-LG	70.91.22.584.0	RAG-SP-B7T30-L	70.91.11.928.0
	 RAG-2525-B7T30H5-LR100	719.78.010.38	RAG-ST-B7T30H5-LR100	70.91.22.585.0	RAG-SP-B7T30-L	70.91.11.928.0
	 RAG-2525-B7T30H5-LL100	719.78.010.39	RAG-ST-B7T30H5-LL100	70.91.22.586.0	RAG-SP-B7T30-L	70.91.11.928.0
Rechts Right a = 7 mm t = 30 mm	 RAG-2525-B7T30H5-RG	719.77.010.37	RAG-ST-B7T30H5-RG	70.91.22.536.0	RAG-SP-B7T30-R	70.91.11.912.0
	 RAG-2525-B7T30H5-RL100	719.77.010.38	RAG-ST-B7T30H5-RL100	70.91.22.537.0	RAG-SP-B7T30-R	70.91.11.912.0
	 RAG-2525-B7T30H5-RR100	719.77.010.39	RAG-ST-B7T30H5-RR100	70.91.22.538.0	RAG-SP-B7T30-R	70.91.11.912.0









33.60.09.11.004.0



70.91.55.224.0

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 7 MM
STECHTIEFE GROOVING DEPTH 30 MM

Stechbreite a Stechtiefe t <i>Grooving width a Grooving depth t</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Stechschwert <i>Grooving blade</i>		Spannelement <i>Clamping element</i>	
		3225	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>
Links <i>Left</i> a = 7 mm t = 30 mm	 RAG-3225-B7T30H5-LG	719.78.011.37	RAG-ST-B7T30H5-LG	70.91.22.584.0	RAG-SP-B7T30-L	70.91.11.928.0
	 RAG-3225-B7T30H5-LR100	719.78.011.38	RAG-ST-B7T30H5-LR100	70.91.22.585.0	RAG-SP-B7T30-L	70.91.11.928.0
	 RAG-3225-B7T30H5-LL100	719.78.011.39	RAG-ST-B7T30H5-LL100	70.91.22.586.0	RAG-SP-B7T30-L	70.91.11.928.0
Rechts <i>Right</i> a = 7 mm t = 30 mm	 RAG-3225-B7T30H5-RG	719.77.011.37	RAG-ST-B7T30H5-RG	70.91.22.536.0	RAG-SP-B7T30-R	70.91.11.912.0
	 RAG-3225-B7T30H5-RL100	719.77.011.38	RAG-ST-B7T30H5-RL100	70.91.22.537.0	RAG-SP-B7T30-R	70.91.11.912.0
	 RAG-3225-B7T30H5-RR100	719.77.011.39	RAG-ST-B7T30H5-RR100	70.91.22.538.0	RAG-SP-B7T30-R	70.91.11.912.0



33.60.09.11.004.0

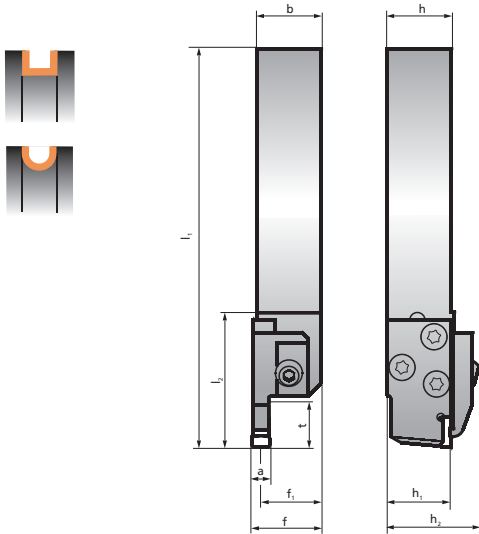


70.91.55.224.0

RAG Stechsystem RAG Grooving System

STECHBREITE GROOVING WIDTH 8 MM
STECHTIEFE GROOVING DEPTH 18 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
2525



Schaft Shank	Abmessungen Dimensions (mm)								
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂
2525	25	25	156	47	18	8	23,5	$f_1 + \frac{a}{2}$	36
3225	32	25	176	47	18	8	23,5	$f_1 + \frac{a}{2}$	43

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 8 mm t = 18 mm	RAG-2525-B8T18H5-LG	719.78.010.40	RAG-ST-B8T18H5-LG	70.91.22.587.0	RAG-SP-B8T18-L	70.91.11.929.0
	RAG-2525-B8T18H5-LR100	719.78.010.41	RAG-ST-B8T18H5-LR100	70.91.22.588.0	RAG-SP-B8T18-L	70.91.11.929.0
	RAG-2525-B8T18H5-LL100	719.78.010.42	RAG-ST-B8T18H5-LL100	70.91.22.589.0	RAG-SP-B8T18-L	70.91.11.929.0
Rechts Right a = 8 mm t = 18 mm	RAG-2525-B8T18H5-RG	719.77.010.40	RAG-ST-B8T18H5-RG	70.91.22.539.0	RAG-SP-B8T18-R	70.91.11.913.0
	RAG-2525-B8T18H5-RL100	719.77.010.41	RAG-ST-B8T18H5-RL100	70.91.22.540.0	RAG-SP-B8T18-R	70.91.11.913.0
	RAG-2525-B8T18H5-RR100	719.77.010.42	RAG-ST-B8T18H5-RR100	70.91.22.541.0	RAG-SP-B8T18-R	70.91.11.913.0









33.60.09.11.004.0



70.91.55.224.0

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 8 MM
STECHTIEFE GROOVING DEPTH 18 MM

Stechbreite a Stechtiefe t <i>Grooving width a Grooving depth t</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Stechschwert <i>Grooving blade</i>		Spannelement <i>Clamping element</i>	
		3225	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>
Links <i>Left</i> a = 8 mm t = 18 mm	 RAG-3225-B8T18H5-LG	719.78.011.40	RAG-ST-B8T18H5-LG	70.91.22.587.0	RAG-SP-B8T18-L	70.91.11.929.0
	 RAG-3225-B8T18H5-LR100	719.78.011.41	RAG-ST-B8T18H5-LR100	70.91.22.588.0	RAG-SP-B8T18-L	70.91.11.929.0
	 RAG-3225-B8T18H5-LL100	719.78.011.42	RAG-ST-B8T18H5-LL100	70.91.22.589.0	RAG-SP-B8T18-L	70.91.11.929.0
Rechts <i>Right</i> a = 8 mm t = 18 mm	 RAG-3225-B8T18H5-RG	719.77.011.40	RAG-ST-B8T18H5-RG	70.91.22.539.0	RAG-SP-B8T18-R	70.91.11.913.0
	 RAG-3225-B8T18H5-RL100	719.77.011.41	RAG-ST-B8T18H5-RL100	70.91.22.540.0	RAG-SP-B8T18-R	70.91.11.913.0
	 RAG-3225-B8T18H5-RR100	719.77.011.42	RAG-ST-B8T18H5-RR100	70.91.22.541.0	RAG-SP-B8T18-R	70.91.11.913.0



33.60.09.11.004.0

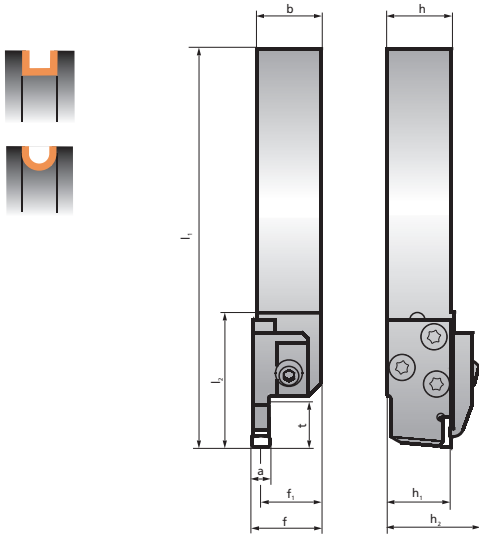


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RAG Stechsystem RAG Grooving System

STECHBREITE GROOVING WIDTH 8 MM
STECHTIEFE GROOVING DEPTH 24 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
2525



Schaft Shank	Abmessungen Dimensions (mm)								
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂
2525	25	25	162	47	24	8	23,5	$f_1 + \frac{a}{2}$	36
3225	32	25	182	47	24	8	23,5	$f_1 + \frac{a}{2}$	43

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			2525	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 8 mm t = 24 mm	RAG-2525-B8T24H5-LG	719.78.010.43	RAG-ST-B8T24H5-LG	70.91.22.590.0	RAG-SP-B8T24-L	70.91.11.930.0
	RAG-2525-B8T24H5-LR100	719.78.010.44	RAG-ST-B8T24H5-LR100	70.91.22.591.0	RAG-SP-B8T24-L	70.91.11.930.0
	RAG-2525-B8T24H5-LL100	719.78.010.45	RAG-ST-B8T24H5-LL100	70.91.22.592.0	RAG-SP-B8T24-L	70.91.11.930.0
Rechts Right a = 8 mm t = 24 mm	RAG-2525-B8T24H5-RG	719.77.010.43	RAG-ST-B8T24H5-RG	70.91.22.542.0	RAG-SP-B8T24-R	70.91.11.914.0
	RAG-2525-B8T24H5-RL100	719.77.010.44	RAG-ST-B8T24H5-RL100	70.91.22.543.0	RAG-SP-B8T24-R	70.91.11.914.0
	RAG-2525-B8T24H5-RR100	719.77.010.45	RAG-ST-B8T24H5-RR100	70.91.22.544.0	RAG-SP-B8T24-R	70.91.11.914.0









33.60.09.11.004.0



70.91.55.224.0

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 8 MM
STECHTIEFE GROOVING DEPTH 24 MM

Stechbreite a Stechtiefe t <i>Grooving width a Grooving depth t</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Stechschwert <i>Grooving blade</i>		Spannelement <i>Clamping element</i>	
		3225	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>
Links <i>Left</i> a = 8 mm t = 24 mm	 RAG-3225-B8T24H5-LG	719.78.011.43	RAG-ST-B8T24H5-LG	70.91.22.590.0	RAG-SP-B8T24-L	70.91.11.930.0
	 RAG-3225-B8T24H5-LR100	719.78.011.44	RAG-ST-B8T24H5-LR100	70.91.22.591.0	RAG-SP-B8T24-L	70.91.11.930.0
	 RAG-3225-B8T24H5-LL100	719.78.011.45	RAG-ST-B8T24H5-LL100	70.91.22.592.0	RAG-SP-B8T24-L	70.91.11.930.0
Rechts <i>Right</i> a = 8 mm t = 24 mm	 RAG-3225-B8T24H5-RG	719.77.011.43	RAG-ST-B8T24H5-RG	70.91.22.542.0	RAG-SP-B8T24-R	70.91.11.914.0
	 RAG-3225-B8T24H5-RL100	719.77.011.44	RAG-ST-B8T24H5-RL100	70.91.22.543.0	RAG-SP-B8T24-R	70.91.11.914.0
	 RAG-3225-B8T24H5-RR100	719.77.011.45	RAG-ST-B8T24H5-RR100	70.91.22.544.0	RAG-SP-B8T24-R	70.91.11.914.0



33.60.09.11.004.0



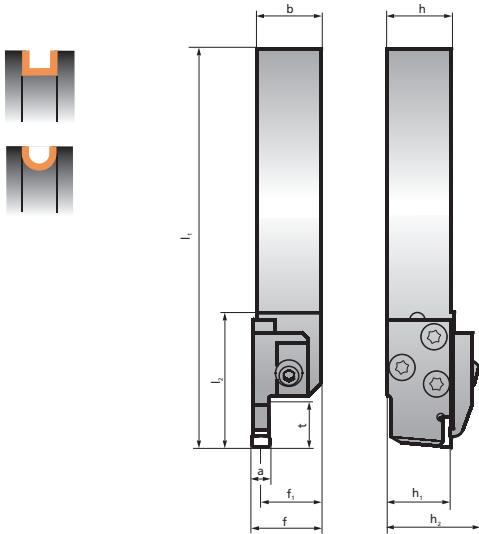
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RAG Stechsystem

RAG Grooving System

STECHBREITE GROOVING WIDTH 8 MM
 STECHTIEFE GROOVING DEPTH 30 MM

SCHAFTAUSFÜHRUNG SHANK VERSION
 2525



Schaft Shank	Abmessungen Dimensions (mm)								
	h=h ₁	b	l ₁	l ₂	t	a	f ₁	f	h ₂
2525	25	25	168	47	30	8	23,5	$f_1 + \frac{a}{2}$	36
3225	32	25	188	47	30	8	23,5	$f_1 + \frac{a}{2}$	43

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
		2525	Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 8 mm t = 30 mm	RAG-2525-B8T30H5-LG	719.78.010.46	RAG-ST-B8T30H5-LG	70.91.22.593.0	RAG-SP-B8T30-L	70.91.11.931.0
	RAG-2525-B8T30H5-LR100	719.78.010.47	RAG-ST-B8T30H5-LR100	70.91.22.594.0	RAG-SP-B8T30-L	70.91.11.931.0
	RAG-2525-B8T30H5-LL100	719.78.010.48	RAG-ST-B8T30H5-LL100	70.91.22.595.0	RAG-SP-B8T30-L	70.91.11.931.0
Rechts Right a = 8 mm t = 30 mm	RAG-2525-B8T30H5-RG	719.77.010.46	RAG-ST-B8T30H5-RG	70.91.22.545.0	RAG-SP-B8T30-R	70.91.11.915.0
	RAG-2525-B8T30H5-RL100	719.77.010.47	RAG-ST-B8T30H5-RL100	70.91.22.546.0	RAG-SP-B8T30-R	70.91.11.915.0
	RAG-2525-B8T30H5-RR100	719.77.010.48	RAG-ST-B8T30H5-RR100	70.91.22.547.0	RAG-SP-B8T30-R	70.91.11.915.0









33.60.09.11.004.0



70.91.55.224.0

SCHAFTAUSFÜHRUNG SHANK VERSION
3225

STECHBREITE GROOVING WIDTH 8 MM
STECHTIEFE GROOVING DEPTH 30 MM

Stechbreite a Stechtiefe t <i>Grooving width a Grooving depth t</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Stechschwert <i>Grooving blade</i>		Spannelement <i>Clamping element</i>	
		3225	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>	Typ <i>Type</i>	Best.-Nr. <i>Ref. no.</i>
Links <i>Left</i> a = 8 mm t = 30 mm	 RAG-3225-B8T30H5-LG	719.78.011.46	RAG-ST-B8T30H5-LG	70.91.22.593.0	RAG-SP-B8T30-L	70.91.11.931.0
	 RAG-3225-B8T30H5-LR100	719.78.011.47	RAG-ST-B8T30H5-LR100	70.91.22.594.0	RAG-SP-B8T30-L	70.91.11.931.0
	 RAG-3225-B8T30H5-LL100	719.78.011.48	RAG-ST-B8T30H5-LL100	70.91.22.595.0	RAG-SP-B8T30-L	70.91.11.931.0
Rechts <i>Right</i> a = 8 mm t = 30 mm	 RAG-3225-B8T30H5-RG	719.77.011.46	RAG-ST-B8T30H5-RG	70.91.22.545.0	RAG-SP-B8T30-R	70.91.11.915.0
	 RAG-3225-B8T30H5-RL100	719.77.011.47	RAG-ST-B8T30H5-RL100	70.91.22.546.0	RAG-SP-B8T30-R	70.91.11.915.0
	 RAG-3225-B8T30H5-RR100	719.77.011.48	RAG-ST-B8T30H5-RR100	70.91.22.547.0	RAG-SP-B8T30-R	70.91.11.915.0



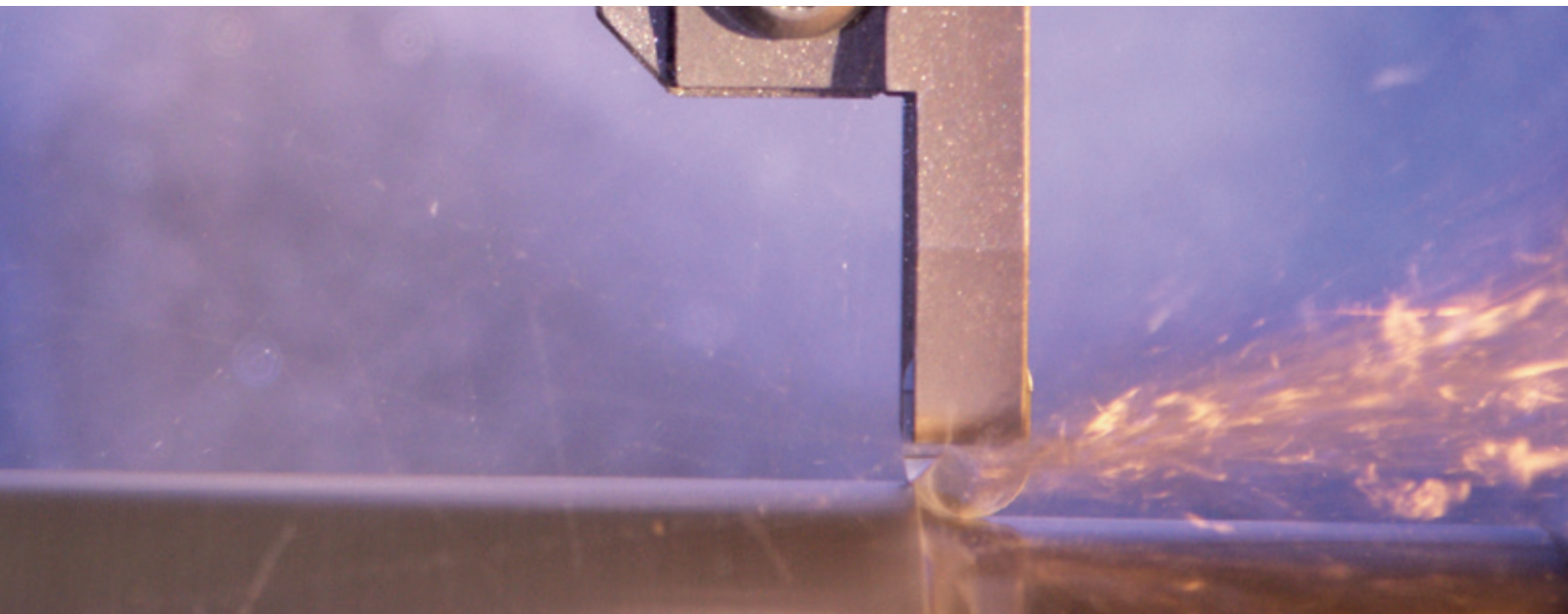
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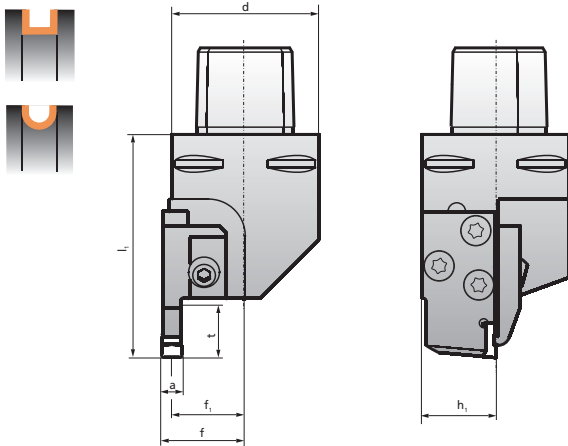
CMS-Scheidköpfe für RAG Stechsystem
CMS Cutting Heads for RAG Grooving System



RAG Stechsystem RAG Grooving System

STECHBREITE GROOVING WIDTH 4 MM
STECHTIEFE GROOVING DEPTH 12 MM

AUSFÜHRUNG VERSION
CMS5



	Abmessungen Dimensions (mm)						
	h ₁	d	l ₁	t	a	f	f ₁
CMS5	25	50	70	12	4	f ₁ + $\frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 4 mm t = 12 mm	RAG-CMS5-B4T12H5-LG	799.78.001.01	RAG-ST-B4T12H5-LG	70.91.22.548.0	RAG-SP-B4T12-L	70.91.11.916.0
	RAG-CMS5-B4T12H5-LR100	799.78.001.02	RAG-ST-B4T12H5-LR100	70.91.22.549.0	RAG-SP-B4T12-L	70.91.11.916.0
	RAG-CMS5-B4T12H5-LL100	799.78.001.03	RAG-ST-B4T12H5-LL100	70.91.22.550.0	RAG-SP-B4T12-L	70.91.11.916.0
Rechts Right a = 4 mm t = 12 mm	RAG-CMS5-B4T12H5-RG	799.77.001.01	RAG-ST-B4T12H5-RG	70.91.22.500.0	RAG-SP-B4T12-R	70.91.11.900.0
	RAG-CMS5-B4T12H5-RL100	799.77.001.02	RAG-ST-B4T12H5-RL100	70.91.22.501.0	RAG-SP-B4T12-R	70.91.11.900.0
	RAG-CMS5-B4T12H5-RR100	799.77.001.03	RAG-ST-B4T12H5-RR100	70.91.22.502.0	RAG-SP-B4T12-R	70.91.11.900.0



33.60.09.11.004.0



70.91.55.224.0

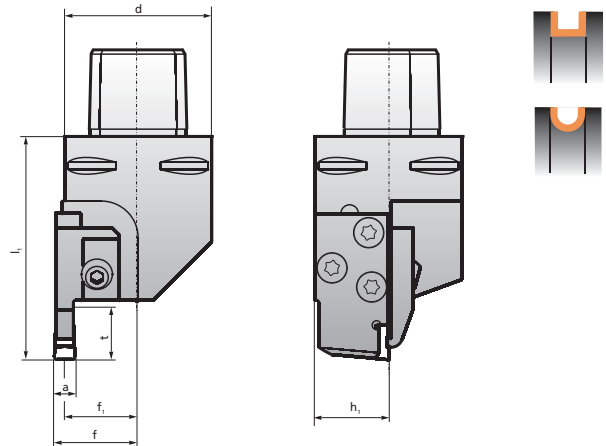
RAG Stechsystem RAG Grooving System







AUSFÜHRUNG VERSION
CMS5

STECHBREITE GROOVING WIDTH 4 MM
STECHTIEFE GROOVING DEPTH 18 MM

	Abmessungen Dimensions (mm)						
	h_1	d	l_1	t	a	f	f_1
CMS5	25	50	76	18	4	$f_1 + \frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°



Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade	Spannelement Clamping element		
		CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type	Best.-Nr. Ref. no.
Links Left a = 4 mm t = 18 mm	 RAG-CMS5-B4T18H5-LG	799.78.001.04	RAG-ST-B4T18H5-LG	70.91.22.551.0	RAG-SP-B4T18-L	70.91.11.917.0
	 RAG-CMS5-B4T18H5-LR100	799.78.001.05	RAG-ST-B4T18H5-LR100	70.91.22.552.0	RAG-SP-B4T18-L	70.91.11.917.0
	 RAG-CMS5-B4T18H5-LL100	799.78.001.06	RAG-ST-B4T18H5-LL100	70.91.22.553.0	RAG-SP-B4T18-L	70.91.11.917.0
Rechts Right a = 4 mm t = 18 mm	 RAG-CMS5-B4T18H5-RG	799.77.001.04	RAG-ST-B4T18H5-RG	70.91.22.503.0	RAG-SP-B4T18-R	70.91.11.901.0
	 RAG-CMS5-B4T18H5-RL100	799.77.001.05	RAG-ST-B4T18H5-RL100	70.91.22.504.0	RAG-SP-B4T18-R	70.91.11.901.0
	 RAG-CMS5-B4T18H5-RR100	799.77.001.06	RAG-ST-B4T18H5-RR100	70.91.22.505.0	RAG-SP-B4T18-R	70.91.11.901.0



33.60.09.11.004.0

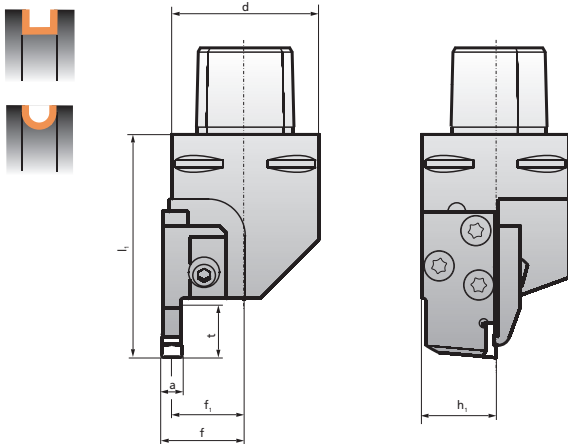


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RAG Stechsystem RAG Grooving System







STECHBREITE GROOVING WIDTH 5 MM
STECHTIEFE GROOVING DEPTH 12 MM

AUSFÜHRUNG VERSION
CMS5



	Abmessungen Dimensions (mm)						
	h ₁	d	l ₁	t	a	f	f ₁
CMS5	25	50	70	12	5	f ₁ + $\frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 5 mm t = 12 mm	 RAG-CMS5-B5T12H5-LG	799.78.001.07	RAG-ST-B5T12H5-LG	70.91.22.554.0	RAG-SP-B5T12-L	70.91.11.918.0
	 RAG-CMS5-B5T12H5-LR100	799.78.001.08	RAG-ST-B5T12H5-LR100	70.91.22.555.0	RAG-SP-B5T12-L	70.91.11.918.0
	 RAG-CMS5-B5T12H5-LL100	799.78.001.09	RAG-ST-B5T12H5-LL100	70.91.22.556.0	RAG-SP-B5T12-L	70.91.11.918.0
Rechts Right a = 5 mm t = 12 mm	 RAG-CMS5-B5T12H5-RG	799.77.001.07	RAG-ST-B5T12H5-RG	70.91.22.506.0	RAG-SP-B5T12-R	70.91.11.902.0
	 RAG-CMS5-B5T12H5-RL100	799.77.001.08	RAG-ST-B5T12H5-RL100	70.91.22.507.0	RAG-SP-B5T12-R	70.91.11.902.0
	 RAG-CMS5-B5T12H5-RR100	799.77.001.09	RAG-ST-B5T12H5-RR100	70.91.22.508.0	RAG-SP-B5T12-R	70.91.11.902.0



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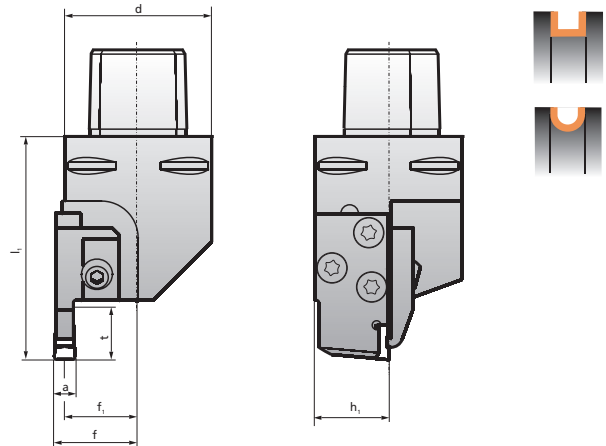
RAG Stechsystem RAG Grooving System

AUSFÜHRUNG VERSION
CMS5

STECHBREITE GROOVING WIDTH 5 MM
STECHTIEFE GROOVING DEPTH 18 MM

	Abmessungen Dimensions (mm)						
	h_1	d	l_1	t	a	f	f_1
CMS5	25	50	76	18	5	$f_1 - \frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°



Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 5 mm t = 18 mm	RAG-CMS5-B5T18H5-LG	799.78.001.10	RAG-ST-B5T18H5-LG	70.91.22.557.0	RAG-SP-B5T18-L	70.91.11.919.0
	RAG-CMS5-B5T18H5-LR100	799.78.001.11	RAG-ST-B5T18H5-LR100	70.91.22.558.0	RAG-SP-B5T18-L	70.91.11.919.0
	RAG-CMS5-B5T18H5-LL100	799.78.001.12	RAG-ST-B5T18H5-LL100	70.91.22.559.0	RAG-SP-B5T18-L	70.91.11.919.0
Rechts Right a = 5 mm t = 18 mm	RAG-CMS5-B5T18H5-RG	799.77.001.10	RAG-ST-B5T18H5-RG	70.91.22.509.0	RAG-SP-B5T18-R	70.91.11.903.0
	RAG-CMS5-B5T18H5-RL100	799.77.001.11	RAG-ST-B5T18H5-RL100	70.91.22.510.0	RAG-SP-B5T18-R	70.91.11.903.0
	RAG-CMS5-B5T18H5-RR100	799.77.001.12	RAG-ST-B5T18H5-RR100	70.91.22.511.0	RAG-SP-B5T18-R	70.91.11.903.0



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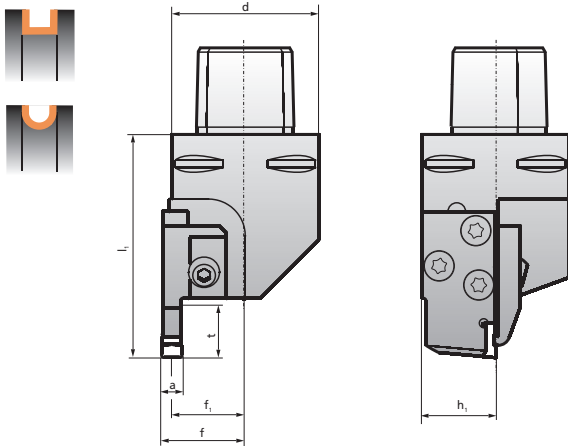
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RAG Stechsystem

RAG Grooving System







STECHBREITE GROOVING WIDTH 5 MM
 STECHTIEFE GROOVING DEPTH 24 MM

AUSFÜHRUNG VERSION
 CMS5



	Abmessungen Dimensions (mm)						
	h ₁	d	l ₁	t	a	f	f ₁
CMS5	25	50	82	24	5	f ₁ + $\frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 5 mm t = 24 mm	 RAG-CMS5-B5T24H5-LG	799.78.001.13	RAG-ST-B5T24H5-LG	70.91.22.560.0	RAG-SP-B5T24-L	70.91.11.920.0
	 RAG-CMS5-B5T24H5-LR100	799.78.001.14	RAG-ST-B5T24H5-LR100	70.91.22.561.0	RAG-SP-B5T24-L	70.91.11.920.0
	 RAG-CMS5-B5T24H5-LL100	799.78.001.15	RAG-ST-B5T24H5-LL100	70.91.22.562.0	RAG-SP-B5T24-L	70.91.11.920.0
Rechts Right a = 5 mm t = 24 mm	 RAG-CMS5-B5T24H5-RG	799.77.001.13	RAG-ST-B5T24H5-RG	70.91.22.512.0	RAG-SP-B5T24-R	70.91.11.904.0
	 RAG-CMS5-B5T24H5-RL100	799.77.001.14	RAG-ST-B5T24H5-RL100	70.91.22.513.0	RAG-SP-B5T24-R	70.91.11.904.0
	 RAG-CMS5-B5T24H5-RR100	799.77.001.15	RAG-ST-B5T24H5-RR100	70.91.22.514.0	RAG-SP-B5T24-R	70.91.11.904.0



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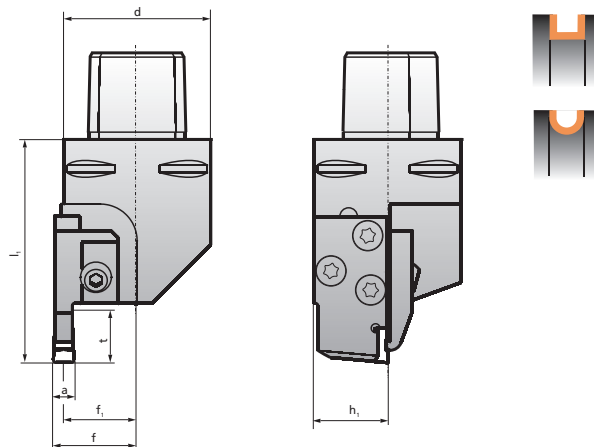
RAG Stechsystem RAG Grooving System







AUSFÜHRUNG VERSION
CMS5

STECHBREITE GROOVING WIDTH 6 MM
STECHTIEFE GROOVING DEPTH 12 MM

	Abmessungen Dimensions (mm)						
	h_1	d	l_1	t	a	f	f_1
CMS5	25	50	70	12	6	$f_1 + \frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°



Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 6 mm t = 12 mm	 RAG-CMS5-B6T12H5-LG	799.78.001.16	RAG-ST-B6T12H5-LG	70.91.22.563.0	RAG-SP-B6T12-L	70.91.11.921.0
	 RAG-CMS5-B6T12H5-LR100	799.78.001.17	RAG-ST-B6T12H5-LR100	70.91.22.564.0	RAG-SP-B6T12-L	70.91.11.921.0
	 RAG-CMS5-B6T12H5-LL100	799.78.001.18	RAG-ST-B6T12H5-LL100	70.91.22.565.0	RAG-SP-B6T12-L	70.91.11.921.0
Rechts Right a = 6 mm t = 12 mm	 RAG-CMS5-B6T12H5-RG	799.77.001.16	RAG-ST-B6T12H5-RG	70.91.22.515.0	RAG-SP-B6T12-R	70.91.11.905.0
	 RAG-CMS5-B6T12H5-RL100	799.77.001.17	RAG-ST-B6T12H5-RL100	70.91.22.516.0	RAG-SP-B6T12-R	70.91.11.905.0
	 RAG-CMS5-B6T12H5-RR100	799.77.001.18	RAG-ST-B6T12H5-RR100	70.91.22.517.0	RAG-SP-B6T12-R	70.91.11.905.0



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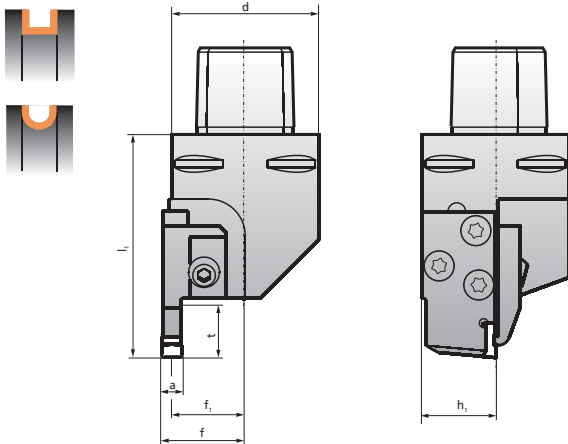


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RAG Stechsystem RAG Grooving System

STECHBREITE GROOVING WIDTH 6 MM
STECHTIEFE GROOVING DEPTH 18 MM

AUSFÜHRUNG VERSION
CMS5



	Abmessungen Dimensions (mm)						
	h ₁	d	l ₁	t	a	f	f ₁
CMS5	25	50	76	18	6	f ₁ + $\frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 6 mm t = 18 mm	RAG-CMS5-B6T18H5-LG	799.78.001.19	RAG-ST-B6T18H5-LG	70.91.22.566.0	RAG-SP-B6T18-L	70.91.11.922.0
	RAG-CMS5-B6T18H5-LR100	799.78.001.20	RAG-ST-B6T18H5-LR100	70.91.22.567.0	RAG-SP-B6T18-L	70.91.11.922.0
	RAG-CMS5-B6T18H5-LL100	799.78.001.21	RAG-ST-B6T18H5-LL100	70.91.22.568.0	RAG-SP-B6T18-L	70.91.11.922.0
Rechts Right a = 6 mm t = 18 mm	RAG-CMS5-B6T18H5-RG	799.77.001.19	RAG-ST-B6T18H5-RG	70.91.22.518.0	RAG-SP-B6T18-R	70.91.11.906.0
	RAG-CMS5-B6T18H5-RL100	799.77.001.20	RAG-ST-B6T18H5-RL100	70.91.22.519.0	RAG-SP-B6T18-R	70.91.11.906.0
	RAG-CMS5-B6T18H5-RR100	799.77.001.21	RAG-ST-B6T18H5-RR100	70.91.22.520.0	RAG-SP-B6T18-R	70.91.11.906.0



33.60.09.11.004.0



70.91.55.224.0

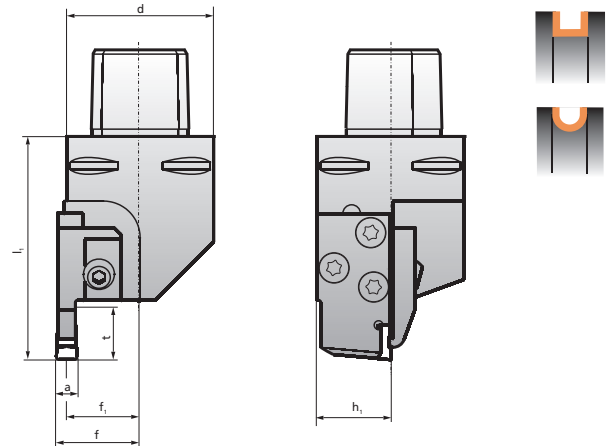
RAG Stechsystem RAG Grooving System







AUSFÜHRUNG VERSION
CMS5

STECHBREITE GROOVING WIDTH 6 MM
STECHTIEFE GROOVING DEPTH 24 MM

	Abmessungen Dimensions (mm)						
	h_1	d	l_1	t	a	f	f_1
CMS5	25	50	82	24	6	$f_1 + \frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°



Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 6 mm t = 24 mm	 RAG-CMS5-B6T24H5-LG	799.78.001.22	RAG-ST-B6T24H5-LG	70.91.22.569.0	RAG-SP-B6T24-L	70.91.11.923.0
	 RAG-CMS5-B6T24H5-LR100	799.78.001.23	RAG-ST-B6T24H5-LR100	70.91.22.570.0	RAG-SP-B6T24-L	70.91.11.923.0
	 RAG-CMS5-B6T24H5-LL100	799.78.001.24	RAG-ST-B6T24H5-LL100	70.91.22.571.0	RAG-SP-B6T24-L	70.91.11.923.0
Rechts Right a = 6 mm t = 24 mm	 RAG-CMS5-B6T24H5-RG	799.77.001.22	RAG-ST-B6T24H5-RG	70.91.22.521.0	RAG-SP-B6T24-R	70.91.11.907.0
	 RAG-CMS5-B6T24H5-RL100	799.77.001.23	RAG-ST-B6T24H5-RL100	70.91.22.522.0	RAG-SP-B6T24-R	70.91.11.907.0
	 RAG-CMS5-B6T24H5-RR100	799.77.001.24	RAG-ST-B6T24H5-RR100	70.91.22.523.0	RAG-SP-B6T24-R	70.91.11.905.0



33.60.09.11.004.0



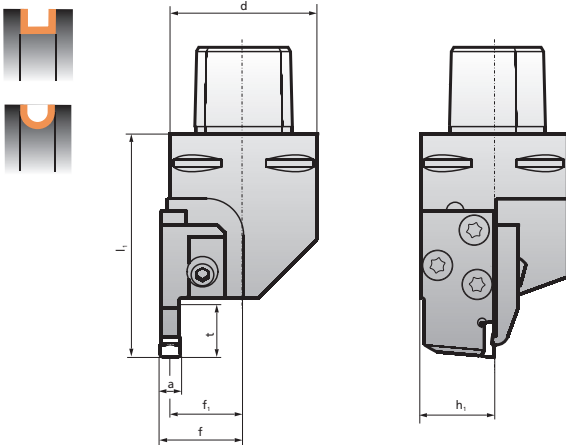
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RAG Stechsystem

RAG Grooving System

STECHBREITE GROOVING WIDTH 6 MM
 STECHTIEFE GROOVING DEPTH 30 MM

AUSFÜHRUNG VERSION
 CMS5



	Abmessungen Dimensions (mm)						
	h_1	d	l_1	t	a	f	f_1
CMS5	25	50	88	30	6	$f_1 + \frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 6 mm t = 30 mm	RAG-CMS5-B6T30H5-LG	799.78.001.25	RAG-ST-B6T30H5-LG	70.91.22.572.0	RAG-SP-B6T30-L	70.91.11.924.0
	RAG-CMS5-B6T30H5-LR100	799.78.001.26	RAG-ST-B6T30H5-LR100	70.91.22.573.0	RAG-SP-B6T30-L	70.91.11.924.0
	RAG-CMS5-B6T30H5-LL100	799.78.001.27	RAG-ST-B6T30H5-LL100	70.91.22.574.0	RAG-SP-B6T30-L	70.91.11.924.0
Rechts Right a = 6 mm t = 30 mm	RAG-CMS5-B6T30H5-RG	799.77.001.25	RAG-ST-B6T30H5-RG	70.91.22.524.0	RAG-SP-B6T30-R	70.91.11.908.0
	RAG-CMS5-B6T30H5-RL100	799.77.001.26	RAG-ST-B6T30H5-RL100	70.91.22.525.0	RAG-SP-B6T30-R	70.91.11.908.0
	RAG-CMS5-B6T30H5-RR100	799.77.001.27	RAG-ST-B6T30H5-RR100	70.91.22.526.0	RAG-SP-B6T30-R	70.91.11.908.0



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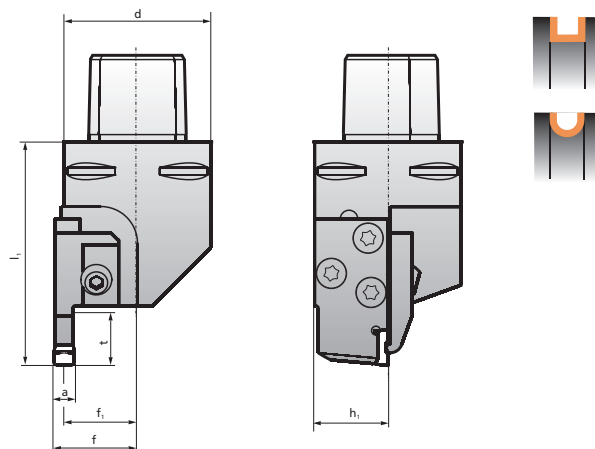
RAG Stechsystem RAG Grooving System

AUSFÜHRUNG VERSION
CMS5

STECHBREITE GROOVING WIDTH 7 MM
STECHTIEFE GROOVING DEPTH 12 MM

	Abmessungen Dimensions (mm)						
	h_1	d	l_1	t	a	f	f_1
CMS5	25	50	70	12	7	$f_1 + \frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°



Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 7 mm t = 12 mm	RAG-CMS5-B7T12H5-LG	799.78.001.28	RAG-ST-B7T12H5-LG	70.91.22.575.0	RAG-SP-B7T12-L	70.91.11.925.0
	RAG-CMS5-B7T12H5-LR100	799.78.001.29	RAG-ST-B7T12H5-LR100	70.91.22.576.0	RAG-SP-B7T12-L	70.91.11.925.0
	RAG-CMS5-B7T12H5-LL100	799.78.001.30	RAG-ST-B7T12H5-LL100	70.91.22.577.0	RAG-SP-B7T12-L	70.91.11.925.0
Rechts Right a = 7 mm t = 12 mm	RAG-CMS5-B7T12H5-RG	799.77.001.28	RAG-ST-B7T12H5-RG	70.91.22.527.0	RAG-SP-B7T12-R	70.91.11.909.0
	RAG-CMS5-B7T12H5-RL100	799.77.001.29	RAG-ST-B7T12H5-RL100	70.91.22.528.0	RAG-SP-B7T12-R	70.91.11.909.0
	RAG-CMS5-B7T12H5-RR100	799.77.001.30	RAG-ST-B7T12H5-RR100	70.91.22.529.0	RAG-SP-B7T12-R	70.91.11.909.0



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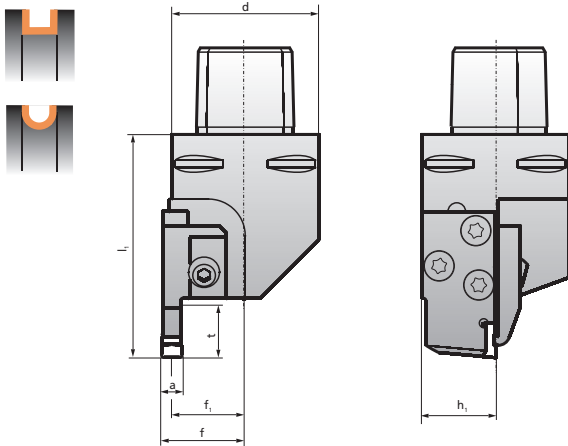
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RAG Stechsystem

RAG Grooving System

STECHBREITE GROOVING WIDTH 7 MM
 STECHTIEFE GROOVING DEPTH 18 MM

AUSFÜHRUNG VERSION
 CMS5



	Abmessungen Dimensions (mm)						
	h ₁	d	l ₁	t	a	f	f ₁
CMS5	25	50	76	18	7	f ₁ + $\frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 7 mm t = 18 mm	RAG-CMS5-B7T18H5-LG	799.78.001.31	RAG-ST-B7T18H5-LG	70.91.22.578.0	RAG-SP-B7T18-L	70.91.11.926.0
	RAG-CMS5-B7T18H5-LR100	799.78.001.32	RAG-ST-B7T18H5-LR100	70.91.22.579.0	RAG-SP-B7T18-L	70.91.11.926.0
	RAG-CMS5-B7T18H5-LL100	799.78.001.33	RAG-ST-B7T18H5-LL100	70.91.22.580.0	RAG-SP-B7T18-L	70.91.11.926.0
Rechts Right a = 7 mm t = 18 mm	RAG-CMS5-B7T18H5-RG	799.77.001.31	RAG-ST-B7T18H5-RG	70.91.22.530.0	RAG-SP-B7T18-R	70.91.11.910.0
	RAG-CMS5-B7T18H5-RL100	799.77.001.32	RAG-ST-B7T18H5-RL100	70.91.22.531.0	RAG-SP-B7T18-R	70.91.11.910.0
	RAG-CMS5-B7T18H5-RR100	799.77.001.33	RAG-ST-B7T18H5-RR100	70.91.22.532.0	RAG-SP-B7T18-R	70.91.11.910.0



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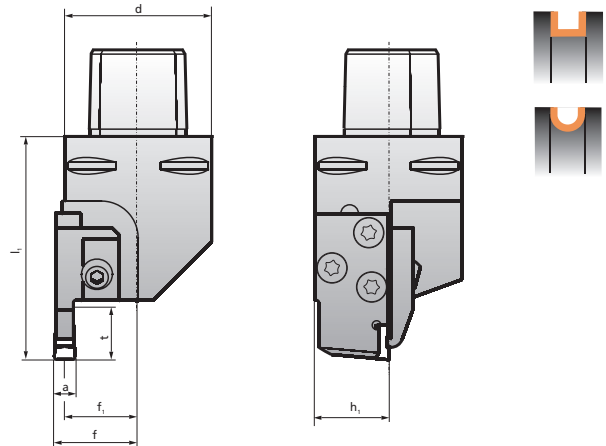
RAG Stechsystem RAG Grooving System







AUSFÜHRUNG VERSION
CMS5

STECHBREITE GROOVING WIDTH 7 MM
STECHTIEFE GROOVING DEPTH 24 MM

	Abmessungen Dimensions (mm)						
	h_1	d	l_1	t	a	f	f_1
CMS5	25	50	82	24	7	$f_1 + \frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°



Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 7 mm t = 24 mm	 RAG-CMS5-B7T24H5-LG	799.78.001.34	RAG-ST-B7T24H5-LG	70.91.22.581.0	RAG-SP-B7T24-L	70.91.11.927.0
	 RAG-CMS5-B7T24H5-LR100	799.78.001.35	RAG-ST-B7T24H5-LR100	70.91.22.582.0	RAG-SP-B7T24-L	70.91.11.927.0
	 RAG-CMS5-B7T24H5-LL100	799.78.001.36	RAG-ST-B7T24H5-LL100	70.91.22.583.0	RAG-SP-B7T24-L	70.91.11.927.0
Rechts Right a = 7 mm t = 24 mm	 RAG-CMS5-B7T24H5-RG	799.77.001.34	RAG-ST-B7T24H5-RG	70.91.22.533.0	RAG-SP-B7T24-R	70.91.11.911.0
	 RAG-CMS5-B7T24H5-RL100	799.77.001.35	RAG-ST-B7T24H5-RL100	70.91.22.534.0	RAG-SP-B7T24-R	70.91.11.911.0
	 RAG-CMS5-B7T24H5-RR100	799.77.001.36	RAG-ST-B7T24H5-RR100	70.91.22.535.0	RAG-SP-B7T24-R	70.91.11.911.0



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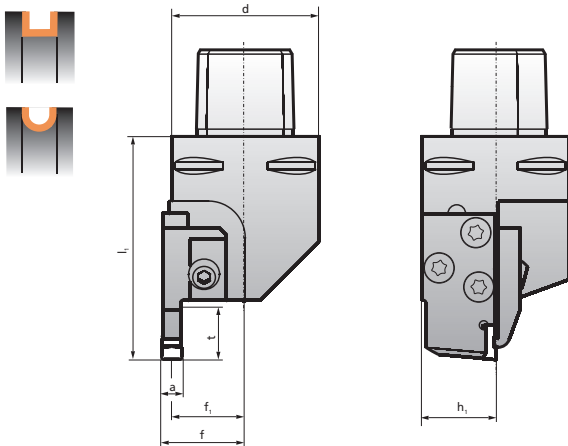
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RAG Stechsystem

RAG Grooving System

STECHBREITE GROOVING WIDTH 7 MM
 STECHTIEFE GROOVING DEPTH 30 MM

AUSFÜHRUNG VERSION
 CMS5



	Abmessungen Dimensions (mm)						
	h ₁	d	l ₁	t	a	f	f ₁
CMS5	25	50	88	30	7	f ₁ + $\frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 7 mm t = 30 mm	RAG-CMS5-B7T30H5-LG	799.78.001.37	RAG-ST-B7T30H5-LG	70.91.22.584.0	RAG-SP-B7T30-L	70.91.11.928.0
	RAG-CMS5-B7T30H5-LR100	799.78.001.38	RAG-ST-B7T30H5-LR100	70.91.22.585.0	RAG-SP-B7T30-L	70.91.11.928.0
	RAG-CMS5-B7T30H5-LL100	799.78.001.39	RAG-ST-B7T30H5-LL100	70.91.22.586.0	RAG-SP-B7T30-L	70.91.11.928.0
Rechts Right a = 7 mm t = 30 mm	RAG-CMS5-B7T30H5-RG	799.77.001.37	RAG-ST-B7T30H5-RG	70.91.22.536.0	RAG-SP-B7T30-R	70.91.11.912.0
	RAG-CMS5-B7T30H5-RL100	799.77.001.38	RAG-ST-B7T30H5-RL100	70.91.22.537.0	RAG-SP-B7T30-R	70.91.11.912.0
	RAG-CMS5-B7T30H5-RR100	799.77.001.39	RAG-ST-B7T30H5-RR100	70.91.22.538.0	RAG-SP-B7T30-R	70.91.11.912.0



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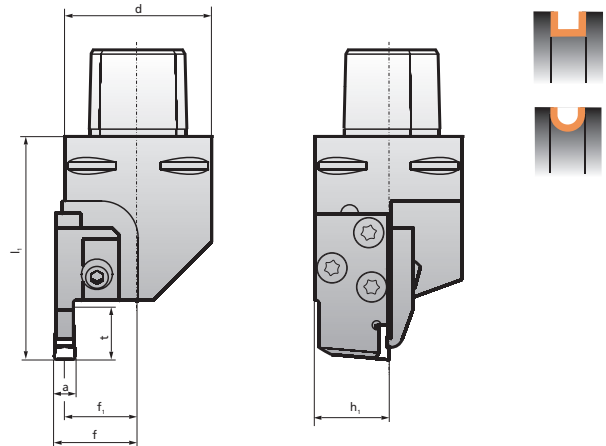
RAG Stechsystem RAG Grooving System







AUSFÜHRUNG VERSION
CMS5

STECHBREITE GROOVING WIDTH 8 MM
STECHTIEFE GROOVING DEPTH 18 MM

	Abmessungen Dimensions (mm)						
	h_1	d	l_1	t	a	f	f_1
CMS5	25	50	76	18	8	$f_1 + \frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°



Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 8 mm t = 18 mm	 RAG-CMS5-B8T18H5-LG	799.78.001.40	RAG-ST-B8T18H5-LG	70.91.22.587.0	RAG-SP-B8T18-L	70.91.11.929.0
	 RAG-CMS5-B8T18H5-LR100	799.78.001.41	RAG-ST-B8T18H5-LR100	70.91.22.588.0	RAG-SP-B8T18-L	70.91.11.929.0
	 RAG-CMS5-B8T18H5-LL100	799.78.001.42	RAG-ST-B8T18H5-LL100	70.91.22.588.0	RAG-SP-B8T18-L	70.91.11.929.0
Rechts Right a = 8 mm t = 18 mm	 RAG-CMS5-B8T18H5-RG	799.77.001.40	RAG-ST-B8T18H5-RG	70.91.22.539.0	RAG-SP-B8T18-R	70.91.11.913.0
	 RAG-CMS5-B8T18H5-RL100	799.77.001.41	RAG-ST-B8T18H5-RL100	70.91.22.540.0	RAG-SP-B8T18-R	70.91.11.913.0
	 RAG-CMS5-B8T18H5-RR100	799.77.001.42	RAG-ST-B8T18H5-RR100	70.91.22.541.0	RAG-SP-B8T18-R	70.91.11.913.0



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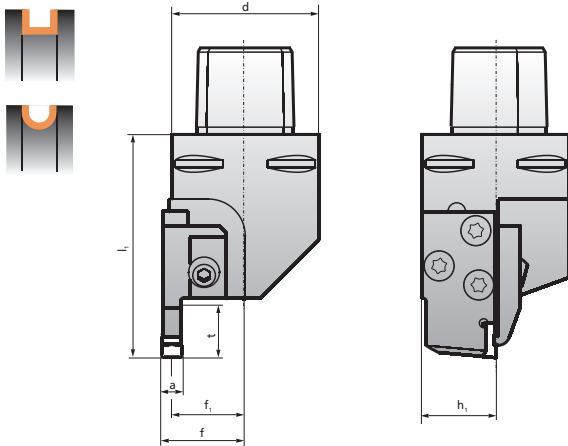
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RAG Stechsystem

RAG Grooving System







STECHBREITE GROOVING WIDTH 8 MM
 STECHTIEFE GROOVING DEPTH 24 MM

AUSFÜHRUNG VERSION
 CMS5



	Abmessungen Dimensions (mm)						
	h ₁	d	l ₁	t	a	f	f ₁
CMS5	25	50	82	24	8	f ₁ + $\frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°

Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 8 mm t = 24 mm	 RAG-CMS5-B8T24H5-LG	799.78.001.43	RAG-ST-B8T24H5-LG	70.91.22.590.0	RAG-SP-B8T24-L	70.91.11.930.0
	 RAG-CMS5-B8T24H5-LR100	799.78.001.44	RAG-ST-B8T24H5-LR100	70.91.22.591.0	RAG-SP-B8T24-L	70.91.11.930.0
	 RAG-CMS5-B8T24H5-LL100	799.78.001.45	RAG-ST-B8T24H5-LL100	70.91.22.592.0	RAG-SP-B8T24-L	70.91.11.930.0
Rechts Right a = 8 mm t = 24 mm	 RAG-CMS5-B8T24H5-RG	799.77.001.43	RAG-ST-B8T24H5-RG	70.91.22.542.0	RAG-SP-B8T24-R	70.91.11.914.0
	 RAG-CMS5-B8T24H5-RL100	799.77.001.44	RAG-ST-B8T24H5-RL100	70.91.22.543.0	RAG-SP-B8T24-R	70.91.11.914.0
	 RAG-CMS5-B8T24H5-RR100	799.77.001.45	RAG-ST-B8T24H5-RR100	70.91.22.544.0	RAG-SP-B8T24-R	70.91.11.914.0



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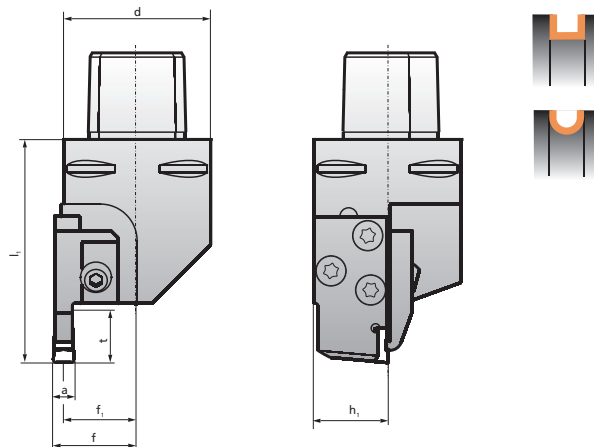
RAG Stechsystem RAG Grooving System







AUSFÜHRUNG VERSION
CMS5

STECHBREITE GROOVING WIDTH 8 MM
STECHTIEFE GROOVING DEPTH 30 MM

	Abmessungen Dimensions (mm)						
	h_1	d	l_1	t	a	f	f_1
CMS5	25	50	88	30	8	$f_1 + \frac{a}{2}$	25

Spanwinkel Rake angle γ	0°
Neigungswinkel Back rake angle λ	0°



Stechbreite a Stechtiefe t Grooving width a Grooving depth t	Typ Type	Best.-Nr. Ref. no.	Stechschwert Grooving blade		Spannelement Clamping element	
			CMS5	Typ Type	Best.-Nr. Ref. no.	Typ Type
Links Left a = 8 mm t = 30 mm	 RAG-CMS5-B8T30H5-LG	799.78.001.46	RAG-ST-B8T30H5-LG	70.91.22.593.0	RAG-SP-B8T30-L	70.91.11.931.0
	 RAG-CMS5-B8T30H5-LR100	799.78.001.47	RAG-ST-B8T30H5-LR100	70.91.22.594.0	RAG-SP-B8T30-L	70.91.11.931.0
	 RAG-CMS5-B8T30H5-LL100	799.78.001.48	RAG-ST-B8T30H5-LL100	70.91.22.595.0	RAG-SP-B8T30-L	70.91.11.931.0
Rechts Right a = 8 mm t = 30 mm	 RAG-CMS5-B8T30H5-RG	799.77.001.46	RAG-ST-B8T30H5-RG	70.91.22.545.0	RAG-SP-B8T30-R	70.91.11.915.0
	 RAG-CMS5-B8T30H5-RL100	799.77.001.47	RAG-ST-B8T30H5-RL100	70.91.22.546.0	RAG-SP-B8T30-R	70.91.11.915.0
	 RAG-CMS5-B8T30H5-RR100	799.77.001.48	RAG-ST-B8T30H5-RR100	70.91.22.547.0	RAG-SP-B8T30-R	70.91.11.915.0



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