

ISCAR New Products

Metric Version-5



LOGIQUICK
MACHINING INTELLIGENTLY

YOU

MACHINING

INTELLIGENTLY?

Member IMC Group
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CONTENTS

MILLING

1

TURNING

55

GROOVING

89

HOLEMAKING

111

YOU

MILLING

INTELLIGENTLY?

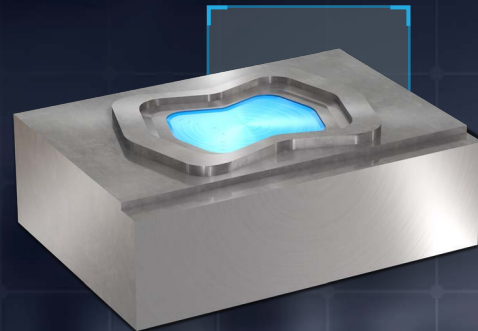


LOGIQUICK
MACHINING INTELLIGENTLY

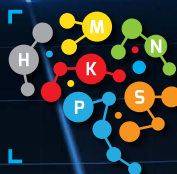


QUICKD MILL

**Combined Functions
for Drilling and Milling
In One Single Cutter
for Maximum
Machining Efficiency**

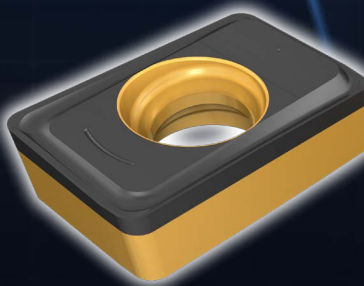


Cutter Dia.: 16mm, 20mm & 25mm.



**YOU Milling
Intelligently?**

QUICK-D-MILL Insert with 4 Cutting Edges. Two Outer Cutting Edges for Milling, 2 Center Cutting Edges for Drilling Applications. Incorporates Dovetail Clamping and Assures High Process Reliability.

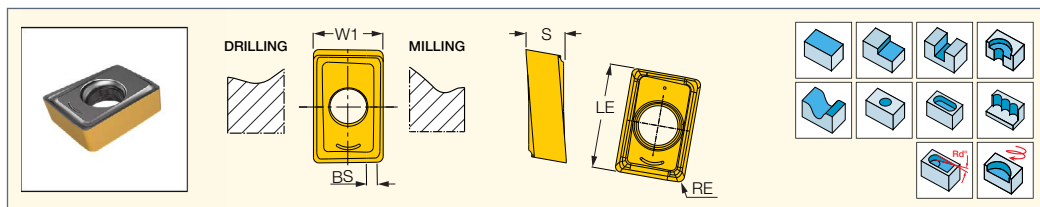


SCAN ME



QUICKDMILL

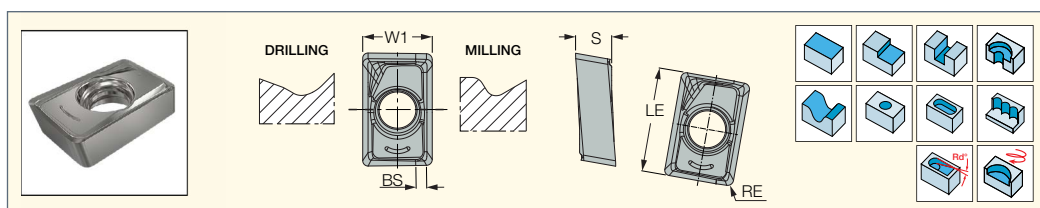
MDR ANMU PNTR
Double-Sided Rectangle Inserts
with 2 Center Cutting Edges
for Drilling and 2 Peripheral
Cutting Edges for Milling



Designation	Dimensions					Tough ↔ Hard					Recommended Machining Data f_z (mm/t)
	W1	LE	S	BS	RE	IC882	IC328	IC830	IC808	IC810	
MDR ANMU 070304PNTR	5.20	7.80	2.70	0.80	0.40	•	•	•	•	•	0.05-0.20
MDR ANMU 090305PNTR	6.30	9.40	3.15	0.80	0.50	•	•	•	•	•	0.05-0.23
MDR ANMU 120408PNTR	7.50	12.40	4.07	0.80	0.80	•	•	•	•	•	0.05-0.25
MDR ANMU 160508PNTR	9.50	15.80	5.14	1.00	0.80				•		0.05-0.28

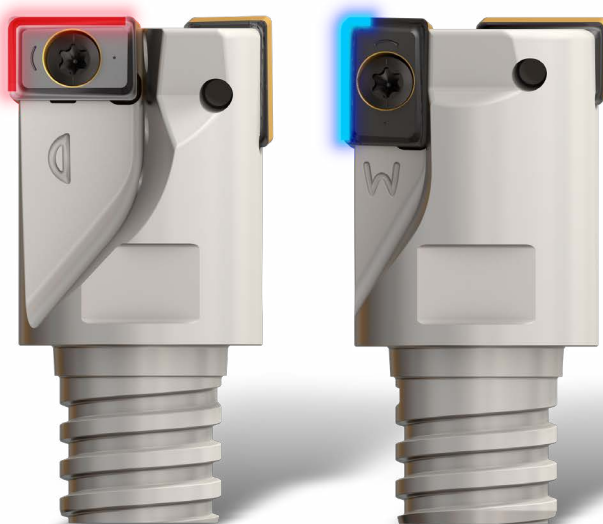
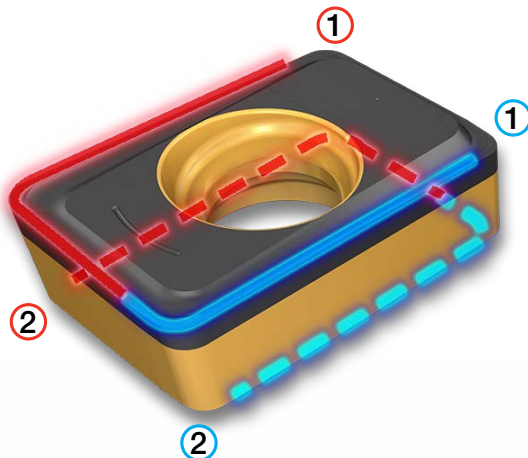
QUICKDMILL

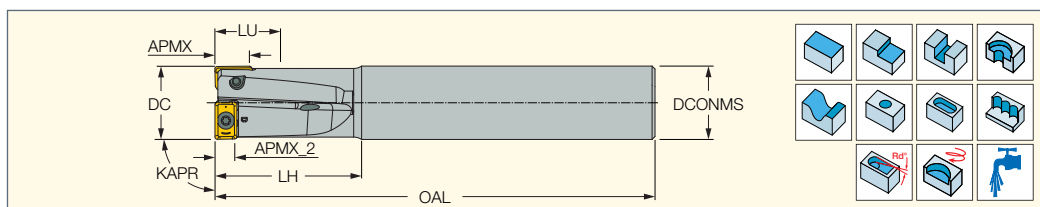
MDR ANHU FR-P
Inserts With Sharp Cutting
Edge and Polished Rake Face
for ISO N Applications (for
machining non-ferrous materials)



Designation	Dimensions					IC08	Recommended Machining Data f_z (mm/t)
	W1	LE	S	BS	RE		
MDR ANHU 070304FR-P	5.20	7.80	2.70	0.80	0.45	•	0.10-0.30
MDR ANHU 090305FR-P	6.30	9.40	2.95	0.80	0.50	•	0.10-0.30
MDR ANHU 120408FR-P	7.50	12.40	3.85	0.80	0.80	•	0.10-0.30

Two center edges
Two peripheral edges





Designation	DC	APMX	APMX_2	KAPR ⁽¹⁾	CICT ⁽²⁾	LU ⁽³⁾	LH	OAL	DCONMS	Shank	CSP ⁽⁴⁾	MDN ⁽⁵⁾	MDX ⁽⁶⁾	MIID ⁽⁷⁾	kg
MDR D16-2-C16-AN07	16.00	7.30	4.70	90.0	2	12.00	30.0	130.00	16.00	C	1	16.80	30.80	MDR ANMU 07...	0.14
MDR D20-2-C20-AN09	20.00	8.90	5.70	90.0	2	15.00	35.0	145.00	20.00	C	1	21.80	38.20	MDR ANMU 09...	0.30
MDR D25-2-C25-AN12	25.00	11.50	6.50	90.0	2	18.50	50.0	150.00	25.00	C	1	26.30	47.60	MDR ANMU 12...	0.47
MDR D32-2-C32-AN16	32.00	14.90	8.50	90.0	2	23.50	50.0	150.00	32.00	C	1	33.30	60.90	MDR ANMU 16...	0.72

• When drilling holes deeper than 5 mm, it is recommended to use the pecking method (G83)

⁽¹⁾ Tool cutting edge angle

⁽²⁾ Number of inserts (or edges for solid tool)

⁽³⁾ Max.drilling depth

⁽⁴⁾ 0 - Without coolant supply, 1 - With coolant supply

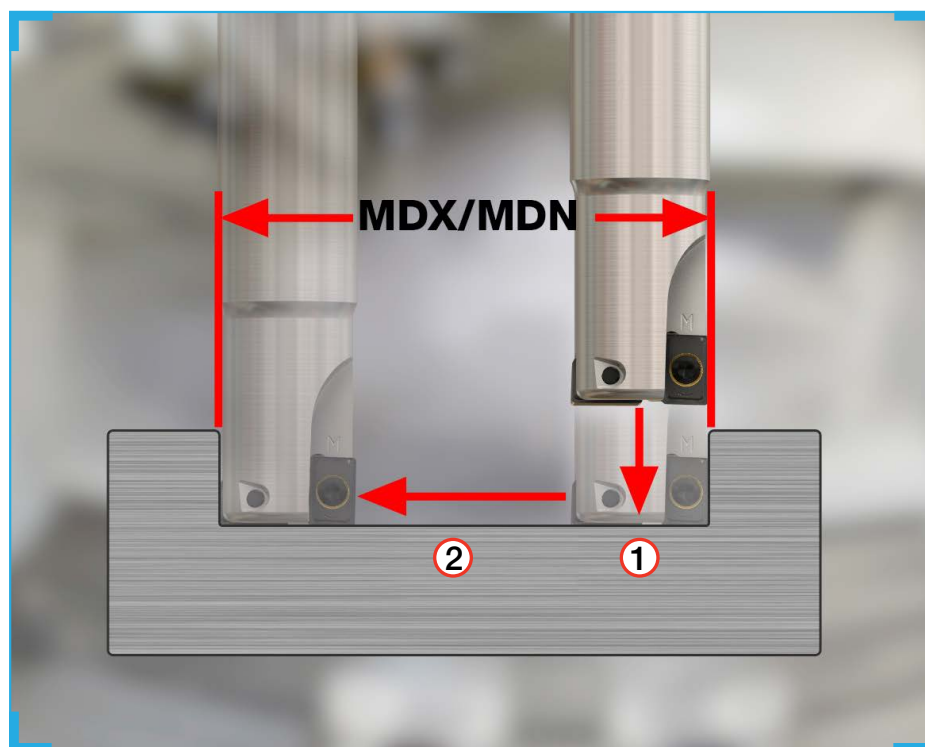
⁽⁵⁾ Minimum diameter to obtain a flat-bottom pocket having no protrusions by use of helical or circular interpolation

⁽⁶⁾ Maximum diameter to obtain a flat-bottom pocket having no protrusions by use of helical or circular interpolation

⁽⁷⁾ Master insert identification

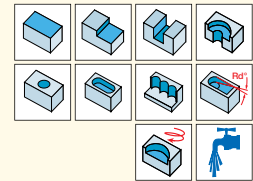
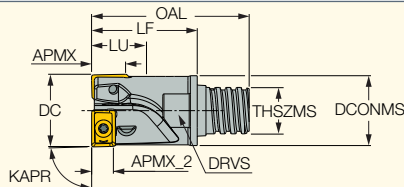
Spare Parts

Designation					
MDR D16-2-C16-AN07				SR M2.5-L6-D3.25-T7	T-7/51
MDR D20-2-C20-AN09				SR 10508082-HG	T-8/53
MDR D25-2-C25-AN12				SR 14-571	T-10/51
MDR D32-2-C32-AN16	SR M4X0.7IP15	SW6-T-SH	BLD IP15/S7		



MDR MMT-JHP

MULTI-FUNCTION Modular Head
for Endmill Cutters with
a MULTI-MASTER
Threaded Adaptation



Designation	DC	APMX	APMX_2	KAPR ⁽¹⁾	CICT ⁽²⁾	LU ⁽³⁾	LF	OAL	THSZMS	DCONMS	DRVS ⁽⁴⁾	RMPX ⁽⁵⁾	MDN ⁽⁶⁾	MDX ⁽⁷⁾	MIID ⁽⁸⁾	CSP ⁽⁹⁾	
MDR D16/.63-2-MMT10-07JHP	16.00	7.30	4.70	90.0	2	12.00	23.00	34.30	T10	15.20	13.0	90.0	16.80	30.80	MDR ANMU 07	1	0.07
MDR D20/.79-2-MMT12-09JHP	20.00	8.90	5.70	90.0	2	15.00	24.70	38.00	T12	18.30	16.0	90.0	21.80	38.20	MDR ANMU 09	1	0.08
MDR D25/.98-2-MMT15-12JHP	25.00	11.50	6.50	90.0	2	18.50	33.00	50.00	T15	23.90	20.0	90.0	26.30	47.60	MDR ANMU 12	1	0.08

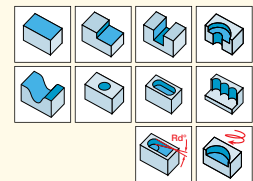
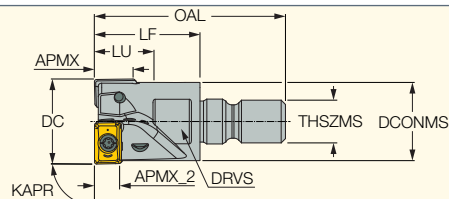
- Do not apply lubricant to the MULTI-MASTER threaded connection
- When drilling holes deeper than 5 mm, it is recommended to use the pecking method (G83)
- ⁽¹⁾ Tool cutting edge angle
- ⁽²⁾ Number of inserts (or edges for solid tool)
- ⁽³⁾ Max.drilling depth
- ⁽⁴⁾ Torque key size
- ⁽⁵⁾ Maximum ramping angle
- ⁽⁶⁾ Minimum diameter to obtain a flat-bottom pocket having no protrusions by use of helical or circular interpolation
- ⁽⁷⁾ Maximum diameter to obtain a flat-bottom pocket having no protrusions by use of helical or circular interpolation
- ⁽⁸⁾ Master insert identification
- ⁽⁹⁾ 0 - Without coolant supply, 1 - With coolant supply

Spare Parts

Designation		
MDR D16/.63-2-MMT10-07JHP	SR M2.5-L6-D3.25-T7	T-7/51
MDR D20/.79-2-MMT12-09JHP	SR 10508082-HG	T-8/53
MDR D25/.98-2-MMT15-12JHP	SR 14-571	T-10/51

MDR M-JHP

MULTI-FUNCTION Modular
Head for Endmill Cutters with a
FLEX-FIT Threaded Adaptation

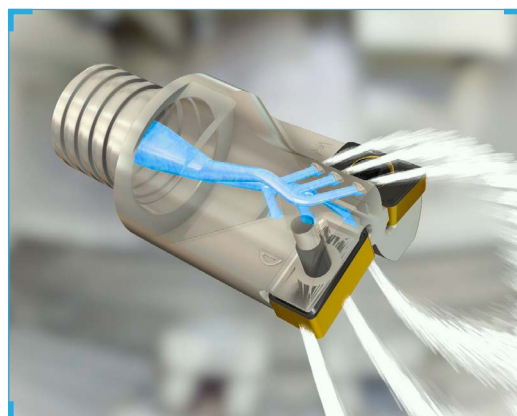


Designation	DC	APMX	APMX_2	KAPR ⁽¹⁾	CICT ⁽²⁾	LU	LF	OAL	THSZMS	DCONMS	DRVS ⁽³⁾	RMPX ⁽⁴⁾	MDN	MDX	TQ_3 ⁽⁵⁾	MIID ⁽⁶⁾	CSP ⁽⁷⁾	
MDR D20/.79-2-M10-09JHP	20.00	8.90	5.70	90.0	2	15.00	24.70	44.70	M10	18.30	18.0	90.0	21.80	38.20	29	MDR ANMU 09...	1	0.18
MDR D25/.98-2-M12-12JHP	25.00	11.50	6.50	90.0	2	18.50	33.00	55.00	M12	24.00	21.0	90.0	26.30	47.60	33	MDR ANMU 12...	1	0.18
MDR D32/1.26-2-M16-16JHP	32.00	14.50	8.70	90.0	2	23.50	40.00	65.00	M16	30.00	25.1	90.0	33.30	61.60	40	MDR ANMU 16...	1	0.16

- Before mounting the FLEX-FIT adaptation, clean the mating surfaces and threads. Tighten to eliminate gaps, using the torque value from TQ_3.
- When drilling holes deeper than 5 mm, it is recommended to use the pecking method (G83).
- ⁽¹⁾ Tool cutting edge angle
- ⁽²⁾ Number of inserts (or edges for solid tool)
- ⁽³⁾ Torque key size
- ⁽⁴⁾ Maximum ramping angle
- ⁽⁵⁾ Tool tightening torque Nxm (lbfxin)
- ⁽⁶⁾ Master insert identification
- ⁽⁷⁾ 0 - Without coolant supply, 1 - With coolant supply

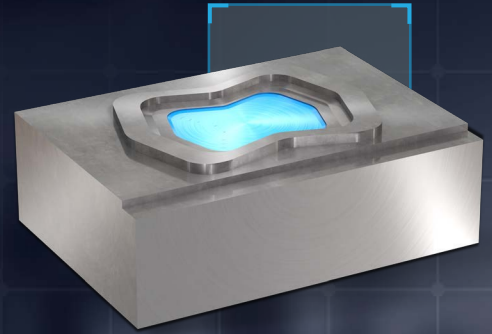
Spare Parts

Designation					
MDR D20/.79-2-M10-09JHP				SR 10508082-HG	T-8/53
MDR D25/.98-2-M12-12JHP				SR 14-571	T-10/51
MDR D32/1.26-2-M16-16JHP	SR M4X0.7IP15	SW6-T-SH	BLD IP15/S7		



MULTI-MASTER

New MULTI-MASTER
High Feed Heads with
6 Effective Cutting Edges



Dia: 8, 10, 12, 16, 20 & 25mm.



YOU Milling
Intelligently?

The New Heads Have Ramping and
Slotting Capabilities.



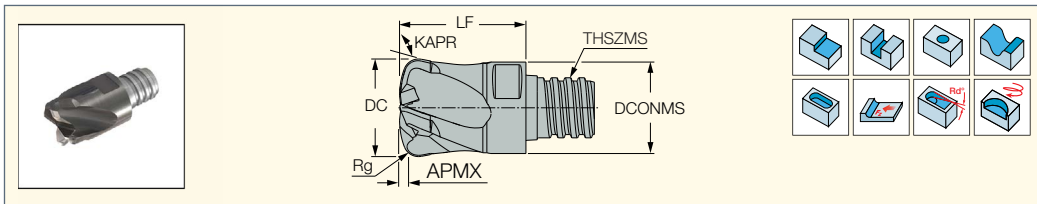
SCAN ME



MULTI^{FEED} MASTER

MM EFF

4, 6 Flute Solid Carbide Heads for Milling at Very Fast Feeds and Small D.O.C.



Designation	Dimensions											Tough ↔ Hard		Recommended Machining Data
	DC	NOF ⁽¹⁾	APMX	THSZMS	DCONMS	LF	RMPX ⁽²⁾	KAPR ⁽³⁾	FHA	Rg ⁽⁴⁾	CSP ⁽⁵⁾	IC908	IC903	
MM EFF080T3R1.62-4T05	8.00	4	0.40	T05	7.50	10.00	5.0	97.0	20.0	1.62	0		●	0.12-0.48
MM EFF080S2R0.86-6T05	8.00	6	0.40	T05	7.50	10.00	5.0	97.0	0.0	0.86	0		●	0.12-0.48
MM EFF100T4R2.01-4T06	10.00	4	0.50	T06	9.50	13.00	5.0	97.0	20.0	2.01	0		●	0.16-0.57
MM EFF100S2R1.0-6T06	10.00	6	0.45	T06	9.50	13.00	5.0	97.0	0.0	1.00	0		●	0.16-0.57
MM EFF100T2R1.0-6T06H	10.00	6	0.45	T06	9.50	10.00	3.0	97.0	20.0	1.00	1		●	0.16-0.47
MM EFF120T4R1.8-4T08H	12.00	4	0.60	T08	11.50	16.50	5.0	97.0	20.0	1.80	1	●	●	0.16-0.67
MM EFF120T4R2.47-4T08	12.00	4	0.60	T08	11.50	16.50	5.0	97.0	20.0	2.47	0		●	0.16-0.67
MM EFF120S3R1.2-6T08	12.00	6	0.65	T08	11.50	16.50	5.0	97.0	0.0	1.20	0		●	0.16-0.67
MM EFF120T2R1.2-6T08H	12.00	6	0.65	T08	11.50	12.00	3.0	97.0	20.0	1.20	1		●	0.16-0.54
MM EFF127T4R2.59-4T08	12.70	4	0.60	T08	12.20	16.50	5.0	97.0	20.0	2.59	0		●	0.16-0.67
MM EFF127S3R1.3-6T08	12.70	6	0.70	T08	12.70	16.50	5.0	97.0	0.0	1.30	0		●	0.16-0.67
MM EFF127T4R1.3-6T08H	12.70	6	0.70	T08	12.20	12.70	3.0	97.0	20.0	1.30	1		●	0.16-0.67
MM EFF160T5R2.2-4T10H	16.00	4	0.80	T10	15.40	20.50	5.0	97.0	20.0	2.20	1	●		0.20-0.75
MM EFF160T5R3.25-4T10	16.00	4	0.80	T10	15.40	20.50	5.0	97.0	20.0	3.25	0		●	0.20-0.75
MM EFF160S4R2.0-6T10	16.00	6	1.05	T10	15.40	20.50	5.0	97.0	0.0	2.00	0		●	0.20-0.75
MM EFF160T4R2.0-6T10H	16.00	6	1.05	T10	15.40	16.00	3.0	97.0	20.0	2.00	1		●	0.20-0.65
MM EFF200T6R4.02-4T12	20.00	4	1.00	T12	18.45	25.50	5.0	97.0	20.0	4.02	0		●	0.20-0.90
MM EFF200S5R2.2-6T12	20.00	6	1.25	T12	18.45	25.50	5.0	97.0	0.0	2.20	0		●	0.20-0.90
MM EFF200T5R2.2-6T12H	20.00	6	1.25	T12	18.45	20.00	3.0	97.0	20.0	2.20	1		●	0.20-0.80
MM EFF250A7R3.1-6T15	25.00	6	1.20	T15	23.90	25.00	5.0	97.0	30.0	3.10	0		●	0.25-1.00
MM EFF250S6R2.5-6T15	25.00	6	1.55	T15	23.90	25.00	5.0	97.0	0.0	2.50	0		●	0.25-1.00
MM EFF254A7R3.1-6T15	25.40	6	1.20	T15	23.90	25.00	5.0	97.0	30.0	3.10	0		●	0.25-1.00

- Do not apply lubricant to the threaded connection
- Heads with coolant supply are recommended for shouldering operations

(1) Number of flutes

(2) Maximum ramping angle

(3) Tool cutting edge angle

(4) Radius for programming

(5) 0 - Without coolant supply, 1 - With coolant supply

MULTI-MASTER Machining Recommendations for MM EFF Heads

VDI 3323	Material Group ⁽¹⁾	v _c (m/min)	f _z (mm/t) vs. Tool Diameter (mm) ^(5,6)							
			a _p	a _e	8	10	12	16	20	25
P	1	180	0.045xD	0.7xD	0.48	0.57	0.67	0.75	0.90	1.00
	2	160	0.045xD	0.7xD	0.48	0.57	0.67	0.75	0.90	1.00
	3	160	0.045xD	0.7xD	0.48	0.57	0.67	0.75	0.90	1.00
	4	160	0.045xD	0.7xD	0.48	0.57	0.67	0.75	0.90	1.00
	5	150	0.045xD	0.7xD	0.43	0.50	0.57	0.65	0.75	0.87
	6	150	0.045xD	0.7xD	0.33	0.40	0.48	0.57	0.67	0.78
	7	140	0.045xD	0.7xD	0.33	0.40	0.48	0.57	0.67	0.78
	8	140	0.045xD	0.7xD	0.30	0.35	0.43	0.52	0.60	0.70
	9	140	0.045xD	0.7xD	0.30	0.35	0.43	0.52	0.60	0.70
	10	130	0.04xD	0.6xD	0.28	0.33	0.38	0.48	0.57	0.67
	11	120	0.04xD	0.6xD	0.25	0.30	0.35	0.43	0.52	0.62
	12, 13	120	0.04xD	0.6xD	0.30	0.35	0.43	0.52	0.60	0.70
K	15-16	180	APMX	0.7xD	0.45	0.52	0.60	0.70	0.80	0.90
	17-18	160	APMX	0.7xD	0.38	0.45	0.52	0.60	0.70	0.80
H	38.1 ⁽²⁾	100	0.035xD	0.45xD	0.20	0.25	0.33	0.40	0.48	0.55
	38.2 ⁽³⁾	80	0.03xD	0.3xD	0.16	0.22	0.30	0.38	0.45	0.52
	39 ⁽⁴⁾	60	0.02xD	0.25xD	0.12	0.16	0.16	0.20	0.20	0.25

(1) ISCAR material group in accordance with VDI 3323 standard

(2) HRC 45-49

(3) HRC 50-55

(4) HRC 56-63

(5) For Full Slot: f_z slot=0.6 x f_z

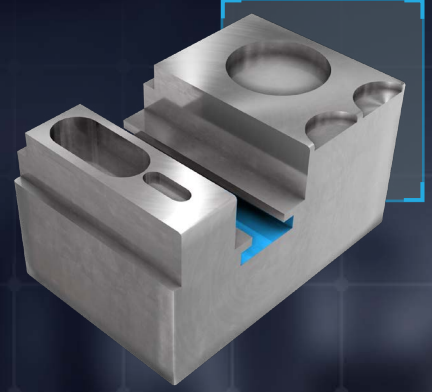
(6) For Ramp Down: f_z ramp=0.1 x f_z

a_p - Depth of cut

a_e - Width of cut

HELISLOT

Slotting Cutters
with a Unique Helical
Shaped Insert with
8 Cutting Edges



Slot Widths: 7 – 10mm.
Dia. Range: 32 – 160mm.



YOU Milling
Intelligently?

Unique Twisted Insert with
a High Positive Rake Angle.
Helical Shape for Easy
and Accurate Cut.



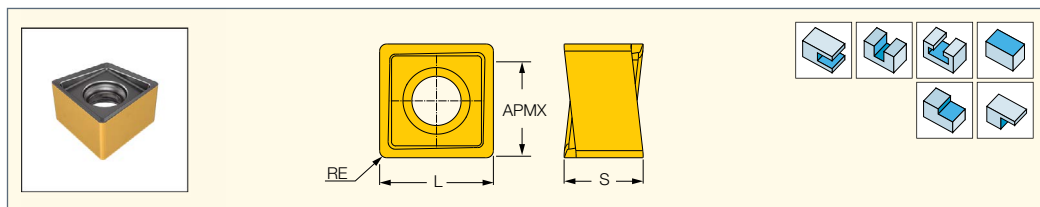
SCAN ME



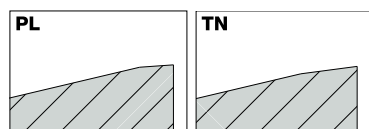
HELI-SLOT

XNMU/XNHU 06

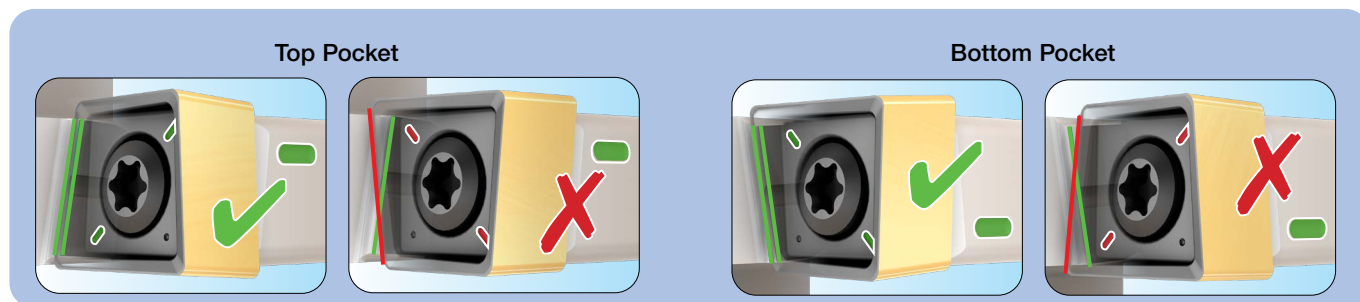
Square Inserts with 4 Right- and 4 Left-Hand Cutting Edges



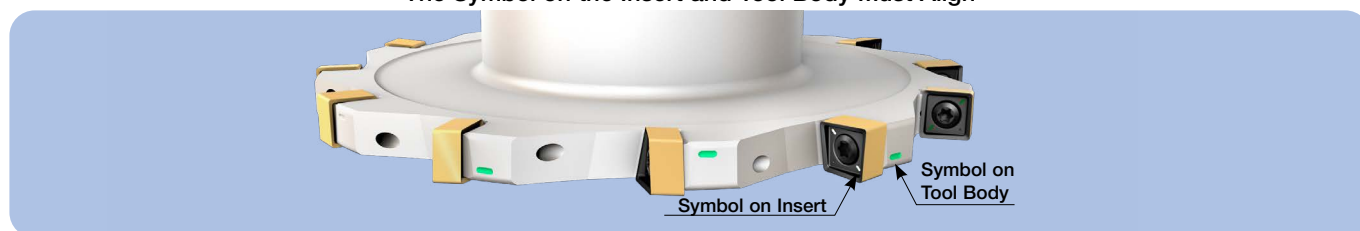
Designation	Dimensions				Tough ↔ Hard				Recommended Machining Data f_z (mm/t)
	APMX	L	S	RE	IC830	IC08	IC808	IC810	
XNHU 060304-PNN-PL-P	6.00	6.40	4.70	0.40	•	•	•	•	0.10-0.25
XNMU 060304-PNTN	6.00	6.40	4.40	0.40	•	•	•	•	0.05-0.12



Mounting an XNMU 0603... Insert on Slot Milling Cutters



The Symbol on the Insert and Tool Body Must Align



Starting Feed Per Tooth f_z for HELI-SLOT 06 Slotting Mills with Inserts XNMU 06...

ISO Class DIN/ISO 513	Description	Workpiece Material				Feed f_z mm/tooth	
		ISCAR Material Group**	Typical Representative		Hardness, HB	Grades	
			AISI/SAE/ASTM	DIN W.-Nr.		IC808	IC830
P	non-alloy steel	1	1020	1.0044	130-180	0.10-0.20	0.10-0.20
	alloy steel	8	4340	1.6582	260-300	0.08-0.12	0.08-0.12
	alloy steel	9	4340	1.6582	HRC 35-42*	0.08-0.12	0.08-0.12
	high alloy steel	10	H13	1.2344	200-220	0.08-0.12	0.08-0.12
	martensitic S.S.	12	420	1.4021	200	0.08-0.12	0.08-0.12
M	austenitic S.S.	14	304L	1.4306	200	0.08-0.12	0.08-0.12
	austenitic S.S.	14	316L	1.4404	140	0.08-0.12	0.08-0.12
K	grey cast iron	16	class 40	0.6025 (GG25)	250	0.10-0.20	
	nodular cast iron	17	class 65-45-12	0.7050 (GGG50)	200	0.08-0.15	
H	hard steel and cast iron	38.1	H11	1.2343	HRC 45-49	0.06-0.12	
		38.2	P20	1.2330	HRC 50-55	0.05-0.10	

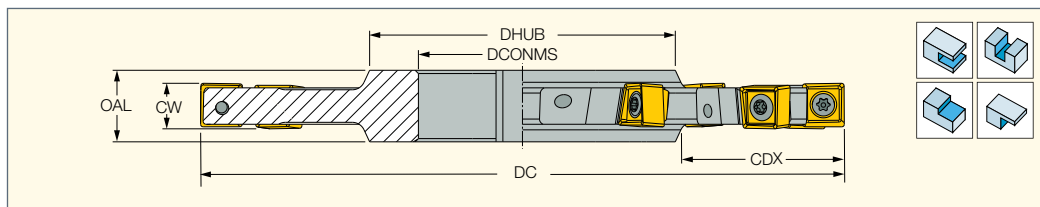
* Quenched and tempered

** ISCAR material group in accordance with VDI 3323 standard

HELI-SLOT

SDN-XN06

Full Slot Disk Type Slotting
Cutters Carrying XNMU 0603
Square Inserts with 4 Right- and
4 Left-Hand Cutting Edges



Designation	DC	CW	CICT ⁽¹⁾	ZEFP	CDX	DHUB	DCONMS	OAL	CSP ⁽²⁾
SDN D063-07-22-XN06	63.00	7.00	8	8	15.00	30.00	22.00	11.00	0
SDN D080-07-27-XN06	80.00	7.00	10	10	19.00	38.00	27.00	11.00	0
SDN D080-08-27-XN06	80.00	8.00	10	5	19.00	38.00	27.00	11.00	0
SDN D100-07-32-XN06	100.00	7.00	12	12	23.00	47.00	32.00	11.00	0
SDN D125-07-40-XN06	125.00	7.00	14	14	27.00	55.00	40.00	11.00	0

⁽¹⁾ Number of inserts (or edges for solid tool)

⁽²⁾ 0 - Without coolant supply, 1 - With coolant supply

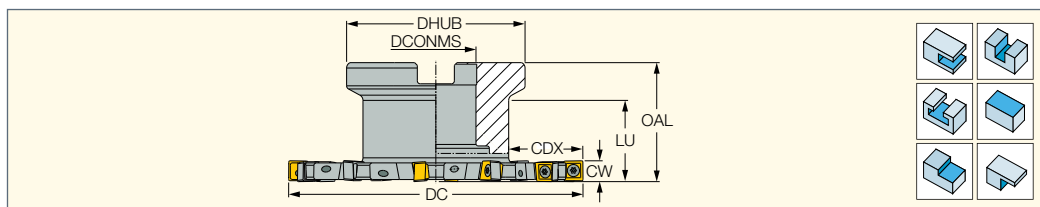
Spare Parts

Designation		
SDN-XN06	SR M2.5X6-T7-60	T-7/51

HELI-SLOT

FDN-XN06

Full Slot Flange Type Slotting
Cutters Carrying XNMU 0603
Square Inserts with 4 Right- and
4 Left-Hand Cutting Edges



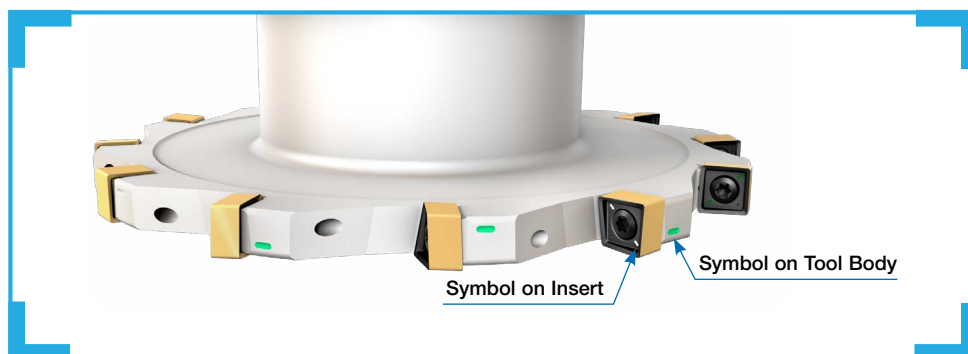
Designation	DC	CW	CICT ⁽¹⁾	ZEFP	CDX	DHUB	DCONMS	LU	OAL	Arbor	CSP ⁽²⁾	
FDN D063-07-16-XN06	63.00	7.00	8	8	17.00	38.00	16.00	28.5	40.00	A	0	0.18
FDN D080-07-22-XN06	80.00	7.00	10	10	20.00	48.00	22.00	28.5	40.00	A	0	0.55
FDN D080-08-22-XN06	80.00	8.00	10	5	20.00	48.00	22.00	28.5	40.00	A	0	0.39
FDN D100-07-27-XN06	100.00	7.00	12	12	23.00	60.00	27.00	28.5	40.00	B	0	0.18
FDN D100-08-27-XN06	100.00	8.00	12	6	23.00	60.00	27.00	28.5	40.00	B	0	0.64
FDN D125-07-32-XN06	125.00	7.00	14	14	27.00	65.00	32.00	31.5	45.00	B	0	0.90
FDN D125-09-32-XN06	125.00	9.00	14	7	27.00	65.00	32.00	31.5	45.00	B	0	1.04
FDN D160-10-40-XN06	160.00	10.00	18	9	30.00	80.00	40.00	45.0	60.00	B	0	1.99

⁽¹⁾ Number of inserts (or edges for solid tool)

⁽²⁾ 0 - Without coolant supply, 1 - With coolant supply

Spare Parts

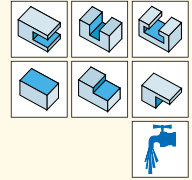
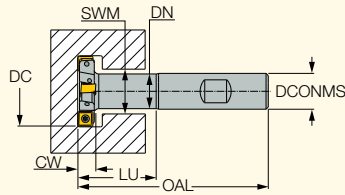
Designation			
FDN D063-07-16-XN06	SR M2.5X6-T7-60	T-7/51	SR M8X25DIN912
FDN D080-07-22-XN06	SR M2.5X6-T7-60	T-7/51	SR M10X25 DIN912
FDN D080-08-22-XN06	SR M2.5X6-T7-60	T-7/51	SR M10X25 DIN912
FDN D100-07-27-XN06	SR M2.5X6-T7-60	T-7/51	
FDN D100-08-27-XN06	SR M2.5X6-T7-60	T-7/51	
FDN D125-07-32-XN06	SR M2.5X6-T7-60	T-7/51	
FDN D125-09-32-XN06	SR M2.5X6-T7-60	T-7/51	
FDN D160-10-40-XN06	SR M2.5X6-T7-60	T-7/51	



HELISLOT

ETS-XN06

T-SLOT Endmills Carrying
XNMU 0603 Square Inserts
with 4 Right- and 4 Left-Hand
Cutting Edges



Designation	DC	CICT ⁽¹⁾	ZEFP	DN	SWM	CW	LU	OAL	DCONMS	Shank ⁽²⁾	CSP ⁽³⁾	kg
ETS D032-07-W16-XN06	32.00	4	4	15.50	17.00	7.00	30.00	80.00	16.00	W	1	0.20
ETS D032-08-W16-XN06	32.00	4	2	15.50	17.00	8.00	35.00	85.00	16.00	W	1	0.13
ETS D040-07-W16-XN06	40.00	4	4	15.50	17.00	7.00	30.00	80.00	16.00	W	1	0.14
ETS D040-08-W16-XN06	40.00	4	2	15.50	17.00	8.00	35.00	85.00	16.00	W	1	0.15
ETS D050-07-W20-XN06	50.00	6	6	19.50	21.00	7.00	33.00	85.00	20.00	W	1	0.22
ETS D050-10-W20-XN06	50.00	6	3	19.50	21.00	10.00	38.00	90.00	20.00	W	1	0.25

⁽¹⁾ Number of inserts (or edges for solid tool)

⁽²⁾ W-Weldon

⁽³⁾ 0 - Without coolant supply, 1 - With coolant supply

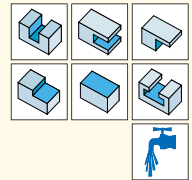
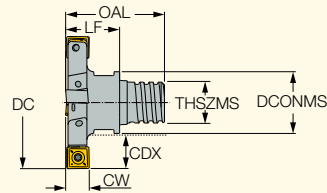
Spare Parts

Designation		
ETS-XN06	SR M2.5X6-T7-60	T-7/51

HELISLOT

ETS-XN06-MM

T-SLOT Endmills with
a MULTI-MASTER Threaded
Connection, Mount XNMU 0603
Square Inserts



Designation	DC	CICT ⁽¹⁾	ZEFP	CW	CDX	DCONMS	THSZMS	LF	OAL	DRVS ⁽²⁾	CSP ⁽³⁾
ETS D032-07-XN06-MMT10	31.70	4	4	7.00	7.70	15.30	T10	16.00	27.30	13.0	1
ETS D040-07-XN06-MMT12	39.80	4	4	7.00	10.00	18.30	T12	16.00	29.30	16.0	1
ETS D050-07-XN06-MMT15	49.80	6	6	7.00	12.50	23.90	T15	19.00	36.00	20.0	1

⁽¹⁾ Number of inserts (or edges for solid tool)

⁽²⁾ Torque key size

⁽³⁾ 0 - Without coolant supply, 1 - With coolant supply

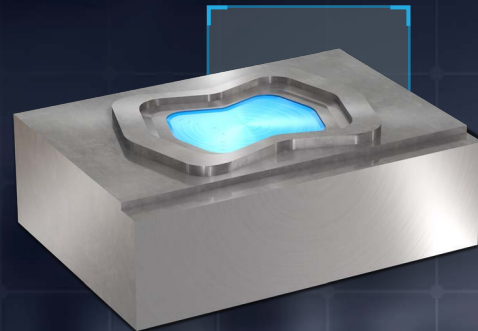
Spare Parts

Designation		
ETS-XN06-MM	SR M2.5X6-T7-60	T-7/51

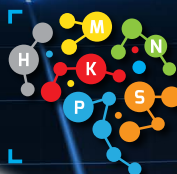


MILL4FEED

Small 06 High Feed
Square Inserts with 4 Positive
Cutting Edges for Machining
Diverse Material Types



For Machining Deep Cavities on
a Wide Variety of Materials.



YOU Milling Intelligently?

.....
Deep Cavity Machining at High
Overhangs and High Feed Rates.
Assures Stable Machining, No
Vibrations for Fast Metal Removal.
.....

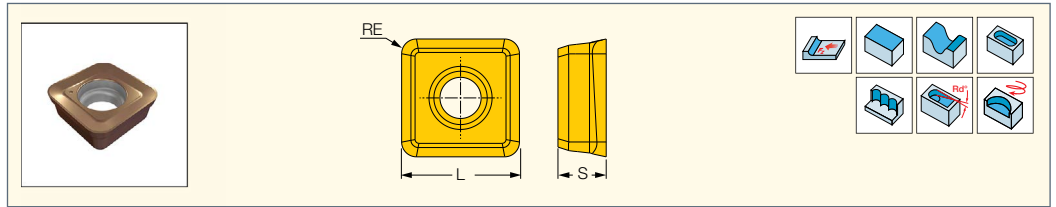


SCAN ME



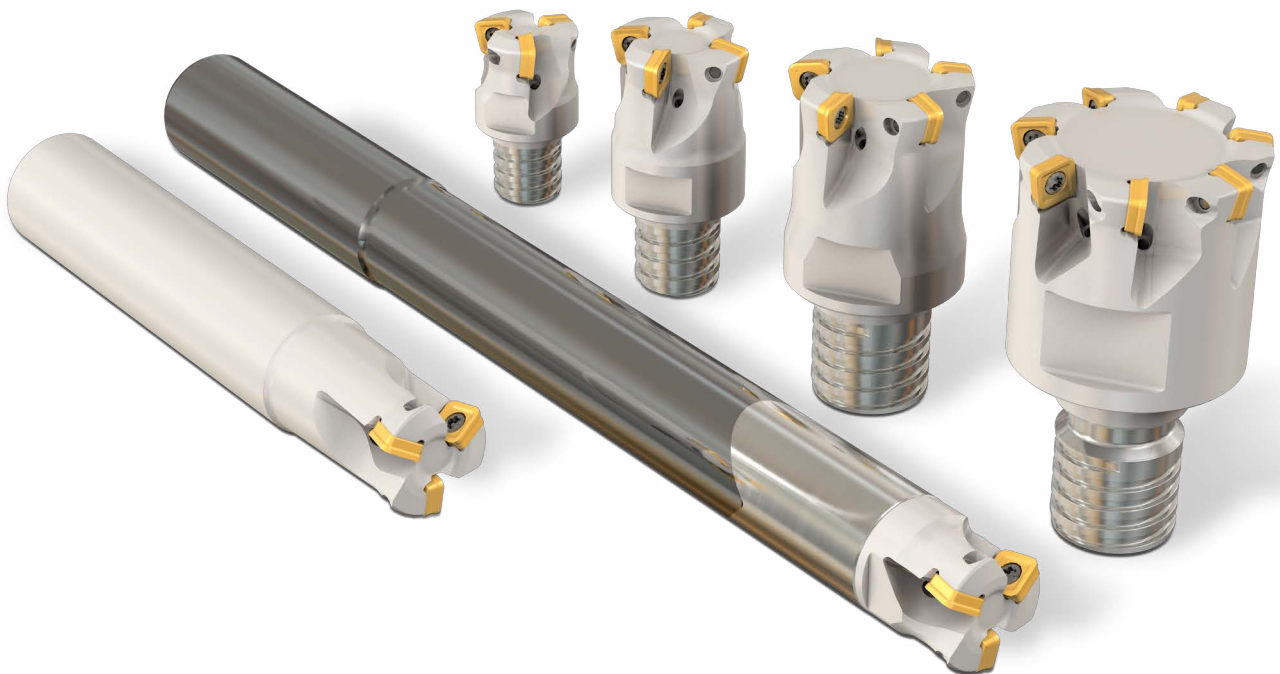
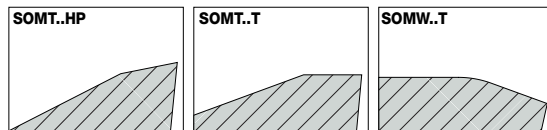
MILL4FEED

FFQ4 SOMT/W 0602
Single-Sided Square Inserts
with 4 Cutting Edges
for Fast Feed Milling



Designation	Dimensions			Tough $\longleftrightarrow$ Hard					Recommended Machining Data	
	L	S	RE	IC882	IC840	IC830	IC08	IC808	a_p (mm)	f_z (mm/t)
FFQ4 SOMT 060210HP	5.50	2.00	1.00	•	•			•	0.20-0.70	0.20-0.90
FFQ4 SOMT 060210HP-P	5.50	2.00	1.00				•		0.20-0.70	0.20-0.90
FFQ4 SOMT 060210T	5.50	2.04	1.00			•		•	0.20-0.70	0.20-1.00
FFQ4 SOMW 060213T	5.60	2.11	1.30					•	0.20-0.60	0.20-1.00

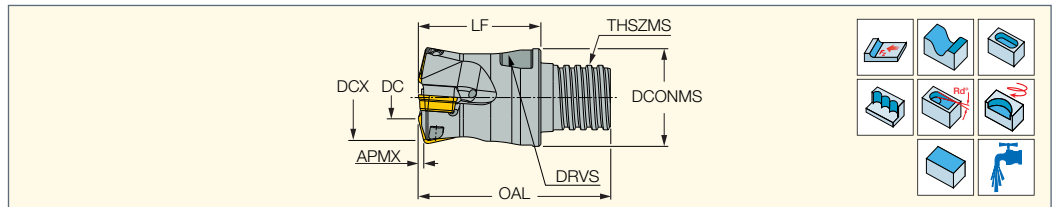
- For side plunging, the initial cutting feed is 0.1 mm/t • T type for steel, ferritic and martensitic stainless steel and cast iron
- HP type for austenitic stainless steel and high temperature alloys • SOMW- flat insert for hard material (up to 60 HRC) and uneven surface



MILL4FEED

FFQ4 D-MM-06

Fast Feed Endmills with
MULTI-MASTER Threaded
Adaptation Carrying
Single-Sided Square Inserts
with 4 Cutting Edges



Designation	DCX ⁽¹⁾	DC	APMX	AE ⁽²⁾	CICT ⁽³⁾	THSZMS	LF	OAL	DCONMS	DRVS ⁽⁴⁾	RMPX ⁽⁵⁾	CSP ⁽⁶⁾	MDN	MDX	TQ_3 ⁽⁷⁾	MIID ⁽⁸⁾	TQ
FFQ4 D16/.63-03-MMT10-06	16.00	7.20	0.70	4.4	3	T10	16.00	27.30	15.20	13.0	6.0	1	23.20	31.00	28	FFQ4 SOMT 060210T	0.9 0.02
FFQ4 D20-04-MMT12-06	20.00	11.20	0.70	4.4	4	T12	25.00	38.30	18.80	16.0	3.5	1	31.20	39.00	28	FFQ4 SOMT 060210T	0.9 0.05
FFQ4 D25/.98-05-MMT15-06	25.00	16.20	0.70	4.4	5	T15	30.00	47.00	24.00	20.0	2.2	1	41.20	49.00	40	FFQ4 SOMT 060210T	0.9 0.09
FFQ4 D32/1.26-07-MMT21-06	32.00	23.20	0.70	4.4	7	T21	30.00	53.10	29.40	24.0	1.4	1	55.20	63.00	110	FFQ4 SOMT 060210T	0.9 0.17

- Do not apply lubricant to the MULTI-MASTER threaded connection.
- To generate a straight surface without cusps, the width of cut must not exceed DC.
- Radius for programming: for insert SOMT 1.7 mm, for insert SOMW 1.9 mm.
- When mounting insert SOMW, APMX=0.6 mm
- For slot milling or machining with high tool overhang, the maximum depth of cut should be reduced by 50%.

⁽¹⁾ Cutting diameter maximum

⁽²⁾ Maximum plunging width

⁽³⁾ Number of inserts (or edges for solid tool)

⁽⁴⁾ Torque key size

⁽⁵⁾ Maximum ramping angle

⁽⁶⁾ 0 - Without coolant supply, 1 - With coolant supply

⁽⁷⁾ Tool tightening torque Nxm (lbf·in)

⁽⁸⁾ Master insert identification

Spare Parts

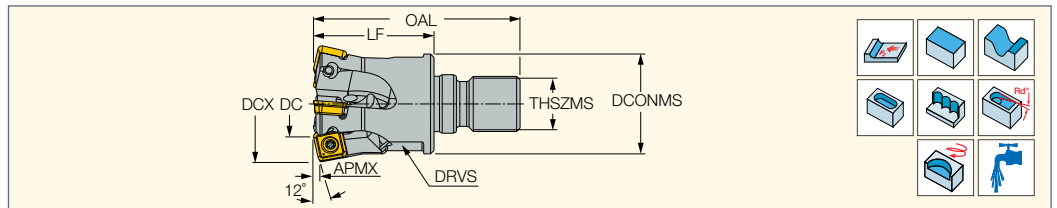
Designation		
FFQ4 D-MM-06	SR 10516050-L4.6	IP-7/51 ^(a)

^(a) For limiting torque, use optional 7007378 BLD 4 IP07-0.9NM blade & 7007318 HSD 4-0.9NM handle.

MILL4FEED

FFQ4 D-M-06

Fast Feed Endmills with
FLEX-FIT Threaded Adaptation
Carrying Single-Sided Square
Inserts with 4 Cutting Edges



Designation	DCX ⁽¹⁾	DC	APMX	AE ⁽²⁾	CICT ⁽³⁾	LF	OAL	DCONMS	THSZMS	RMPX ⁽⁴⁾	MDN	MDX	DRVS ⁽⁵⁾	MIID ⁽⁶⁾	CSP ⁽⁷⁾	TQ	TQ_3 ⁽⁸⁾
FFQ4 D20-04-M10-06	20.00	11.20	0.70	4.4	4	25.00	45.00	18.00	M10	3.5	31.20	39.00	15.1	FFQ4 SOMT 060210T	1	0.04 0.9	29
FFQ4 D25-05-M12-06	25.00	16.20	0.70	4.4	5	30.00	52.00	21.00	M12	2.2	41.20	49.00	17.1	FFQ4 SOMT 060210T	1	0.18 0.9	33
FFQ4 D32-07-M16-06	32.00	23.20	0.70	4.4	7	30.00	55.00	29.40	M16	1.4	55.20	63.00	25.1	FFQ4 SOMT 060210T	1	0.16 0.9	40
FFQ4 D35-08-M16-06	35.00	26.20	0.70	4.4	8	35.00	60.00	29.00	M16	1.4	61.20	69.00	25.1	FFQ4 SOMT 060210T	1	0.20 0.9	40

- To generate a straight surface without cusps, the width of cut must not exceed DC
- Radius for programming: for insert SOMT 1.7 mm, for insert SOMW 1.9 mm
- When mounting insert SOMW, APMX=0.6 mm
- For slot milling or machining with high tool overhang, the maximum depth of cut should be reduced by 50%

⁽¹⁾ Cutting diameter maximum

⁽²⁾ Maximum plunging width

⁽³⁾ Number of inserts (or edges for solid tool)

⁽⁴⁾ Maximum ramping angle

⁽⁵⁾ Torque key size

⁽⁶⁾ Master insert identification

⁽⁷⁾ 0 - Without coolant supply, 1 - With coolant supply

⁽⁸⁾ Tool tightening torque Nxm (lbf·in)

Spare Parts

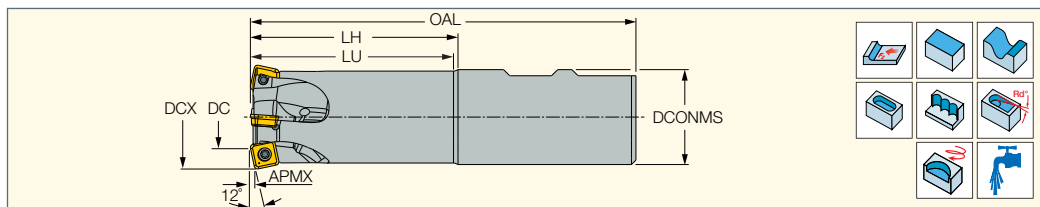
Designation		
FFQ4 D-M-06	SR 10516050-L4.6	IP-7/51 ^(a)

^(a) For limiting torque, use optional 7007378 BLD 4 IP07-0.9NM blade & 7007318 HSD 4-0.9NM handle.

MILL4FEED

FFQ4 D-C/W-06

Fast Feed Endmills Carrying
Single-Sided Square Inserts
with 4 Cutting Edges



Designation	DCX ⁽¹⁾	DC	APMX	AE ⁽²⁾	CICT ⁽³⁾	LU	LH	DCONMS	OAL	Shank	RMPX ⁽⁴⁾	MDN	MDX	MIID ⁽⁵⁾	CSP ⁽⁶⁾	kg	TQ
FFQ4 D16-03-C16-06	16.00	7.20	0.70	4.4	3	24.50	26.0	16.00	90.00	C	6.0	23.20	31.00	FFQ4 SOMT 060210T	1	0.11	0.9
FFQ4 D20-04-C20-06	20.00	11.20	0.70	4.4	4	40.00	42.0	20.00	130.00	C	3.5	31.20	39.00	FFQ4 SOMT 060210T	1	0.27	0.9
FFQ4 D25-05-W25-06	25.00	16.20	0.70	4.4	5	50.00	52.0	25.00	110.00	W	2.2	41.20	49.00	FFQ4 SOMT 060210T	1	0.33	0.9
FFQ4 D32-07-W32-06	32.00	23.20	0.70	4.4	7	64.00	66.0	32.00	130.00	W	1.4	55.20	63.00	FFQ4 SOMT 060210T	1	0.68	0.9

- To generate a straight surface without cusps, the width of cut must not exceed DC
- When mounting insert SOMW, APMX=0.6 mm
- Radius for programming: for insert SOMT 1.7 mm, for insert SOMW 1.9 mm
- For slot milling or machining with high tool overhang, the maximum depth of cut should be reduced by 50%

⁽¹⁾ Cutting diameter maximum

⁽²⁾ Maximum plunging width

⁽³⁾ Number of inserts (or edges for solid tool)

⁽⁴⁾ Maximum ramping angle

⁽⁵⁾ Master insert identification

⁽⁶⁾ 0 - Without coolant supply, 1 - With coolant supply

Spare Parts

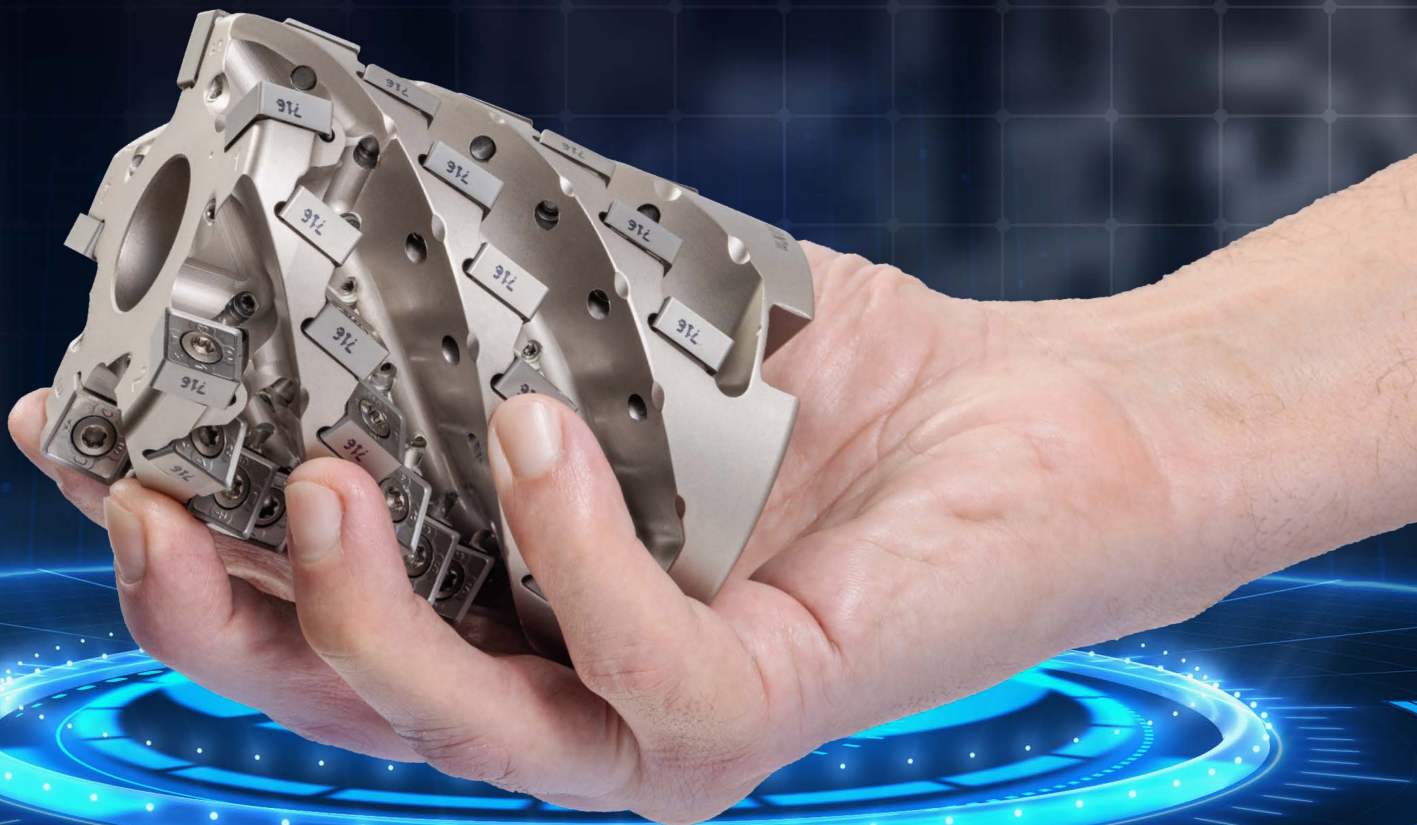
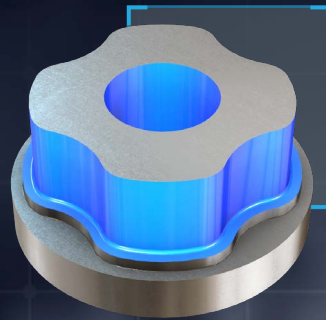
Designation		
FFQ4 D-C/W-06	SR 10516050-L4.6	IP-7/51 ^(a)

^(a) For limiting torque, use optional 7007378 BLD 4 IP07-0.9NM blade & 7007318 HSD 4-0.9NM handle.

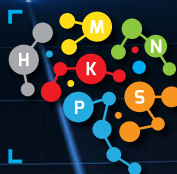
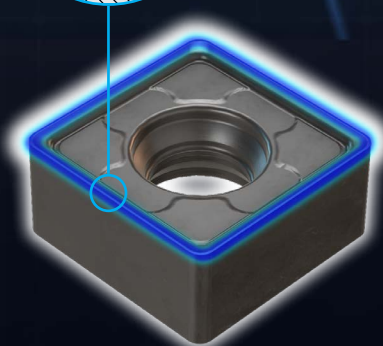
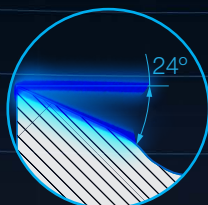


QUICKXFLUTE

Innovative Extended Flute
Cutters Optimized for Efficient
and Cost-effective Roughing at
High Material Removal Rates



Shellmill Diameter: 63 and 80mm.
Direct Coolant to Each Insert.



YOU Milling
Intelligently?

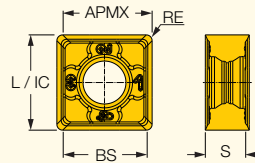
Economical Double-sided Square
13mm Inserts for High-Strength
Steel, Stainless Steel, and
Aerospace Materials.

SCAN ME



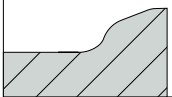
QUICKXFLUTE

S890 SNMU 1306
Double-Sided Square Inserts
with 4/8 Cutting Edges

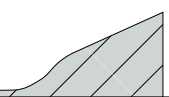


Designation	Dimensions						Tough ↔ Hard						Recommended Machining Data	
	IC	S	APMX	BS	RE	CEDC	IC882	IC716	IC840	IC830	IC5820	IC808	a_p (mm)	f_z (mm/t)
S890 SNMU 130608HP	13.00	5.50	12.20	11.40	0.80	8	●	●	●	●	●		1.00-12.20	0.07-0.20
S890 SNMU 130608PN	13.00	5.50	12.20	11.40	0.80	8				●		●	1.00-12.20	0.07-0.20
S890 SNMU 130632HP	13.00	5.50	12.20	9.00	3.20	4		●	●				3.40-12.20	0.07-0.20
S890 SNMU 130640HP	13.00	5.50	12.20	8.20	4.00	4		●	●				4.20-12.20	0.07-0.20

PN

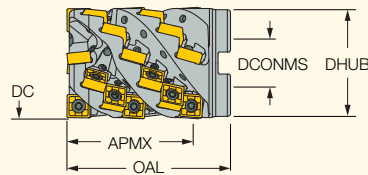


HP



QUICKXFLUTE

S890 SM
Extended Flute Cutters Carrying
Double-Sided Square Inserts
with 8 Cutting Edges



Designation	DC	APMX	NOF ⁽¹⁾	DCONMS	CICT ⁽²⁾	OAL	DHUB	Arbor	CSP ⁽³⁾	kg	MIID ⁽⁴⁾
S890 SM D63-71-4-27-13	63.00	71.00	4	27.00	28	92.00	60.00	A	1	1.50	S890 SNMU 130608
S890 SM D80-83-5-32-13	80.00	83.00	5	32.00	40	100.00	78.00	A	1	1.89	S890 SNMU 130608

• When using inserts with a corner radius of above 3.2mm, the pockets in the first row of the tool body should be modified to accommodate larger insert corners.

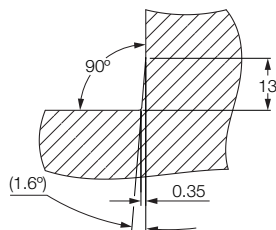
⁽¹⁾ Number of flutes

⁽²⁾ Number of inserts (or edges for solid tool)

⁽³⁾ 0 - Without coolant supply, 1 - With coolant supply

⁽⁴⁾ Master insert identification

The generated profile when milling a shoulder using
any kind of QUICK-X-FLUTE line cutters

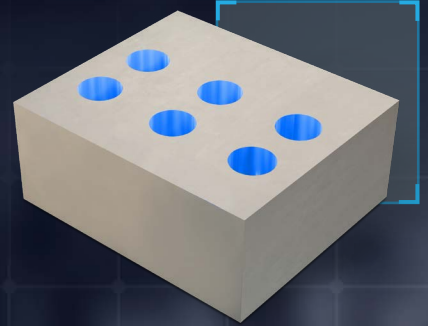


Spare Parts

Designation					
S890 SM D63-71-4-27-13	SR 10513105-L10.5	BLD IP20/S7-4MM	SW6-T-SH	SR M12X80DIN912	NOZZLE 1.2 569102604 L5.5
S890 SM D80-83-5-32-13	SR 10513105-L10.5	BLD IP20/S7-4MM	SW6-T-SH	SR M16X84DIN912	NOZZLE 1.2 569102604 L5.5

MULTI-MASTER

Modular MULTI-MASTER
Drill Head with 3 Effective
Cutting Edges



Smooth Cut with Less Vibrations
Due to the Solid Core.



YOU Drilling Intelligently?

The New Drilling Head Can be
Mounted on All MULTI-MASTER
Holders. Recommended
for Shallow Depths and
High Overhangs.



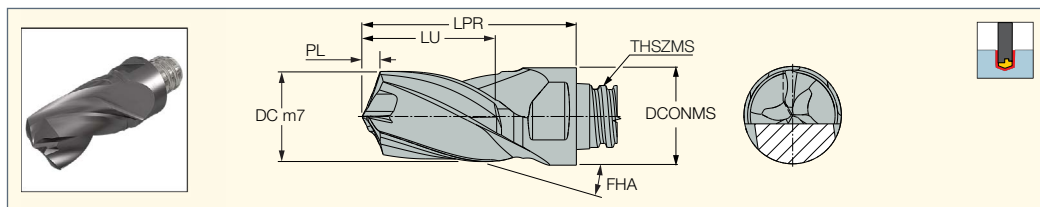
SCAN ME



MULTI-MASTER

MM SPD-3T

Three-Flute Exchangeable
Solid Carbide Drilling Heads



Designation	Dimensions								IC908
	DC	LU	LPR	PL	FHA	THSZMS	DCONMS	CSP ⁽¹⁾	
MM SPD080-08-3T06	8.00	12.10	22.00	1.590	15.0	T06	10.00	0	●
MM SPD085-09-3T06	8.50	12.20	22.00	1.680	15.0	T06	10.00	0	●
MM SPD090-09-3T06	9.00	12.30	22.00	1.780	15.0	T06	10.00	0	●
MM SPD0925-10-3T06	9.25	13.80	22.00	1.830	15.0	T06	10.00	0	●
MM SPD095-10-3T06	9.50	13.90	22.00	1.870	15.0	T06	10.00	0	●
MM SPD100-10-3T08	10.00	15.00	27.00	1.970	15.0	T08	12.00	0	●
MM SPD105-11-3T08	10.50	15.00	27.00	2.050	15.0	T08	12.00	0	●
MM SPD1075-11-3T08	10.75	15.10	27.00	2.120	15.0	T08	12.00	0	●
MM SPD110-11-3T08	11.00	15.10	27.00	2.160	15.0	T08	12.00	0	●
MM SPD1125-12-3T08	11.25	16.20	27.00	2.200	15.0	T08	12.00	0	●
MM SPD115-12-3T08	11.50	16.20	27.00	2.260	15.0	T08	12.00	0	●
MM SPD120-12-3T08	12.00	16.60	27.00	2.350	15.0	T08	12.70	0	●
MM SPD125-13-3T08	12.50	16.60	27.00	2.430	15.0	T08	12.70	0	●
MM SPD1275-13-3T10	12.75	20.00	33.50	2.500	15.0	T10	16.00	0	●
MM SPD130-13-3T10	13.00	20.00	33.50	2.540	15.0	T10	16.00	0	●
MM SPD140-14-3T10	14.00	19.70	33.50	2.730	15.0	T10	16.00	0	●
MM SPD145-15-3T10	14.50	20.80	33.50	2.810	15.0	T10	16.00	0	●
MM SPD150-15-3T10	15.00	20.40	33.50	2.930	15.0	T10	16.00	0	●
MM SPD1525-16-3T10	15.25	20.50	33.50	2.970	15.0	T10	16.00	0	●
MM SPD155-16-3T10	15.50	20.50	33.50	3.020	15.0	T10	16.00	0	●
MM SPD160-16-3T12	16.00	25.10	41.00	3.100	15.0	T12	18.43	0	●

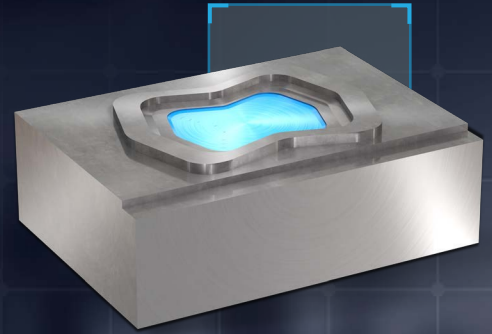
• Do not apply lubricant to the threaded connection

(1) 0 - Without coolant supply, 1 - With coolant supply

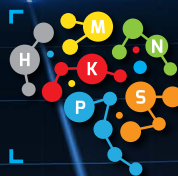
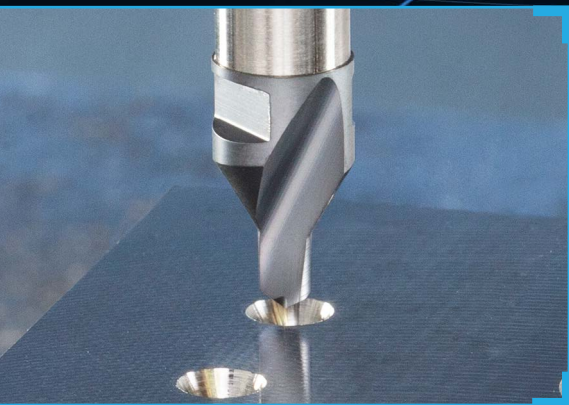


MULTI-MASTER

Double-Sided Steel Shanks
For Center Drilling and
General Endmill Applications



Double-Sided Shank Dia.:
6mm-20mm.



YOU Milling Intelligently?

.....
Double Ended Shank Concept with
a Variety of Diameters Assures
Lower Production Costs, Reduced
Stock. Two-In-One Concept for
Center Drilling and Milling.
.....



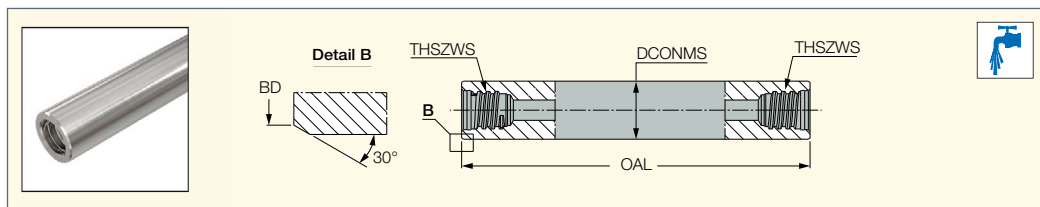
SCAN ME



MULTI-MASTER

MM TS2-A

Double-Sided Cylindrical Shanks
for Interchangeable Heads



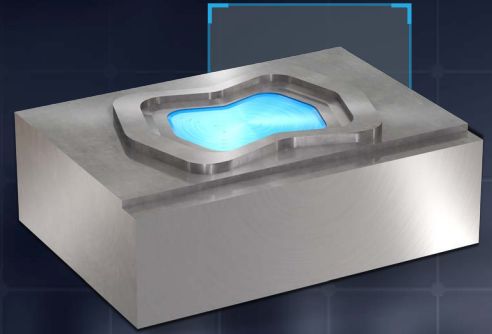
Designation	THSZWS	DCONMS	BD	OAL	Shank m.	CSP ⁽¹⁾	kg
MM TS2-A-L050-C06-T04-CH	T04	6.00	5.80	50.00	S	1	0.03
MM TS2-A-L050-C08-T05-CH	T05	8.00	7.60	50.00	S	1	0.02
MM TS2-A-L060-C10-T06-CH	T06	10.00	9.60	60.00	S	1	0.04
MM TS2-A-L070-C12-T08-CH	T08	12.00	11.60	70.00	S	1	0.06
MM TS2-A-L080-C16-T10-CH	T10	16.00	15.30	80.00	S	1	0.09
MM TS2-A-L090-C20-T12-CH	T12	20.00	18.30	90.00	S	1	0.18

- Do not apply lubricant to the threaded connection
- ⁽¹⁾ 0 - Without coolant supply, 1 - With coolant supply

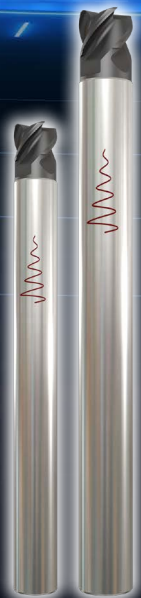
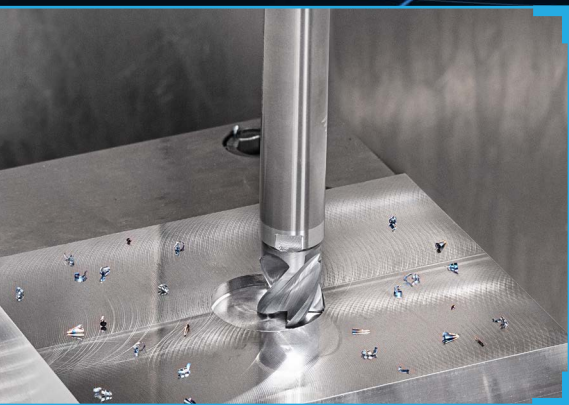


MULTI-MASTER

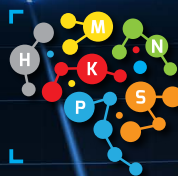
Anti-Vibration
WHISPER-LINE
Features an Internal
Shank Absorber



Tool Range Diameter:
20mm, 25mm.



Ø20 Ø25



YOU Milling Intelligently?

.....
Ultimate Solution for Machining
Deep Cavities with High Overhangs.
Damping Mechanism Suppresses
the Vibrations and Ensures Quiet
and Safe Machining.
.....

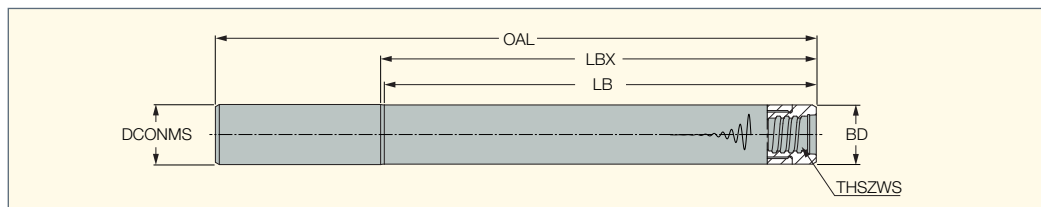
SCAN ME



MULTI-MASTER

MM S-A-AV

Anti-Vibration Cylindrical
Shanks Mount Interchangeable
Milling Heads



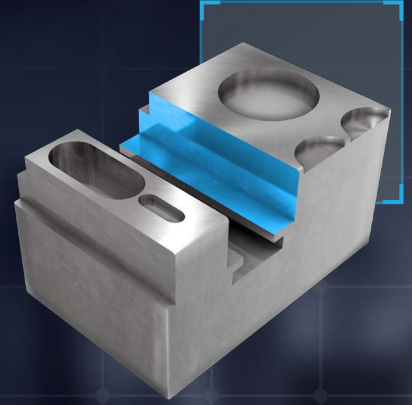
Designation	THSZWS	OAL	LBX	LB	DCONMS	BD	CSP ⁽¹⁾
MM S-A-L175/120-C20-T12AV	T12	175.00	120.00	118.80	20.00	19.70	0
MM S-A-L200/145-C20-T12AV	T12	200.00	145.00	143.80	20.00	19.70	0
MM S-A-L210/150-C25-T15AV	T15	210.00	150.00	148.60	25.00	24.60	0
MM S-A-L250/190-C25-T15AV	T15	250.00	190.00	188.60	25.00	24.60	0

- Do not apply lubricant to the threaded connection
- ⁽¹⁾ 0 - Without coolant supply, 1 - With coolant supply

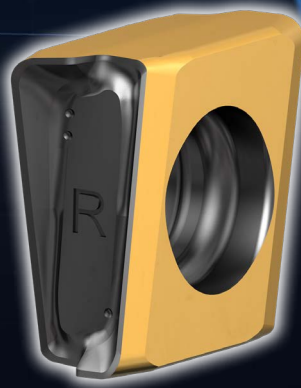


HELITANG

Milling Tools Carrying Small Tangentially Mounted Inserts with 4 Helical Cutting Edges for Effective Square-Shoulder Milling



Endmill Dia.: 10mm - 25mm.
SD Face Mill Dia.: 25mm - 50mm.



YOU Milling Intelligently?

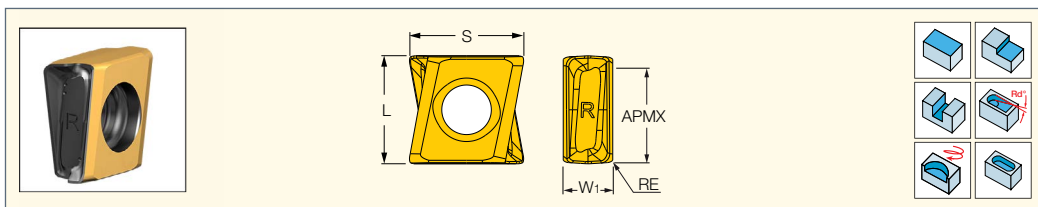
Insert with Positive Cutting Edges
Ensures Soft, Easy Cut with
Smooth Chip Flow. Unique Pocket
Design, Prevents Insert Pull-out.

SCAN ME



T490 LNMT 0502

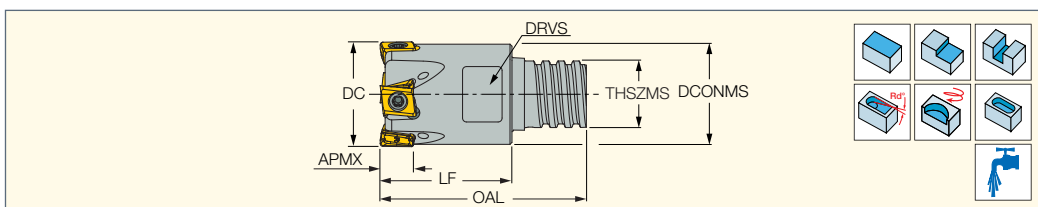
Tangentially Clamped Inserts
with 4 Helical Cutting Edges



Designation	Dimensions					Tough ↔ Hard				Recommended Machining Data
	W1	L	APMX	RE	S	IC830	IC808	IC810	IC5600	
T490 LNMT 0502PNR-RD	2.30	5.02	4.60	0.40	5.30	●	●	●	●	f _z (mm/t) 0.08-0.12

T490 ELN-MM-05

90° Endmills with
a MULTI-MASTER Threaded
Adaptation Carrying Tangentially
Clamped Inserts
with 4 Helical Cutting Edges



Designation	DC	CICT ⁽¹⁾	APMX	DCONMS	LF	OAL	THSZMS	DRVS ⁽²⁾	RMPX ^{o(3)}	CSP ⁽⁴⁾		MIID ⁽⁵⁾		
T490 ELN D10-2-MMT06-05	10.00	2	4.60	9.20	13.00	19.30	T06	8.0	1.3	1	0.01	T490 LNMT 0502PNR-RD	SR M2X0.4-3.8 IP6	T-6IP/51
T490 ELN D12-3-MMT08-05	12.00	3	4.60	11.00	14.50	22.00	T08	10.0	0.9	1	0.01	T490 LNMT 0502PNR-RD	SR M2X0.4-4.8 IP6	T-6IP/51
T490 ELN D16-4-MMT10-05	16.00	4	4.60	15.20	20.00	31.30	T10	13.0	0.6	1	0.03	T490 LNMT 0502PNR-RD	SR M2X0.4-4.8 IP6	T-6IP/51
T490 ELN D20-5-MMT12-05	20.00	5	4.60	19.20	22.00	35.30	T12	16.0	0.5	1	0.05	T490 LNMT 0502PNR-RD	SR M2X0.4-4.8 IP6	T-6IP/51

• Do not apply lubricant to the MULTI-MASTER threaded connection

(1) Number of inserts (or edges for solid tool)

(2) Torque key size

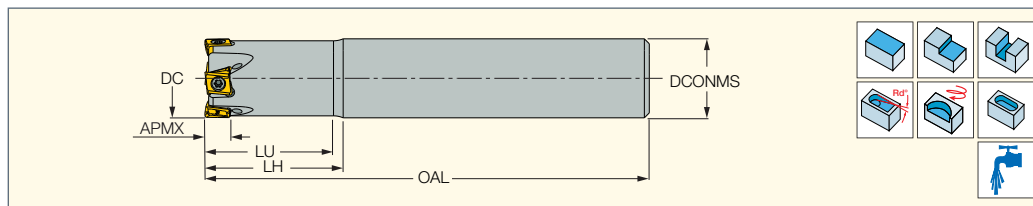
(3) Maximum ramping angle

(4) 0 - Without coolant supply, 1 - With coolant supply

(5) Master insert identification

T490 ELN-05

90° Endmills Carrying
Tangentially Clamped Inserts
with 4 Helical Cutting Edges



Designation	DC	CICT ⁽¹⁾	OAL	LH	LU	APMX	DCONMS	Shank	RMPX ⁽²⁾	CSP ⁽³⁾	MIID ⁽⁴⁾		
T490 ELN D10-2-C10-05	10.00	2	80.00	21.0	20.1	4.60	10.00	C	1.3	1	T490 LNMT 0502PNR-RD	SR M2X0.4-3.8 IP6	T-6IP/51
T490 ELN D12-3-C12-05	12.00	3	80.00	25.5	23.3	4.60	12.00	C	0.9	1	T490 LNMT 0502PNR-RD	SR M2X0.4-4.8 IP6	T-6IP/51
T490 ELN D16-4-C16-05	16.00	4	90.00	28.0	26.0	4.60	16.00	C	0.6	1	T490 LNMT 0502PNR-RD	SR M2X0.4-4.8 IP6	T-6IP/51
T490 ELN D20-5-C20-05	20.00	5	110.00	27.0	25.5	4.60	20.00	C	0.5	1	T490 LNMT 0502PNR-RD	SR M2X0.4-4.8 IP6	T-6IP/51
T490 ELN D25-6-C25-05	25.00	6	120.00	30.0	28.5	4.60	25.00	C	0.4	1	T490 LNMT 0502PNR-RD	SR M2X0.4-4.8 IP6	T-6IP/51

(1) Number of inserts (or edges for solid tool)

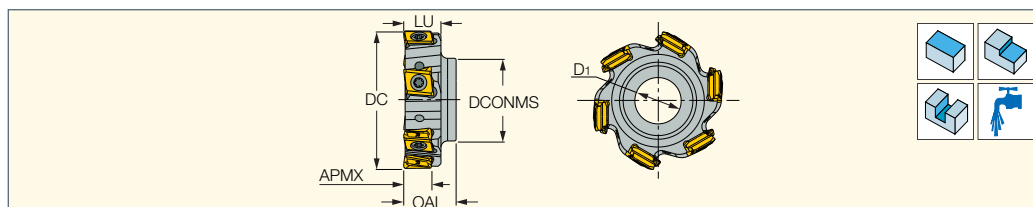
(2) Maximum ramping angle

(3) 0 - Without coolant supply, 1 - With coolant supply

(4) Master insert identification

T490 FM-05

90° Face Mills with a
SP Connection Carrying
Tangentially Clamped Inserts
with 4 Helical Cutting Edges



Designation	DC	CICT ⁽¹⁾	APMX	OAL	LU	DCONMS	D1	CSP ⁽²⁾	MIID ⁽³⁾
T490 FM D025-06-SP15-05	25.00	6	4.60	9.50	6.75	15.00	8.40	1	T490 LNMT 0502PNR-RD
T490 FM D032-08-SP17-05	32.00	8	4.60	10.50	6.75	17.00	9.80	1	T490 LNMT 0502PNR-RD
T490 FM D040-10-SP19-05	40.00	10	4.60	14.10	6.75	19.00	9.80	1	T490 LNMT 0502PNR-RD
T490 FM D050-12-SP19-05	50.00	12	4.60	14.10	6.75	19.00	9.80	1	T490 LNMT 0502PNR-RD

(1) Number of inserts (or edges for solid tool)

(2) 0 - Without coolant supply, 1 - With coolant supply

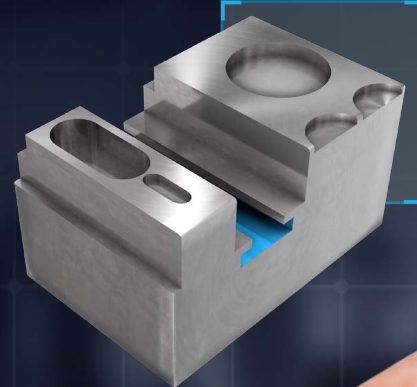
(3) Master insert identification

Spare Parts

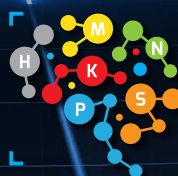
Designation		
T490 FM-05	SR M2X0.4-4.8 IP6	T-6IP/51

TANGDISC

Small Diameter Slotting
Cutters with Highly
Effective Tangentially
Mounted Inserts



Endmill Dia.: 16mm-32mm.
SD Dia.: 25mm-50mm.



YOU Milling Intelligently?

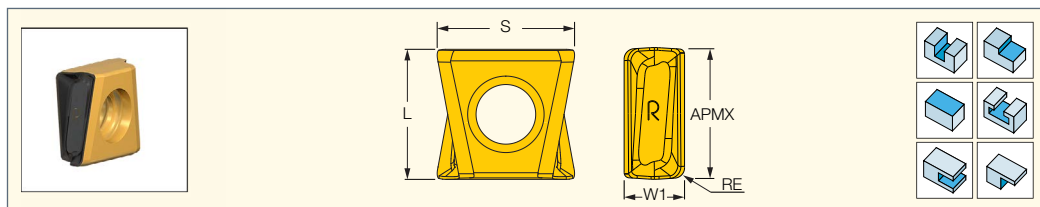
Precise Slotting with
Powerful Clamping Geometry,
Simplifies Head Change and
Minimizes Setup Time.

SCAN ME

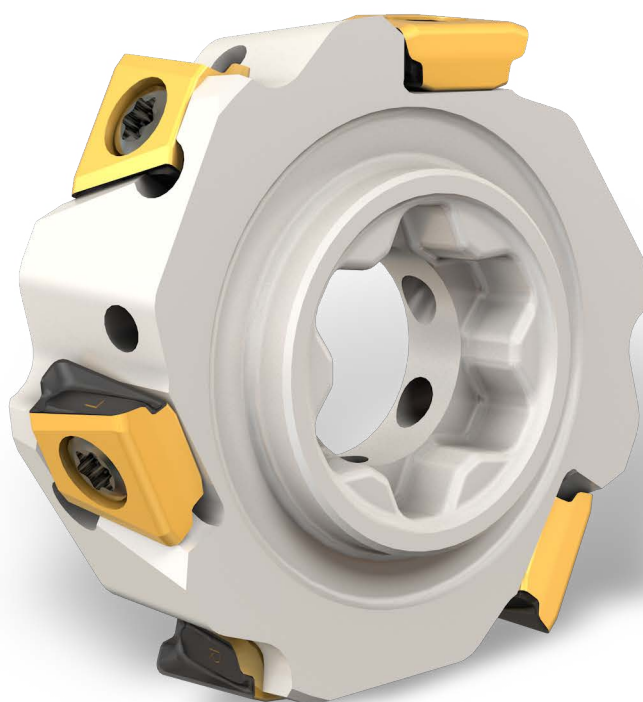


TANGDISC

T490 LNHT 05-PNTN
 HELI-TANG - Tangentially
 Clamped Inserts for Slotting
 and Precision Grooving



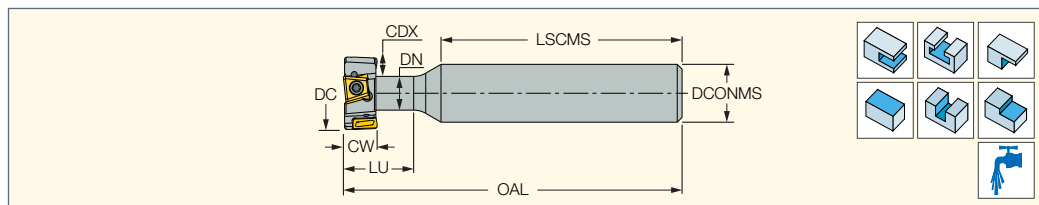
Designation	Dimensions					Tough ↔ Hard			Recommended Machining Data
	W1	L	APMX	RE	S	IC830	IC808	IC810	
T490 LNHT 0502-PNTN	2.30	5.00	4.60	0.40	5.30	●	●	●	f_z (mm/t) 0.06-0.12



TANGDISC

ETS-T490

T-SLOT Endmills Slotting Cutters
Carrying T490 0502 PNTN
Inserts with 2 Right- and 2
Left-Hand Cutting Edges



Designation	DC	NOF ⁽¹⁾	ZEFP	DN	LSCMS	CW	CDX	LU	OAL	DCONMS	Shank	CSP ⁽²⁾	MIID ⁽³⁾
ETS D016-07-C12-T490-05	15.70	4	2	8.00	50.00	7.00	3.50	11.50	65.00	12.00	C	1	T490 LNHT 0502-PNTN
ETS D020-07-C12-T490-05	19.70	4	2	10.00	50.00	7.00	4.50	12.80	65.00	12.00	C	1	T490 LNHT 0502-PNTN
ETS D025-07-C16-T490-05	24.70	6	3	14.00	60.00	7.00	5.00	13.20	75.00	16.00	C	1	T490 LNHT 0502-PNTN
ETS D032-07-C16-T490-05	31.70	8	4	15.70	60.00	7.00	7.80	19.00	80.00	16.00	C	1	T490 LNHT 0502-PNTN

⁽¹⁾ Number of flutes

⁽²⁾ 0 - Without coolant supply, 1 - With coolant supply

⁽³⁾ Master insert identification

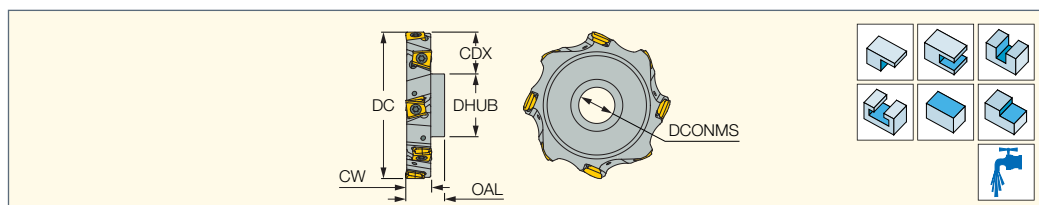
Spare Parts

Designation		
ETS-T490	SR M2X0.4-4.8 IP6	T-6IP/51

TANGDISC

SD-T490

Interchangeable T-SLOT with SP
Connection Carrying T490 0502
PNTN Inserts with 2 Right- and
2 Left-Hand Cutting Edges



Designation	DC	DHUB	CW	NOF ⁽¹⁾	ZEFP	CDX ⁽²⁾	DCONMS	OAL	CSP ⁽³⁾	MIID ⁽⁴⁾
SD D025-07-SP13-T490-05	24.70	13.00	7.00	6	3	5.75	7.50	8.25	1	T490 LNHT 0502-PNTN
SD D032-07-SP15-T490-05	31.70	15.00	7.00	8	4	8.25	8.40	9.50	1	T490 LNHT 0502-PNTN
SD D040-07-SP17-T490-05	39.70	17.00	7.00	10	5	11.25	9.80	10.50	1	T490 LNHT 0502-PNTN
SD D050-07-SP19-T490-05	49.70	19.00	7.00	12	6	15.25	9.80	14.10	1	T490 LNHT 0502-PNTN

⁽¹⁾ Number of flutes

⁽²⁾ Alpha numeric parameter

⁽³⁾ 0 - Without coolant supply, 1 - With coolant supply

⁽⁴⁾ Master insert identification

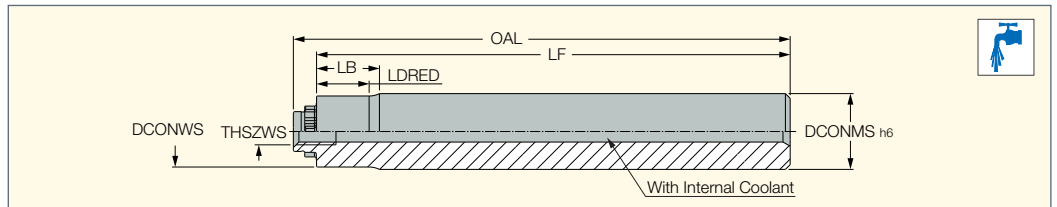
Spare Parts

Designation		
SD-T490	SR M2X0.4-4.8 IP6	T-6IP/51

TANGDISC

SD S-A-C-SP

Stepped Cylindrical
Shanks for Interchangeable
Milling Cutter Heads



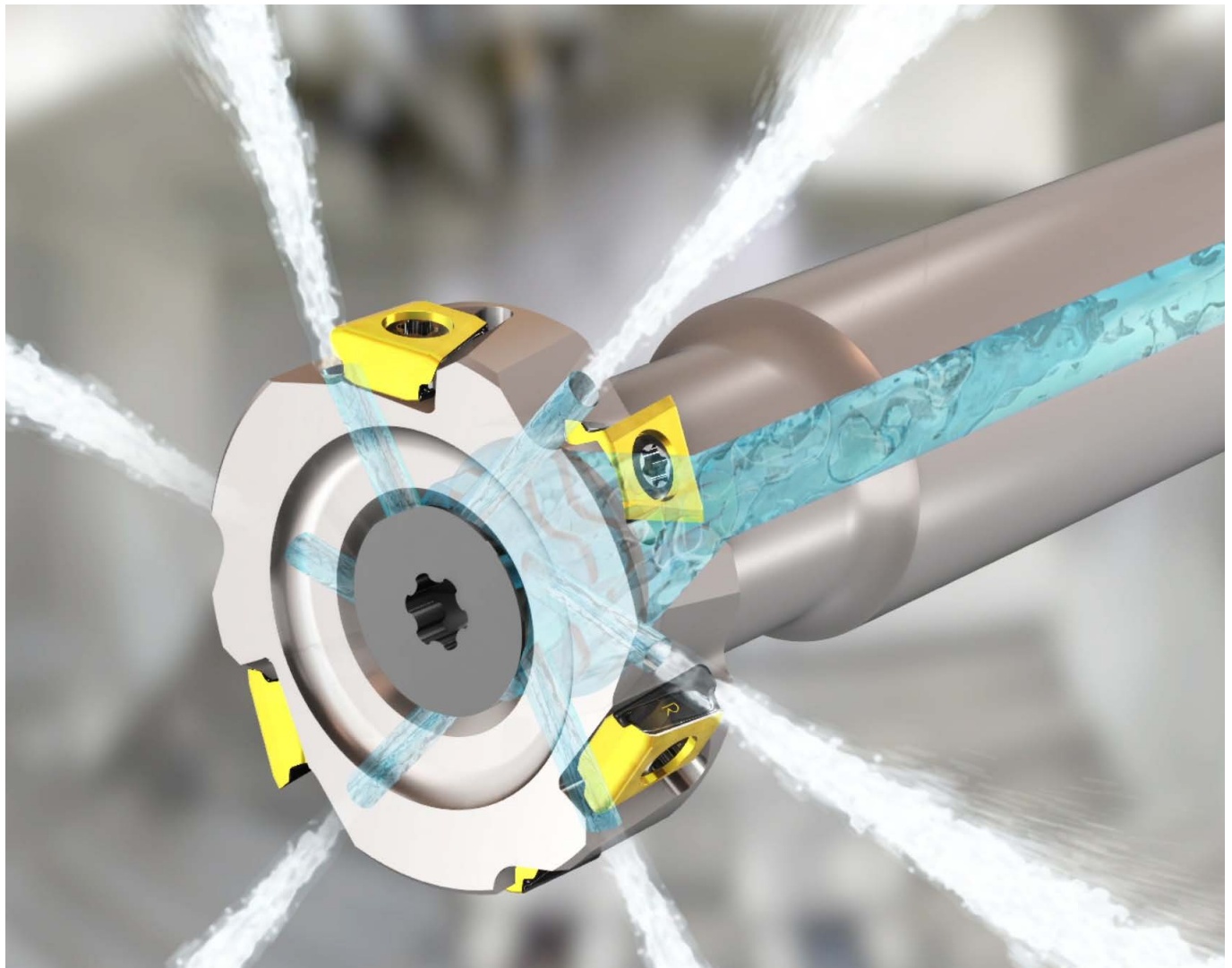
Designation	DCONMS	DCONWS	THSZWS	LDRED	LB	LF	OAL	Shank m.	CSP ⁽¹⁾
SD S-A-L090-C16-CH-SP13	16.00	13.00	M4x0.5	13.00	16.6	90.00	94.00	S	1
SD S-A-L090-C16-CH-SP15	16.00	15.00	M5x0.5	16.00	18.2	90.00	94.00	S	1
SD S-A-L130-C20-CH-SP17	20.00	17.00	M6x0.5	20.20	23.8	130.00	136.00	S	1
SD S-A-L150-C25-CH-SP19	25.00	19.00	M6x0.5	20.00	27.9	150.00	158.00	S	1

• Apply lubricant to the clamping screw

⁽¹⁾ 0 - Without coolant supply, 1 - With coolant supply

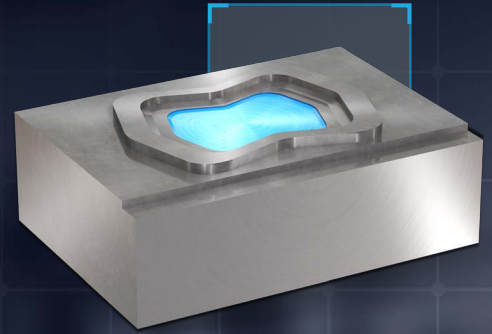
Spare Parts

Designation			
SD S-A-L090-C16-CH-SP13	SR M4X0.5-SP13-IP15-HG	BLD IP15/S7	SW6-T-SH
SD S-A-L090-C16-CH-SP15	SR M5X0.5-SP15-IP20-HG	BLD IP20/S7	SW6-T-SH
SD S-A-L130-C20-CH-SP17	SR M6X0.5-SP1719-IP25-HG	BLD IP25/S7	SW6-T
SD S-A-L150-C25-CH-SP19	SR M6X0.5-SP1719-IP25-HG	BLD IP25/S7	SW6-T



CERMILL

Innovative Endmill
Cutters with a Smart
Locking Mechanism for
Round Ceramic Inserts

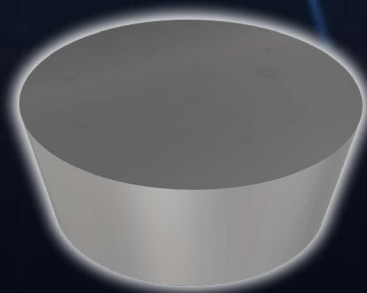


Diameter Range: 16mm - 40mm.



YOU Milling Intelligently?

Side Locking Mechanism for
Maximum Tightening and High
Machining Stability Intended
for High Temperature Alloys.

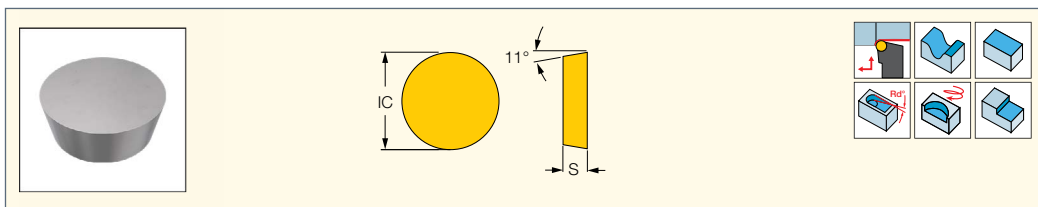


SCAN ME



RPGN (CER)

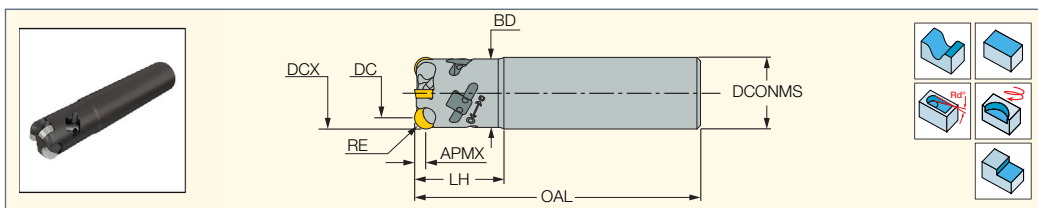
Positive Round Ceramic Inserts for Machining Cast Iron and Heat-Resistant Alloys



Designation	Dimensions		Tough ↔ Hard			Recommended Machining Data	
	IC	S	IS14	IS15	IS45	a_p (mm)	f_z (mm/rev)
RPGN 060200 E004	6.35	2.38	●	●	●	0.50-1.50	0.08-0.15
RPGN 060200 T00520	6.35	2.38	●	●	●	0.50-1.50	0.01-0.15
RPGN 060200 T01020	6.35	2.38	●	●	●	0.50-1.50	0.08-0.15

CERMILL
ERP

Endmills Carrying Single-Sided Ceramic Round Inserts



Designation	DCX ⁽¹⁾	DC	RE	APMX	CIC ⁽²⁾	LH	OAL	BD	DCONMS	RMPX ⁽³⁾	Shank ⁽⁴⁾	CSP ⁽⁵⁾	MIID ⁽⁶⁾
ERP D010A016-03-C16-06	16.00	9.65	3.18	1.50	3	25.0	80.00	15.00	16.00	2.5	C	0	RPGN 06
ERP D014A020-04-C20-06	20.00	13.65	3.18	1.50	4	30.0	80.00	19.00	20.00	4.0	C	0	RPGN 06
ERP D019A025-05-C25-06	25.00	18.65	3.18	1.50	5	40.0	100.00	24.00	25.00	3.5	C	0	RPGN 06
ERP D026A032-06-C32-06	32.00	25.64	3.18	1.50	6	50.0	120.00	31.00	32.00	2.0	C	0	RPGN 06
ERP D034A040-07-C32-06	40.00	33.64	3.18	1.50	7	50.0	120.00	39.00	32.00	1.5	C	0	RPGN 06

• When milling deep pockets in high temperature alloys by use of helical interpolation, it is recommended to set the stepdown up to 1 mm for efficient chip evacuation.

⁽¹⁾ Cutting diameter maximum

⁽²⁾ Number of inserts (or edges for solid tool)

⁽³⁾ Maximum ramping angle

⁽⁴⁾ C-Cylindrical

⁽⁵⁾ 0 - Without coolant supply, 1 - With coolant supply

⁽⁶⁾ Master insert identification

Spare Parts

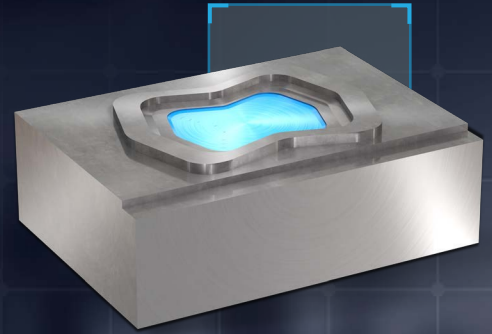
Designation					
ERP	CL-D4-L9-M3X0.5	NUT-D4.5-L6-M3X0.5	CW 1.7-L20	ERP BIT D4-30°	T.WRENCH TBN 0.7NM*

* Optional, to be ordered separately



CERMILL

Indexable Ceramic Inserts for High Feed Machining



Endmill Dia.: 25mm - 40mm.
Face Mill Dia.: 50mm - 80mm.

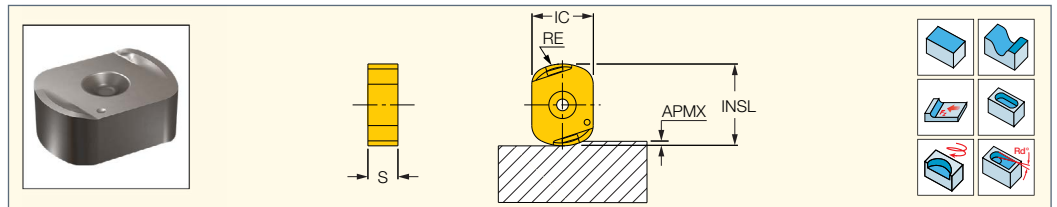


YOU Milling Intelligently?

.....
Double-Sided Ceramic Inserts with Six and Four Indexable Cutting Edges. The Top and Bottom Surfaces of the Inserts Feature a Specially Designed Chipformer Geometry to Enhance Cutting Performance and Improve Chip Evacuation.
.....

SCAN ME





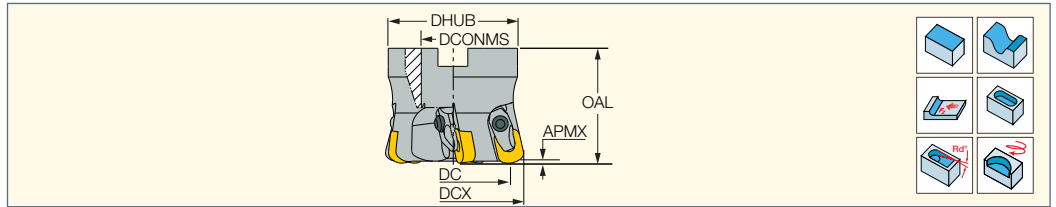
Designation	Dimensions						Recommended Machining Data	
	INSL	IC	S	APMX	RE	IS35	a_p (mm)	f (mm/t)
EFN WDNX 0904-E04	12.00	9.00	5.00	1.50	7.00	●	0.50-1.00	0.15-0.35

- To generate a straight surface without cusps, the width of cut must not exceed DC



EFN FD-09

Fast Feed Face Mills Carrying
Double-Sided Inserts
with 4 Cutting Edges



Designation	DC	DCX ⁽¹⁾	APMX	CICT ⁽²⁾	OAL	RMPX ⁽³⁾	DHUB	DCONMS	Rg ⁽⁴⁾	Arbor	CSP ⁽⁵⁾	kg	MIID ⁽⁶⁾
EFN FD50-5-22-09X	39.40	50.00	1.50	5	40.00	0.5	45.00	22.00	3.40	A	0	0.43	EFN WDNX 0904-E04

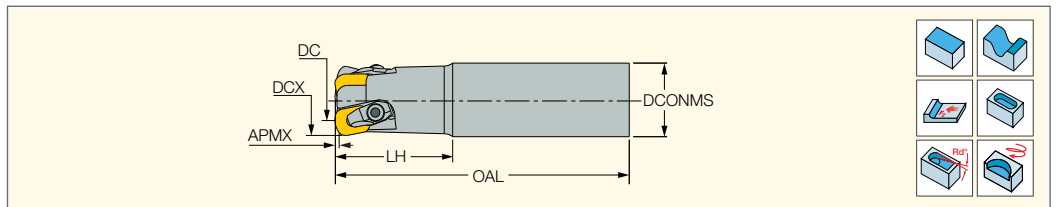
- To generate a straight surface without cusps, the width of cut must not exceed DC
- ⁽¹⁾ Cutting diameter maximum
- ⁽²⁾ Number of inserts (or edges for solid tool)
- ⁽³⁾ Maximum ramping angle
- ⁽⁴⁾ Radius for programming
- ⁽⁵⁾ 0 - Without coolant supply, 1 - With coolant supply (use only air-coolant is prohibited)
- ⁽⁶⁾ Master insert identification

Spare Parts

Designation					
EFN FD-09	SR M10X1.5X30 DIN912	HW 2.0	CCL-3S	CLS-35A120/HG CLAMP SCREW	CSR 1.25

EFN ED-09

Fast Feed Endmills Carrying
Double-Sided Inserts
with 4 Cutting Edges



Designation	DC	DCX ⁽¹⁾	APMX	CICT ⁽²⁾	OAL	RMPX ⁽³⁾	DCONMS	Rg ⁽⁴⁾	kg	MIID ⁽⁵⁾
EFN ED25-3-100-C25-09X	14.80	25.00	1.50	3	100.00	1.2	25.00	3.40	0.34	EFN WDNX 0904-E04
EFN ED32-3-120-C25-09X	21.50	32.00	1.50	3	120.00	0.6	32.00	3.40	0.67	EFN WDNX 0904-E04
EFN ED40-4-120-C32-09X	29.40	40.00	1.50	4	120.00	0.6	32.00	3.40	0.74	EFN WDNX 0904-E04

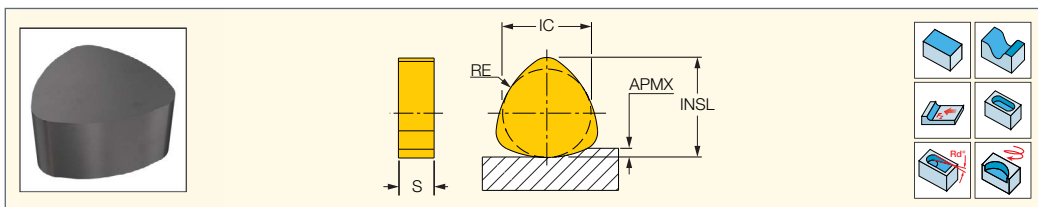
- To generate a straight surface without cusps, the width of cut must not exceed DC
- ⁽¹⁾ Cutting diameter maximum
- ⁽²⁾ Number of inserts (or edges for solid tool)
- ⁽³⁾ Maximum ramping angle
- ⁽⁴⁾ Radius for programming
- ⁽⁵⁾ Master insert identification

Spare Parts

Designation				
EFN ED-09	CCL-3S	CLS-35A120/HG CLAMP SCREW	HW 2.0	CSR 1.25

FFN WNGF

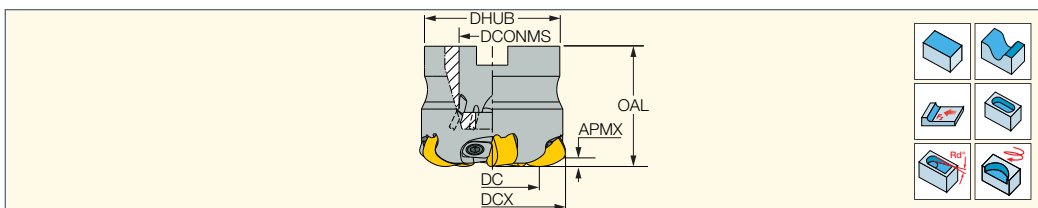
Double-Sided Ceramic
Inserts with 6 Cutting Edges
for Fast Feed Machining



Designation	Dimensions						Recommended Machining Data	
	INSL	IC	S	APMX	RE	IS35	a_p (mm)	f (mm/t)
FFN WNGF 1207-E04	13.57	12.00	7.00	2.50	13.00	●	1.00-2.00	0.15-0.35

FFN FD-12

Fast Feed Face Mills Carrying
Double-Sided Inserts
with 6 Cutting Edges



Designation	DC	DCX ⁽¹⁾	APMX	CICT ⁽²⁾	OAL	RMPX ⁽³⁾	DHUB	DCONMS	Rg ⁽⁴⁾	Arbor	CSP ⁽⁵⁾	kg	MIID ⁽⁶⁾
FFN FD050-5-22-12F	32.80	50.00	2.50	5	40.00	0.6	45.00	22.00	4.50	A	1	0.46	FFN WNGF 1207-E04
FFN FD063-6-22-12F	45.70	63.00	2.50	6	40.00	0.5	47.00	22.00	4.50	A	1	0.62	FFN WNGF 1207-E04
FFN FD080-8-27-12F	62.60	80.00	2.50	8	50.00	0.4	70.00	27.00	4.50	A	1	1.35	FFN WNGF 1207-E04

- To generate a straight surface without cusps, the width of cut must not exceed DC

⁽¹⁾ Cutting diameter maximum

⁽²⁾ Number of inserts (or edges for solid tool)

⁽³⁾ Maximum ramping angle

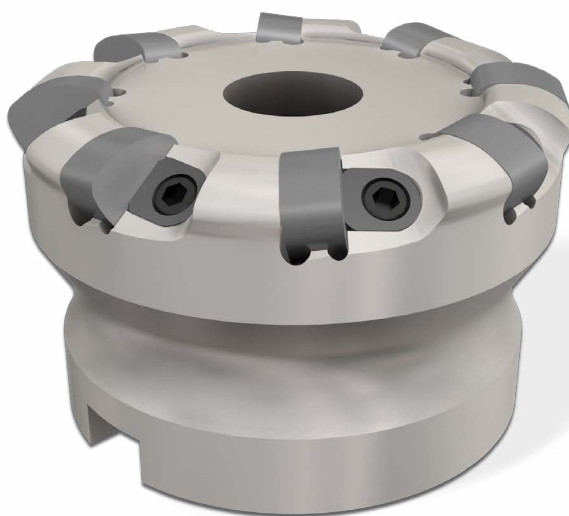
⁽⁴⁾ Radius for programming

⁽⁵⁾ 0 - Without coolant supply, 1 - With coolant supply (use only air-coolant is prohibited)

⁽⁶⁾ Master insert identification

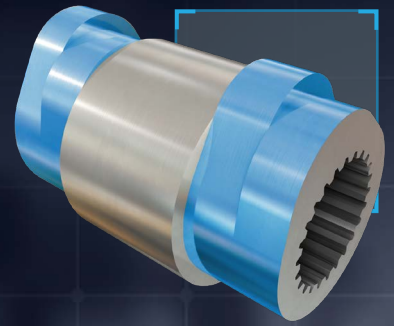
Spare Parts

Designation				
FFN FD050-5-22-12F	SR M10X1.5X30 DIN912	WEDGE SCREW	LW 1207C	T-W3
FFN FD063-6-22-12F	SR M10X1.5X30 DIN912	WEDGE SCREW	LW 1207C	T-W3
FFN FD080-8-27-12F	SR M12X1.75X35 DIN912	WEDGE SCREW	LW 1207C	T-W3

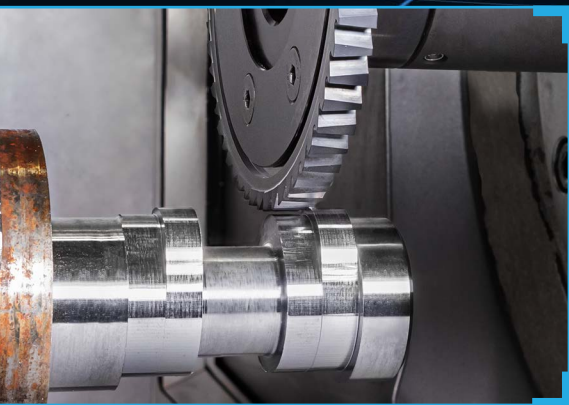


DISC MILL

High-Precision Carbide Ring
for Machining Mass Production
Automotive Parts



Diameter Range: 125mm.
Width of Cut: 8.85mm.

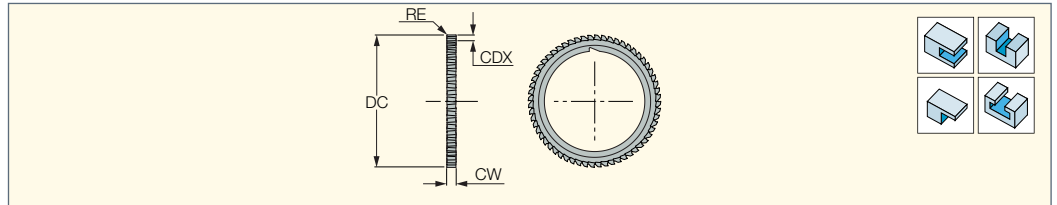


YOU Milling Intelligently?

.....
A Carbide Ring with a High Number
of Teeth for Increased Productivity
& Stability. High Clamping Rigidity
Guarantees Stable Machining.
The Same Ring Can Be Clamped
on the Same Tool Body for Right
or Left Hand Machining.
.....

SCAN ME

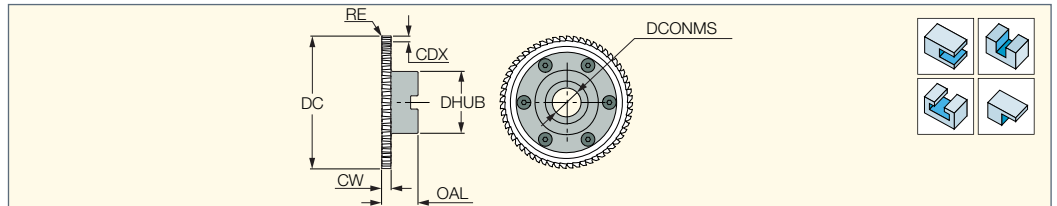




Designation	DC	CDX	CW	RE	CICT ⁽¹⁾	CSP ⁽²⁾	ZEFP
SD D125-8.85-R0.3-C100-P	125.00	5.50	8.85	0.30	60	0	60

⁽¹⁾ Number of inserts (or edges for solid tool)

⁽²⁾ 0 - Without coolant supply, 1 - With coolant supply



Designation	DC	CW	CDX	OAL	DHUB	DCONMS	Arbor	CSP ⁽¹⁾	kg
MP F-D125-27-C100	125.00	8.85	5.50	33.85	58.00	27.00	B	0	0.87

⁽¹⁾ 0 - Without coolant supply, 1 - With coolant supply

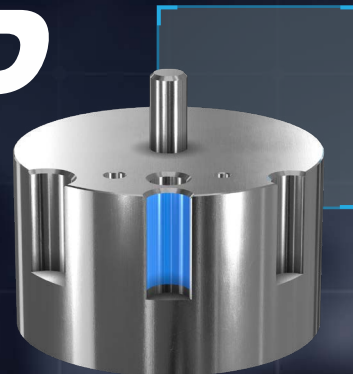
Spare Parts

Designation			
MP F	CAP D125-C100	SR M3X5.5	HW 4.0

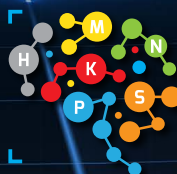
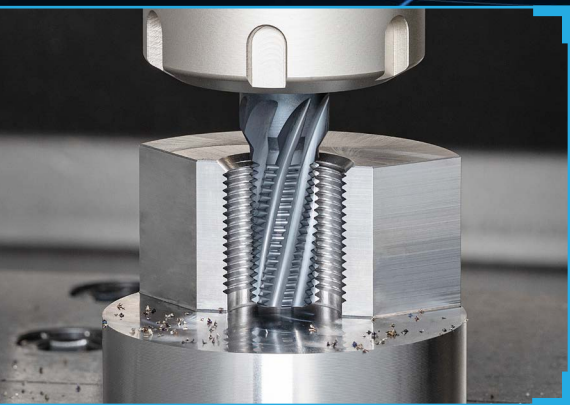


SOLID^M THREAD

High Performance
Solid Carbide Thread-Mills
The New Alternative
to Tapping Tools



Dia. Range: 4.8mm-16.0mm.



YOU Milling
Intelligently?

.....
Threading Large Diameters, Short
Chips for Easy Machining of Thin
Walls. Coolant-Through the Tool,
Ideal for Blind-Hole Applications
and Improved Chip Evacuation.
.....

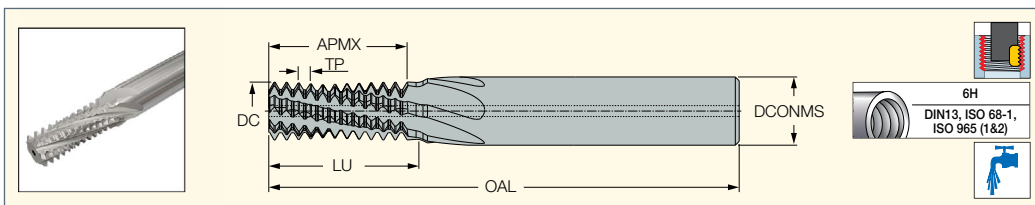
SCAN ME



SOLIDMTHREAD

MTECBF-ISO

Solid Carbide Internal Threading Endmills with a Coolant Hole.
Intended for ISO Thread Profiles



Designation	Dimensions									IC908		
	TP ⁽¹⁾	M Coarse	M Fine	DCONMS	DC	NOF ⁽²⁾	APMX	OAL	Shank			
	MTECBF06048F10 1.0ISO	1.000	M6	=>7	6.00	4.80	6	10.20	57.00		C	●
	MTECBF08064G14 1.25ISO	1.250	M8	=>10	8.00	6.40	7	14.00	63.00		C	●
	MTECBF 1008G16 1.5ISO	1.500	M10	=>12	10.00	8.00	7	16.70	72.00		C	●
	MTECBF12095G20 1.75ISO	1.750	M12	=>12	12.00	9.50	7	20.00	84.00		C	●

• Internal & External tolerance: ISO 228-1 - Medium class

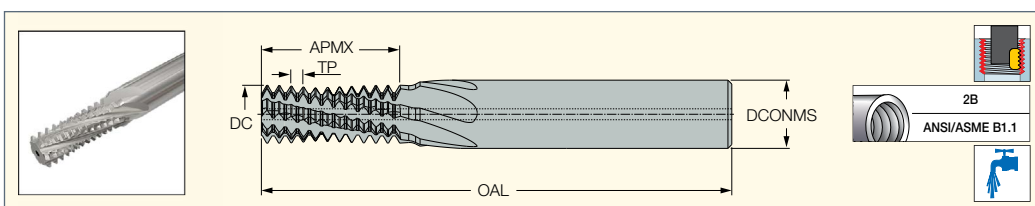
⁽¹⁾ Thread pitch

⁽²⁾ Number of flutes

SOLIDMTHREAD

MTECBF-UN

Solid Carbide Internal Threading Endmills with a Coolant Hole.
Intended for UN Thread Profile



Designation	Dimensions										IC908
	TPI ⁽¹⁾	UNC	UNF	UNEF	DCONMS	DC	NOF ⁽²⁾	APMX	OAL	Shank	
MTECBF 08066G14 24UN	24.0		5/16"		8.00	6.60	7	14.20	64.00	C	●
MTECBF 10066G14 24UN	24.0		5/16"		10.00	6.60	7	14.20	73.00	C	●
MTECBF 06048E12 20UN	20.0	1/4"			6.00	4.80	5	12.00	58.00	C	●
MTECBF 10092H21 20UN	20.0		7/16"		10.00	9.20	8	20.90	73.00	C	●
MTECBF 12092H21 20UN	20.0		7/16"		12.00	9.20	8	20.90	84.00	C	●
MTECBF 0806F14 18UN	18.0	5/16"			8.00	6.00	6	14.70	64.00	C	●
MTECBF 16125H26 18UN	18.0		9/16, 5/8"	11/16"	16.00	12.50	8	26.00	105.00	C	●
MTECBF 10074F16 16UN	16.0	3/8"			10.00	7.40	6	16.60	73.00	C	●
MTECBF 10085F20 14UN	14.0	7/16"			10.00	8.50	6	20.80	73.00	C	●
MTECBF 12098F24 13UN	13.0	1/2"			12.00	9.80	6	24.30	84.00	C	●
MTECBF 16116F26 12UN	12.0	5/8"	1/1-1/2"		16.00	11.60	6	26.40	105.00	C	●

• Internal & External tolerance: ISO 228-1 - Medium class

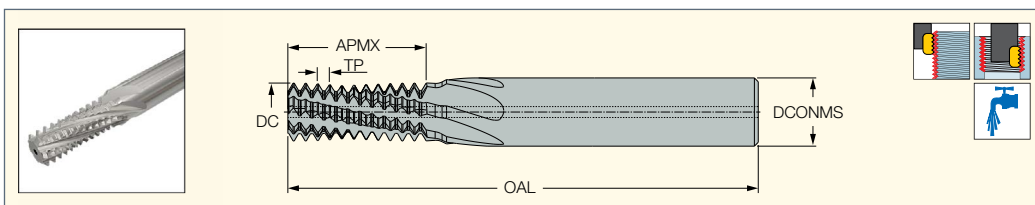
⁽¹⁾ Threads per inch

⁽²⁾ Number of flutes

SOLIDMTHREAD

MTECBF-W

Solid Carbide Internal or External Threading Endmills with a Coolant Hole. Intended for BSF/BSP Thread Profiles



Designation	Dimensions								IC908
	TPI ⁽¹⁾	TDZ	DCONMS	DC	NOF ⁽²⁾	APMX	OAL	Shank	
MTECBF 08078H14 28W	28.0	1/8"	8.00	7.80	8	14.00	64.00	C	●
MTECBF 1010G16 19W	19.0	1/4-3/8"	10.00	10.00	7	16.00	73.00	C	●
MTECBF 1614H26 14W	14.0	1/2-7/8"	16.00	14.00	8	26.20	105.00	C	●
MTECBF 1616H38 11W	11.0	7/18"	16.00	16.00	8	37.90	105.00	C	●

• Internal & External tolerance: B.S.84 - Medium class

⁽¹⁾ Threads per inch

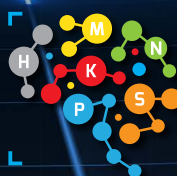
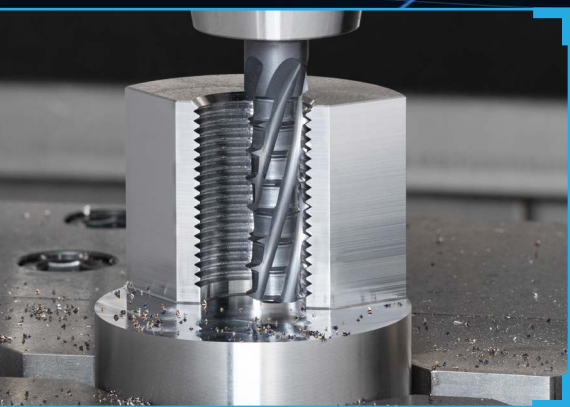
⁽²⁾ Number of flutes

SOLID^MTHREAD

High Performance
Solid Carbide Thread-Mills



Dia. Range: 3.1mm- 13.1mm.



YOU Milling
Intelligently?

.....
Threading Large, Short Chips
for Easy Machining Thin Walls.
Coolant-Through the Tool Ideal
for Blind-Hole Applications and
Improved Chip Evacuation.
.....

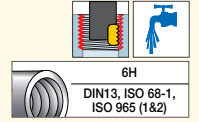
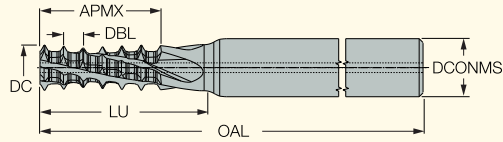
SCAN ME



SOLIDMTHREAD

MTECK-ISO

Solid Carbide Internal Threading
Endmill Step Release, Lead
x2 With Coolant Hole, Used
for ISO Thread Profile



Designation	Dimensions										IC908
	TP ⁽¹⁾	M Coarse	M Fine	DBL	APMX	OAL	NOF ⁽²⁾	DCONMS	DC	Shank	
MTECK 06032D8 0.5ISO	0.500	-	M4	1.00	8.20	58.00	4	6.00	3.20	C	●
MTECK 06031C9 0.7ISO	0.700	M4	-	1.40	8.70	58.00	3	6.00	3.10	C	●
MTECK 06039C10 0.8ISO	0.800	M5	-	1.60	10.80	58.00	3	6.00	3.90	C	●
MTECK 06047D12 1.0ISO	1.000	M6	-	2.00	12.50	58.00	4	6.00	4.70	C	●
MTECK 08063D16 1.25ISO	1.250	M8	-	2.50	16.90	64.00	4	8.00	6.30	C	●
MTECK 08079D21 1.5ISO	1.500	M10	-	3.00	21.70	64.00	4	8.00	7.90	C	●
MTECK 120117E28 1.5ISO	1.500	-	M16	3.00	29.30	94.00	5	12.00	11.70	C	●
MTECK 160125F33 1.5ISO	1.500	-	M16	3.00	33.70	93.00	6	16.00	12.50	C	●
MTECK10098E24 1.5ISO	1.500	-	M13	3.00	24.80	73.00	5	10.00	9.80	C	●
MTECK 10096D24 1.75ISO	1.750	M12	-	3.50	25.30	73.00	4	10.00	9.60	C	●
MTECK 12112D28 2.0ISO	2.000	M16	-	4.00	28.90	84.00	4	12.00	11.20	C	●
MTECK 16131E32 2.0ISO	2.000	M16	-	4.00	32.90	93.00	5	16.00	13.10	C	●

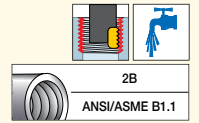
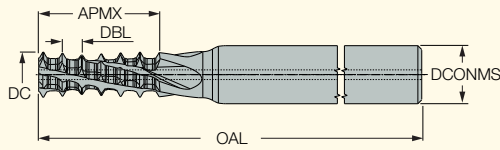
⁽¹⁾ Thread pitch

⁽²⁾ Number of flutes

SOLIDMTHREAD

MTECK-UN

Solid Carbide Internal Threading
Endmill Step Release, Lead
x2 With Coolant Hole, Used
for UN Thread Profiles



Designation	Dimensions										IC908
	TPI ⁽¹⁾	UNC	UNF	DBL	APMX	OAL	DCONMS	DC	Shank	NOF ⁽²⁾	
MTECK 0250C34 32UN	32.0	8		1.59	9.10	63.50	6.35	3.10	C	3	●
MTECK 0250D50 28UN	28.0		1/4"	1.81	13.10	63.50	6.35	5.00	C	4	●
MTECK 06035C10 24UN	24.0	10		2.12	11.00	58.00	6.00	3.50	C	3	●
MTECK 0250C50 20UN	20.0	1/4"		2.54	13.30	63.50	6.35	4.70	C	3	●
MTECK 0250D67 18UN	18.0	5/16"		2.82	17.60	63.50	6.35	6.10	C	4	●
MTECK 08061D17 18UN	18.0	5/16"		2.82	17.60	64.00	8.00	6.10	C	4	●
MTECK 08061D22 18UN	18.0	5/16"		2.82	23.20	76.00	8.00	6.10	C	4	●
MTECK 12011E29 18UN	18.0		9/16"	2.82	30.40	84.00	12.00	11.00	C	5	●
MTECK 08074D19 16UN	16.0	3/8"		3.17	19.80	64.00	8.00	7.40	C	4	●
MTECK 1298D25 13UN	13.0	1/2"		3.91	26.30	84.00	12.00	9.80	C	4	●

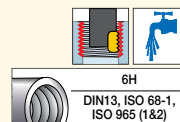
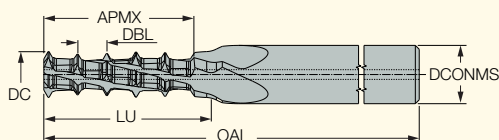
⁽¹⁾ Threads per inch

⁽²⁾ Number of flutes

SOLID^MTHREAD

MTECM-ISO

Solid Carbide Internal Threading
Endmill Step Release, Lead
x3 With Coolant Holes, Used
for ISO Thread Profile



Designation	Dimensions										IC908
	TP ⁽¹⁾	M Coarse	M Fine	DBL	APMX	OAL	NOF ⁽²⁾	DCONMS	DC	Shank	
MTECM 06031C11 0.7ISO	0.700	M4	-	2.10	10.80	58.00	3	6.00	3.10	C	●
MTECM 06039C12 0.8ISO	0.800	M5	-	2.40	13.20	58.00	3	6.00	3.90	C	●
MTECM 06047D14 1.0ISO	1.000	M6	-	3.00	15.40	58.00	4	6.00	4.70	C	●
MTECM 08079E21 1.0ISO	1.000	-	M10	3.00	21.40	64.00	5	8.00	7.90	C	●
MTECM 10096D32 1.75ISO	1.750	M12	-	5.25	32.30	81.00	4	10.00	9.60	C	●
MTECM 16131E42 2.0ISO	2.000	M16	-	6.00	42.90	105.00	5	16.00	13.10	C	●

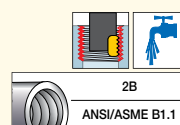
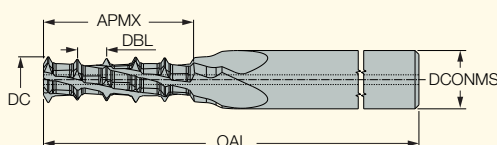
⁽¹⁾ Thread pitch

⁽²⁾ Number of flutes

SOLID^MTHREAD

MTECM-UN

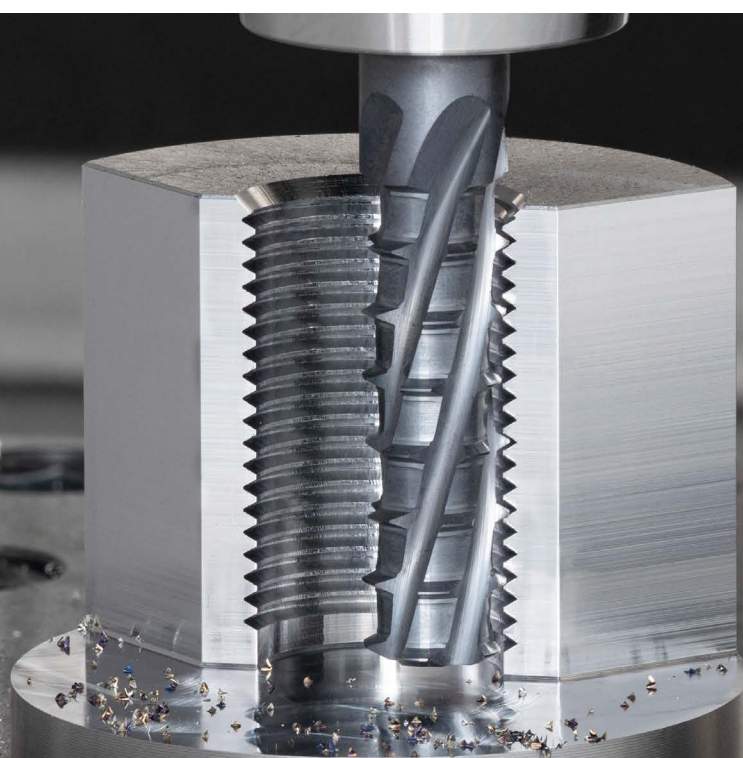
Solid Carbide Internal Threading
Endmill Step Release, Lead
x3 With Coolant Hole, Used
for UN Thread Profiles



Designation	Dimensions											IC908
	TPI ⁽¹⁾	UNC	UNF	UNEF	DBL	APMX	OAL	DCONMS	DC	Shank	NOF ⁽²⁾	
MTECM 0250C28 32UN	32.0	8	-	-	2.38	7.50	63.50	6.35	3.10	C	3	●
MTECM 0250C50 24UN	24.0	10	-	-	3.17	13.20	63.50	6.35	3.50	C	3	●
MTECM 06047C16 20UN	20.0	1/4"	-	-	3.81	17.10	58.00	6.00	4.70	C	3	●
MTECM 0250C65 20UN	20.0	1/4"	-	-	3.81	17.10	63.50	6.35	4.70	C	3	●
MTECM 0312D09 16UN	16.0	3/8"	-	-	4.76	24.50	63.50	7.94	7.40	C	4	●

⁽¹⁾ Threads per inch

⁽²⁾ Number of flutes



Cutting Conditions

Recommended initial cutting conditions are shown in the tables below.

Use the **ISCAR MILL-THREAD** Advisor, for correct process and cutting condition re-considerations (<https://www.iscar.com/mts/>).

See machining data for solid carbide threading endmills with small diameters and short solid carbide thread mills.

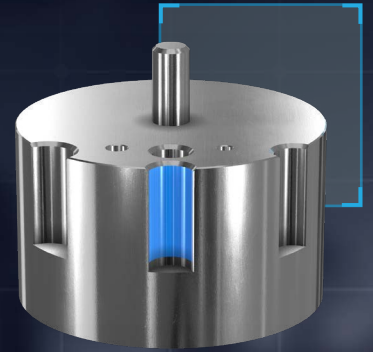
Machining Data for Solid Carbide Threading Endmills (MTECK, MTECM, MTECBF)

ISO		Material	Condition	Tensile Strength [N/mm²]	Hardness HB	Material Group No.	Cutting Speed (m/min)	Cutting Diameter											
								Feed in/tooth											
								2	3	4	6	8	10	12	14	16	20	25	30
P	non-alloy steel and cast steel, free cutting steel	<0.25% C	annealed	420	125	1	100-250	0.06	0.08	0.08	0.12	0.14	0.16	0.17	0.20	0.20	0.22	0.24	0.27
		≥0.25% C	annealed	650	190	2	80-210	0.06	0.08	0.08	0.12	0.14	0.16	0.17	0.20	0.20	0.22	0.24	0.27
		<0.55% C	quenched and tempered	850	250	3	65-170	0.06	0.08	0.08	0.12	0.14	0.16	0.17	0.20	0.20	0.22	0.24	0.27
		≥0.55% C	annealed	750	220	4	110-180	0.04	0.06	0.06	0.10	0.12	0.14	0.16	0.17	0.18	0.20	0.22	0.24
			quenched and tempered	1000	300	5	95-160	0.04	0.06	0.06	0.10	0.12	0.14	0.16	0.17	0.18	0.20	0.22	0.24
	low alloy and cast steel (less than 5% of alloying elements)	annealed	600	200	6	90-160	0.04	0.04	0.06	0.06	0.08	0.10	0.10	0.12	0.14	0.16	0.2	0.20	
			930	275	7	65-200	0.04	0.04	0.06	0.06	0.08	0.10	0.10	0.12	0.14	0.16	0.2	0.20	
			1000	300	8	70-210	0.04	0.04	0.06	0.06	0.08	0.10	0.10	0.12	0.14	0.16	0.2	0.20	
			1200	350	9	95-160	0.04	0.04	0.06	0.06	0.08	0.10	0.10	0.12	0.14	0.16	0.2	0.20	
	high alloyed steel, cast steel and tool steel	annealed	680	200	10	130-170	0.04	0.04	0.06	0.06	0.08	0.10	0.10	0.12	0.14	0.16	0.2	0.20	
		quenched and tempered	1100	325	11	75-100	0.04	0.04	0.06	0.06	0.08	0.10	0.10	0.12	0.14	0.16	0.2	0.20	
	stainless steel and cast steel	ferritic / martensitic	680	200	12	110-170	0.04	0.04	0.06	0.06	0.08	0.10	0.10	0.12	0.14	0.16	0.18	0.20	
		martensitic	820	240	13	70-155	0.04	0.04	0.06	0.06	0.08	0.10	0.10	0.12	0.14	0.16	0.18	0.20	
M	stainless steel and cast steel	austenitic, duplex	600	180	14	85-110	0.04	0.04	0.06	0.06	0.08	0.10	0.10	0.12	0.14	0.16	0.18	0.20	
K	gray cast iron (GG)	ferritic / pearlitic		180	15	120-160	0.06	0.08	0.08	0.12	0.14	0.16	0.17	0.20	0.20	0.22	0.24	0.27	
		pearlitic / martensitic		260	16	75-160	0.06	0.08	0.08	0.12	0.14	0.16	0.17	0.20	0.20	0.22	0.24	0.27	
	nodular cast iron (GGG)	ferritic		160	17	70-150	0.06	0.08	0.08	0.12	0.14	0.16	0.17	0.20	0.20	0.22	0.24	0.27	
		pearlitic		250	18	110-140	0.06	0.08	0.08	0.12	0.14	0.16	0.17	0.20	0.20	0.22	0.24	0.27	
	malleable cast iron	ferritic		130	19	120-160	0.06	0.08	0.08	0.12	0.14	0.16	0.17	0.20	0.20	0.22	0.24	0.27	
		pearlitic		230	20	110-140	0.06	0.08	0.08	0.12	0.14	0.16	0.17	0.20	0.27	0.22	0.24	0.27	
N	aluminum-wrought alloys	not hardenable		60	21	160-300	0.06	0.08	0.08	0.12	0.14	0.16	0.17	0.20	0.20	0.22	0.24	0.27	
		hardenable		100	22	120-280	0.06	0.08	0.08	0.12	0.14	0.16	0.17	0.20	0.20	0.22	0.24	0.27	
	aluminum-cast alloys	not hardenable		75	23	150-350	0.06	0.08	0.08	0.12	0.14	0.16	0.17	0.20	0.20	0.22	0.24	0.27	
		hardenable		90	24	130-320	0.06	0.08	0.08	0.12	0.14	0.16	0.17	0.20	0.20	0.22	0.24	0.27	
		>12% Si	high temperature	130	25	100-250	0.04	0.04	0.06	0.06	0.08	0.10	0.10	0.12	0.14	0.16	0.18	0.20	
	copper alloys	>1% Pb	free cutting	110	26	110-280	0.04	0.04	0.06	0.06	0.08	0.10	0.10	0.12	0.14	0.16	0.18	0.20	
		brass		90	27	110-260	0.04	0.04	0.06	0.06	0.08	0.10	0.10	0.12	0.14	0.16	0.18	0.20	
		electrolytic copper		100	28	90-200	0.04	0.04	0.06	0.06	0.08	0.10	0.10	0.12	0.14	0.16	0.18	0.20	
	non metallic	duroplastics, fiber plastics		70 Shore D	29	100-400	0.10	0.12	0.14	0.17	0.2	0.20	0.20	0.21	0.22	0.24	0.26	0.27	
		hard rubber		55 Shore D	30	120-200	0.10	0.11	0.12	0.14	0.16	0.18	0.19	0.19	0.20	0.21	0.22	0.23	
S	high temperature alloys	Fe based	annealed		200	31	40-60	0.03	0.04	0.04	0.06	0.06	0.06	0.06	0.08	0.08	0.08	0.10	0.10
			hardened		280	32	30-50	0.03	0.04	0.04	0.06	0.06	0.06	0.06	0.08	0.08	0.08	0.10	0.10
		Ni or Co based	annealed		250	33	25-65	0.03	0.04	0.04	0.06	0.06	0.06	0.06	0.08	0.08	0.08	0.10	0.10
			hardened		350	34	25-60	0.03	0.04	0.04	0.06	0.06	0.06	0.06	0.08	0.08	0.08	0.10	0.10
			cast		320	35	20-40	0.03	0.04	0.04	0.06	0.06	0.06	0.06	0.08	0.08	0.08	0.10	0.10
	titanium alloys	pure		400	190	36	25-63	0.03	0.04	0.04	0.06	0.06	0.06	0.06	0.08	0.08	0.08	0.10	0.10
		alpha+beta alloys, hardened		1050	310	37	20-80	0.04	0.04	0.04	0.06	0.06	0.06	0.06	0.08	0.08	0.08	0.10	0.10

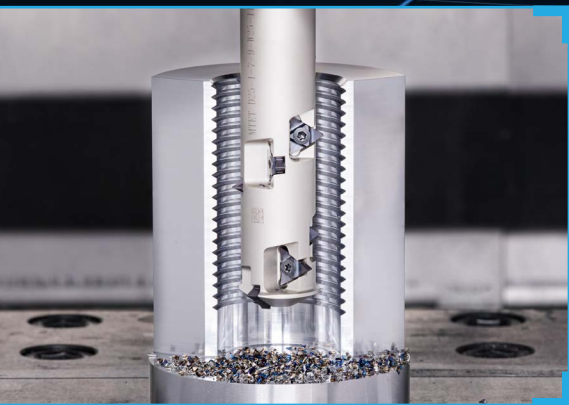
- steel
- stainless steel
- cast iron
- non-ferrous metals
- superalloys and titanium

QUICKM-THREAD

Endmill Thread-Milling Cutters
with Indexable Inserts for
High Productivity



Cutter Range: 20mm - 42mm.



YOU Milling Intelligently?

.....
Inserts with 3 Cutting Edges for
Various Profiles and Pitches. Pocket
Design with Robust Clamping Area.
Thread Pitch Range from 2 to 6mm.
Each QUICK-M-THREAD Pocket with
Pin-Pointed Coolant Outlet.
.....

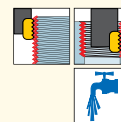
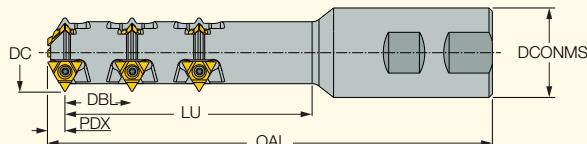


SCAN ME



MTET Step Release

Indexable Threading Endmills
with Cylindrical Shanks
for Single Point Inserts



Designation	DC	PDX	NOF ⁽¹⁾	CICT ⁽²⁾	DBL	DCONMS	OAL	LU	Shank ⁽³⁾	MIID ⁽⁴⁾
MTET D20-1-12-5-W25-11U	20.00	5.20	1	5	12.00	25.00	115.10	60.00	W	MT TNCT 11U
MTET D25-3-21-3-W25-11U	25.00	5.20	3	9	21.00	25.00	144.60	79.50	W	MT TNCT 11U
MTET D30-3-36-3-W32-11U	30.00	5.20	3	9	36.00	32.00	179.70	110.00	W	MT TNCT 11U
MTET D36-3-30-3-W40-16U	36.00	7.90	3	9	30.00	40.00	192.90	110.50	W	MT TNCT 16U
MTET D42-3-60-2-W40-16U	42.00	7.90	3	6	60.00	40.00	212.20	127.00	W	MT TNCT 16U

• Tool cutting diameter should not exceed 2/3 of thread bore diameter

⁽¹⁾ Number of flutes

⁽²⁾ Number of inserts (or edges for solid tool)

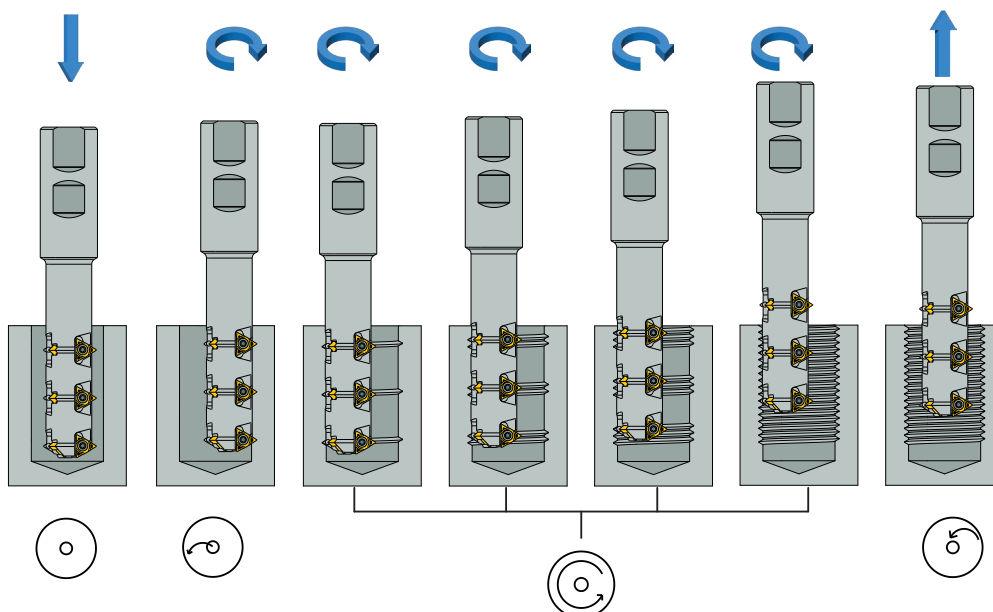
⁽³⁾ W-Weldon

⁽⁴⁾ Master insert identification

Spare Parts

Designation		
MTET D20-1-12-5-W25-11U	SR M2.6-L6.7-S11	T-8/5
MTET D25-3-21-3-W25-11U	SR M2.6-L6.7-S11	T-8/5
MTET D30-3-36-3-W32-11U	SR M2.6-L6.7-S11	T-8/5
MTET D36-3-30-3-W40-16U	SR 14-562	T-10/5
MTET D42-3-60-2-W40-16U	SR 14-562	T-10/5

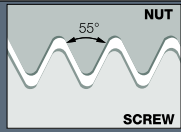
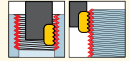
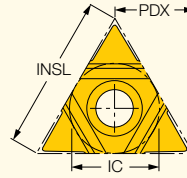
Tool with Inserts	Suitable Pitches INT [mm]			Suitable Pitches EXT [mm]		
MTET D20-1-12-5-W25-11U+MT TNCT 11U 60D	3			2	3	
MTET D25-3-21-3-W25-11U+MT TNCT 11U 60D	3	3.5		3		
MTET D30-3-36-3-W32-11U+MT TNCT 11U 60D	3	4		2	3	
MTET D36-3-30-3-W40-16U+MT TNCT 16U 60D	5	6		3	5	
MTET D42-3-60-2-W40-16U+MT TNCT 16U 60D	4	5	6	3	4	5



MILLTHREAD

MT TNCT-U55

55° Partial Profile Laydown
U-Type Thread Milling Inserts,
for General Industry



Dimensions

Designation	IC	INSL	TTP	TPIN ⁽¹⁾	TPIX ⁽²⁾	PDX	TTP_DF2	TPIN_DF2	TPIX_DF2	IC908
MT TNCT 11U 55D 908	6.35	11.00	INT	7.00	12.00	5.00	EXT	7.00	12.00	●
MT TNCT 16U 55D 908	9.52	16.49	INT	4.50	6.00	7.60	EXT	4.50	6.00	●

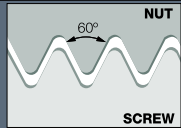
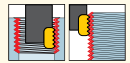
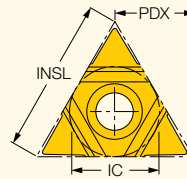
⁽¹⁾ Threads per inch minimum

⁽²⁾ Threads per inch maximum

MILLTHREAD

MT TNCT-U60

60° Partial Profile Laydown
U-Type Thread Milling Inserts,
for General Industry



Dimensions

Designation	IC	INSL	TTP	TPN ⁽¹⁾	TPX ⁽²⁾	TPIN ⁽³⁾	TPIX ⁽⁴⁾	TTP_DF2	TPIN_DF2	TPIX_DF2	TPN_DF2	TPX_DF2	IC908
MT TNCT 11U 60D 908	6.35	11.00	INT	2.500	4.000	6.00	10.00	EXT	8.00	12.00	2.000	3.000	●
MT TNCT 16U 60D 908	9.52	16.49	INT	4.000	6.000	4.00	6.00	EXT	5.00	8.00	3.000	5.000	●

⁽¹⁾ Thread pitch minimum (mm)

⁽²⁾ Thread pitch maximum (mm)

⁽³⁾ Threads per inch minimum

⁽⁴⁾ Threads per inch maximum

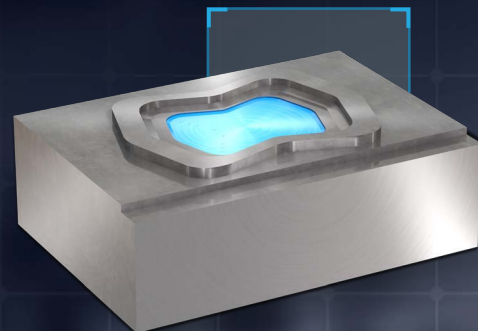
Cutting conditions for MTET Step Release

ISO	Material	Condition	Hardness HB	Tensile Strength [N/mm ²]	Material Group No.	Cutting conditions		
						v _c (m/min)	F _z mm/tooth	
							Insert designation	
							MT TNCT 11U	MT TNCT 16U
P	non-alloy steel and cast steel, free cutting steel	<0.25% C annealed	125	428	1	200	0.3	0.4
		≥0.25% C annealed	190	639	2	200	0.3	0.4
		<0.55% C quenched and tempered	210	708	3	200	0.3	0.4
		≥0.55% C annealed	190	639	4	200	0.3	0.4
		quenched and tempered	300	1013	5	200	0.3	0.4
	low alloy and cast steel (less than 5% of alloying elements)	annealed	220	745	6	200	0.3	0.4
		quenched and tempered	175	591	7	200	0.3	0.4
			285	960	8	200	0.3	0.4
			380	1282	9	150	0.35	0.35
	high alloyed steel, cast steel and tool steel	annealed	430	1477	10	100	0.2	0.3
		quenched and tempered	200	675	11	200	0.3	0.4
	stainless steel and cast steel	ferritic / martensitic	200	675	12	200	0.25	0.35
		martensitic	330	1114	13	150	0.25	0.35
M	stainless steel and cast steel	austenitic, duplex	230	778	14	80	0.2	0.3
K	gray cast iron (GG)	ferritic / pearlitic	200	400	19	200	0.3	0.4
		pearlitic / martensitic	260	700	20	200	0.3	0.4
	nodular cast iron (GGG)	ferritic	180	200	17	250	0.3	0.4
		pearlitic	245	350	18	200	0.3	0.4
	malleable cast iron	ferritic	155	400	15	200	0.3	0.4
		pearlitic	265	700	16	200	0.3	0.4
N	aluminum-wrought alloys	not hardenable	30	–	21	–	–	–
		hardenable	100	343	22	–	–	–
	aluminum-cast alloys	≤12% Si not hardenable	75	260	23	–	–	–
		hardenable	130	447	24	300	0.3	0.4
		>12% Si high temperature	70	250	27	250	0.3	0.4
	copper alloys	>1% Pb free cutting	100	343	28	–	–	–
		brass	90	314	27	–	–	–
		Cu-alloys, short-chipping	110	382	28	–	–	–
	non metallic	high-strength, ampcu	300	1013	28	–	–	–
		duroplastics, fiber plastics	70 Shore D	–	29	300	0.4	0.5
		hard rubber	55 Shore D	–	30	300	0.35	0.45
S	high temperature alloys	Fe based annealed	200	675	31	40	0.25	0.25
		hardened	280	943	32	25	0.15	0.15
		Ni or Co based annealed	250	839	33	40	0.25	0.25
		hardened	350	1177	34	25	0.15	0.15
		cast	320	1076	35	30	0.2	0.2
	titanium alloys	Pure titanium	200	675	36	40	0.25	0.25
		α and β alloys, hardened	375	1262	37	40	0.25	0.25
		β alloys	410	1396	38	30	0.2	0.2
H	hardened steel	hardened	50 HRC	–	38	45	0.2	0.3
		hardened	55 HRC	–	39	–	–	–
	chilled cast iron	cast	60 HRC	–	40	–	–	–
	cast iron	hardened	55 HRC	–	41	45	0.2	0.3

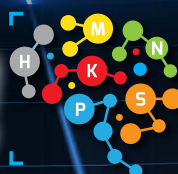


QUICKCLAMP

Adaptor Mechanism Clamps
Small Solid Carbide Round
Shank Tools with Maximum
Tightening Force



Cylindrical Carbide Drills
or Endmills Dia: 3-6mm.



YOU Milling Intelligently?

Unique Mechanism with ER 32
Collet Holder for High Rigidity and
Strong Clamping Forces. Effective
Pinpointed Coolant to the Cutting
Edge for Ultimate Chip Evacuation
and Longer Tool Life.

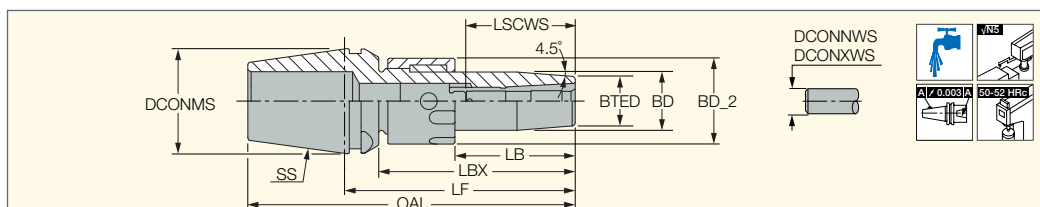
SCAN ME



QUICKCLAMP

ER-MS

QUICK-CLAMP System for Small Cutting Tools with Integral Solid ER Shank



Designation	DCONNWS ⁽¹⁾	DCONXWS ⁽²⁾	SS	BD	BD_2	LB	LBX	LF	OAL	DCONMS
ER32 MS6X60	3.00	6.00	ER32	17.80	26.20	36.00	60.00	70.00	100.00	32.00

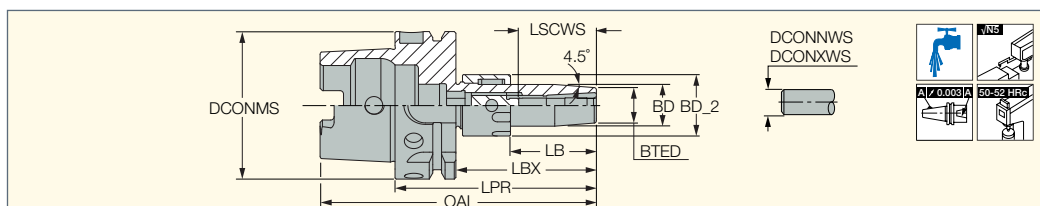
⁽¹⁾ Minimum diameter

⁽²⁾ Maximum diameter

QUICKCLAMP

HSK-A-MS

QUICK-CLAMP System for Small Cutting Tools with HSK ISO12164-1 Shank

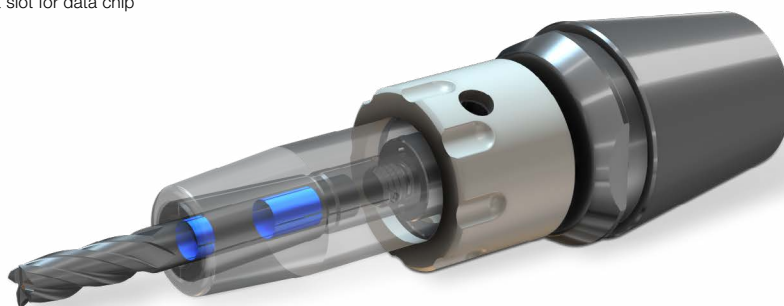


Designation	DCONNWS ⁽¹⁾	DCONXWS ⁽²⁾	BTED	BD	BD_2	LB	LBX	LPR	OAL	DCONMS	LSCWS	DCP ⁽³⁾
HSK A63 MS6X60	3.00	6.00	15.00	17.80	26.20	36.00	60.00	86.00	118.00	63.00	33.00	1

⁽¹⁾ Minimum diameter

⁽²⁾ Maximum diameter

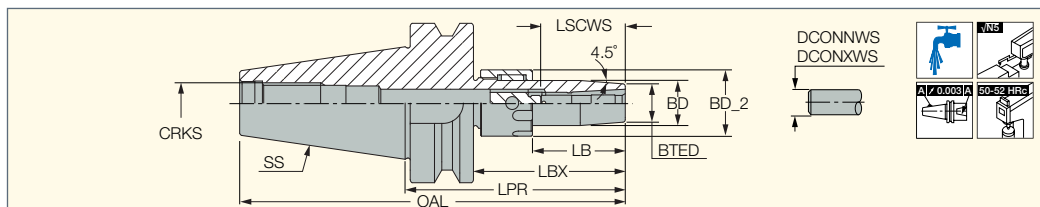
⁽³⁾ 1 - Slot for data chip, 0 - Without slot for data chip



QUICKCLAMP

BT-MS

QUICK-CLAMP System for Small Cutting Tools with BT MAS-403 Form AD Shank



Designation	DCONNWS ⁽¹⁾	DCONXWS ⁽²⁾	SS	BTED	BD	BD_2	LPR	LB	LBX	OAL	LSCWS	CRKS	DCP ⁽³⁾
BT40 MS6X60	3.00	6.00	BT40	15.00	17.80	26.20	87.00	36.00	60.00	152.40	33.00	M16	0

⁽¹⁾ Minimum diameter

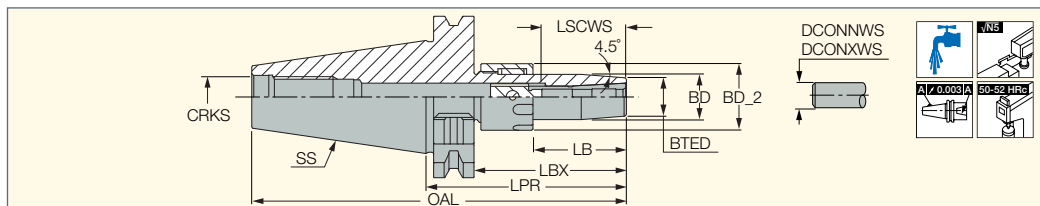
⁽²⁾ Maximum diameter

⁽³⁾ 1 - Slot for data chip, 0 - Without slot for data chip

QUICKCLAMP

DIN69871-MS

QUICK-CLAMP System for Small Cutting Tools with DIN69871 Form AD Shank



Designation	DCONNWS ⁽¹⁾	DCONXWS ⁽²⁾	SS	BTED	BD	BD_2	LPR	LBX	LB	OAL	LSCWS	CRKS	DCP ⁽³⁾
DIN69871 40 MS6X60	3.00	6.00	40	15.00	17.80	26.20	79.10	60.00	36.00	147.50	33.00	M16	0

⁽¹⁾ Minimum diameter

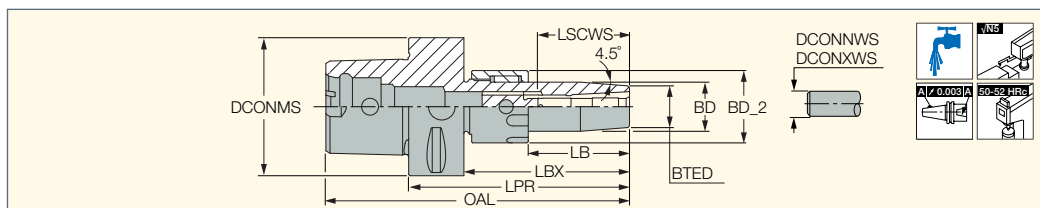
⁽²⁾ Maximum diameter

⁽³⁾ 1 - Slot for data chip, 0 - Without slot for data chip

QUICKCLAMP

C#-MS

QUICK-CLAMP System for Small Cutting Tools with CAMFIX ISO26623-1 Shank



Designation	DCONNWS ⁽¹⁾	DCONXWS ⁽²⁾	BTED	BD	BD_2	LPR	LBX	LB	DCONMS	LSCWS	OAL	DCP ⁽³⁾
C5 MS6X60	3.00	6.00	15.00	17.80	26.20	80.00	60.00	36.00	50.00	33.00	110.00	1
C6 MS6X60	3.00	6.00	15.00	17.80	26.20	82.00	60.00	36.00	63.00	33.00	120.00	1

⁽¹⁾ Minimum diameter

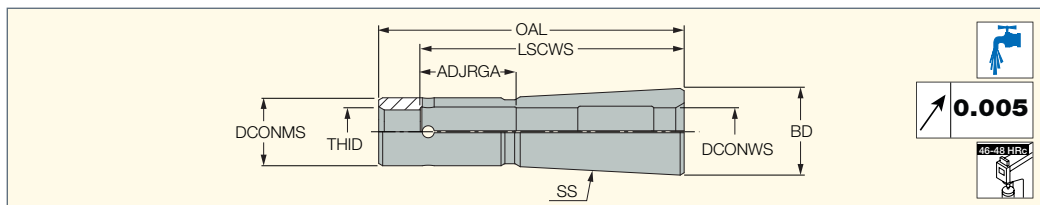
⁽²⁾ Maximum diameter

⁽³⁾ 1 - Slot for data chip, 0 - Without slot for data chip

QUICKCLAMP

MS-COLLET

Collet for QUICK-CLAMP System

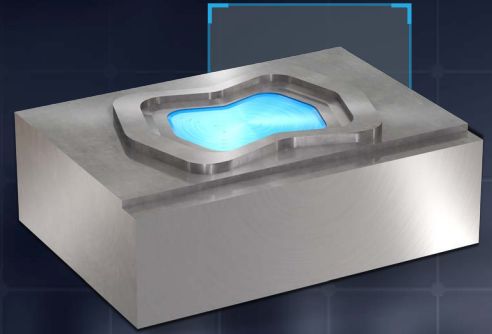


Designation	DCONWS	DCONMS	THID	ADJRGA	LSCWS	SS	BD	OAL
MS6-3 COLLET	3.00	8.50	M6	12.00	33.00	MS6	10.90	38.00
MS6-4 COLLET	4.00	8.50	M6	12.00	33.00	MS6	10.90	38.00
MS6-5 COLLET	5.00	8.50	M6	12.00	33.00	MS6	10.90	38.00
MS6-6 COLLET	6.00	8.50	M6	12.00	33.00	MS6	10.90	38.00



WHISPERLINE

Anti-Vibration Damping
System for Shellmill
Cutters to Machine
Deep Cavities
and Long Overhangs



Shell-Mill Cutters Diameter:
50mm, 63mm.



YOU Milling
Intelligently?

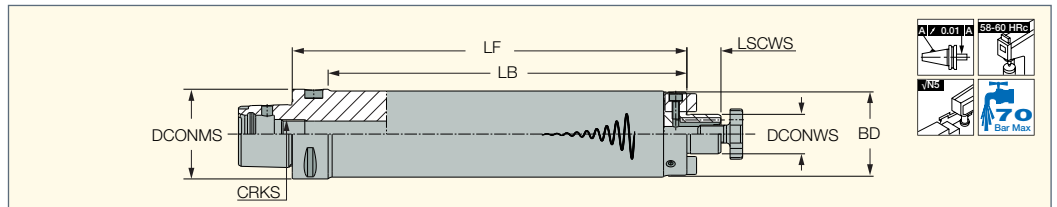
.....
Long Reach of up to 6XD with
Range of CAMFIX 5-6 Connections.
Internal Coolant Directed to the
Cutting Edge for Deep Milling
Applications.
.....

SCAN ME



AV C#-SEM

Anti-Vibration Shell Mill Holders
with Coolant Holes and CAMFIX
(ISO 26623-1) Shanks



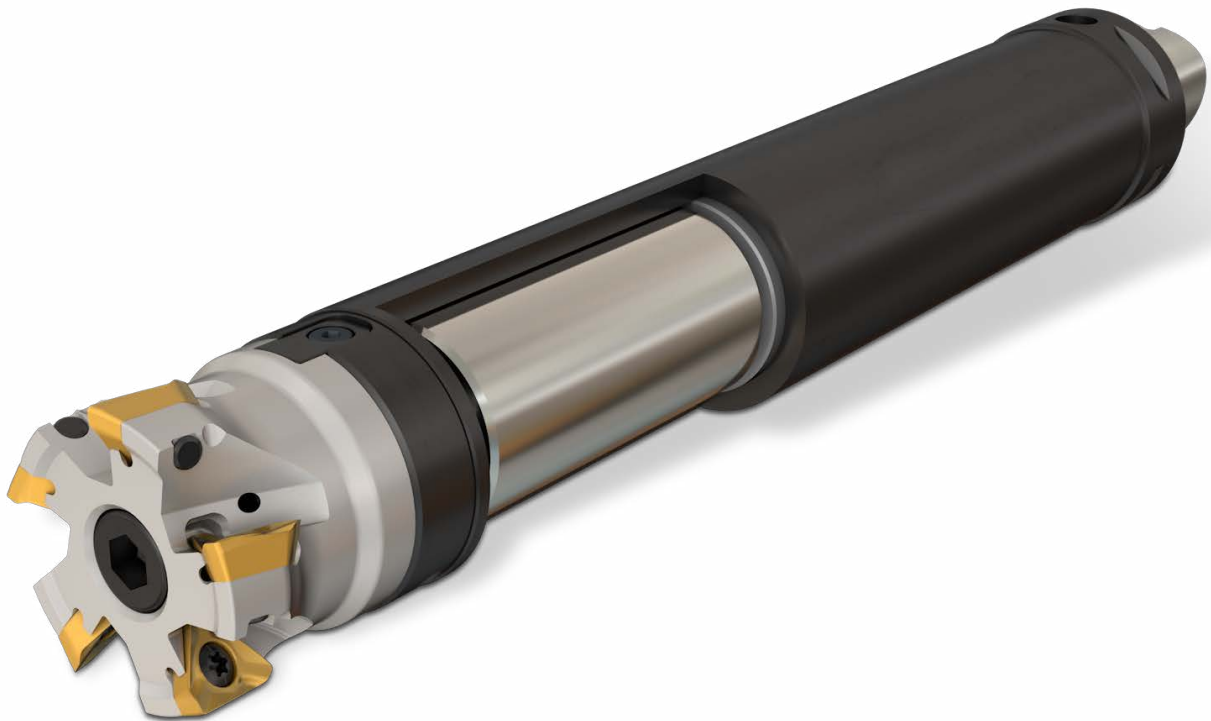
Designation	DCONMS	DCONWS	BD	LSCWS	LB	LF	CRKS	DCP ⁽¹⁾	kg
AV C5 SEM22 48X220	50.00	22.00	48.00	19.00	200.0	220.00	M16	1	3.80
AV C5 SEM22 48X270	50.00	22.00	48.00	19.00	250.0	270.00	M16	1	4.70
AV C6 SEM22 48X270	63.00	22.00	48.00	19.00	248.0	270.00	M20	1	4.60
AV C6 SEM22 61X260	63.00	22.00	61.00	19.00	238.0	260.00	M20	1	7.50
AV C6 SEM22 61X310	63.00	22.00	61.00	19.00	288.0	310.00	M20	1	8.70
AV C6 SEM27 61X250	63.00	27.00	61.00	21.00	228.0	250.00	M20	1	7.40
AV C6 SEM27 61X300	63.00	27.00	61.00	21.00	278.0	300.00	M20	1	8.50

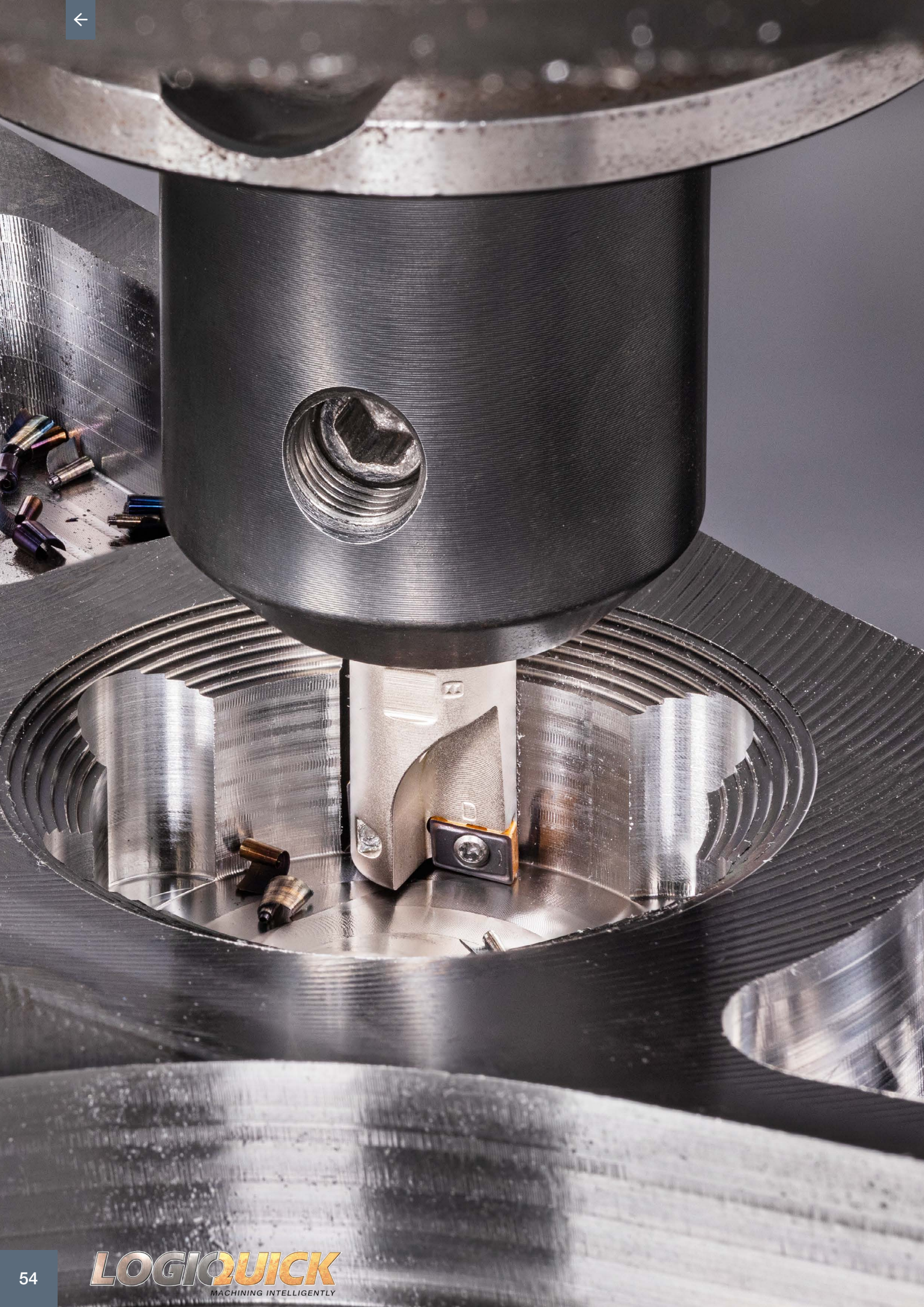
⁽¹⁾ 1 - Slot for data chip, 0 - Without slot for data chip

Spare Parts

Designation						
AV C5 SEM22 48X220	SR M4X10DIN912	DR.DOG 10S	M10 CLAMP SCREW SEM22	COOLING TUBE C5*	WRENCH COOL TUBE C5*	WRENCH M10 SEMC 22*
AV C5 SEM22 48X270	SR M4X10DIN912	DR.DOG 10S	M10 CLAMP SCREW SEM22	COOLING TUBE C5*	WRENCH COOL TUBE C5*	WRENCH M10 SEMC 22*
AV C6 SEM22 48X270	SR M4X10DIN912	DR.DOG 10S	M10 CLAMP SCREW SEM22	COOLING TUBE C6*	WRENCH COOL TUBE C6*	WRENCH M10 SEMC 22*
AV C6 SEM22 61X260	SR M4X10DIN912	DR.DOG 10S	M10 CLAMP SCREW SEM22	COOLING TUBE C6*	WRENCH COOL TUBE C6*	WRENCH M10 SEMC 22*
AV C6 SEM22 61X310	SR M4X10DIN912	DR.DOG 10S	M10 CLAMP SCREW SEM22	COOLING TUBE C6*	WRENCH COOL TUBE C6*	WRENCH M10 SEMC 22*
AV C6 SEM27 61X250	SR M5X14DIN912	DR.DOG 12S	M12 CLAMP SCREW SEM27	COOLING TUBE C6*	WRENCH COOL TUBE C6*	WRENCH M12 SEMC 27*
AV C6 SEM27 61X300	SR M5X14DIN912	DR.DOG 12S	M12 CLAMP SCREW SEM27	COOLING TUBE C6*	WRENCH COOL TUBE C6*	WRENCH M12 SEMC 27*

* Optional, to be ordered separately





YOU

TURNING

INTELLIGENTLY?

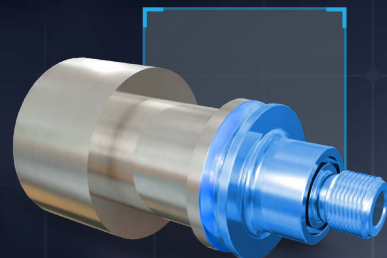


LOGIQUICK
MACHINING INTELLIGENTLY

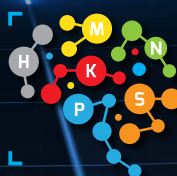


QUICKSWISS

Modular Tooling System for Back Machining on Swiss Type Machines



QUICK-SWISS Modular Tools are Designed with Coolant Nozzles Directed to the Cutting Edge.



YOU Turning Intelligently?

The QUICK-SWISS System for Turning, Threading and Drilling.

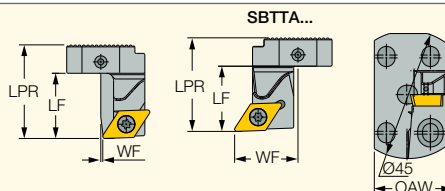
SCAN ME



QUICKSWISS

SBTT#-SDJCR/L-JHP

Screw Lock JET-CUT Modular Heads Mount 7° Clearance
55° Rhombic Inserts for Back-End Machining on Swiss-Type Machines



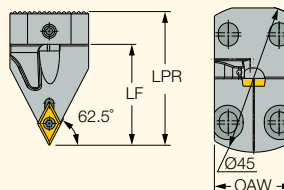
Designation	LF	LPR	OAW	WF	MIID ⁽¹⁾			
SBTT-SDJCR/L07-JHP	23.00	33.00	27.50	0.17	DCGT 070202	SR 14-548	T-7/5	SR M5X30 DIN7984
SBTT-SDJCR/L11-JHP	23.00	33.00	27.50	0.70	DCGT 11T302	SR 16-236	T-15/5	SR M5X30 DIN7984
SBTTA-SDJCR/L11-JHP	23.00	33.00	28.00	22.30	DCGT 11T302	SR 16-236	T-15/5	SR M5X30 DIN7984
SBTTL-SDJCR/L07-JHP	40.00	50.00	27.50	0.17	DCGT 070202	SR 14-548	T-7/5	SR M5X45 DIN7984
SBTTL-SDJCR/L11-JHP	40.00	50.00	27.50	0.70	DCGT 11T302	SR 16-236	T-15/5	SR M5X45 DIN7984

⁽¹⁾ Master insert identification

QUICKSWISS

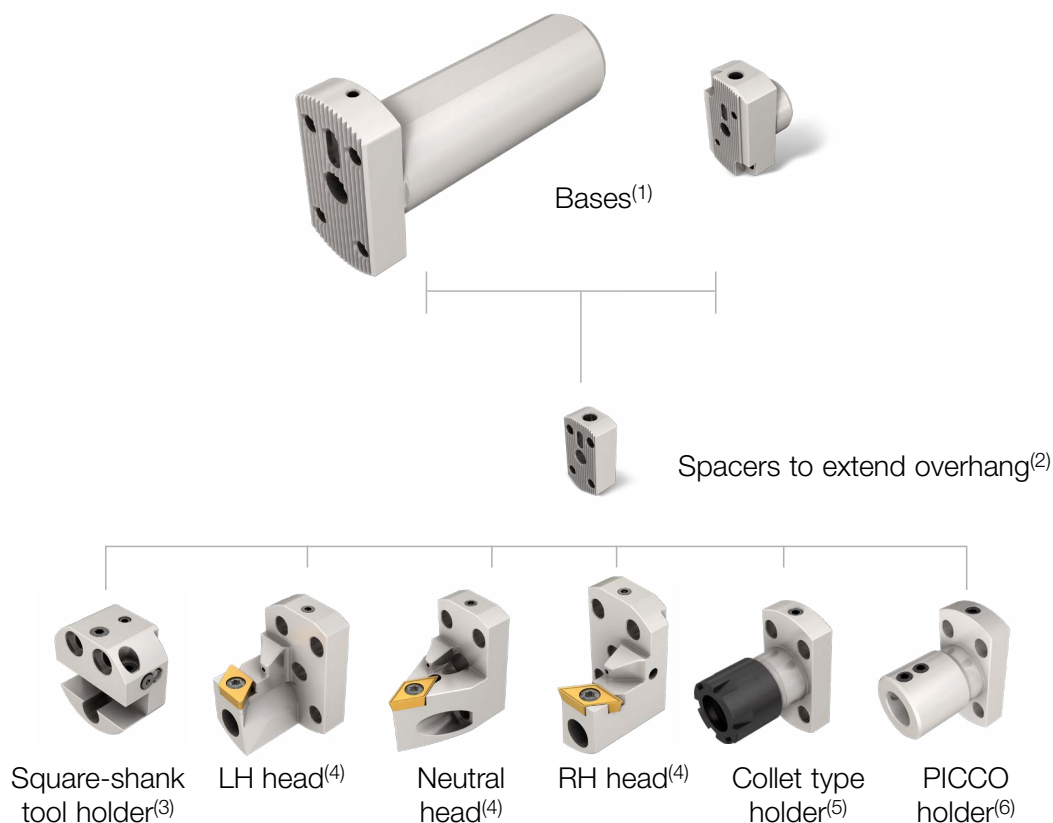
SBTT-SDNCN-JHP

Screw Lock JET-CUT Modular Heads Mount 7° Clearance
55° Rhombic Inserts for Back-End Machining on Swiss-Type Machines



Designation	LF	LPR	OAW	MIID ⁽¹⁾			
SBTT-SDNCN07-JHP	31.00	41.00	24.00	DCGT 070204	SR 14-548	SR M5X25 DIN7984	T-7/5
SBTT-SDNCN11-JHP	31.00	41.00	24.00	DCGT 11T302	SR 16-236	SR M5X25 DIN7984	T-15/5

⁽¹⁾ Master insert identification



1 The bases are available in different shanks diameters and suitable for a variety of different Swiss-Type machine interfaces.

2 Spacers are available in different thicknesses from 10mm up to 30mm, extending the overhang and coolant option through the base.

3 The holder is suitable for size 10 and 12 square shanks.

4 A large variety of heads are available for different insert types, with short and long head overhangs.

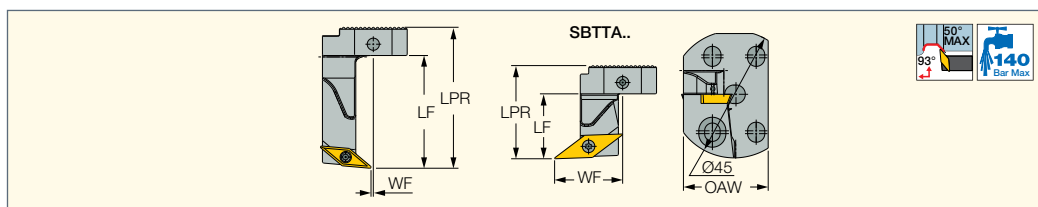
5 Collet type holder for ER11 and ER16 collet sizes.

6 Holders for PICCO-CUT inserts.

QUICKSWISS

SBTT#-SVJCR/L-JHP

Screw Lock JET-CUT Modular Heads Mount 7° Clearance
35° Rhombic Inserts for Back-End Machining on Swiss-Type Machines



Designation	LF	LPR	OAW	WF	MIID ⁽²⁾			
SBTT-SVJCR/L11-JHP	23.00	33.00	30.00	0.80	VCMT 110302-F3P	SR 14-560	T-8/5	SR M5X30 DIN7984
SBTTA-SVJCR13-JHP ⁽¹⁾	23.00	33.00	27.00	24.00	VCMT 130302-PF	SR 14-513	T-8/5	SR M5X30 DIN7984
SBTTL-SVJCR/L11-JHP	40.00	50.00	30.00	0.80	VCMT 110302-F3P	SR 14-560	T-8/5	SR M5X45 DIN7984

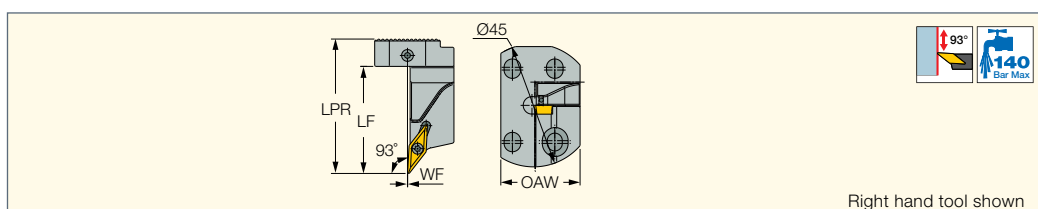
⁽¹⁾ Available on request

⁽²⁾ Master insert identification

QUICKSWISS

SBTT#-SVUCR/L-JHP

Screw Lock JET-CUT Modular Heads Mount 7° Clearance
35° Rhombic Inserts for Back-End Machining on Swiss-Type Machines



Right hand tool shown

Designation	LF	LPR	OAW	WF	MIID ⁽²⁾			
SBTT-SVUCR/L11-JHP	23.00	33.00	29.00	0.00	VCMT 110302-F3M	SR 14-560	T-8/5	SR M5X25 DIN7984
SBTTL-SVUCR11-JHP ⁽¹⁾	40.00	50.00	29.00	0.00	VCMT 110302-F3M	SR 14-560	T-8/5	SR M5X40 DIN7984

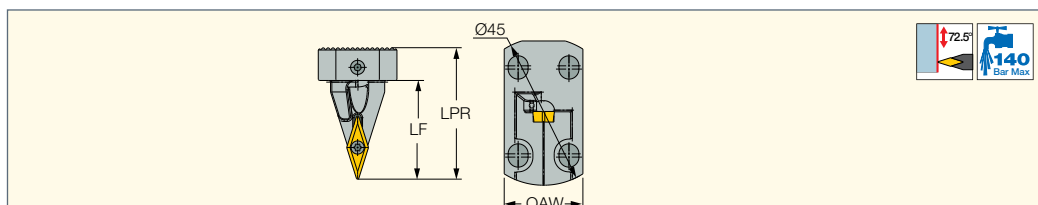
⁽¹⁾ Available on request

⁽²⁾ Master insert identification

QUICKSWISS

SBTT-SVVCN-JHP

Screw Lock JET-CUT Modular Heads Mount 7° Clearance
35° Rhombic Inserts for Back-End Machining on Swiss-Type Machines



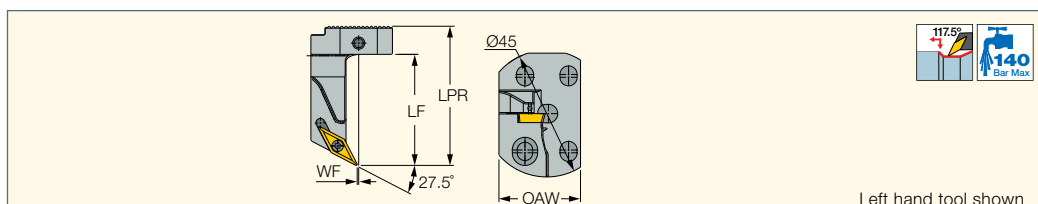
Designation	LF	LPR	OAW	MIID ⁽¹⁾		
SBTT-SVVCN11-JHP	30.00	40.00	24.00	VCMT 110302-F3P	SR 14-560	T-8/5

⁽¹⁾ Master insert identification

QUICKSWISS

SBTT#-SVQCR/L-JHP

Screw Lock JET-CUT Modular Heads Mount 7° Clearance
35° Rhombic Inserts for Back-End Machining on Swiss-Type Machines



Left hand tool shown

Designation	LF	LPR	OAW	WF	MIID ⁽²⁾			
SBTT-SVQCR/L11-JHP	23.00	33.00	29.00	0.50	VCMT 110302-F3P	SR 14-560	T-8/5	SR M5X30 DIN7984
SBTTL-SVQCR/L11-JHP ⁽¹⁾	40.00	50.00	29.00	0.50	VCMT 110302-F3P	SR 14-560	T-8/5	SR M5X45 DIN7984

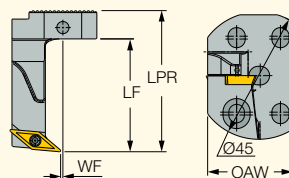
⁽¹⁾ Available on request

⁽²⁾ Master insert identification

QUICKSWISS

SBTT#-SVJBR/L-JHP

Screw Lock JET-CUT Modular Heads Mount 5° Clearance
35° Rhombic Inserts for Back-End Machining on Swiss-Type Machines



Left hand tool shown

Designation	LF	LPR	OAW	WF	MIID ⁽²⁾			
SBTT-SVJBR/L11-JHP ⁽¹⁾	23.00	33.00	30.00	0.80	VBGW 110304-F2	SR 11201753-3	T-8/5	SR M5X30 DIN7984
SBTTM-SVJBR/L11-JHP ⁽¹⁾	31.00	41.00	30.00	0.80	VBGW 110304-F2	SR 11201753-3	T-8/5	SR M5X35 DIN7984
SBTTM-SVJBR1102-JHP ⁽¹⁾	31.00	41.00	30.00	0.80	VBGW 110204-F	SR 14-560	T-8/5	SR M5X35 DIN7984
SBTTL-SVJBR/L11-JHP ⁽¹⁾	40.00	50.00	30.00	0.80	VBGW 110304-F2	SR 11201753-3	T-8/5	SR M5X45 DIN7984

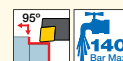
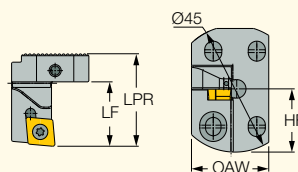
⁽¹⁾ Available on request

⁽²⁾ Master insert identification

QUICKSWISS

SBTT#-SCLCR/L-JHP

Screw Lock JET-CUT Modular Heads Mount 7° Clearance
80° Rhombic Inserts for Back-End Machining on Swiss-Type Machines



Left hand tool shown

Designation	LF	LPR	HF	OAW	MIID ⁽²⁾			
SBTT-SCLCR/L06-JHP ⁽¹⁾	23.00	33.00	22.5	28.00	CCMT 060202-PF	SR 14-548	T-7/5	SR M5X30 DIN7984
SBTT-SCLCR/L09-JHP	23.00	33.00	22.5	27.50	CCMT 09T302-PF	SR 16-236	T-15/5	SR M5X30 DIN7984
SBTTL-SCLCR09-JHP	39.00	49.00	22.5	27.50	CCMT 09T302-PF	SR 16-236	T-15/5	SR M5X45 DIN7984

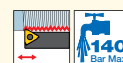
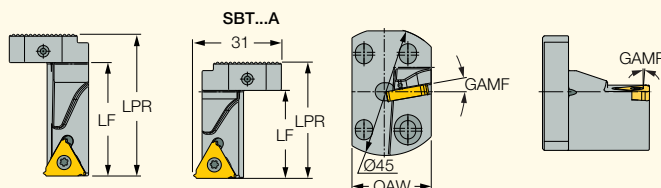
⁽¹⁾ Available on request

⁽²⁾ Master insert identification

QUICKSWISS

SBTT#-16ER/L-JHP

Screw Lock JET-CUT Modular Heads Mount ISO Laydown Threading Inserts for Back-End Machining on Swiss-Type Machines



Designation	LF	LPR	OAW	GAMP	GAMF	MIID ⁽²⁾			
SBTT-16ER-0-JHP ⁽¹⁾	31.00	41.00	28.00	0.0	10.0	16ER A 60	SR 5-40-L9.7-S16S	T-10/5	SR M5X35 DIN7984
SBTT-16ER-15-JHP	31.00	41.00	28.00	1.5	10.0	16ER A 60	SR 5-40-L9.7-S16S	T-10/5	SR M5X35 DIN7984
SBTT-16ER-3-JHP	31.00	41.00	28.00	3.0	10.0	16ER A 60	SR 5-40-L9.7-S16S	T-10/5	SR M5X35 DIN7984
SBTTA-16ER-0-JHP ⁽¹⁾	31.00	41.00	28.00	0.0	10.0	16ER A 60	SR 5-40-L9.7-S16S	T-10/5	SR M5X35 DIN7984
SBTTA-16ER-15-JHP ⁽¹⁾	31.00	41.00	28.00	1.5	10.0	16ER A 60	SR 5-40-L9.7-S16S	T-10/5	SR M5X35 DIN7984
SBTTA-16ER-3-JHP ⁽¹⁾	31.00	41.00	28.00	3.0	10.0	16ER A 60	SR 5-40-L9.7-S16S	T-10/5	SR M5X35 DIN7984
SBTTL-16EL-15-JHP	40.00	50.00	28.00	1.5	10.0	16EL A 60	SR 5-40-L9.7-S16S	T-10/5	SR M5X45 DIN7984
SBTTL-16ER-0-JHP	40.00	50.00	28.00	0.0	10.0	16ER A 60	SR 5-40-L9.7-S16S	T-10/5	SR M5X45 DIN7984
SBTTL-16ER-15-JHP	40.00	50.00	28.00	1.5	10.0	16ER A 60	SR 5-40-L9.7-S16S	T-10/5	SR M5X45 DIN7984
SBTTL-16ER-3-JHP	40.00	50.00	28.00	3.0	10.0	16ER A 60	SR 5-40-L9.7-S16S	T-10/5	SR M5X45 DIN7984
SBTTLA-16ER-15-JHP ⁽¹⁾	40.00	50.00	28.00	1.5	10.0	16ER A 60	SR 5-40-L9.7-S16S	T-10/5	SR M5X45 DIN7984

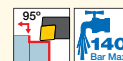
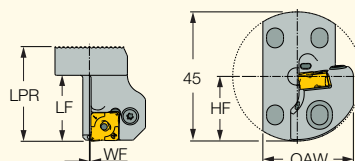
⁽¹⁾ Available on request

⁽²⁾ Master insert identification

QUICKSWISS

SBTT-PCLXR/L09-JHP

Lever Lock JET-CUT Modular Heads on which Double-Sided 80° Rhombic Inserts are Mounted for Back-End Machining



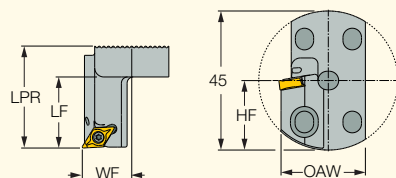
Designation	LF	HF	LPR	OAW	WF	MIID ⁽¹⁾			
SBTT-PCLXR/L09-JHP	23.00	22.5	33.00	31.60	0.25	CXMG 090408	SR M6XL11.5V	LR 3X SET	T-8/5

⁽¹⁾ Master insert identification

QUICKSWISS

SBTT/L/A-SDJNR/L07-JHP

Screw Lock JET-CUT Modular Heads on which Positive Double-Sided 55° Rhombic Inserts are Mounted for Back-End Machining



Designation	LF	HF	LPR	OAW	WF	MIID ⁽¹⁾
SBTT-SDJNL07-JHP	23.00	22.5	33.00	27.00	0.25	DNGP 070302R
SBTT-SDJNR07-JHP	23.00	22.5	33.00	27.00	0.25	DNGP 070302L
SBTTA-SDJNL07-JHP	23.00	22.5	33.00	27.30	16.00	DNGP 070302R
SBTTA-SDJNR07-JHP	23.00	22.5	33.00	27.30	16.00	DNGP 070302L
SBTTL-SDJNL07-JHP	40.00	22.5	50.00	27.00	0.25	DNGP 070302R
SBTTL-SDJNR07-JHP	40.00	22.5	50.00	27.00	0.25	DNGP 070302L

⁽¹⁾ Master insert identification

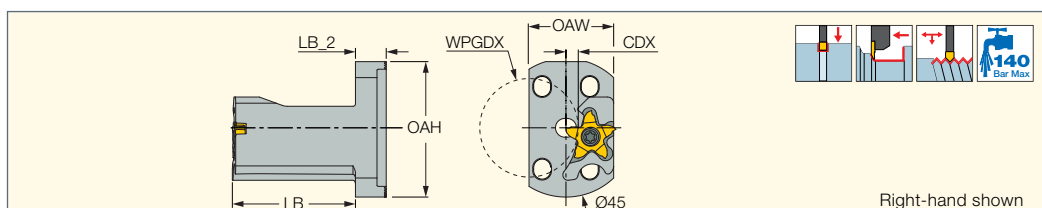
Spare Parts

Designation		
SBTT/L/A-SDJNR/L07-JHP	SR 34-514	T-7/5

QUICKSWISS

SBTT#-PCHRS/LS-17-JHP

Screw Lock JET-CUT Modular Heads Mount PENTA 17 Grooving Inserts for Back-End Machining on Swiss-Type Machines



Right-hand shown

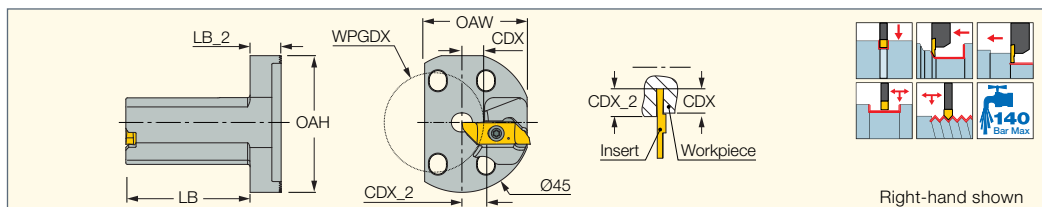
Designation	LB	LB_2	OAW	OAH	CDX	WPGDX	MIID ⁽¹⁾		
SBTT-PCHRS17-JHP	23.00	10.00	27.50	44.00	4.00	32.0	PENTA 17...RS	SR M4-39432L	T-15/5
SBTT-PCHLS17-JHP	23.00	10.00	27.50	44.00	4.00	32.0	PENTA 17...LS	SR M4-39432	T-15/5
SBTTL-PCHRS17-JHP	40.00	10.00	27.50	44.00	4.00	32.0	PENTA 17...RS	SR M4-39432L	T-15/5
SBTTL-PCHLS17-JHP	40.00	10.00	27.50	44.00	4.00	32.0	PENTA 17...LS	SR M4-39432	T-15/5

⁽¹⁾ Master insert identification

QUICKSWISS

SBTT#-SCHR/L22-JHP

Screw Lock JET-CUT Modular Heads Mount SWISS-CUT Groove-Turn Inserts for Back-End Machining on Swiss-Type Machines



Right-hand shown

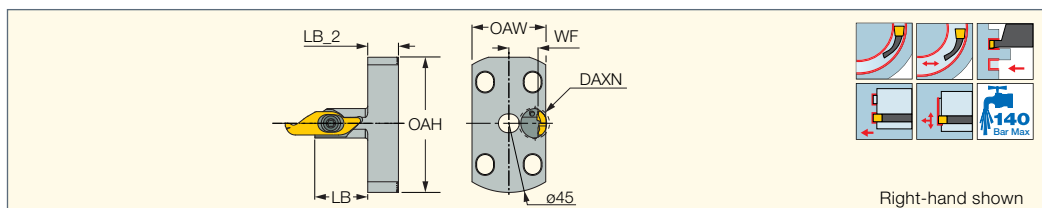
Designation	LB	LB_2	OAW	OAH	CDX	CDX_2	WPGDX	MIID ⁽¹⁾		
SBTT-SCHR22-JHP	23.00	10.00	33.00	44.00	7.00	8.00	32.0	SCIR 22-...	SR M4X0.7-19425	T-8/5
SBTT-SCHL22-JHP	23.00	10.00	33.00	44.00	7.00	8.00	32.0	SCIL 22-...	SR M4X0.7-19425	T-8/5
SBTTL-SCHR22-JHP	40.00	10.00	33.00	44.00	7.00	8.00	32.0	SCIR 22-...	SR M4X0.7-19425	T-8/5
SBTTL-SCHL22-JHP	40.00	10.00	33.00	44.00	7.00	8.00	32.0	SCIL 22-...	SR M4X0.7-19425	T-8/5

⁽¹⁾ Master insert identification

QUICKSWISS

SBTT#-MIFHR-JHP

Screw Lock JET-CUT Modular Heads Mount MINCUT Face Grooving Inserts for Back-End Machining on Swiss-Type Machines



Right-hand shown

Designation	LB	LB_2	OAW	WF	OAH	DAXN ⁽¹⁾	MIID ⁽²⁾		
SBTT-MIFHR-8-JHP	12.50	10.00	24.00	7.50	44.00	8.0	MIFR 8-...	SR 14-297	T-8/5
SBTT-MIFHR-10-JHP	17.20	10.00	24.00	9.50	44.00	10.0	MIFR 10-...	SR 34-506 M3X0.5	T-9/5
SBTTM-MIFHR-15-JHP	15.00	10.00	24.00	7.70	44.00	18.5	MIFR 15-...	SR 34-506/L	T-9/5

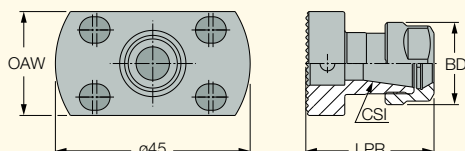
⁽¹⁾ Minimum axial grooving diameter

⁽²⁾ Master insert identification

QUICKSWISS

SBTH-ER

DIN6499 ER Collet Chuck
Holders for Height adjustable
Modular Back-End Machining
System for Swiss-Type Machines



Designation	BD	CSI	OAW	LPR
SBTH-ER11	19.00	ER11	24.00	31.60
SBTH-ER16	22.00	ER16	24.00	42.00

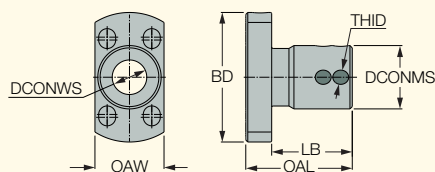
Spare Parts

Designation					
SBTH-ER11	SBTA-IK-SP1	SBTA-ZEN1	SBTA-QR5.28X1.78	NUT ER11 UM	SR M5X0.5X16 DIN913
SBTH-ER16	SBTA-IK-SP1	SBTA-ZEN1	SBTA-QR5.28X1.78	NUT ER16 MINI	SR M5X0.5X16 DIN913

QUICKSWISS

SBTH-PICCO

Height-Adjustable Modular
Back-End Machining System
for Swiss-Type Machines
with Round Shank Holders



Designation	DCONMS	DCONWS	BD	OAL	LB	OAW	THID
SBTH-PICCO	22.00	12.00	45.00	37.00	28.00	24.00	M5x0.5

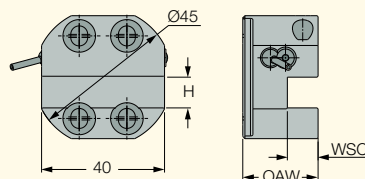
Spare Parts

Designation					
SBTH-PICCO	SR M5X0.5X16 DIN913	SBTA-IK-SP1	SBTA-ZEN1	SBTA-QR5.28X1.78	SR M5X0.5X8 DIN913

QUICKSWISS

SBTH-JHP

Square Shank Tool Holders
for Height Adjustable Modular
Back-End Machining Systems
for Swiss-Type Machines



Designation	WSC	OAW	H
SBTH-1010-JHP	10.0	24.50	10.0
SBTH-1212-JHP	12.0	24.50	12.0

Spare Parts

Designation									
SBTH-1010-JHP	SBTA-IK-SP1	SBTA-ZEN1	HW 3.0	SBTA-QR5.28X1.78	FLAT RING-SW-S5	SBTA-BALL-5.5	SBTA-BCN-L16	SR M5X16 DIN7984	SR M5X30 DIN7984
SBTH-1212-JHP	SBTA-IK-SP1	SBTA-ZEN2	HW 3.0	SBTA-QR5.28X1.78	FLAT RING-SW-S5	SBTA-BALL-5.5	SBTA-BCN-L16	SR M5X14 DIN7984	SR M5X35 DIN7984

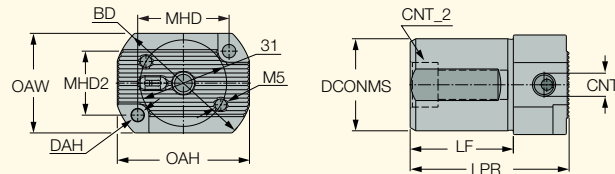
Spare Parts

Designation							
SBTH-1010-JHP	SR M6X12 DIN916	SR M5X0.5X16 DIN913	SCREW DIN 7991 M3 X 8	SR M6X20 DIN916			
SBTH-1212-JHP	SR M7X12 DIN916	SR M5X0.5X12 DIN913	SCREW DIN 7991 M3 X 8		SR M7X16 DIN916	SR M5X8 DIN7984	SBTA-1212AP

QUICKSWISS

SBTB-JHP-T/R

JET-CUT Base Holders for
Back-End Machining
Heads Intended for
Swiss-Type Machines



Designation	DCONMS	BD	LF	LPR	MHD	MHD2	DAH	OAH	OAW	CNT	CNT_2
SBTB1620SRWD	16.00	45.00	20.00	30.00	-	-	-	-	24.00	-	-
SBTB1660-JHP-R	16.00	45.00	60.00	70.00	-	-	-	-	24.00	-	M8X1
SBTB1960-JHP-R	19.05	45.00	60.00	70.00	-	-	-	-	24.00	-	G1/8
SBTB20125-JHP-R	20.00	45.00	120.00	130.00	-	-	-	-	24.00	-	G1/8
SBTB2060-JHP-R	20.00	45.00	60.00	70.00	-	-	-	-	24.00	-	G1/8
SBTB2270-JHP-R	22.00	45.00	70.00	80.00	-	-	-	-	24.00	-	G1/8
SBTB2225SW-JHP-T	22.00	47.00	25.00	45.00	30.00	25.0	4.50	37.50	32.50	M8X1	-
SBTB2225SRWD	22.00	48.00	25.00	35.00	26.90	26.9	5.50	-	38.00	-	-
SBTB2225SRR-JHP-T	22.00	52.00	25.00	45.00	37.60	13.7	5.50	-	28.00	M8X1	-
SBTB25100-JHP-R	25.00	45.00	100.00	110.00	-	-	-	-	24.00	-	G1/8
SBTB2560-JHP-R	25.00	45.00	60.00	70.00	-	-	-	-	24.00	-	G1/8
SBTB2670-JHP-R	25.40	45.00	70.00	80.00	-	-	-	-	24.00	-	G1/8
SBTB2885-JHP-R	28.00	45.00	85.00	95.00	-	-	-	-	24.00	-	M12X1.5
SBTB2885-JHP-T	28.00	45.00	85.00	105.00	-	-	-	-	24.00	M8X1	M12X1.5
SBTB2836CT20-JHP-T	28.00	46.00	36.00	56.00	27.00	27.0	4.50	36.00	34.50	M8X1	-
SBTB3115CIT-JHP-T	31.00	60.00	15.00	35.00	40.70	23.5	5.50	59.00	34.00	M8X1	-
SBTB3225HA32-JHP-T	32.00	50.00	25.00	45.00	28.40	28.4	4.50	39.00	39.00	M8X1	-
SBTB3337HA20-JHP-T	33.00	50.00	37.00	57.00	32.80	22.9	4.50	47.40	35.70	M8X1	-
SBTB3440-JHP-T	34.00	50.00	44.00	64.00	29.70	29.7	4.50	37.50	37.50	M8X1	-

Designation	Machines
SBTB1620SRWD	STAR SR16 / SST16 / SR20 / RNC16
SBTB2225SRWD	STAR SR32 / SR32J (old)
SBTB2225SRR-JHP-T	STAR SR10J / SB16 / SB20 / SR20J / SR20JN / SR20 R / II / III / SR32J / SR32JN / ECAS12 / ECAS20 / SR20R IV (Positions T21 - T24)
SBTB2225SW-JHP-T	STAR SB12R / SB20R / SR20R IV / SW20 / SV20R / SR32J II / SR38 / SW12R II / SR20J II
SBTB3440-JHP-T	STAR SV38R / ECAS32, MAIER
SBTB1660-JHP-R	STAR, TRAUB, MANURHIN
SBTB1960-JHP-R	CITIZEN L20/C16/M16
SBTB2060-JHP-R	CITIZEN B12, TSUGAMI BS12 / BS20
SBTB20125-JHP-R	TORNOS DECO, MANURHIN Swing 7-13
SBTB2270-JHP-R	STAR (most 12/16/20/32mm machines), TORNOS DELTA20 / GAMMA20
SBTB2560-JHP-R	CITIZEN L20, TORNOS, HANWHA STL32 / STL35H / STL33 / STL35J, TSUGAMI BS12 / BS20, MANURHIN Swing
SBTB25100-JHP-R	TORNOS DECO, MANURHIN KMX 5/20 / KMX 5/26 / KMX 5/32 / Swing 7-20 / Swing 7-26
SBTB2670-JHP-R	CITIZEN M32 / C32 / L32
SBTB2836CT20-JHP-T	TORNOS CT20
SBTB2885-JHP-R	TRAUB TNL 12 / TNL16
SBTB2885-JHP-T	TRAUB TNL 12 / TNL16
SBTB3115CIT-JHP-T	CITIZEN A32-VII / L32
SBTB3225HA32-JHP-T	HANWHA STL38H
SBTB3337HA20-JHP-T	HANWHA XD20H / XD20J / XD32H / XD32J

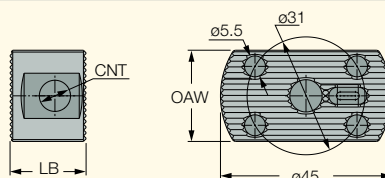
Spare Parts

Designation									
SBTB1620SRWD	SBTA-1K-HOP	SBTA-EXB	SBTA-QR5.28X1.78	HW 3.0	FLAT RING-SW-S5	SR M5X18 DIN7984			
SBTB1660-JHP-R	SBTA-1K-HOP	SBTA-EXB	SBTA-QR5.28X1.78	HW 3.0	FLAT RING-SW-S5	SR M5X18 DIN7984	SR M8X1X6 DIN913		
SBTB1960-JHP-R	SBTA-1K-HOP	SBTA-EXB	SBTA-QR5.28X1.78	HW 3.0	FLAT RING-SW-S5	SR M5X18 DIN7984	PLG G1/8 TL360		
SBTB20125-JHP-R	SBTA-1K-HOP	SBTA-EXB	SBTA-QR5.28X1.78	HW 3.0	FLAT RING-SW-S5	SR M5X18 DIN7984	PLG G1/8 TL360		
SBTB2060-JHP-R	SBTA-1K-HOP	SBTA-EXB	SBTA-QR5.28X1.78	HW 3.0	FLAT RING-SW-S5	SR M5X18 DIN7984	PLG G1/8 TL360		
SBTB2270-JHP-R	SBTA-1K-HOP	SBTA-EXB	SBTA-QR5.28X1.78	HW 3.0	FLAT RING-SW-S5	SR M5X18 DIN7984	PLG G1/8 TL360		
SBTB2225SW-JHP-T	SBTA-1K-HOP	SBTA-EXB	SBTA-QR5.28X1.78	HW 3.0	FLAT RING-SW-S5	SR M5X18 DIN7984	SR M8X1X8 DIN906		SR M4X10DIN912
SBTB2225SRWD	SBTA-1K-HOP	SBTA-EXB	SBTA-QR5.28X1.78	HW 3.0	FLAT RING-SW-S5	SR M5X18 DIN7984			SR M5X10 DIN7984
SBTB2225SRR-JHP-T	SBTA-1K-HOP	SBTA-EXB	SBTA-QR5.28X1.78	HW 3.0	FLAT RING-SW-S5	SR M5X18 DIN7984	SR M8X1X8 DIN906		SR M5X10 DIN7984
SBTB25100-JHP-R	SBTA-1K-HOP	SBTA-EXB	SBTA-QR5.28X1.78	HW 3.0	FLAT RING-SW-S5	SR M5X18 DIN7984	PLG G1/8 TL360		
SBTB2560-JHP-R	SBTA-1K-HOP	SBTA-EXB	SBTA-QR5.28X1.78	HW 3.0	FLAT RING-SW-S5	SR M5X18 DIN7984	PLG G1/8 TL360		
SBTB2670-JHP-R	SBTA-1K-HOP	SBTA-EXB	SBTA-QR5.28X1.78	HW 3.0	FLAT RING-SW-S5	SR M5X18 DIN7984	PLG G1/8 TL360		
SBTB2885-JHP-R	SBTA-1K-HOP	SBTA-EXB	SBTA-QR5.28X1.78	HW 3.0	FLAT RING-SW-S5	SR M5X18 DIN7984	SR M12X1.5X10 DIN913		
SBTB2885-JHP-T	SBTA-1K-HOP	SBTA-EXB	SBTA-QR5.28X1.78	HW 3.0	FLAT RING-SW-S5	SR M5X18 DIN7984	SR M8X1X8 DIN906	SR M12X1.5X10 DIN913	
SBTB2836CT20-JHP-T	SBTA-1K-HOP	SBTA-EXB	SBTA-QR5.28X1.78	HW 3.0	FLAT RING-SW-S5	SR M5X18 DIN7984	SR M8X1X8 DIN906		SR M4X10DIN912
SBTB3115CIT-JHP-T	SBTA-1K-HOP	SBTA-EXB	SBTA-QR5.28X1.78	HW 3.0	FLAT RING-SW-S5	SR M5X18 DIN7984	SR M8X1X8 DIN906		
SBTB3225HA32-JHP-T	SBTA-1K-HOP	SBTA-EXB	SBTA-QR5.28X1.78	HW 3.0	FLAT RING-SW-S5	SR M5X18 DIN7984	SR M8X1X8 DIN906		SR M4X20 DIN912
SBTB3337HA20-JHP-T	SBTA-1K-HOP	SBTA-EXB	SBTA-QR5.28X1.78	HW 3.0	FLAT RING-SW-S5	SR M5X18 DIN7984	SR M8X1X8 DIN906		SR M4X25DIN912
SBTB3440-JHP-T	SBTA-1K-HOP	SBTA-EXB	SBTA-QR5.28X1.78	HW 3.0	FLAT RING-SW-S5	SR M5X18 DIN7984	SR M8X1X8 DIN906		SR M4X10DIN912

QUICKSWISS

SBTS##S-JHP

Spacer for Tool Extension for
Height Adjustable Modular
Back-End Machining System
for Swiss-Type Machines



Designation	OAW	LB	CNT
SBTS10S ⁽¹⁾	24.00	10.00	-
SBTS15S-JHP	24.00	15.00	M8X1
SBTS20S-JHP	24.00	20.00	M8X1
SBTS25S-JHP	24.00	25.00	M8X1
SBTS30S-JHP	24.00	30.00	M8X1

(1) Without coolant connection

Spare Parts

Designation							
SBTS10S	SBTA-IK-HOP	SBTA-IK-SP1	SBTA-IK-SP2	SBTA-ZEN10	SBTA-EXB10	SBTA-QR5.28X1.78	FLAT RING-SW-S5
SBTS15S-JHP	SBTA-IK-HOP	SBTA-IK-SP1	SBTA-IK-SP2	SBTA-ZEN15	SBTA-EXB15	SBTA-QR5.28X1.78	FLAT RING-SW-S5
SBTS20S-JHP	SBTA-IK-HOP	SBTA-IK-SP1	SBTA-IK-SP2	SBTA-ZEN20	SBTA-EXB20	SBTA-QR5.28X1.78	FLAT RING-SW-S5
SBTS25S-JHP	SBTA-IK-HOP	SBTA-IK-SP1	SBTA-IK-SP2	SBTA-ZEN25	SBTA-EXB25	SBTA-QR5.28X1.78	FLAT RING-SW-S5
SBTS30S-JHP	SBTA-IK-HOP	SBTA-IK-SP1	SBTA-IK-SP2	SBTA-ZEN30	SBTA-EXB30	SBTA-QR5.28X1.78	FLAT RING-SW-S5

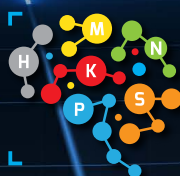
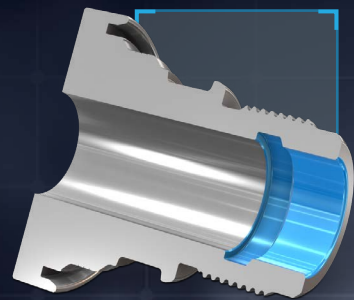
Spare Parts

Designation							
SBTS10S	SR M5X25 DIN7984	SR M5X35 DIN7984	SR M5X40 DIN7984	SR M5X45 DIN7984	SR M5X50 DIN7984	SR M5X55 DIN7984	SR M8X1X8 DIN906
SBTS15S-JHP	SR M5X30 DIN7984	SR M5X40 DIN7984	SR M5X45 DIN7984	SR M5X50 DIN7984	SR M5X55 DIN7984	SR M5X60 DIN7984	SR M8X1X8 DIN906
SBTS20S-JHP	SR M5X35 DIN7984	SR M5X45 DIN7984	SR M5X50 DIN7984	SR M5X55 DIN7984	SR M5X60 DIN7984	SR M5X65 DIN7984	SR M8X1X8 DIN906
SBTS25S-JHP	SR M5X45 DIN7984	SR M5X50 DIN7984	SR M5X55 DIN7984	SR M5X60 DIN7984	SR M5X65 DIN7984	SR M5X70 DIN7984	SR M8X1X8 DIN906
SBTS30S-JHP		SR M5X45 DIN7984	SR M5X55 DIN7984	SR M5X65 DIN7984	SR M5X70 DIN7984	SR M5X75 DIN7984	SR M8X1X8 DIN906



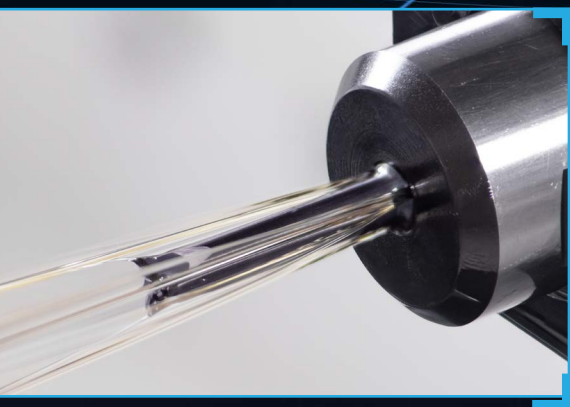
PICCO3CUT

Multi-Cornered PICCO-CUT
Inserts with 3 Precise
Cutting Edges Designed
for Miniature Applications



YOU Turning
Intelligently?

.....
High Precision PICCO-3-CUT for
Accurate Parts and Reduced
Tool Stock. Coolant Through Three
Sides of the Insert Directed to the
Cutting Edges.
.....



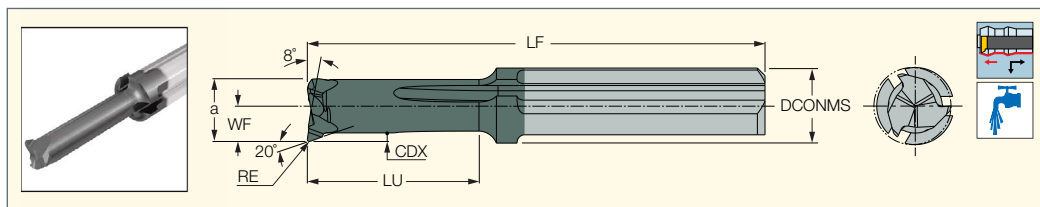
SCAN ME



PICCO³CUT

PMC R/L

Inserts with Three Cutting Edges for Internal Turning and Chamfering



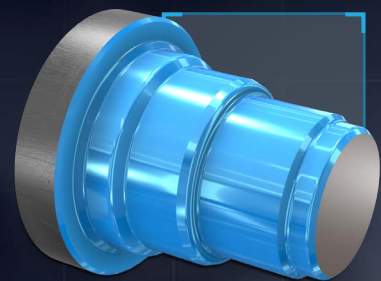
Designation	Dimensions								IC908	Recommended Machining Data	
	DCONMS	D min	CDX	LU	RE	LF	a	WF		a _p (mm)	f (mm/rev)
PMC R/LT20D30R10-10	4.00	3.00	0.20	9.30	0.10	24.00	2.40	1.35	●	0.00-0.15	0.012-0.036
PMC R/LT20D30R10-15	4.00	3.00	0.20	14.30	0.10	29.00	2.40	1.35	●	0.00-0.15	0.012-0.036
PMC R/LT20D30R10-20	4.00	3.00	0.20	19.30	0.10	34.00	2.40	1.35	●	0.00-0.15	0.012-0.036
PMC R/LT20D40R10-10	4.00	4.00	0.30	9.30	0.10	24.00	3.30	1.85	●	0.00-0.20	0.016-0.048
PMC R/LT20D40R10-15	4.00	4.00	0.30	14.30	0.10	29.00	3.30	1.85	●	0.00-0.20	0.016-0.048
PMC R/LT20D40R10-20	4.00	4.00	0.30	19.30	0.10	34.00	3.30	1.85	●	0.00-0.20	0.016-0.048
PMC R/LT20D40R10-25	4.00	4.00	0.30	24.30	0.10	39.00	3.30	1.85	●	0.00-0.20	0.016-0.048
PMC R/LT20D50R15-10	5.00	5.00	0.50	9.30	0.15	25.00	4.00	2.30	●	0.00-0.25	0.020-0.060
PMC R/LT20D50R15-20	5.00	5.00	0.50	19.30	0.15	35.00	4.00	2.30	●	0.00-0.25	0.020-0.060
PMC R/LT20D50R15-25	5.00	5.00	0.50	24.30	0.15	40.00	4.00	2.30	●	0.00-0.25	0.020-0.060
PMC R/LT20D50R15-35	5.00	5.00	0.50	34.30	0.15	50.00	4.00	2.30	●	0.00-0.25	0.020-0.060
PMC R/LT20D60R15-15	6.00	6.00	0.50	14.30	0.15	30.00	5.00	2.80	●	0.00-0.30	0.024-0.072
PMC R/LT20D60R15-25	6.00	6.00	0.50	24.30	0.15	40.00	5.00	2.80	●	0.00-0.30	0.024-0.072
PMC R/LT20D60R15-30	6.00	6.00	0.50	29.30	0.15	45.00	5.00	2.80	●	0.00-0.30	0.024-0.072
PMC R/LT20D60R15-40	6.00	6.00	0.50	39.30	0.15	55.00	5.00	2.80	●	0.00-0.30	0.024-0.072
PMC R/LT20D70R15-20	7.00	7.00	0.60	19.30	0.15	35.00	5.90	3.30	●	0.00-0.35	0.028-0.084
PMC R/LT20D70R15-30	7.00	7.00	0.60	29.30	0.15	45.00	5.90	3.30	●	0.00-0.35	0.028-0.084
PMC R/LT20D70R15-40	7.00	7.00	0.60	39.30	0.15	55.00	5.90	3.30	●	0.00-0.35	0.028-0.084
PMC R/LT20D70R15-50	7.00	7.00	0.60	49.30	0.15	65.00	5.90	3.30	●	0.00-0.35	0.028-0.084

- Specify right- or left-hand bars

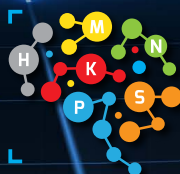


LOGIQUICK^{FINISH} 6TURN

Six Positive Cutting Edge
Insert for Semi Finishing and
Finishing Guarantees Excellent
Surface Quality



An Economic Alternative to Positive
Inserts with 2 Cutting Edges.



YOU Turning Intelligently?

Positive Insert, Easy Soft Cut, Less
Cutting Forces with Low Power
Consumption, Reduces Burrs
on Steel, Stainless Steel and
Titanium Parts.



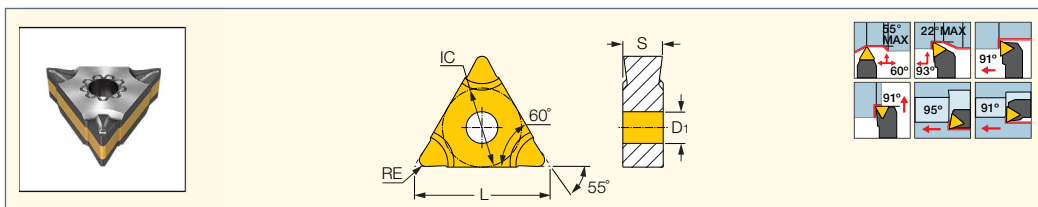
SCAN ME



LOGIQ6^{FINISH}TURN

D6NMG-F3P

Double-Sided Triangular Inserts with 55° Corner Angle and a Positive Rake Angle, for Finishing ISO-P Materials



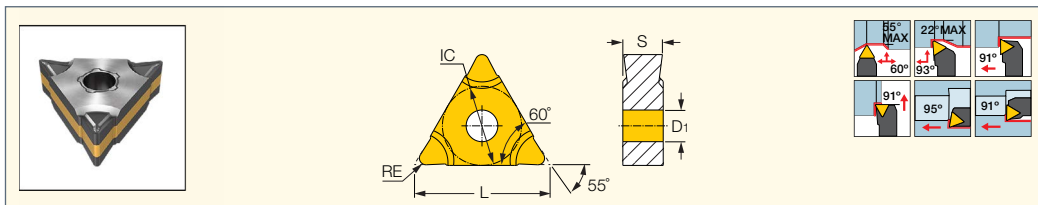
Designation	Dimensions					Tough ↔ Hard					Recommended Machining Data	
	L	IC	S	RE	D1	IC830	IC8250	IC8150	IC520N	IC807	a _p (mm)	f (mm/rev)
D6NMG 160404-F3P	16.47	9.52	4.76	0.40	3.81	•	•	•	•	•	0.50-2.50	0.050-0.250
D6NMG 160408-F3P	16.47	9.52	4.76	0.80	3.81	•	•	•	•	•	0.80-2.50	0.070-0.250

• The LOGIQ-6-TURN inserts fit standard holders also suitable for TNMG inserts

LOGIQ6^{FINISH}TURN

D6NMG-M3P

Double-Sided Triangular Inserts with 55° Corner Angle and a Positive Rake Angle, for Semi-Finishing and Finishing ISO-P



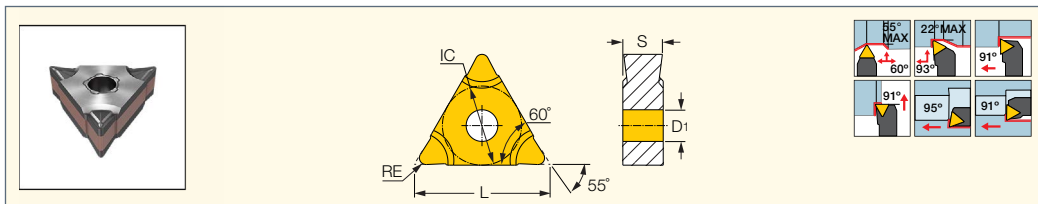
Designation	Dimensions					Tough ↔ Hard						Recommended Machining Data	
	L	IC	S	RE	D1	IC830	IC8250	IC8150	IC5010	IC5005	IC807	a _p (mm)	f (mm/rev)
D6NMG 160404-M3P	16.47	9.52	4.76	0.40	3.81	●	●	●	●	●	●	0.50-2.50	0.050-0.250
D6NMG 160408-M3P	16.47	9.52	4.76	0.80	3.81	●	●	●	●	●	●	0.80-2.50	0.070-0.250
D6NMG 160412-M3P	16.47	9.52	4.76	1.20	3.81	●	●	●	●	●	●	1.00-2.50	0.080-0.250

• The LOGIQ-6-TURN inserts fit standard holders also suitable for TNMG inserts

LOGIQ6^{FINISH}TURN

D6NMG-M3M

Double-Sided Triangular Inserts with 55° Corner Angle and a Positive Rake Angle, for Semi-Finishing and Finishing ISO-M



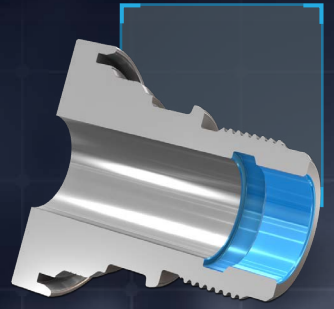
Designation	Dimensions					Tough ↔ Hard							Recommended Machining Data	
	L	IC	S	RE	D1	IC830	IC6025	IC6015	IC806	IC1017	IC807	IC706	a _p (mm)	f (mm/rev)
D6NMG 160404-M3M	16.47	9.52	4.76	0.40	3.81	●	●	●	●	●	●	●	0.50-2.50	0.050-0.250
D6NMG 160408-M3M	16.47	9.52	4.76	0.80	3.81	●	●	●	●	●	●	●	0.80-2.50	0.070-0.250
D6NMG 160412-M3M	16.47	9.52	4.76	1.20	3.81	●	●	●	●	●	●	●	1.00-2.50	0.080-0.250

• The LOGIQ-6-TURN inserts fit standard holders also suitable for TNMG inserts

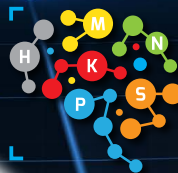
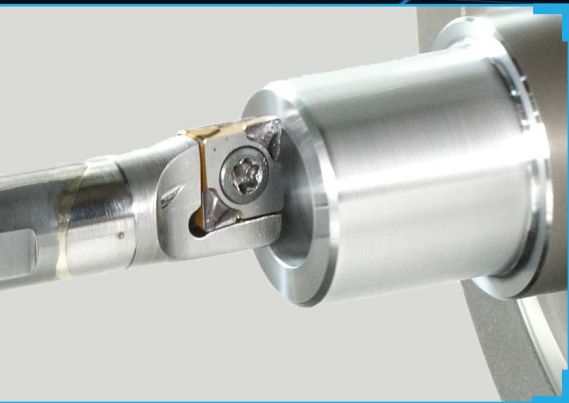


LOGIQ4TURN

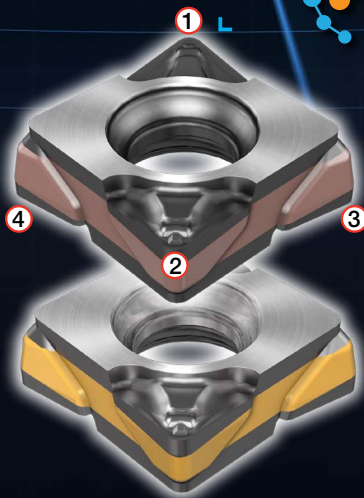
Positive Rake
Inserts for Miniature
and Small Parts



Designed for External and
Internal Turning with Shanks.
Fits Swiss Machines.



YOU Turning Intelligently?



80° Double-Sided Positive Insert.
Clamped in a
Dove-Tail Shaped Pocket
for Better Insert Stability
and Longer Tool Life.

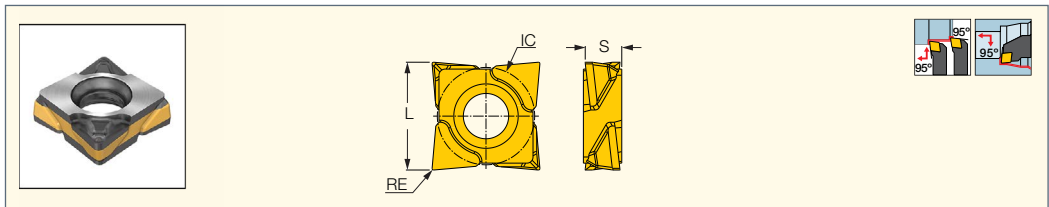
SCAN ME



LOGIQ4TURN

CXMU-F3P

80° Double-Sided and Double-Positive Inserts with a Positive Rake for Finishing Alloyed Steel

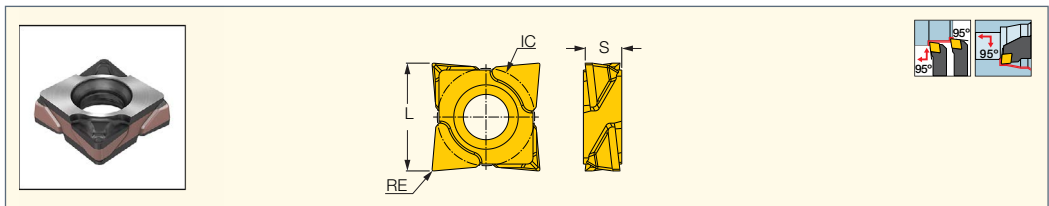


Designation	Dimensions				Tough ↔ Hard				Recommended Machining Data	
	L	IC	S	RE	IC8250	IC1008	IC8150	IC807	a _p (mm)	f (mm/rev)
CXMU 060202-F3P	7.00	6.34	2.38	0.20	•	•	•	•	0.30-2.00	0.050-0.250
CXMU 060204-F3P	6.96	6.34	2.38	0.40	•	•	•	•	0.50-2.00	0.050-0.250
CXMU 060208-F3P	6.88	6.34	2.38	0.80	•	•	•	•	0.80-2.00	0.070-0.250

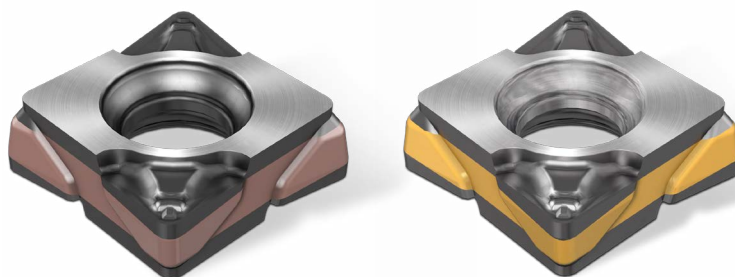
LOGIQ4TURN

CXMU-F3M

80° Double-Sided and Double-Positive Inserts with a Positive Rake for Finishing Stainless Steel and H.T.A.



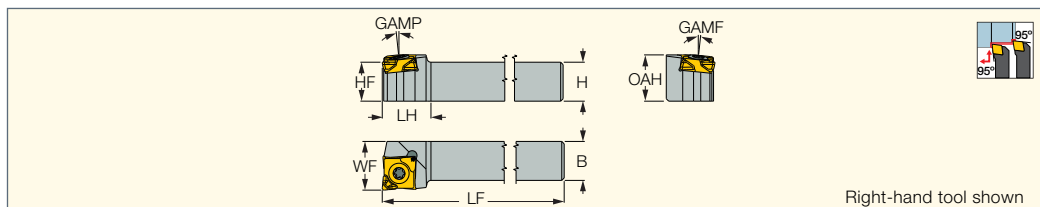
Designation	Dimensions				Tough ↔ Hard						Recommended Machining Data	
	L	IC	S	RE	IC6025	IC1008	IC6015	IC806	IC807	IC706	a _p (mm)	f (mm/rev)
CXMU 060202-F3M	7.00	6.34	2.38	0.20	•	•	•	•	•	•	0.30-2.00	0.050-0.250
CXMU 060204-F3M	6.96	6.34	2.38	0.40	•	•	•	•	•	•	0.50-2.00	0.050-0.250
CXMU 060208-F3M	6.88	6.34	2.38	0.80	•	•	•	•	•	•	0.80-2.00	0.070-0.250



LOGIQ4TURN

SCLXR/L 06X

Screw Lock Carrying CXMU
80° Rhombic Inserts



Right-hand tool shown

Designation	B	H	HF	LF	LH	WF	OAH	GAMP ⁽¹⁾	GAMF ⁽²⁾	MIID ⁽³⁾
SCLXR/L 0808F-06X	8.0	8.0	8.00	80.00	10.0	10.00	9.50	6.0	6.0	CXMU 060204

⁽¹⁾ Rake angle axial

⁽²⁾ Rake angle radial

⁽³⁾ Master insert identification

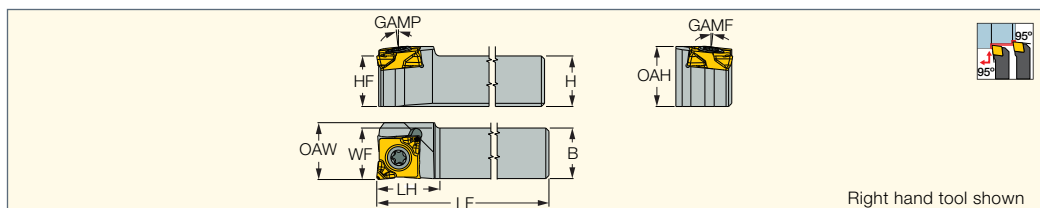
Spare Parts

Designation		
SCLXR/L 06X	SR M2.5-T8-MT	T-8/5

LOGIQ4TURN

SCLXR/L 06XS

Screw Lock Carrying CXMU 80°
Rhombic Inserts for
Swiss-Type Automatic Lathes



Right hand tool shown

Designation	B	H	HF	LF	LH	WF	OAW	OAH	GAMP ⁽¹⁾	GAMF ⁽²⁾	MIID ⁽³⁾
SCLXR/L 0808K-06XS	8.0	8.0	8.00	125.00	10.0	8.15	9.00	9.50	6.0	6.0	CXMU 060204

⁽¹⁾ Rake angle axial

⁽²⁾ Rake angle radial

⁽³⁾ Master insert identification

Spare Parts

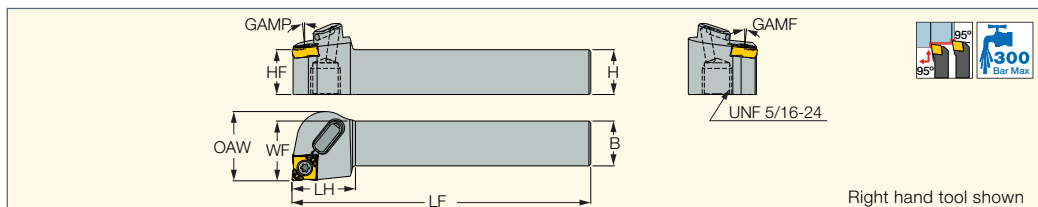
Designation		
SCLXR/L 06XS	SR M2.5-T8-MT	T-8/5



LOGIC4TURN

SCLXR/L 06X-JHP

Screw Lock Tools with
Channel for High-Pressure
Coolant Carrying CXMU
80° Rhombic Inserts



Right hand tool shown

Designation	B	H	HF	LF	LH	WF	OAW	GAMP ⁽¹⁾	GAMF ⁽²⁾	MIID ⁽³⁾
SCLXR/L 1010F-06X-JHP	10.0	10.0	10.00	80.00	17.0	12.00	18.50	6.0	6.0	CXMU 060208
SCLXR/L 1212F-06X-JHP	12.0	12.0	12.00	80.00	17.0	16.00	18.50	6.0	6.0	CXMU 060208
SCLXR/L 1616H-06X-JHP	16.0	16.0	16.00	100.00	17.0	20.00	20.00	6.0	6.0	CXMU 060208

(1) Rake angle axial

(2) Rake angle radial

(3) Master insert identification

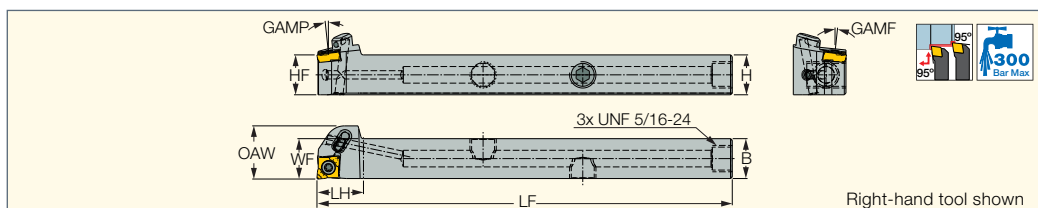
Spare Parts

Designation		
SCLXR/L 06X-JHP	SR M2.5-T8-MT	T-8/5

LOGIC4TURN

SCLXR/L 06XS-JHP-MC

Screw Lock Tools with
JET-CUT Coolant System
Carrying CXMU 80° Rhombic
Inserts for Swiss-Type
Automatic Lathes



Right-hand tool shown

Designation	B	H	HF	LF	LH	WF	OAW	GAMP ⁽¹⁾	GAMF ⁽²⁾	MIID ⁽³⁾
SCLXR/L 1010K-06XS-JHP-MC	10.0	10.0	10.00	125.00	14.0	10.15	16.00	6.0	6.0	CXMU 060208
SCLXR/L 1212K-06XS-JHP-MC	12.0	12.0	12.00	125.00	14.0	12.15	16.00	6.0	6.0	CXMU 060208
SCLXR/L 1616K-06XS-JHP-MC	16.0	16.0	16.00	125.00	14.0	16.15	16.15	6.0	6.0	CXMU 060208

(1) Rake angle axial

(2) Rake angle radial

(3) Master insert identification

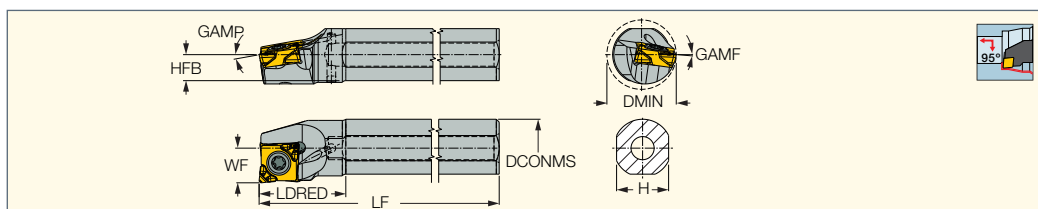
Spare Parts

Designation				
SCLXR/L 06XS-JHP-MC	SR M2.5-T8-MT	T-8/5	SR 5/16UNF TL360	SR M3X3 DIN913 TL360

LOGIC4TURN

A/E-SCLXR/L-06X

Screw Lock Boring Bars on
which CXMU 80° Rhombic
Inserts are Mounted



Designation	DCONMS	LF	LDRED	H	HFB	WF	DMIN	GAMP ⁽¹⁾	GAMF ⁽²⁾	MIID ⁽³⁾
A08H SCLXR/L-06X	8.00	100.00	12.0	7.2	3.6	5.00	10.00	8.0	10.0	CXMU 060208
E08K SCLXR/L-06X	8.00	125.00	19.0	7.2	3.6	5.00	10.00	8.0	10.0	CXMU 060208
A10K SCLXR/L-06X	10.00	125.00	15.0	9.0	4.5	6.00	12.00	8.0	8.0	CXMU 060208
E10M SCLXR/L-06X	10.00	150.00	21.5	9.0	4.5	6.00	12.00	8.0	8.0	CXMU 060208
A12M SCLXR/L-06X	12.00	150.00	18.0	11.0	5.5	9.00	16.00	8.0	8.0	CXMU 060208
E12Q SCLXR/L-06X	12.00	180.00	25.0	11.0	5.5	9.00	16.00	8.0	8.0	CXMU 060208

• A - steel shank with coolant hole, E - carbide shank with coolant hole

(1) Rake angle axial

(2) Rake angle radial

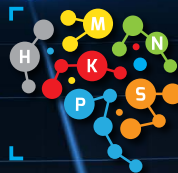
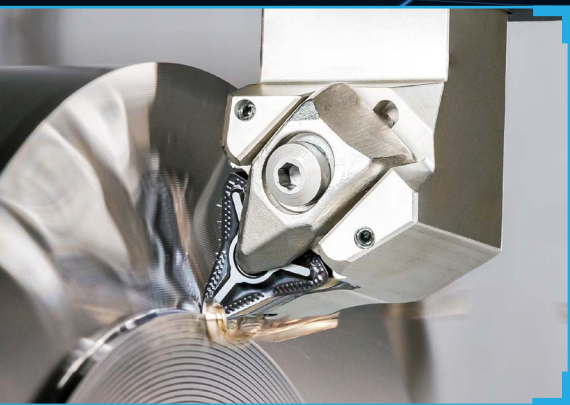
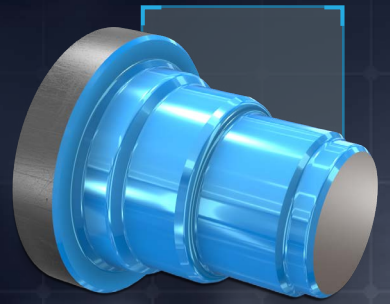
(3) Master insert identification

Spare Parts

Designation		
A/E-SCLXR/L-06X	SR M2.5-T8-MT	T-8/5

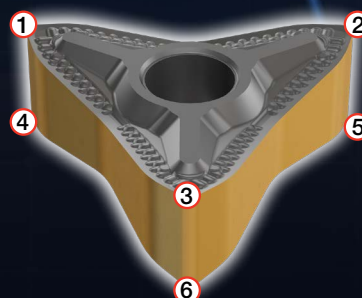
QUICKTURN

**6 Cutting Edge Turning
Insert for Multi Directional
Facing and Profiling
Applications with
High Productivity**



**YOU Turning
Intelligently?**

.....
Highly Versatile Insert Used in All
Turning Directions. Saves Time and
Provides Productivity Gains with
Back-Turning.
.....



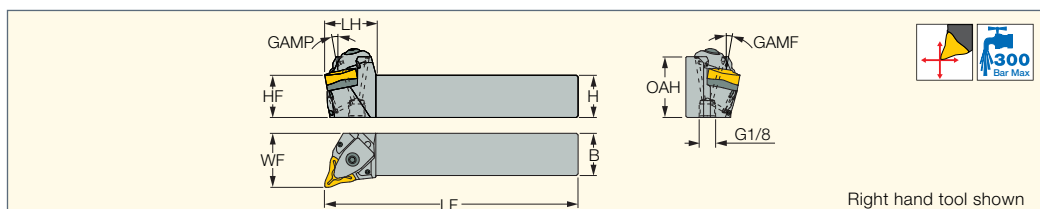
SCAN ME



QUICKTURN

Q6-DMXNR/L-SL-JHP

Safety Lock Tools with High Feed Negative Inserts for Roughing Applications



Designation	H	OAH	HF	B	LF	LH	WF	GAMP ⁽¹⁾	GAMF ⁽²⁾	MIID ⁽³⁾
Q6-DMXNR/L 2525M-12-SL-JHP	25.0	36.00	25.0	25.0	150.00	31.0	32.00	7.8	7.8	Q6-MNMG120608-M3#-SL
Q6-DMXNR/L 3232P-12-SL-JHP	32.0	43.00	32.0	32.0	170.00	31.0	39.00	7.8	7.8	Q6-MNMG120608-M3#-SL

⁽¹⁾ Rake angle axial

⁽²⁾ Rake angle radial

⁽³⁾ Master insert identification

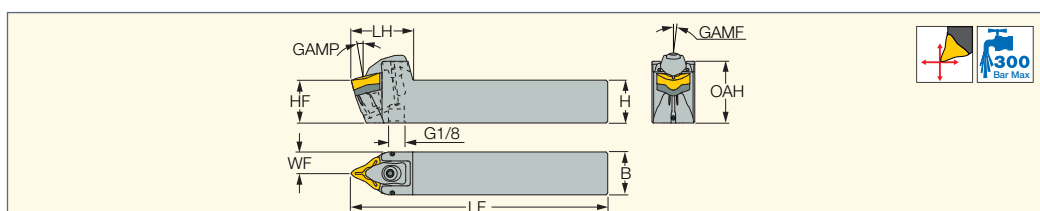
Spare Parts

Designation							
Q6-DMXNR/L-SL-JHP	Q6-TMN 1206-SL	SR M2.5X2.5 DIN913 TL360	HW 3.0	SR 10513105-L10.5	DSP 4	DLS 4	DLM 4

QUICKTURN

Q6-DMXNN-SL-JHP

Safety Lock Tools with High Feed Negative Inserts for Roughing Applications



Designation	H	OAH	HF	B	LF	LH	WF	GAMP ⁽¹⁾	GAMF ⁽²⁾	MIID ⁽³⁾
Q6-DMXNN 2525M-12-SL-JHP	25.0	36.00	25.0	25.0	150.00	37.0	12.50	11.0	0.0	Q6-MNMG1206#-M3#-SL
Q6-DMXNN 3232P-12-SL-JHP	32.0	43.00	32.0	32.0	170.00	37.0	16.00	11.0	0.0	Q6-MNMG1206#-M3#-SL

⁽¹⁾ Rake angle axial

⁽²⁾ Rake angle radial

⁽³⁾ Master insert identification

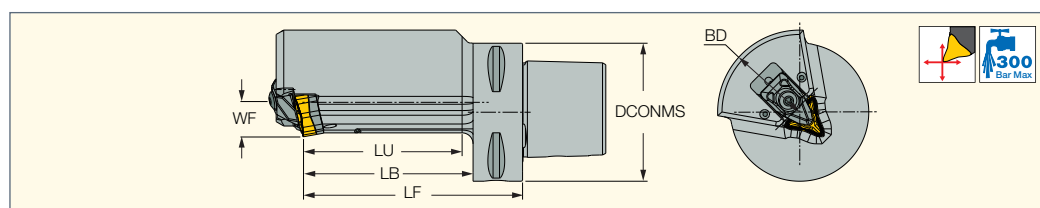
Spare Parts

Designation							
Q6-DMXNN-SL-JHP	SR 10513105-L10.5	Q6-TMN 1206-SL	HW 3.0	DSP 4	DLS 4	DLM 4	SR M2.5X2.5 DIN913 TL360

QUICKTURN

C#-Q6-DMXNN-SL-Y

Y-Axis Turning Tools with a Safety Lock Clamping Mechanism for Negative Inserts, Intended for Roughing and Medium Applications



Designation	BD	LF	LB	LU	WF	DCONMS	MIID ⁽¹⁾
C4 Q6-DMXNN-12-SL-H065-Y	40.20	65.00	44.40	34.40	11.20	40.00	Q6-MNMG1206
C5 Q6-DMXNN-12-SL-H080-Y	50.20	80.00	59.40	44.40	11.20	50.00	Q6-MNMG1206
C6 Q6-DMXNN-12-SL-H100-Y	63.20	100.00	77.40	62.40	11.20	63.00	Q6-MNMG1206
C8 Q6-DMXNN-12-SL-H100-Y	80.00	100.00	70.00	55.00	11.20	80.00	Q6-MNMG1206

⁽¹⁾ Master insert identification

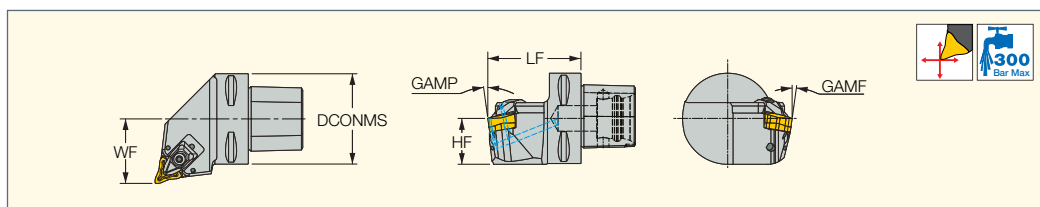
Spare Parts

Designation								
C#-Q6-DMXNN-SL-Y	SR 10513105-L10.5	Q6-TMN 1206-SL	HW 3.0	DSP 4	DLS 4	DLM 4	SR M4X4 DIN913 TL360	SR M2.5X2.5 DIN913 TL360

QUICKTURN

C#-Q6-DMXNR/L-SL

Safety Lock Tools with CAMFIX Shanks for High Feed Negative Inserts for Roughing Applications



Designation	LF	h1	WF	DCONMS	GAMP ⁽¹⁾	GAMF ⁽²⁾	MIID ⁽³⁾
C4 Q6-DMXNR/L-27050-12-SL	50.00	26.0	27.00	40.00	7.8	7.8	Q6-MNMG1206#-M3#-SL
C5 Q6-DMXNR/L-35060-12-SL	60.00	25.5	35.00	50.00	7.8	7.8	Q6-MNMG1206#-M3#-SL
C6 Q6-DMXNR/L-45065-12-SL	65.00	32.5	45.00	63.00	7.8	7.8	Q6-MNMG1206#-M3#-SL
C8 Q6-DMXNR/L-55080-12-SL	80.00	41.0	55.00	80.00	7.8	7.8	Q6-MNMG1206#-M3#-SL

⁽¹⁾ Rake angle axial

⁽²⁾ Rake angle radial

⁽³⁾ Master insert identification

Spare Parts

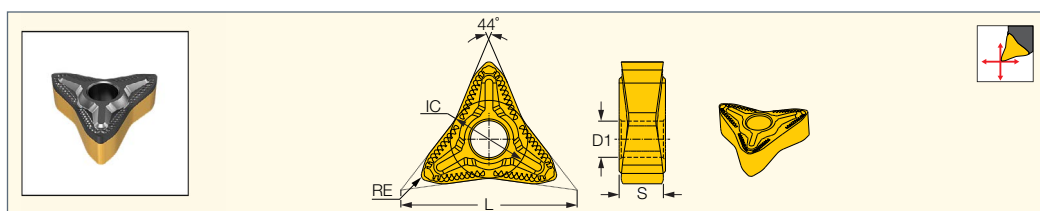
Designation									
C4 Q6-DMXNR/L-27050-12-SL	DLM 4	DLS 4	DSP 4	HW 3.0	Q6-TMN 1206-SL	SR 10513105-L10.5	SR M5X5 DIN913 TL360	SR M2.5X2.5 DIN913 TL360	L-KEY TORX PLUS IP20 62MM
C5 Q6-DMXNR/L-35060-12-SL	DLM 4	DLS 4	DSP 4	HW 3.0	Q6-TMN 1206-SL	SR 10513105-L10.5	SR M5X5 DIN913 TL360	SR M2.5X2.5 DIN913 TL360	L-KEY TORX PLUS IP20 62MM
C6 Q6-DMXNR/L-45065-12-SL	DLM 4	DLS 4	DSP 4	HW 3.0	Q6-TMN 1206-SL	SR 10513105-L10.5	SR M5X5 DIN913 TL360	SR M2.5X2.5 DIN913 TL360	L-KEY TORX PLUS IP20 62MM
C8 Q6-DMXNR/L-55080-12-SL	DLM 4	DLS 4	DSP 4	HW 3.0	Q6-TMN 1206-SL	SR 10513105-L10.5	SR M5X5 DIN913 TL360	SR M2.5X2.5 DIN913 TL360	L-KEY TORX PLUS IP20 62MM*

* Optional, to be ordered separately

QUICKTURN

Q6-MNMG-M3P-SL

High Feed Insert with Six Reinforced Cutting Edges and Negative Flank for Roughing Applications

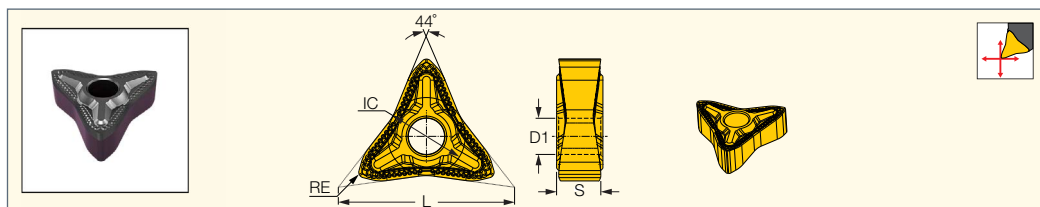


Designation	Dimensions					Tough ↔ Hard			Recommended Machining Data			
	L	D1	IC	S	RE	IC8250	IC8150	IC807	a _p (Forward machining) (mm)	a _p (Backward machining) (mm)	Feed turning (Forward machining)	Feed turning (Backward machining)
Q6-MNMG120608-M3P-SL	25.10	5.15	11.05	6.30	0.80	●	●	●	0.50-3.50	0.50-2.20	0.200-0.600	0.300-1.200

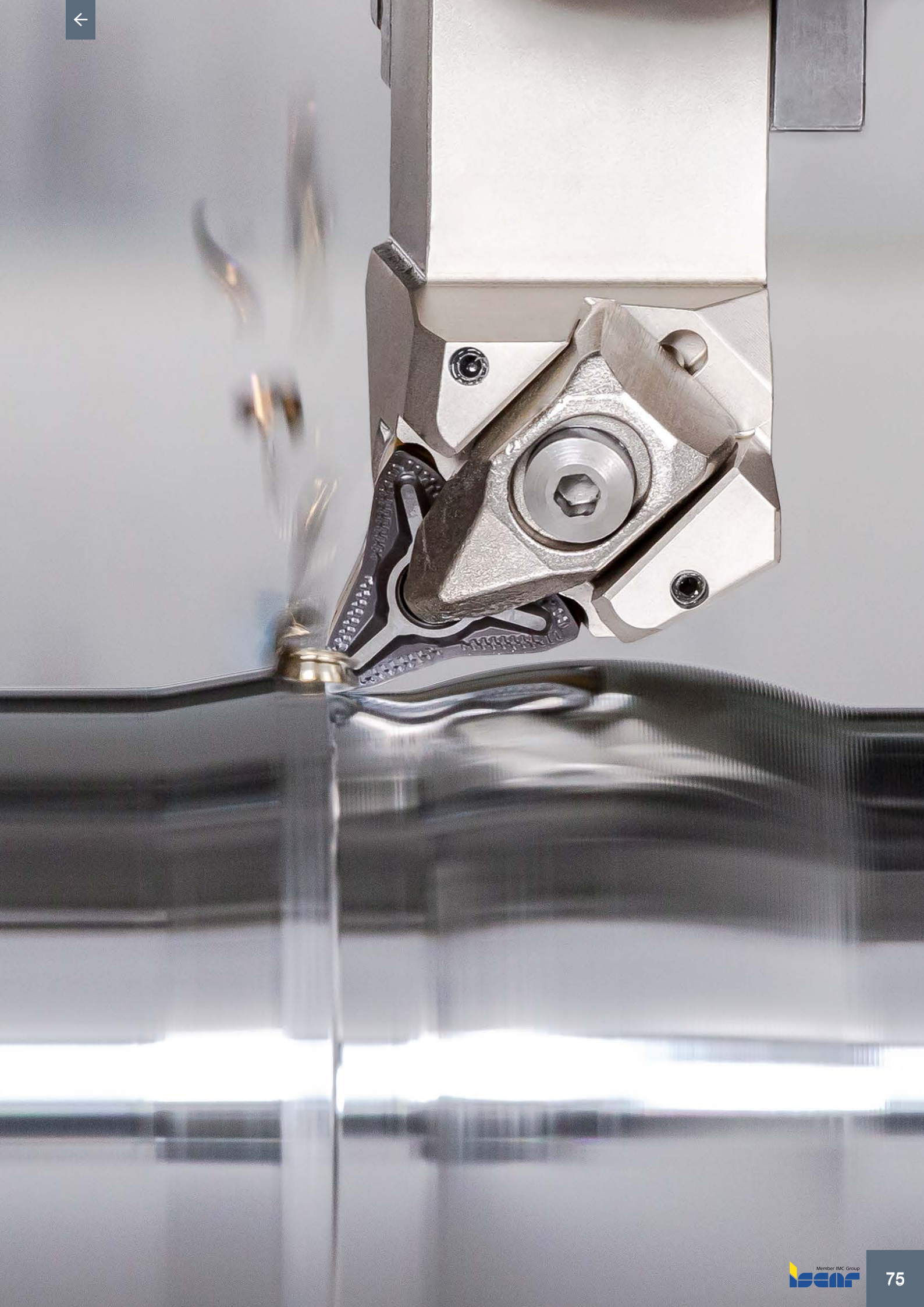
QUICKTURN

Q6-MNMG-M3M-SL

High Feed Insert with Six Reinforced Cutting Edges and Negative Flank for Roughing Applications

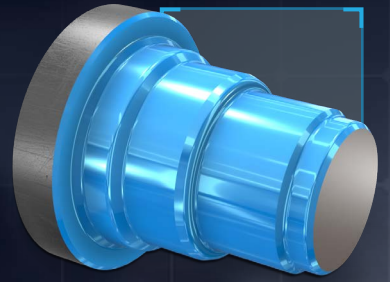


Designation	Dimensions					Tough ↔ Hard			Recommended Machining Data			
	L	D1	IC	S	RE	IC6025	IC6015	IC807	a _p (Forward machining) (mm)	a _p (Backward machining) (mm)	Feed turning (Forward machining)	Feed turning (Backward machining)
Q6-MNMG120608-M3M-SL	25.10	5.15	11.05	6.30	0.80	●	●	●	0.50-3.50	0.50-2.20	0.200-0.600	0.300-1.000

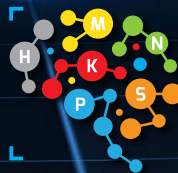
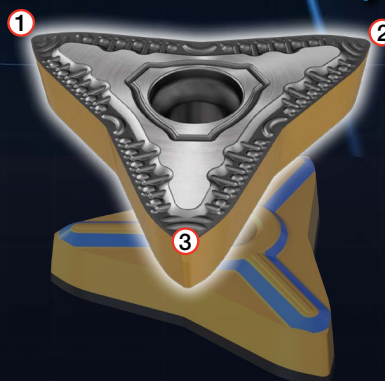


QUICK T LOCK

3 Cutting Edge Insert
with SAFE-T-LOCK for
Multi Directional and
High Productivity Turning



New Y-Axis QUICK-T-LOCK Holders
Withstand High Cutting Forces
Without Vibrations.



YOU Turning
Intelligently?

Highly Versatile Insert Used
in All Turning Directions.
Saves Time and Provides
Productivity Gains with
Back-Turning.

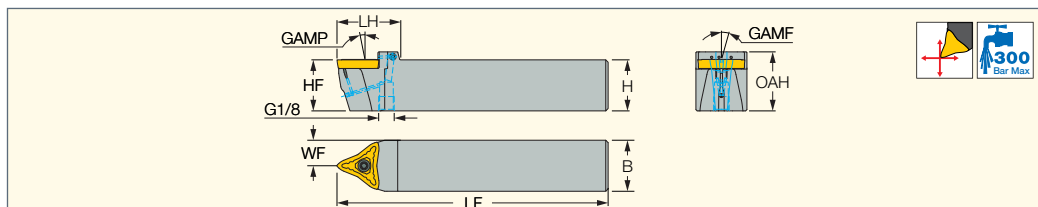
SCAN ME



QUICKTLOCK

Q3-SMXCN-SL-JHP

Safety Lock Tools on which High Feed Positive Inserts are Mounted for Roughing Applications



Designation	H	OAH	HF	B	LF	LH	WF	GAMP	GAMF	MIID ⁽¹⁾
Q3-SMXCN 2525M-16-SL-JHP	25.0	30.00	25.0	25.0	150.00	40.0	12.50	0.0	0.0	Q3-MCMT 1606#-R3#-SL
Q3-SMXCN 3232P-16-SL-JHP	32.0	37.00	32.0	32.0	170.00	40.0	16.00	0.0	0.0	Q3-MCMT 1606#-R3#-SL

⁽¹⁾ Master insert identification

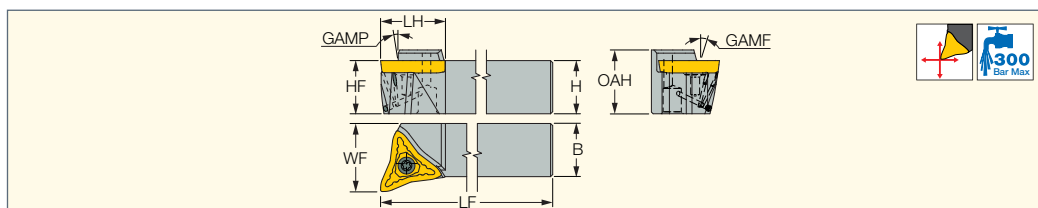
Spare Parts

Designation					
Q3-SMXCN-SL-JHP	SR M5-14 IP20	BLD IP20/M7	SW6-T	SR M4X4 DIN913 TL360	SR M2.5X2.5 DIN913 TL360

QUICKTLOCK

Q3-SMXCR/L-SL-JHP

Safety Lock Tools on which High Feed Positive Inserts are Mounted for Roughing Applications



Designation	H	OAH	HF	B	LF	LH	WF	GAMP	GAMF	MIID ⁽¹⁾
Q3-SMXCR/L 2525M-16-SL-JHP	25.0	30.00	25.0	25.0	150.00	31.0	32.00	0.0	0.0	Q3-MCMT 1606#-R3#-SL
Q3-SMXCR/L 3232P-16-SL-JHP	32.0	37.00	32.0	32.0	170.00	31.0	39.00	0.0	0.0	Q3-MCMT 1606#-R3#-SL

⁽¹⁾ Master insert identification

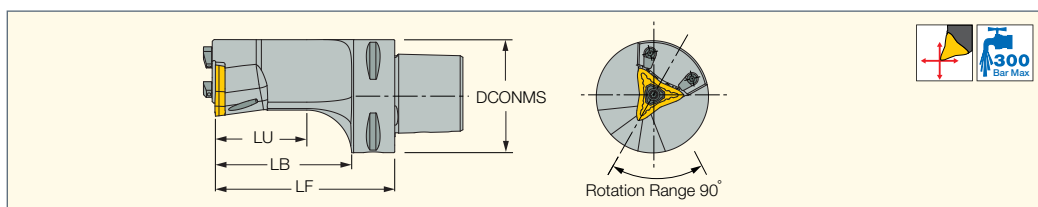
Spare Parts

Designation					
Q3-SMXCR/L 2525M-16-SL-JHP	SR M5-14 IP20	SW6-T	BLD IP20/M7	SR M4X4 DIN913 TL360	SR M2.5X2.5 DIN913 TL360
Q3-SMXCR/L 3232P-16-SL-JHP	SR M5-14 IP20	SW6-T	BLD IP20/M7	SR M4X4 DIN913 TL360	SR M2.5X2.5 DIN913 TL360

QUICKTLOCK

C#-Q3-SMXCN-SL-Y

Y-Axis Turning Tools with Safety Lock Clamping Mechanism for Positive Inserts, for Roughing and Medium Applications



Designation	DCONMS	LU	LB	LF	CSP ⁽¹⁾	MIID ⁽²⁾
C4 Q3-SMXCN-16-SL-H065-Y	40.00	38.50	43.50	65.00	1	Q3-MCMT1606
C5 Q3-SMXCN-16-SL-H080-Y	50.00	51.00	58.50	80.00	1	Q3-MCMT1606
C6 Q3-SMXCN-16-SL-H100-Y	63.00	51.00	76.00	100.00	1	Q3-MCMT1606
C8 Q3-SMXCN-16-SL-H100-Y	80.00	51.00	70.00	100.00	1	Q3-MCMT1606

• A cooling tube must be used with all coolant through HSK spindles (should be ordered separately).

⁽¹⁾ 0 - Without coolant supply, 1 - With coolant supply

⁽²⁾ Master insert identification

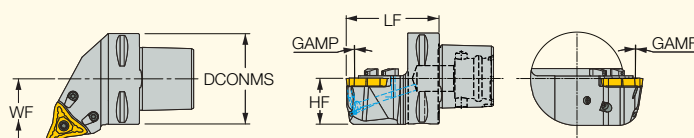
Spare Parts

Designation					
C4 Q3-SMXCN-16-SL-H065-Y	SR M5-14 IP20	SR M3X3 DIN913 TL360	BLD IP20/M7	SW6-T	CH-1.9D-JHP-A SET
C5 Q3-SMXCN-16-SL-H080-Y	SR M5-14 IP20	SR M5X5 DIN913 TL360	BLD IP20/M7	SW6-T	CH-1.9D-JHP-A SET
C6 Q3-SMXCN-16-SL-H100-Y	SR M5-14 IP20	SR M5X5 DIN913 TL360	BLD IP20/M7	SW6-T	CH-1.9D-JHP-A SET
C8 Q3-SMXCN-16-SL-H100-Y	SR M5-14 IP20	SR M5X5 DIN913 TL360	BLD IP20/M7	SW6-T	CH-1.9D-JHP-A SET

QUICKTLOCK

C#-Q3-SMXCR/L-SL

Safety Lock Tools with CAMFIX Shanks for High Feed Positive Inserts for Roughing Applications



Designation	LF	HF	WF	DCONMS	GAMP ⁽¹⁾	GAMF ⁽²⁾	MIID ⁽³⁾
C5 Q3-SMXCR/L-35060-16-SL	60.00	25.50	35.00	50.00	0.0	0.0	C# Q3-SMXCL/R-##-16-SL
C6 Q3-SMXCR/L-45065-16-SL	65.00	32.00	45.00	63.00	0.0	0.0	C# Q3-SMXCL/R-##-16-SL
C8 Q3-SMXCR/L-55080-16-SL	80.00	40.50	55.00	80.00	0.0	0.0	C# Q3-SMXCL/R-##-16-SL

• A cooling tube must be used with all coolant through HSK spindles (should be ordered separately).

⁽¹⁾ Rake angle axial

⁽²⁾ Rake angle radial

⁽³⁾ Master insert identification

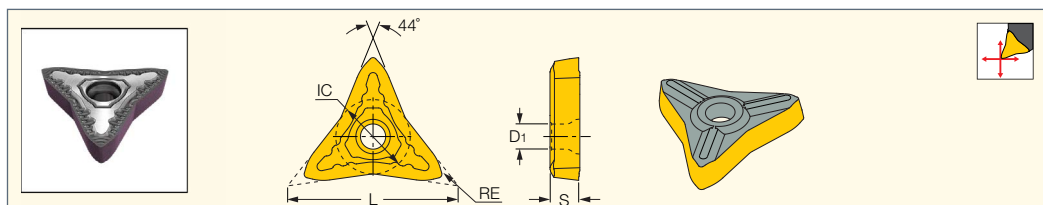
Spare Parts

Designation						
C#-Q3-SMXCR/L-SL	CH-1.9D-JHP-A SET	SR M5X5 DIN913 TL360	SW6-T	BLD IP20/M7	SR M5-14 IP20	SR M2.5X2.5 DIN913 TL360

QUICKTLOCK

Q3-MCMT-R3M-SL

High Feed Inserts with 3 Reinforced Cutting Edges and a Positive Flank

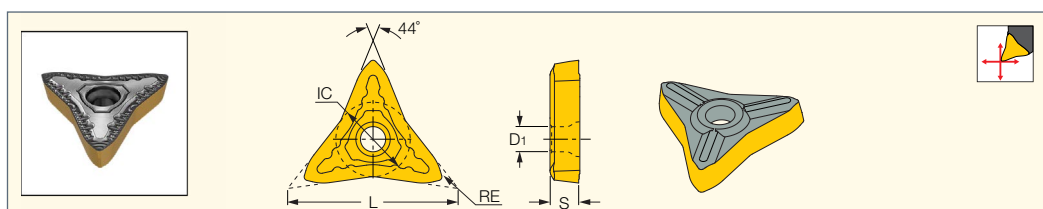


Designation	Dimensions					Tough ↔ Hard			Recommended Machining Data			
	L	IC	S	RE	D1	IC8025	IC6015	IC807	a _p (Forward machining) (mm)	a _p (Backward machining) (mm)	Feed turning (Forward machining)	Feed turning (Backward machining)
Q3-MCMT160608-R3M-SL	36.60	16.00	6.15	0.80	5.40	●	●	●	1.50-7.50	0.50-4.00	0.300-0.600	0.200-1.000

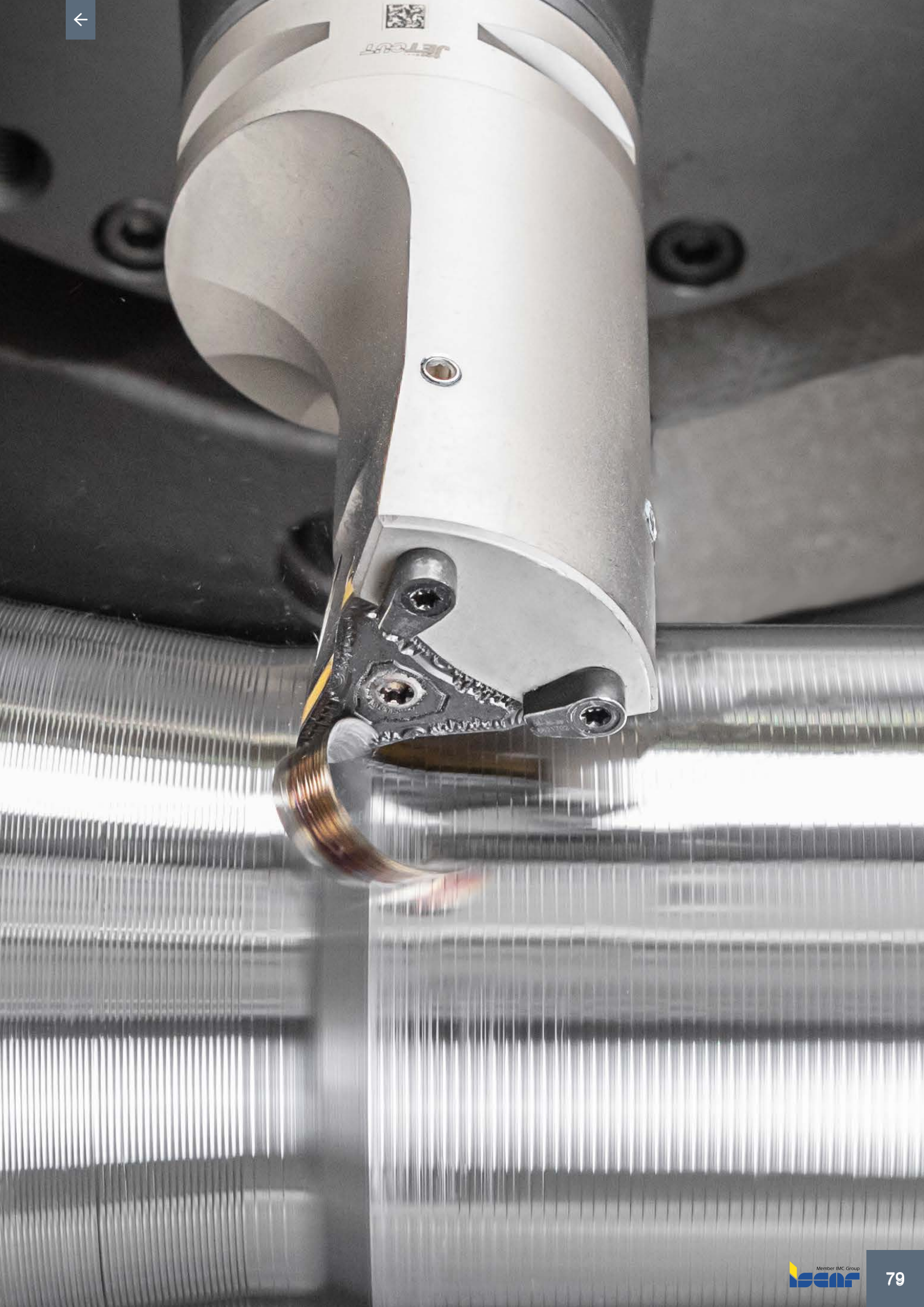
QUICKTLOCK

Q3-MCMT-R3P-SL

High Feed Inserts with 3 Reinforced Cutting Edges and a Positive Flank

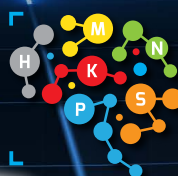
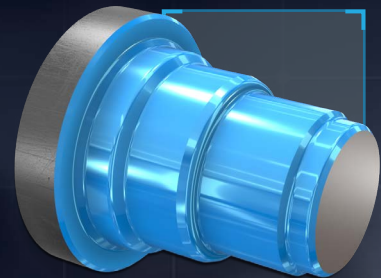


Designation	Dimensions					Tough ↔ Hard					Recommended Machining Data			
	L	IC	S	RE	D1	IC8250	IC8150	IC5010	IC5005	IC807	a _p (Forward machining) (mm)	a _p (Backward machining) (mm)	Feed turning (Forward machining)	Feed turning (Backward machining)
Q3-MCMT160608-R3P-SL	36.60	16.00	6.15	0.80	5.40	●	●	●	●	●	1.50-7.50	0.50-4.00	0.300-0.600	0.200-1.200



CER-M-TURN

Turning CAMFIX Holder
with 2 Indexable Cartridges
for RNGN Round and CNGN
Square Ceramic Inserts



YOU Turning
Intelligently?

Two Types of Indexable
Cartridges Fit the Same
CER-M-TURN Holder.

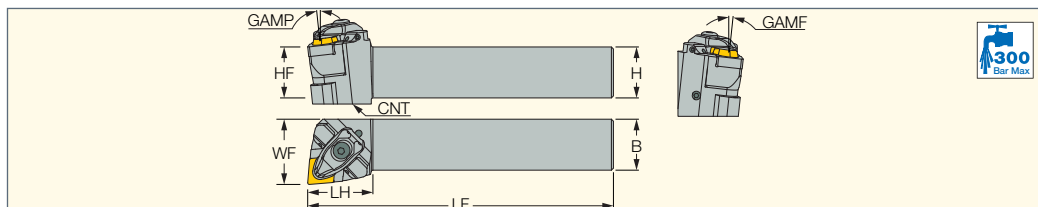
SCAN ME



CERMTURN

CXXNR/L-AD-JHP

Square Turning Tools with a Channel for High-Pressure Coolant, Carrying Inserts Mounted on Cartridges



Designation	B	H	HF	LF	LH	WF	CNT	GAMP ⁽¹⁾	GAMF ⁽²⁾
CXXNR/L 2525M-AD-09/12-JHP	25.0	25.0	25.0	150.00	32.0	32.00	G1/8	6.0	6.0
CXXNR/L 3232P-AD-09/12-JHP	32.0	32.0	32.0	170.00	32.0	40.00	G1/8	6.0	6.0

⁽¹⁾ Rake angle axial

⁽²⁾ Rake angle radial

Spare Parts

Designation							
CXXNR/L-AD-JHP	DCL S-4F	DLS 4	DSP 4	HW 3.0	SR M5X0.5X12.5	SR M4X4 DIN913 TL360	SW6-T-SH

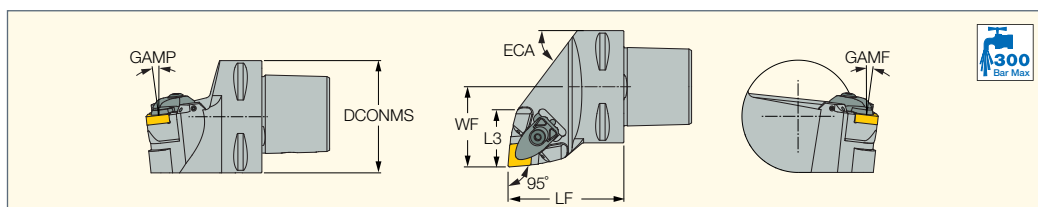
Designation					
CXXNR/L-AD-JHP	BLD IP20/S7	SR M2.5X2.5 DIN913 TL360	DLM 4-7063*	HC6CN-H.T*	SR M5X0.8-L22*

* Optional, to be ordered separately

CERMTURN

C#-CXXNR/L-AD-JHP

Turning Tools with CAMFIX Polygon Shaped Shanks with Indexable Inserts Mounted on Cartridges



Designation	DCONMS	WF	LF	L3	GAMP ⁽¹⁾	GAMF ⁽²⁾	ECA	DCP ⁽³⁾
C5 CXXNR/L-35060-AD09/12JHP	50.00	35.00	60.00	32.00	6.0	6.0	42.0	1
C6 CXXNR/L-45065-AD09/12JHP	63.00	45.00	65.00	32.00	6.0	6.0	53.0	1
C8 CXXNR/L-55080-AD09/12JHP	80.00	55.00	80.00	32.00	6.0	6.0	57.0	1

⁽¹⁾ Rake angle axial

⁽²⁾ Rake angle radial

⁽³⁾ 1 - Slot for data chip, 0 - Without slot for data chip

Spare Parts

Designation							
C#-CXXNR/L-AD-JHP	DCL S-4F	DLS 4	DSP 4	HW 3.0	SR M5X0.5X12.5	SR M4X4 DIN913 TL360	SW6-T-SH

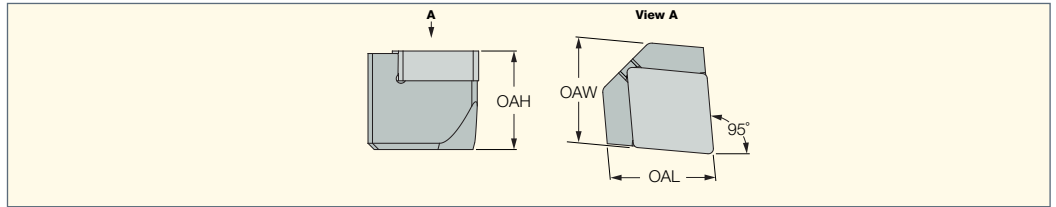
Designation						
C#-CXXNR/L-AD-JHP	BLD IP20/S7	SR M5X5 DIN913 TL360	SR M2.5X2.5 DIN913 TL360	DLM 4-7063*	HC6CN-H.T*	SR M5X0.8-L22*

* Optional, to be ordered separately

CERMTURN

AD-CCLNX

Indexable Cartridges for 80°
Rhombic Ceramic Inserts



Designation	OAH	OAW	OAL	MIID ⁽¹⁾
AD-CCLNX-1204	15.76	16.85	16.85	CNGN 1204
AD-CCLNX-1207	15.76	16.85	16.85	CNGN 1207

⁽¹⁾ Master insert identification

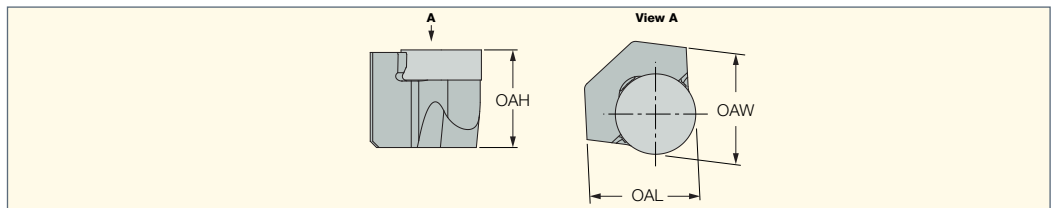
Spare Parts

Designation	
AD-CCLNX	SR M5X0.5X12.5

CERMTURN

AD-CRSNX

Indexable Cartridges for
Round Ceramic Inserts



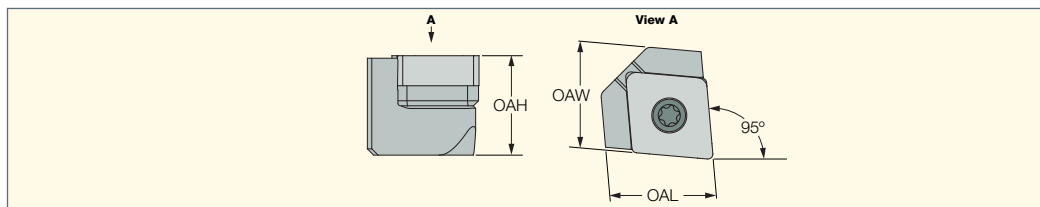
Designation	OAH	OAW	OAL	MIID ⁽¹⁾
AD-CRSNX-0903	15.42	17.21	17.21	RNGN 0903
AD-CRSNX-0904	15.42	17.21	17.21	RNGN 0904
AD-CRSNX-1204	15.42	17.36	17.36	RNGN 1204
AD-CRSNX-1207	15.44	17.36	17.36	RNGN 1207

⁽¹⁾ Master insert identification

Spare Parts

Designation	
AD-CRSNX	SR M5X0.5X12.5

AD-CCLNX-S

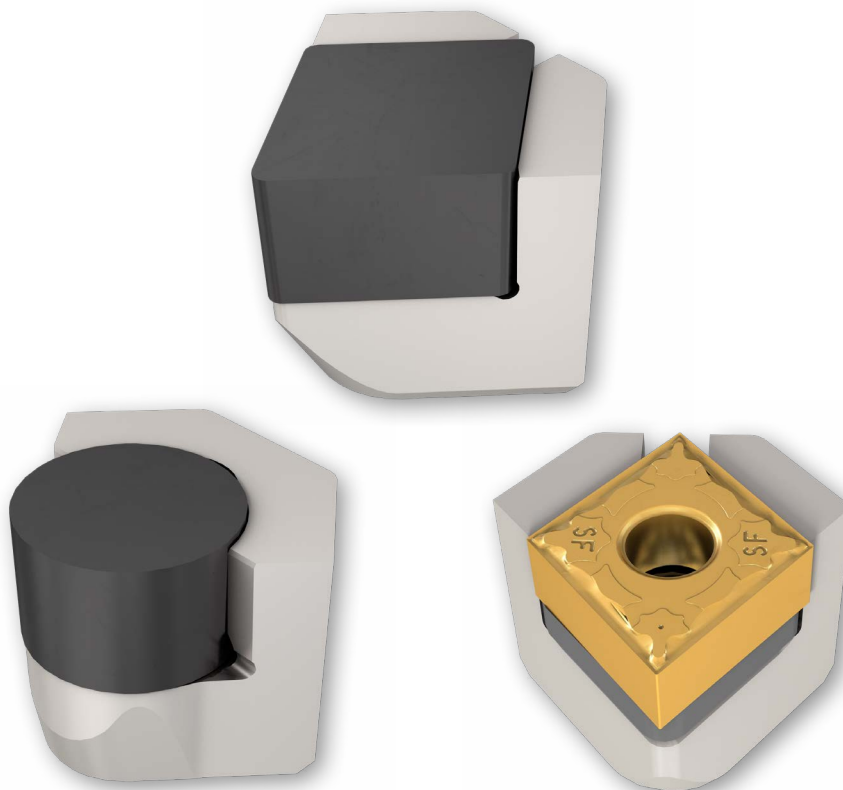
 Indexable Cartridges for
80° Rhombic Inserts


Designation	OAH	OAW	OAL	MIID ⁽¹⁾
AD-CCLNX-1204-S	15.76	16.85	16.85	CNGA 1204

⁽¹⁾ Master insert identification

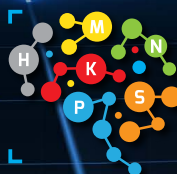
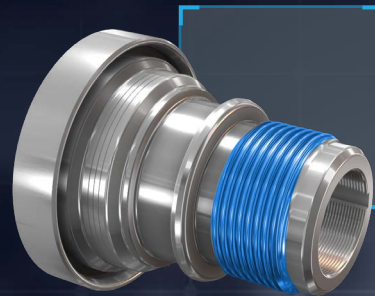
Spare Parts

Designation				
AD-CCLNX-1204-S	TSC 424	T-15/5	SR 76-2067/8.3	SR M5X0.5X12.5



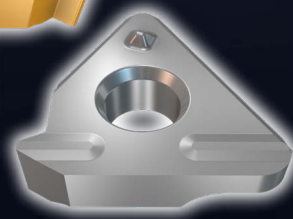
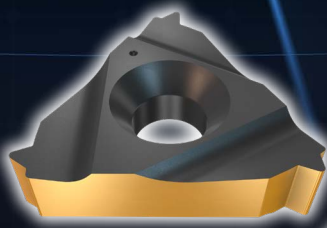
THREADQLOCK

Threading Inserts and Anvils
Based on Unique Insert
Position Provide
Longer Tool Life



YOU Turning
Intelligently?

.....
Ideal Clamping Position, and
Increased Rigidity During
Machining Processes.
.....

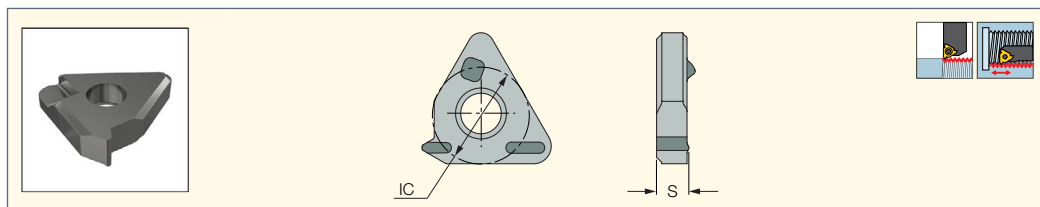


SCAN ME



THREADQLOCK

Thread Anvils AE-XG
Quick Lock Thread Anvils
for External Right &
Internal Left Inserts



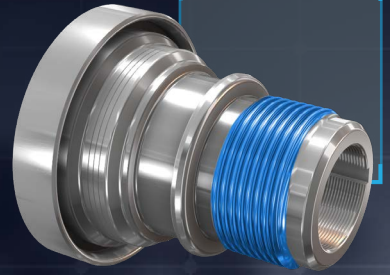
Designation	Dimensions			IC28
	IC	a°	S	
AE16-0.5-XG	9.53	-0.5	3.20	•
AE16+0.5-XG	9.53	0.5	3.20	•
AE16-1.5-XG	9.53	-1.5	3.20	•
AE16-XG	9.53	1.5	3.20	•
AE16-0-XG	9.53	1.5	3.20	•
AE16+2.5-XG	9.53	2.5	3.20	•
AE16+3.5-XG	9.53	3.5	3.20	•
AE16+4.5-XG	9.53	4.5	3.20	•

- Anvil suitable for standard ISO Type Tools and select ISCAR's Inserts. Three concave shapes assure the exact placement of the insert for stable cutting

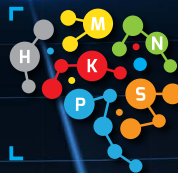


QUICKTHREAD

Reduce the Number of Passes When Performing Threading Applications on Lathes

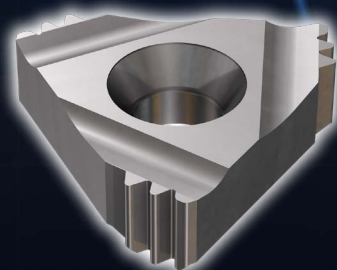


Decreases Cycle Times and Number of Passes by 75%.



YOU Turning Intelligently?

- Increased Productivity
- Reduced Cycle Times
- Longer Tool Life
- Improved Surface Finish
- Fewer Number of Passes Required
- Larger Thread Relief Required to Clear Multiple Teeth Upon Exit
- Tremendous Cost Savings



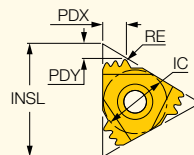
SCAN ME



QUICKTHREAD

ER-ISO 3M-Q

External ISO Metric (DIN13 12-1986 class: 6g) Laydown Threading Inserts for General Applications



Designation	Dimensions							IC908
	IC	TP ⁽¹⁾	INSL	RE	PDX	PDY		
16ER 0.75 ISO 3M-Q IC908	9.53	0.750	16.00	0.12	1.90	1.40		•
16ER 1.00 ISO 3M-Q IC908	9.53	1.000	16.00	0.13	2.50	1.70		•
22ER 1.50 ISO 3M-Q IC908	12.70	1.500	22.00	0.23	3.70	2.40		•
22ER 2.00 ISO 3M-Q IC908	12.70	2.000	22.00	0.26	4.80	2.90		•

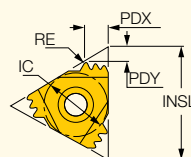
• For threading between walls use GRIP-type inserts TIP-ISO class: 6g

⁽¹⁾ Thread pitch

QUICKTHREAD

IR-ISO 3M-Q

Internal ISO Metric (DIN13 12-1986 class 6H) Laydown Threading Inserts for General Applications



Designation	Dimensions							IC908
	IC	PDX	PDY	INSL	RE	TP ⁽¹⁾	NT ⁽²⁾	
16IR 1.00 ISO 3M-Q IC908	9.53	2.50	1.50	16.00	0.07	1.000	3	•
22IR 1.50 ISO 3M-Q IC908	12.70	3.70	2.30	22.00	0.11	1.500	3	•
22IR 2.00 ISO 3M-Q IC908	12.70	5.00	3.10	22.00	0.13	2.000	3	•

• Tolerance: Class 6H.

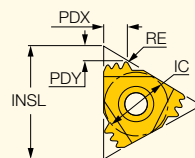
⁽¹⁾ Thread pitch

⁽²⁾ Number of teeth per corner

QUICKTHREAD

ER-NPT 3M-Q

External NPT (National Pipe Threads) Full Profile Laydown Threading Inserts for Steam, Gas and Water Pipes



Designation	Dimensions							IC908
	IC	TP ⁽¹⁾	INSL	RE	PDX	PDY	NT ⁽²⁾	
27ER 11.5 NPT 3M-Q IC908	15.88	11.5	27.00	0.09	5.50	3.30	3	•

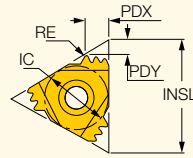
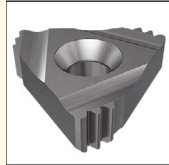
• For threading between walls use GRIP-type insert TIP-NPT • National Pipe Threads ANSI/ASME B1.20.1-1983 ⁽¹⁾ Threads per inch

⁽²⁾ Number of teeth per corner

QUICKTHREAD

IR-NPT 3M-Q

Internal NPT (National Pipe Threads) Full Profile Laydown Threading Inserts for Steam, Gas and Water Pipes



Dimensions								IC908
Designation	IC	TPI ⁽¹⁾	INSL	RE	PDX	PDY	NT ⁽²⁾	
27IR 11.5 NPT 3M-Q IC908	15.88	11.5	27.00	0.09	5.50	3.30	3	

• National Pipe Threads ANSI/ASME B1.20.1-1983.

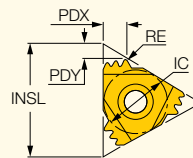
⁽¹⁾ Threads per inch

⁽²⁾ Number of teeth per corner

QUICKTHREAD

ER-W 3M-Q

External Whitworth (BSW, BSF, BSP) B.S.84-1956 DIN 259 Medium Class Full Profile Laydown Threading Inserts



Dimensions								IC908
Designation	IC	TPI ⁽¹⁾	INSL	RE	PDX	PDY	NT ⁽²⁾	
22ER 14 W 3M-Q IC908	12.70	14.0	22.00	0.23	4.30	2.60	3	

• For threading between walls use GRIP-type insert TIP-BSW • Tolerance: medium class

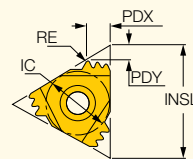
⁽¹⁾ Threads per inch

⁽²⁾ Number of teeth per corner

QUICKTHREAD

IR-UN 3M-Q

Internal American UN Full Profile (UN, UNC, UNF, UNEF) Laydown Threading Inserts for General Applications



Dimensions								IC908
Designation	IC	TPI ⁽¹⁾	INSL	RE	PDX	PDY	NT ⁽²⁾	
22IR 12 UN 3M-Q IC908	12.70	12.0	22.00	0.17	5.10	3.10	3	
22IR 16 UN 3M-Q IC908	12.70	16.0	22.00	0.13	4.00	2.40	3	

• Tolerance: class 2B, ANSI B1, 3M-1986.

⁽¹⁾ Threads per inch

⁽²⁾ Number of teeth per corner

YOU

GROOVING

INTELLIGENTLY?



LOGIQUICK
MACHINING INTELLIGENTLY

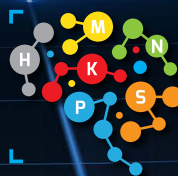
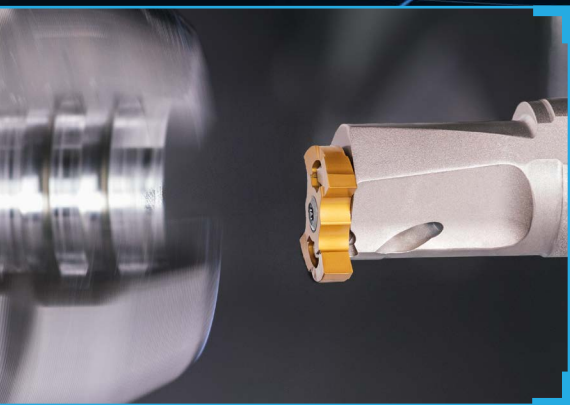
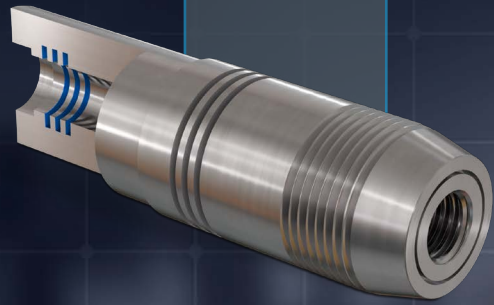


Member IMC Group



QUICK I GROOVE

Innovative 4 Cutting
Edge Insert for
Internal Grooving
and Turning



YOU Grooving
Intelligently?



Unique Double-Sided Insert can be Mounted on Right and Left Hand Tools. Rigid Clamping Provides High Repeatability and Accuracy. Internal Pinpointed Coolant Directed to the Cutting Edge.

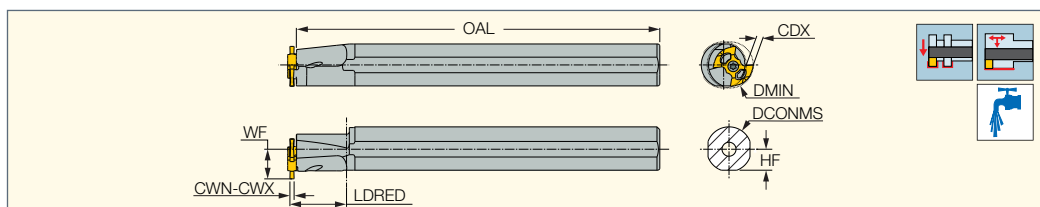
SCAN ME



QUICKGROOVE

GQHINR/L

Internal Grooving and Turning
Bars on which Inserts with 4
Cutting Edges are Mounted



Designation	CWN ⁽¹⁾	CWX ⁽²⁾	DCONMS	DMIN	CDX	OAL	LDRED	WF	HF
GQHINR/L 16C-16.5-20	1.00	3.00	16.00	16.50	2.50	130.00	20.0	10.60	7.5
GQHINR/L 16C-16.5-40	1.00	3.00	16.00	16.50	2.50	150.00	40.0	10.60	7.5
GQHINR/L 20C-24	1.00	3.00	20.00	24.00	2.50	160.00	60.0	13.00	9.0

⁽¹⁾ Minimum cutting width

⁽²⁾ Maximum cutting width

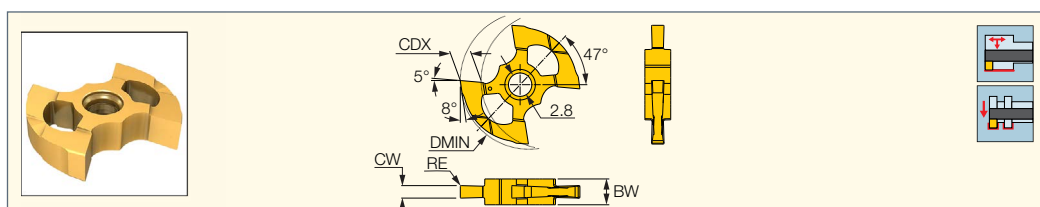
Spare Parts

Designation			
GQHINR/L 16C-16.5-20	SR 14-560	T-8/5	PL 16
GQHINR/L 16C-16.5-40	SR 14-560	T-8/5	PL 16
GQHINR/L 20C-24	SR 14-560	T-8/5	PL 20

QUICKGROOVE

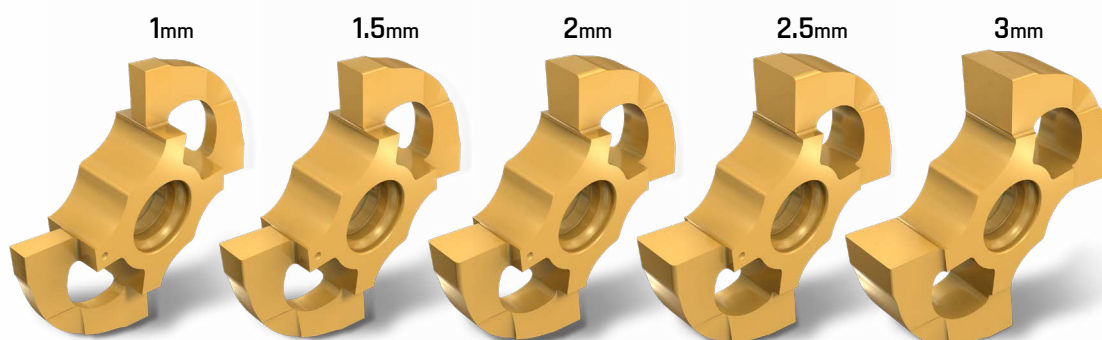
GQIN

4 Cutting Edges Precision
Grounded Inserts for
Internal Grooving and
Recessing Operations



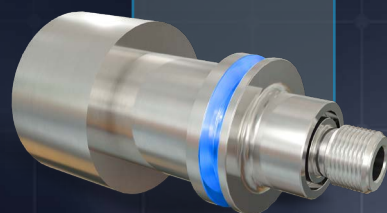
Designation	Dimensions					IC808G	Recommended Machining Data		
	CW	RE	DMIN	CDX	BW		a _p (mm)	f turn (mm/rev)	f groove (mm/rev)
GQIN 1.00-0.05	1.00	0.05	16.50	2.50	3.10	●	0.05-0.30	0.02-0.05	0.02-0.06
GQIN 1.50-0.10	1.50	0.10	16.50	2.50	3.10	●	0.10-0.40	0.02-0.05	0.02-0.06
GQIN 2.00-0.20	2.00	0.20	16.50	2.50	3.10	●	0.20-0.50	0.02-0.05	0.02-0.06
GQIN 2.50-0.20	2.50	0.20	16.50	2.50	3.10	●	0.20-0.65	0.02-0.05	0.02-0.06
GQIN 3.00-0.20	3.00	0.20	16.50	2.50	3.10	●	0.20-0.75	0.02-0.05	0.02-0.06

- Cutting edge with high positive rake, suitable for thin walled parts and for small diameters
- Suitable for Machining soft materials and bearing steel at low to medium feeds

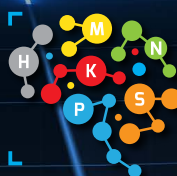
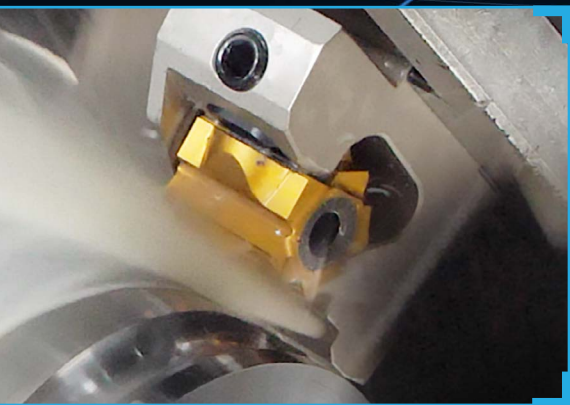


PENTACUT

Wide Forming Inserts
for Special Profiles
Provides High Repeatability,
Stability and Accuracy



Pinpointed Coolant Directed to
the Cutting Zone. Endless Options
Provide Diverse Insert Geometries
that Fit Unique Toolholders.



YOU Grooving
Intelligently?

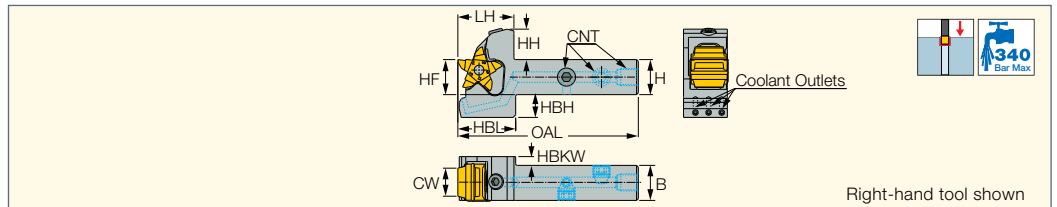
Smart Clamping Mechanism Places
the Insert in an Accurate Position
for High Repeatability, Stability and
Accuracy.

SCAN ME



PENTACUT-27

PCHR/L-27-JHP-MC
Tools Carrying Pentagonal
Wide Inserts for Specially
Tailored Profiles

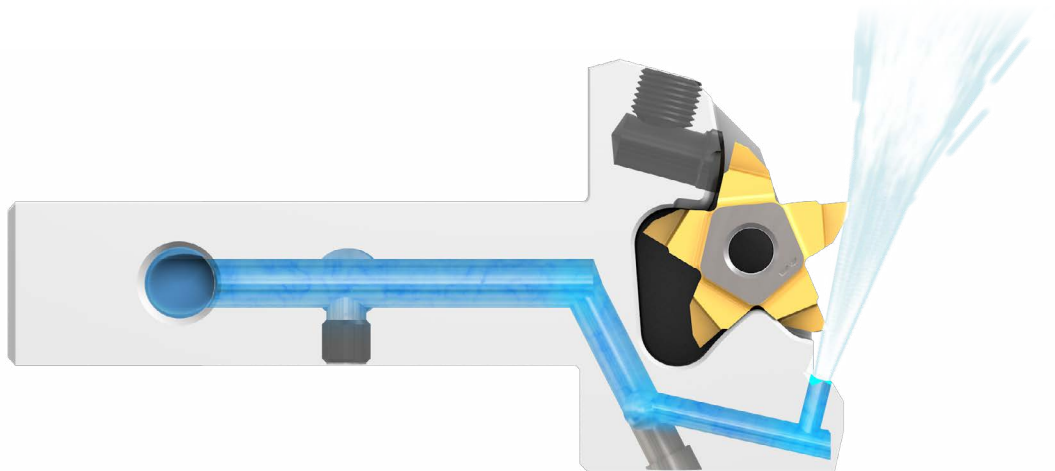


Right-hand tool shown

Designation	CW	H	B	HF	LH	HBL	HH	HBH	HBKW	OAL	CNT
PCHR/L 20-27-10-JHP-MC	10.00	20.0	20.0	20.00	32.0	33.0	17.4	13.0	5.00	103.00	G1/8
PCHR/L 25-27-10-JHP-MC	10.00	25.0	25.0	25.00	32.0	33.0	17.4	8.0	-	118.00	G1/8
PCHR/L 20-27-15-JHP-MC	15.00	20.0	20.0	20.00	32.0	33.0	17.4	13.0	5.00	103.00	G1/8
PCHR/L 25-27-15-JHP-MC	15.00	25.0	25.0	25.00	32.0	33.0	17.4	8.0	-	118.00	G1/8
PCHR/L 20-27-20-JHP-MC	20.00	20.0	20.0	20.00	32.0	33.0	17.4	13.0	5.00	103.00	G1/8
PCHR/L 25-27-20-JHP-MC	20.00	25.0	25.0	25.00	32.0	33.0	17.4	8.0	-	118.00	G1/8

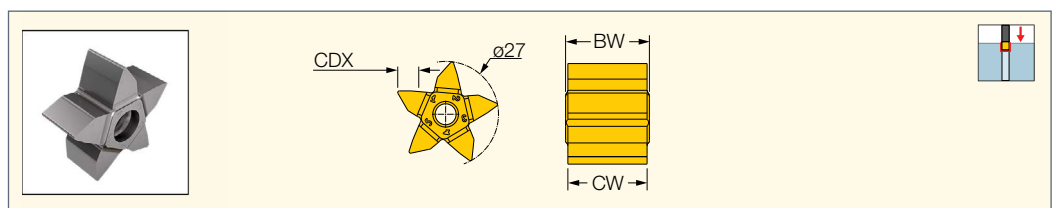
Spare Parts

Designation							
PCHR/L 20-27-10-JHP-MC	SR M8-40530	HW 3.0	SR M6X6 DIN913 TL360		HW 4.0	PLG G1/8 TL360	HW 5.0
PCHR/L 25-27-10-JHP-MC	SR M8-40530	HW 3.0	SR M6X6 DIN913 TL360		HW 4.0	PLG G1/8 TL360	HW 5.0
PCHR/L 20-27-15-JHP-MC	SR M8-40530	HW 3.0	SR M6X6 DIN913 TL360		HW 4.0	PLG G1/8 TL360	HW 5.0
PCHR/L 25-27-15-JHP-MC	SR M8-40530	HW 3.0	SR M6X6 DIN913 TL360		HW 4.0	PLG G1/8 TL360	HW 5.0
PCHR/L 20-27-20-JHP-MC	SR M8-40530	HW 3.0	SR M6X6 DIN913 TL360	PUSH ROD - 40529	HW 4.0	PLG G1/8 TL360	HW 5.0
PCHR/L 25-27-20-JHP-MC	SR M8-40530	HW 3.0	SR M6X6 DIN913 TL360	PUSH ROD - 40529	HW 4.0	PLG G1/8 TL360	HW 5.0

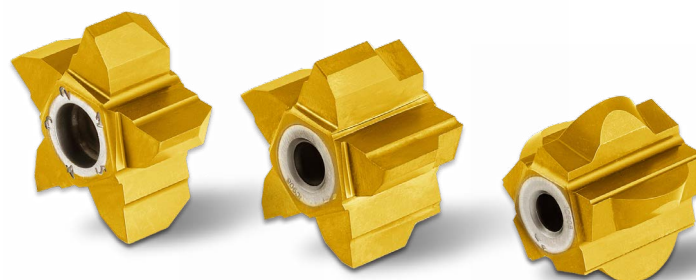


PENTACUT-27

PENTAS 27 blanks
Blank Inserts with 5 Wide
Cutting Edges for the Production
of Special Profile Contours

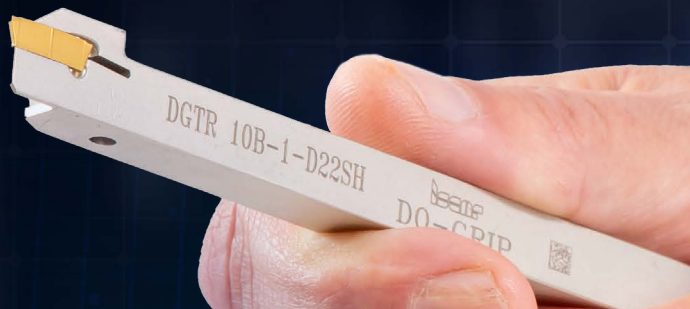


Designation	Dimensions			IC8
	CW	CDX	BW	
PENTAS 27-10FT	10.00	4.00	11.80	•
PENTAS 27-15FT	15.00	4.00	16.80	•
PENTAS 27-20FT	20.00	4.00	21.80	•

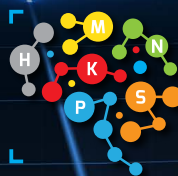
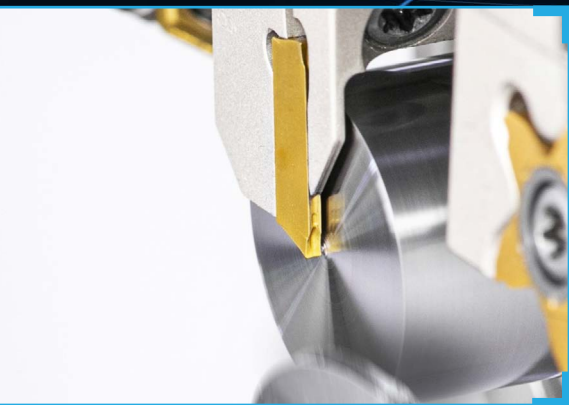


DO-GRIP

New DO-GRIP Narrow Cut Double Sided insert for Swiss-Type Machines



Insert Widths 0.8mm
up to 1.2mm.



YOU Grooving Intelligently?

Economical Narrow Double-Sided Insert Provides Maximum Material Savings. Provides Stable Cut, Improved Surface Finish & Part Straightness with Excellent Chip Control.

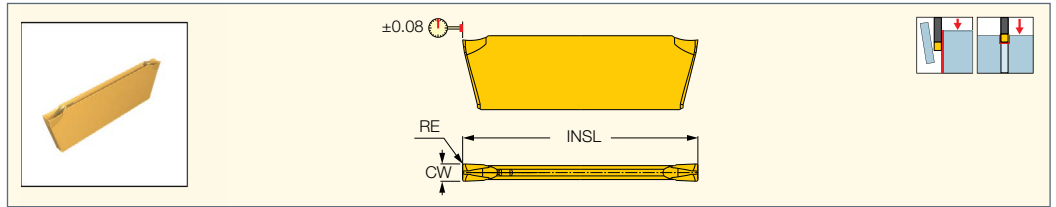
SCAN ME



DOGRIP

DGN-J/JS-D

Double-Sided Inserts for Parting and Grooving Soft Materials, Parting Tubes, Small Diameters and Thin-Walled Parts



Designation	Dimensions						Tough ↔ Hard			Recommended Machining Data
	CW	RE	CWTOL ⁽¹⁾	RETOL ⁽²⁾	CUTDIA	INSL	IC1030	IC1010	IC1508	
DGN 0801J-D12	0.80	0.10	0.030	0.020	12.0	11.10	●	●		f groove (mm/rev) 0.02-0.06
DGN 1001J-D22	1.00	0.10	0.030	0.020	22.0	13.50	●	●		0.03-0.08
DGN 1000JS-D22	1.00	0.00	0.030	0.020	22.0	13.50			●	0.03-0.08
DGN 1201J-D22	1.20	0.10	0.030	0.020	22.0	13.50	●	●		0.03-0.10

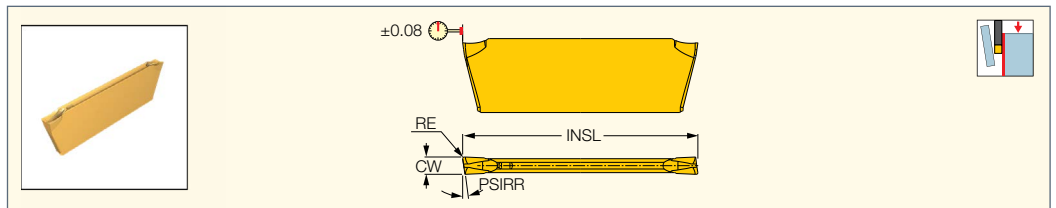
⁽¹⁾ Cutting width tolerance (+/-)

⁽²⁾ Corner radius tolerance (+/-)

DOGRIP

DGR/L-J/JS-D

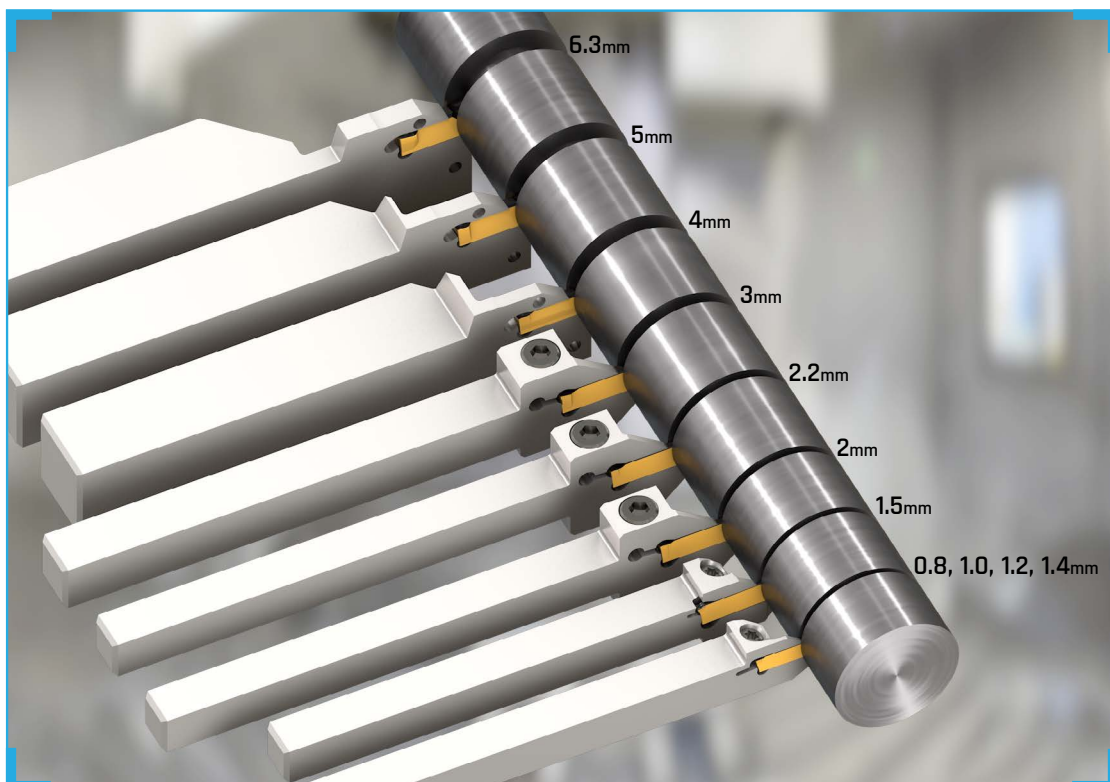
Double-Sided Inserts for Parting Soft Materials, Parting Tubes, Small Diameters and Thin-Walled Parts



Designation	Dimensions						Tough ↔ Hard			Recommended Machining Data
	CW	RE	CUTDIA	INSL	PSIRL ⁽¹⁾	PSIRR ⁽²⁾	IC1030	IC1010	IC1508	
DGL 0801J-6D-D12	0.80	0.10	12.0	11.10	6.0	-	●	●		f groove (mm/rev) 0.02-0.05
DGR 0801J-6D-D12	0.80	0.10	12.0	11.10	-	6.0	●	●		0.02-0.05
DGL 1001J-8D-D22	1.00	0.10	22.0	13.50	8.0	-	●	●		0.02-0.06
DGR 1001J-8D-D22	1.00	0.10	22.0	13.50	-	8.0	●	●		0.02-0.06
DGL 1000JS-15D-D22	1.00	0.00	22.0	13.50	15.0	-			●	0.02-0.06
DGR 1000JS-15D-D22	1.00	0.00	22.0	13.50	-	15.0		●	●	0.02-0.06
DGL 1201J-8D-D22	1.20	0.10	22.0	13.50	8.0	-	●	●		0.03-0.08
DGR 1201J-8D-D22	1.20	0.10	22.0	13.50	-	8.0	●	●		0.03-0.08

⁽¹⁾ Lead angle type for minimal burr size (left)

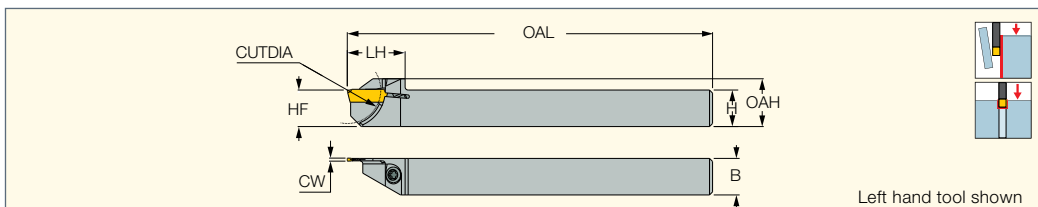
⁽²⁾ Lead angle type for minimal burr size (right)



DO-GRIP

DGTR/L-B-D-SH (NARROW CUT)

Parting and Grooving
Short Head Tools for CNC
and Swiss Automatics



Designation	CW	H	B	HF	HL	LH	CUTDIA	OAH	OAL
DGTR/L 0810B-0.8-D12SH	0.80	8.0	10.0	8.0	16.1	15.6	12.0	13.70	120.00
DGTR/L 10B-0.8-D12SH	0.80	10.0	10.0	10.0	-	15.6	12.0	13.70	120.00
DGTR/L 12B-0.8-D12SH	0.80	12.0	12.0	12.0	-	15.6	12.0	15.70	120.00
DGTR/L 16B-0.8-D12SH	0.80	16.0	16.0	16.0	-	15.6	12.0	15.70	120.00
DGTR/L 0810B-1.0-D22SH	1.00	8.0	10.0	8.0	20.5	20.0	22.0	15.00	120.00
DGTR/L 10B-1.0-D22SH	1.00	10.0	10.0	10.0	-	20.0	22.0	15.70	120.00
DGTR/L 12B-1.0-D22SH	1.00	12.0	12.0	12.0	-	20.0	22.0	15.70	120.00
DGTR/L 16B-1.0-D22SH	1.00	16.0	16.0	16.0	-	20.0	22.0	15.70	120.00
DGTR/L 0810B-1.2-D22SH	1.20	8.0	10.0	8.0	20.5	20.0	22.0	15.00	120.00
DGTR/L 10B-1.2-D22SH	1.20	10.0	10.0	10.0	-	20.0	22.0	15.70	120.00
DGTR/L 12B-1.2-D22SH	1.20	12.0	12.0	12.0	-	20.0	22.0	15.70	120.00
DGTR/L 16B-1.2-D22SH	1.20	16.0	16.0	16.0	-	20.0	22.0	15.70	120.00

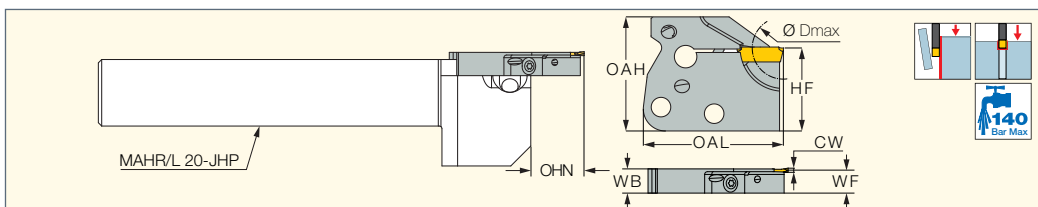
Spare Parts

Designation		
DGTR/L-B-D-SH (NARROW CUT)	SR 16-236 P	T-15/5

MODULAR-GRIP

DGPAD-D12/22-JHP

Adapters with High-Pressure
Coolant Channels for DO-GRIP
Parting and Grooving Inserts



Designation	CW	CUTDIA ⁽¹⁾	OHN ⁽²⁾	WF	WB	OAL	OAH	HF	MIID ⁽³⁾
DGPAD 0.8R/L-D12-JHP	0.80	12.0	16.0	6.65	7.00	40.50	31.00	24.0	DGN 08
DGPAD 1.0R/L-D22-JHP	1.00	22.0	16.0	6.60	7.00	40.50	33.00	24.0	DGN 10
DGPAD 1.2R/L-D22-JHP	1.20	22.0	16.0	6.50	7.00	40.50	33.00	24.0	DGN 12

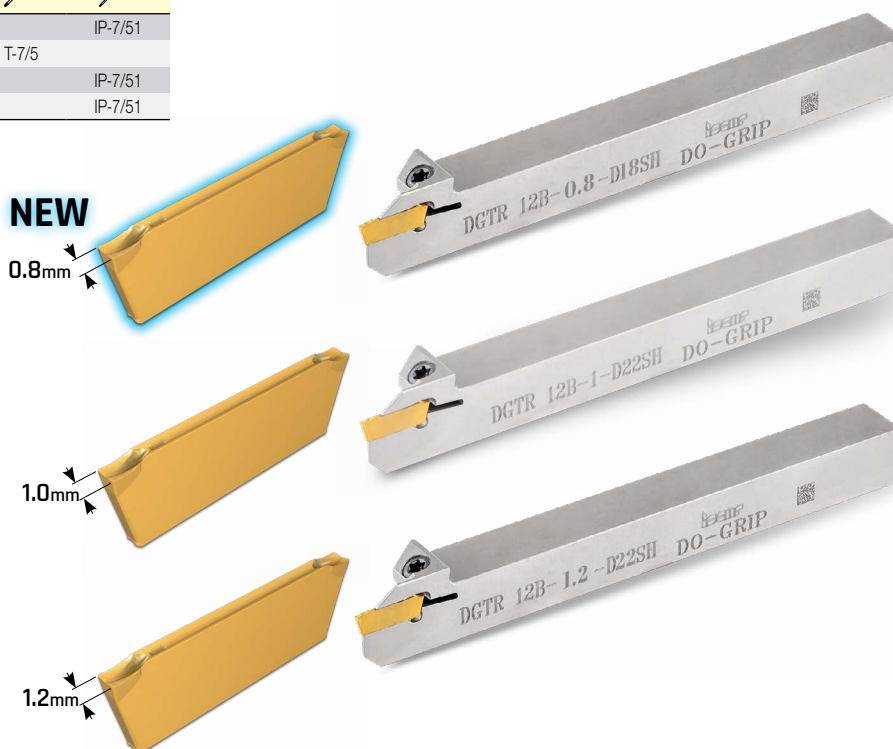
⁽¹⁾ Maximum workpiece diameter for grooving operation

⁽²⁾ Minimum overhang

⁽³⁾ Master insert identification

Spare Parts

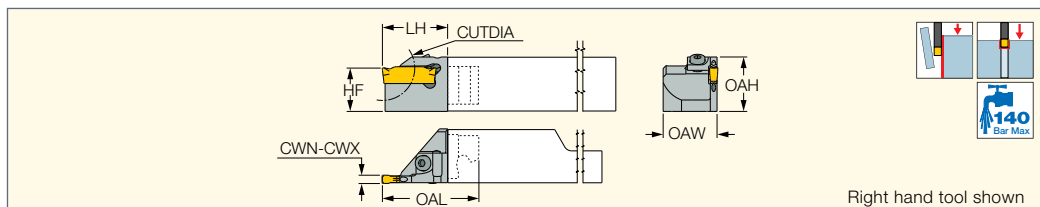
Designation			
DGPAD 0.8L-D12-JHP	SR 10500401		IP-7/51
DGPAD 0.8R-D12-JHP	SR 10500401	T-7/5	
DGPAD 1.0R/L-D22-JHP	SR 10500401		IP-7/51
DGPAD 1.2R/L-D22-JHP	SR 10500401		IP-7/51



NEOSWISS

NQCH-DGTR/L-D22-SH-JHP

Screw Lock JET-CUT Modular Heads Carrying DO-GRIP Double-Edged Parting Inserts for Swiss-Type Machines



Right hand tool shown

Designation	CWN ⁽²⁾	CWX ⁽³⁾	HF	OAW	OAH	LH	OAL	CUTDIA	Insert
NQCH12-DGTR/L-1D22SH-JHP	1.00	1.00	12.1	20.00	16.20	20.0	28.80	22.0	DGN 1
NQCH12R-DGTL-1D22SH-JHP ⁽¹⁾	1.00	1.00	12.1	20.00	16.20	20.0	28.80	22.0	DGN 1
NQCH16-DGTR/L-1D22SH-JHP	1.00	1.00	16.1	20.00	20.20	20.0	28.80	22.0	DGN 1
NQCH16R-DGTL-1D22SH-JHP ⁽¹⁾	1.00	1.00	16.1	20.00	20.20	20.0	28.80	22.0	DGN 1
NQCH16-DGTR/L-1.2D22SH-JHP	1.20	1.20	16.1	20.00	20.20	20.0	28.80	22.0	DGN 1.2
NQCH16R-DGTL-1.2D22SH-JHP ⁽¹⁾	1.20	1.20	16.1	20.00	20.20	20.0	28.80	22.0	DGN 1.2

- Use only RH Shank with RH Head and LH Shank with LH Head except NQCH12R/16R... heads.
- ⁽¹⁾ The head is dedicated for the right hand machines and to be mounted on the right hand holder only.
- ⁽²⁾ Minimum cutting width
- ⁽³⁾ Maximum cutting width

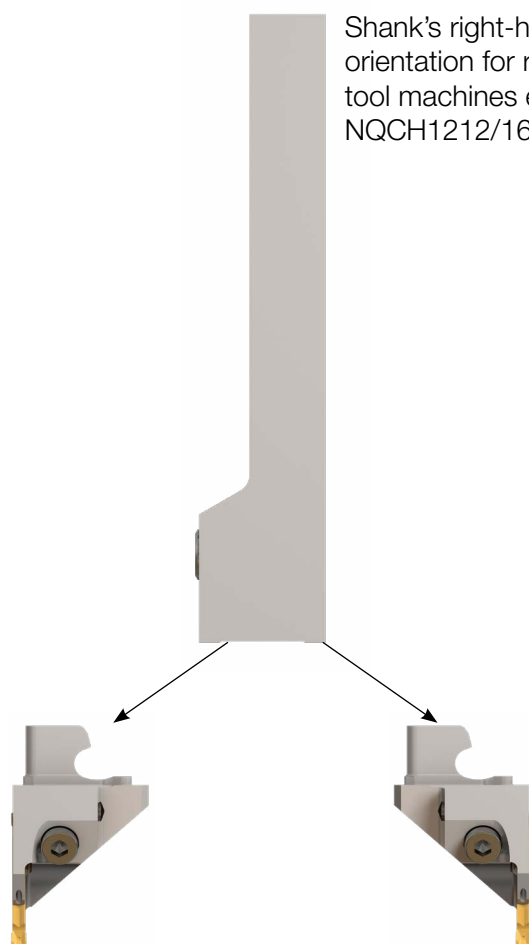
Spare Parts

Designation		
NQCH-DGTR/L-D22-SH-JHP	SR M3X8 DIN912	HW 2.5



Shank's left-hand orientation for left-hand tool machines example: NQCH1212/1616

Left hand head example: NQCH12/16-DGTL...



Shank's right-hand orientation for right-hand tool machines example: NQCH1212/1616

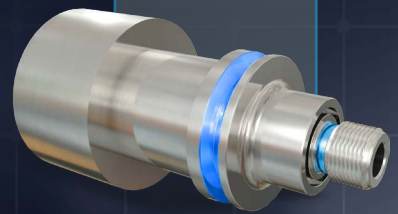
Left hand head for Shank's right-hand orientation example: NQCH12R/16R-DGTL...

Right hand head example: NQCH12/16-DGTR...

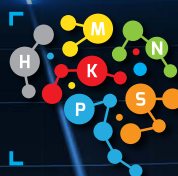
* Available for Grooving & Parting

QUICK2CUT^{MINI}

High Precision Tangential Insert for Grooving and Parting Suitable for Swiss Type Machines

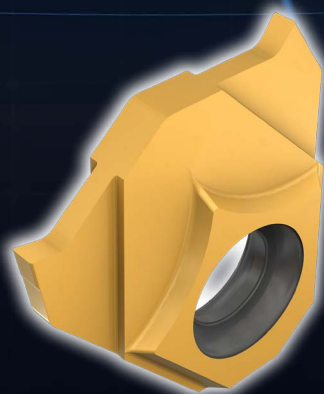


Pinpointed Coolant Improves Chip Evacuation, Increased Insert Tool Life and High Surface Finish.



YOU Grooving
Intelligently?

Stable Mounting and Safe
Machining with Excellent
Repeatability.



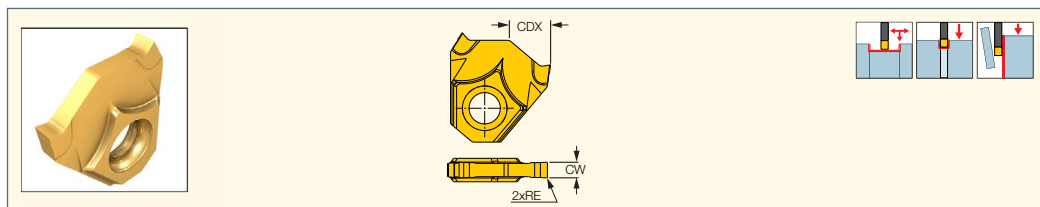
SCAN ME



QUICK2CUT^{MINI}

TGV N

Double Sided Tangential Insert for SWISS Type Machines, Intended for Grooving, Parting and Recessing Small Parts



Designation	Dimensions					IC1010	Recommended Machining Data
	CW	RE	CWTOL ⁽¹⁾	RETOL ⁽²⁾	CDX		f groove (mm/rev)
TGV N033P-000	0.33	0.00	0.020	0.030	2.00	●	0.02-0.04
TGV N050P-000	0.50	0.00	0.020	0.030	2.50	●	0.03-0.05
TGV N075P-005	0.75	0.05	0.020	0.030	3.00	●	0.03-0.06
TGV N1.00P-005	1.00	0.05	0.020	0.030	4.00	●	0.03-0.08
TGV N2.00P-0.1	2.00	0.10	0.020	0.030	6.00	●	0.03-0.10

• Cutting edge with high positive rake, suitable for parting small and miniature parts

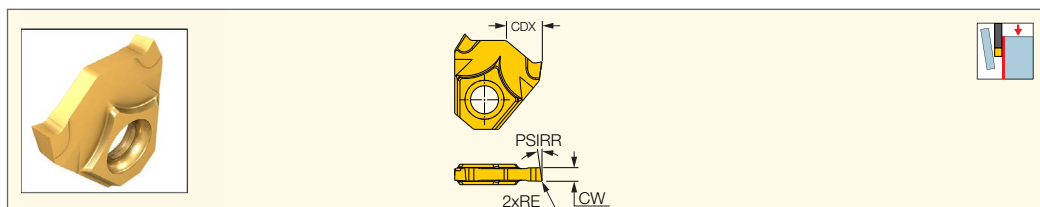
⁽¹⁾ Cutting width tolerance (+/-)

⁽²⁾ Corner radius tolerance (+/-)

QUICK2CUT^{MINI}

TGV R/L

Double Sided Tangential Insert with Lead Angle Cutting Edge to minimize Burr size, Intended for Parting Small Parts

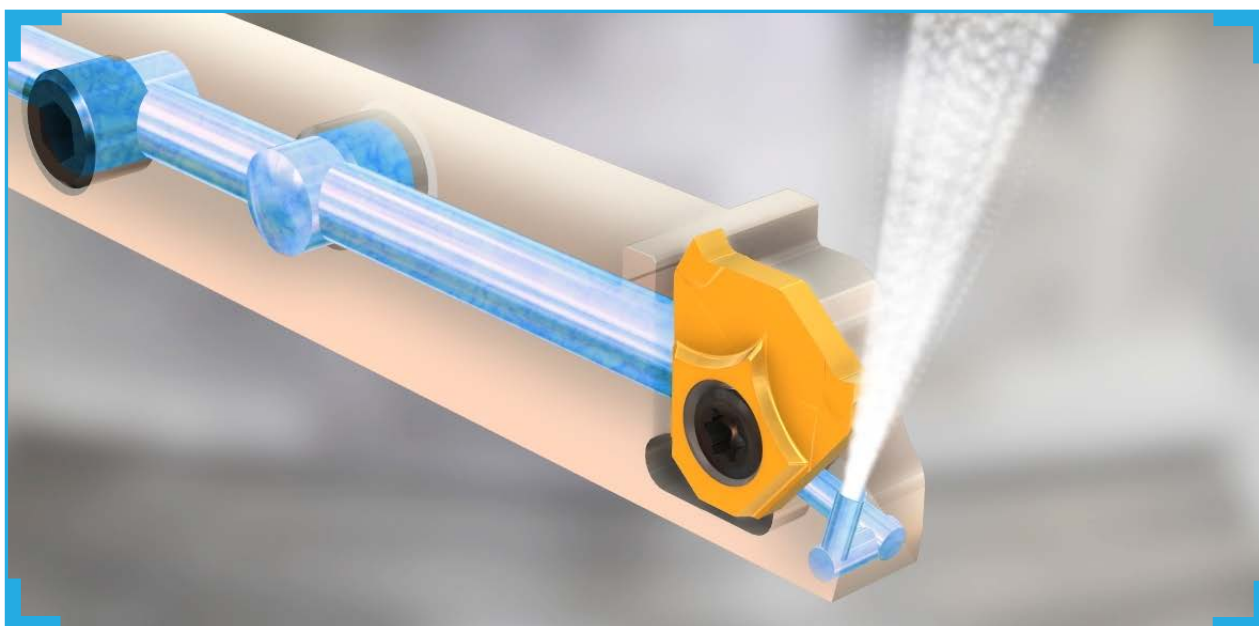


Designation	Dimensions					IC1010	Recommended Machining Data
	CW	PSIRL ⁽¹⁾	PSIRR ⁽²⁾	RE	CDX		f groove (mm/rev)
TGV L1.00P-0.05-8D	1.00	8.0	-	0.05	4.00	●	0.03-0.06
TGV R1.00P-0.05-8D	1.00	-	8.0	0.05	4.00	●	0.03-0.06
TGV L2.00P-0.05-8D	2.00	8.0	-	0.05	6.00	●	0.03-0.08
TGV R2.00P-0.05-8D	2.00	-	8.0	0.05	6.00	●	0.03-0.08

• Cutting edge with high positive rake, suitable for parting small and miniature parts

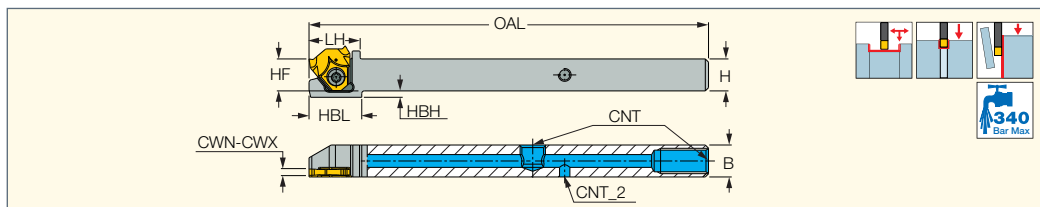
⁽¹⁾ Lead angle type for minimal burr size (left)

⁽²⁾ Lead angle type for minimal burr size (right)



TGVR/L-JHP

Grooving, Parting and
Recessing Tools Carrying
TGV Inserts with Channels
for High-Pressure Coolant



Designation	H	HF	B	CWN ⁽¹⁾	CWX ⁽²⁾	OAL	LH	HBL	HBH	CNT	CNT_2	MIID ⁽³⁾
TGVR/L 1010-JHP	10.0	10.0	10.0	0.33	2.00	125.00	16.0	16.5	2.0	UNF 5/16-24	M4	TGV N/R/L 0.33-3.0
TGVR/L 1212-JHP	12.0	12.0	12.0	0.33	2.00	125.00	16.0	-	-	UNF 5/16-24	M4	TGV N/R/L 0.33-3.0
TGVR/L 1616-JHP	16.0	16.0	16.0	0.33	2.00	125.00	16.0	-	-	UNF 5/16-24	M4	TGV N/R/L 0.33-3.0

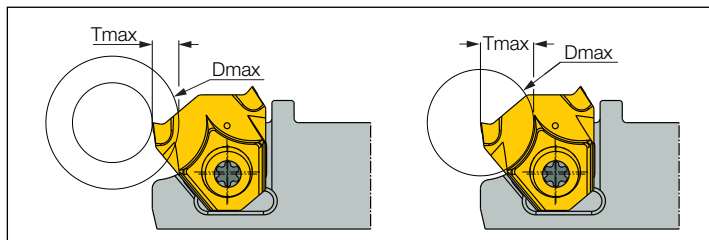
⁽¹⁾ Minimum cutting width

⁽²⁾ Maximum cutting width

⁽³⁾ Master insert identification

Depth Capacity

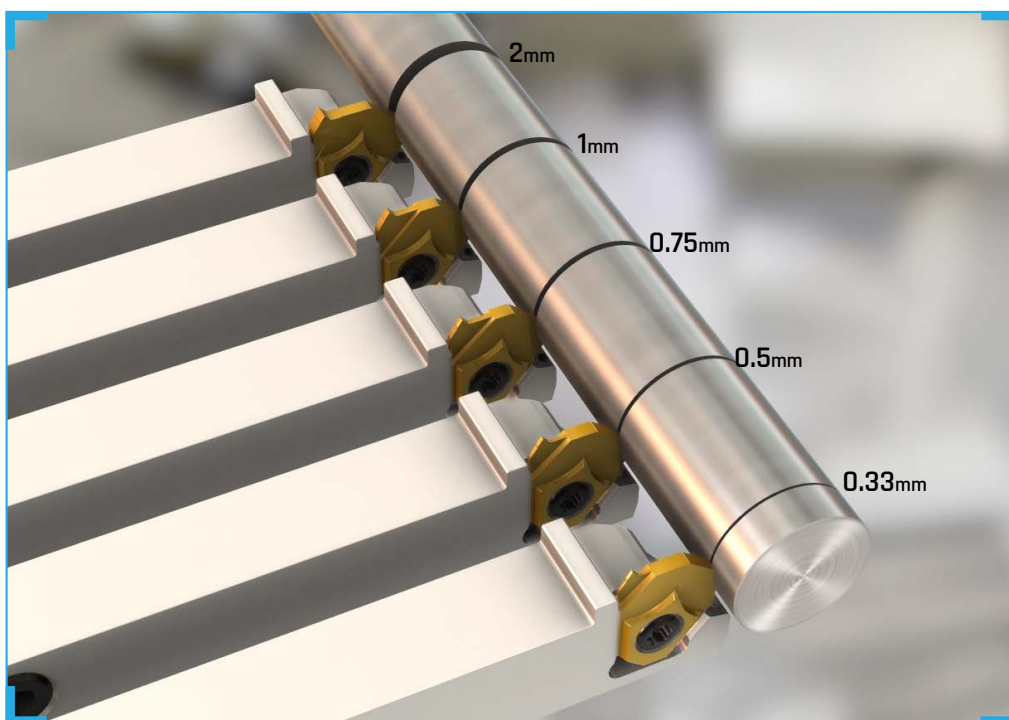
Determining depth of cut (Tmax) as function of workpiece diameter (Dmax.)

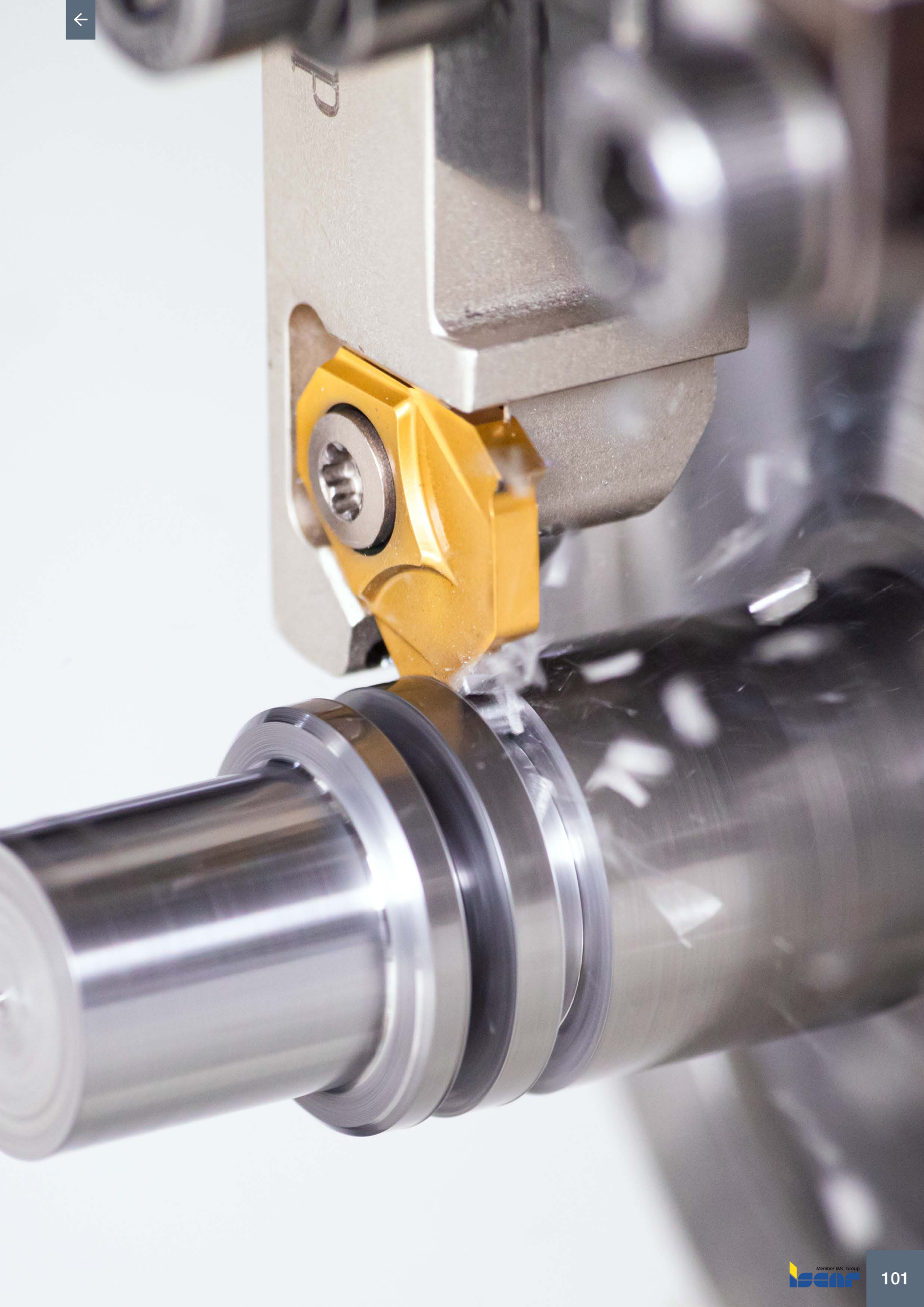


W (insert)	Tmax	Dmax	T≤0.5	T≤1.0	T≤1.5	T≤2.0	T≤2.5	T≤3.0	T≤3.5	T≤4.0	T≤4.5	T≤5.0	T≤5.5	T≤6.0
0.33	2.0	24.0	72	45	31	24	20	-	-	-	-	-	-	-
0.50	2.5	20.0						-	-	-	-	-	-	-
0.75	3.0	18.0						-	-	-	-	-	-	-
1.00	4.0	15.0						18	-	-	-	-	-	-
2.00	6.0	12.0						-	16	15	14	13	13	12

Spare Parts

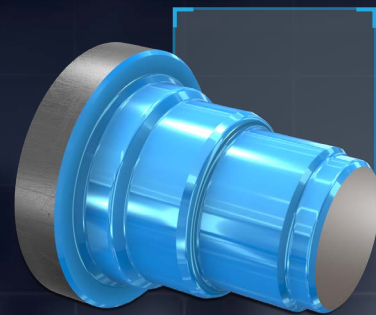
Designation					
TGVR/L-JHP	SR M3.5X0.6-L8.5 IP10	IP-10/5	SR 5/16UNF TL360	SR M4X4 DIN913 TL360	HW 5/32"



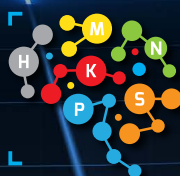


CUTVGRIP

Multifunctional Narrow Insert for External Turning, Profiling and Undercutting



V-Type Insert Geometry for Longitudinal Shallow Turning, Radial Turning, and 45 Degrees Undercutting.



YOU Grooving
Intelligently?

Superior Insert Clamping and High Precision Indexing for Exact Insert Location and Machining Repeatability.

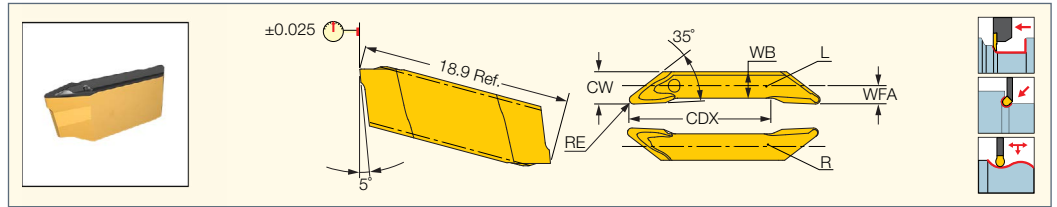


SCAN ME



CUTVGRIP

GIVR/L
Double-Edged Groove-Turn
Inserts for Back Turning,
Undercutting and Profiling



Designation	Dimensions						IC808	Recommended Machining Data	
	RE	RETOL ⁽¹⁾	CW	CDX	WB	WFA		a_p (mm)	f turn (mm/rev)
GIVR/L 302-F1M-12P	0.20	0.030	2.80	12.80	2.40	1.53	•	0.10-1.50	0.05-0.30
GIVR/L 304-F1M-12P	0.40	0.030	2.93	12.80	2.40	1.66	•	0.10-1.50	0.05-0.30

⁽¹⁾ Corner radius tolerance (+/-)

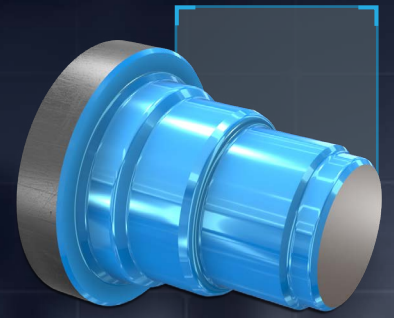
Shallow and Radial

Shallow and Radial

45° Undercutting

QUICKPENTA

New Generation Penta 24 Inserts & Tools for Grooving, Parting, and Light Turning. Intended for Quick Cutting-Edge Indexing and a Safety Lock Clamping Mechanism.



Pinpointed Coolant directed to the Cutting Zone.



YOU Grooving Intelligently?

Superior Insert Clamping and High Precision Indexing for Exact Insert Location and Machining Repeatability. Quick Cutting Edge Indexing.



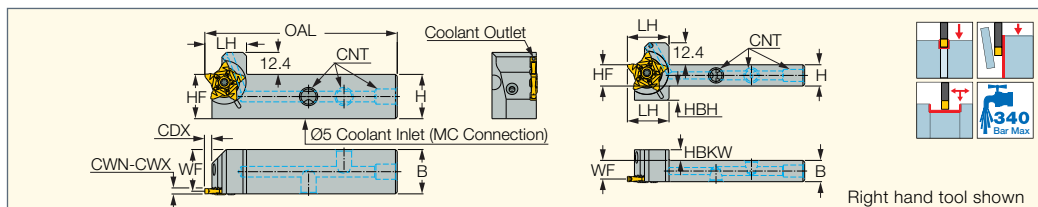
SCAN ME



QUICKPENTA

PCHR/L-24-JHP-QC/MC

Grooving, Parting and Recessing Tools with Safety Lock Clamping for Five Cutting Edged Inserts



Designation	H	HF	B	CWN ⁽²⁾	CWX ⁽³⁾	CDX	WF	HBKW	OAL	CNT	LH	HBH	Insert
PCHR/L 12-24-JHP-QC	12.0	12.0	12.0	0.50	3.18	6.40	10.50	6.00	100.00	UNF 5/16-24	23.5	8.0	PENTA 24...SL
PCHR/L 16-24-JHP-QC	16.0	16.0	16.0	0.50	3.18	6.40	14.50	2.00	93.50	UNF 5/16-24	23.5	4.0	PENTA 24...SL
PCHR/L 20-24-JHP-MC-QC ⁽¹⁾	20.0	20.0	20.0	0.50	3.18	6.40	18.50	-	93.50	G1/8	23.5	-	PENTA 24...SL
PCHR/L 25-24-JHP-MC-QC ⁽¹⁾	25.0	25.0	25.0	0.50	3.18	6.40	23.50	-	108.50	G1/8	23.5	-	PENTA 24...SL

⁽¹⁾ In addition, an MC connection is available for this tool

⁽²⁾ Minimum cutting width

⁽³⁾ Maximum cutting width

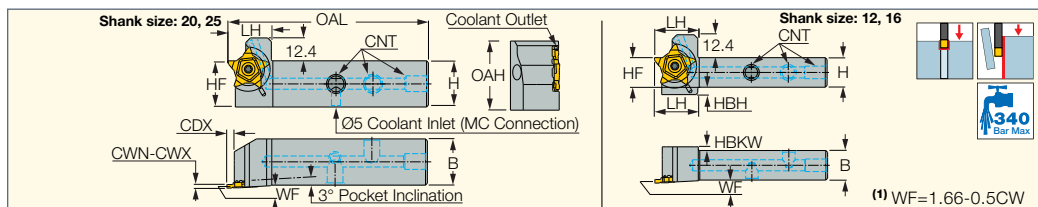
Spare Parts

Designation				
PCHR/L 12-24-JHP-QC	SR 16-212-01397R-SET	SR 5/16UNF TL360	T-2010/5	SR M3X0.5X10DIN7991 10.9
PCHR/L 16-24-JHP-QC	SR 16-212-01397R-SET	SR 5/16UNF TL360	T-2010/5	SR M3X0.5X10DIN7991 10.9
PCHR/L 20-24-JHP-MC-QC	SR 16-212-01397R-SET	SR M6X6 DIN913 TL360	PLG G1/8 TL360	SR M3X0.5X10DIN7991 10.9
PCHR/L 25-24-JHP-MC-QC	SR 16-212-01397R-SET	SR M6X6 DIN913 TL360	PLG G1/8 TL360	SR M3X0.5X10DIN7991 10.9

QUICKPENTA

PCHRS-24 JHP-QC/MC

Holders with PENTA-CUT Inserts for Grooving and Parting Next to High Shoulders, Enables Quick Cutting Edge Indexing



Designation	H	B	HF	CWN ⁽¹⁾	CWX ⁽²⁾	CDX	OAL	LH	HBH	HBKW	OAH	CNT
PCHRS 12-24 JHP-QC	12.0	12.0	12.0	0.80	3.18	6.20	100.00	23.5	8.0	6.00	32.40	UNF 5/16-24
PCHRS 16-24 JHP-QC	16.0	16.0	16.0	0.80	3.18	6.20	93.50	23.5	4.0	2.00	32.40	UNF 5/16-24
PCHRS 20-24 JHP-MC-QC	20.0	20.0	20.0	0.80	3.18	6.20	93.50	23.5	-	-	32.40	G1/8
PCHRS 25-24 JHP-MC-QC	25.0	25.0	25.0	0.50	3.18	6.00	108.50	23.5	-	-	37.40	G1/8

⁽¹⁾ Minimum cutting width

⁽²⁾ Maximum cutting width

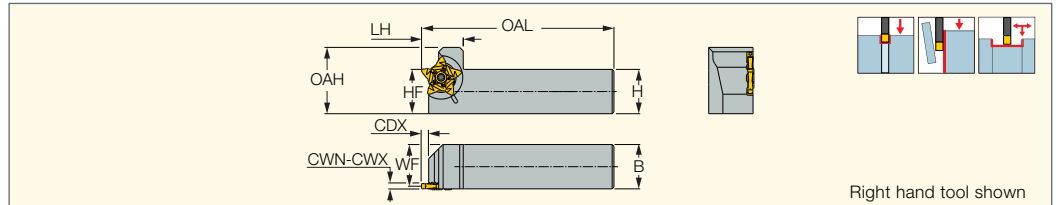
Spare Parts

Designation			
PCHRS-24 JHP-QC/MC	SR 16-212-01397R-SET	T-2010/5	SR M3X0.5X10DIN7991 10.9

QUICKPENTA

PCHR/L 24-QC

Grooving, Parting and Recessing Tools with Safety Lock Clamping for Five Cutting Edged Inserts



Designation	H	HF	B	CWN ⁽¹⁾	CWX ⁽²⁾	CDX	WF	OAL	LH	OAH	MIID ⁽³⁾
PCHL 20-24-QC	20.0	20.0	20.0	0.50	3.18	6.40	18.50	125.00	23.5	29.30	PENTA 24N....LS
PCHR 20-24-QC	20.0	20.0	20.0	0.50	3.18	6.40	18.50	125.00	23.5	29.30	PENTA 24N....RS
PCHL 25-24-QC	25.0	25.0	25.0	0.50	3.18	6.40	23.50	135.00	23.5	34.30	PENTA 24N....LS
PCHR 25-24-QC	25.0	25.0	25.0	0.50	3.18	6.40	23.50	135.00	23.5	34.30	PENTA 24N....RS

⁽¹⁾ Minimum cutting width

⁽²⁾ Maximum cutting width

⁽³⁾ Master insert identification

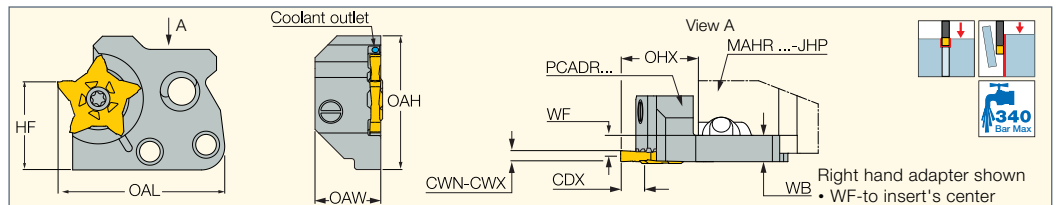
Spare Parts

Designation		
PCHR/L 24-QC	T-2010/5	SR 16-212-01397R-SET

QUICKPENTA

PCADR/L 24-JHP-QC

QUICK-PENTA Adapters with High-Pressure Coolant Holes, for QUICK-PENTA Grooving and Parting Inserts



Designation	CWN ⁽¹⁾	CWX ⁽²⁾	CDX	OHX ⁽³⁾	OAL	OAW	OAH	HF	WF	WB	Insert
PCADR/L 24-JHP-QC	0.50	3.18	6.40	21.1	45.60	18.00	36.60	24.0	5.70	7.20	PENTA 24....SL

• CDX and CUTDIA according to insert limitation

⁽¹⁾ Minimum cutting width

⁽²⁾ Maximum cutting width

⁽³⁾ Maximum overhang

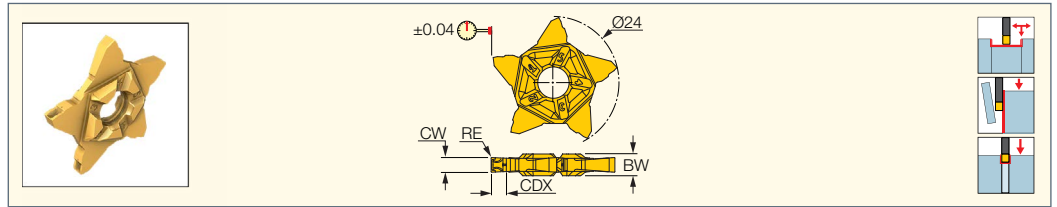
Spare Parts

Designation				
PCADR/L 24-JHP-QC	SR 16-212-01397R-SET	T-2010/5	SR M3X0.5X10DIN7991 10.9	SR M3X3 DIN913 TL360

QUICKPENTA

PENTA 24N-C-SL

First Choice for The Parting of Bars, Hard Materials, and Tough Applications with a Negative Cutting Rake Angle



Designation	Dimensions						IC808G	Recommended Machining Data
	CW	CWTOL ⁽¹⁾	RE	RETOL ⁽²⁾	CDX	BW		f groove (mm/rev)
PENTA 24N200C020SL	2.00	0.020	0.20	0.030	6.00	4.00	●	0.05-0.16
PENTA 24N300C020SL	3.00	0.020	0.20	0.030	6.20	4.00	●	0.06-0.20

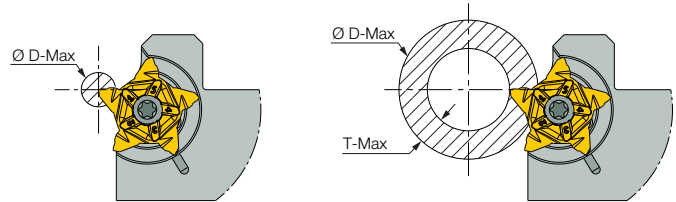
● CUTDIA as a function of depth of cut (CDX).

⁽¹⁾ Cutting width tolerance (+/-)

⁽²⁾ Corner radius tolerance (+/-)

Designation	CW ± 0.02	Parting to Center D-Max	Parting Hollow Bars	
			T-Max	D-Max
PENTA 24...SL	CW = 0.50	5	2.5*	250
	CW = 1.00	7	3.5	250
	CW = 1.50	10	5.0	30
	CW = 2.00	12	6.0	20
	CW = 2.47	10	5.0	30
	CW = 3.00	12.4	6.2	20

*Refers to PENTA 24N050J004SL



Designation	D-Max As a Function of Depth of Cut (T)								
	T-Max	T≤3.0	T≤3.5	T≤4.0	T≤4.5	T≤5.0	T≤5.5	T≤6.0	T≤6.2
PENTA 24N200C020SL	6.0	N.L.	470	210	120	75	45	20	-
PENTA 24N300C020SL	6.2	N.L.	470	210	120	75	60	40	20

⁽¹⁾ The data in those tables refers to standard inserts only.

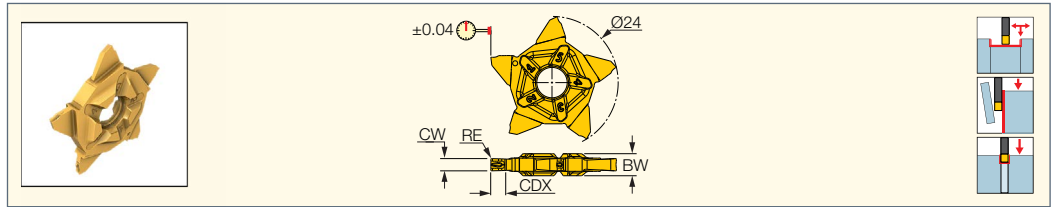
⁽²⁾ As T decreases ,D-Max Increases. See tables for further data.

⁽³⁾ N.L. = No Limit.

QUICKPENTA

PENTA 24N-J-SL

Five Cutting Edges for Parting and Grooving with Positive Rake Angle Clamped Onto Standard PENTA-CUT Holders



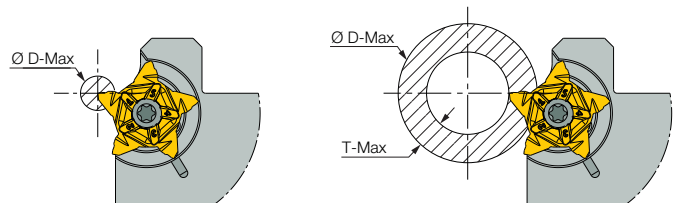
Designation	Dimensions						IC808G	Recommended Machining Data
	CW	CWTOL ⁽¹⁾	RE	RETOL ⁽²⁾	CDX	BW		f groove (mm/rev)
PENTA 24N050J004SL	0.50	0.020	0.04	0.020	2.50	4.00	●	0.02-0.06
PENTA 24N100J006SL	1.00	0.020	0.06	0.020	3.50	4.00	●	0.02-0.08
PENTA 24N150J010SL	1.50	0.020	0.10	0.020	5.00	4.00	●	0.03-0.10
PENTA 24N200J020SL	2.00	0.020	0.20	0.030	6.00	4.00	●	0.03-0.12
PENTA 24N247J020SL	2.47	0.020	0.20	0.030	5.00	4.00	●	0.03-0.15
PENTA 24N300J020SL	3.00	0.020	0.20	0.030	6.20	4.00	●	0.03-0.15

⁽¹⁾ Cutting width tolerance (+/-)

⁽²⁾ Corner radius tolerance (+/-)

Designation	CW ± 0.02	Parting to Center D-Max	Parting Hollow Bars	
			T-Max	D-Max
PENTA 24...SL	CW = 0.50	5	2.5*	250
	CW = 1.00	7	3.5	250
	CW = 1.50	10	5.0	30
	CW = 2.00	12	6.0	20
	CW = 2.47	10	5.0	30
	CW = 3.00	12.4	6.2	20

*Refers to PENTA 24N050J004SL

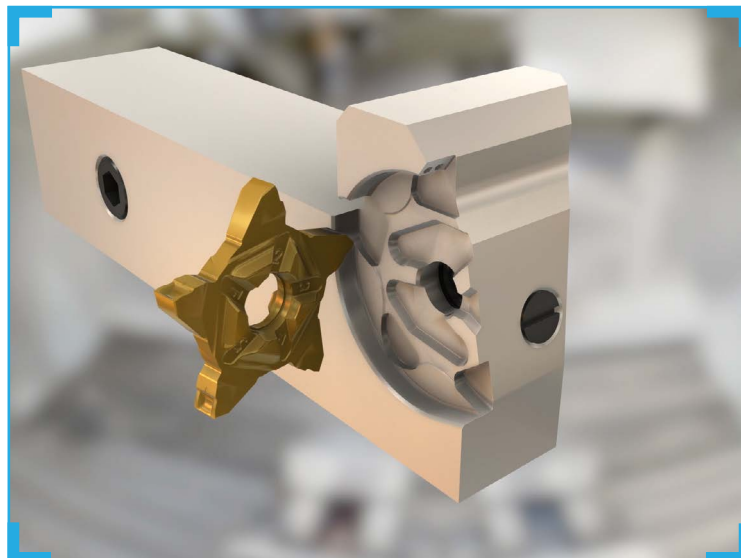


Designation	D-Max As a Function of Depth of Cut (T)								
	T-Max	T≤3.0	T≤3.5	T≤4.0	T≤4.5	T≤5.0	T≤5.5	T≤6.0	T≤6.2
PENTA 24N050J004SL	2.5	-	-	-	-	-	-	-	-
PENTA 24N100J006SL	3.5	N.L.	250	-	-	-	-	-	-
PENTA 24N150J010SL	5.0	N.L.	470	210	70	30	-	-	-
PENTA 24N200J020SL	6.0	N.L.	470	210	120	75	45	20	-
PENTA 24N247J020SL	5.0	N.L.	470	210	70	30	-	-	-
PENTA 24N300J020SL	6.2	N.L.	470	210	120	75	60	40	20

⁽¹⁾ The data in those tables refers to standard inserts only.

⁽²⁾ As T decreases ,D-Max Increases. See tables for further data.

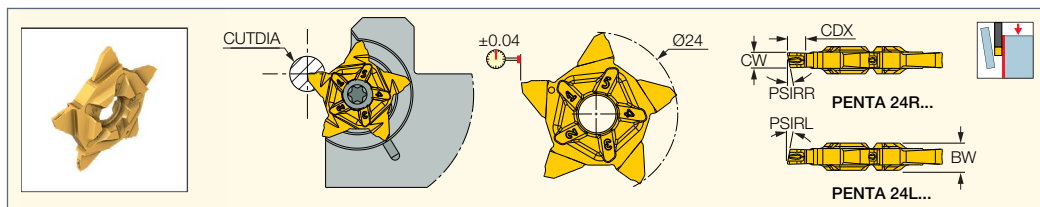
⁽³⁾ N.L. = No Limit.



QUICKPENTA

PENTA 24R/L-DSL

Parting Insert with 5 Angled Cutting Edges to Minimize Burr Size. Can Be Clamped Also on Standard PENTA-CUT Holders



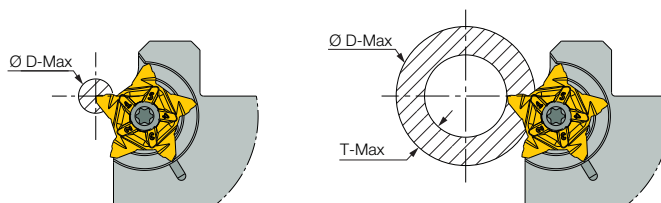
Designation	Dimensions						IC1010	Recommended Machining Data f groove (mm/rev)
	CW	CWTOL ⁽¹⁾	CDX	PSIRL	PSIRR	CUTDIA		
PENTA 24L100J15DSL	1.00	0.020	3.50	15.0	-	7.0	●	0.02-0.05
PENTA 24R100J15DSL	1.00	0.020	3.50	-	15.0	7.0	●	0.02-0.05
PENTA 24L150J06DSL	1.50	0.020	5.00	6.0	-	10.0	●	0.03-0.08
PENTA 24R150J06DSL	1.50	0.020	5.00	-	6.0	10.0	●	0.03-0.08
PENTA 24L200J06DSL	2.00	0.020	6.00	6.0	-	12.0	●	0.03-0.10
PENTA 24R200J06DSL	2.00	0.020	6.00	-	6.0	12.0	●	0.03-0.10

● CUTDIA - parting to center

⁽¹⁾ Cutting width tolerance (+/-)

Designation	CW ± 0.02	Parting to Center D-Max	Parting Hollow Bars	
			T-Max	D-Max
PENTA 24...SL	CW = 0.50	5	2.5*	250
	CW = 1.00	7	3.5	250
	CW = 1.50	10	5.0	30
	CW = 2.00	12	6.0	20
	CW = 2.47	10	5.0	30
	CW = 3.00	12.4	6.2	20

*Refers to PENTA 24N050J004SL



Designation	D-Max As a Function of Depth of Cut (T) (for Parting Hollow Bars)							
	Parting to Center D-Max	T ≤ 3.0	T ≤ 3.5	T ≤ 4.0	T ≤ 4.5	T ≤ 5.0	T ≤ 5.5	T ≤ 6.0
PENTA 24R/L100J15DSL	7	N.L.	250	-	-	-	-	-
PENTA 24R/L150J06DSL	10	N.L.	470	210	70	30	-	-
PENTA 24R/L200J06DSL	12	N.L.	470	210	120	75	45	20

⁽¹⁾ The data in those tables refers to standard inserts only.

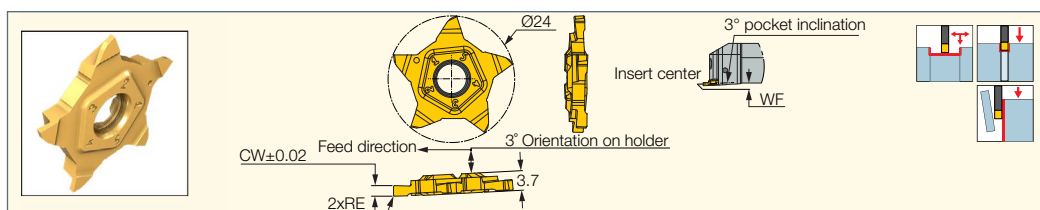
⁽²⁾ As T decreases, D-Max Increases. See tables for further data.

⁽³⁾ N.L. = No Limit.

QUICKPENTA

PENTA 24N-NF-RS-SL

Pentagonal Parting and Grooving Inserts for Quick Cutting Edge Indexing. Used for Next to High Shoulder Applications

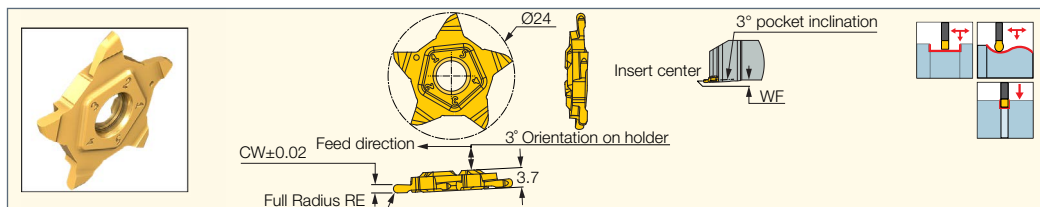


Designation	Dimensions				IC808G	Recommended Machining Data f groove (mm/rev)
	CW	RE	CDX	WF		
PENTA 24N080NF01RS-SL	0.80	0.10	1.60	1.26	●	0.03-0.07
PENTA 24N100NF01RS-SL	1.00	0.10	1.80	1.16	●	0.03-0.08
PENTA 24N119NF01RS-SL	1.19	0.10	2.00	1.06	●	0.03-0.10
PENTA 24N157NF02RS-SL	1.57	0.20	3.00	0.88	●	0.04-0.12
PENTA 24N200NF02RS-SL	2.00	0.20	3.00	0.66	●	0.04-0.12
PENTA 24N239NF02RS-SL	2.39	0.20	5.00	0.46	●	0.04-0.14
PENTA 24N300NF02RS-SL	3.00	0.20	6.20	0.16	●	0.04-0.14

QUICKPENTA

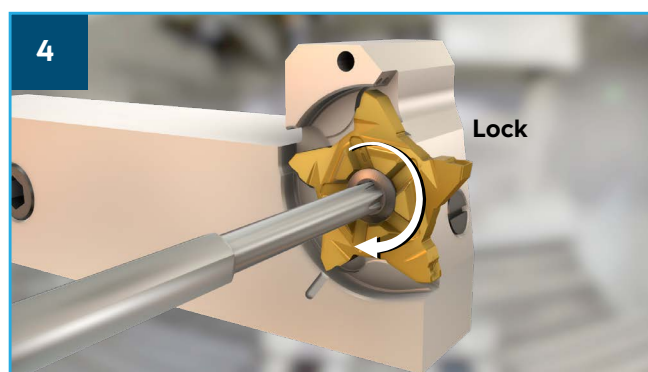
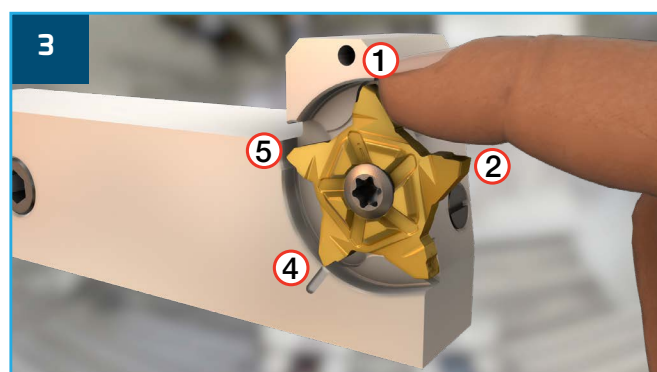
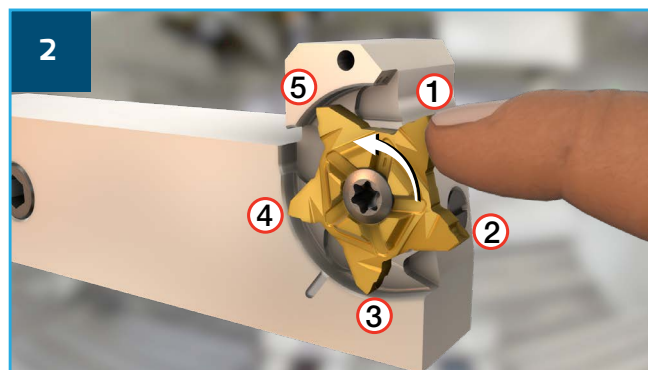
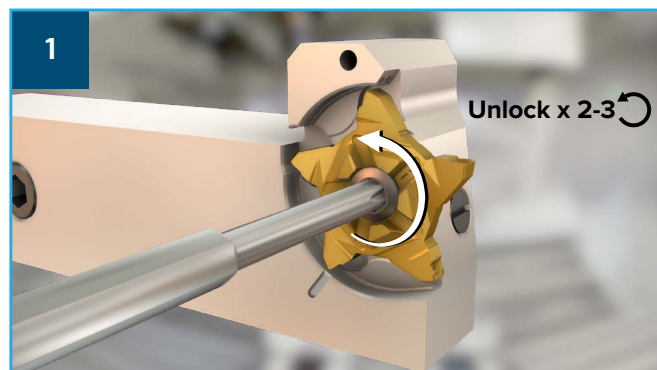
PENTA 24N-NF-RSSL (full radius)

Precision Grooving Pentagonal Full Radius Inserts for Quick and Accurate Cutting Edge Indexing



Designation	Dimensions				IC808G	Recommended Machining Data
	CW	RE	CDX			f groove (mm/rev)
PENTA 24N157NF079RSSL	1.57	0.79	3.00	•	•	0.04-0.10
PENTA 24N318NF159RSSL	3.18	1.59	6.20	•		0.05-0.15

• Recessing is possible only with 2.39 mm and wider inserts.





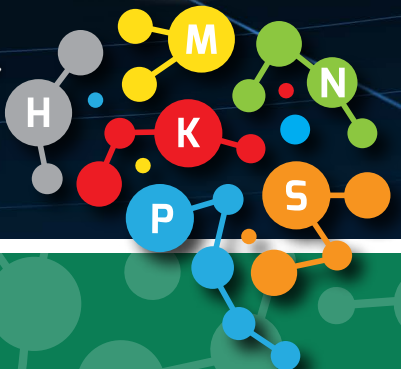
YOU

DRILLING

INTELLIGENTLY?



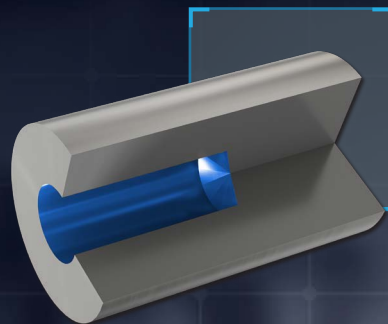
LOGIQUICK
MACHINING INTELLIGENTLY



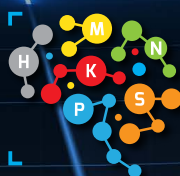
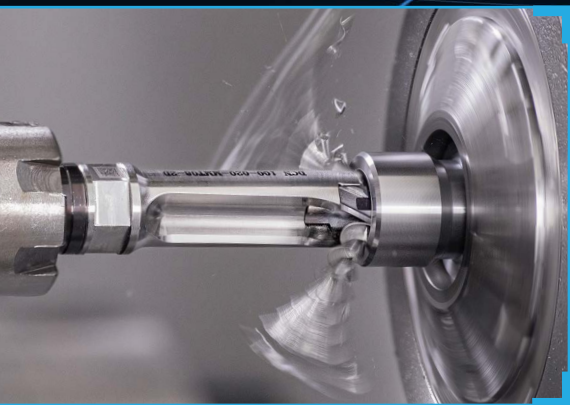
Member IMC Group
isera

SUMOCHAM

Modular Drill with
a MULTI-MASTER
Connection



Dia. Range: 4mm-10mm.
Enables Using MULTI-MASTER
Shanks for Multi-Spindle and
Swiss-Type Machines.



YOU Drilling Intelligently?

.....
Easy and Quick Tool Change Saves
Setup and Machine Downtime.
Internal Channels Provide
Effective Coolant.
.....

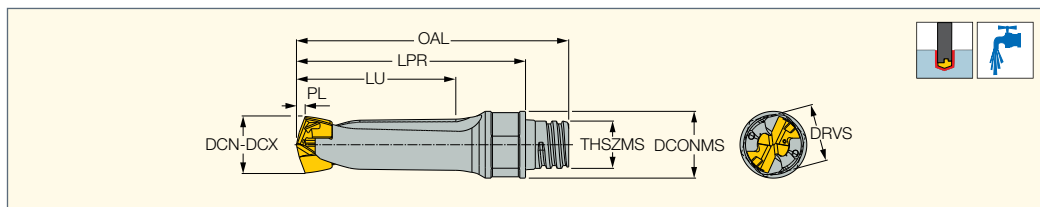
SCAN ME



SUMOCHAM

DCN-MM

Modular Drill Body with
Exchangeable Heads,
Internal Coolant Holes and
MULTI-MASTER Connection,
Drilling Depth 2xD



Designation	DCN ⁽²⁾	DCX ⁽³⁾	DCONMS	LU	LPR	PL	OAL	THSZMS	SSC ⁽⁴⁾	MIID ⁽⁵⁾	DRVS ⁽⁶⁾	CSP ⁽⁷⁾	
DCN 040-008-MMT05-2D ⁽¹⁾	4.00	4.49	7.60	8.62	22.00	0.620	28.75	T05	4.0	ICP 040	5.5	1	
DCN 045-009-MMT05-2D ⁽¹⁾	4.50	4.99	7.60	9.66	23.30	0.660	30.05	T05	4.5	ICP 045	5.5	1	
DCN 050-010-MMT06-2D ⁽¹⁾	5.00	5.49	9.60	10.73	27.25	0.730	33.55	T06	5.0	ICP 050	8.0	1	
DCN 055-011-MMT06-2D ⁽¹⁾	5.50	5.99	9.60	11.81	27.50	0.810	33.80	T06	5.5	ICP 055	8.0	1	
DCN 060-012-MMT06-2D	6.00	6.49	9.60	12.96	27.90	0.960	34.20	T06	6.0	ICP 060	8.0	1	K DCN 6-9.99-Y
DCN 065-013-MMT06-2D	6.50	6.99	9.60	14.18	29.50	1.180	35.80	T06	6.5	ICP 065	8.0	1	K DCN 6-9.99-Y
DCN 070-014-MMT06-2D	7.00	7.49	9.60	15.01	30.10	1.010	36.39	T06	7.0	ICP 070	8.0	1	K DCN 6-9.99
DCN 075-015-MMT06-2D	7.50	7.99	9.60	16.01	31.10	1.100	37.40	T06	7.0	ICP 075	8.0	1	K DCN 6-9.99
DCN 080-016-MMT06-2D	8.00	8.49	9.60	17.18	32.90	1.200	39.19	T06	8.0	ICP 080	8.0	1	K DCN 6-9.99
DCN 085-017-MMT06-2D	8.50	8.99	9.60	18.29	33.90	1.290	40.19	T06	8.0	ICP 085	8.0	1	K DCN 6-9.99
DCN 090-018-MMT08-2D	9.00	9.49	11.60	19.35	37.40	1.350	44.90	T08	9.0	ICP 090	10.0	1	K DCN 6-9.99
DCN 095-019-MMT08-2D	9.50	9.99	11.60	20.44	38.40	1.440	45.90	T08	9.0	ICP 095	10.0	1	K DCN 6-9.99
DCN 100-020-MMT08-2D	10.00	10.49	11.60	21.50	39.80	1.500	47.30	T08	10.0	ICP 100	10.0	1	K DCN 10-13.99

• Do not mount smaller drilling heads other than the specified range of the drill body

⁽¹⁾ The SK DCN key is supplied with the insert

⁽²⁾ Cutting diameter minimum

⁽³⁾ Cutting diameter maximum

⁽⁴⁾ Seat size code

⁽⁵⁾ Master insert identification

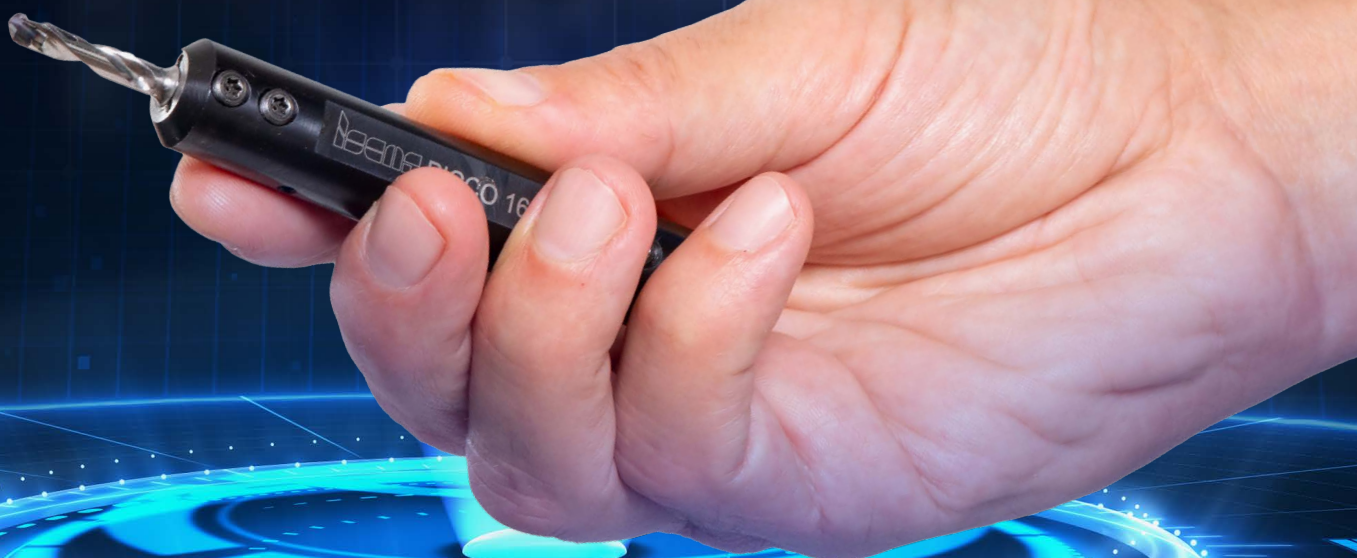
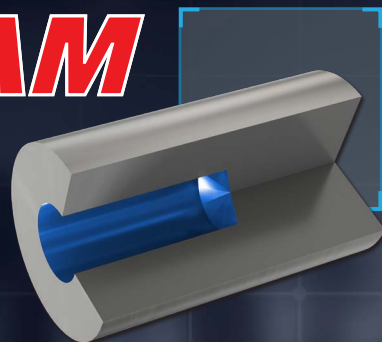
⁽⁶⁾ Torque key size

⁽⁷⁾ 0 - Without coolant supply, 1 - With coolant supply

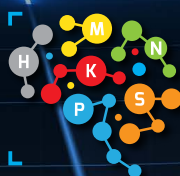


PICCO SUMO CHAM

**SUMO-CHAM Drill with
a PICCO-CUT Connection
for Small Diameter
Drilling Solutions**



Dia. Range: 4.00 -10.90mm.
Drilling Depth 3XD.



**YOU Drilling
Intelligently?**

.....
Small 3xD Holders with Internal
Coolant Channels. Suitable
for Small and Swiss Type Machines.
.....



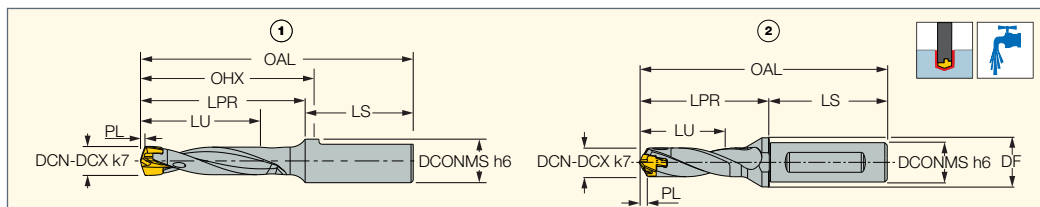
SCAN ME



PICCO SUMO CHAM

DCN-PICCO

Drill Body with Exchangeable Heads, Internal Coolant Holes and PICCO Connection, Drilling Depth 3xD



Designation	DCN ⁽²⁾	DCX ⁽³⁾	DCONMS	DF	LU	LPR	OHX ⁽⁴⁾	PL	LS	OAL	SSC ⁽⁵⁾	Fig.	MIID ⁽⁶⁾	
DCN 040-012-06-3D-PICCO ⁽¹⁾	4.00	4.49	6.00	-	12.62	22.70	23.2	0.620	14.9	37.60	4.0	1	ICP 040	
DCN 045-014-06-3D-PICCO ⁽¹⁾	4.50	4.99	6.00	-	14.66	24.65	25.1	0.660	14.9	39.55	4.5	1	ICP 045	
DCN 050-015-06-3D-PICCO ⁽¹⁾	5.00	5.49	6.00	-	15.73	26.30	26.8	0.730	14.9	41.20	5.0	1	ICP 050	
DCN 055-017-06-3D-PICCO ⁽¹⁾	5.50	5.99	6.00	-	17.81	27.95	28.6	0.810	14.9	42.85	5.5	1	ICP 055	
DCN 060-018-06-3D-PICCO	6.00	6.49	6.00	-	18.96	29.60	30.1	0.960	14.9	44.50	6.0	1	ICP 060	K DCN 6-9.99-Y
DCN 065-020-06-3D-PICCO	6.50	6.99	6.00	-	21.18	30.67	31.8	1.180	15.6	46.30	6.5	1	ICP 065	K DCN 6-9.99-Y
DCN 070-021-08-3D-PICCO	7.00	7.49	8.00	10.00	22.01	35.60	-	1.010	20.0	55.60	7.0	2	ICP 070	K DCN 6-9.99
DCN 075-023-08-3D-PICCO	7.50	7.99	8.00	10.00	24.10	37.10	-	1.100	20.0	57.10	7.0	2	ICP 075	K DCN 6-9.99
DCN 080-024-08-3D-PICCO	8.00	8.49	8.00	10.00	25.20	39.40	-	1.200	20.0	59.40	8.0	2	ICP 080	K DCN 6-9.99
DCN 085-026-08-3D-PICCO	8.50	8.99	8.00	10.00	26.35	40.90	-	1.350	20.0	60.90	8.0	2	ICP 085	K DCN 6-9.99
DCN 090-027-08-3D-PICCO	9.00	9.49	8.00	10.00	28.35	43.30	-	1.350	20.0	63.30	9.0	2	ICP 090	K DCN 6-9.99
DCN 095-029-08-3D-PICCO	9.50	9.99	8.00	11.00	30.44	44.30	-	1.440	20.0	64.30	9.0	2	ICP 095	K DCN 6-9.99
DCN 100-030-08-3D-PICCO	10.00	10.49	8.00	11.00	31.50	46.20	-	1.500	20.0	66.20	10.0	2	ICP 100	K DCN 10-13.99
DCN 105-032-08-3D-PICCO	10.50	10.99	8.00	11.00	33.00	47.70	-	1.590	20.0	67.69	10.5	2	ICP 105	K DCN 10-13.99

• Do not mount smaller drilling heads other than the specified range of the drill body

⁽¹⁾ The SK DCN key is supplied with the insert

⁽²⁾ Cutting diameter minimum

⁽³⁾ Cutting diameter maximum

⁽⁴⁾ Maximum overhang

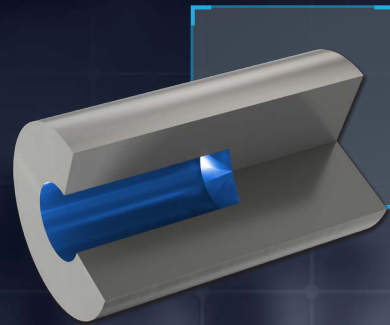
⁽⁵⁾ Seat size code

⁽⁶⁾ Master insert identification

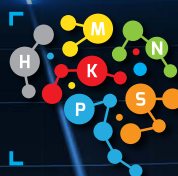


PICCO DRILL

Solid Carbide Drills for
Swiss and Small CNC
Machines with PICCO-CUT
Connections

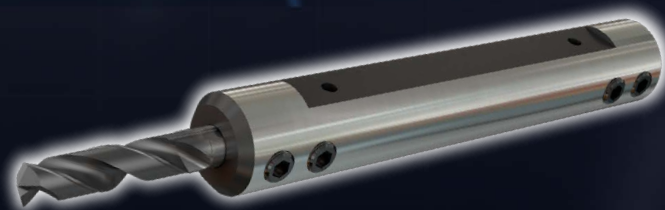


Drill Dia. Range: 3-8mm.
Drilling Depths of 3×D.



YOU Drilling
Intelligently?

Pinpointed Coolant Through Two
Side Channels Directed to the
Cutting Edges.



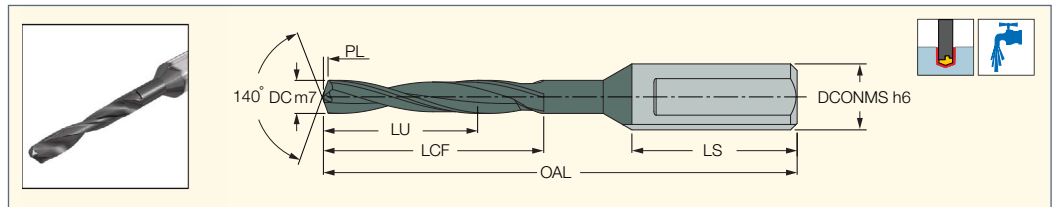
SCAN ME



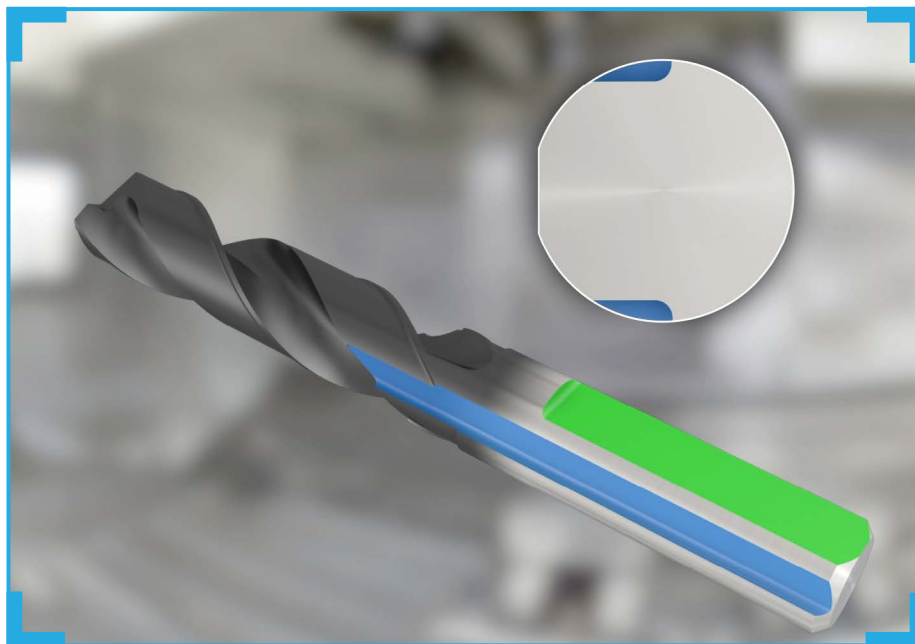
PICCODRILL

SCD-PICCO 3D

Solid Carbide Drills for Swiss and Small CNC Machines

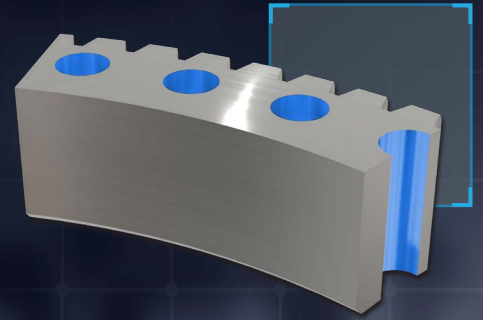


Designation	Dimensions							IC908
	DC	LU	LCF	LS	OAL	PL	DCONMS	
SCD 030-014-060 PICCO 3D	3.00	14.00	21.0	15.0	43.00	0.500	6.00	●
SCD 032-014-060 PICCO 3D	3.20	14.00	21.0	15.0	43.00	0.500	6.00	●
SCD 033-014-060 PICCO 3D	3.30	14.00	21.0	15.0	43.00	0.500	6.00	●
SCD 035-014-060 PICCO 3D	3.50	14.00	21.0	15.0	43.00	0.600	6.00	●
SCD 038-017-060 PICCO 3D	3.80	17.00	25.0	15.0	46.00	0.600	6.00	●
SCD 039-017-060 PICCO 3D	3.90	17.00	25.0	15.0	46.00	0.600	6.00	●
SCD 040-017-060 PICCO 3D	4.00	17.00	25.0	15.0	46.00	0.600	6.00	●
SCD 041-017-060 PICCO 3D	4.10	17.00	25.0	15.0	46.00	0.700	6.00	●
SCD 042-017-060 PICCO 3D	4.20	17.00	25.0	15.0	46.00	0.700	6.00	●
SCD 045-017-060 PICCO 3D	4.50	17.00	25.0	15.0	46.00	0.700	6.00	●
SCD 046-017-060 PICCO 3D	4.60	17.00	25.0	15.0	46.00	0.700	6.00	●
SCD 048-020-060 PICCO 3D	4.80	20.00	29.0	15.0	46.00	0.800	6.00	●
SCD 050-020-060 PICCO 3D	5.00	20.00	29.0	15.0	46.00	0.800	6.00	●
SCD 055-020-060 PICCO 3D	5.50	20.00	29.0	15.0	46.00	0.900	6.00	●
SCD 060-020-060 PICCO 3D	6.00	20.00	29.0	15.0	46.00	0.900	6.00	●
SCD 062-024-080 PICCO 3D	6.20	24.00	35.0	19.0	62.00	1.000	8.00	●
SCD 065-024-080 PICCO 3D	6.50	24.00	35.0	19.0	62.00	1.000	8.00	●
SCD 066-024-080 PICCO 3D	6.60	24.00	35.0	19.0	62.00	1.000	8.00	●
SCD 068-024-080 PICCO 3D	6.80	24.00	35.0	19.0	62.00	1.100	8.00	●
SCD 070-024-080 PICCO 3D	7.00	24.00	35.0	19.0	62.00	1.100	8.00	●
SCD 071-029-080 PICCO 3D	7.10	29.00	42.0	19.0	62.00	1.100	8.00	●
SCD 075-029-080 PICCO 3D	7.50	29.00	42.0	19.0	62.00	1.200	8.00	●
SCD 078-029-080 PICCO 3D	7.80	29.00	42.0	19.0	62.00	1.200	8.00	●
SCD 080-029-080 PICCO 3D	8.00	29.00	42.0	19.0	62.00	1.300	8.00	●



MODUDRILL

Interchangeable
Heads for Large
Diameter Drilling

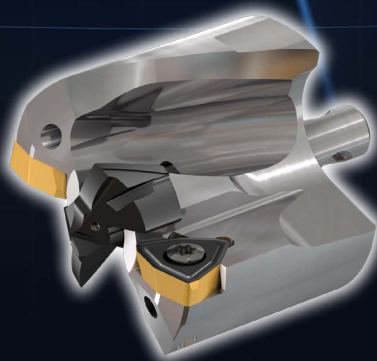


Dia. Range: 33-40mm.
Drilling Depth: 3-5-8XD up to
10XD as Standard Items.



YOU Drilling Intelligently?

Interchangeable Drill Heads with a
Wide Range of TRIGON Inserts and
SUMO-CHAM Drilling Heads. High
Torque Transfer with Large Flutes
for Better Chip Evacuation.



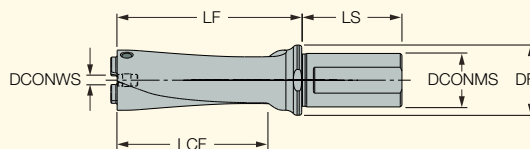
SCAN ME



MODUDRILL

MD-BODY-3D

Modular Drill Bodies, Each Can Carry a Variety of Exchangeable Drilling Heads with Different Diameters



Designation	DCONMS	DF	LS	LF	LCF	DCN ⁽¹⁾	DCX ⁽²⁾	DCONWS			
MD-BODY-28-32-096-32A-3D	32.00	42.00	60.0	105.00	84.0	28.00	32.90	6.50	SET SCREW M5-MODU-DRILL	BLD T15/S7	SW6-T-SH
MD-BODY-33-36-108-32A-3D	32.00	42.00	60.0	121.00	99.0	33.00	36.90	6.70	SET SCREW M6-MODU-DRILL	BLD T15/S7	SW6-T-SH
MD-BODY-37-40-120-32A-3D	32.00	42.00	60.0	137.00	113.0	37.00	40.90	6.90	SET SCREW M6-MODU-DRILL	BLD T15/S7	SW6-T-SH
MD-BODY-41-45-135-40A-3D	40.00	50.00	68.0	155.00	127.0	41.00	45.90	7.10	SET SCREW M6-MODU-DRILL	BLD T15/S7	SW6-T-SH

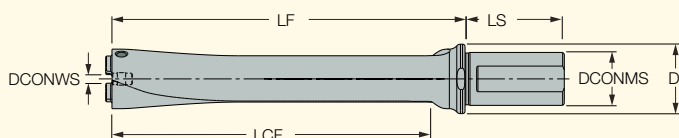
⁽¹⁾ Cutting diameter minimum

⁽²⁾ Cutting diameter maximum

MODUDRILL

MD-BODY-5D

Modular Drill Bodies, Each Can Carry a Variety of Exchangeable Drilling Heads with Different Diameters



Designation	DCONMS	DF	LS	LF	LCF	DCN ⁽¹⁾	DCX ⁽²⁾	DCONWS			
MD-BODY-28-32-160-32A-5D	32.00	42.00	60.0	169.00	148.0	28.00	32.90	6.50	SET SCREW M5-MODU-DRILL	BLD T15/S7	SW6-T-SH
MD-BODY-33-36-180-32A-5D	32.00	42.00	60.0	193.00	171.0	33.00	36.90	6.70	SET SCREW M6-MODU-DRILL	BLD T15/S7	SW6-T-SH
MD-BODY-37-40-200-32A-5D	32.00	42.00	60.0	217.00	193.0	37.00	40.90	6.90	SET SCREW M6-MODU-DRILL	BLD T15/S7	SW6-T-SH
MD-BODY-41-45-225-40A-5D	40.00	50.00	68.0	245.00	217.0	41.00	45.90	7.10	SET SCREW M6-MODU-DRILL	BLD T15/S7	SW6-T-SH

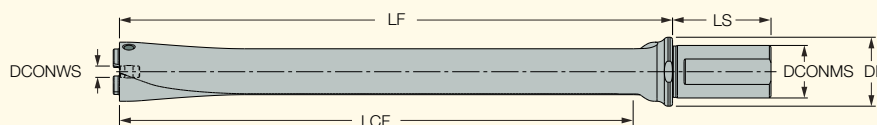
⁽¹⁾ Cutting diameter minimum

⁽²⁾ Cutting diameter maximum

MODUDRILL

MD-BODY-8D

Modular Drill Bodies, Each Can Carry a Variety of Exchangeable Drilling Heads with Different Diameters



Designation	DCONMS	DF	LS	LF	LCF	DCN ⁽¹⁾	DCX ⁽²⁾	DCONWS			
MD-BODY-28-32-256-32A-8D	32.00	42.00	60.0	265.00	244.0	28.00	32.90	6.50	SET SCREW M5-MODU-DRILL	BLD T15/S7	SW6-T-SH
MD-BODY-33-36-288-32A-8D	32.00	42.00	60.0	301.00	279.0	33.00	36.90	6.70	SET SCREW M6-MODU-DRILL	BLD T15/S7	SW6-T-SH
MD-BODY-37-40-320-32A-8D	32.00	42.00	60.0	337.00	313.0	37.00	40.90	6.90	SET SCREW M6-MODU-DRILL	BLD T15/S7	SW6-T-SH
MD-BODY-41-45-360-40A-8D	40.00	50.00	68.0	380.00	352.0	41.00	45.90	7.10	SET SCREW M6-MODU-DRILL	BLD T15/S7	SW6-T-SH

⁽¹⁾ Cutting diameter minimum

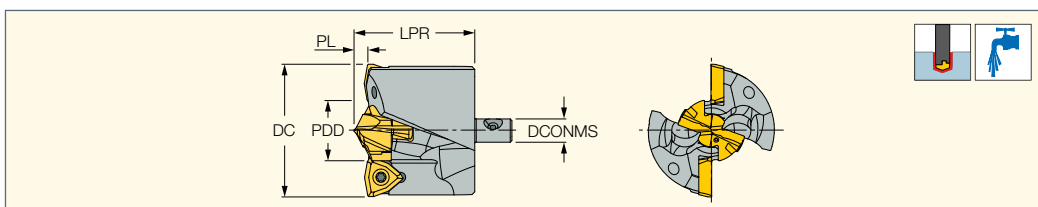
⁽²⁾ Cutting diameter maximum



MODUDRILL

MD-MNC-HEAD

Exchangeable Modular
Drilling Heads with a Pilot
SUMO-CHAM Head and
Peripheral Triangular Inserts



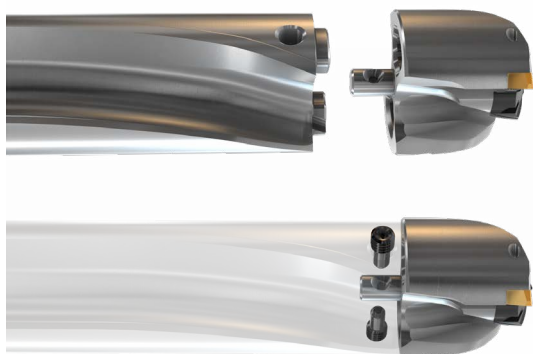
Designation	DC	PDD	LPR	DCONMS	PL	MIID ⁽¹⁾	MIID 2 ⁽²⁾
MD-MNC 280-119-W5	28.00	11.90	30.00	6.50	3.300	ICP 119-MNC 4F	WCGX 05T308-W-DC
MD-MNC 290-129-W5	29.00	12.90	30.30	6.50	3.500	ICP 129-MNC 4F	WCGX 05T308-W-DC
MD-MNC 300-139-W5	30.00	13.90	30.60	6.50	3.700	ICP 139-MNC 4F	WCGX 05T308-W-DC
MD-MNC 310-149-W5	31.00	14.90	30.70	6.50	3.800	ICP 149-MNC 4F	WCGX 05T308-W-DC
MD-MNC 320-159-W5	32.00	15.90	34.80	6.50	4.100	ICP 159-MNC 4F	WCGX 05T308-W-DC
MD-MNC 330-169-W5	33.00	16.90	35.00	6.70	4.300	ICP 169-MNC 4F	WCGX 05T308-W-DC
MD-MNC 332-169-W5	33.20	16.90	35.00	6.70	4.300	ICP 169-MNC 4F	WCGX 05T308-W-DC
MD-MNC 340-189-W5	34.00	18.90	35.00	6.70	3.300	ICP 189-MNC 4F	WCGX 05T308-W-DC
MD-MNC 350-199-W5	35.00	19.90	35.00	6.70	3.300	ICP 199-MNC 4F	WCGX 05T308-W-DC
MD-MNC 360-209-W5	36.00	20.90	35.30	6.70	4.600	ICP 209-MNC 4F	WCGX 05T308-W-DC
MD-MNC 362-209-W5	36.20	20.90	35.30	6.70	3.300	ICP 209-MNC 4F	WCGX 05T308-W-DC
MD-MNC 370-179-W6	37.00	17.90	35.00	6.90	4.600	ICP 179-MNC 4F	WCGX 06T308-W-DC
MD-MNC 380-189-W6	38.00	18.90	35.00	6.90	4.600	ICP 189-MNC 4F	WCGX 06T308-W-DC
MD-MNC 390-199-W6	39.00	19.90	35.00	6.90	4.600	ICP 199-MNC 4F	WCGX 06T308-W-DC
MD-MNC 392-159-W7	39.20	15.90	33.40	6.90	4.400	ICP 159-MNC 4F	WCGX 070408-W-DC
MD-MNC 392-199-W6	39.20	19.90	35.60	6.90	4.600	ICP 199-MNC 4F	WCGX 06T308-W-DC
MD-MNC 400-209-W6	40.00	20.90	35.30	6.90	4.900	ICP 209-MNC 4F	WCGX 06T308-W-DC
MD-MNC 410-219-W6	41.00	21.90	35.80	7.10	5.400	ICP 219-MNC 4F	WCGX 06T308-W-DC
MD-MNC 420-189-W7	42.00	18.90	35.30	7.10	5.000	ICP 189-MNC 4F	WCGX 070408-W-DC
MD-MNC 430-199-W7	43.00	19.90	35.10	7.10	4.800	ICP 199-MNC 4F	WCGX 070408-W-DC
MD-MNC 440-209-W7	44.00	20.90	35.30	7.10	5.000	ICP 209-MNC 4F	WCGX 070408-W-DC
MD-MNC 450-219-W7	45.00	21.90	35.70	7.10	5.400	ICP 219-MNC 4F	WCGX 070408-W-DC

⁽¹⁾ Master insert identification

⁽²⁾ Master insert identification 2

Spare Parts

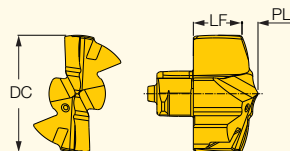
Designation						
MD-MNC 280-119-W5	K MNC 10-13.99		SR 34-506 M3X0.5	T-9/5		
MD-MNC 290-129-W5	K MNC 10-13.99		SR 34-506 M3X0.5	T-9/5		
MD-MNC 300-139-W5	K MNC 10-13.99		SR 34-506 M3X0.5	T-9/5		
MD-MNC 310-149-W5		K MNC 14-21.99	SR 34-506 M3X0.5	T-9/5		
MD-MNC 320-159-W5		K MNC 14-21.99	SR 34-506 M3X0.5	T-9/5		
MD-MNC 330-169-W5		K MNC 14-21.99	SR 34-506 M3X0.5	T-9/5		
MD-MNC 332-169-W5		K MNC 14-21.99	SR 34-506 M3X0.5	T-9/5		
MD-MNC 340-189-W5		K MNC 14-21.99	SR 34-506 M3X0.5	T-9/5		
MD-MNC 350-199-W5		K MNC 14-21.99	SR 34-506 M3X0.5	T-9/5		
MD-MNC 360-209-W5		K MNC 14-21.99	SR 34-506 M3X0.5	T-9/5		
MD-MNC 362-209-W5		K MNC 14-21.99	SR 34-506 M3X0.5	T-9/5		
MD-MNC 370-179-W6		K MNC 14-21.99	SR 34-550-M2	T-10/5		
MD-MNC 380-189-W6		K MNC 14-21.99	SR 34-550-M2	T-10/5		
MD-MNC 390-199-W6		K MNC 14-21.99	SR 34-550-M2	T-10/5		
MD-MNC 392-159-W7		K MNC 14-21.99	SR 34-501..N		SW6-SD	BLD T15/S7
MD-MNC 392-199-W6		K MNC 14-21.99	SR 34-550-M2	T-10/5		
MD-MNC 400-209-W6		K MNC 14-21.99	SR 34-550-M2	T-10/5		
MD-MNC 410-219-W6		K MNC 14-21.99	SR 34-550-M2	T-10/5		
MD-MNC 420-189-W7		K MNC 14-21.99	SR 34-501..N		SW6-SD	BLD T15/S7
MD-MNC 430-199-W7		K MNC 14-21.99	SR 34-501..N		SW6-SD	BLD T15/S7
MD-MNC 440-209-W7		K MNC 14-21.99	SR 34-501..N		SW6-SD	BLD T15/S7
MD-MNC 450-219-W7		K MNC 14-21.99	SR 34-501..N		SW6-SD	BLD T15/S7



MODUDRILL

ICP-MNC

Exchangeable SUMO-CHAM
Drilling Heads for
Modular Combi Drills



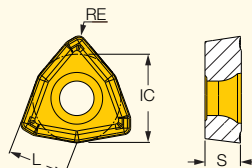
Designation	Dimensions				IC908
	DC	PL	LF	SSC ⁽¹⁾	
ICP 119-MNC 4F	11.90	1.800	4.80	11.0	•
ICP 129-MNC 4F	12.90	2.000	5.00	12.0	•
ICP 139-MNC 4F	13.90	2.100	5.50	13.0	•
ICP 149-MNC 4F	14.90	2.250	5.90	14.0	•
ICP 159-MNC 4F	15.90	2.400	6.30	15.0	•
ICP 169-MNC 4F	16.90	2.600	6.70	16.0	•
ICP 179-MNC 4F	17.90	2.800	7.10	17.0	•
ICP 189-MNC 4F	18.90	2.900	7.60	18.0	•
ICP 199-MNC 4F	19.90	2.700	8.30	19.0	•
ICP 209-MNC 4F	20.90	3.000	8.60	20.0	•
ICP 219-MNC 4F	21.90	3.600	8.50	21.0	•
ICP 229-MNC 4F	22.90	3.500	9.30	22.0	•
ICP 239-MNC 4F	23.90	3.600	9.70	23.0	•
ICP 249-MNC 4F	24.90	3.780	10.12	24.0	•
ICP 259-MNC 4F	25.90	3.960	10.54	25.0	•
ICP 269-MNC 4F	26.90	4.110	10.96	26.0	•
ICP 279-MNC 4F	27.90	4.270	11.38	27.0	•
ICP 289-MNC 4F	28.90	4.620	11.60	28.0	•

⁽¹⁾ Seat size code

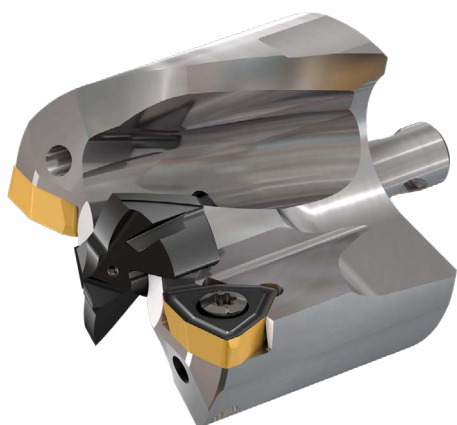
MODUDRILL

WCGX

Precision Ground Trigon Inserts
for Modular MNC Drills



Designation	Dimensions				IC918
	L	IC	S	RE	
WCGX 05T308-W-DC	5.35	7.94	3.88	0.80	•
WCGX 06T308-W-DC	6.38	9.47	3.80	0.80	•
WCGX 070408-W-DC	7.60	11.28	4.76	0.80	•
WCGX 080508-W-DC	8.58	12.74	5.56	0.80	•

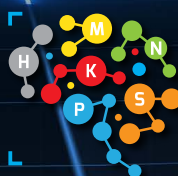


QUICK3CHAM

Exchangeable HEADS
with 3 Effective Cutting
Edges for Boring and
Enlarging Hole Sizes

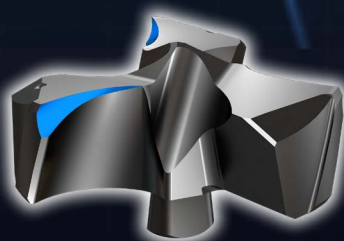


Dia. Range: 12mm-25.9mm.
No Setup Time!



YOU Drilling
Intelligently?

3 Cutting Edges with a Positive
Chipbreaker, for Excellent Chip
Forming, Suitable for a Variety
of Materials.

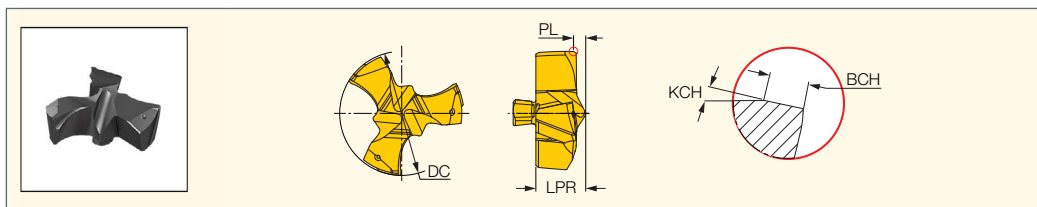


SCAN ME



F3B

Exchangeable 3 Flute
Counterboring Heads

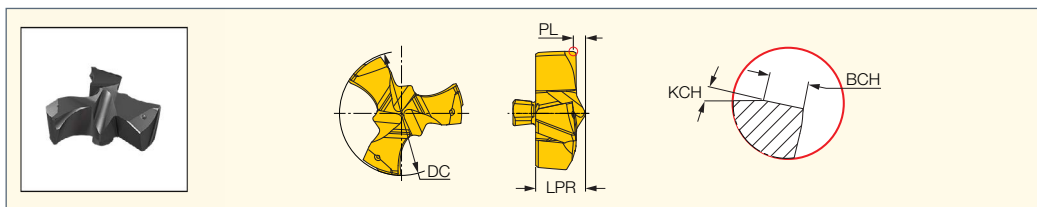


Designation	Dimensions						IC308
	DC	LPR	PL	BCH	KCH	SSC ⁽¹⁾	
F3B 120-IQ	12.00	4.90	0.850	0.40	30.0	12	●
F3B 121-IQ	12.10	4.90	0.850	0.40	30.0	12	●
F3B 122-IQ	12.20	4.90	0.850	0.40	30.0	12	●
F3B 123-IQ	12.30	4.90	0.850	0.40	30.0	12	●
F3B 124-IQ	12.40	4.90	0.850	0.40	30.0	12	●
F3B 125-IQ	12.50	4.90	0.850	0.40	30.0	12	●
F3B 126-IQ	12.60	4.90	0.850	0.40	30.0	12	●
F3B 127-IQ	12.70	4.90	0.850	0.40	30.0	12	●
F3B 128-IQ	12.80	4.90	0.850	0.40	30.0	12	●
F3B 129-IQ	12.90	4.90	0.850	0.40	30.0	12	●
F3B 130-IQ	13.00	5.00	1.000	0.40	30.0	13	●
F3B 131-IQ	13.10	5.00	1.000	0.40	30.0	13	●
F3B 132-IQ	13.20	5.00	1.000	0.40	30.0	13	●
F3B 133-IQ	13.30	5.00	1.000	0.40	30.0	13	●
F3B 134-IQ	13.40	5.00	1.000	0.40	30.0	13	●
F3B 135-IQ	13.50	5.00	1.000	0.40	30.0	13	●
F3B 136-IQ	13.60	5.00	1.000	0.40	30.0	13	●
F3B 137-IQ	13.70	5.00	1.000	0.40	30.0	13	●
F3B 138-IQ	13.80	5.00	1.000	0.40	30.0	13	●
F3B 139-IQ	13.90	5.00	1.000	0.40	30.0	13	●
F3B 140-IQ	14.00	5.74	1.440	0.40	30.0	14	●
F3B 141-IQ	14.10	5.74	1.440	0.40	30.0	14	●
F3B 142-IQ	14.20	5.74	1.440	0.40	30.0	14	●
F3B 143-IQ	14.30	5.74	1.440	0.40	30.0	14	●
F3B 144-IQ	14.40	5.74	1.440	0.40	30.0	14	●
F3B 145-IQ	14.50	5.74	1.440	0.40	30.0	14	●
F3B 146-IQ	14.60	5.74	1.440	0.40	30.0	14	●
F3B 147-IQ	14.70	5.74	1.440	0.40	30.0	14	●
F3B 148-IQ	14.80	5.74	1.440	0.40	30.0	14	●
F3B 149-IQ	14.90	5.74	1.440	0.40	30.0	14	●
F3B 150-IQ	15.00	6.01	1.440	0.40	30.0	15	●
F3B 151-IQ	15.10	6.01	1.440	0.40	30.0	15	●
F3B 152-IQ	15.20	6.01	1.440	0.40	30.0	15	●
F3B 153-IQ	15.30	6.01	1.440	0.40	30.0	15	●
F3B 154-IQ	15.40	6.01	1.440	0.40	30.0	15	●
F3B 155-IQ	15.50	6.01	1.440	0.40	30.0	15	●
F3B 156-IQ	15.60	6.01	1.440	0.40	30.0	15	●
F3B 157-IQ	15.70	6.01	1.440	0.40	30.0	15	●
F3B 158-IQ	15.80	6.01	1.440	0.40	30.0	15	●
F3B 1588-IQ	15.88	6.01	1.440	0.40	30.0	15	●
F3B 159-IQ	15.90	6.01	1.440	0.40	30.0	15	●
F3B 160-IQ	16.00	6.43	1.580	0.40	30.0	16	●
F3B 1605-IQ	16.05	6.43	1.580	0.40	30.0	16	●
F3B 161-IQ	16.10	6.43	1.580	0.40	30.0	16	●
F3B 162-IQ	16.20	6.43	1.580	0.40	30.0	16	●
F3B 163-IQ	16.30	6.43	1.580	0.40	30.0	16	●
F3B 164-IQ	16.40	6.43	1.580	0.40	30.0	16	●
F3B 165-IQ	16.50	6.43	1.580	0.40	30.0	16	●
F3B 166-IQ	16.60	6.43	1.580	0.40	30.0	16	●
F3B 167-IQ	16.70	6.43	1.580	0.40	30.0	16	●
F3B 168-IQ	16.80	6.43	1.580	0.40	30.0	16	●
F3B 169-IQ	16.90	6.43	1.580	0.40	30.0	16	●
F3B 170-IQ	17.00	6.95	1.630	0.40	30.0	17	●
F3B 171-IQ	17.10	6.95	1.630	0.40	30.0	17	●
F3B 172-IQ	17.20	6.95	1.630	0.40	30.0	17	●
F3B 173-IQ	17.30	6.95	1.630	0.40	30.0	17	●
F3B 174-IQ	17.40	6.95	1.630	0.40	30.0	17	●
F3B 1747-IQ	17.47	6.95	1.630	0.40	30.0	17	●
F3B 175-IQ	17.50	6.95	1.630	0.40	30.0	17	●
F3B 176-IQ	17.60	6.95	1.630	0.40	30.0	17	●
F3B 177-IQ	17.70	6.95	1.630	0.40	30.0	17	●
F3B 178-IQ	17.80	6.95	1.630	0.40	30.0	17	●

• For counterboring operations ONLY

⁽¹⁾ Seat size code

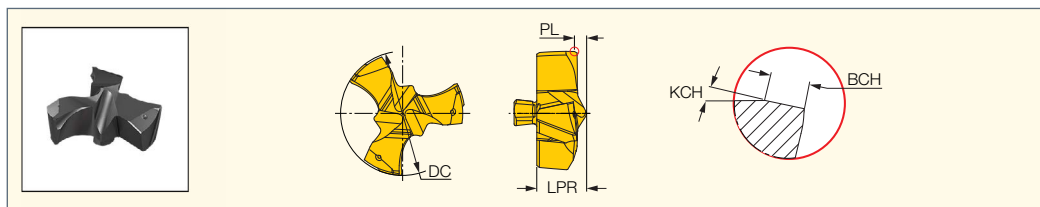
F3B

Exchangeable 3 Flute
Counterboring Heads


Designation	Dimensions						IC908
	DC	LPR	PL	BCH	KCH	SSC ⁽¹⁾	
F3B 179-IQ	17.90	6.95	1.630	0.40	30.0	17	●
F3B 180-IQ	18.00	7.30	1.610	0.40	30.0	18	●
F3B 181-IQ	18.10	7.30	1.610	0.40	30.0	18	●
F3B 182-IQ	18.20	7.30	1.610	0.40	30.0	18	●
F3B 183-IQ	18.30	7.30	1.610	0.40	30.0	18	●
F3B 184-IQ	18.40	7.30	1.610	0.40	30.0	18	●
F3B 185-IQ	18.50	7.30	1.610	0.40	30.0	18	●
F3B 186-IQ	18.60	7.30	1.610	0.40	30.0	18	●
F3B 187-IQ	18.70	7.30	1.610	0.40	30.0	18	●
F3B 188-IQ	18.80	7.30	1.610	0.40	30.0	18	●
F3B 189-IQ	18.90	7.30	1.610	0.40	30.0	18	●
F3B 190-IQ	19.00	7.58	1.600	0.40	30.0	19	●
F3B 1905-IQ	19.05	7.58	1.600	0.40	30.0	19	●
F3B 191-IQ	19.10	7.58	1.600	0.40	30.0	19	●
F3B 192-IQ	19.20	7.58	1.600	0.40	30.0	19	●
F3B 1927-IQ	19.27	7.58	1.600	0.40	30.0	19	●
F3B 193-IQ	19.30	7.58	1.600	0.40	30.0	19	●
F3B 194-IQ	19.40	7.58	1.600	0.40	30.0	19	●
F3B 195-IQ	19.50	7.58	1.600	0.40	30.0	19	●
F3B 196-IQ	19.60	7.58	1.600	0.40	30.0	19	●
F3B 197-IQ	19.70	7.58	1.600	0.40	30.0	19	●
F3B 198-IQ	19.80	7.58	1.600	0.40	30.0	19	●
F3B 199-IQ	19.90	7.58	1.600	0.40	30.0	19	●
F3B 200-IQ	20.00	7.52	1.760	0.40	30.0	20	●
F3B 201-IQ	20.10	7.52	1.760	0.40	30.0	20	●
F3B 202-IQ	20.20	7.52	1.760	0.40	30.0	20	●
F3B 203-IQ	20.30	7.52	1.760	0.40	30.0	20	●
F3B 204-IQ	20.40	7.52	1.760	0.40	30.0	20	●
F3B 205-IQ	20.50	7.52	1.760	0.40	30.0	20	●
F3B 206-IQ	20.60	7.52	1.760	0.40	30.0	20	●
F3B 2064-IQ	20.64	7.52	1.760	0.40	30.0	20	●
F3B 207-IQ	20.70	7.52	1.760	0.40	30.0	20	●
F3B 208-IQ	20.80	7.52	1.760	0.40	30.0	20	●
F3B 209-IQ	20.90	7.52	1.760	0.40	30.0	20	●
F3B 210-IQ	21.00	7.98	1.740	0.40	30.0	21	●
F3B 211-IQ	21.10	7.98	1.740	0.40	30.0	21	●
F3B 212-IQ	21.20	7.98	1.740	0.40	30.0	21	●
F3B 213-IQ	21.30	7.98	1.740	0.40	30.0	21	●
F3B 214-IQ	21.40	7.98	1.740	0.40	30.0	21	●
F3B 215-IQ	21.50	7.98	1.740	0.40	30.0	21	●
F3B 216-IQ	21.60	7.98	1.740	0.40	30.0	21	●
F3B 217-IQ	21.70	7.98	1.740	0.40	30.0	21	●
F3B 218-IQ	21.80	7.98	1.740	0.40	30.0	21	●
F3B 219-IQ	21.90	7.98	1.740	0.40	30.0	21	●
F3B 220-IQ	22.00	8.67	1.830	0.40	30.0	22	●
F3B 221-IQ	22.10	8.67	1.830	0.40	30.0	22	●
F3B 222-IQ	22.20	8.67	1.830	0.40	30.0	22	●
F3B 2223-IQ	22.23	8.67	1.830	0.40	30.0	22	●
F3B 223-IQ	22.30	8.67	1.830	0.40	30.0	22	●
F3B 224-IQ	22.40	8.67	1.830	0.40	30.0	22	●
F3B 225-IQ	22.50	8.67	1.830	0.40	30.0	22	●
F3B 226-IQ	22.60	8.67	1.830	0.40	30.0	22	●
F3B 227-IQ	22.70	8.67	1.830	0.40	30.0	22	●
F3B 228-IQW	22.80	8.67	1.830	0.40	30.0	22	●
F3B 229-IQ	22.90	8.67	1.830	0.40	30.0	22	●
F3B 230-IQ	23.00	8.78	1.960	0.40	30.0	23	●
F3B 231-IQ	23.10	8.78	1.960	0.40	30.0	23	●
F3B 232-IQ	23.20	8.78	1.960	0.40	30.0	23	●
F3B 233-IQ	23.30	8.78	1.960	0.40	30.0	23	●
F3B 234-IQ	23.40	8.78	1.960	0.40	30.0	23	●
F3B 235-IQ	23.50	8.78	1.960	0.40	30.0	23	●
F3B 236-IQ	23.60	8.78	1.960	0.40	30.0	23	●

● For counterboring operations ONLY

⁽¹⁾ Seat size code



Designation	Dimensions						IC908
	DC	LPR	PL	BCH	KCH	SSC ⁽¹⁾	
F3B 237-IQ	23.70	8.78	1.960	0.40	30.0	23	●
F3B 238-IQ	23.80	8.78	1.960	0.40	30.0	23	●
F3B 2381-IQ	23.81	8.78	1.960	0.40	30.0	23	●
F3B 239-IQ	23.90	8.78	1.960	0.40	30.0	23	●
F3B 240-IQ	24.00	8.91	1.800	0.40	30.0	24	●
F3B 241-IQ	24.10	8.91	1.800	0.40	30.0	24	●
F3B 242-IQ	24.20	8.91	1.800	0.40	30.0	24	●
F3B 243-IQ	24.30	8.91	1.800	0.40	30.0	24	●
F3B 244-IQ	24.40	8.91	1.800	0.40	30.0	24	●
F3B 245-IQ	24.50	8.91	1.800	0.40	30.0	24	●
F3B 246-IQ	24.60	8.91	1.800	0.40	30.0	24	●
F3B 247-IQ	24.70	8.91	1.800	0.40	30.0	24	●
F3B 248-IQ	24.80	8.91	1.800	0.40	30.0	24	●
F3B 249-IQ	24.90	8.91	1.800	0.40	30.0	24	●
F3B 250-IQ	25.00	9.87	1.970	0.40	30.0	25	●
F3B 251-IQ	25.10	9.87	1.970	0.40	30.0	25	●
F3B 252-IQ	25.20	9.87	1.970	0.40	30.0	25	●
F3B 253-IQ	25.30	9.87	1.970	0.40	30.0	25	●
F3B 254-IQ	25.40	9.87	1.970	0.40	30.0	25	●
F3B 255-IQ	25.50	9.87	1.970	0.40	30.0	25	●
F3B 256-IQ	25.60	9.87	1.970	0.40	30.0	25	●
F3B 2565-IQ	25.65	9.87	1.970	0.40	30.0	25	●
F3B 257-IQ	25.70	9.87	1.970	0.40	30.0	25	●
F3B 258-IQ	25.80	9.87	1.970	0.40	30.0	25	●
F3B 259-IQ	25.90	9.87	1.970	0.40	30.0	25	●

• For counterboring operations ONLY

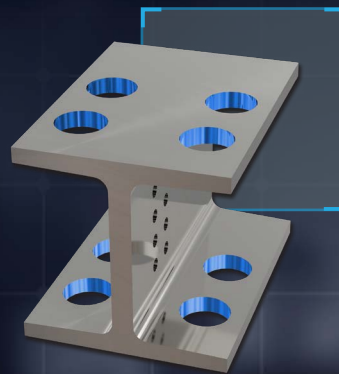
⁽¹⁾ Seat size code

User Guide Lines and Recommendations

- When counterboring with F3B heads, the diameter of the hole being counterbored shall meet the following requirements:
 - 1 The MINIMUM hole diameter must not be less than 70% of the selected F3B head diameter
 An example: Final hole - 16mm
 Calculation: $16 \times 0.7 = 11.2$
 As result, for required counterboring diameter 16mm
 the smallest possible pre-hole diameter is - 11.2mm.
 - 2 The MAXIMUM hole diameter should be smaller by 2mm than the F3B head diameter (1mm on each side). An example: Final hole - 16mm
 Calculation: $16 - 2 = 14$
 As a result, for required counterboring diameter 16mm
 the biggest possible pre-hole diameter is - 14mm.
- Therefore, the pre-hole diameter range for further counterboring operations with a diameter of 16mm can vary from 11.2mm to 14mm.
- For long-reach operations that require applying tools with a cutting depth exceeding $5 \times D$, it is recommended to machine the hole using the same F3B head mounted on a tool with a shorter cutting depth (up to $3 \times D$) to create a pilot hole with a depth of at least $1 \times D$. Next, the machining can be continued using the long-reach tool.



The SUMO-CHAM & SPADE-CHAM Tools and Inserts for Drilling Profile Construction Beams



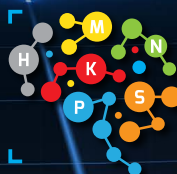
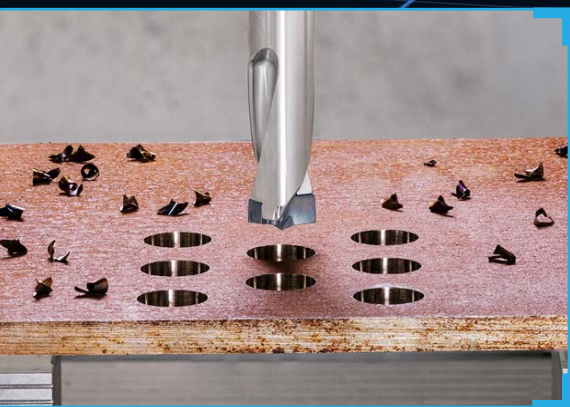
SUMOCHAM



SPADECHAM



Dia. Range: 13.5mm-40mm.
Drilling Ratios: 5xD and 8xD.



YOU Drilling Intelligently?

The New Beam Drilling Tool Line is Designed with a Self-Centering Geometry and a Reinforced Tool Body that Reduces Vibrations, Eliminates Burrs, and Significantly Increases Productivity.

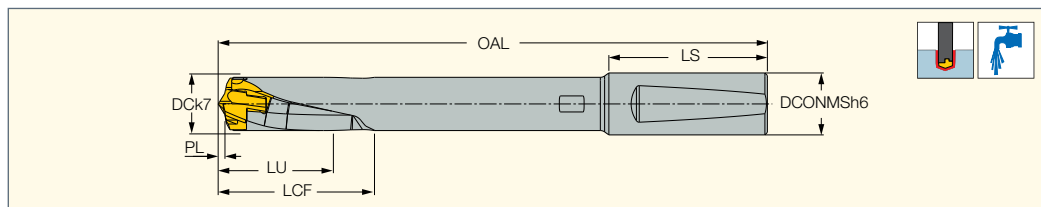
SCAN ME



SUMOCHAM

DCN-N-5D-BD

Exchangeable Head Drills with a Reinforced Body and a WN Shank, Diameter Ratio 5xD, for Construction Beam Industry



Designation	DCN ⁽¹⁾	DCX ⁽²⁾	DCONMS	LU	OAL	PL	LCF	LS	SSC ⁽³⁾	MIID ⁽⁴⁾	
DCN 135-050-16N-5D-BD	13.50	13.99	16.00	40.00	153.60	1.600	50.0	57.0	13.0	IHP 135-BD	K DCN 10-13.99
DCN 140-050-16N-5D-BD	14.00	14.99	16.00	40.00	157.70	1.700	50.0	57.0	14.0	IHP 140-BD	K DCN 14-17.99
DCN 160-050-20N-5D-BD	16.00	16.99	20.00	40.00	175.00	1.950	50.0	59.0	16.0	IHP 160-BD	K DCN 14-17.99
DCN 170-050-20N-5D-BD	17.00	17.99	20.00	40.00	182.00	2.000	50.0	59.0	17.0	IHP 170-BD	K DCN 14-17.99
DCN 180-050-20N-5D-BD	18.00	18.99	20.00	40.00	189.40	2.400	50.0	59.0	18.0	IHP 180-BD	K DCN 18-21.99
DCN 190-050-20N-5D-BD	19.00	19.99	20.00	40.00	197.10	2.550	50.0	59.0	19.0	IHP 190-BD	K DCN 18-21.99
DCN 200-050-25N-5D-BD	20.00	20.99	25.00	40.00	207.60	2.600	50.0	64.0	20.0	IHP 200-BD	K DCN 18-21.99
DCN 210-050-25N-5D-BD	21.00	21.99	25.00	40.00	214.70	2.650	50.0	64.0	21.0	IHP 210-BD	K DCN 18-21.99
DCN 220-050-25N-5D-BD	22.00	22.99	25.00	40.00	221.80	2.750	50.0	64.0	22.0	IHP 220-BD	K DCN 22-26.99
DCN 230-050-25N-5D-BD	23.00	23.99	25.00	40.00	228.90	2.900	50.0	64.0	23.0	IHP 230-BD	K DCN 22-26.99
DCN 240-050-25N-5D-BD	24.00	24.99	25.00	40.00	236.00	3.000	50.0	64.0	24.0	IHP 240-BD	K DCN 22-26.99
DCN 250-050-32N-5D-BD	25.00	25.99	32.00	40.00	246.10	3.100	50.0	68.0	25.0	IHP 250-BD	K DCN 22-26.99
DCN 260-050-32N-5D-BD	26.00	26.99	32.00	40.00	253.30	3.300	50.0	68.0	26.0	IHP 260-BD	K DCN 22-26.99
DCN 270-050-32N-5D-BD	27.00	27.99	32.00	40.00	260.40	3.400	50.0	68.0	27.0	IHP 270-BD	K DCN 27-32.99
DCN 280-050-32N-5D-BD	28.00	28.99	32.00	40.00	267.60	3.550	50.0	68.0	28.0	IHP 280-BD	K DCN 27-32.99
DCN 300-070-32N-5D-BD	30.00	30.99	32.00	50.00	280.80	3.800	70.0	68.0	30.0	IHP 300-BD	K DCN 27-32.99
DCN 320-070-32N-5D-BD	32.00	32.99	32.00	50.00	295.00	3.950	70.0	68.0	32.0	IHP 320-BD	K DCN 27-32.99

• Do not mount smaller drilling heads other than the specified range of the drill body

(1) Cutting diameter minimum

(2) Cutting diameter maximum

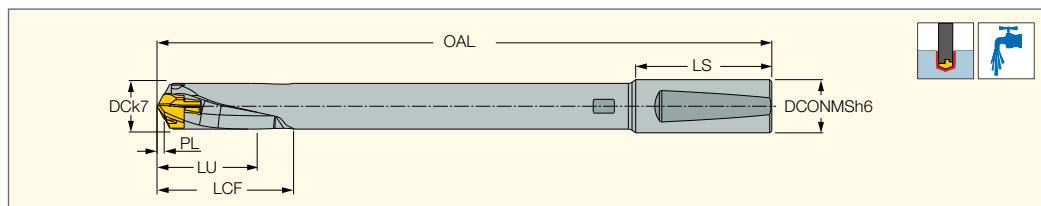
(3) Seat size code

(4) Master insert identification

SUMOCHAM

DCN-N-8D-BD

Exchangeable Head Drills with a Reinforced Body and a WN Shank, Diameter Ratio 8xD, for Construction Beam Industry



Designation	DCN ⁽¹⁾	DCX ⁽²⁾	DCONMS	LU	OAL	PL	LCF	LS	SSC ⁽³⁾	MIID ⁽⁴⁾	
DCN 135-050-16N-8D-BD	13.50	13.99	16.00	40.00	194.10	1.600	50.0	57.0	13.0	IHP 135-BD	K DCN 10-13.99
DCN 140-050-16N-8D-BD	14.00	14.99	16.00	40.00	199.70	1.700	50.0	57.0	14.0	IHP 140-BD	K DCN 14-17.99
DCN 160-050-20N-8D-BD	16.00	16.99	20.00	40.00	223.00	1.950	50.0	59.0	16.0	IHP 160-BD	K DCN 14-17.99
DCN 170-050-20N-8D-BD	17.00	17.99	20.00	40.00	233.00	2.000	50.0	59.0	17.0	IHP 170-BD	K DCN 14-17.99
DCN 180-050-20N-8D-BD	18.00	18.99	20.00	40.00	243.40	2.400	50.0	59.0	18.0	IHP 180-BD	K DCN 18-21.99
DCN 190-050-20N-8D-BD	19.00	19.99	20.00	40.00	254.10	2.550	50.0	59.0	19.0	IHP 190-BD	K DCN 18-21.99
DCN 200-050-25N-8D-BD	20.00	20.99	25.00	40.00	267.60	2.600	50.0	64.0	20.0	IHP 200-BD	K DCN 18-21.99
DCN 210-050-25N-8D-BD	21.00	21.99	25.00	40.00	277.70	2.650	50.0	64.0	21.0	IHP 210-BD	K DCN 18-21.99
DCN 220-050-25N-8D-BD	22.00	22.99	25.00	40.00	287.80	2.750	50.0	64.0	22.0	IHP 220-BD	K DCN 22-26.99
DCN 230-050-25N-8D-BD	23.00	23.99	25.00	40.00	297.90	2.900	50.0	64.0	23.0	IHP 230-BD	K DCN 22-26.99
DCN 240-050-25N-8D-BD	24.00	24.99	25.00	40.00	308.00	3.000	50.0	64.0	24.0	IHP 240-BD	K DCN 22-26.99
DCN 250-050-32N-8D-BD	25.00	25.99	32.00	40.00	321.10	3.100	50.0	68.0	25.0	IHP 250-BD	K DCN 22-26.99
DCN 260-050-32N-8D-BD	26.00	26.99	32.00	40.00	331.30	3.300	50.0	68.0	26.0	IHP 260-BD	K DCN 22-26.99
DCN 270-050-32N-8D-BD	27.00	27.99	32.00	40.00	341.40	3.400	50.0	68.0	27.0	IHP 270-BD	K DCN 27-32.99
DCN 280-050-32N-8D-BD	28.00	28.99	32.00	40.00	351.60	3.550	50.0	68.0	28.0	IHP 280-BD	K DCN 27-32.99
DCN 300-070-32N-8D-BD	30.00	30.99	32.00	50.00	370.80	3.800	70.0	68.0	30.0	IHP 300-BD	K DCN 27-32.99
DCN 320-070-32N-8D-BD	32.00	32.99	32.00	50.00	391.00	3.950	70.0	68.0	32.0	IHP 320-BD	K DCN 27-32.99

• Do not mount smaller drilling heads other than the specified range of the drill body

(1) Cutting diameter minimum

(2) Cutting diameter maximum

(3) Seat size code

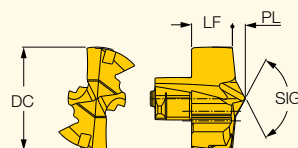
(4) Master insert identification



SUMOCHAM

IHP-BD

Exchangeable Drilling Heads
for DCN Drills for Machining
Construction Beams and
Structural Steel Materials



Designation	Dimensions					IC954
	DC	LF	PL	SIG ⁽¹⁾	SSC ⁽²⁾	
IHP 138-BD	13.80	5.40	1.700	128	13.0	●
IHP 140-BD	14.00	5.60	1.800	128	14.0	●
IHP 1429-BD	14.29	5.60	1.800	128	14.0	●
IHP 160-BD	16.00	6.10	1.950	128	16.0	●
IHP 170-BD	17.00	6.80	2.000	128	17.0	●
IHP 1746-BD	17.46	6.80	2.000	128	17.0	●
IHP 178-BD	17.80	6.80	2.000	128	17.0	●
IHP 180-BD	18.00	7.30	2.400	128	18.0	●
IHP 1905-BD	19.05	7.60	2.550	128	19.0	●
IHP 200-BD	20.00	8.10	2.600	128	20.0	●
IHP 2064-BD	20.64	8.10	2.600	128	20.0	●
IHP 210-BD	21.00	8.50	2.650	128	21.0	●
IHP 218-BD	21.80	8.50	2.650	128	21.0	●
IHP 220-BD	22.00	8.70	2.750	128	22.0	●
IHP 225-BD	22.50	8.70	2.750	128	22.0	●
IHP 230-BD	23.00	9.30	2.900	128	23.0	●
IHP 2381-BD	23.81	9.30	2.900	128	23.0	●
IHP 240-BD	24.00	10.00	3.000	128	24.0	●
IHP 250-BD	25.00	10.00	3.100	128	25.0	●
IHP 254-BD	25.40	10.00	3.100	128	25.0	●
IHP 258-BD	25.80	10.00	3.100	128	25.0	●
IHP 260-BD	26.00	10.30	3.300	128	26.0	●
IHP 265-BD	26.50	10.30	3.300	128	26.0	●
IHP 2699-BD	26.99	10.30	3.300	128	26.0	●
IHP 270-BD	27.00	10.80	3.400	128	27.0	●
IHP 275-BD	27.50	10.80	3.400	128	27.0	●
IHP 280-BD	28.00	11.30	3.550	128	28.0	●
IHP 2858-BD	28.58	11.30	3.550	128	28.0	●
IHP 300-BD	30.00	12.00	3.800	128	30.0	●
IHP 3016-BD	30.16	12.00	3.800	128	30.0	●
IHP 3175-BD	31.75	12.40	3.900	128	31.0	●
IHP 320-BD	32.00	13.30	3.950	128	32.0	●

• Intermediate sizes can be supplied on request

⁽¹⁾ SIG angle varies $\pm 5^\circ$; depends on insert design optimization

⁽²⁾ Seat size code

Cutting Parameters

Material Groups							Recommended Machining Conditions					
ISO	Material	Condition	Tensile Strength [N/mm²]	Hardness HB	Material Group No	Cutting Speed V m/min	Feed vs. Drill Diameter					
							D=12-13.9	D=14-15.9	D=16-19.9	D=20-25.9	D=26-32.9	
							mm/rev					
P	non-alloy steel and cast steel, free cutting steel	< 0.25 %C	annealed	420	125	1	80- 110 -140	0.18 0.24	0.20 0.27	0.25 0.35	0.25 0.35	0.30 0.40
		≥ 0.25 %C	annealed	650	190	2	80- 105 -130					
		< 0.55 %C	quenched and tempered	850	250	3	80- 100 -120					
			annealed	750	220	4	70- 90 -110					
		≥ 0.55 %C	quenched and tempered	1000	300	5	50- 70 -90					
	low alloy and cast steel (less than 5% of alloying elements)	quenched and tempered	annealed	600	200	6	80- 100 -120	0.16 0.24	0.18 0.26	0.23 0.31	0.25 0.35	0.30 0.40
			930	275	7	70- 90 -110						
			1000	300	8	50- 70 -90						
			1200	350	9	40- 55 -70						
	high alloyed steel, cast steel and tool steel	annealed	680	200	10	50- 70 -90	0.15 0.20	0.18 0.23	0.20 0.25	0.22 0.27	0.25 0.30	
		quenched and tempered	1100	325	11	40- 60 -80						
	stainless steel and cast steel	ferritic/martensitic	680	200	12	40- 55 -70	0.14 0.17	0.16 0.20	0.16 0.21	0.18 0.24	0.20 0.27	
		martensitic	820	240	13	40- 55 -70						

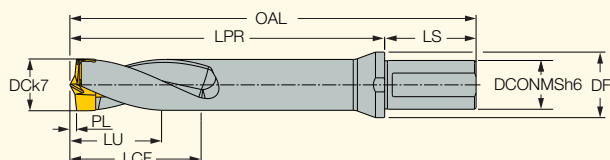
Recommended cutting data



SPADECHAM

DFN A-5D-BD

Exchangeable Head Drills with a Reinforced Body and a Flat Shank, Diameter Ratio 5xD, for Construction Beam Industry



Designation	DCN ⁽¹⁾	DCX ⁽²⁾	DCONMS	LU	OAL	LPR	PL	DF	LCF	LS	SSC ⁽³⁾	
DFN 330-070-32A-5D-BD	33.00	33.99	32.00	50.00	259.60	199.60	4.250	43.00	70.0	60.0	33.0	K DFN 30-40
DFN 340-080-32A-5D-BD	34.00	34.99	32.00	50.00	265.70	205.70	4.510	43.00	80.0	60.0	34.0	K DFN 30-40
DFN 360-080-32A-5D-BD	36.00	36.99	32.00	50.00	277.90	217.90	4.760	43.00	80.0	60.0	36.0	K DFN 30-40
DFN 380-080-32A-5D-BD	38.00	38.99	32.00	50.00	291.00	231.00	5.030	43.00	80.0	60.0	38.0	K DFN 30-40
DFN 390-080-32A-5D-BD	39.00	39.99	32.00	50.00	296.60	236.60	5.160	43.00	80.0	60.0	39.0	K DFN 30-40

• Do not mount smaller drilling heads other than the specified range of the drill body

⁽¹⁾ Cutting diameter minimum

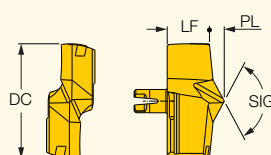
⁽²⁾ Cutting diameter maximum

⁽³⁾ Seat size code

SPADECHAM

IFHP-BD

Exchangeable DFN Drill Heads for Machining Construction Beams and Structural Steel Materials



Designation	Dimensions					IC954
	DC	LF	SSC ⁽¹⁾	PL	SIG ⁽²⁾	
IFHP 330-SPADE-BD	33.00	10.80	33.0	4.250	137	•
IFHP 3334-SPADE-BD	33.34	10.80	33.0	4.250	137	•
IFHP 335-SPADE-BD	33.50	10.80	33.0	4.250	137	•
IFHP 340-SPADE-BD	34.00	11.60	34.0	4.510	137	•
IFHP 3493-SPADE-BD	34.93	11.60	34.0	4.510	137	•
IFHP 3651-SPADE-BD	36.51	12.40	36.0	4.760	137	•
IFHP 380-SPADE-BD	38.00	14.10	38.0	5.030	137	•
IFHP 381-SPADE-BD	38.10	14.10	38.0	5.030	137	•
IFHP 390-SPADE-BD	39.00	13.40	39.0	5.160	137	•
IFHP 397-SPADE-BD	39.70	13.40	39.0	5.160	137	•

• Intermediate sizes can be supplied on request

⁽¹⁾ Seat size code

⁽²⁾ SIG angle varies $\pm 5^\circ$; depends on insert design optimization

Cutting Conditions Recommendations

Mtl. No.	V M/min	IFHP-BD
		Feed Vs. Drill Diameter
		D=33.0-40.0 mm/rev
1	80- 110 -140	0.30 0.40 0.50
2	80- 105 -130	
3	80- 100 -120	
4	70- 90 -110	
5	50- 70 -90	0.30 0.40 0.50
6	80- 100 -120	
7	70- 90 -110	
8	50- 70 -90	
9	40- 55 -70	

Self CENTERING

No burs on the exit due to the sharp cutting edge that eliminates the need for deburring.

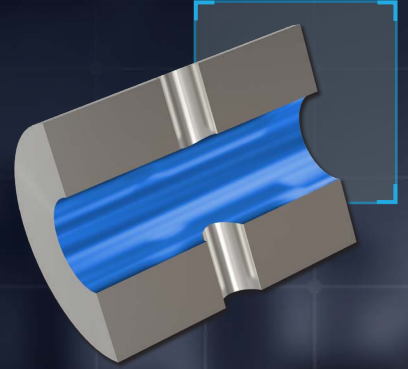


No noise and no vibrations due to the dedicated insert geometry.

Tough nano-layer PVD coating for high chipping and wear resistance.

SUMO**L**DRILL

The Drilling Concept
with a Side Screw Locking
Mechanism for Drilling
Under Unstable Conditions



Dia. Range: 12mm-25.9mm.
Drilling Depth: 3XD & 5XD.



YOU Drilling Intelligently?

.....
Designed with Screw Locking
Mechanism. 2 Symmetrical
Slots Ensure Easy Mounting.
Suitable for ISO P and ISO K
materials.
.....



SCAN ME

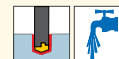
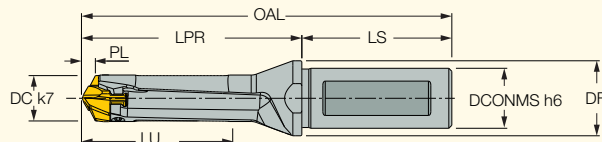




SUMOLDRILL

DLN A-3D

Exchangeable Head Drills
with Screw Lock System for
Interrupted Drilling Applications



Designation	DCN ⁽¹⁾	DCX ⁽²⁾	DCONMS	DF	LU	LPR	PL	LS	OAL	SSC ⁽³⁾	MIID ⁽⁴⁾
DLN 120-036-16A-3D	12.00	12.49	16.00	20.00	38.26	53.0	2.260	48.0	101.00	12.0	ILP 120-2M
DLN 125-037-16A-3D	12.50	12.99	16.00	20.00	39.76	54.5	2.260	48.0	102.50	12.0	ILP 125-2M
DLN 130-039-16A-3D	13.00	13.49	16.00	20.00	41.45	56.6	2.450	48.0	104.60	13.0	ILP 130-2M
DLN 135-041-16A-3D	13.50	13.99	16.00	20.00	42.95	58.1	2.450	48.0	106.10	13.0	ILP 135-2M
DLN 140-042-16A-3D	14.00	14.49	16.00	20.00	44.55	62.1	2.550	48.0	110.15	14.0	ILP 140-2M
DLN 145-044-16A-3D	14.50	14.99	16.00	20.00	46.05	63.6	2.550	48.0	111.65	14.0	ILP 145-2M
DLN 150-045-20A-3D	15.00	15.99	20.00	25.00	47.69	68.7	2.690	50.0	118.73	15.0	ILP 150-2M
DLN 160-048-20A-3D	16.00	16.99	20.00	25.00	50.91	73.3	2.910	50.0	123.30	16.0	ILP 160-2M
DLN 170-051-20A-3D	17.00	17.99	20.00	25.00	54.01	77.9	3.010	50.0	127.90	17.0	ILP 170-2M
DLN 180-054-25A-3D	18.00	18.99	25.00	32.00	57.16	82.5	3.160	56.0	138.50	18.0	ILP 180-2M
DLN 190-057-25A-3D	19.00	19.99	25.00	32.00	60.35	87.0	3.350	56.0	143.00	19.0	ILP 190-2M
DLN 200-060-25A-3D	20.00	20.99	25.00	32.00	63.50	91.6	3.500	56.0	147.60	20.0	ILP 200-2M
DLN 210-063-25A-3D	21.00	21.99	25.00	32.00	66.67	96.2	3.670	56.0	152.18	21.0	ILP 210-2M
DLN 220-066-25A-3D	22.00	22.99	25.00	32.00	69.80	100.8	3.810	56.0	156.76	22.0	ILP 220-2M
DLN 230-069-32A-3D	23.00	23.99	32.00	42.00	72.94	105.3	3.950	60.0	165.33	23.0	ILP 230-2M
DLN 240-072-32A-3D	24.00	24.99	32.00	42.00	76.11	109.9	4.110	60.0	169.90	24.0	ILP 240-2M
DLN 250-075-32A-3D	25.00	25.99	32.00	42.00	79.29	114.5	4.290	60.0	174.50	25.0	ILP 250-2M

• Do not mount smaller drilling heads other than the specified range of the drill body

⁽¹⁾ Cutting diameter minimum

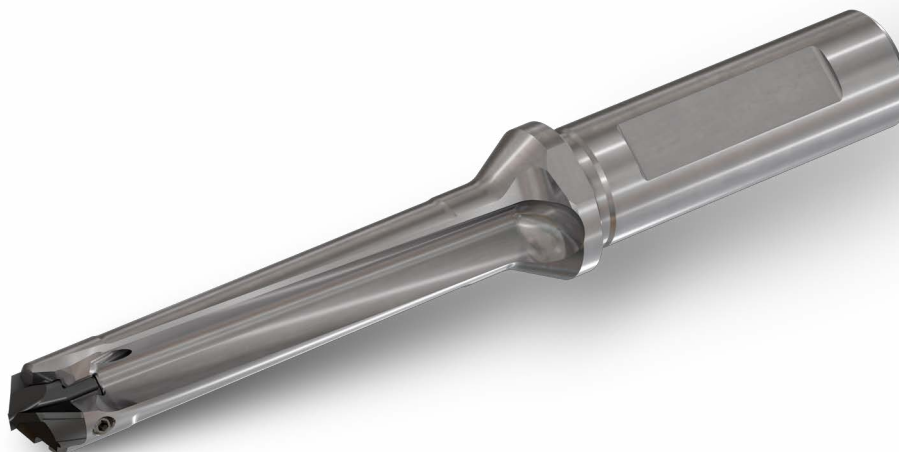
⁽²⁾ Cutting diameter maximum

⁽³⁾ Seat size code

⁽⁴⁾ Master insert identification

Spare Parts

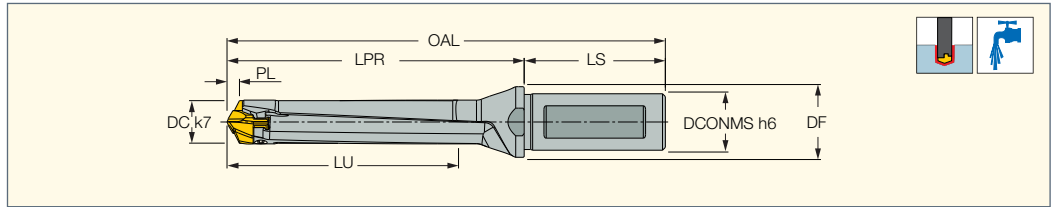
Designation			
DLN 120-036-16A-3D	SR M2.5-L4.5-SL	HW 1.3	
DLN 125-037-16A-3D	SR M2.5-L4.5-SL	HW 1.3	
DLN 130-039-16A-3D	SR M2.5-L5.0-SL	HW 1.3	
DLN 135-041-16A-3D	SR M2.5-L5.0-SL	HW 1.3	
DLN 140-042-16A-3D	SR M3.0-L5.4-SL		L-KEY HEX SL 331 1.5X40MM
DLN 145-044-16A-3D	SR M3.0-L5.4-SL		L-KEY HEX SL 331 1.5X40MM
DLN 150-045-20A-3D	SR M3.0-L5.4-SL		L-KEY HEX SL 331 1.5X40MM
DLN 160-048-20A-3D	SR M3.0-L5.8-SL		L-KEY HEX SL 331 1.5X40MM
DLN 170-051-20A-3D	SR M3.0-L5.8-SL		L-KEY HEX SL 331 1.5X40MM
DLN 180-054-25A-3D	SR M3.0-L6.6-SL		L-KEY HEX SL 331 1.5X40MM
DLN 190-057-25A-3D	SR M3.0-L6.6-SL		L-KEY HEX SL 331 1.5X40MM
DLN 200-060-25A-3D	SR M3.0-L7.6-SL-HSS-HEX		L-KEY HEX SL 331 1.5X40MM
DLN 210-063-25A-3D	SR M3.0-L7.6-SL-HSS-HEX		L-KEY HEX SL 331 1.5X40MM
DLN 220-066-25A-3D	SR M4.0-L8.2-SL-HSS-HEX		L-KEY HEX SL 331 2.0X40MM
DLN 230-069-32A-3D	SR M4.0-L8.2-SL-HSS-HEX		L-KEY HEX SL 331 2.0X40MM
DLN 240-072-32A-3D	SR M4.0-L8.8-SL-HSS-HEX		L-KEY HEX SL 331 2.0X40MM
DLN 250-075-32A-3D	SR M4.0-L8.8-SL-HSS-HEX		L-KEY HEX SL 331 2.0X40MM



SUMOLDRILL

DLN A-5D

Exchangeable Head Drills
with Screw Lock System for
Interrupted Drilling Applications



Designation	DCN ⁽¹⁾	DCX ⁽²⁾	DCONMS	DF	LU	LPR	PL	LS	OAL	SSC ⁽³⁾	MIID ⁽⁴⁾
DLN 120-060-16A-5D	12.00	12.49	16.00	20.00	62.26	77.0	2.280	48.0	125.00	12.0	ILP 120-2M
DLN 125-062-16A-5D	12.50	12.99	16.00	20.00	64.26	79.5	2.260	48.0	127.50	12.0	ILP 125-2M
DLN 130-065-16A-5D	13.00	13.49	16.00	20.00	67.45	82.6	2.450	48.0	130.60	13.0	ILP 130-2M
DLN 135-068-16A-5D	13.50	13.99	16.00	20.00	70.45	85.1	2.450	48.0	133.10	13.0	ILP 135-2M
DLN 140-070-16A-5D	14.00	14.49	16.00	20.00	72.55	90.2	2.550	48.0	138.15	14.0	ILP 140-2M
DLN 145-073-16A-5D	14.50	14.99	16.00	20.00	75.55	92.7	2.550	48.0	140.65	14.0	ILP 145-2M
DLN 150-075-20A-5D	15.00	15.99	20.00	25.00	77.69	98.7	2.690	50.0	148.73	15.0	ILP 150-2M
DLN 160-080-20A-5D	16.00	16.99	20.00	25.00	82.91	105.3	2.910	50.0	155.30	16.0	ILP 160-2M
DLN 170-085-20A-5D	17.00	17.99	20.00	25.00	88.01	111.9	3.010	50.0	161.90	17.0	ILP 170-2M
DLN 180-090-25A-5D	18.00	18.99	25.00	32.00	93.16	118.5	3.160	56.0	174.50	18.0	ILP 180-2M
DLN 190-095-25A-5D	19.00	19.99	25.00	32.00	98.35	125.0	3.350	56.0	181.00	19.0	ILP 190-2M
DLN 200-100-25A-5D	20.00	20.99	25.00	32.00	103.50	131.6	3.500	56.0	187.60	20.0	ILP 200-2M
DLN 210-105-25A-5D	21.00	21.99	25.00	32.00	108.67	138.2	3.670	56.0	194.18	21.0	ILP 210-2M
DLN 220-110-25A-5D	22.00	22.99	25.00	32.00	113.80	144.8	3.810	56.0	200.76	22.0	ILP 220-2M
DLN 230-115-32A-5D	23.00	23.99	32.00	42.00	118.94	151.3	3.950	60.0	211.33	23.0	ILP 230-2M
DLN 240-120-32A-5D	24.00	24.99	32.00	42.00	124.11	157.9	4.110	60.0	217.90	24.0	ILP 240-2M
DLN 250-125-32A-5D	25.00	25.99	32.00	42.00	129.29	164.5	4.290	60.0	224.50	25.0	ILP 250-2M

• Do not mount smaller drilling heads other than the specified range of the drill body

(1) Cutting diameter minimum

(2) Cutting diameter maximum

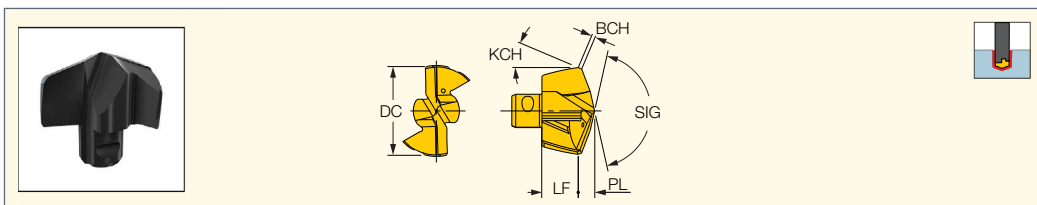
(3) Seat size code

(4) Master insert identification

Spare Parts

Designation			
DLN 120-060-16A-5D	SR M2.5-L4.5-SL	HW 1.3	
DLN 125-062-16A-5D	SR M2.5-L4.5-SL	HW 1.3	
DLN 130-065-16A-5D	SR M2.5-L5.0-SL	HW 1.3	
DLN 135-068-16A-5D	SR M2.5-L5.0-SL	HW 1.3	
DLN 140-070-16A-5D	SR M3.0-L5.4-SL		L-KEY HEX SL 331 1.5X40MM
DLN 145-073-16A-5D	SR M3.0-L5.4-SL		L-KEY HEX SL 331 1.5X40MM
DLN 150-075-20A-5D	SR M3.0-L5.4-SL		L-KEY HEX SL 331 1.5X40MM
DLN 160-080-20A-5D	SR M3.0-L5.8-SL		L-KEY HEX SL 331 1.5X40MM
DLN 170-085-20A-5D	SR M3.0-L5.8-SL		L-KEY HEX SL 331 1.5X40MM
DLN 180-090-25A-5D	SR M3.0-L6.6-SL		L-KEY HEX SL 331 1.5X40MM
DLN 190-095-25A-5D	SR M3.0-L6.6-SL		L-KEY HEX SL 331 1.5X40MM
DLN 200-100-25A-5D	SR M3.0-L7.6-SL-HSS-HEX		L-KEY HEX SL 331 1.5X40MM
DLN 210-105-25A-5D	SR M3.0-L7.6-SL-HSS-HEX		L-KEY HEX SL 331 1.5X40MM
DLN 220-110-25A-5D	SR M4.0-L8.2-SL-HSS-HEX		L-KEY HEX SL 331 2.0X40MM
DLN 230-115-32A-5D	SR M4.0-L8.2-SL-HSS-HEX		L-KEY HEX SL 331 2.0X40MM
DLN 240-120-32A-5D	SR M4.0-L8.8-SL-HSS-HEX		L-KEY HEX SL 331 2.0X40MM
DLN 250-125-32A-5D	SR M4.0-L8.8-SL-HSS-HEX		L-KEY HEX SL 331 2.0X40MM





Designation	Dimensions							IC908
	DC	PL	LF	SIG ⁽¹⁾	KCH	BCH	SSC ⁽²⁾	
ILP 120-2M	12.00	2.260	4.74	140	30.0	0.70	12.0	●
ILP 123-2M	12.30	2.260	4.74	140	30.0	0.70	12.0	●
ILP 125-2M	12.50	2.260	4.74	140	30.0	0.70	12.0	●
ILP 127-2M	12.70	2.260	4.74	140	30.0	0.70	12.0	●
ILP 130-2M	13.00	2.450	5.15	140	30.0	0.70	13.0	●
ILP 135-2M	13.50	2.450	5.15	140	30.0	0.70	13.0	●
ILP 140-2M	14.00	2.550	5.60	140	30.0	0.70	14.0	●
ILP 145-2M	14.50	2.550	5.60	140	30.0	0.70	14.0	●
ILP 149-2M	14.90	2.550	5.60	140	30.0	0.70	14.0	●
ILP 150-2M	15.00	2.690	6.04	140	30.0	0.70	15.0	●
ILP 155-2M	15.50	2.690	6.04	140	30.0	0.70	15.0	●
ILP 1588-2M	15.88	2.690	6.04	140	30.0	0.70	15.0	●
ILP 160-2M	16.00	2.910	6.39	140	30.0	0.70	16.0	●
ILP 165-2M	16.50	2.910	6.39	140	30.0	0.70	16.0	●
ILP 167-2M	16.70	2.910	6.39	140	30.0	0.70	16.0	●
ILP 169-2M	16.90	3.200	6.39	140	30.0	0.70	16.0	●
ILP 170-2M	17.00	3.010	6.89	140	30.0	0.70	17.0	●
ILP 1746-2M	17.46	3.010	6.89	140	30.0	0.70	17.0	●
ILP 175-2M	17.50	3.010	6.89	140	30.0	0.70	17.0	●
ILP 180-2M	18.00	3.160	7.34	140	30.0	0.70	18.0	●
ILP 185-2M	18.50	3.160	7.34	140	30.0	0.70	18.0	●
ILP 190-2M	19.00	3.350	7.65	140	30.0	0.70	19.0	●
ILP 1905-2M	19.05	3.350	7.65	140	30.0	0.70	19.0	●
ILP 195-2M	19.50	3.350	7.65	140	30.0	0.70	19.0	●
ILP 200-2M	20.00	3.500	8.10	140	30.0	0.70	20.0	●
ILP 205-2M	20.50	3.600	8.10	140	30.0	0.70	20.0	●
ILP 210-2M	21.00	3.670	8.51	140	30.0	0.70	21.0	●
ILP 215-2M	21.50	3.760	8.51	140	30.0	0.70	21.0	●
ILP 220-2M	22.00	3.810	8.96	140	30.0	0.70	22.0	●
ILP 225-2M	22.50	3.900	8.96	140	30.0	0.70	22.0	●
ILP 230-2M	23.00	3.950	9.39	140	30.0	0.70	23.0	●
ILP 235-2M	23.50	4.040	9.39	140	30.0	0.70	23.0	●
ILP 240-2M	24.00	4.110	9.79	140	30.0	0.70	24.0	●
ILP 245-2M	24.50	4.200	9.79	140	30.0	0.70	24.0	●
ILP 250-2M	25.00	4.290	10.21	140	30.0	0.70	25.0	●
ILP 255-2M	25.50	4.380	10.21	140	30.0	0.70	25.0	●

⁽¹⁾ SIG angle varies $\pm 5^\circ$; depends on insert design optimization

⁽²⁾ Seat size code

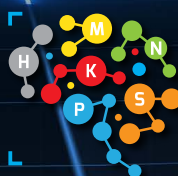


WHISPERLINE

Anti-Vibration Holders with Exchangeable Heads for Deep Boring Applications

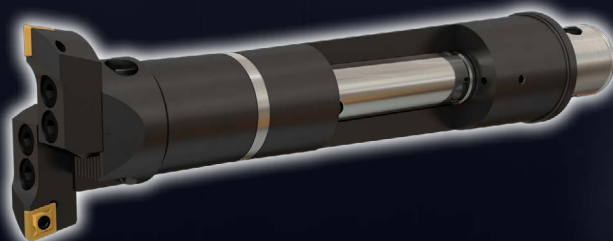


Internal Coolant Supply for Effective Chip Evacuation in Deep Boring.



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Anti Vibration Shank up to 10xD.
MB40 - MB80 Connections with a
Long Overhang for Roughing
and Finishing.



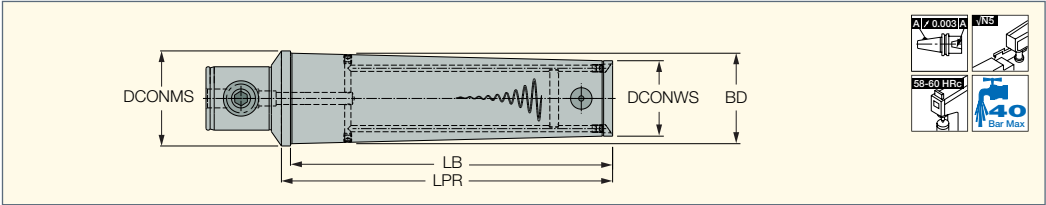
SCAN ME





WHISPERLINE

AV-RE-MB
MB Modular System
Anti-Vibration Reducers

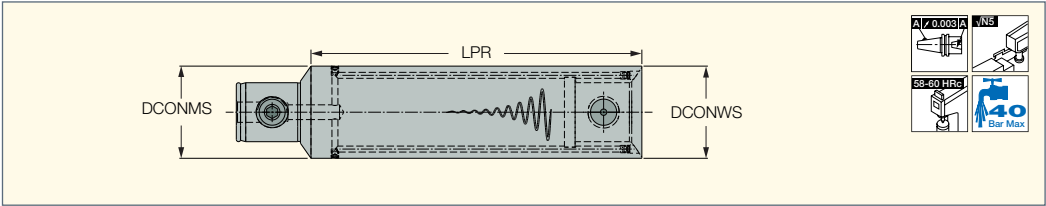


Designation	DCONMS	DCONWS	LPR	BD	LB	kg
AV RE MB50 MB40X176	50.00	40.00	176.00	47.00	170.0	2.36
AV RE MB63 MB50X220	63.00	50.00	220.00	60.00	214.0	4.66
AV RE MB80 MB63X280	80.00	63.00	280.00	77.00	272.0	8.40

• Verify that the weight of the entire tool assembly does not exceed the machine spindle's carrying capability.

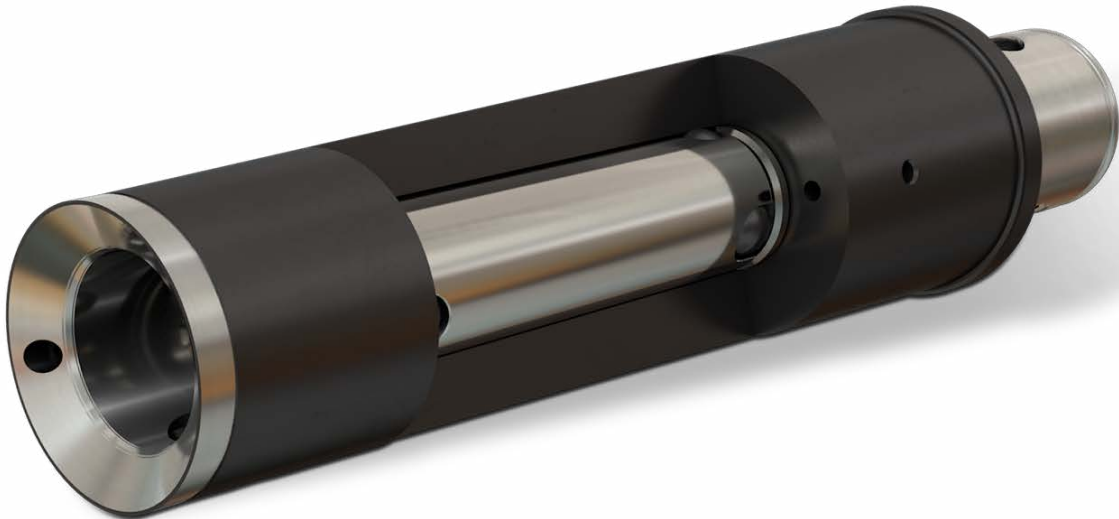
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AV-EX-MB
MB Modular System
Anti-Vibration Extensions



Designation	DCONMS	DCONWS	LPR	kg
AV EX MB50X180	50.00	50.00	180.00	3.04
AV EX MB63X230	63.00	63.00	230.00	6.22
AV EX MB80X280	80.00	80.00	280.00	8.70

• Verify that the weight of the entire tool assembly does not exceed the machine spindle's carrying capability.





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