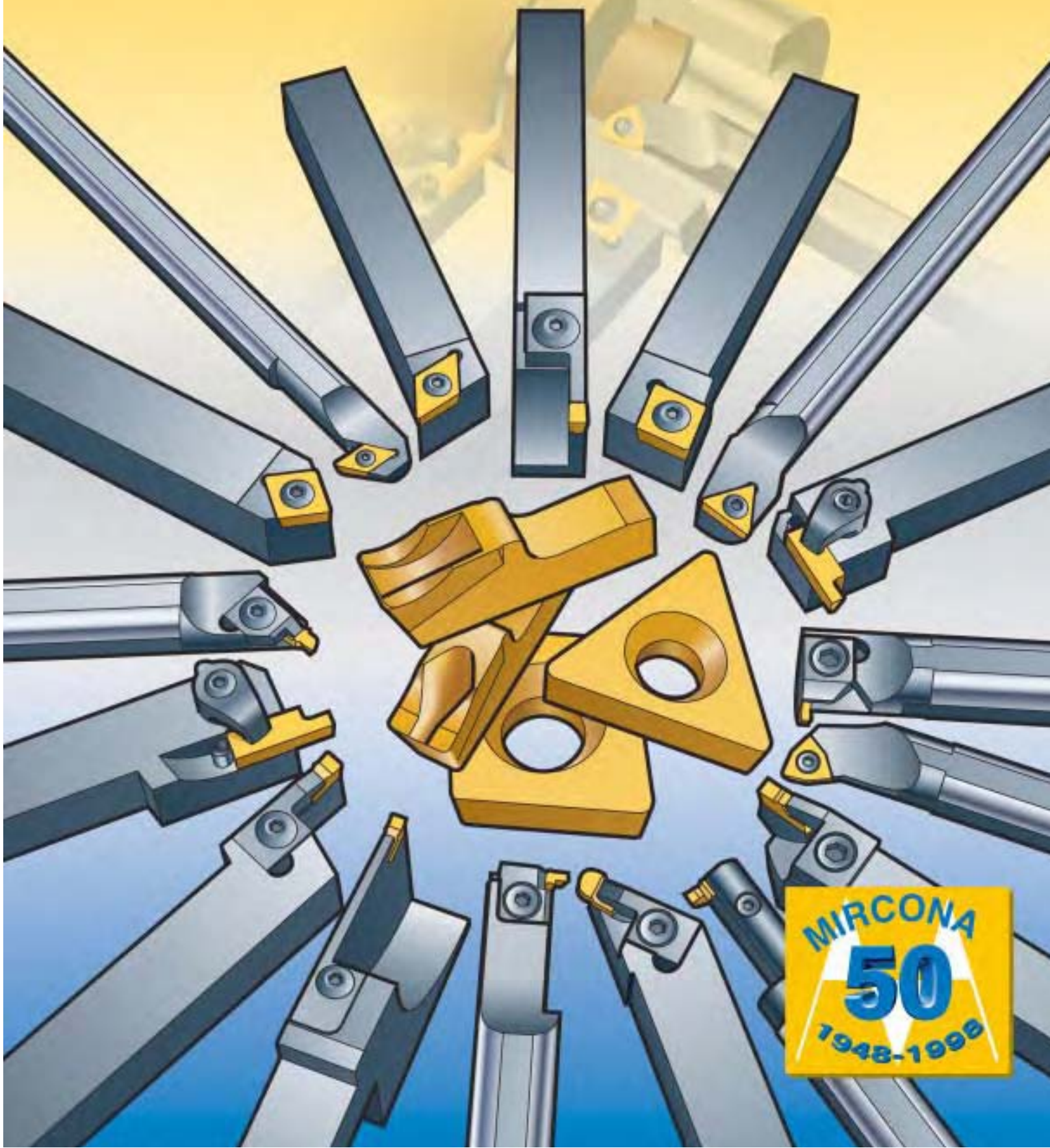




MIRCONA

D

Mini-tools for automatic lathes
Miniaturwerkzeuge für Drehautomaten
Miniverktyg för automatsvarvar



Tool holder

Applications

Recommendations;
PageTechnical speci-
fications; Page

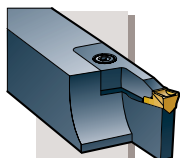
Klemmhalter

Anwendungen

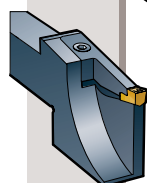
Empfehlungen;
SeiteTechnische Spezi-
fikationen; Seite

Verktygshållare

Användningsområde

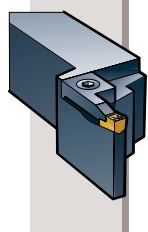
Rekommendationer;
SidaTekniska specifi-
kationer; Sida**151F****151FA**

D8

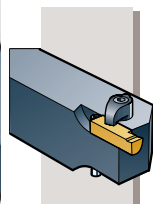
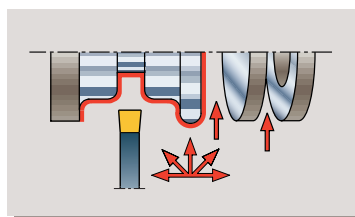
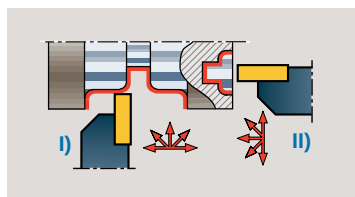
**151RF**

A18–A22

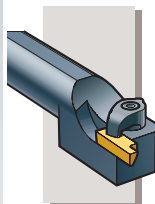
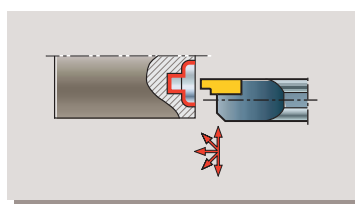
D9

**151G****151GA**Circlip grooves
Sicherungsringnuten
Låsringsspår

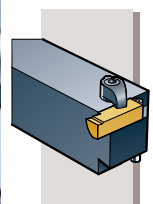
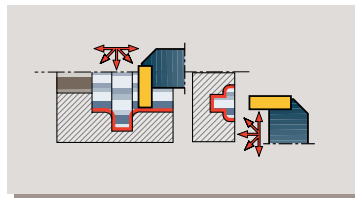
D10

**153E**

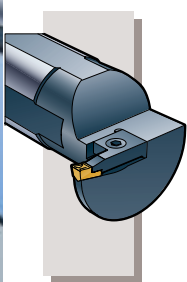
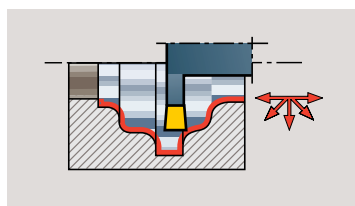
D11

A18–A22¹⁾A23–A26¹⁾**153E-00**

D11

**158E**A30–A32¹⁾A23–A26¹⁾

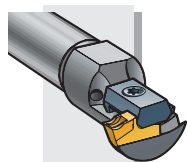
D12

**157G-00****157S-00****157GA-00****157SA-00**Circlip grooves
Sicherungsringnuten
Låsringsspår

A30–A32

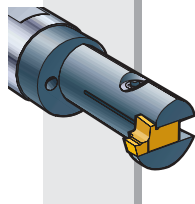
D13-D14

Tool holder	Applications	Recommendations; Page	Technical speci- fications; Page
Klemmhalter	Anwendungen	Empfehlungen; Seite	Technische Spezi- fikationen; Seite
Verkt�ygsh��llare	Anv�ndningsomr�de	Rekommendationer; Sida	Tekniska specifi- kationer; Sida



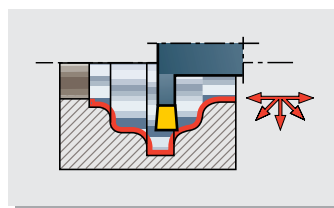
157TA-00

Solid carbide shank
Solider Hartmetallschaft
Skaft i solid h rdmetall



157HA-00

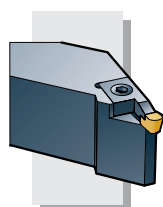
Circlip grooves
S keringsringnuten
L sringssp r



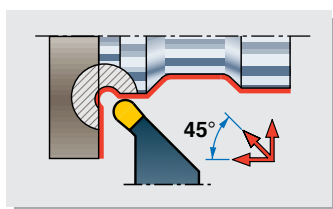
A30-A32

D15

D15

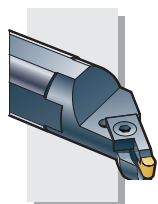


151B

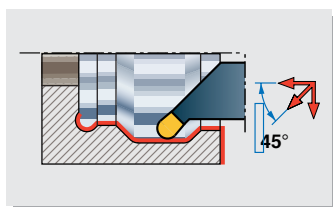


A33-A34

D16



157B



A33-A34

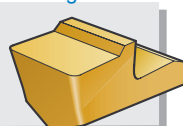
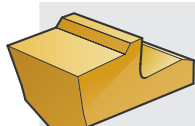
D16

Inserts	Applications	Recommendations; Page	Technical specifi- cations; Page
Schneiden	Anwendungsbereich	Empfehlungen; Seite	Technische Spezi- fikationen; Seite
Sk�r	Anv�ndningsomr�de	Rekommendationer; Sida	Tekniska specifi- kationer; Sida

MT

MTr

O-Ring



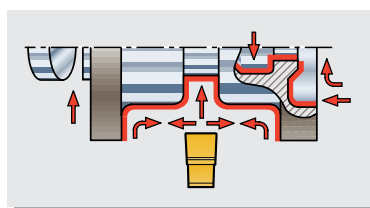
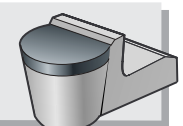
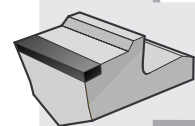
A44-A58

D17-D18

MT

MT-..Fr

Boron nitride/Diamond
Bornitrid/Diamant
Bornitrid/Diamant

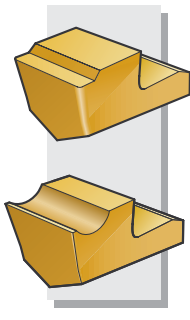
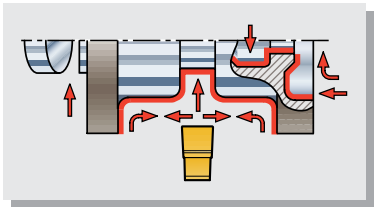


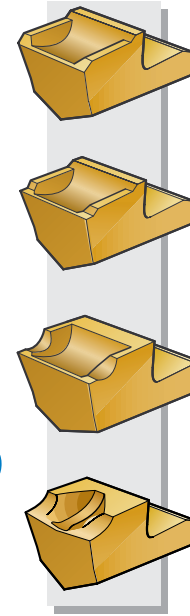
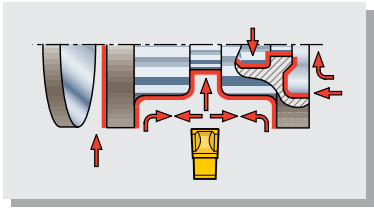
A146-A147

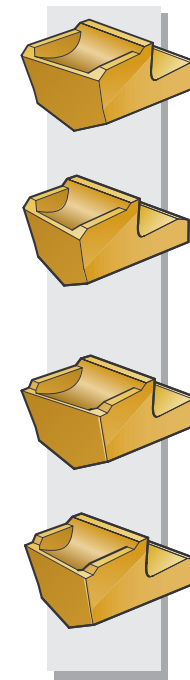
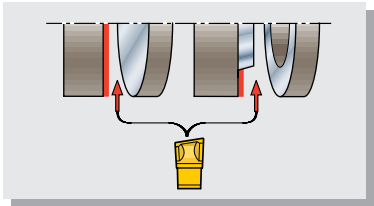
D27



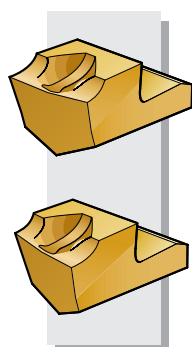
Inserts	Applications	Recommendations; Page	Technical speci- fications; Page
Schneiden	Anwendungsbereich	Empfehlungen; Seite	Technische Spezi- fikationen; Seite
Skär	Användningsområde	Rekommendationer; Sida	Tekniska specifi- kationer; Sida

	MTb		A44–A58	D18
	MTc			D19

	MS		A44–A58	D20
	MZ			D21
	MP			D22
	MA			D22

	R/L MS		A44–A49	D20
	RMS			
	LMS			D21
	R/L MZ			
	RMZ			
	LMZ			

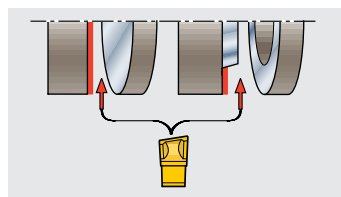
Inserts	Applications	Recommendations; Page	Technical speci- fications; Page
Schneiden	Anwendungsbereich	Empfehlungen; Seite	Technische Spezi- fikationen; Seite
Skär	Användningsområde	Rekommendationer; Sida	Tekniska specifi- kationer; Sida



R/L MA

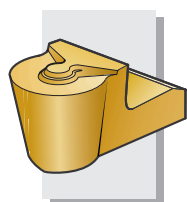
RMA

LMA

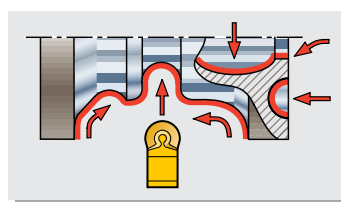


A44–A49

D23

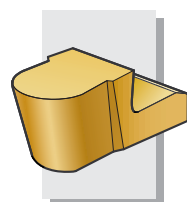


MB

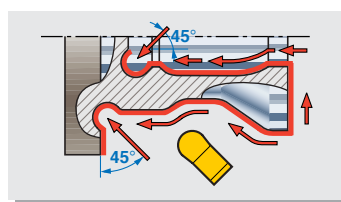


A44–A58

D23

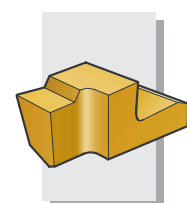


B



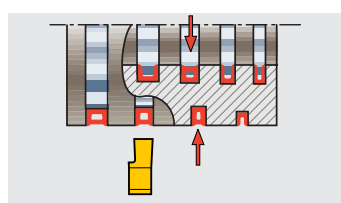
A44–47, A59

D24



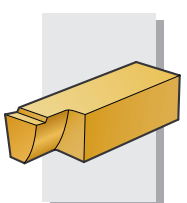
G

Circlip grooves
Sicherungsringnuten
Låsringsspår

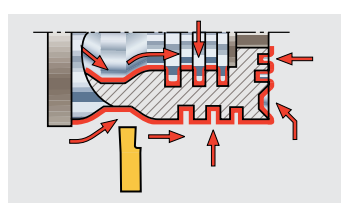


A44–A53

D24

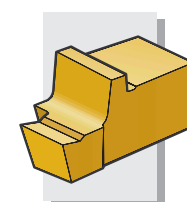


R/LE



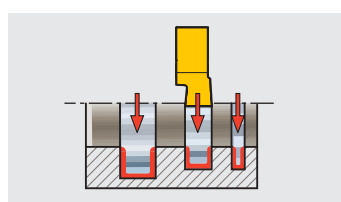
A44–A58

D25



R/LH

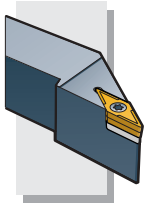
Circlip grooves
Sicherungsringnuten
Låsringsspår



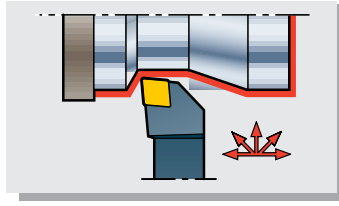
A44–A47, A52–A54

D26

Tool holder	Applications	Recommendations; Page	Technical speci- fications; Page
Klemmhalter	Anwendungen	Empfehlungen; Seite	Technische Spezi- fikationen; Seite
Verktygshållare	Användningsområde	Rekommendationer; Sida	Tekniska speci- fikationer; Sida

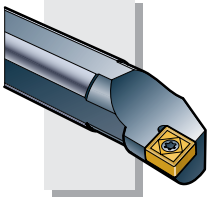


S

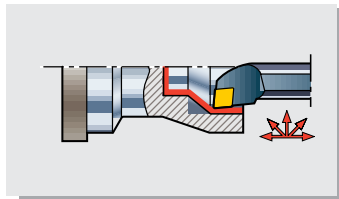


B12-B14, B18

D28-D41



S

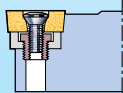


B12-B14, B18

D42-D48



S



Page
Seite
Sida

D

TCMT-PF1

TCGT-PF1

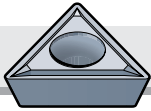
TCMT-PF2

TCMT-PF3

TCMT-PM1

TCMT-PM2

Cermet



D49-D53

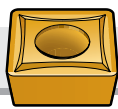
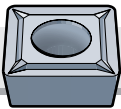
SCMT-PF1

SCMT-PF2

SCMT-PM1

SCMT-PM2

Cermet



D49-D53

CCMT-PF1

CCGT-PF1

CCMT-PF2

CCMT-PF3

CCMT-PM1

CCMT-PM2

CCGT-AL1

Cermet



D49-D53

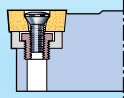
CCXT-AL2



D49-D53



S



Page
Seite
Sida

WCMT-PF1

WCGT-PF1

WCMT-PF2

WCMT-PM1

WCMT-PM2

Cermet



D49-D53

DCMT-PF1

DCGT-PF1

DCMT-PF2

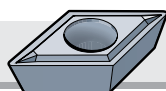
DCMT-PF3

DCMT-PM1

DCMT-PM2

DCGT-AL1

Cermet



D49-D53

DCXT-AL2



D49-D53

VCGT-PF1

Cermet

VCMT-PF2

VCMT-PF3

VCMT-PM1

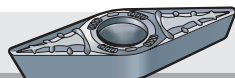
VCMT-PM2



D49-D53

VCGT-AL1

VCXT-AL2



D49-D53

RCMT-PF2

RCMT-PM1

RCMX

RCGT-AL1

RCXT-AL2



D49-D53

Technical Specifications on Tool Holders

Technische Spezifikationen für Werkzeughalter

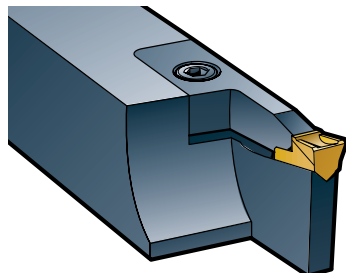
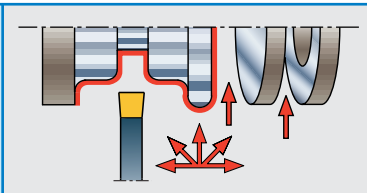
Tekniska specifikationer på verktygshållare

151F

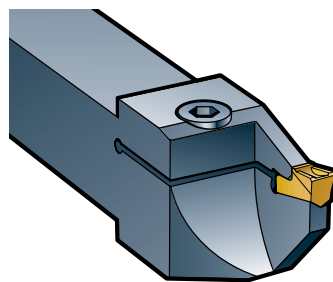
151FA

Recommendations
Empfehlungen
Rekommendationer

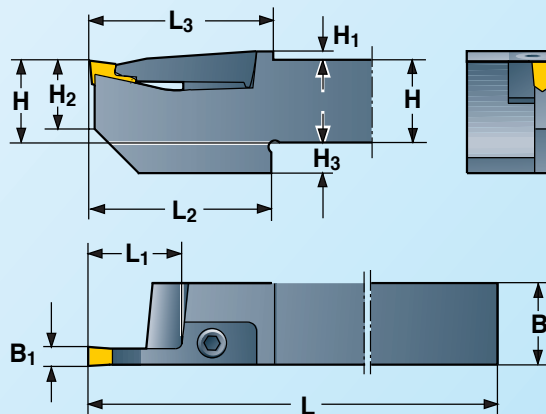
Page:
Seite:
Sida: **A18**



151F



151FA
Automatic lathes
Drehautomaten
Automatsvarvar



The drawing shows right-hand version.
Left-hand version reversed.

Ritningen visar högerutförande.
Vänsterutförande spegelvänt.

Die Zeichnung zeigt Rechtsausführung.
Linksausführung umgekehrt.

EB

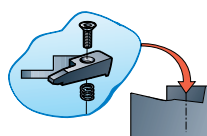
Page: Seite: **A38 - A41**
Sida:



	H	B	L	H ₁	H ₂	H ₃	L ₁	L ₂	L ₃	B ₁	SHR	SHL	MC6S-314	BF 04M	NY 2.5	MT-20 MS-20 R/LMS-20 MZ-20	MP-20 MA-20 R/LMA-20
R/L151FA-1010x10x2	10	10	125	2,5	7	2	10	18	18	2	—	—	—	—	—	—	—
R/L151FA-1212x12.5x2	12	12	150	2,5	7	2	12,5	20	20	2	—	—	—	—	—	—	—
R/L151FA-1414x12.5x2	14	14	150	2,5	8	2	12,5	20	20	2	—	—	—	—	—	—	—
R/L151FA-1616x16x2	16	16	150	3	8	—	16	25	25	2	—	—	—	—	—	—	—
R/L151FA-1010x10x2.5	10	10	125	2,5	7	2	10	18	18	2,5	—	—	—	—	—	—	—
R/L151FA-1212x12.5x2.5	12	12	150	2,5	7	2	12,5	20	20	2,5	—	—	—	—	—	—	—
R/L151FA-1414x12.5x2.5	14	14	150	2,5	8	2	12,5	20	20	2,5	—	—	—	—	—	—	—
R/L151FA-1616x16x2.5	16	16	150	3	8	—	16	25	25	2,5	—	—	—	—	—	—	—
R/L151F-1616x20x2.5	16	16	150	4	—	5	20	40	40	2,5	SHR 202.5	SHL 202.5	F6S 418	BF 04M	—	—	—
R/L151F-1010x13x3S	10	10	90	3,5	—	6	13	25	26	3	SHR 133	SHL 133	F6S 411	—	—	—	—
R/L151F-1212x13x3	12	12	110	3	—	4	13	25	26	3	SHR 133	SHL 133	F6S 411	—	—	—	—
R/L151F-1212x16x3	12	12	150	4	—	4	16	30	34	3	SHR 163F	SHL 163F	F6S 418	—	—	—	—
R/L151F-1414x16x3	14	14	150	3,5	—	2	16	30	34	3	SHR 163F	SHL 163F	F6S 418	—	—	—	—
R/L151F-1616x16x3T	16	16	110	—	—	—	16	—	—	—	SHR 203M	SHL 203M	F6S 415	—	—	—	—
R/L151F-1616x20x3	16	16	150	4	—	4	20	33	42	3	SHR 203M	SHL 203M	F6S418	BF 04M	—	—	—
R/L151F-1010x13x4S	10	10	90	3,5	—	6	13	25	26	4-4,5	SHR 134	SHL 134	F6S 411	—	—	—	—
R/L151F-1212x13x4	12	12	110	3	—	4	13	25	26	4-4,5	SHR 134	SHL 134	F6S 411	—	—	—	—
R/L151F-1616x20x4	16	16	150	4	—	4	20	33	42	4-4,5	SHR 204MT	SHL 204MT	F6S 418	BF 04M	—	—	—
															NY 2.5	MT-4 MT3.7r1 MT-4r1 MT-4.5r1 MT-4b MT-4c MS-4 MS-4D R/LMS-4 MZ-4 R/LMZ-4 MP-4 MP-40 MA-40	R/LMA-40 MB-4F MT-40Fr MT-5 MT-5 r1 MT-5b MT-5c MS-5 R/LMS-5 MZ-5 MP-5 MA-50 MB-5F MT-50Fr

Effective Entry Length for Type 151F, page:
Effektive Stechtiefe für Typ 151F, Seite:
Effektivt stickdjup för typ 151F, sid:

A68



Spare parts shown in the coloured columns are supplied assembled in each tool.

Die in den farbigen Spalten aufgeführten Ersatzteile sind in den Werkzeugen montiert.

Reservdelar i de färgade kolumnerna ingår monterade i varje verktyg.

Ordering example:
Bestellbeispiel:
Beställningsexempel:

R151F-1010 x 13 x 4S



Selection of cutting geometry, page:
Wahl der Schneidengeometrie, Seite:
Val av skärgeometri, sid:

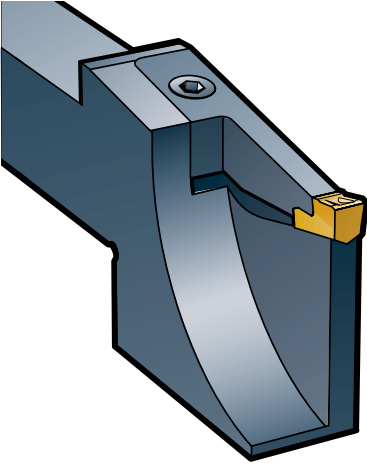
A44-A58

151RF

Recommendations
Empfehlungen
Rekommandationer

Page:
Seite:
Sida:

A20



55,5

H

L₂

f₂

H

42

L₁

B₁

B

L

The drawing shows right-hand version.
Left-hand version reversed.

Die Zeichnung zeigt Rechtsausführung.
Linksausführung umgekehrt.

Ritningen visar högerutförande.
Vänsterutförande spegelvänt.

L151RF R151RF	H	B	L	f ₂	L ₁	L ₂	B ₁	SHR	SHL				* Page: Seite: Sida: D17-D27
R/L151RF-1616x35x3	16	16	150	26	35	48,5	3	SHR 353	SHL 353	F6S 418	BF 04T	NY 2.5	MT-3 MT-3.1r0.5 MT-3b MT-3c MS-3D MS-3 R/LMS-3 MZ-3 R/LMZ-3 MP-30 MP-3 MA-30 R/LMA-30 MB-3F MT-30Fr

*

Selection of cutting geometry, page:

Wahl der Schneidengeometrie, Seite:

Val av skärgeometri, sid:

A44-A58

Ordering example:

Bestellbeispiel:

Beställningsexempel:

L151RF-1616 x 35 x 3

Spare parts shown in the coloured columns are supplied assembled in each tool.

Die in den farbigen Spalten aufgeführten Ersatzteile sind in den Werkzeugen montiert.

Reservdelar i de färgade kolumnerna ingår monterade i varje verktyg.

Effective Entry Length for Type 151RF

Effektive Stechtiefe für Typ 151RF

Effektivt stickdjup för typ 151RF

L151RF R151RF	ØX ØY	50 75 100 150 200 250 300	t									
R/L151RF-1616x35x3	70	35	35	17	10	7	6	5				

ØY

ØX

t

t = maximum entry length

t = maximale Stechtiefe

t = maximalt stickdjup

MIRCONA

D9

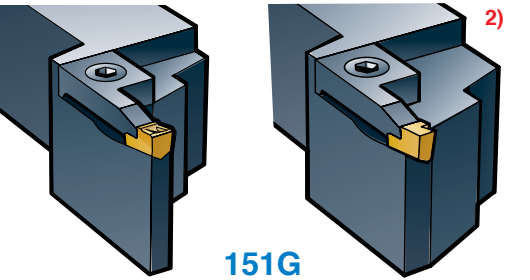
151G

151GA

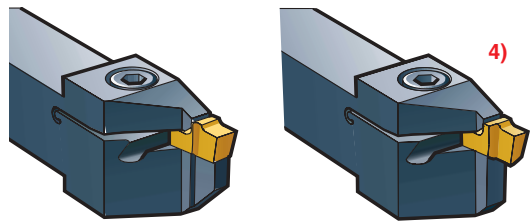
Recommendations
Empfehlungen
Rekommendationer
Page:
Seite:
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A19

Circlip grooves
Sicherungsringnuten
Låsringsspår



151G



151GA
Automatic lathes
Drehautomaten
Automatsvarvar

151G

The drawing shows right-hand version.
Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung.
Linksausführung umgekehrt.
Ritningen visar högerutförande.
Vänsterutförande spegelvänt.

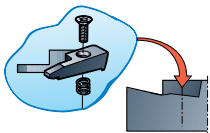
For tool holders marked 2).
Für Klemmhalter mit Kennzeichen 2).
För verktygshållare märkta 2).

151GA

For tool holders marked 4).
Für Klemmhalter mit Kennzeichen 4).
För verktygshållare märkta 4).

D

	H	B	L	H ₁	H ₂	f	L ₁	L ₂	B ₁										
⁴ R/L 151GA-1010x6x1T	10	10	125	2.5	2	10,3													
⁴ R/L 151GA-1212x6x1T	12	12	150	2.5	2	2,3	6	18	0,50-1,85										
⁴ R/L 151GA-1414x6x1T	14	14	150	2.5	2	14,3													
² R/L 151G-1616x3x1T	16	16	100	—	—	20	3	29	0,50-1,85	SHR 133	SHL 133	F6S 411	—	NY 2.5					
R/L 151GA-1010x6x2	10	10	125	2.5	2	10,3													
R/L 151GA-1212x6x2	12	12	150	2.5	2	25	6	18	2,15-2,65										
R/L 151GA-1414x6x2	14	14	150	2.5	2	32													
R/L 151G-1616x4x2	16	16	100	—	—	20	4	29	2,15-3,15	SHR 133	SHL 133	F6S 411	—	NY 2.5					
R/L 151G-1616x13x3	16	16	100	—	—	20	13	29	3	SHR 133	SHL 133	F6S 411	—	NY 2.5					
R/L 151G-1616x13x4	16	16	100	—	—	20	13	29	4-5	SHR 134	SHL 134	F6S 411	—	NY 2.5					



Spare parts shown in the coloured columns are supplied assembled in each tool.

Die in den farbigen Spalten aufgeführten Ersatzteile sind in den Werkzeugen montiert.

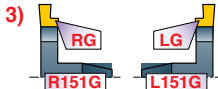
Reservdelar i de färgade kolumnerna ingår monterade i varje verktyg.

Ordering example:

Bestellbeispiel:

Beställningsexempel:

L151G-1616 x 13 x 4



³ Right-hand inserts (RG) are used in right-hand holders and left-hand inserts (LG) are used in left-hand holders.

³ Rechtsschneiden (RG) werden in Rechtshaltern und Linksschneiden (LG) in Linkshaltern verwendet.

³ Högerskär (RG) används i högerhållare och vänsterskär (LG) i vänsterhållare.



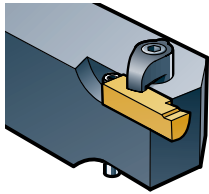
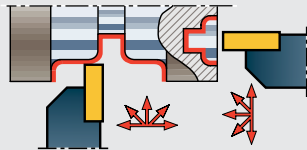
Selection of cutting geometry, page:
Wahl der Schneidengeometrie, Seite:
Val av skärgeometri, sid:

A44-A58

153E

Recommendations
Empfehlungen
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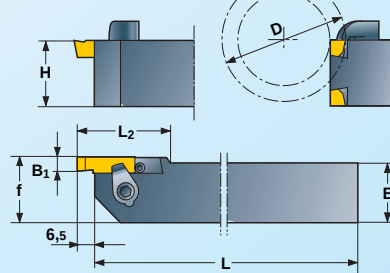
2)



- 2) The holders are assembled for right (R) or left (L) performance by moving the clamp from the holder's upside to its underside.
2) Die Halter werden für Rechts(R)- oder Links (L) ausführung montiert durch Versetzen des Spannhakens von der Oberseite des Halters auf dessen Unterseite.
2) Hållarna monteras för höger(R)- eller vänster(L)utförande genom att flytta spännhaken ifrån hållarens översida till dess undersida.

Radial use.
Radiale Verwendung.
Radiell användning.

Axial use.
Axiale Verwendung.
Axiell användning.



The drawing shows right-hand version. Left-hand version reversed.

Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.

Ritningen visar högerutförande. Vänsterutförande spegelvänt.

	H	B	L	f	L ₂	B ₁	D						Page: Seite: Sida: D25
 1) R/L153E-1212x3x2.5/14-∞ 2) 153E-1616x3x2.5/14-∞	12 16	12 16	90 110	16 16	24 -	2-5	14-∞	RP310 RP316	SH 51	6S 61K	NY 3	R/LE-2b R/LE-2.5b R/LE-3b R/LE-4b R/LE-5b	R/LE-2bQ R/LE-2.5bQ R/LE-3bQ R/LE-4bQ R/LE-5bQ

1)



- 1) Shank 1212 is ordered in right- or left-hand version.
1) Schaft 1212 wird in Rechts- oder Linksausführung bestellt.
1) Skaft 1212 beställs i höger- eller vänsterutförande.



Right-hand inserts (RE) are used in right-hand holders and left-hand inserts (LE) are used in left-hand holders.

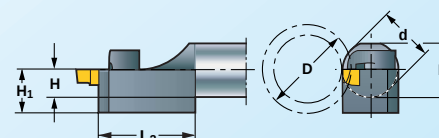
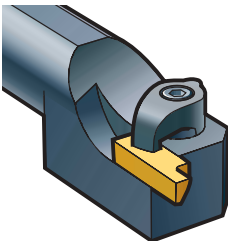
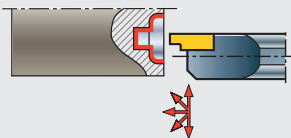
Rechtsschneiden (RE) werden in Rechtshaltern und Linksschneiden (LE) in Linkshaltern verwendet.

Högerskär (RE) används i högerhållare och vänsterskär (LE) i vänsterhållare.

153E-00

Recommendations
Empfehlungen
Rekommendationer

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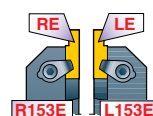


The drawing shows right-hand version. Left-hand version reversed.

Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.

Ritningen visar högerutförande. Vänsterutförande spegelvänt.

	H	H ₁	H ₂	d	L	f	L ₃	B ₁	D						Page: Seite: Sida: D25
R/L153E-0016x3x2.5/14-∞	7,5	15	15	16	110	8	28	2-5	14-∞	RP310	SH 51	6S 61K	NY 3	R/LE-2b R/LE-2.5b R/LE-3b R/LE-4b R/LE-5b	R/LE-2bQ R/LE-2.5bQ R/LE-3bQ R/LE-4bQ R/LE-5bQ



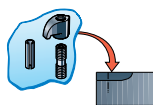
Right-hand inserts (RE) are used in right-hand holders and left-hand inserts (LE) are used in left-hand holders.

Rechtsschneiden (RE) werden in Rechtshaltern und Linksschneiden (LE) in Linkshaltern verwendet.

Högerskär (RE) används i högerhållare och vänsterskär (LE) i vänsterhållare.

Ordering example:
Bestellbeispiel:
Beställningsexempel:

153E-1616 x 3 x 2.5/14-∞



Spare parts shown in the coloured columns are supplied assembled in each tool.
Die in den farbigen Spalten aufgeführten Ersatzteile sind in den Werkzeugen montiert.
Reservdelar i de färgade kolumnerna ingår monterade i varje verktyg.

158E

Recommendations
Empfehlungen
Rekommendationer

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2)

2)

The holder are a embled for right (R) or left (L) performance by moving the clamp from the holder up ide to it under ide.

2)

Die Halter werden für Recht (R)- oder Link (L) au führung montiert durch Ver etzen de Spannhaken von der Ober eite de Halter auf de en Unter eite.

2)

Hållarna montera för höger (R)- eller vän ter(L)utförande genom att flytta pännhaken ifrån hållaren över ida till de under ida.

Axial use.
Axiale Verwendung.
Axiell användning.

Radial use.
Radiale Verwendung.
Radiell användning.

The drawing shows right-hand version.
Left-hand version reversed.

Die Zeichnung zeigt Rechtsausführung.
Linksausführung umgekehrt.

Ritningen visar högerutförande.
Vänsterutförande spegelvänt.

	H	B	L	f	L ₂	B ₁	D						Page: Seite: Sida:
													D25
1) R/L 158E-1212x3x2.5/14-∞ 2) 158E-1616x3x2.5/14-∞	12 16	12 16	90 110	22,5 22,5	17 -	2-5	14-∞	RP310 RP316	SH 51	6S 61K	NY 3	R/LE-2b R/LE-2.5b R/LE-3b R/LE-4b R/LE-5b	R/LE-2bQ R/LE-2.5bQ R/LE-3bQ R/LE-4bQ R/LE-5bQ

1)

1)

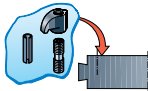
Shank 1212 is ordered in right- or left-hand version.

1)

Schaft 1212 wird in Rechts- oder Linksausführung bestellt.

1)

Skaft 1212 beställs i höger- eller vänsterutförande.



Spare parts shown in the coloured columns are supplied assembled in each tool.
Die in den farbigen Spalten aufgeführten Ersatzteile sind in den Werkzeugen montiert.
Reservdelar i de färgade kolumnerna ingår monterade i varje verktyg.

Ordering example:
Bestellbeispiel:
Beställningsexempel:

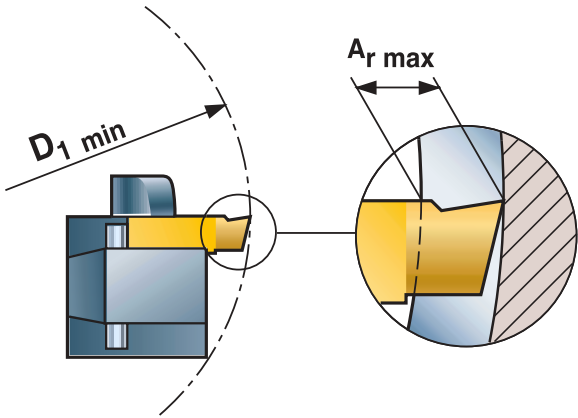
158E-1616 x 3 x 2.5/14-



Right-hand inserts (RE) are used in right-hand holders and left-hand inserts (LE) are used in left-hand holders.
Rechtsschneiden (RE) werden in Rechtshaltern und Linksschneiden (LE) in Linkshaltern verwendet.
Högerskär (RE) används i högerhållare och vänsterskär (LE) i vänsterhållare.

Maximum entry length A_{rmax} , for internal grooving with type 158E, at smallest hole diameter D_{1min}
Maximale Einstechtiefe A_{rmax} , für innen Nutendrehen mit Typ 158E, beim kleinsten Lochdurchmesser D_{1min}
Maximal instickslängd A_{rmax} , för invändig spårsvarning med typ 158E, vid minsta håldiameter D_{1min}

		D _{1 min}				
		Shank size	Schaft grösse	Schaft storlek		
	A _{r max} (mm)	1212	1616	2020	2525	3225
R/LE-2b	1	50	54	80	121	193
R/LE-2.5b	2	50	63	95	145	234
R/LE-3b	2,5	50	70	105	162	262
	2,8	-	-	113	175	283
R/LE-4b	1	50	54	80	121	193
R/LE-5b	2	50	63	95	145	234
	3	50	78	120	184	298
	4	62	106	164	254	414
	5	100	174	270	420	686
	5,5	147	259	403	628	1027
	6	290	514	803	1252	2050



By modifying the holder s shank all tools can be adapted to smallest hole diameter $D_{1min} = 50$ mm.

Beim Modifizieren des Halterschaftes können sämtliche Werkzeuge dem kleinsten Lochdurchmesser $D_{1min} = 50$ mm angepasst werden.

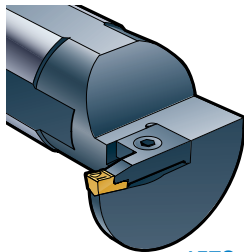
Genom att modifiera hållarens skaft kan samtliga verktyg anpassas till minsta håldiameter $D_{1min} = 50$ mm.

157S-00

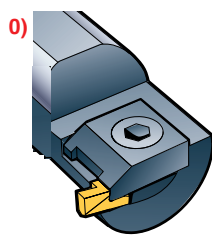
157G-00

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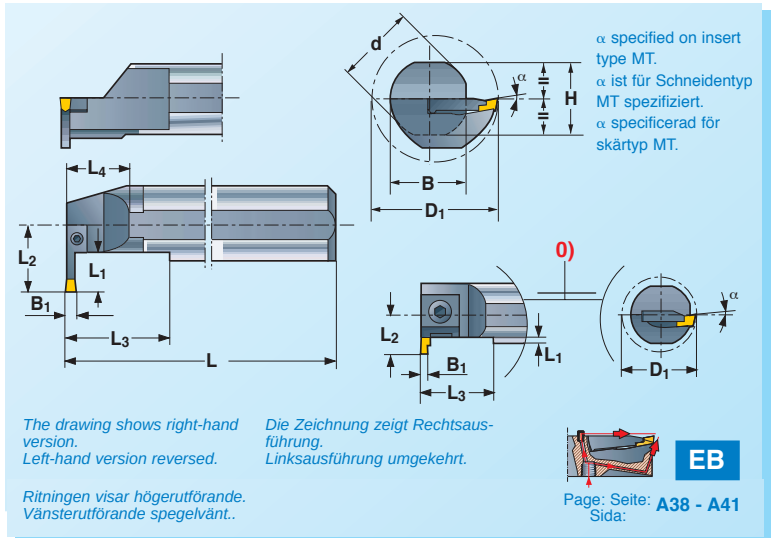
A30

Circlip grooves - Sicherungsringnuten -
Låsringsspår

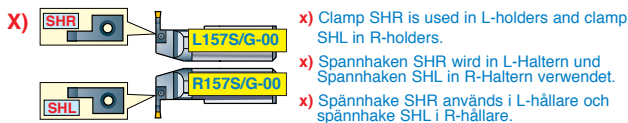
157S-00



157G-00

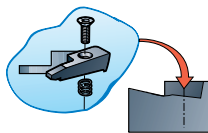


 	α	H	B	D ₁ min	d	L	L ₂	L ₃	L ₄	L ₁	B ₁	  	  		Page: Seite: Sida:		
																D17-D27	
⁰⁾ R/L157G-0016x3x1/16	5	15	15,5	16	16	150	7,5	30	–	3	0,5	^{x)} SHR 43S	^{x)} SHL 43S	F6S 411	–	NY 2.5	R/LG-050b R/LG-110b R/LG-060b R/LG-125b R/LG-070b R/LG-130b R/LG-080b R/LG-155b R/LG-090b R/LG-160b R/LG-105b R/LG-185b
⁰⁾ R/L157G-0016x3x1T	9	15	15,5	20	16	150	10,5	–	–	3	– 1,85	SHN 43		F6S 411	–		
R/L157G-0016x4x2/16	5	15	15,5	16	16	150	7,5	30	–	4	2,15 – 2,65	^{x)} SHR 43S	^{x)} SHL 43S	F6S 411	–	NY 2.5	R/LG-215b ²⁾ R/LG-265b ²⁾
R/L157S-0016x3x3/16	20	15	15,5	16	16	150	7,5	30	–	3	3	^{x)} SHR 43S	^{x)} SHL 43S	F6S 411	–	NY 2.5	MT-3c MP-30 MP-3 MA-30
R/L157S-0016x3x3	1	15	15,5	20	16	150	11	–	25	3	3	SHN 43		F6S-411	– ⁰⁾	NY 2.5	MT-3 MT-3b MT-3c MS-3D MS-3 MZ-3 MP-30 MP-3 MA-30 MB-3F MT-30Fr



Selection of cutting geometry, page:
Wahl der Schneidengeometrie, Seite:
Val av skärgeometri, sid:

A44-A58



Spare parts shown in the coloured columns are supplied assembled in each tool.

Die in den farbigen Spalten aufgeführten Ersatzteile sind in den Werkzeugen montiert.

Reservdelar i de färgade kolumnerna ingår monterade i varje verktyg.

Ordering example:
Bestellbeispiel:
Beställningsexempel:

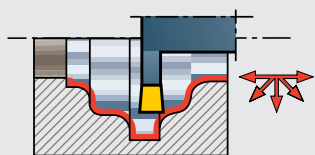
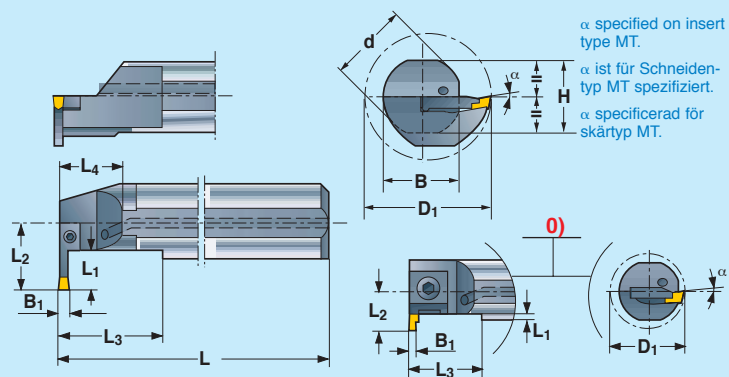
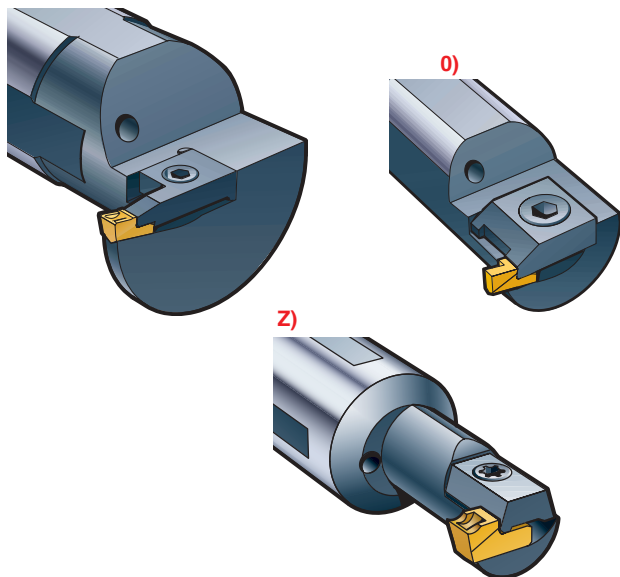
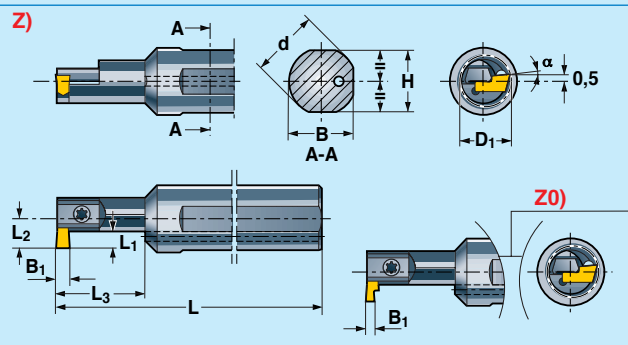
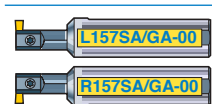
R157S-0016 x 3 x 1T

157SA-00

157GA-00

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Through coolant
Innere Kühlmittelzufuhr
Invändig kylvätsketill-
förselCirclip grooves
Sicherungsringnuten
Läsringsspår α specified on insert
type MT. α ist für Schneiden-
typ MT spezifiziert. α specificerad för
skärtyp MT.The drawing shows right-hand
version.
Left-hand version reversed.Die Zeichnung zeigt Rechtsaus-
führung.
Linksausführung umgekehrt.Ritningen visar högerutförande.
Vänsterutförande spegelvänt. α

H

B

 $D_{1\min}$

d

L

 L_2 L_3 L_4 L_1 B_1

SHN

SHR

SHL

FTX072507

F6S 411

NY7X

NY2.5

NY2.5

R/LG-050b

R/LG-060b

R/LG-070b

R/LG-080b

R/LG-090b

R/LG-105b

R/LG-110b

R/LG-125b

R/LG-130b

R/LG-155b

R/LG-160b

R/LG-185b

Page:
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D17-D27

D

2) R/L157GA-0016x3x1/12
 0) R/L157GA-0016x3x1/16
 0) R/L157GA-0016x3x1

5

15

15,5

12

16

130

6,0

25

-

-

0,50

-

1,85

SHN 33

FTX072507

F6S 411

-

NY7X

NY2.5

NY2.5

R/LG-050b

R/LG-060b

R/LG-070b

R/LG-080b

R/LG-090b

R/LG-105b

R/LG-110b

R/LG-125b

R/LG-130b

R/LG-155b

R/LG-160b

R/LG-185b

R/L157GA-0016x4x2/16

5

15

15,5

16

16

150

7,5

30

-

4

2,15

-

3,15

SHN 33

FTX072507

F6S 411

-

NY2.5

NY2.5

R/LG-215b²⁾R/LG-315b²⁾R/LG-265b²⁾

2) R/L157SA-0016x3x2/12

20

15

15,5

12

16

130

6,0

25

-

3

2

SHN 33

FTX072507

F6S 411

-

NY7X

NY2.5

NY2.5

R/LG-050b

R/LG-060b

R/LG-070b

R/LG-080b

R/LG-090b

R/LG-105b

R/LG-110b

R/LG-125b

R/LG-130b

R/LG-155b

R/LG-160b

R/LG-185b

R/L157SA-0016x3x2/16

20

15

15,5

16

16

150

7,5

30

-

3

2

SHN 33

FTX072507

F6S 411

-

NY7X

NY2.5

NY2.5

R/LG-050b

R/LG-060b

R/LG-070b

R/LG-080b

R/LG-090b

R/LG-105b

R/LG-110b

R/LG-125b

R/LG-130b

R/LG-155b

R/LG-160b

R/LG-185b

R/L157SA-0016x3x2

20

15

15,5

20

16

150

10,5

-

25

3

2

SHN 33

FTX072507

F6S 411

-

NY7X

NY2.5

NY2.5

R/LG-050b

R/LG-060b

R/LG-070b

R/LG-080b

R/LG-090b

R/LG-105b

R/LG-110b

R/LG-125b

R/LG-130b

R/LG-155b

R/LG-160b

R/LG-185b

R/L157SA-0016x3x2.5/12

20

15

15,5

12

16

130

6,0

25

-

3

2,5

SHN 33

FTX072507

F6S 411

-

NY7X

NY2.5

NY2.5

R/LG-050b

R/LG-060b

R/LG-070b

R/LG-080b

R/LG-090b

R/LG-105b

R/LG-110b

R/LG-125b

R/LG-130b

R/LG-155b

R/LG-160b

R/LG-185b

R/L157SA-0016x3x2.5/16

20

15

15,5

16

16

150

7,5

30

-

3

2,5

SHN 33

FTX072507

F6S 411

-

NY7X

NY2.5

NY2.5

R/LG-050b

R/LG-060b

R/LG-070b

R/LG-080b

R/LG-090b

R/LG-105b

R/LG-110b

R/LG-125b

R/LG-130b

R/LG-155b

R/LG-160b

R/LG-185b

R/L157SA-0016x3x3/12

20

15

15,5

12

16

130

6,0

25

-

3

2,5

SHN 33

FTX072507

F6S 411

-

NY7X

NY2.5

NY2.5

R/LG-050b

R/LG-060b

R/LG-070b

R/LG-080b

R/LG-090b

R/LG-105b

R/LG-110b

R/LG-125b

R/LG-130b

R/LG-155b

R/LG-160b

R/LG-185b

R/L157SA-0016x3x3/16

20

15

15,5

16

16

150

7,5

30

-

3

2,5

SHN 33

FTX072507

F6S 411

-

NY7X

NY2.5

NY2.5

R/LG-050b

R/LG-060b

R/LG-070b

R/LG-080b

R/LG-090b

R/LG-105b

R/LG-110b

R/LG-125b

R/LG-130b

R/LG-155b

R/LG-160b

R/LG-185b

R/L157SA-0016x3x3

20

15

15,5

20

16

150

10,5

-

25

3

2,5

SHN 33

FTX072507

F6S 411

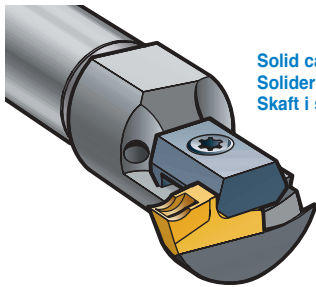
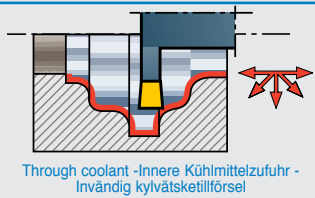
-

157TA-00

Recommendations
Empfehlungen
Rekommendationer

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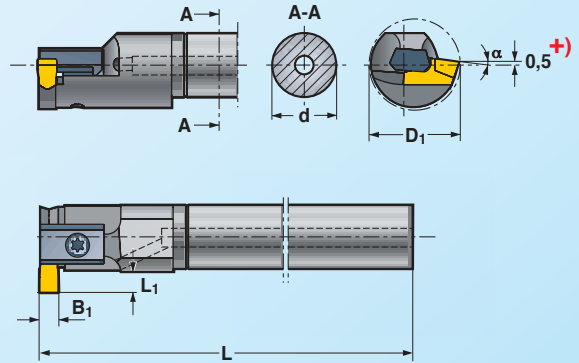
Solid carbide shank
Solider Hartmetallschaft
Skaf i solid hårdmetall

$f_n = 0,01 - 0,03$

f_n = Feed, mm/rev

f_n = Vorschub, mm/U

f_n = Matning, mm/varv



The drawing shows right-hand version.
Left-hand version reversed.

Die Zeichnung zeigt Rechtsausführung.
Linksausführung umgekehrt.

Ritningen visar högerutförande.
Vänsterutförande spegelvänt.

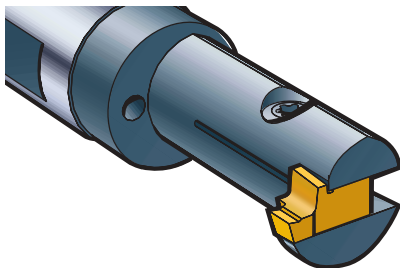
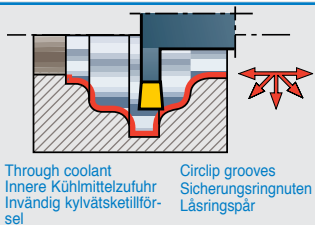
	α	D_1 min	d	L	L_1	B_1	SHN	FTX072507	NY7X	*	Page: Seite: Sida:
R/L157TA-0008x3x2/12 R/L157TA-0010x3x2/14	20 20	12 14	8 10	130 150	3	2	SHN 33	FTX072507	NY7X	MP-20 MA-20	D22-D23
R/L157TA-0008x3x2.5/12 R/L157TA-0010x3x2.5/14	20 20	12 14	8 10	130 150	3	2,5	SHN 33	FTX072507	NY7X	MP-25 MA-25	
R/L157TA-0008x3x3/12 R/L157TA-0010x3x3/14	20 20	12 14	8 10	130 150	3	3	SHN 33	FTX072507	NY7X	MP-3 MA-30 MP-30	
R/L157TA-0008x3x4/12 R/L157TA-0010x3x4/14	20 20	12 14	8 10	130 150	3	4	SHN 33	FTX072507	NY7X	MP-40 MA-40 MP-4	

157HA-00

Recommendations
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Rekommendationer

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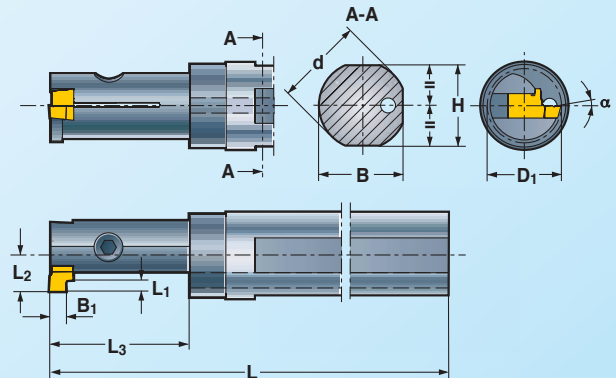


$f_n = 0,01 - 0,03$

f_n = Feed, mm/rev

f_n = Vorschub, mm/U

f_n = Matning, mm/varv

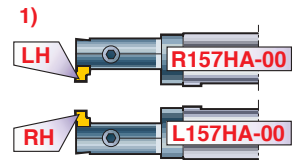


The drawing shows right-hand version.
Left-hand version reversed.

Die Zeichnung zeigt Rechtsausführung.
Linksausführung umgekehrt.

Ritningen visar högerutförande.
Vänsterutförande spegelvänt.

	α	H	B	D_1 min	d	L	L_2	L_3	L_1	B_1	FTX072206	NY7X	*	Page: Seite: Sida:
R/L157HA-0012x2x1/8 R/L157HA-0012x2.5x2/10	10 10	11 11	11,5 11,5	8 10	12 12	125 125	3,6 4,6	21 21	1 2,5	0,4 2	FTX072206 MC6S-205	NY7X NY1.5	R/LH-040b1) R/LH-090b1) R/LH-110b1) R/LH-125b1) R/LH-200b1)	D26



1) Left-hand inserts (LH) are used in right-hand holders and right-hand inserts (RH) are used in left-hand holders.

1) Linksschneiden (LH) werden in Rechtshaltern und Rechtsschneiden (RH) in Linkshaltern verwendet.

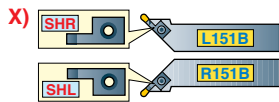
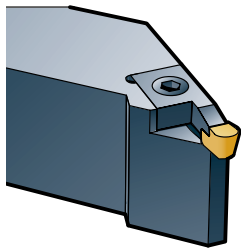
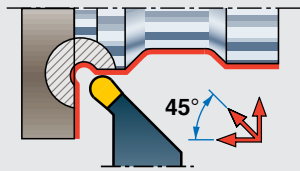
1) Vänsterskär (LH) används i högerhållare och högerskär (RH) i vänsterhållare.

151B

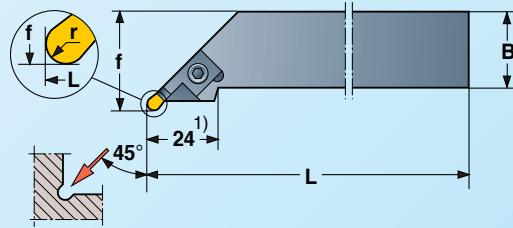
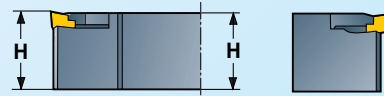
Recommendations
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Rekommendationer

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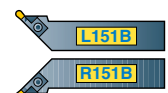
- x) Clamp SHR is used in L-holders and clamp SHL in R-holders.
- x) Spannhaken SHR wird in L-Haltern und Spannhaken SHL in R-Haltern verwendet.
- x) Spännhake SHR används i L-hållare och spännhake SHL i R-hållare.



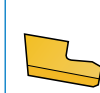
The drawing shows right-hand version.
Left-hand version reversed.

Die Zeichnung zeigt Rechtsausführung.
Linksausführung umgekehrt.

Ritningen visar högerutförande.
Vänsterutförande spegelvänt.



H B L f r



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D24

R/L151B-1616x2x2

16 16 100 20 1-1,5

* SHR 134

* SHL 134

F6S 411

-

NY 2.5

B-200r1
B-300r1.5

R/L151B-1616x4x4

16 16 100 20 2-3

* SHR 134

* SHL 134

F6S 411

-

NY 2.5

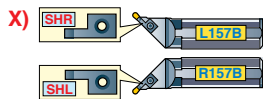
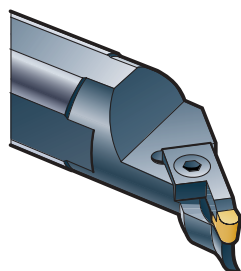
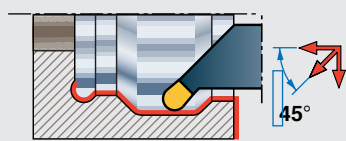
B-400r2
B-500r2.5
B-600r3

157B

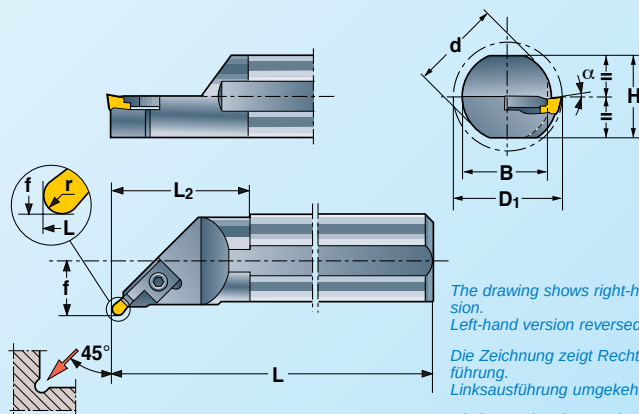
Recommendations
Empfehlungen
Rekommendationer

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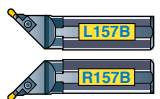
- x) Clamp SHR is used in L-holders and clamp SHL in R-holders.
- x) Spannhaken SHR wird in L-Haltern und Spannhaken SHL in R-Haltern verwendet.
- x) Spännhake SHR används i L-hållare och spännhake SHL i R-hållare.



The drawing shows right-hand version.
Left-hand version reversed.

Die Zeichnung zeigt Rechtsausführung.
Linksausführung umgekehrt.

Ritningen visar högerutförande.
Vänsterutförande spegelvänt.



α

H

B

D₁

d

L

f

L₂

r

L

r

L

r

L

r

L

r

L

r

L

r

L

r

L

r

L

r

L

r

L

r

R/L157B-0016x2x2

-2

15

15,5

21

16

150

9,5

-

1-1,5

* SHR 43

* SHL 43

F6S 411

-

NY2.5

B-200r1
B-300r1.5

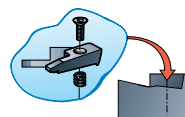
1) On master inserts with:
r = 1,5 mm
r = 3,0 mm
r = 4,0 mm

1) Für Schneiden mit:
r = 1,5 mm
r = 3,0 mm
r = 4,0 mm

1) Till masterskär med:
r = 1,5 mm
r = 3,0 mm
r = 4,0 mm

Ordering example:
Bestellbeispiel:
Beställningsexempel:

R151B-1616 x 4 x 4

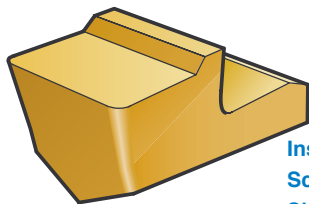


Spare parts shown in the coloured columns are supplied assembled in each tool.

Die in den farbigen Spalten aufgeführten Ersatzteile sind in den Werkzeugen montiert.

Reservdelar i de färgade kolumnerna ingår monterade i varje verktyg.

D17



MTr

Insert type MT with corner radii (MTr)
Schneidentyp MT mit Eckradien (MTr)
Skärtyp MT med hörnradien (MTr)

For holder types
Für Haltertypen
För hållartyper

151F, 151FA, 151RF, 151S,
151G, 156C, 156S, HD56S,
155S, 152S, 152S-00, 153S,
153SD, 153CD, 158S, 159S,
157S-00, 157SA-00, 157S



A $\begin{smallmatrix} +0 \\ -0,15 \end{smallmatrix}$

r

TNC 150
P35/M30

TNC 250
P25/M20/K25

ALC 350 P15/
M10/K10/S10

TNP 175
P25/M25

TNP 2105 P30/
M30/K25/S30/N25

SAFM
P25/M20

H20 M20/K20/
S25/N20/H20

FG 20 P30/M25/
K20/S25/N25/H25

H30
M30/K30/N30

2,5
3

MT-2.3r0.5
MT-3.1r0.5

2,5
3,3

0,5

2) 4
4
4
5

MT-3.7r1
MT-4r1
MT-4.5r1
MT-5r1

3,9
4,2
4,7
5,2

1

A $\begin{smallmatrix} +0,05 \\ -0 \end{smallmatrix}$

3

MT-3.0+0.05/-0r0.5
MT-3.0+0.05/-0r1

3,0
3,0

0,5
1

4

MT-4.0+0.05/-0r0.5
MT-4.0+0.05/-0r1

4,0
4,0

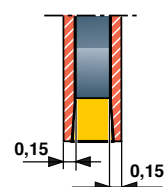
0,5
1

5

MT-5.0+0.05/-0r0.5
MT-5.0+0.05/-0r1

5,0
5,0

0,5
1



2) Clamp and tool must be ground 0.15 mm on both sides.

2) Der Spannhaken und die Werkzeugzunge müssen auf beiden Seiten 0,15 mm geschliffen werden.

2) Spännhake och verktygstunga måste slipas 0,15 mm på båda sidor.

Ordering example:

Bestellbeispiel:

MT-4 TNC 150 P35

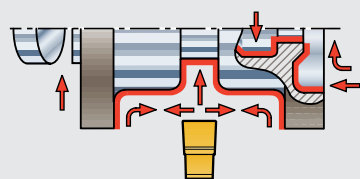
Beställningsexempel:

MTb

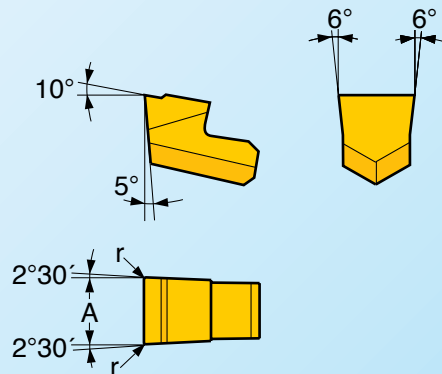
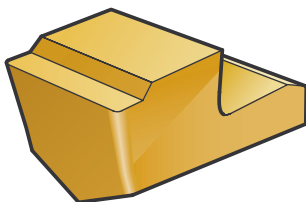
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Gebrauch:
Tillämpning:



For holder types
Für Haltertypen
För hållartyper

151F, 151RF, 151S, 151G,
156C, 156S, HD56S, 155S,
152S, 152S-00, 153S,
153SD, 153CD, 158S, 159S,
157S-00, 157SA-00, 157S



A $\begin{smallmatrix} +0,15 \\ -0 \end{smallmatrix}$

r

TNC 150
P35/M30

ALC 350 P15/
M10/K10/S10

TNP 175
P25/M25

SAFM
P25/M20

H20 M20/K20/
S25/N20/H20

3
4
5

MT-3b
MT-4b
MT-5b

3,2
4,1
5,1

0,25

Page:
Seite:
Sida:

D8-D15

Ordering example:

Bestellbeispiel:

Beställningsexempel:

MT-4b TNC 150 P35

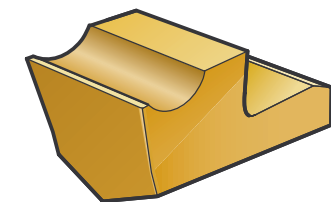
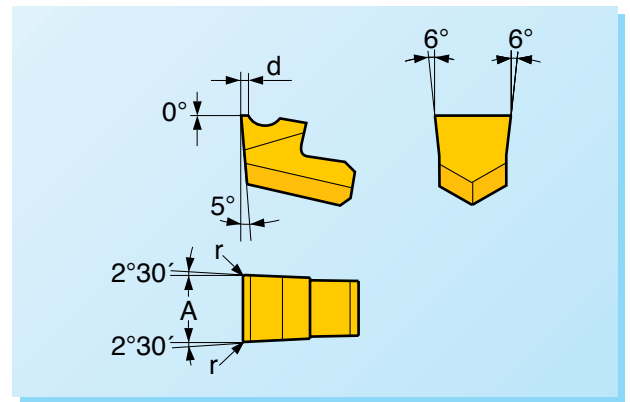
MTc

Recommendations
Empfehlungen
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For holder types Für Haltertypen För hållartyper	151F, 151RF, 151S, 151G, 156C, 156S, HD56S, 155S, 152S, 152S-00, 153S, 153SD, 153CD, 158S, 159S, 157S-00, 157SA-00, 157S			A ^{+0,15} ₋₀	r	d	TNC 150 P35/M30	ALC 350 P15/ M10/K10/S10	TNP 175 P25/M25	TNP 2105 P30/ M30/K25/S30/N25	SAFM P25/M20	H20 M20/K20/ S25/N20/H20
 Page: Seite: Sida:	D8-D15	3 4 5	MT-3c MT-4c MT-5c	3,2 4,1 5,1	0,25	0,10 0,10 0,15	■ ■ ■	■		■ ■ ■	■ ■ ■	■ ■ ■

Ordering example:

Bestellbeispiel:

Beställningsexempel:

MT-3c ALC 350 P15/K15

● Coated carbide grades ● Beschichtete Hartmetallsorten

● Belagda hårdmetallsorter.

CVD TiN/TiCN/ TiN	CVD TiN/TiCN/ Al ₂ O ₃ /TiN	PVD TiN	PVD TiAlN
-------------------------	---	------------	--------------

CVD = Chemical Vapour Deposition

PVD = Physical Vapour Deposition

■ Stocked - Ab Lager - Lagerfört

□ Limited stocked - Begrenzt ab Lager - Begränsat lagerfört

Selection of insert grade, page:
Wahl der Schneidsorte, Seite:
Val av skärsort, sida:

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Cutting data, page:
Schnittdaten, Seite:
Skärdata, sida:

A158-A169

¹⁾ ISO Material index - Werkstoff-Index - Materialindex

P: All types of steels, cast steels and long-chipping cast irons except aust/duplex stainless steels - Stähle, Stahlguss und langspanender Guss aller arten ohne aust/duplex rostfreie Stähle - Alla typer av stål, gjutstål och långspånande gjutjärn utom aust/duplexa rostfria stål.

M: All types of aust/duplex stainless steels - Aust/duplex rostfreie Stähle aller Arten - Alla typer av aust/duplext rostfritt stål.

K: All types of short-chipping cast iron - Kurzspanender Guss aller arten - Alla typer av kortspånande gjutjärn.

S: All types of heat-resistant Ni-, Co-, Fe-, and Ti-alloys - Warmfeste Ni-, Co-, Fe-, und Ti-Legierungen aller Arten - Alla typer av varmhållfasta Ni-, Co-, Fe-, och Ti-legeringar.

N: All types of non-ferrous metals and non-metallic materials - NE-Metalle aller Arten und nicht metallische Materialien - Alla typer av icke-järnmetaller och icke metalliska material.

H: Hard materials; all types of hardened steels and cast irons - Harte Materialien; Gehärtete Stähle und guss aller Arten - Hårda material; alla typer av hårdade stål och gjutjärn.

● Main application area - Hauptsätzliches Gebrauch - Främsta tillämpningsområde

							Finishing/light roughing - Schlichten/leichtes Schruppen - Finbearbetning/lätt grovbearbetning
							Medium roughing - Mittleres Schruppen - Medelgrov bearbetning
							Roughing/heavy roughing - Schruppen/Starkes Schruppen - Grovbearbetning/tung grovbearbetning



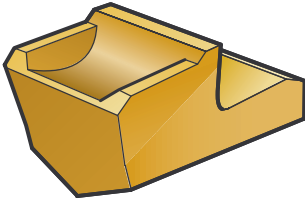
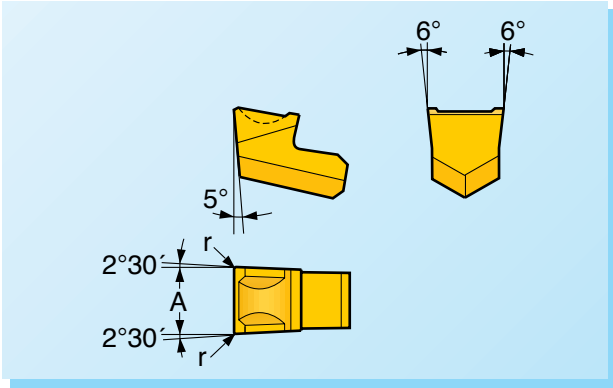
MS

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New execution
D = Neue Ausführung
Nytt utförande

Ordering example:
Bestellbeispiel:
Beställningsexempel:

MS-3 TNC 250 P25/K25

For holder types Für Haltertypen För hållartyper	151F, 151FA, 151RF, 151S, 151G, 156C, 156S, HD56S, 155S, 152S, 152S-00, 153S, 153SD, 153CD, 158S, 159S, 157S-00, 157SA-00, 157S			A ^{+0,15} ₋₀	r	TNC 100 P40/M40	TNC 150 P35/M30	TNC 250 P25/M20/K25	ALC 355 P15/ M15/K15/S15	TNP 175 P25/M25	TNP 2105 P30/ M30/K25/S30/N25	TNP 2255 P20/ M20/K15/S20/N15	SAFM P25/M20	S6 P40/M30	M4 P50/M40	FG 20 P30/M25/ K20/S25/N25/H25	H20 M20/K20/ S25/N20/H20	H30 M30/K30/N30
	2	MS-20	2,0	0,20														
	2,5	MS-25	2,5															
	3	MS-3D	3,2															
	3	MS-3	3,2															
	4	MS-4D	4,1	0,25														
	4	MS-4	4,1															
	5	MS-5	5,1															

D

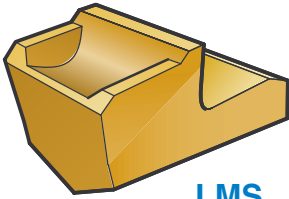
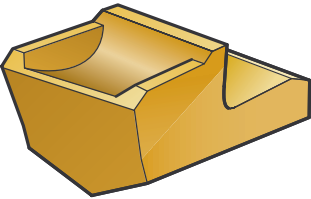
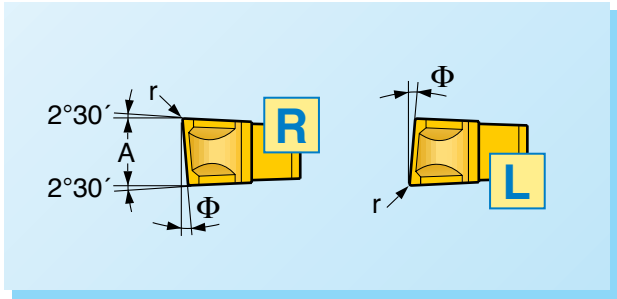
R/L MS

Recommendations
Empfehlungen
Rekommendationer

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A44-A51

Application:
Gebrauch:
Tillämpning:



RMS

LMS

For holder types Für Haltertypen För hållartyper	151F, 151FA, 151RF, 151S, 151G, 156C, 156S, HD56S, 155S, 157S-00, 157SA-00, 157S			A ^{+0,15} ₋₀	Φ	r	TNC 100 P40/M40	TNC 150 P35/M30	TNC 250 P25/M20/K25	ALC 355 P15/ M15/K15/S15	TNP 175 P25/M25	TNP 2105 P30/ M30/K25/S30/N25	TNP 2255 P20/ M20/K15/S20/N15	SAFM P25/M20	S6 P40/M30	FG 20 P30/M25/ K20/S25/N25/H25	H20 M20/K20/ S25/N20/H20	H30 M30/K30/N30
	2	R/LMS-20/6	2,0	6°	0,20													
	2,5	R/LMS-25/6	2,5	6°														
	3	R/LMS-3	3,2															
	4	R/LMS-4	4,1															
	5	R/LMS-5	5,1	5°	0,25													

Ordering example:

Bestellbeispiel:

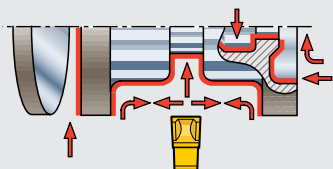
RMS-5 TNC 100 P45

Beställningsexempel:

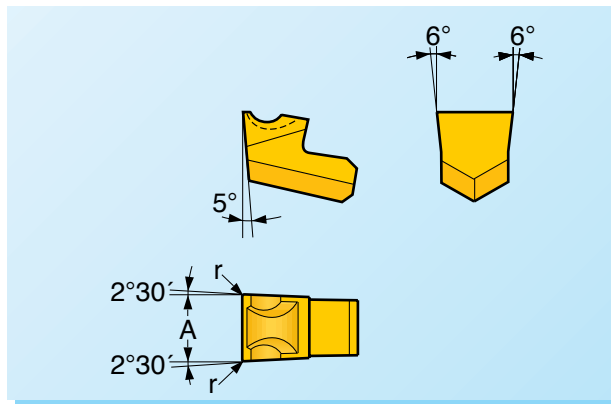
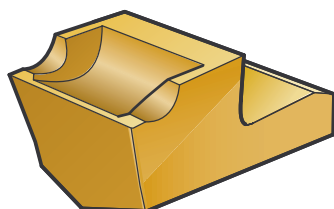
- Coated carbide grades ● Beschichtete Hartmetallsorten
- Belagda hårdmetallsorter.

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CVD = Chemical Vapour Deposition
PVD = Physical Vapour Deposition

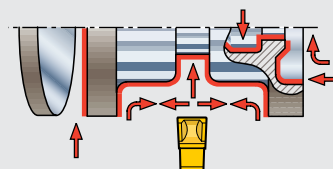
Page:
Seite:
Sida: **A44-A58**

Application:
Gebrauch:
Tillämpning:

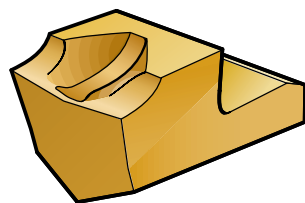


For holder types Für Haltertypen För hållartyper	151F, 151FA, 151RF, 151S, 151G, 156C, 156S, HD56S, 155S, 152S, 152S-00, 153S, 153SD, 153CD, 158S, 159S, 157S-00, 157SA-00, 157TA-00, 157S				$A \begin{smallmatrix} +0,15 \\ -0 \end{smallmatrix}$	r	TNC 150 P35/M30	ALC 350 P15/ M10/K10/S10	ALC 355 P15/ M15/K15/S15	TNP 175 P25/M25	TNP 2105 P30/ M30/K25/S30/	TNP 2255 P20/ M20/K15/S20/	SAFM P25/M20	S6 P40/M30	FG 20 P30/M2 K20/S25/N25/	M20/K20 S25/N20/H20	H30 M30/K30/N30	
		2 2,5	MP-20 MP-25	2,0 2,5	0,2	 				 		 	 		 			
Page: Seite: Sida:		3	MP-30	3,0	0,25													
		3	MP-3	3,2														
		4	MP-40	4,0														
		4	MP-4	4,1														
		5	MP-5	5,1														

Beställningsexempel:

Page:
Seite:
Sida: **A44-A58**

Application:
Gebrauch:
Tillämpning:



MA-30 TNC 150 P35

For holder types För Hållertypen För hållartyper	151F, 151FA, 151RF, 151S, 151G, 156C, 152S, 152S-00, 153S, 153SD, 153CD, 158S, 159S, 157S-00, 157SA-00, 157TA-00, 157S			$A^{+0,15}_{-0}$	r	TNC 150 P35/M30	ALC 355 P M15/K15/S1	TNP 175 P25/M25	TNP 2255 P M20/K15/S2	SAFM P25/M20	S6 P40/M30	FG 20 P30/M K20/S25/M2
	Page: Seite: Sida:	D8-D15	2	MA-20	2,0	0,2	■		■	■		■
			2.5	MA-25	2,5		■		■	■		■
			3	MA-30	3,0	0,25	■	■	■	■		■
			4	MA-40	4,0		■	■	■	■	■	■
			5	MA-50	5,0		■	■	■	■	■	■



PVD
TiAlN

R/L MA

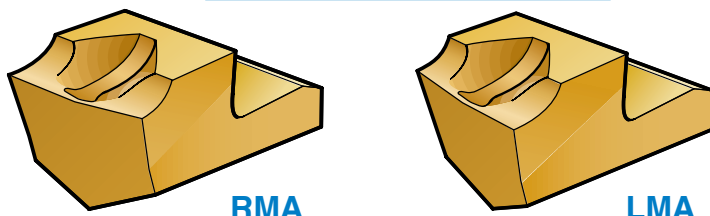
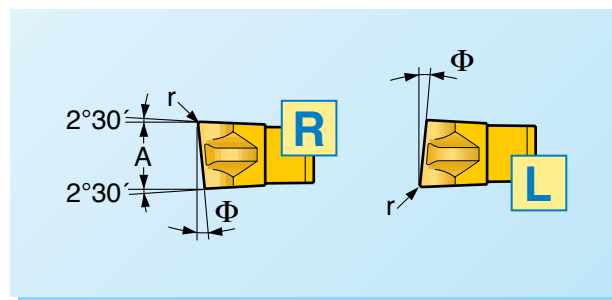
Recommendations
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Gebrauch:
Tillämpning:

●	●	●	●	●	1)
●	●	●	●	●	
●	●	●	●	●	



For holder types Für Haltertypen För hållartyper	151F, 151RF, 151S, 151G, 156C, 157S-00, 157SA-00, 157S			A ^{+0,15} ₋₀	Φ	r	TNC 150 P35/M30	ALC 355 P15/ M15/K15/S15	TNP 175 P25/M25	TNP 2255 P20/ M20/K15/S20/N15	SAFM P25/M20	S6 P40/M30	FG 20 P30/M25/ K20/S25/N25/H25
	2	R/L MA-20/6	2,0	6	0,20	0,20	■			■	■		■
	2	R/L MA-20/12	2,0	12			■			■	■		■
	2,5	R/L MA-25/6	2,5	6			■			■	■		■
	2,5	R/L MA-25/12	2,5	12			■			■	■		■
	3	R/L MA-30/5	3,0	5°	0,25	0,25	■		■	■	■	□	■
	3	R/L MA-30/10	3,0	10°			■		■	■	■	□	■
	4	R/L MA-40/5	4,0	5°			■		■	■	■		■
	4	R/L MA-40/10	4,0	10°			■		■	■	■		■

Ordering example:

Bestellbeispiel:

Beställningsexempel:

RMA-30/5 TNC 150 P35

MB

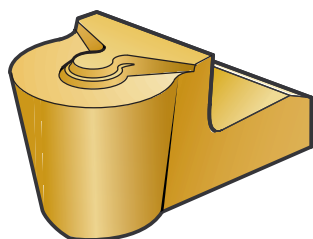
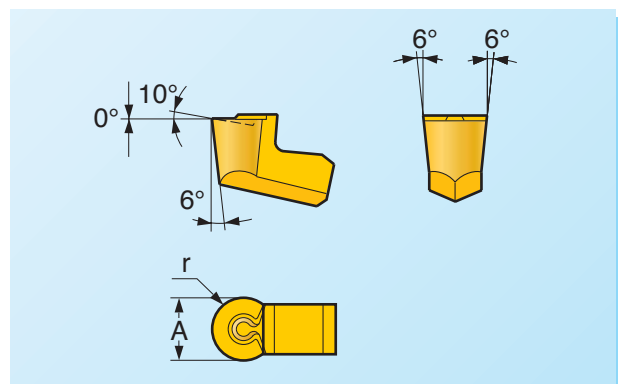
Recommendations
Empfehlungen
Rekomendationer

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Application:
Gebrauch:
Tillämpning:

●	●	●	●	●	1)
●	●	●	●	●	
●	●	●	●	●	



For holder types Für Haltertypen För hållartyper	151F, 151RF, 151S, 151G, 156C, 152S ¹⁾ , 152S-00 ¹⁾ , 153S ¹⁾ , 153SD, 153CD ¹⁾ , 158S ¹⁾ , 159S ¹⁾ , 157S-00, 157SA-00, 157S			A ±0,075	r	TNC 150 P35/M30	TNC 250 P25/M20/K25	TNP 175 P25/M25	TNP 2105 P30/ /M30/K25/S30/N25	SAFM P25/M20	H20 M20/K20/ S25/N20/H20
	Page: Seite: Sida:	D8-D15	3 ^{x)}	MB-3F	3,0	1,5	■	■	■	■	■
			4 ^{x)}	MB-4F	4,0	2,0	■	■	■	■	■
			5 ^{x)}	MB-5F	5,0	2,5	■	■	■	■	■

Ordering example:

Bestellbeispiel:

Beställningsexempel:

MB-5F TNC 250 P25/K25

X) To achieve best possible machining conditions, preferably the tool holder blade should be modified in accordance with the insert radius.

X) Um die bestmöglichen Bearbeitungsverhältnisse zu erhalten, soll die Zunge des Werkzeughalters gemäß dem Radius der Schneide, modifiziert werden.

X) För att åstadkomma optimala bearbetningsförhållanden bör skärhållarens tunga modifieras i överensstämmelse med skärets radie.

■ Stocked - Ab Lager - Lagerfört

□ Limited stocked - Begrenzt ab Lager - Begränsat lagerfört

Selection of insert grade,
Wahl der Schneidsorte, Seite:
Val av skärsort, sida:

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Cutting data, page:
Schnittdaten, Seite:
Skärdata, sida:

A158-A169

1) Page:
Seite:
Sida:

D26

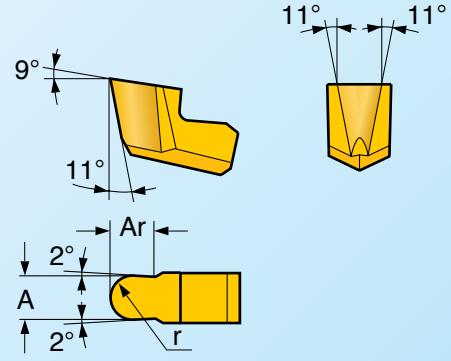
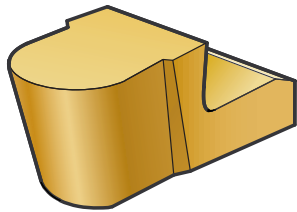
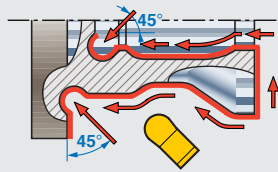


B

Recommendations
Empfehlungen
Rekommendationer

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Seite:
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Application:
Gebrauch:
Tillämpning:



For holder types Für Haltertypen För hållartyper	151B 157B			A ±0,075	r	Ar	TNC 150 P35/M30	ALC 350 P15/ M10/K10/S10	TNP 175 P25/M25	S1V P10	SAFM P25/M20	H20 M20/K20/ S25/N20/H20
	1-1,5 1-1,5 2-3 2-3 2-3	B-200r1 B-300r1.5 B-400r2 B-500r2.5 B-600r3	2,0 3,0 4,0 5,0 6,0	1,0 1,5 2,0 2,5 3,0	2,0 3,0 4,0 5,0 8,5							

Ordering example:
Bestellbeispiel:
Beställningsexempel:
B-400r2 TNC 150 P35

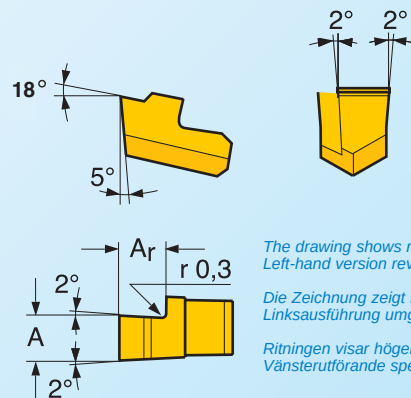
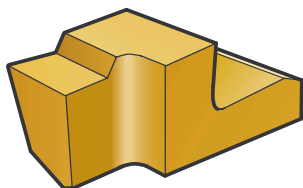
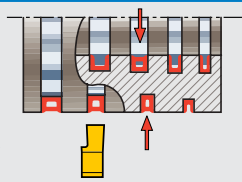
G

Recommendations
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Seite:
Sida: **A44-A47, A50-A53**

Circlip grooves
Sicherungsring-
nuten
Låsringsspår

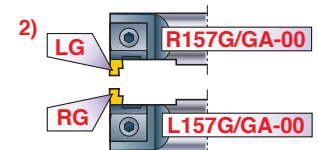
Application:
Gebrauch:
Tillämpning:



The drawing shows right-hand version.
Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung.
Linksausführung umgekehrt.
Ritningen visar högerutförande.
Vänsterutförande spegelvänt.

Ordering example:
Bestellbeispiel:
Beställningsexempel:
RG-110b ALC 350 P15/K15

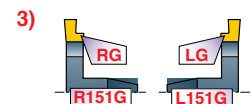
For holder types Für Haltertypen För hållartyper	151G ²⁾ 157G-00 ²⁾ , 157GA-00 ²⁾			A +0,14 +0,05	Ar	TNC 150 P35/M30	ALC 350 P15/ M10/K10/S10	TNP 175 P25/M25	S1V P10	SAFM P25/M20	H20 M20/K20/ S25/N20/H20
	0,50 – 1,85	R/L G-050b R/L G-060b R/L G-070b R/L G-080b R/L G-090b R/L G-105b R/L G-110b R/L G-125b R/L G-130b R/L G-155b R/L G-160b R/L G-185b	0,50 0,60 0,70 0,80 0,90 1,05 1,10 1,25 1,30 1,55 1,60 1,85	1,3 1,3 1,3 1,6 1,6 2,1 2,1 2,3 2,3 2,6 2,6 2,9							
	2,15 – 3,15	R/L G-215b R/L G-265b R/L G-315b	2,15 2,65 3,15	3,2 3,7 3,7							



2) Left-hand inserts (LG) are used in right-hand holders and right-hand inserts (RG) are used in left-hand holders.

2) Linksschneiden (LG) werden in Rechtshaltern und Rechtsschneiden (RG) in Linkshaltern verwendet.

2) Vänsterskär (LG) används i högerhållare och högerskär (RG) i vänsterhållare.



3) Right-hand inserts (RG) are used in right-hand holders and left-hand inserts (LG) are used in left-hand holders.

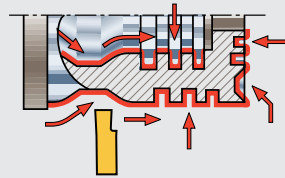
3) Rechtsschneiden (RG) werden in Rechtshaltern und Linksschneiden (LG) in Linkshaltern verwendet.

3) Högerskär (RG) används i högerhållare och vänsterskär (LG) i vänsterhållare.

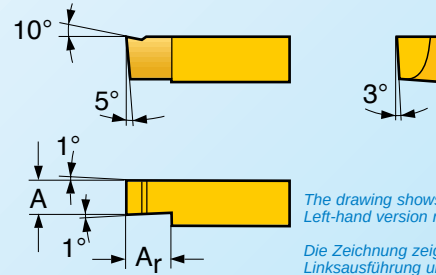
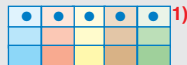
E

Recommendations
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Sida: **A45-A47, A50-A57**



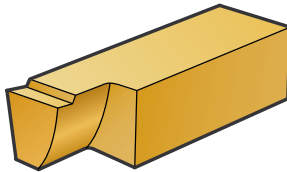
Application:
Gebrauch:
Tillämpning:



The drawing shows right-hand version.
Left-hand version reversed.

Die Zeichnung zeigt Rechtsausführung.
Linksausführung umgekehrt.

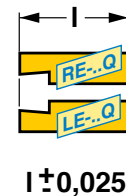
Ritningen visar högerutförande.
Vänsterutförande spegelvänt.



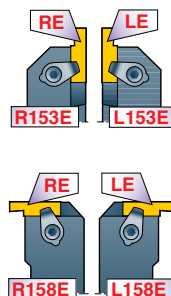
For holder types Für Haltertypen För hållartyper	153E 158E			A +0,15 - 0	Ar	TNC 150 P35/M30	ALC 350 P15/ M10/K10/S10	S1V P10	SAFM P25/M20	H20 M20/K20/ S25/N20/H20	H30 M30/K30/N30
Page: Seite: Sida: D11-D12	2 - 5	R/L E-2b R/L E-2.5b R/L E-3b R/L E-4b R/L E-5b	2,0 2,5 3,0 4,0 5,0	3,0 3,0 3,0 6,5 6,5	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■

Precision ground performance (= Q)
Präzisionsgeschliffene Ausführung (= Q)
Precisionsslipat utförande (=Q)

For holder types Für Haltertypen För hållartyper	153E 158E			A +0,05 - 0	Ar	TNC 150 P35/M30	ALC 350 P15/ M10/K10/S10	S1V P10	SAFM P25/M20	H20 M20/K20/ S25/N20/H20	H30 M30/K30/N30
Page: Seite: Sida: D11-D12	2 - 5	R/L E-2bQ R/L E-2.5bQ R/L E-3bQ R/L E-4bQ R/L E-5bQ	2,0 2,5 3,0 4,0 5,0	3,0 3,0 3,0 6,5 6,5	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■	■ ■ ■ ■ ■



Ordering example:
Bestellbeispiel: **RE-3b ALC 350 P15/K15**
Beställningsexempel:



Right-hand inserts (RE) are used in right-hand holders and
left-hand inserts (LE) are used in left-hand holders.

Rechtsschneiden (RE) werden in Rechtshaltern und Links-
schneiden (LE) in Linkshaltern verwendet.

Högerskär (RE) används i högerhållare och vänsterskär (LE)
i vänsterhållare.

■ Stocked - Ab Lager - Lagerfört

□ Limited stocked - Begrenzt ab Lager - Begränsat lagerfört

Selection of insert grade, page:
Wahl der Schneidsorte, Seite:
Val av skärsort, sida:

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Cutting data, page:
Schnittdaten, Seite:
Skärdata, sida:

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Seite:
Sida: **D26**

● Coated carbide grades ● Beschichtete Hartmetallsorten
● Belagda hårdmetallsorter.

CVD
TiN/TiCN/
TiN

CVD
TiN/TiCN/
Al₂O₃/TiN

PVD
TiN

PVD
TiALN

CVD = Chemical Vapour Deposition
PVD = Physical Vapour Deposition



MT

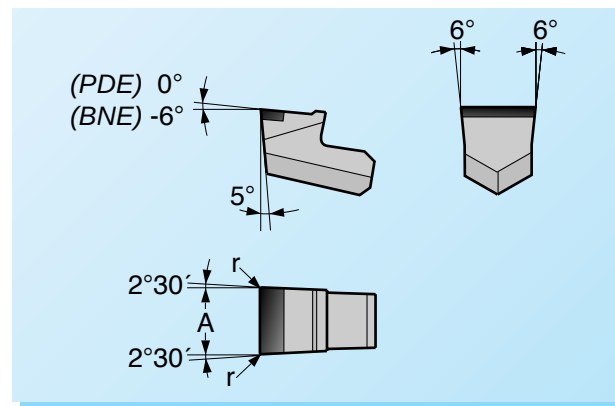
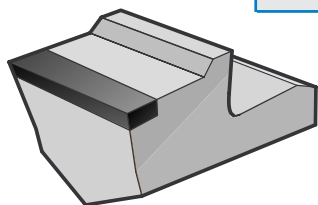
Recommendations
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Application:
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Tillämpning:

1)



For holder types Für Haltertypen För hållartyper	151F, 151FA, 151RF, 151S, 151G, 156C, 156S, HD56S, 155S, 152S, 152S-00, 153S, 153SD, 153CD, 158S, 159S, 157S-00, 157SA-00, 157S			A $+0,15$ -0	r			
	2,5	MT-25	2,5	0,2				
	3	MT-3	3,2	0,25				
	4	MT-4	4,1					
	5	MT-5	5,1					

Page:
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D8-D15

Ordering example:
Bestellbeispiel:
Beställningsexempel:

MT-5 PDE 1000

MT-...Fr

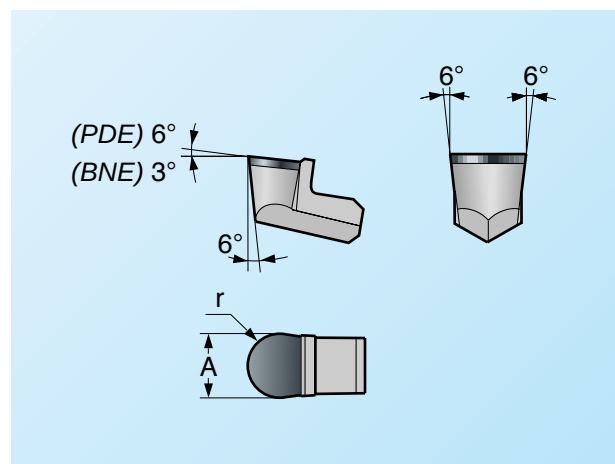
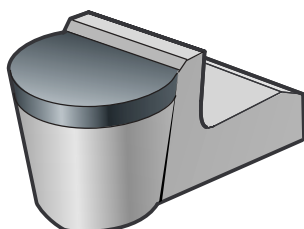
Recommendations
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Application:
Gebrauch:
Tillämpning:

1)



For holder types Für Haltertypen För hållartyper	151F, 151RF, 151S, 151G, 156C, 152S ^{x)} , 152S-00 ^{x)} , 153S ^{x)} , 153SD, 153CD ^{x)} , 158S ^{x)} , 159S ^{x)} , 157S-00, 157SA-00, 157S			A $+0,15$ -0	r			
	2,5	MT-25Fr	2,5	1,25				
	3	MT-30Fr	3,0	1,5				
	4	MT-40Fr	4,0	2,0				
	5	MT-50Fr	5,0	2,5				

Page:
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Sida:

D8-D15

Ordering example:
Bestellbeispiel:
Beställningsexempel:

MT-40Fr BNE 500

x) To achieve best possible machining conditions, preferably the tool holder blade should be modified in accordance with the insert radius.

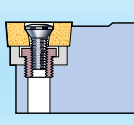
x) Um die bestmöglichen Bearbeitungsverhältnisse zu erhalten, soll die Zunge des Werkzeughalters gemäß dem Radius der Schneide, modifiziert werden.

x) För att åstadkomma optimala bearbetningsförhållanden bör skärhållarens tunga modifieras i överensstämmelse med skärets radie.

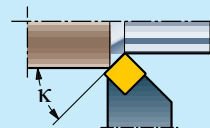
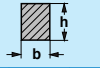
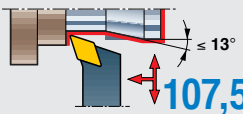
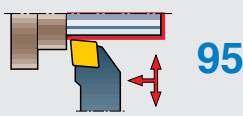
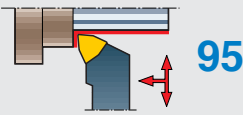
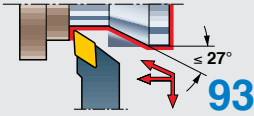
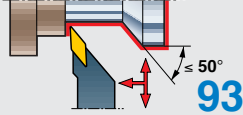
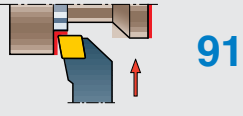
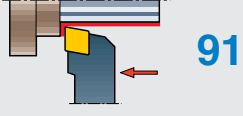
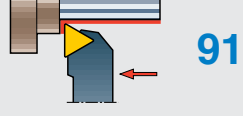
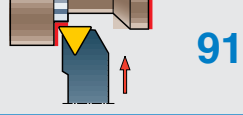
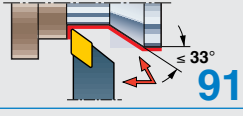
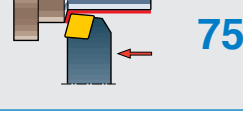
● Diamond, boron nitride ● Diamant, Bornitrid
● Diamant, bornitrid

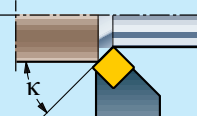
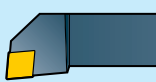
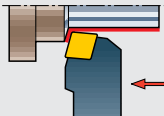
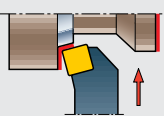
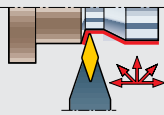
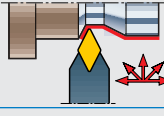
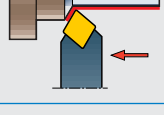
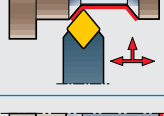
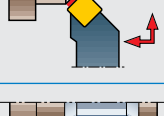
PCD CBN





D

										Page Seite Sida	EB  Page: Seite: Sida: B24 - B26
		0606	0808	1010	1212	1414	1616				
	SDHC R/L			07	07		11			D30	
	SCLC R/L	06	06	06	09		09			D30	EB 
	SWLC R/L		04	04	06		06			D31	EB 
	SDJC R/L		07	07	11		11			D31	EB 
	SVJC R/L				11		11			D32	EB 
	SCAC R/L		06	06	09	09				D32	
	SCFC R/L		06	06	09		09			D33	
	SCGC R/L		06	06	09		09			D33	
	STGC R/L		09	09	11		11 16			D34	
	STFC R/L						16			D34	
	SDAC R/L		07	07	07		11			D35	
	SCBC R/L		06	06			09			D36	

		060608081010121214141616 								Page Seite Sida	EB  Page: Seite: Sida: B24 - B26	
 75°	SCRC R/L				09		09				D36	
 75°	SSKC R/L						09				D37	
 72,5°	SVVC N				11		11				D37	EB 
 62,5°	SDNC N		07	07	07		11	11			D38	EB 
 60°	SCEC R/L			06		09		09			D38	
 50°	SCMC N		06	06		09		09			D39	
 45°	SCSC R/L							12			D39	
 45°	SSSC R/L							09			D40	
 45°	SSDC N					09		09			D40	
	SRDC N					06		06 08 10			D41	
 ≤ 43°	SRSC R/L					06		06 08 10			D41	

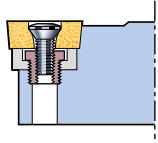
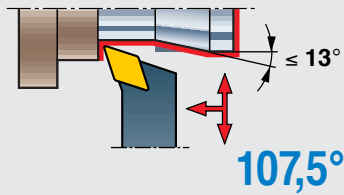
D

SDHC R/L

Recommendations
Empfehlungen
Rekommendationer

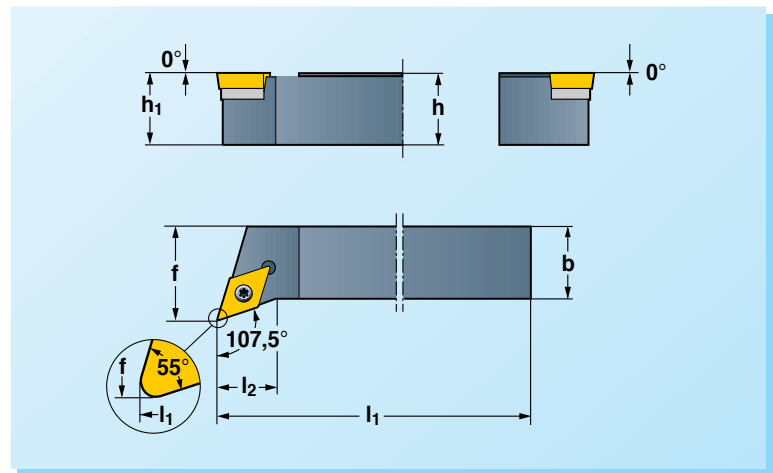
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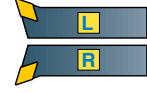
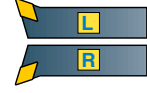
B12-B14, B18



S

The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.



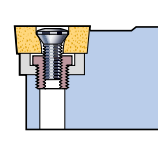
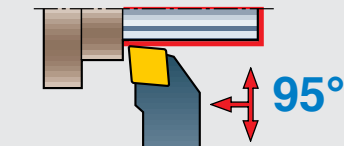
			$h=h_1$	b	l_1	l_2	f						DCMW DCMT		Page: Seite: Sida:
SDHCR/L 1010E07			10	10	70	5,5	12	FTX072507	NY7X	—	—	—	0702 . .		
SDHCR/L 1212F07			12	12	80	12,0	16								
SDHCR/L 1616H11			16	16	100	10,5	20	FTX153514	NY15X	UDC11	RSM508	NY3.5	11T3 . .		

SCLC R/L

Recommendations
Empfehlungen
Rekommendationer

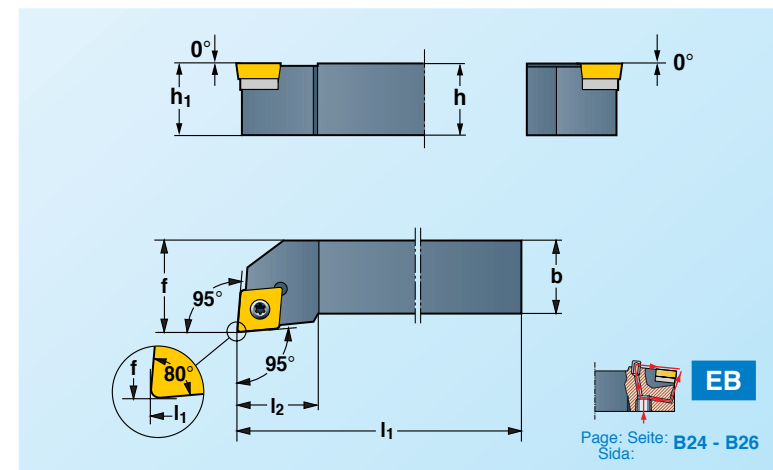
Page: Seite: Sida:

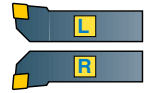
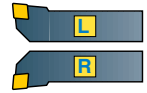
B12-B14, B18



S

The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.



			$h=h_1$	b	l_1	l_2	f						CCMW CCMT		Page: Seite: Sida:
SCLCR/L 0606C06			6	6	50	10	8	FTX072507	NY7X	—	—	—	0602 . .		
SCLCR/L 0808D06			8	8	60	10	10								
SCLCR/L 1010E06			10	10	70	10	12								
SCLCR/L 1212F09			12	12	80	16	16	FTX154010	NY15X	—	—	—	09T3 . .		
SCLCR/L 1616H09			16	16	100	16	20	FTX153512	NY15X	UCC09	RSM5T	NY2.5			

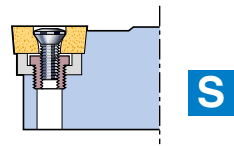
SWLC R/L

Recommendations
Empfehlungen
Rekommendationer

Page: Seite: Sida:

B12-B14, B18

95°



The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.

0°

95°

EB

Page: Seite: B24 - B26
Sida:

	h=h ₁	b	l ₁	l ₂	f		 torx				WCMW WCMT	Page: Seite: Sida: D49-D53
SWLCR/L 0808X04	8	8	120	10	10	FTX072507	NY7X	—	—	—	0402 . .	
SWLCR/L 1010X04	10	10	120	10	12			—	—	—		
SWLCR/L 1212X06	12	12	120	15	16	FTX154010	NY15X	—	—	—	06T3 . .	
SWLCR/L 1616H06	16	16	100	15	20			—	—	—		

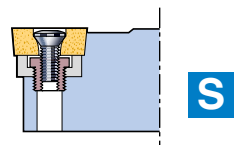
SDJC R/L

Recommendations
Empfehlungen
Rekommendationer

Page: Seite: Sida:

B12-B14, B18

93°



The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.

0°

93°

EB

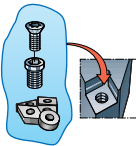
Page: Seite: B24 - B26
Sida:

	h=h ₁	b	l ₁	l ₂	f		 torx				DCMW DCMT	Page: Seite: Sida: D49-D53
SDJCR/L 0808D07	8	8	60	15	10	FTX072507	NY7X	—	—	—	0702 . .	
SDJCR/L 1010E07	10	10	70	15	12			—	—	—		
SDJCR/L 1212F11	12	12	80	22	16	FTX154010	NY15X	—	—	—		
SDJCR/L 1616H11	16	16	100	22	20	FTX153512	NY15X	UDC11	RSM5T	NY2.5	11T3 . .	

Selection of cutting geometry page:
Wahl der Schneidgeometrie, Seite:
Val av skärgeometri, sid:

B27-B39

Ordering example:
Bestellbeispiel: SWLCR 1212X06
Beställningsexempel:



Spare parts shown in the coloured columns are supplied assembled in each tool.

Die in den farbigen Spalten aufgeführten Ersatzteile sind in den Werkzeugen montiert.

Reservdelar i de färgade kolumnerna ingår monterade i varje verktyg.



SVJC R/L

Recommendations
Empfehlungen
Rekommendationer

Page: Seite: Sida:
B12-B14, B18

93°

≤ 50°

EB

Page: Seite: B24 - B26
Sida:

The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.

	h=h ₁	b	l ₁	l ₂	f		 torx				VCMW VCMT	Page: Seite: Sida: D49-D53
SVJCR/L 1212M11 SVJCR/L 1616M11	12 16	12 16	150 150	30 30	16 20	FTX072507	NY7X	-	-	-	1103 . .	

D

SCAC R/L

Recommendations
Empfehlungen
Rekommendationer

Page: Seite: Sida:
B12-B14, B18

91°

CCMT

Page: Seite: Sida:
D49-D53

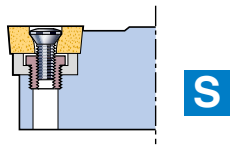
The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.

	h=h ₁	b	l ₁	l ₂	f		 torx				CCMW CCMT	Page: Seite: Sida: D49-D53
SCACR/L 0808K06 SCACR/L 1010M06	8 10	8 10	125 150	— —	8,5 10,5	FTX072507	NY7X	—	—	—	0602 . .	
SCACR/L 1212M09 SCACR/L 1414M09	12 14	12 14	150 150	— —	12,5 14,5	FTX154010	NY15X	—	—	—	09T3 . .	

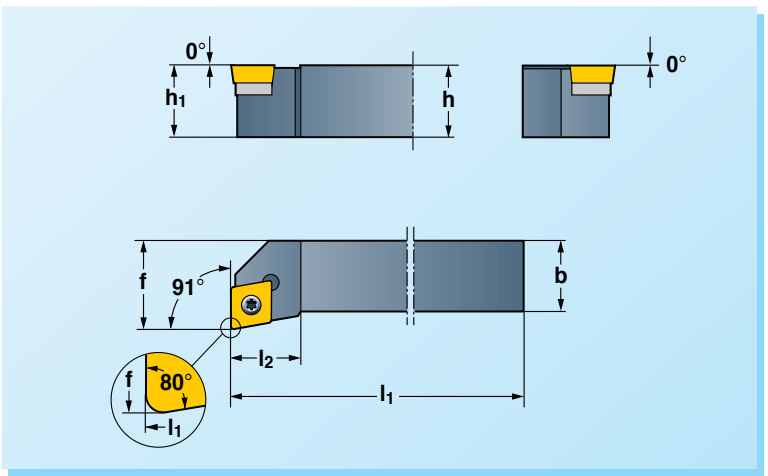
SCFC R/L

Recommendations
Empfehlungen
Rekommendationer

Page: Seite: Sida:
B12-B14, B18



The drawing shows right-hand version. Left-hand version reversed.
 Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
 Ritningen visar högerutförande. Vänsterutförande spegelvänt.

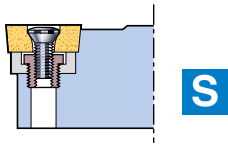


	h=h ₁	b	l ₁	l ₂	f		 torx				CCMW CCMT	* Page: Seite: Sida: D49-D53
SCFCR/L 0808D06 SCFCR/L 1010E06	8 10	8 10	60 70	10 10	10 12	FTX072507	NY7X	—	—	—	0602 . .	
SCFCR/L 1212F09 SCFCR/L 1616H09	12 16	12 16	80 100	16 16	16 20	FTX154010 FTX153512	NY15X NY15X	— UCC09	— RSM5T	— NY2.5	09T3 . .	

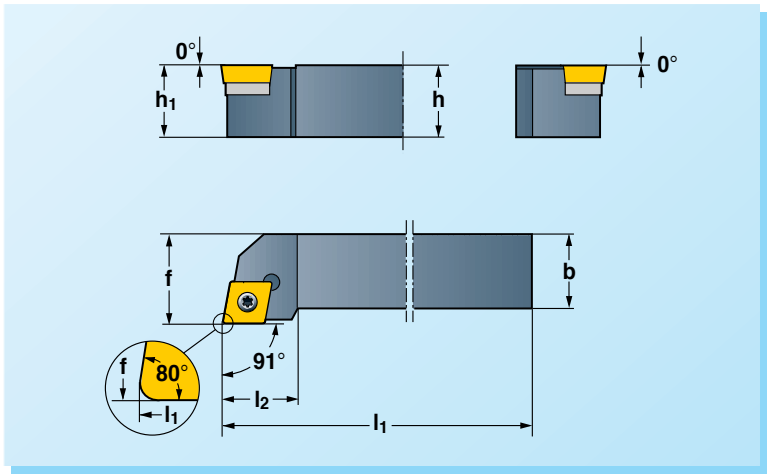
SCGC R/L

Recommendations
Empfehlungen
Rekommendationer

Page: Seite: Sida:
B12-B14, B18



The drawing shows right-hand version. Left-hand version reversed.
 Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
 Ritningen visar högerutförande. Vänsterutförande spegelvänt.

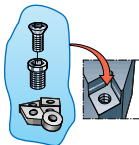


	h=h ₁	b	l ₁	l ₂	f		 torx				CCMW CCMT	* Page: Seite: Sida: D49-D53
SCGCR/L 0808D06 SCGCR/L 1010E06	8 10	8 10	60 70	10 10	10 12	FTX072507	NY7X	—	—	—	0602 . .	
SCGCR/L 1212F09 SCGCR/L 1616H09	12 16	12 16	80 100	16 16	16 20	FTX154010 FTX153512	NY15X NY15X	— UCC09	— RSM5T	— NY2.5	09T3 . .	

*

 Selection of cutting geometry page:
 Wahl der Schneidgeometrie, Seite: **B27-B39**
 Val av skärgeometri, sid:

Ordering example:
 Bestellbeispiel: **SCGCR 1616H09**
 Beställningsexempel:



Spare parts shown in the coloured columns are supplied assembled in each tool.

Die in den farbigen Spalten aufgeführten Ersatzteile sind in den Werkzeugen montiert.

Reservdelar i de färgade kolumnerna ingår monterade i varje verktyg.

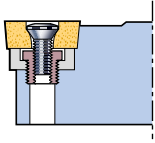
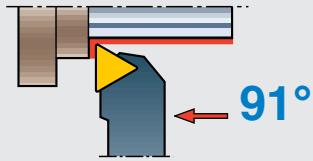


STGCR/L

Recommendations
Empfehlungen
Rekommendationer

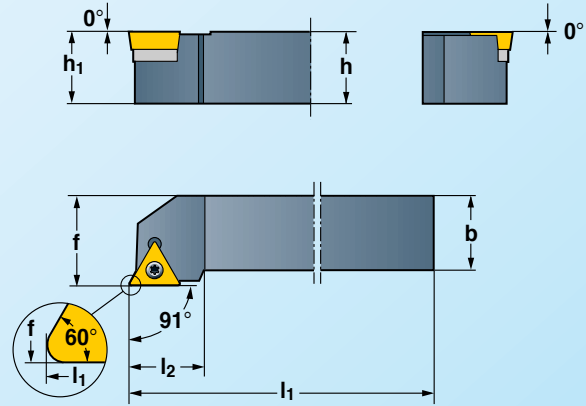
Page: Seite: Sida:

B12-B14, B18



S

The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.



	$h=h_1$	b	l_1	l_2	f		 torx				TCMW  * TCMT 	Page: Seite: Sida: D49-D53
STGCR/L 0808D09	8	8	60	12	10	FTX072206	NY7X	—	—	—	0902 ..	
STGCR/L 1010E09	10	10	70	12	12							
STGCR/L 1212F11	12	12	80	15	16	FTX072507	NY7X	—	—	—	1102 ..	
STGCR/L 1616H11	16	16	100	15	20							
STGCR/L 1616H16	16	16	100	21	20	FTX153512	NY15X	UTC16	RSM5T	NY2.5	16T3 ..	

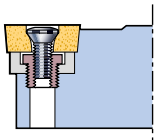
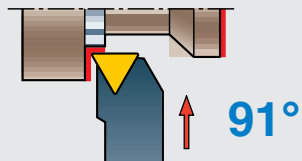
D

STFCR/L

Recommendations
Empfehlungen
Rekommendationer

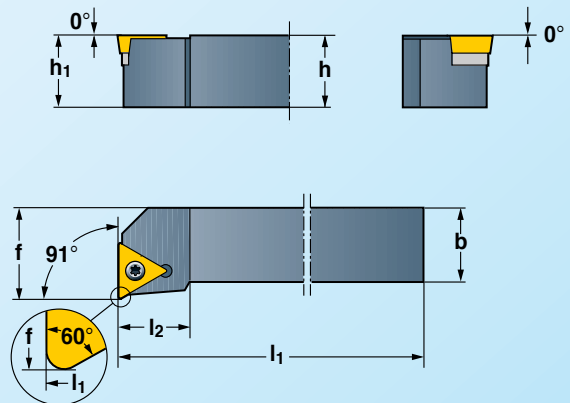
Page: Seite: Sida:

B12-B14, B18



S

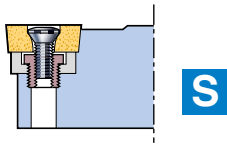
The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.



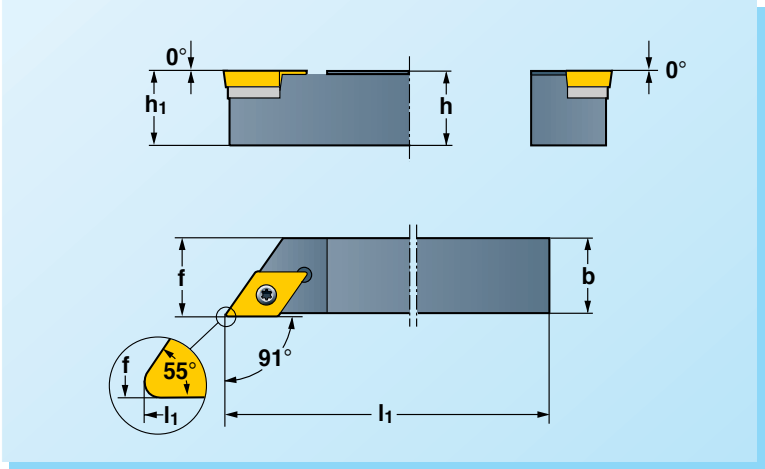
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STFCR/L 1616H16	16	16	100	20	20	FTX153512	NY15X	UTC16	RSM5T	NY2.5	16T3 ..	

SDAC R/L

Recommendations
Empfehlungen
Rekomendationer
Page: Seite: Sida:
B12-B14, B18



The drawing shows right-hand version. Left-hand version reversed.
 Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
 Ritningen visar högerutförande. Vänsterutförande spegelvänt.



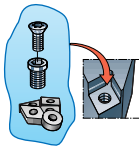
	h=h ₁	b	l ₁	l ₂	f		 torx				DCMW DCMT *	Page: Seite: Sida: D49-D53
SDACR/L 0808K07 SDACR/L 1010M07 SDACR/L 1212M07	8 10 12	8 10 12	125 150 150	– – –	8,5 10,5 12,5	FTX072507	NY7X	–	–	–	0702 . .	
SDACR/L 1414M11	14	14	150	–	14,5	FTX154010	NY15X	–	–	–	11T3 . .	

*

Selection of cutting geometry page:
Wahl der Schneidgeometrie, Seite:
Val av skärgeometri, sid:

B27-B39

Ordering example:
 Bestellbeispiel: SDACR 0808K07
 Beställningsexempel:



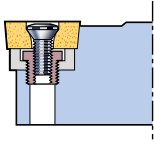
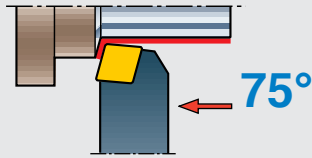
Spare parts shown in the coloured columns are supplied assembled in each tool.
 Die in den farbigen Spalten aufgeführten Ersatzteile sind in den Werkzeugen montiert.
 Reservdelar i de färgade kolumnerna ingår monterade i varje verktyg.

SCBC R/L

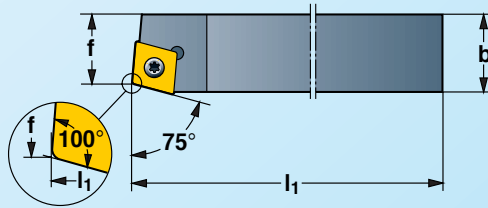
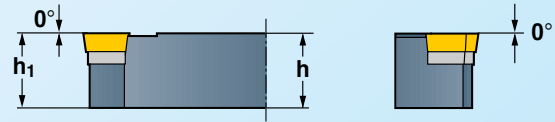
Recommendations
Empfehlungen
Rekommendationer

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B12-B14, B18



The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.



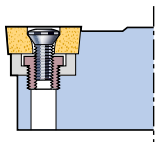
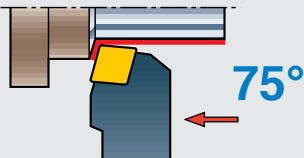
	$h=h_1$	b	l_1	l_2	f		 torx				CCMW CCMT	* 	Page: Seite: Sida: D49-D53
SCBCR/L 0808D06	8	8	60	—	7	FTX072507	NY7X	—	—	—	—	0602 . .	
SCBCR/L 1010E06	10	10	70	—	9	FTX072507	NY7X	—	—	—	—	0602 . .	
SCBCR/L 1616H09	16	16	100	—	13	FTX153512	NY15X	UCC09	RSM5T	NY2.5	—	09T3 . .	

SCRC R/L

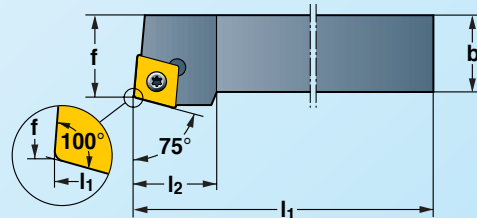
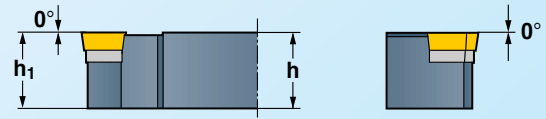
Recommendations
Empfehlungen
Rekommendationer

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B12-B14, B18



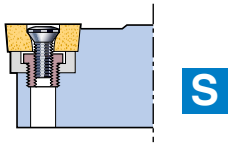
The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.



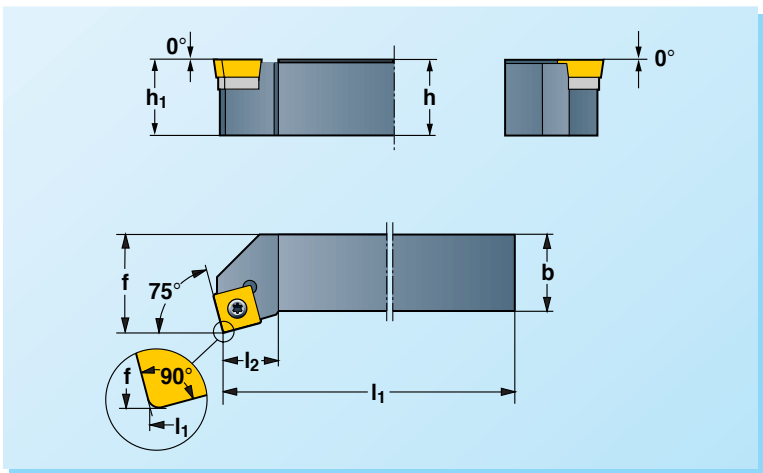
	$h=h_1$	b	l_1	l_2	f		 torx				CCMW CCMT	* 	Page: Seite: Sida: D49-D53
SCRCR/L 1212F09	12	12	80	16	13	FTX154010	NY15X	—	—	—	—	09T3 . .	
SCRCR/L 1616H09	16	16	100	16	17	FTX153512	NY15X	UCC09	RSM5T	NY2.5	—	09T3 . .	

SSKC R/L

Recommendations
Empfehlungen
Rekommendationer
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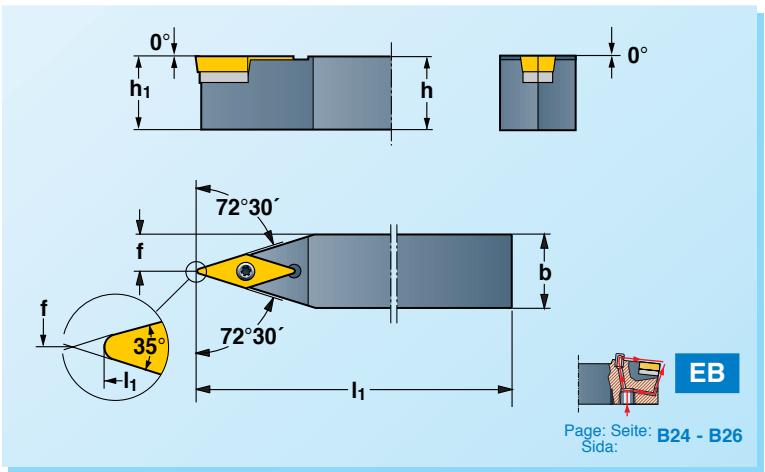
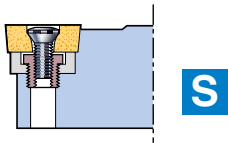
The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.



	h=h ₁	b	l ₁	l ₂	f		 torx				SCMW SCMT	Page: Seite: Sida: D49-D53
SSKCR/L 1616H09	16	16	100	13	20	FTX153512	NY15X	USC09	RSM5T	NY2.5	09T3 . .	

SVVC N

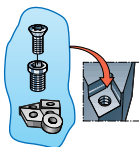
Recommendations
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	h=h ₁	b	l ₁	l ₂	f		 torx				VCMW VCMT	Page: Seite: Sida: D49-D53
SVVCN 1212M11 SVVCN 1616M11	12 16	12 16	150 150	- -	6 8	FTX072507	NY7X	-	-	-	1103 . .	

*
 Selection of cutting geometry page:
 Wahl der Schneidgeometrie, Seite:
 Val av skärgeometri, sid:
B27-B39

Ordering example:
Bestellbeispiel: SVVCN 1212M11
Beställningsexempel:



Spare parts shown in the coloured columns are supplied assembled in each tool.

Die in den farbigen Spalten aufgeführten Ersatzteile sind in den Werkzeugen montiert.

Reservdelar i de färgade kolumnerna ingår monterade i varje verktyg.

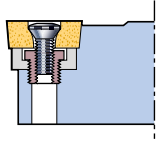
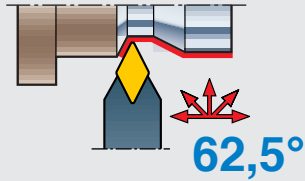
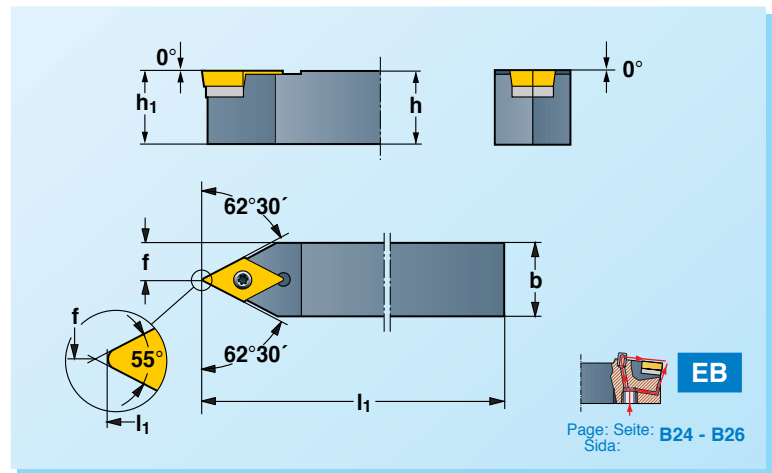


SDNC N

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**S****EB**

Page: Seite: **B24 - B26**
Sida:

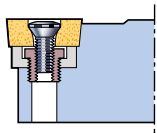
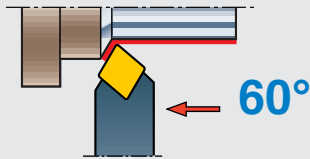
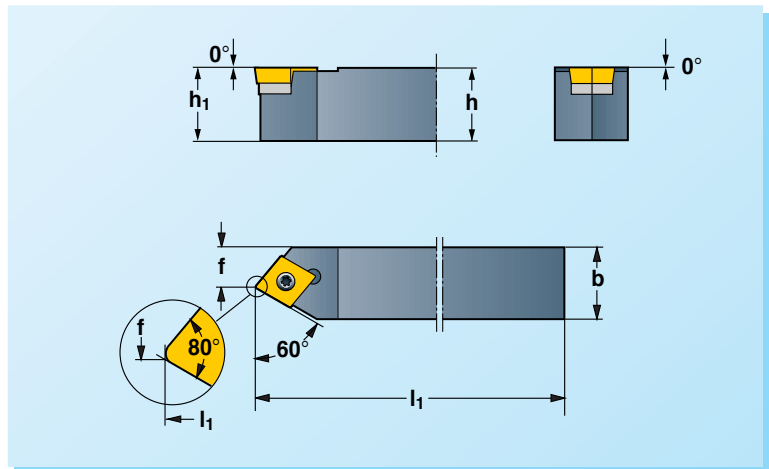
	$h=h_1$	b	l_1	l_2	f		 torx				DCMW  * DCMT 	Page: Seite: Sida: D49-D53
SDNCN 0808K07 SDNCN 1010M07 SDNCN 1212M07	8 10 12	8 10 12	125 150 150	— — —	4 5 6	FTX072507	NY7X	—	—	—	0702 . .	
SDNCN 1414M11 SDNCN 1616M11	14 16	14 16	150 150	— —	7 8	FTX154010 FTX153514	NY15X NY15X	— UDC11	— RSM508	— NY3.5	11T3 . .	

SCEC R/L

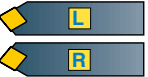
Recommendations
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**S**

The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.

	$h=h_1$	b	l_1	l_2	f		 torx				CCMW  * CCMT 	Page: Seite: Sida: D49-D53
SCECR/L 1010E06	10	10	70	—	5,2	FTX072507	NY7X	—	—	—	0602 . .	
SCECR/L 1212F09 SCECR/L 1616H09	12 16	12 16	80 100	— —	8 12	FTX154010 FTX153512	NY15X NY15X	— UCC09	— RSM5T	— NY2.5	09T3 . .	

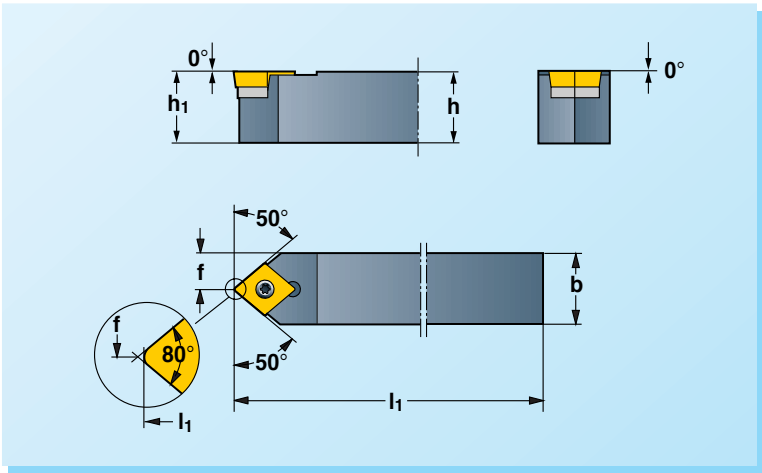
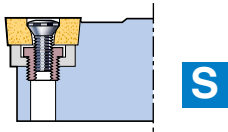
SCMC N

Recommendations
Empfehlungen
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B12-B14, B18

50°



	$h=h_1$	b	l_1	l_2	f		 torx				CCMW CCMT *
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Page:
Seite:
Sida:

D49-D53

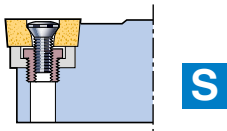
SCSC R/L

Recommendations
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Rekommendationer

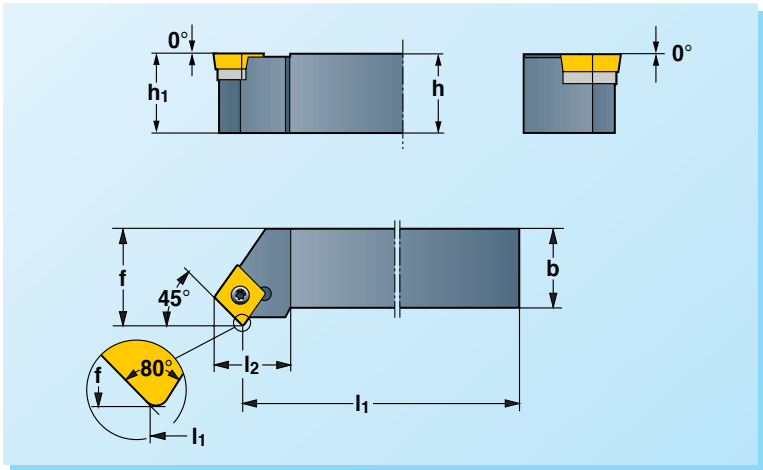
Page: Seite: Sida:

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45°



The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.



	$h=h_1$	b	l_1	l_2	f		 torx				CCMW CCMT *
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Page:
Seite:
Sida:

D49-D53

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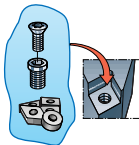
Selection of cutting geometry page:
Wahl der Schneidgeometrie, Seite:
Val av skärgeometri, sid:

B27-B39

Ordering example:
Bestellbeispiel:

SCSCR 1616H12

Beställningsexempel:



Spare parts shown in the coloured columns are supplied assembled in each tool.

Die in den farbigen Spalten aufgeführten Ersatzteile sind in den Werkzeugen montiert.

Reservdelar i de färgade kolumnerna ingår monterade i varje verktyg.

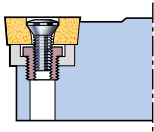


SSSC R/L

Recommendations
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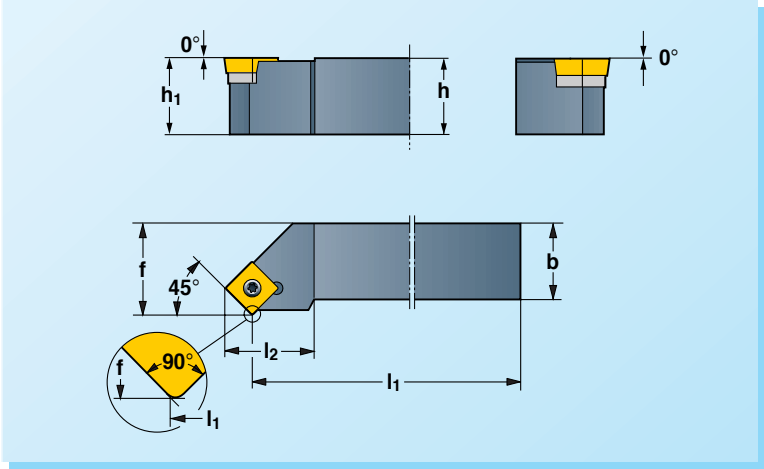
Page: Seite: Sida:

B12-B14, B18



S

The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.



	h=h ₁	b	l ₁	l ₂	f		 torx				SCMW SCMT	* Page: Seite: Sida: D49-D53
SSSCR/L 1616H09	16	16	100	16	20	FTX153512	NY15X	USC09	RSM5	NY2.5	09T3 . .	

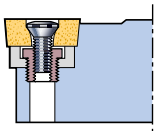
D

SSDC N

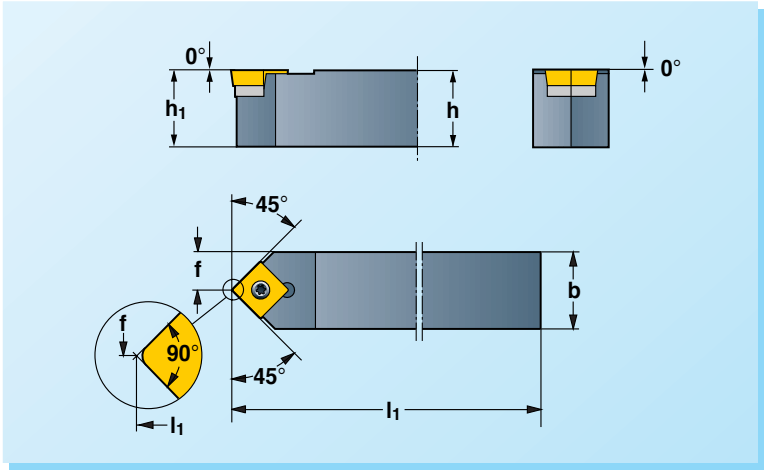
Recommendations
Empfehlungen
Rekommendationer

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S



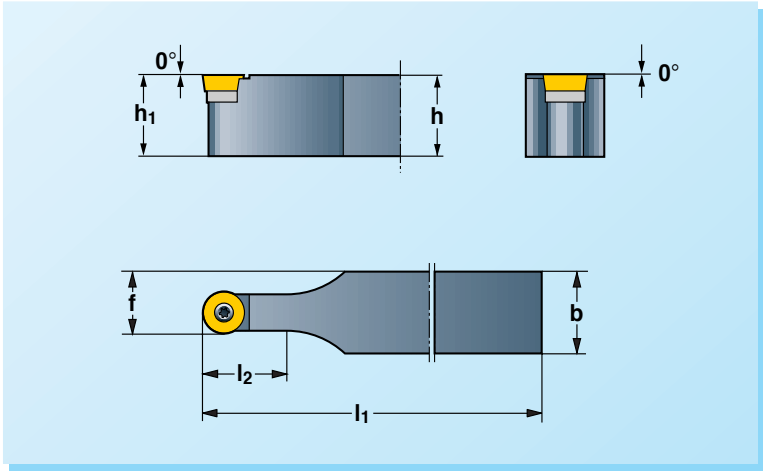
	h=h ₁	b	l ₁	l ₂	f		 torx				SCMW SCMT	* Page: Seite: Sida: D49-D53
SSDCN 1212F09	12	12	80	—	6	FTX154010	NY15X	—	—	—	09T3 . .	
SSDCN 1616H09	16	16	100	—	8	FTX153512	NY15X	USC09	RSM5T	NY2.5		

SRDC N

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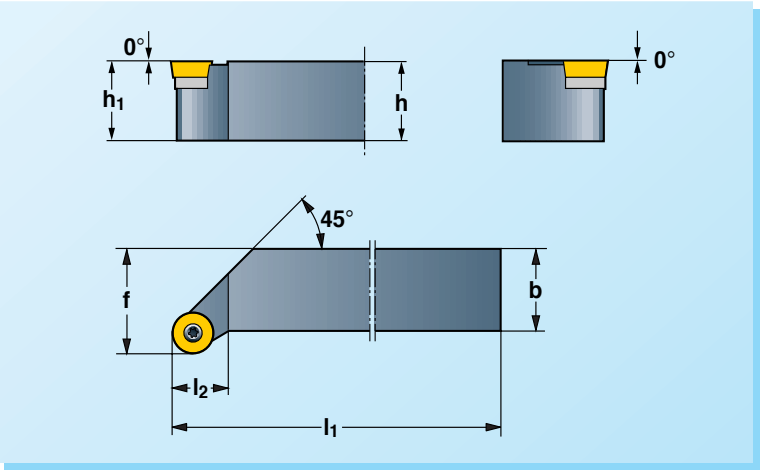
	$h=h_1$	b	l_1	l_2	f		 torx				RCMT * RCGT  RCXT	Page: Seite: Sida: D49-D53
SRDCN 1212F06 SRDCN 1616H06	12 16	12 16	80 100	10 12	9 11	FTX072507	NY7X	—	—	—	0602M0	
SRDCN 1616H08	16	16	100	16	12	FTX093008	NY9X	—	—	—	0803M0	
SRDCN 1616H10	16	16	100	18	13	FTX153514	NY15X	URC10	RSM508	NY3.5	10T3M0	

SRSC R/L

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Page: Seite: Sida:

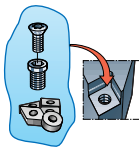
B12-B14, B18



	$h=h_1$	b	l_1	l_2	f		 torx				RCMT * RCGT  RCXT	Page: Seite: Sida: D49-D53
SRSCR/L 1212F06 SRSCR/L 1616H06	12 16	12 16	80 100	10 12	16 20	FTX072507	NY7X	—	—	—	0602M0	
SRSCR/L 1616H08	16	16	100	14	20	FTX093008	NY9X	—	—	—	0803M0	
SRSCR/L 1616H10	16	16	100	16	20	FTX153514	NY15X	URC10	RSM508	NY3.5	10T3M0	

*
 Selection of cutting geometry page:
Wahl der Schneidgeometrie, Seite: **B27-B39**
 Val av skärgeometri, sid:

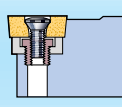
Ordering example:
Bestellbeispiel: **SRSCR 1616H08**
Beställningsexempel:

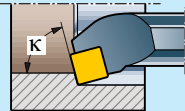
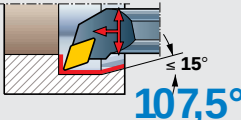
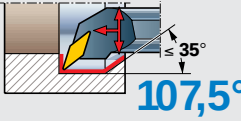
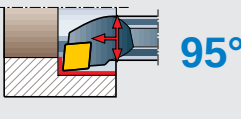
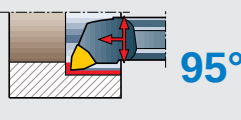
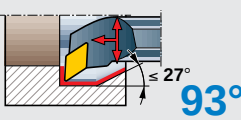
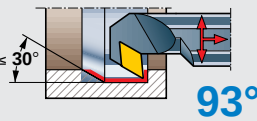
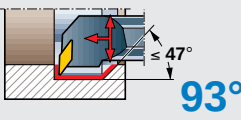
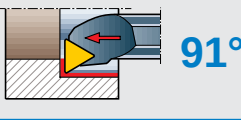
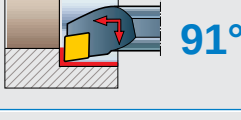
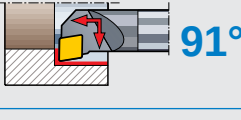
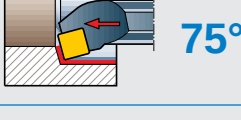
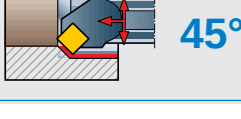


Spare parts shown in the coloured columns are supplied assembled in each tool.

Die in den farbigen Spalten aufgeführten Ersatzteile sind in den Werkzeugen montiert.

Reservdelar i de färgade kolumnerna ingår monterade i varje verktyg.



		 										Page Seite Sida	EB  Page: Seite: Sida: B24 - B26
		8	10	12	16	20	25	32	40	50	60		
 107,5°	SDQC R/L			07	07							D43	
 107,5°	SVQC R/L			11	11							D43	EB 
 95°	SCLC R/L	06	06	06	09							D44	EB 
 95°	SWLC R/L Solid tungsten carbide Massives Hartmetall Solid hårdmetall	02 04	04	04	06							D44	EB 
 93°	SDUC R/L Solid tungsten carbide Massives Hartmetall Solid hårdmetall		07	07	07							D45	EB 
 93°	SDXC R/L			07	07							D45	
 93°	SVUC R/L				11							D46	EB 
 91°	STFC R/L		09	11	11							D46	
 91°	SCFC R/L	06	06	06	09							D47	EB 
 91°	SCFC R/L Solid tungsten carbide Massives Hartmetall Solid hårdmetall	06	06	09	09							D47	
 75°	SSKC R/L				09							D48	
 45°	SSSC R/L				09							D48	

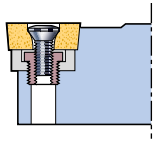
D

SDQC R/L

Recommendations
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107,5°



S

The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.

107,5°

55°

107,5°

55°

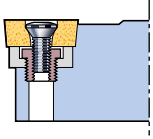
	d	h	l_1	l	f	D_{min}	λ						DCMW DCMT	* 	Page: Seite: Sida: D49-D53
S12Q-SDQC R/L 07 S16R-SDQC R/L 07	12 16	11 15	180 200	20 25	9 11	17 21	-11° -5°	FTX072507	NY7X	-	-	-	-	0702 . .	

SVQC R/L

Recommendations
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Rekommendationer

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B12-B14, B18

107,5°



S

The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.

107,5°

35°

107,5°

35°

107,5°

35°

107,5°

35°

	d	h	l_1	l	f	D_{min}	λ						VCMW VCMT	* 	Page: Seite: Sida: D49-D53
A12M-SVQC R/L 11M-EB A16M-SVQC R/L 11M-EB	12 16	11 15	150 150	20 22	11 13	18 22	-11° -7°	FTX072505 FTX072507	NY7X NY7X	-	-	-	-	1103 . .	

EB = Adapted for MIRCONA micro-lubrication system
A = Through coolant

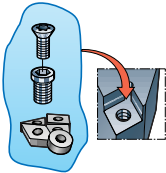
EB = Für MIRCONA Minimalmengensmiersystem angepasst
A = Innenkühlmittelzuführung

EB = Anpassad för MIRCONA minimal-smörjsystem
A = Invändig kylvätsketillförsel

Selection of cutting geometry page:
Wahl der Schneidgeometrie, Seite:
Val av skärgeometri, sid:

B27-B39

Ordering example:
Bestellbeispiel: **S16M-SVQCR 11M-EB**
Beställningsexempel:



Spare parts shown in the coloured columns are supplied assembled in each tool.

Die in den farbigen Spalten aufgeführten Ersatzteile sind in den Werkzeugen montiert.

Reservdelar i de färgade kolumnerna ingår monterade i varje verktyg.



SCLC R/L

Recommendations
Empfehlungen
Rekomendationer

Page: Seite: Sida:
B12-B14, B18

The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.

Page: Seite: B24 - B26
Sida:

	d	h	l ₁	l	f	D _{min}	λ		 torx				CCMW CCMT		Page: Seite: Sida:
S08K-SCLC R/L 06	8	7	125	20	5	11	-11°	FTX072505							
S10L-SCLC R/L 06	10	9	140	20	7	13	-11°	FTX072507	NY7X	—	—	—	0602 . .		
S12N-SCLC R/L 06	12	11	160	25	9	16	-15°	FTX072507							
S16R-SCLC R/L 09M	16	15	200	30	11	20	-12°	FTX154008	NY15X	—	—	—	09T3 . .		

SWLC R/L

Recommendations
Empfehlungen
Rekomendationer

Page: Seite: Sida:
B12-B14, B18

The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.

Page: Seite: B24 - B26
Sida:

-EB

-RA
Carbide shank
Hartmetallschaft
Hårdmetallskäft

	d	h	l ₁	l	f	D _{min}	λ		 torx				WCMW WCMT WCGT		Page: Seite: Sida:
S10L-SWLC R/L 04	10	9	140	20	7	13	-11°	FTX072507	NY7X	—	—	—	0402 . .		
S12N-SWLC R/L 04	12	11	160	25	9	16	-12°								
S16R-SWLC R/L 06	16	15	200	30	11	20	-7°	FTX154010	NY15X	—	—	—	06T3 . .		
A08H-SWLC R/L 02/6-EB	8	7	100	20	2,9	6	-17°	FTX062003	NY6X	—	—	—	0201 . .R/L ¹⁾		
A08H-SWLC R/L 02/8-EB	8	7	100	20	4	8	-12°						0201 . .		
A08H-SWLC R/L 04-EB	8	7	100	20	5	10	-11°	FTX072505	NY7X	—	—	—	0402 . .		
A10K-SWLC R/L 04-EB	10	9	125	20	7	13	-12°								
A12M-SWLC R/L 04-EB	12	11	150	25	9	16	-12°	FTX072505	NY7X	—	—	—			
A16M-SWLC R/L 06-EB	16	15	150	30	11	20	-7°	FTX154010	NY15X	—	—	—	06T3 . .		
E08K-SWLC R/L 04-RA	8	-	125	12	5	10	-11°	FTX072505	NY7X	—	—	—	0402 . .		
E10M-SWLC R/L 04-RA	10	-	150	12	7	13	-11°								
A12Q-SWLC R/L 04-RA	12	-	180	12	9	16	-12°	FTX072507	NY7X	—	—	—			
A16R-SWLC R/L 06-RA	16	-	200	12	11	20	-7°	FTX150410	NY15X	—	—	—	06T3 .		

¹⁾ Left-hand inserts (L) are used in right-hand holders and right-hand inserts (R) are used in left-hand holders.

¹⁾ Linksschneiden (L) werden in Rechtshaltern und Rechtsschneiden (R) in Linkshaltern verwendet.

¹⁾ Vänsterskär (L) används i högerhållare och högerskär (R) i vänsterhållare.

SDUC R/L

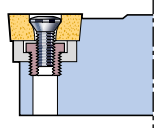
Recommendations
Empfehlungen
Rekomendationer

Page: Seite: Sida:

B12-B14, B18

93°

≤ 27°



S

The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.

EB

Page: Seite: Sida:

B24 - B26

0°

93°

EB

Carbide shank
Hartmetallschaft
Hårdmetallskäft

EB

Carbide shank
Hartmetallschaft
Hårdmetallskäft

EB

Carbide shank
Hartmetallschaft
Hårdmetallskäft

	d	h	l ₁	l	f	D _{min}	λ		 torx				DCMW DCMT	* D49-D53	Page: Seite: Sida: D49-D53
S12N-SDUC R/L 07 S16R-SDUC R/L 07	12 16	11 15	160 200	20 30	9 11	17 20	-11° -5°	FTX072507	NY7X	—	—	—	0702 . .		
A10K-SDUC R/L 07-EB A12M-SDUC R/L 07-EB A16M-SDUC R/L 07-EB	10 12 16	9 11 15	125 150 150	20 20 30	7 9 11	13 17 20	-15° -11° -5°	FTX072505 FTX072507	NY7X NY7X	— — —	— — —	— — —	0702 . .		
E10M-SDUC R/L 07-RAM E12Q-SDUC R/L 07-RAM E16R-SDUC R/L 07-RAM	10 12 16	— — —	150 180 200	23 26 32	9 11 13	15 18 22	-7° -5° -5°	FTX072505 FTX072507	NY7X NY7X	— — —	— — —	— — —	0702 . .		

SDXC R/L

Recommendations
Empfehlungen
Rekomendationer

Page: Seite: Sida:

B12-B14, B18

93°

≤ 30°

S

The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.

EB

Page: Seite: Sida:

D49-D53

0°

93°

EB

Carbide shank
Hartmetallschaft
Hårdmetallskäft

EB

Carbide shank
Hartmetallschaft
Hårdmetallskäft

EB

Carbide shank
Hartmetallschaft
Hårdmetallskäft

	d	h	l ₁	l ₂	f	D _{min}	λ		 torx	DCMW DCMT	* D49-D53	Page: Seite: Sida: D49-D53
S12Q-SDXC R/L 07T S16R-SDXC R/L 07T	12 16	11 15	180 200	25 30	9 11	17 20	-5° -5°	FTX072507	NY7X	0702 . .		

EB = Adapted for MIRCONA micro-lubrication system
E = Carbide shank
R = Cylindrical shank
A = Through coolant

EB = Für MIRONA Minimalmengensmiersystem angepasst
E = Hartmetallschaft
R = Zylindrisches Schaft
A = Innenkühlmittelführung

EB = Anpassad för MIRCONA minimal-smörjsystem
E = Hårdmetallskäft
R = Cylindriskt skäft
A = Invändig kylvätsketillförsel

*

Selection of cutting geometry page:
Wahl der Schneidgeometrie, Seite:
Val av skärgeometri, sid:

B27-B39

Ordering example:
Bestellbeispiel: **S12N-SDUCR 07**
Beställningsexempel:

Spare parts shown in the coloured columns are supplied assembled in each tool.

Die in den farbigen Spalten aufgeführten Ersatzteile sind in den Werkzeugen montiert.

Reservdelar i de färgade kolumnerna ingår monterade i varje verktyg.

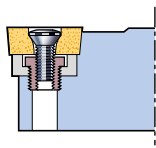
D45

SVUC R/L

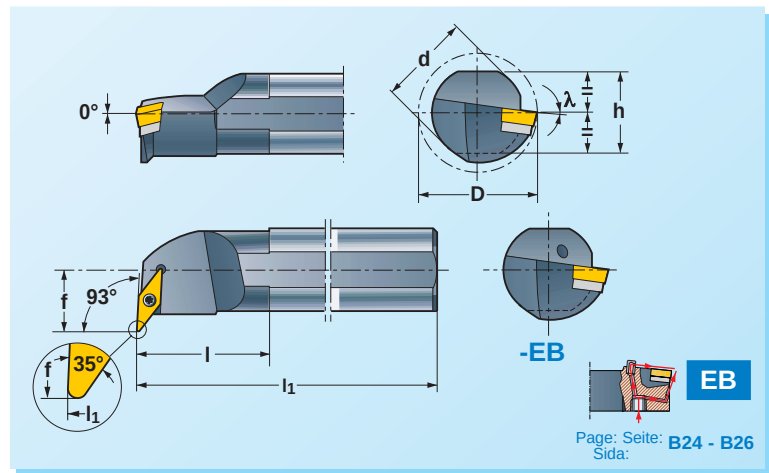
Recommendations
Empfehlungen
Rekommendationer

Page: Seite: Sida:

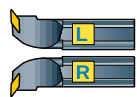
B12-B14, B18

**S**

The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.

93°

Page: Seite: **B24 - B26**
Sida:



d

h

l₁

l

f

D_{min}

λ



torx

-

-

-



VCMT *
VCGT

Page:
Seite:
Sida:

D49-D53

A16M-SVUC R/L 11M-EB	16	15	150	20	13	22	-7°	FTX072507	NY7X	-	-	-	1103 . .
-----------------------------	----	----	-----	----	----	----	-----	-----------	------	---	---	---	----------

EB = Adapted for MIRCONA micro-lubrication system
A = Through coolant

EB = Für MIRCONA Minimalmengen-schmiersystem angepasst
A = Innenkühlmittelzuführung

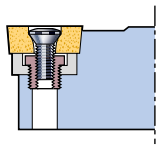
EB = Anpassad för MIRCONA minimal-smörjsystem
A = Invändig kylvätsketillförsel

STFC R/L

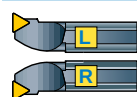
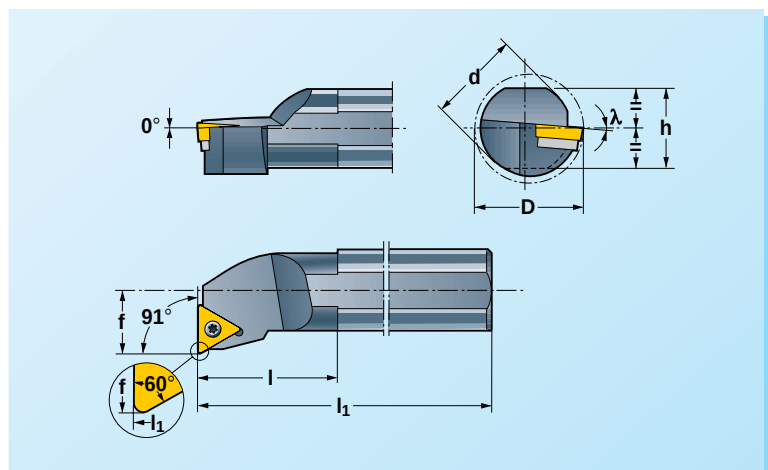
Recommendations
Empfehlungen
Rekommendationer

Page: Seite: Sida:

B12-B14, B18

**S**

The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.

91°

d

h

l₁

l

f

D_{min}

λ



torx

TCMW *

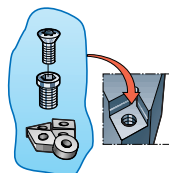
TCMT

Page:
Seite:
Sida:

D49-D53

S10L-STFC R/L 09	10	9	140	20	7	13	-15°	FTX072206	NY7X	0902 . .
S12N-STFC R/L 11	12	11	160	25	9	16	-10°	FTX072507	NY7X	1102 . .
S16R-STFC R/L 11	16	15	200	30	11	20	-6°	FTX072507	NY7X	1102 . .

* Selection of cutting geometry page:
Wahl der Schneidgeometrie, Seite:
Val av skärgeometri, sid:

B27-B39

Spare parts shown in the coloured columns are supplied assembled in each tool.

Die in den farbigen Spalten aufgeführten Ersatzteile sind in den Werkzeugen montiert.

Reservdelar i de färgade kolumnerna ingår monterade i varje verktyg.

Ordering example:

Bestellbeispiel:

Beställningsexempel:

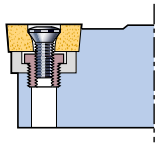
S10L-STFCR 09

SCFC R/L

Recommendations
Empfehlungen
Rekommendationer

Page: Seite: Sida:
B12-B14, B18

91°



S

The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.

Page: Seite: Sida:
B24 - B26

EB

 	d	h	l_1	l	f	D_{min}	λ	 	 	CCMW * CCMT	Page: Seite: Sida: D49-D53
S08K-SCFC R/L 06	8	7	125	20	5	10	-11°	FTX072505	NY7X	0602 . .	
S10L-SCFC R/L 06	10	9	140	20	7	13	-11°	FTX072507			
S12N-SCFC R/L 06	12	11	160	25	9	16	-15°	FTX072507			
S16R-SCFC R/L 09M	16	15	200	25	11	20	-12°	FTX154010	NY15X	09T3 . .	

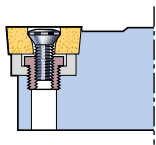
SCFC R/L

Recommendations
Empfehlungen
Rekommendationer

Page: Seite: Sida:
B12-B14, B18

91°

Solid tungsten carbide
Massives Hartmetall
Solid hårdmetall



S

The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.

 	d	l_1	f	l_2	D_{min}	λ	 	 	CCMW * CCMT	Page: Seite: Sida: D49-D53
E08K-SCFCR/L 06-RA	8	125	5	18	10	-11°	FTX072505	NY7X	0602 . .	
E10M-SCFCR/L 06-RA	10	150	7	23	13	-11°	FTX072505			
E12Q-SCFCR/L 09-RA	12	180	9	26	17	-11°	FTX154010	NY15X	09T3 . .	
E16R-SCFCR/L 09-RA	16	200	11	32	20	-7°	FTX154010			

A = Through coolant
R = Cylindrical shank

A = Innenkühlmittelzuführung
R = Zylindrisches Schaft

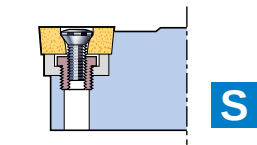
A = Invändig kylvätsketillförsel
R = Cylindriskt skaft

SSKC R/L

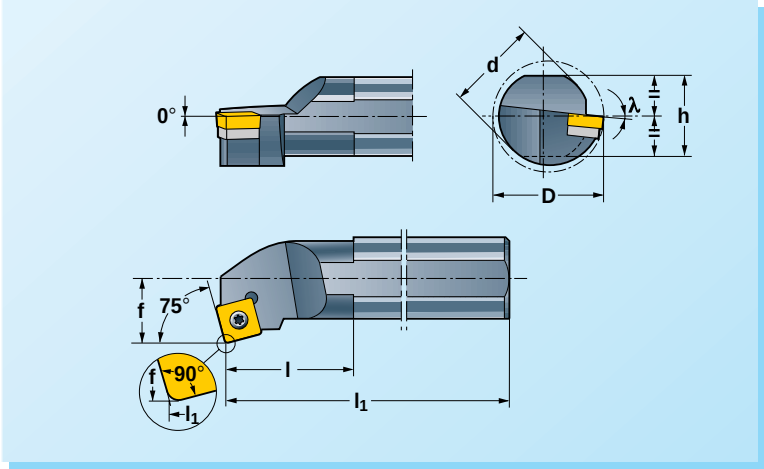
Recommendations
Empfehlungen
Rekomendationer

Page: Seite: Sida:
B12-B14, B18

75°



The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.



	d	h	l ₁	l	f	D _{min}	λ		 torx	SCMW SCMT	*	Page: Seite: Sida: D49-D53
S16R-SSKC R/L 09M	16	15	200	30	11	20	-11°	FTX153512	NY15X	09T3 . .		

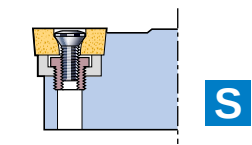
D

SSSC R/L

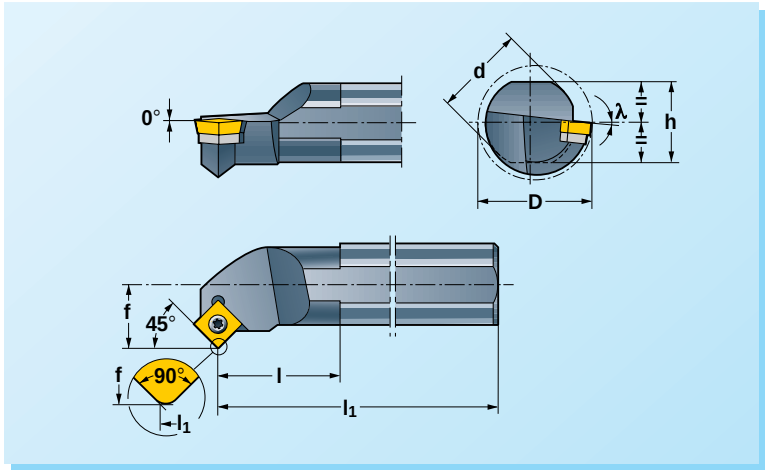
Recommendations
Empfehlungen
Rekomendationer

Page: Seite: Sida:
B12-B14, B18

45°



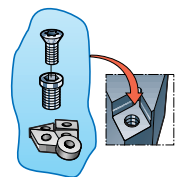
The drawing shows right-hand version. Left-hand version reversed.
Die Zeichnung zeigt Rechtsausführung. Linksausführung umgekehrt.
Ritningen visar högerutförande. Vänsterutförande spegelvänt.



	d	h	l ₁	l	f	D _{min}	λ		 torx				SCMW SCMT	*	Page: Seite: Sida: D49-D53
S16R-SSSC R/L 09	16	15	200	30	11	21	-5°	FTX153512	NY15X	—	—	—	09T3 . .		

*
 Selection of cutting geometry page:
Wahl der Schneidgeometrie, Seite: B27-B39
 Val av skärgeometri, sid:

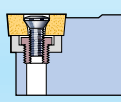
Ordering example:
Bestellbeispiel: S16R-SSSCR 09
Beställningsexempel:



Spare parts shown in the coloured columns are supplied assembled in each tool.

Die in den farbigen Spalten aufgeführten Ersatzteile sind in den Werkzeugen montiert.

Reservdelar i de färgade kolumnerna ingår monterade i varje verktyg.



WCGT-PF05							
WCGT 02 01 01R-PF05		○		○		○	
WCGT 02 01 02R-PF05		○		○		○	
WCGT 02 01 01L-PF05		○		○		○	
WCGT 02 01 02L-PF05		○		○		○	

TCM/GT-PF1 *							
TCMT 11 02 04-PF1		□		○		○	
TCGT 11 02 02-PF1		○		○		○	
TCGT 11 02 04-PF1		○		○		○	
TCGT 11 02 08-PF1		○		○		○	

SCMT-PF1 *							
SCMT 09 T3 04-PF1		○		○		○	
SCMT 09 T3 08-PF1		○		○		○	

● Coated grades ● Beschichtete
Sorten ● Belagda sorter.

	CVD TiN/TiCN/ Al ₂ O ₃ /TiN+		PVD TiAlN
	CVD TiN/TiCN/ Al ₂ O ₃		PVD TiAlN

CVD = Chemical Vapour Deposition
PVD = Physical Vapour Deposition

	Page: Seite: Sida:	D28-D41
	Page: Seite: Sida:	D42-D48

CCM/GT-PF1 *							
CCMT 06 02 04-PF1		○		○		○	
CCMT 06 02 08-PF1		○		○		○	
CCGT 06 02 02-PF1		○		○		○	
CCMT 09 T3 04-PF1		○		○		○	
CCMT 09 T3 08-PF1		○		○		○	
CCGT 09 T3 02-PF1		○		○		○	

WCM/GT-PF1 *							
WCGT 02 01 02-PF1		○		○		○	
WCMT 04 02 04-PF1		○		○		○	
WCGT 04 02 02-PF1		○		○		○	
WCMT 06 T3 04-PF1		○		○		○	
WCGT 06 T3 02-PF1		○		○		○	

DCM/GT-PF1 *							
DCMT 07 02 04-PF1		○		○		○	
DCGT 07 02 02-PF1		○		○		○	
DCMT 11 T3 04-PF1		○		○		○	
DCMT 11 T3 08-PF1		○		○		○	
DCGT 11 T3 02-PF1		○		○		○	

Ordering example:
Bestellbeispiel: **CCMT 060204-PF1 CER 510**
Beställningsexempel:

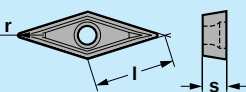
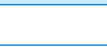
Page:
Seite:
Sida: **D54**

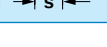
- Stocked - Ab Lager - Lagerfört
- Limited stocked - Begrenzt ab Lager - Begränsat lagerfört
- Offered on request - Auf Anfrage angeboten - Offereras på begäran

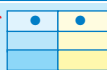
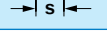
* Selection of cutting geometry, page:
Wahl der Schneidengeometrie, Seite: **B27-B38**
Val av skärgeometri, sida:

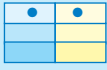
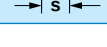
Selection of carbide grade, page:
Wahl der Hartmetallsorte, Seite: **B168-B171**
Val av hårdmetallsort, sida:

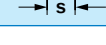
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Schnittdaten, Seite: **B196-B205**
Skärdata, sida:

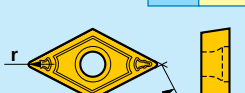
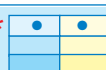
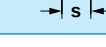
VCMT-PF1 *	1)				
					
					
VCMT 11 03 02-PF1 VCMT 11 03 04-PF1		TNP 220 P20/M20/S15	TNP 140 P40/M25/S25	CER 510 P10/M10	FG25 K20/ S20/N25/H15
					S6 P40

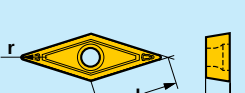
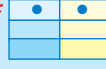
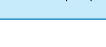
TCMT-PF2 *	1)				
					
					
TCMT 11 02 02-PF2 TCMT 11 02 04-PF2 TCMT 11 02 08-PF2		ALC 400 P10/M10/K10	ALC 410 K15	ALC 345 P15/M20/K20	ALC 245 P25
TCMT 16 T3 02-PF2 TCMT 16 T3 04-PF2 TCMT 16 T3 08-PF2					ALC 145 P30/M30

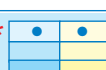
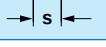
SCMT-PF2 *	1)				
					
					
SCMT 09 T3 04-PF2 SCMT 09 T3 08-PF2		ALC 400 P10/M10/K10	ALC 410 K15	ALC 345 P15/M20/K20	ALC 245 P25
					ALC 145 P30/M30

CCMT-PF2 *	1)				
					
					
CCMT 06 02 02-PF2 CCMT 06 02 04-PF2 CCMT 06 02 08-PF2		ALC 400 P10/M10/K10	ALC 410 K15	ALC 345 P15/M20/K20	ALC 245 P25
CCMT 09 T3 02-PF2 CCMT 09 T3 04-PF2 CCMT 09 T3 08-PF2					ALC 145 P30/M30
CCMT 12 04 04-PF2 CCMT 12 04 08-PF2					

WCMT-PF2 *	1)				
					
					
WCMT 04 02 02-PF2 WCMT 04 02 04-PF2 WCMT 04 02 08-PF2		ALC 400 P10/M10/K10	ALC 410 K15	ALC 345 P15/M20/K20	ALC 245 P25
WCMT 06 T3 02-PF2 WCMT 06 T3 04-PF2 WCMT 06 T3 08-PF2					ALC 145 P30/M30

DCMT-PF2 *	1)				
					
					
DCMT 07 02 02-PF2 DCMT 07 02 04-PF2 DCMT 07 02 08-PF2		ALC 400 P10/M10/K10	ALC 410 K15	ALC 345 P15/M20/K20	ALC 245 P25
DCMT 11 T3 02-PF2 DCMT 11 T3 04-PF2 DCMT 11 T3 08-PF2					ALC 145 P30/M30

VCMT-PF2 *	1)				
					
					
VCMT 11 03 02-PF2 VCMT 11 03 04-PF2 VCMT 11 03 08-PF2		ALC 400 P10/M10/K10	ALC 410 K15	ALC 345 P15/M20/K20	ALC 245 P25
					ALC 145 P30/M30

RCMT-PF2 *	1)				
					
					
RCMT 08 03 M0 E-PF2		ALC 400 P10/M10/K10	ALC 345 P15/M20/K20	ALC 245 P25	ALC 145 P30/M30
RCMT 10 T3 M0 E-PF2 RCMT 10 T3 M0 S-PF2					FG25 K20/ S20/N25/H15
					S6 P40

Ordering example:
Bestellbeispiel: **VCMT 110302-PF2 ALC 245 P25**
Beställningsexempel:

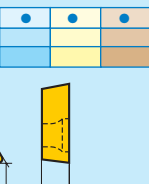
● Coated grades ● Beschichtete
Sorten ● Belagda sorter.

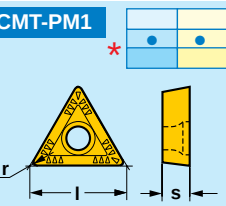
CVD = Chemical Vapour Deposition
PVD = Physical Vapour Deposition

 CVD TiN/TiCN/Al₂O₃/TiN+  PVD TiAlN  CVD TiN/TiCN/Al₂O₃

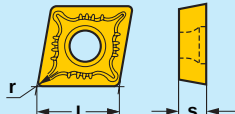
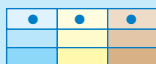
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	Page: D42-D48 Seite: D42-D48 Sida: D42-D48

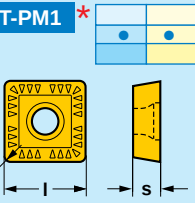
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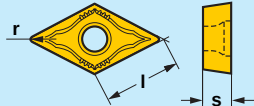
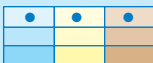
TCMT-PF3 *					
 l s r	ALC 400 P10/M10/K10	ALC 410 K15	ALC 245 P25	ALC 145 P30/M30	ALC 135 P35/M30/S30
TCMT 11 02 02-PF3	○		○	○	□
TCMT 11 02 04-PF3	○		□	○	□
TCMT 16 T3 04-PF3	○		□	○	□
TCMT 16 T3 08-PF3	○		■	○	□

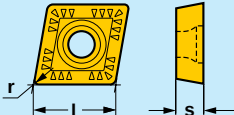
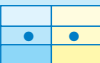
TCMT-PM1		1)
		
TCMT 11 02 04-PM1 TCMT 11 02 08-PM1		
TCMT 16 T3 04-PM1 TCMT 16 T3 08-PM1 TCMT 16 T3 12-PM1		

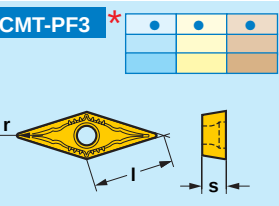
					
ALC 400 P10/M10/K10	ALC 410 K15	ALC 345 P15/M20/K20	ALC 245 P25	ALC 145 P30/M30	
			 	 	

CCMT-PF3 *			1)		
 l s r	ALC 400 P10/M10/K10	ALC 410 K15	ALC 245 P25	ALC 145 P30/M30	ALC 135 P35/M30/S30
CCMT 06 02 02-PF3	○		□	□	□
CCMT 06 02 04-PF3	○		□	□	□
CCMT 09 T3 02-PF3	○		□	□	□
CCMT 09 T3 04-PF3	○		□	□	□
CCMT 09 T3 08-PF3	○		■	□	□

SCMT-PM1 *		1)					
			ALC 400 P10/M10/K10	ALC 410 K15	ALC 345 P15/M20/K20	ALC 245 P25	ALC 145 P30/M30
SCMT 09 T3 04-PM1 SCMT 09 T3 08-PM1							

DCMT-PF3 *		1)					
							
	l s r	ALC 400 P10/M10/K10	ALC 410 K15	ALC 245 P25	ALC 145 P30/M30	ALC 135 P35/M30/S30	
DCMT 07 02 02-PF3		○		□	□	□	
DCMT 07 02 04-PF3		○		□	□	□	
DCMT 11 T3 02-PF3		○		□	□	□	
DCMT 11 T3 04-PF3		○		□	□	□	
DCMT 11 T3 08-PF3		○		■	□	□	

CCMT-PM1 *	1)					
						
	l s r	ALC 400 P10/M10/K10	ALC 410 K15	ALC 345 P15/M20/K20	ALC 245 P25	ALC 145 P30/M30
CCMT 06 02 04-PM1 CCMT 06 02 08-PM1					■	□
CCMT 09 T3 04-PM1 CCMT 09 T3 08-PM1					■	○
CCMT 12 04 04-PM1 CCMT 12 04 08-PM1 CCMT 12 04 12-PM1					■	■
					□	○

VCMT-PF3 *		1)				
						
		ALC 400 P10/M10/K10	ALC 410 K15	ALC 245 P25	ALC 145 P30/M30	ALC 135 P35/M30/S30
VCMT 11 03 02-PF3		☐		☐	☐	☐
VCMT 11 03 04-PF3		☐		☐	☐	☐

WCMT-PM1 * 1)		
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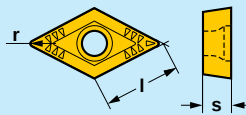
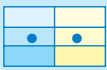
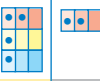
- Stocked - Ab Lager - Lagerfört
- Limited stocked - Begrenzt ab Lager - Begränsat lagerfört
- Offered on request - Auf Anfrage angeboten - Offereras på begäran

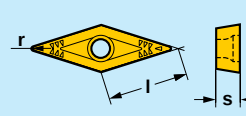
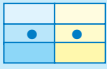
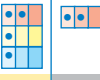


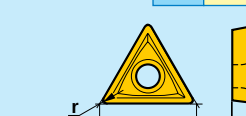
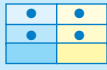
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Val av skärgeometri, sida:

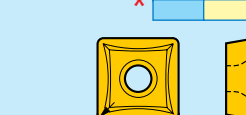
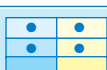
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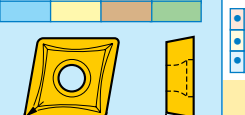
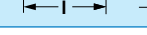
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Skärdata, sida:

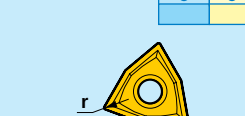
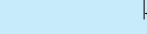
DCMT-PM1 *	1)				
					
		ALC 400 P10/M10/K10	ALC 410 K15	ALC 345 P15/M20/K20	ALC 245 P25
DCMT 07 02 04-PM1 DCMT 07 02 08-PM1					
DCMT 11 T3 04-PM1 DCMT 11 T3 08-PM1					

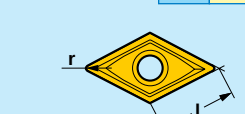
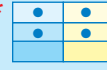
VCMT-PM1 *	1)				
					
		ALC 400 P10/M10/K10	ALC 410 K15	ALC 345 P15/M20/K20	ALC 245 P25
VCMT 11 03 04-PM1 VCMT 11 03 08-PM1					

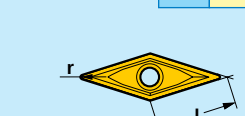
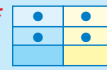
TCMT-PM2 *	1)				
					
		ALC 400 P10/M10/K10	ALC 410 K15	ALC 345 P15/M20/K20	ALC 245 P25
TCMT 11 02 04-PM2 TCMT 11 02 08-PM2					
TCMT 16 T3 04-PM2 TCMT 16 T3 08-PM2					

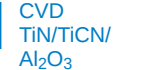
SCMT-PM2 *	1)				
					
		ALC 345 P15/M20/K20	ALC 245 P25	ALC 145 P30/M30	TNP 220 P20/M20/S15
SCMT 09 T3 04-PM2 SCMT 09 T3 08-PM2					

CCMT-PM2 *	1)				
					
		ALC 400 P10/M10/K10	ALC 345 P15/M20/K20	ALC 245 P25	ALC 145 P30/M30
CCMT 06 02 02-PM2 CCMT 06 02 04-PM2 CCMT 06 02 08-PM2					
CCMT 09 T3 04-PM2 CCMT 09 T3 08-PM2					
CCMT 12 04 04-PM2 CCMT 12 04 08-PM2					

WCMT-PM2 *	1)				
					
		ALC 400 P10/M10/K10	ALC 345 P15/M20/K20	ALC 245 P25	ALC 145 P30/M30
WCMT 04 02 04-PM2 WCMT 06 T3 04-PM2					

DCMT-PM2 *	1)				
					
		ALC 400 P10/M10/K10	ALC 345 P15/M20/K20	ALC 245 P25	ALC 145 P30/M30
DCMT 07 02 04-PM2 DCMT 11 T3 04-PM2 DCMT 11 T3 08-PM2					

VCMT-PM2 *	1)				
					
		ALC 345 P15/M20/K20	ALC 245 P25	ALC 145 P30/M30	TNP 220 P20/M20/S15
VCMT 11 03 04-PM2					

● Coated grades ● Beschichtete Sorten ● Belagda sorter.
 CVD = Chemical Vapour Deposition
 PVD = Physical Vapour Deposition
 CVD
 TiN/TiCN/
 Al₂O₃/TiN+
 PVD
 TiAlN
 CVD
 TiN/TiCN/
 Al₂O₃

	Page: Seite: Sida:	D28-D41
	Page: Seite: Sida:	D42-D48

1)	Page: Seite: Sida:	D54
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CCGT-AL1 * 1)			
	TNP 400 N25	FG10 S15/N10	FG15 N15
CCGT 06 02 02F-AL1P CCGT 06 02 04F-AL1P	☐	☐	☐
CCGT 09 T3 02F-AL1P CCGT 09 T3 04F-AL1P CCGT 09 T3 08F-AL1P	☐	☐	☐
CCGT 12 04 02F-AL1P CCGT 12 04 04F-AL1P CCGT 12 04 08F-AL1P	☐	☐	☒

DCGT-AL1 * 1)			
	TNP 400 N25	FG10 S15/N10	FG15 N15
DCGT 07 02 02F-AL1P DCGT 07 02 04F-AL1P	☐	☐	☐
DCGT 11 T3 02F-AL1P DCGT 11 T3 04F-AL1P DCGT 11 T3 08F-AL1P	☐	☐	☒

VCGT-AL1 * 1)			
	TNP 400 N25	FG10 S15/N10	FG15 N15
VCGT 11 03 02F-AL1P	☐	☐	☐

RCGT-AL1 * 1)			
	TNP 400 N25	FG10 S15/N10	FG15 N15
RCGT 08 03 M0F-AL1P	☐	☐	☐

CCXT-AL2 * 1)		
	TNP 315 M15	FG15 N15
CCXT 06 02 04-AL2 CCXT 09 T3 04-AL2 CCXT 09 T3 08-AL2	☐	☐

DCXT-AL2 * 1)		
	TNP 315 M15	FG15 N15
DCXT 07 02 04-AL2 DCXT 11 T3 04-AL2 DCXT 11 T3 08-AL2	☐	☐

VCXT-AL2 * 1)		
	TNP 315 M15	FG15 N15
VCXT 16 04 04-AL2 VCXT 16 04 08-AL2 VCXT 16 04 12-AL2	☐	☐

RCXT-AL2 * 1)		
	TNP 315 M15	FG15 N15
RCGT 08 03 M0-AL2	☐	☐

Ordering example:
Bestellbeispiel: **DCXT 111T304-AL2 FG15**
Beställningsexempel:

TCMT 1)		
	TNC 150 P35/M30	ALC 350 P15/M10/K10/S10
TCMT 06 T1 02 TCMT 09 02 04	☐	☐

CCMT 1)	
	TNC 150 P35/M30
CCMT 09 03 04 CCMT 09 03 08	☐

RCMT 1)		
	SAFM P25	H10 K10/N10
RCMT 06 02 M0	☐	☐

- Stocked - Ab Lager - Lagerfört
- Limited stocked - Begrenzt ab Lager - Begränsat lagerfört
- Offered on request - Auf Anfrage angeboten - Offereras på begäran

* Selection of cutting geometry, page: **B27-B38**
Wahl der Schneidengeometrie, Seite:
Val av skärgeometri, sida:

Selection of carbide grade, page: **B168-B171**
Wahl der Hartmetallsorte, Seite:
Val av hårdmetallsort, sida:

Cutting data, page: **B196-B205**
Schnittdaten, Seite:
Skärdata, sida: