

NC-Stechedrehsystem*NC-Groove turning system*

NC-Sistema di scanalatura e copiatura

Stechedrehsystem zum Außen- und Innenstechedrehen

Groove turning system for external and internal grooving and copy-turning

Sistema di scanalatura e copiatura modulare esterna e interna

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Universal Stechsystem für die Außen- und Innenbearbeitung beim Radialen, Axialen und Kontra Stechen

External and internal groove turning system for radial, axial and contra grooving applications

Sistema di scanalatura universale per lavorazione esterna e interna radiale, assiale e kontra

2

Grundhalter – Außenbearbeitung

Basic holders – External machining

Corpo utensili – Steli per lavorazione esterna



Grundhalter – Innenbearbeitung

Basic holders – Internal machining

Corpo utensili – Steli per lavorazione interna



Systemvorstellung

Ein Werkzeugsystem, das höchsten Ansprüchen gerecht wird. Einfachste Montage verbunden mit höchster Vielfalt. Ein Werkzeughalter wird durch schnellen Wechsel der einzelnen Komponenten zu einem universell einsetzbaren Werkzeugsystem.

Grundhalter – Außenbearbeitung

- Schäfte von 8 x 8 bis 32 x 32 mm
- Stechbreiten 0,55 bis 10 mm
- Capto/UTS/KM/VDI Aufnahmen

Grundhalter – Innenbearbeitung

- Schäfte von Ø 12 bis Ø 50 mm
- D_{\min} ab Ø 16 mm
- Stechbreiten 0,55 bis 10 mm

Introduction

A tool system that meets the highest requirements. Extremely easy handling with maximum variety. One tool holder becomes universally usable tooling system due to the rapid changing of the individual components.

Basic holders – External machining

- Shank sizes from 8 x 8 to 32 x 32 mm
- Groove widths from 0.55 to 10 mm
- Capto/UTS/KM/VDI adaptors

Basic holders – Internal machining

- Shank sizes from Ø 12 to Ø 50 mm
- D_{\min} from Ø 16 mm
- Groove widths from 0.55 to 10 mm

Descrizione

Un sistema di utensili rivolto alle lavorazioni più esigenti. Montaggio semplice e modulare. Grazie al cambio veloce dei singoli componenti diventa un sistema di utensili per un uso universale.

Corpo utensili – Steli per lavorazione esterna

- Steli da 8 x 8 fino a 32 x 32 mm
- Larghezza di taglio da 0,55 a 10 mm
- Capto/UTS/KM/VDI attacchi

Corpo utensili – Steli per lavorazione interna

- Steli da Ø 12 fino a Ø 50 mm
- D_{\min} da Ø 16 mm
- Larghezza di taglio da 0,55 a 10 mm

Fakten

- Verschiedene Stechdrehwerkzeuge für den Einsatz mit speziell entwickelten Schneideinsätzen
- Modulares Stechdrehsystem in vielen Ausführungen mit einem Grundhalter
- Für die Innen- und Außenbearbeitung
- Speziell entwickelte Geometrien für
 - Aluminiumbearbeitung
 - Sicherungseinstiche
 - Späneinschnürung
- SIN (Bohrstangen für die Innenbearbeitung, Einsatz für kleine Bohrungen)

Features

- Various cutting tools for use with specially developed cutting inserts
- Modular grooving system – various capabilities with one single holder
- For internal and external machining
- Special geometries for
 - Aluminum
 - Chip grooves
 - Chip breaking and constriction
- SIN (internal boring bars with coolant directly on cutting edge for smaller bores)

Caratteristiche

- Diverse composizioni di utensili da utilizzare con inserti specifici
- Sistema modulare: diverse versioni con un solo stelo
- Per lavorazioni esterne e interne
- Geometrie specifiche per
 - Alluminio
 - Sedi seeger e OR
 - Controllo truciolo
- SIN (barenì per gole integrale con adduzione diretta sul tagliante)



Grundhalter – Außenbearbeitung / *Basic holders – External machining* / **Corpo utensili – Steli per lavorazione esterna**

Seite/Page/Pagina **98 – 124**



SAN Monoblockhalter / *SAN Monoblock holders* / **SAN Utensili monoblocco**

Seite/Page/Pagina **125**



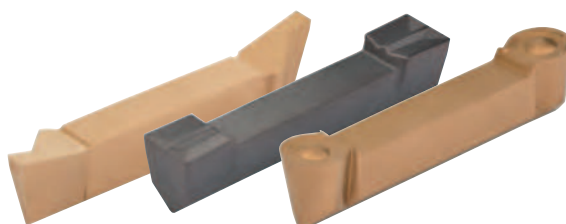
Grundhalter – Innenbearbeitung / *Basic holders – Internal machining* / **Corpo utensili – Steli per lavorazione interna**

Seite/Page/Pagina **132 – 137**



SIN Bohrstangen / *SIN Boring bars* / **SIN Baren**

Seite/Page/Pagina **138**

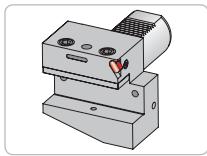


Schneideinsätze / *Inserts* / **Inserti**

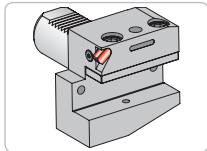
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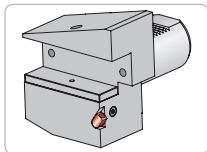
We have a passion for precision.

Übersicht KMH-Werkzeughalter / Program overview KMH holders /
Gamma prodotti adattatori KMH**Form B1***Form B1*

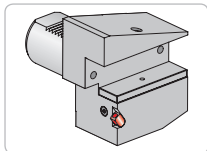
Forma B1

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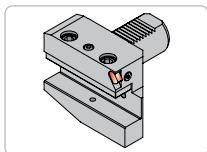
Forma B2

Seite/Page/Pagina **126****Form B3 – Überkopf***Form B3 – Overhead*

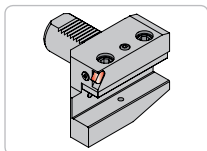
Forma B3 – Invertito

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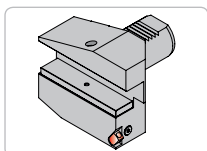
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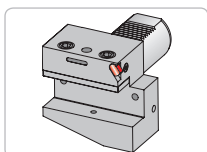
Forma B5

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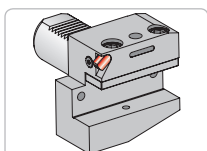
Forma B6

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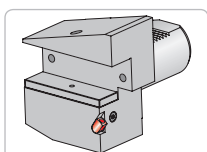
Forma B7 – Invertito

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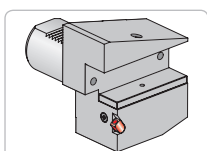
Forma C1

Seite/Page/Pagina **130****Form C2***Form C2*

Forma C2

Seite/Page/Pagina **130****Form C3 – Überkopf***Form C3 – Overhead*

Forma C3 – Invertito

Seite/Page/Pagina **131****Form C4 – Überkopf***Form C4 – Overhead*

Forma C4 – Invertito

Seite/Page/Pagina **131**

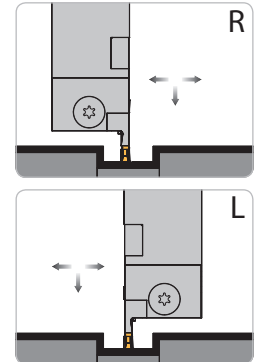
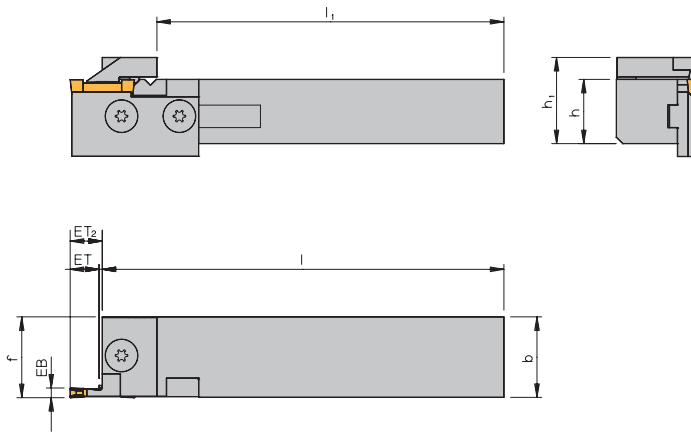
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Radial-Stechdrehen gerade

Radial groove turning straight

Utensile dritto – Scanalatura e copiatura radiale



Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

2

Grundhalter / Basic holder / Corpo utensile

Bezeichnung Designation Articolo	h	b	l	h ₁	l ₁	f
71216 R/L	12	16	90	17	81	16
71616 R/L	16	16	110	21	101	16
72020 R/L	20	20	125	25	116	20
72525 R/L-M	25	25	150	30	141	25
72025 R/L*	20	25	125	27	113	25
72525 R/L*	25	25	150	32	138	25
73225 R/L*	32	25	170	39	158	25
373232 R/L	32	32	170	40	145	33

*Bei Stechbreite 6 mm -> f = b + 0,5; übrige Stechbreiten f = b
*For width of cut 6 mm -> f = b + 0,5; for all others f = b
*Per larghezza di taglio di 6 mm -> f = b + 0,5; altre larghezze f = b

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	ET ₂	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
71216 R/L	0,5 – 1,85	= EB	= EB	UA2/471 R/L	KAM2 R/L	2-../471 R/L	T 154	KS 1111
71616 R/L	0,5 – 3,08	= EB	= EB	UA3/471 R/L	KAM3 R/L	3M-../471 R/L	T 154	KS 1111
72020 R/L	2,00	8,0	8,0	10208 R/L	KAM2 R/L	212....	T 154	KS 1111
72525 R/L-M	3,00	12,0	12,0	10312 R/L	KAM3 R/L	316....	T 154	KS 1111
72025 R/L 72525 R/L 73225 R/L	0,5 – 3,08	= EB	= EB	UA471 R/L	KA3 R/L	3-../471 R/L	T 205	T 5120
	3,00	9,5	9,5	20310 R/L	KA3 R/L	320....	T 205	T 5120
	4,00	11,5	11,5	20412 R/L	KA4 R/L	422....	T 205	T 5120
	5,00	14,5	14,5	20515 R/L	KA5 R/L	525....	T 205	T 5120
	6,00	19,5	19,5	20620 R/L	KA6 R/L	630....	T 205	T 5120
	3,00	16,0	18,5	UT316 R/L	KT3 R/L	320....	T 205	T 5120
	4,00	19,0	21,5	UT419 R/L	KT4 R/L	422....	T 205	T 5120
5,00	22,0	24,5	UT522 R/L	KT5 R/L	525....	T 205	T 5120	
6,00	27,0	29,5	UT627 R/L	KT6 R/L	630....	T 205	T 5120	
373232 R/L	8,00	18,0	18,0	30817 R/L	KAK8 R/L	838....	T 206	T 5120
	10,00	26,0	26,0	31025 R/L	KAK10 R/L	1046....	T 206	T 5120
	8,00	32,5	32,5	UT832 R/L	KA8 R/L	838....	T 206	T 5120
	10,00	40,5	40,5	UT1040 R/L	KA10 R/L	1046....	T 206	T 5120

ET₂ = Stechtiefe kann auf Maß „ET₂“ erhöht werden.
ET₂ = Grooving depth can be increased to measure "ET₂".

ET₂ = La profondità di scanalatura può essere aumentata alla dimensione "ET₂".

Achtung: Schwerverspannklemme für NC-Stechdrehen, bei unterbrochenen Schnitten oder Vibrationen, siehe Seite 104.
Attention: Heavy duty clamp for NC-Groove turning, at interrupted cuts or vibrations, please refer to page 104.
Attenzione: Staffa a serraggio rinforzata, per taglio interrotto o in caso di vibrazioni, vedere pagina 104.

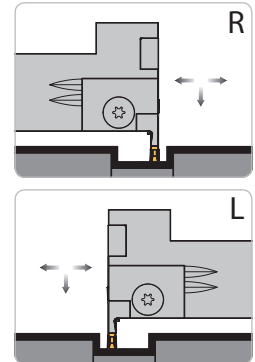
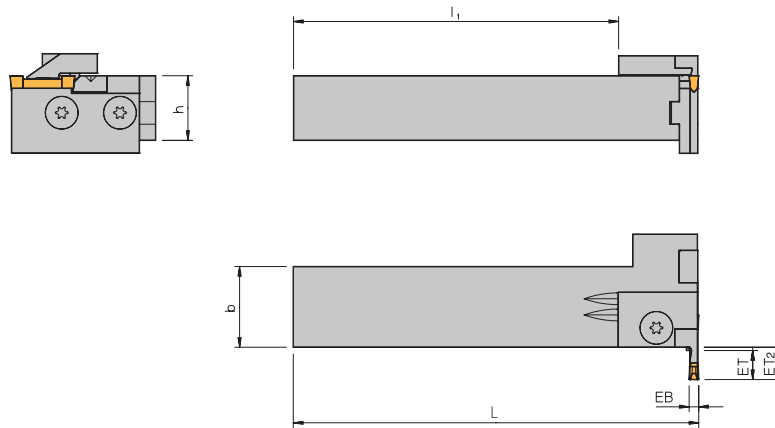
Grundhalter werden mit Schrauben und Schlüsseln geliefert, jedoch ohne U-Platte und Klemme.
Basic holders will be supplied with screws and key, however without support blade and clamp.
Gli steli sono forniti completi di viti e una chiave ma senza staffa e lama.

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Radial-Stechdrehen abgesetzt

Radial groove turning cranked

Utensile inclinato – Scanalatura e copiatura radiale



Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

Grundhalter / Basic holder / Corpo utensile

Bezeichnung Designation Articolo	h	b	L	l ₁
11616 R/L	16	16	110	95
12020 R/L	20	20	125	110
12525 R/L-M	25	25	150	125
12025 R/L	20	25	125	101
12525 R/L	25	25	150	126
13232 R/L	32	32	170	146
313232 R/L	32	32	170	145

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	ET ₂	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
11616 R/L 12020 R/L 12525 R/L-M	0,5 – 1,85	= EB	= EB	UA2/471 R/L	KAM2 R/L	2-../471 R/L	T 154	KS 1111
	0,5 – 3,08	= EB	= EB	UA3/471 R/L	KAM3 R/L	3M-../471 R/L	T 154	KS 1111
	2,00	8,0	8,0	10208 R/L	KAM2 R/L	212....	T 154	KS 1111
	3,00	12,0	12,0	10312 R/L	KAM3 R/L	316....	T 154	KS 1111
12025 R/L 12525 R/L 13232 R/L	0,5 – 3,08	= EB	= EB	UA471 R/L	KA3 R/L	3-../471 R/L	T 205	T 5120
	3,00	9,5	9,5	20310 R/L	KA3 R/L	320....	T 205	T 5120
	4,00	11,5	11,5	20412 R/L	KA4 R/L	422....	T 205	T 5120
	5,00	14,5	14,5	20515 R/L	KA5 R/L	525....	T 205	T 5120
	6,00	19,5	19,5	20620 R/L	KA6 R/L	630....	T 205	T 5120
	3,00	16,0	18,5	UT316 R/L	KT3 R/L	320....	T 205	T 5120
	4,00	19,0	21,5	UT419 R/L	KT4 R/L	422....	T 205	T 5120
	5,00	22,0	24,5	UT522 R/L	KT5 R/L	525....	T 205	T 5120
313232 R/L	8,00	18,0	18,0	30817 R/L	KAK8 R/L	838....	T 206	T 5120
	10,00	26,0	26,0	31025 R/L	KAK10 R/L	1046....	T 206	T 5120
	8,00	32,5	32,5	UT832 R/L	KA8 R/L	838....	T 206	T 5120
	10,00	40,5	40,5	UT1040 R/L	KA10 R/L	1046....	T 206	T 5120

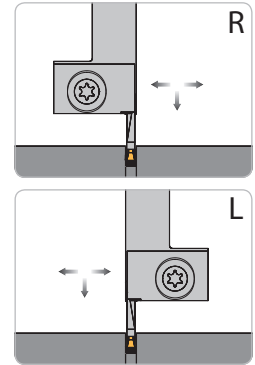
ET₂ = Stechtiefe kann auf Maß „ET₂“ erhöht werden.
ET₂ = Grooving depth can be increased to measure "ET₂".

ET₂ = La profondità di scanalatura può essere aumentata alla dimensione "ET₂".

Achtung: Schwerverspannklemme für NC-Stechdrehen, bei unterbrochenen Schnitten oder Vibrationen, siehe Seite 104.
Attention: Heavy duty clamp for NC-Groove turning, at interrupted cuts or vibrations, please refer to page 104.
Attenzione: Staffa a serraggio rinforzata, per taglio interrotto o in caso di vibrazioni, vedere pagina 104.

Grundhalter werden mit Schrauben und Schlüsseln geliefert, jedoch ohne U-Platte und Klemme.
Basic holders will be supplied with screws and key, however without support blade and clamp.
Gli steli sono forniti completi di viti e una chiave ma senza staffa e lama.

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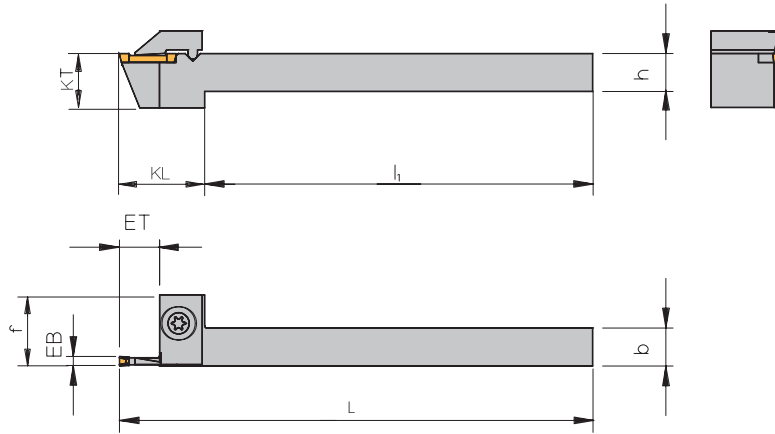
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Right-hand execution shown
Versione destra in figura

Radial-Stechdrehen gerade

Radial groove turning straight

Utensile dritto – Scanalatura e copiatura radiale

Für Langdrehautomaten / For auto lathes / Per torni a fantina mobile



Grundhalter / Basic holder / Corpo utensile

Bezeichnung Designation Articolo	h	b	L	l ₁	f
70808-2 R/L	8	8	100	82	15
71010-2 R/L	10	10	100	82	15
71212-2 R/L	12	12	100	82	15
71616-2 R/L	16	16	100	82	16
70808-3 R/L	8	8	100	82	15
71010-3 R/L	10	10	100	82	15
71212-3 R/L	12	12	100	82	15
71616-3 R/L	16	16	100	82	16

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	KL	KT	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
70808-2 R/L	2	8	18	12	KAM2 R/L	212...	T 154	KS 1111
71010-2 R/L	2	8	18	12	KAM2 R/L	212...	T 154	KS 1111
71212-2 R/L	2	8	18	12	KAM2 R/L	212...	T 154	KS 1111
71616-2 R/L	2	8	18	16	KAM2 R/L	212...	T 154	KS 1111
70808-3 R/L	3	8	18	12	KAML3 R/L	316...	T 154	KS 1111
71010-3 R/L	3	8	18	12	KAML3 R/L	316...	T 154	KS 1111
71212-3 R/L	3	8	18	12	KAML3 R/L	316...	T 154	KS 1111
71616-3 R/L	3	8	18	16	KAML3 R/L	316...	T 154	KS 1111

Grundhalter werden mit Schrauben und Schlüssel geliefert, jedoch ohne U-Platte und Klemme.
Basic holders will be supplied with screws and key, however without support blade and clamp.
Gli steli sono forniti completi di viti e una chiave ma senza staffa e lama.

Hinweis: Grundhalter muss in axialer Richtung an der Werkzeugaufnahme anliegen!
Remark: Basic holder must be adapted in axial direction on to the work holding tool!
Nota: L'utensile base deve essere montato in direzione assiale sull'attacco!

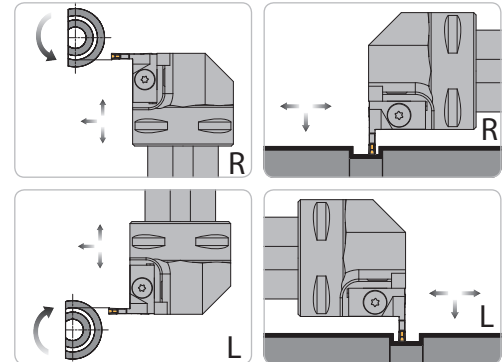
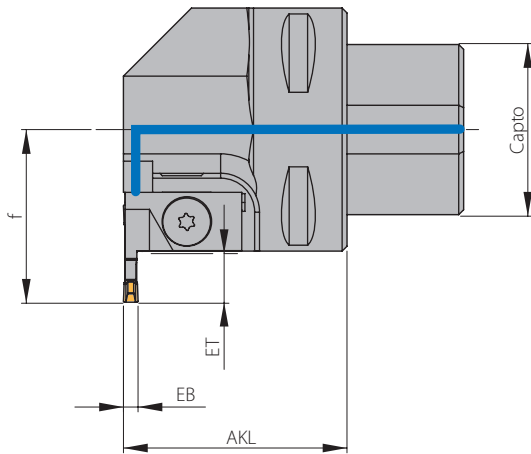
Basic holders and accessories
Corpo utensili e accessori

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Stechdrehen – Axial und Radial
Groove turning – axial and radial
Scanalatura e copiatura assiale e radiale

mit IK
with ic
con ic

Seite
Page
Pagina
152–164



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Right-hand execution shown
Versione destra in figura

Grundhalter / Basic holder / Corpo utensile

Bezeichnung Designation Articolo	EB	H	AKL	f	Capto	Kühlmitteldüse Coolant jet Ugello lubrorefrigerante	Schraube Kühlmitteldüse Screw for coolant jet Vite ugello lubrorefrigerante
C5-2-3RA-R/L	0,5 – 3	25	46	25	C5	KMD0519	AS0020
C5-3-6RA-R/L*	3 – 6	25	46	25	C5	KMD0818	AS0020
C6-3-6RA-R/L*	3 – 6	32	52	32	C6	KMD0818	AS0020
C8-3-6RA-R/L*	3 – 6	41	62	41	C8	KMD0818	AS0020

*Bei Stechbreite 6 mm -> Maß „f“ + 0,5 mm
*For width of cut 6 mm -> Dimension “f” + 0.5 mm
*Per larghezza di taglio di 6 mm -> Dimensione “f” + 0,5 mm

Bitte beachten: Rechter Halter -> Linkes Zubehör / Linker Halter -> Rechtes Zubehör
Please note: Holder right-hand-design -> Left-hand spare parts / Holder left-hand-design -> Right-hand spare parts
Notare: Stelo destro -> accessori sinistri / Stelo sinistro -> accessori destri

Hinweis: Es passen alle Zubehörteile aus dem Standard-Programm „Axial-Stechdrehen – Kontra Ausführung“ Seite 123 – 124 und „Axial-Stechdrehen“ Seite 109 – 111.
Remark: Toolholder is suitable for all spare parts from the standard programme “Axial groove turning – Contra” page 123 – 124 and “Axial groove turning” page 109 – 111.
Nota: l’utensile è compatibile con tutti i ricambi del programma standard “Scanalatura assiale esecuzione Kontra” pagina 123 – 124 e “Scanalatura assiale” pagina 109 – 111.

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	ET ₂	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
C5-2-3RA-R/L	0,5 – 1,85	= EB	= EB	UA2/471 R/L	KAM2 R/L	2-../471 R/L	T 154	KS 1111
	0,5 – 3,08	= EB	= EB	UA3/471 R/L	KAM3 R/L	3M-../471 R/L	T 154	KS 1111
	2,00	8,0	8,0	10208 R/L	KAM2 R/L	212....	T 154	KS 1111
	3,00	12,0	12,0	10312 R/L	KAM3 R/L	316....	T 154	KS 1111
C5-3-6RA-R/L C6-3-6RA-R/L C8-3-6RA-R/L	0,5 – 3,08	= EB	= EB	UA471 R/L	KA3 R/L	3-../471 R/L	T 205	T 5120
	3,00	9,5	9,5	20310 R/L	KA3 R/L	320....	T 205	T 5120
	4,00	11,5	11,5	20412 R/L	KA4 R/L	422....	T 205	T 5120
	5,00	14,5	14,5	20515 R/L	KA5 R/L	525....	T 205	T 5120
	6,00	19,5	19,5	20620 R/L	KA6 R/L	630....	T 205	T 5120
	3,00	16,0	18,5	UT316 R/L	KT3 R/L	320....	T 205	T 5120
	4,00	19,0	21,5	UT419 R/L	KT4 R/L	422....	T 205	T 5120
	5,00	22,0	24,5	UT522 R/L	KT5 R/L	525....	T 205	T 5120
6,00	27,0	29,5	UT627 R/L	KT6 R/L	630....	T 205	T 5120	

ET₂ = Stechtiefe kann auf Maß „ET₂“ erhöht werden.
ET₂ = Grooving depth can be increased to measure “ET₂”.
ET₂ = La profondità di scanalatura può essere aumentata alla dimensione “ET₂”.
Grundhalter werden mit Schrauben und Schlüssel geliefert, jedoch ohne U-Platte und Klemme.
Basic holders will be supplied with screws and key, however without support blade and clamp.
Gli steli sono forniti completi di viti e una chiave ma senza staffa e lama.

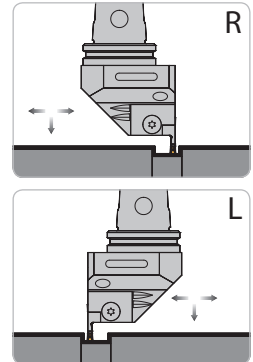
Achtung: Schwere Spannklemme für NC-Stechdrehen, bei unterbrochenen Schnitten oder Vibrationen, siehe Seite 104.
Attention: Heavy duty clamp for NC-Groove turning, at interrupted cuts or vibrations, please refer to page 104.
Attenzione: Staffa a serraggio rinforzata, per taglio interrotto o in caso di vibrazioni, vedere pagina 104.

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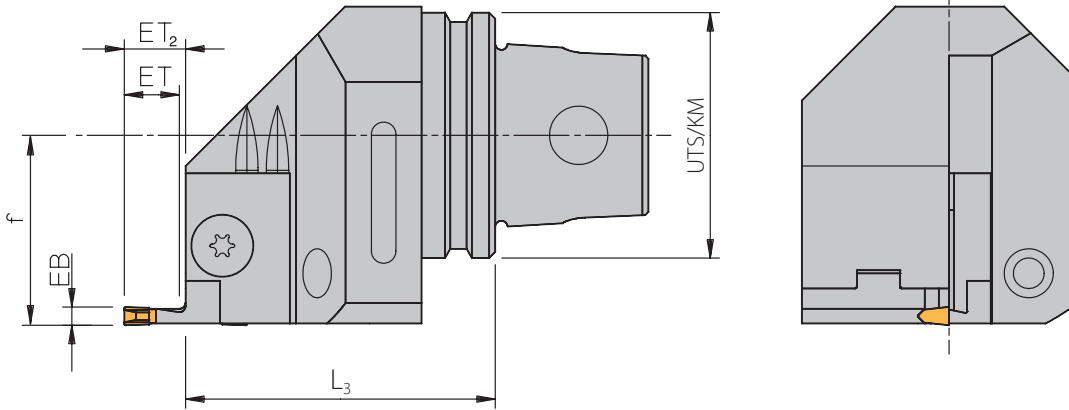
Radial-Stechdrehen

Radial groove turning

Scanalatura e copiatura radiale



Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura



2

Grundhalter / Basic holder / Corpo utensile

Bezeichnung Designation Articolo	UTS/KM	f	L ₃
UT32-2-3 R/L	32	25,0	40,0
UT32-3-6 R/L*	32	25,0	45,0
UT40-3-6 R/L*	40	31,0	50,5
UT50-2-3 R*	50	25,0	45,0
UT50-3-6 R/L*	50	36,0	56,0
UT63-3-6 R/L*	63	42,0	57,0
UT63-8-10 R*	63	41,5	67,0

*Bei Stechbreite 6 mm -> Maß „f“ + 0,5 mm
*For width of cut 6 mm -> Dimension "f" + 0.5 mm
*Per larghezza di taglio di 6 mm -> Dimensione "f" + 0,5 mm

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	ET ₂	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
UT32-2-3 R/L UT50-2-3 R	0,5 - 1,85	= EB	= EB	UA2/471 R/L	KAM2 R/L	2-../471 R/L	T 154	KS 1111
	0,5 - 3,08	= EB	= EB	UA3/471 R/L	KAM3 R/L	3M-../471 R/L	T 154	KS 1111
	2,00	8,0	8,0	10208 R/L	KAM2 R/L	212....	T 154	KS 1111
	3,00	12,0	12,0	10312 R/L	KAM3 R/L	316....	T 154	KS 1111
UT32-3-6 R/L UT40-3-6 R/L UT50-3-6 R/L UT63-3-6 R/L	0,5 - 3,08	= EB	= EB	UA471 R/L	KA3 R/L	3-../471 R/L	T 205	T 5120
	3,00	9,5	9,5	20310 R/L	KA3 R/L	320....	T 205	T 5120
	4,00	11,5	11,5	20412 R/L	KA4 R/L	422....	T 205	T 5120
	5,00	14,5	14,5	20515 R/L	KA5 R/L	525....	T 205	T 5120
	6,00	19,5	19,5	20620 R/L	KA6 R/L	630....	T 205	T 5120
	3,00	16,0	18,5	UT316 R/L	KT3 R/L	320....	T 205	T 5120
	4,00	19,0	21,5	UT419 R/L	KT4 R/L	422....	T 205	T 5120
	5,00	22,0	24,5	UT522 R/L	KT5 R/L	525....	T 205	T 5120
6,00	27,0	29,5	UT627 R/L	KT6 R/L	630....	T 205	T 5120	
UT63-8-10 R	8,00	18,0	18,0	30817 R/L	KAK8 R/L	838....	T 206	T 5120
	10,00	26,0	26,0	31025 R/L	KAK10 R/L	1046....	T 206	T 5120
	8,00	32,5	32,5	UT 832 R/L	KA8 R/L	838....	T 206	T 5120
	10,00	40,5	40,5	UT 1040 R/L	KA10 R/L	1046....	T 206	T 5120

ET₂ = Stechtiefe kann auf Maß „ET₂“ erhöht werden.
ET₂ = Grooving depth can be increased to measure "ET₂".
ET₂ = La profondità di scanalatura può essere aumentata alla dimensione "ET₂".

Grundhalter werden mit Schrauben und Schlüsseln geliefert, jedoch ohne U-Platte und Klemme.
Basic holders will be supplied with screws and key, however without support blade and clamp.
Gli steli sono forniti completi di viti e una chiave ma senza staffa e lama.

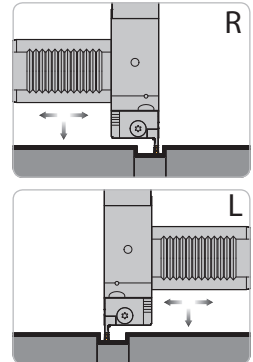
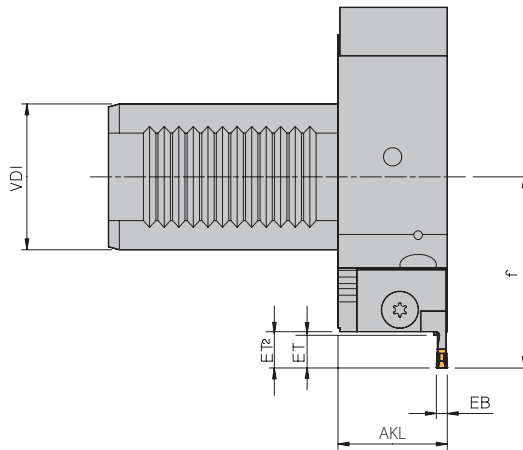
Achtung: Schwerverspannklemme für NC-Stechdrehen, bei unterbrochenen Schnitten oder Vibrationen, siehe Seite 104.
Attention: Heavy duty clamp for NC-Groove turning, at interrupted cuts or vibrations, please refer to page 104.
Attenzione: Staffa a serraggio rinforzata, per taglio interrotto o in caso di vibrazioni, vedere pagina 104.

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Radial-Stechdrehen

Radial groove turning

Scanalatura e copiatura radiale



Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

Grundhalter / Basic holder / Corpo utensile

Bezeichnung Designation Articolo	VDI	AKL	f
VDI30RA-R/L 7	30	30	35,0
VDI40RA-R/L 7	40	30	42,5
VDI50RA-R/L 7	50	30	45,0
VDI60RA-R/L 7	60	40	52,5
VDI40RA-R/L 3*	40	30	45,0
VDI50RA-R/L 3*	50	30	50,0
VDI60RA-R/L 3*	60	40	55,0

*Bei Stechbreite 6 mm -> Maß „AKL“ + 0,5 mm
*For width of cut 6 mm -> Dimension „AKL“ + 0,5 mm
*Per larghezza di taglio di 6 mm -> Dimensione „AKL“ + 0,5 mm

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	ET ₂	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
VDI30RA-R/L 7 VDI40RA-R/L 7 VDI50RA-R/L 7 VDI60RA-R/L 7	0,5 – 3,08	= EB	= EB	UA 471 R/L	KA3 R/L	3-../471 R/L	T 205	T 5120
	3,00	9,5	9,5	20310 R/L	KA3 R/L	320....	T 205	T 5120
	4,00	11,5	11,5	20412 R/L	KA4 R/L	422....	T 205	T 5120
	5,00	14,5	14,5	20515 R/L	KA5 R/L	525....	T 205	T 5120
	6,00	19,5	19,5	20620 R/L	KA6 R/L	630....	T 205	T 5120
	3,00	16,0	18,5	UT 316 R/L	KT3 R/L	320....	T 205	T 5120
	4,00	19,0	21,5	UT 419 R/L	KT4 R/L	422....	T 205	T 5120
	5,00	22,0	24,5	UT 522 R/L	KT5 R/L	525....	T 205	T 5120
VDI40RA-R/L 3 VDI50RA-R/L 3 VDI60RA-R/L 3	8,00	18,0	18,0	30817 R/L	KAK8 R/L	838....	T 206	T 5120
	10,00	26,0	26,0	31025 R/L	KAK10 R/L	1046....	T 206	T 5120
	8,00	32,5	32,5	UT 832 R/L	KA8 R/L	838....	T 206	T 5120
	10,00	40,5	40,5	UT 1040 R/L	KA10 R/L	1046....	T 206	T 5120

ET₂ = Stechtiefe kann auf Maß „ET₂“ erhöht werden.
ET₂ = Grooving depth can be increased to measure “ET₂”.
ET₂ = La profondità di scanalatura può essere aumentata alla dimensione “ET₂”.

Grundhalter werden mit Schrauben und Schlüssel geliefert, jedoch ohne U-Platte und Klemme.
Basic holders will be supplied with screws and key, however without support blade and clamp.
Gli steli sono forniti completi di viti e una chiave ma senza staffa e lama.

Achtung: Schwerverspannklemme für NC-Stechdrehen, bei unterbrochenen Schnitten oder Vibrationen, siehe Seite 104.
Attention: Heavy duty clamp for NC-Groove turning, at interrupted cuts or vibrations, please refer to page 104.
Attenzione: Staffa a serraggio rinforzata, per taglio interrotto o in caso di vibrazioni, vedere pagina 104.

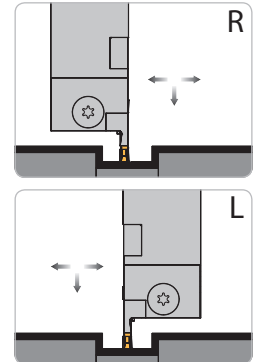
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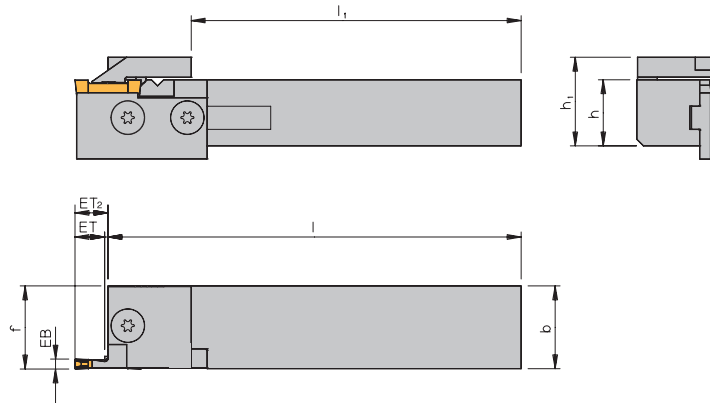
Schwerspannklemme

Heavy duty clamp

Staffa di serraggio rinforzata



Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura



Grundhalter / Basic holder / Corpo utensile

Bezeichnung Designation Articolo	h	b	l	h ₁	l ₁	f
72025 R/L*	20	25	125	27	108	25
72525 R/L*	25	25	150	32	133	25
73225 R/L*	32	25	170	39	153	25
373232 R/L	32	32	170	40	145	33

*Bei Stechbreite 6 mm -> f = b + 0,5; übrige Stechbreiten f = b

*For width of cut 6 mm -> f = b + 0.5; for all others f = b

*Per larghezza di taglio di 6 mm -> f = b + 0,5; altre larghezze f = b

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	ET ₂	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
72025 R/L 72525 R/L 73225 R/L	3,00	9,5	9,5	20310 R/L	KAS3 R/L	320....	T 205	T 5120
	4,00	11,5	11,5	20412 R/L	KAS4 R/L	422....	T 205	T 5120
	5,00	14,5	14,5	20515 R/L	KAS5 R/L	525....	T 205	T 5120
	6,00	19,5	19,5	20620 R/L	KAS6 R/L	630....	T 205	T 5120
	3,00	16,0	18,5	UT 316 R/L	KTS3 R/L	320....	T 205	T 5120
	4,00	19,0	21,5	UT 419 R/L	KTS4 R/L	422....	T 205	T 5120
	5,00	22,0	24,5	UT 522 R/L	KTS5 R/L	525....	T 205	T 5120
373232 R/L	6,00	27,0	29,5	UT 627 R/L	KTS6 R/L	630....	T 205	T 5120
	8,00	18,0	18,0	30817 R/L	KAS8 R/L	838....	T 206	T 5120
	10,00	26,0	26,0	31025 R/L	KAS10 R/L	1046....	T 206	T 5120
	8,00	32,5	32,5	UT 832 R/L	KTS8 R/L	838....	T 206	T 5120
	10,00	40,5	40,5	UT 1040 R/L	KTS10 R/L	1046....	T 206	T 5120

ET₂ = Stechtiefe kann auf Maß „ET₂“ erhöht werden.

ET₂ = Grooving depth can be increased to measure "ET₂".

ET₂ = La profondità di scanalatura può essere aumentata alla dimensione "ET₂".

Grundhalter werden mit Schrauben und Schlüssel geliefert, jedoch ohne U-Platte und Klemme.

Basic holders will be supplied with screws and key, however without support blade and clamp.

Gli steli sono forniti completi di viti e una chiave ma senza staffa e lama.

Achtung: Schwerverspannklemme kann nur bei Grundhaltern mit zweiter Nut auf der Spannfläche eingesetzt werden.

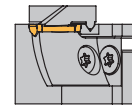
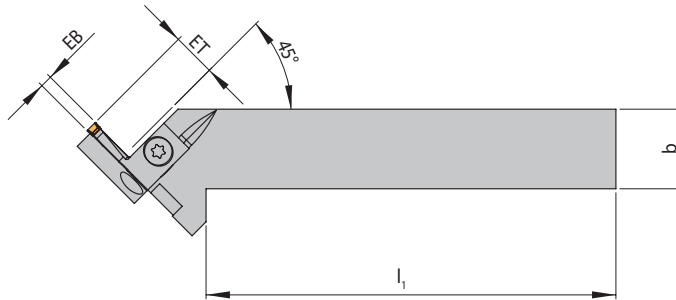
Attention: Heavy duty clamp can only be used with basic holders with two grooves.

Attenzione: Staffa di serraggio rinforzata può solo essere utilizzata su un corpo utensile a due scanalature.

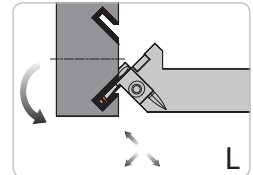
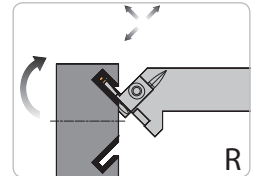
Stechdrehen – 45°

Groove turning – 45°

Scanalatura e copiatura – 45°



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Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

Grundhalter / Basic holder / Corpo utensile

Bezeichnung Designation Articolo	b	h	l ₁
452020 R/L	20	20	103

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

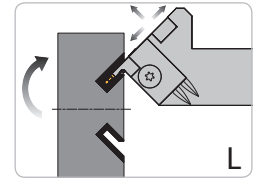
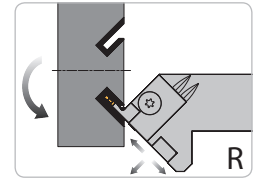
Grundhalter Basic holder Corpo utensile	EB	ET	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
452020 R/L	2	8	102... R/L	KAM2 R/L	212....	T 154	KS 1111
	3	12	103... R/L	KAM3 R/L	316....	T 154	KS 1111

Hinweis: Es passen alle Zubehöerteile aus dem Standard-Programm „Axial-Stechdrehen“ Seite 109.
Achtung: Unterstützplatten immer die nächstgrößere Ausführung bezogen auf den Nut-Außendurchmesser (DA) wählen
z.B.: EB = 3 mm, ET = 12 mm, DA = 67 mm, rechts wählen Sie: 103 - 75100R

Remark: Toolholders are suitable for all spare parts from the standard programme "Axial groove turning" page 109.
Attention: Please select always the next larger range of diameter referring to your OD of groove (DA)
e.g. EB = 3 mm, ET = 12 mm, DA = 67 mm, on the right select: 103 - 75100R

Nota: L'utensile standard può montare tutti gli accessori del programma "Scanalatura Assiale" pagina 109.
Attenzione: Scegliere sempre la misura del diametro successiva riferita al vostro diam. di scanalatura (DA)
p.es. EB = 3 mm, ET = 12 mm, DA = 67 mm, scelta corretta: 103 - 75100R

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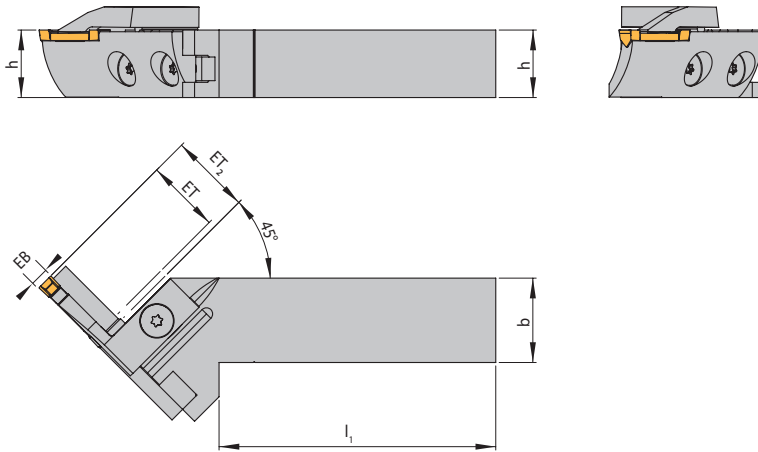


Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

Stechdrehen – 45°

Groove turning – 45°

Scanalatura e copiatura – 45°



Grundhalter / Basic holder / Corpo utensile

Bezeichnung Designation Articolo	b	h	l ₁
452025 R/L	25	20	82
452525 R/L	25	25	82

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	ET ₂	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
452025 R/L 452525 R/L	3	9,5	9,5	203... R/L	KA3 R/L	320...	T 205	T 5120
	3	16,0	18,5	UT3... R/L	KT3 R/L	320...	T 205	T 5120
	4	11,5	11,5	204... R/L	KA4 R/L	422...	T 205	T 5120
	4	19,0	21,5	UT4... R/L	KT4 R/L	422...	T 205	T 5120
	5	14,5	14,5	205... R/L	KA5 R/L	525...	T 205	T 5120
	5	22,0	24,5	UT5... R/L	KT5 R/L	525...	T 205	T 5120
	6	19,5	19,5	206... R/L	KA6 R/L	630...	T 205	T 5120
	6	27,0	29,5	UT6... R/L	KT6 R/L	630...	T 205	T 5120

ET₂ = Stechtiefe kann auf Maß „ET₂“ erhöht werden.
ET₂ = Grooving depth can be increased to measure "ET₂".
ET₂ = La profondità di scanalatura può essere aumentata alla dimensione "ET₂".

Hinweis: Es passen alle Zubehörteile aus dem Standard-Programm „Axial-Stechdrehen“ Seite 110.
Achtung: Unterstützplatten immer die nächstgrößere Ausführung bezogen auf den Nut-Außendurchmesser (DA) wählen
z. B.: EB = 3 mm, ET = 12 mm, DA = 67 mm, rechts wählen Sie: 103 - 75100R

Remark: Toolholders are suitable for all spare parts from the standard programme "Axial groove turning" page 110.
Attention: Please select always the next larger range of diameter referring to your OD of groove (DA)
e.g. EB = 3 mm, ET = 12 mm, DA = 67 mm, on the right select: 103 - 75100R

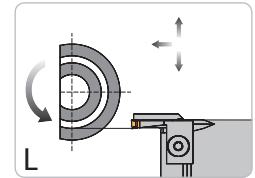
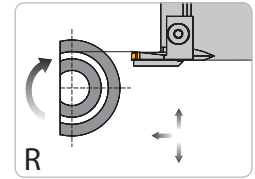
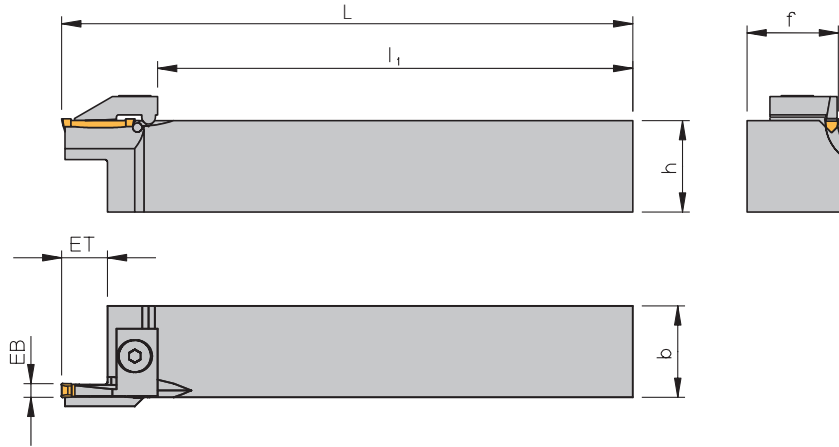
Nota: L'utensile standard può montare tutti gli accessori del programma "Scanalatura Assiale" pagina 110.
Attenzione: Scegliere sempre la misura del diametro successiva riferita al vostro diam. di scanalatura (DA)
p. es. EB = 3 mm, ET = 12 mm, DA = 67 mm, scelta corretta: 103 - 75100R

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Axial-Stechedrehen gerade – Ø 15 – 25 mm

Axial groove turning straight – Ø 15 – 25 mm

Utensile dritto – Scanalatura e copiatura assiale – Ø 15 – 25 mm



Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura



Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Bezeichnung Designation Articolo	Nut-Außen-Ø OD of groove Ø est. di gola	EB	ET	h	b	L	l ₁	f	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
71216-2-1520 R/L	15 – 20	2	6	12	16	90	73	16	KAM2 R/L	212....	T 154	KS 1111
71216-2-2025 R/L	20 – 25	2	6	12	16	90	73	16	KAM2 R/L	212....	T 154	KS 1111
71616-2-1520 R/L	15 – 20	2	6	16	16	110	93	16	KAM2 R/L	212....	T 154	KS 1111
71616-2-2025 R/L	20 – 25	2	6	16	16	110	93	16	KAM2 R/L	212....	T 154	KS 1111
72020-2-1520 R/L	15 – 20	2	6	20	20	125	108	20	KAM2 R/L	212....	T 154	KS 1111
72020-2-2025 R/L	20 – 25	2	6	20	20	125	108	20	KAM2 R/L	212....	T 154	KS 1111
71216-3-1520 R/L	15 – 20	3	9	12	16	90	69	16	KAM3 R/L	316....	T 154	KS 1111
71216-3-2025 R/L	20 – 25	3	9	12	16	90	69	16	KAM3 R/L	316....	T 154	KS 1111
71616-3-1520 R/L	15 – 20	3	9	16	16	110	89	16	KAM3 R/L	316....	T 154	KS 1111
71616-3-2025 R/L	20 – 25	3	9	16	16	110	89	16	KAM3 R/L	316....	T 154	KS 1111
72020-3-1520 R/L	15 – 20	3	9	20	20	125	104	20	KAM3 R/L	316....	T 154	KS 1111
72020-3-2025 R/L	20 – 25	3	9	20	20	125	104	20	KAM3 R/L	316....	T 154	KS 1111

Achtung: Diese Werkzeuge nur nach der Schafthöhe (Maß „h“) ausrichten, da die Schneidkante über der Drehmitte liegt!
Attention: These tools should be set up according to dimension "h" (shank-height), because the cutting edge is above centre height!
Attenzione: Questi utensili devono essere montati secondo l'altezza "h" del gambo, perchè il tagliente è sopra l'altezza del centro!

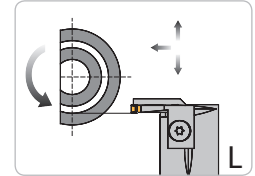
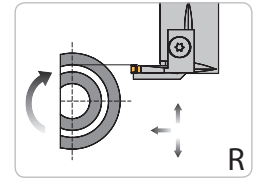
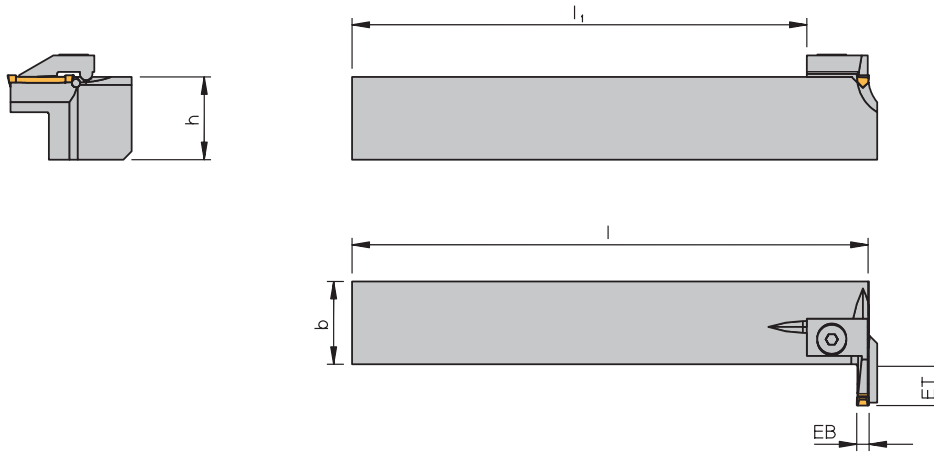
Grundhalter werden mit Schrauben und Schlüssel geliefert, jedoch ohne U-Platte und Klemme.
Basic holders will be supplied with screws and key, however without support blade and clamp.
Gli steli sono forniti completi di viti e una chiave ma senza staffa e lama.

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Axial-Stechdrehen abgesetzt – Ø 15 – 25 mm

Axial groove turning cranked – Ø 15 – 25 mm

Utensile inclinato – Scanalatura e copiatura assiale – Ø 15 – 25 mm



Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Bezeichnung Designation Articolo	Nut-Außen-Ø OD of groove Ø est. di gola	EB	ET	h	b	l	l ₁	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
11616-2-1520 R/L	15 – 20	2	6	16	16	110	93	KAM2 R/L	212....	T 154	KS 1111
11616-2-2025 R/L	20 – 25	2	6	16	16	110	93	KAM2 R/L	212....	T 154	KS 1111
12020-2-1520 R/L	15 – 20	2	6	20	20	125	108	KAM2 R/L	212....	T 154	KS 1111
12020-2-2025 R/L	20 – 25	2	6	20	20	125	108	KAM2 R/L	212....	T 154	KS 1111
11616-3-1520 R/L	15 – 20	3	9	16	16	110	93	KAM3 R/L	316....	T 154	KS 1111
11616-3-2025 R/L	20 – 25	3	9	16	16	110	93	KAM3 R/L	316....	T 154	KS 1111
12020-3-1520 R/L	15 – 20	3	9	20	20	125	108	KAM3 R/L	316....	T 154	KS 1111
12020-3-2025 R/L	20 – 25	3	9	20	20	125	108	KAM3 R/L	316....	T 154	KS 1111

Achtung: Diese Werkzeuge nur nach der Schafthöhe (Maß „h“) ausrichten, da die Schneidkante über der Drehmitte liegt!
Attention: These tools should be set up according to dimension "h" (shank-height), because the cutting edge is above centre height!
Attenzione: Questi utensili devono essere montati secondo l'altezza "h" del gambo, perchè il tagliente è sopra l'altezza del centro!

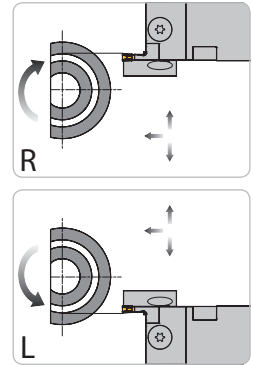
Grundhalter werden mit Schrauben und Schlüssel geliefert, jedoch ohne U-Platte und Klemme.
Basic holders will be supplied with screws and key, however without support blade and clamp.
Gli steli sono forniti completi di viti e una chiave ma senza staffa e lama.

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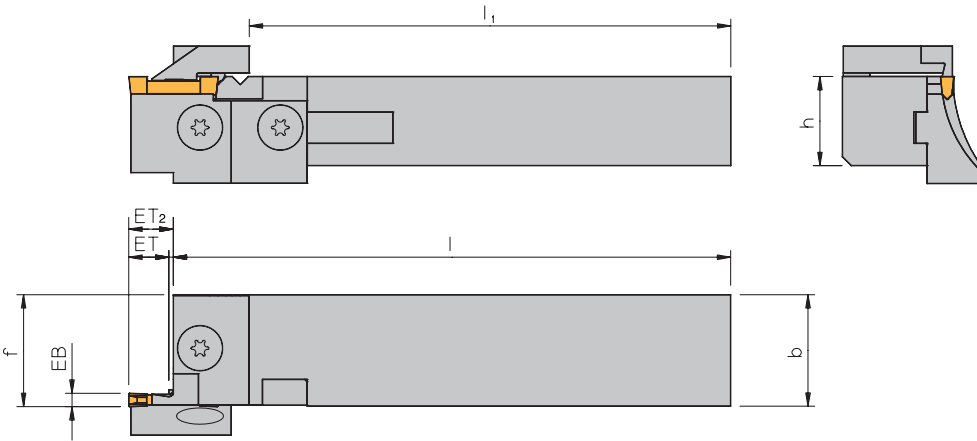
Axial-Stechdrehen gerade

Axial groove turning straight

Utensile dritto – Scanalatura e copiatura assiale



Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura



Grundhalter / Basic holder / Corpo utensile

Bezeichnung Designation Articolo	h	b	l	l ₁	f
71216 R/L	12	16	90	81	16
71616 R/L	16	16	110	101	16
72020 R/L	20	20	125	116	20
72525 R/L-M	25	25	150	141	25
72025 R/L*	20	25	125	113	25
72525 R/L*	25	25	150	138	25
73225 R/L*	32	25	170	158	25
373232 R/L	32	32	170	145	33

*Bei Stechbreite 6 mm -> f = b + 0,5; übrige Stechbreiten f = b
*For width of cut 6 mm -> f = b + 0.5; for all others f = b
*Per larghezza di taglio di 6 mm -> f = b + 0,5; altre larghezze f = b

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	ET ₂	Nut-Außen-Ø OD of groove Ø est. di gola	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
71216 R/L 71616 R/L 72020 R/L 72525 R/L-M	2	8,0	8,0	25 – 30	102-2530 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	30 – 40	102-3040 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	40 – 50	102-4050 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	50 – 60	102-5060 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	60 – 75	102-6075 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	75 – 100	102-75100 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	100 – 150	102-100150 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	150 – 300	102-150300 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	300 – 500	102-300500 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	500 – ∞	10208 R/L*	KAM2 R/L	212....	T 154	KS 1111
	3	12,0	12,0	25 – 30	103-2530 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	30 – 40	103-3040 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	40 – 50	103-4050 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	50 – 60	103-5060 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	60 – 75	103-6075 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	75 – 100	103-75100 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	100 – 150	103-100150 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	150 – 300	103-150300 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	300 – 500	103-300500 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	500 – ∞	10312 R/L*	KAM3 R/L	316....	T 154	KS 1111

*Nacharbeit für Durchmesserbereich erforderlich!
*Minimum retouching work required!
*Potrebbe essere necessaria leggera modifica!

Weiteres Zubehör auf der nächsten Seite
More accessories next page
Altri accessori nella pagina seguente

We have a passion for precision.

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	ET ₂	Nut-Außen-Ø OD of groove Ø est. di gola	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
72025 R/L 72525 R/L 73225 R/L	3	9,5	9,5	50 – 60	203-5060 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	60 – 75	203-6075 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	75 – 100	203-75100 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	100 – 150	203-100150 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	150 – 300	203-150300 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	300 – 500	203-300500 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	500 – ∞	203-500XX R/L	KA3 R/L	320....	T 205	T 5120
	3	16,0	18,5	50 – 60	UT3-5060 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	60 – 75	UT3-6075 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	75 – 100	UT3-75100 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	100 – 150	UT3-100150 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	150 – 300	UT3-150300 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	300 – 500	UT3-300500 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	500 – ∞	UT3-500XX R/L	KT3 R/L	320....	T 205	T 5120
	4	11,5	11,5	50 – 60	204-5060 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	60 – 75	204-6075 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	75 – 100	204-75100 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	100 – 150	204-100150 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	150 – 300	204-150300 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	300 – 500	204-300500 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	500 – ∞	204-500XX R/L	KA4 R/L	422....	T 205	T 5120
	4	19,0	21,5	50 – 60	UT4-5060 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	60 – 75	UT4-6075 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	75 – 100	UT4-75100 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	100 – 150	UT4-100150 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	150 – 300	UT4-150300 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	300 – 500	UT4-300500 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	500 – ∞	UT4-500XX R/L	KT4 R/L	422....	T 205	T 5120
	5	14,5	14,5	50 – 60	205-5060 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	60 – 75	205-6075 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	75 – 100	205-75100 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	100 – 150	205-100150 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	150 – 300	205-150300 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	300 – 500	205-300500 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	500 – ∞	205-500XX R/L	KA5 R/L	525....	T 205	T 5120
	5	22,0	24,5	50 – 60	UT5-5060 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	60 – 75	UT5-6075 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	75 – 100	UT5-75100 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	100 – 150	UT5-100150 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	150 – 300	UT5-150300 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	300 – 500	UT5-300500 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	500 – ∞	UT5-500XX R/L	KT5 R/L	525....	T 205	T 5120
6	19,5	19,5	50 – 60	206-5060 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	60 – 75	206-6075 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	75 – 100	206-75100 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	100 – 150	206-100150 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	150 – 300	206-150300 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	300 – 500	206-300500 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	500 – ∞	206-500XX R/L	KA6 R/L	630....	T 205	T 5120	
6	27,0	29,5	50 – 60	UT6-5060 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	60 – 75	UT6-6075 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	75 – 100	UT6-75100 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	100 – 150	UT6-100150 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	150 – 300	UT6-150300 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	300 – 500	UT6-300500 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	500 – ∞	UT6-500XX R/L	KT6 R/L	630....	T 205	T 5120	

Weiteres Zubehör auf der nächsten Seite
More accessories next page
Altri accessori nella pagina seguente

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Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	ET ₂	Nut-Außen-Ø OD of groove Ø est. di gola	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
373232 R/L	8	17,0	18,0	75 – 100	308-75100 R/L	KAK8 R/L	838....	T 206	T 5120
	8	17,0	18,0	100 – 150	308-100150 R/L	KAK8 R/L	838....	T 206	T 5120
	8	17,0	18,0	150 – 300	308-150300 R/L	KAK8 R/L	838....	T 206	T 5120
	8	17,0	18,0	300 – 500	308-300500 R/L	KAK8 R/L	838....	T 206	T 5120
	8	17,0	18,0	500 – ∞	308-500XX R/L	KAK8 R/L	838....	T 206	T 5120
	8	32,0	32,5	75 – 100	UT8-75100 R/L	KA8 R/L	838....	T 206	T 5120
	8	32,0	32,5	100 – 150	UT8-100150 R/L	KA8 R/L	838....	T 206	T 5120
	8	32,0	32,5	150 – 300	UT8-150300 R/L	KA8 R/L	838....	T 206	T 5120
	8	32,0	32,5	300 – 500	UT8-300500 R/L	KA8 R/L	838....	T 206	T 5120
	8	32,0	32,5	500 – ∞	UT8-500XX R/L	KA8 R/L	838....	T 206	T 5120
	10	25,0	26,0	75 – 100	310-75100 R/L	KAK10 R/L	1046....	T 206	T 5120
	10	25,0	26,0	100 – 150	310-100150 R/L	KAK10 R/L	1046....	T 206	T 5120
	10	25,0	26,0	150 – 300	310-150300 R/L	KAK10 R/L	1046....	T 206	T 5120
	10	25,0	26,0	300 – 500	310-300500 R/L	KAK10 R/L	1046....	T 206	T 5120
	10	25,0	26,0	500 – ∞	310-500XX R/L	KAK10 R/L	1046....	T 206	T 5120
	10	40,0	40,5	75 – 100	UT10-75100 R/L	KA10 R/L	1046....	T 206	T 5120
	10	40,0	40,5	100 – 150	UT10-100150 R/L	KA10 R/L	1046....	T 206	T 5120
	10	40,0	40,5	150 – 300	UT10-150300 R/L	KA10 R/L	1046....	T 206	T 5120
	10	40,0	40,5	300 – 500	UT10-300500 R/L	KA10 R/L	1046....	T 206	T 5120
	10	40,0	40,5	500 – ∞	UT10-500XX R/L	KA10 R/L	1046....	T 206	T 5120

ET₂ = Stechtiefe kann auf Maß „ET₂“ erhöht werden.

ET₂ = Grooving depth can be increased to measure "ET₂".

ET₂ = La profondità di scanalatura può essere aumentata alla dimensione "ET₂".

Grundhalter werden mit Schrauben und Schlüssel geliefert, jedoch ohne U-Platte und Klemme.

Basic holders will be supplied with screws and key, however without support blade and clamp.

Gli steli sono forniti completi di viti e una chiave ma senza staffa e lama.

Achtung: Schwerverspannklemme für NC-Stechdrehen, bei unterbrochenen Schnitten oder Vibrationen, siehe Seite 104.

Attention: Heavy duty clamp for NC-Groove turning, at interrupted cuts or vibrations, please refer to page 104.

Attenzione: Staffa a serraggio rinforzata, per taglio interrotto o in caso di vibrazioni, vedere pagina 104.

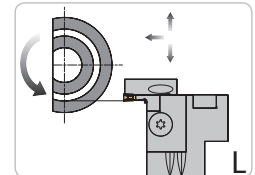
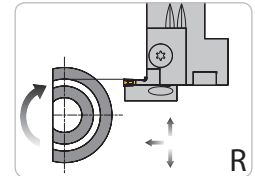
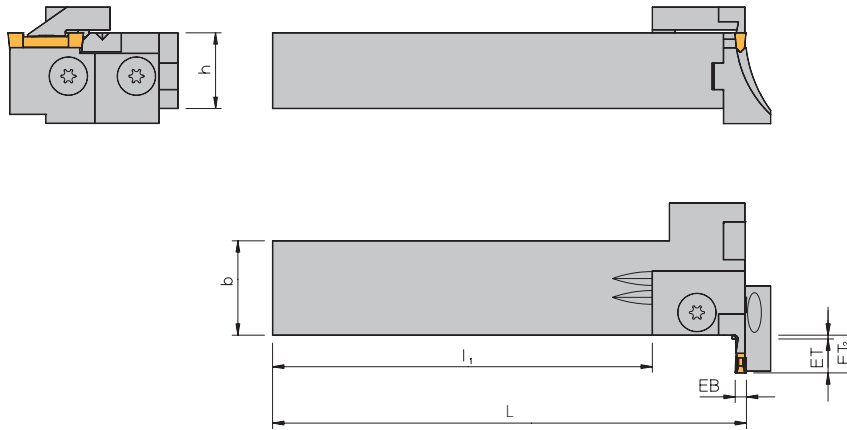
2

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Axial-Stechdrehen abgesetzt

Axial groove turning cranked

Utensile inclinato – Scanalatura e copiatura assiale



Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

2

Grundhalter / Basic holder / Corpo utensile

Bezeichnung Designation Articolo	h	b	L	l ₁
11616 R/L	16	16	110	95
12020 R/L	20	20	125	110
12525 R/L-M	25	25	150	125
12025 R/L	20	25	125	101
12525 R/L	25	25	150	126
13232 R/L	32	32	170	146
313232 R/L	32	32	170	145

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	ET ₂	Nut-Außen-Ø OD of groove Ø est. di gola	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
11616 R/L 12020 R/L 12525 R/L-M	2	8,0	8,0	25 – 30	102-2530 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	30 – 40	102-3040 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	40 – 50	102-4050 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	50 – 60	102-5060 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	60 – 75	102-6075 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	75 – 100	102-75100 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	100 – 150	102-100150 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	150 – 300	102-150300 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	300 – 500	102-300500 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	500 – ∞	10208 R/L*	KAM2 R/L	212....	T 154	KS 1111
	3	12,0	12,0	25 – 30	103-2530 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	30 – 40	103-3040 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	40 – 50	103-4050 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	50 – 60	103-5060 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	60 – 75	103-6075 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	75 – 100	103-75100 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	100 – 150	103-100150 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	150 – 300	103-150300 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	300 – 500	103-300500 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	500 – ∞	10312 R/L*	KAM3 R/L	316....	T 154	KS 1111

*Nacharbeit für Durchmesserbereich erforderlich!
*Minimum retouching work required!
*Potrebbe essere necessaria leggera modifica!

Weiteres Zubehör auf der nächsten Seite
More accessories next page
Altri accessori nella pagina seguente

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Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	ET ₂	Nut-Außen-Ø OD of groove Ø est. di gola	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
12025 R/L 12525 R/L 13232 R/L	3	9,5	9,5	50 – 60	203-5060 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	60 – 75	203-6075 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	75 – 100	203-75100 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	100 – 150	203-100150 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	150 – 300	203-150300 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	300 – 500	203-300500 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	500 – ∞	203-500XX R/L	KA3 R/L	320....	T 205	T 5120
	3	16,0	18,5	50 – 60	UT3-5060 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	60 – 75	UT3-6075 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	75 – 100	UT3-75100 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	100 – 150	UT3-100150 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	150 – 300	UT3-150300 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	300 – 500	UT3-300500 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	500 – ∞	UT3-500XX R/L	KT3 R/L	320....	T 205	T 5120
	4	11,5	11,5	50 – 60	204-5060 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	60 – 75	204-6075 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	75 – 100	204-75100 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	100 – 150	204-100150 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	150 – 300	204-150300 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	300 – 500	204-300500 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	500 – ∞	204-500XX R/L	KA4 R/L	422....	T 205	T 5120
	4	19,0	21,5	50 – 60	UT4-5060 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	60 – 75	UT4-6075 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	75 – 100	UT4-75100 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	100 – 150	UT4-100150 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	150 – 300	UT4-150300 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	300 – 500	UT4-300500 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	500 – ∞	UT4-500XX R/L	KT4 R/L	422....	T 205	T 5120
	5	14,5	14,5	50 – 60	205-5060 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	60 – 75	205-6075 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	75 – 100	205-75100 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	100 – 150	205-100150 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	150 – 300	205-150300 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	300 – 500	205-300500 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	500 – ∞	205-500XX R/L	KA5 R/L	525....	T 205	T 5120
	5	22,0	24,5	50 – 60	UT5-5060 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	60 – 75	UT5-6075 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	75 – 100	UT5-75100 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	100 – 150	UT5-100150 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	150 – 300	UT5-150300 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	300 – 500	UT5-300500 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	500 – ∞	UT5-500XX R/L	KT5 R/L	525....	T 205	T 5120
6	19,5	19,5	50 – 60	206-5060 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	60 – 75	206-6075 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	75 – 100	206-75100 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	100 – 150	206-100150 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	150 – 300	206-150300 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	300 – 500	206-300500 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	500 – ∞	206-500XX R/L	KA6 R/L	630....	T 205	T 5120	
6	27,0	29,5	50 – 60	UT6-5060 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	60 – 75	UT6-6075 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	75 – 100	UT6-75100 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	100 – 150	UT6-100150 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	150 – 300	UT6-150300 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	300 – 500	UT6-300500 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	500 – ∞	UT6-500XX R/L	KT6 R/L	630....	T 205	T 5120	

Weiteres Zubehör auf der nächsten Seite
More accessories next page
Altri accessori nella pagina seguente

We have a passion for precision.

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	ET ₂	Nut-Außen-Ø OD of groove Ø est. di gola	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
313232 R/L	8	17,0	18,0	75 – 100	308-75100 R/L	KAK8 R/L	838....	T 206	T 5120
	8	17,0	18,0	100 – 150	308-100150 R/L	KAK8 R/L	838....	T 206	T 5120
	8	17,0	18,0	150 – 300	308-150300 R/L	KAK8 R/L	838....	T 206	T 5120
	8	17,0	18,0	300 – 500	308-300500 R/L	KAK8 R/L	838....	T 206	T 5120
	8	17,0	18,0	500 – ∞	308-500XX R/L	KAK8 R/L	838....	T 206	T 5120
	8	32,0	32,5	75 – 100	UT8-75100 R/L	KA8 R/L	838....	T 206	T 5120
	8	32,0	32,5	100 – 150	UT8-100150 R/L	KA8 R/L	838....	T 206	T 5120
	8	32,0	32,5	150 – 300	UT8-150300 R/L	KA8 R/L	838....	T 206	T 5120
	8	32,0	32,5	300 – 500	UT8-300500 R/L	KA8 R/L	838....	T 206	T 5120
	8	32,0	32,5	500 – ∞	UT8-500XX R/L	KA8 R/L	838....	T 206	T 5120
	10	25,0	26,0	75 – 100	310-75100 R/L	KAK10 R/L	1046....	T 206	T 5120
	10	25,0	26,0	100 – 150	310-100150 R/L	KAK10 R/L	1046....	T 206	T 5120
	10	25,0	26,0	150 – 300	310-150300 R/L	KAK10 R/L	1046....	T 206	T 5120
	10	25,0	26,0	300 – 500	310-300500 R/L	KAK10 R/L	1046....	T 206	T 5120
	10	25,0	26,0	500 – ∞	310-500XX R/L	KAK10 R/L	1046....	T 206	T 5120
	10	40,0	40,5	75 – 100	UT10-75100 R/L	KA10 R/L	1046....	T 206	T 5120
	10	40,0	40,5	100 – 150	UT10-100150 R/L	KA10 R/L	1046....	T 206	T 5120
	10	40,0	40,5	150 – 300	UT10-150300 R/L	KA10 R/L	1046....	T 206	T 5120
	10	40,0	40,5	300 – 500	UT10-300500 R/L	KA10 R/L	1046....	T 206	T 5120
	10	40,0	40,5	500 – ∞	UT10-500XX R/L	KA10 R/L	1046....	T 206	T 5120

ET₂ = Stechtiefe kann auf Maß „ET₂“ erhöht werden.

ET₂ = Grooving depth can be increased to measure "ET₂".

ET₂ = La profondità di scanalatura può essere aumentata alla dimensione "ET₂".

Grundhalter werden mit Schrauben und Schlüssel geliefert, jedoch ohne U-Platte und Klemme.

Basic holders will be supplied with screws and key, however without support blade and clamp.

Gli steli sono forniti completi di viti e una chiave ma senza staffa e lama.

Achtung: Schwerverspannklemme für NC-Stechdrehen, bei unterbrochenen Schnitten oder Vibrationen, siehe Seite 104.

Attention: Heavy duty clamp for NC-Groove turning, at interrupted cuts or vibrations, please refer to page 104.

Attenzione: Staffa a serraggio rinforzata, per taglio interrotto o in caso di vibrazioni, vedere pagina 104.

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Stechdrehen – Axial und Radial

Groove turning – axial and radial

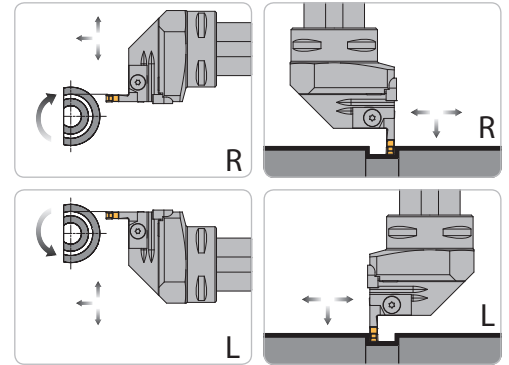
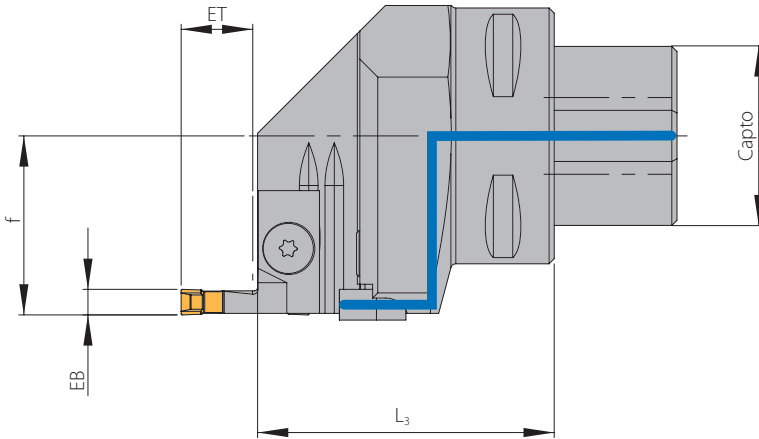
Scanalatura e copiatura assiale e radiale



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Right-hand execution shown
Versione destra in figura

Grundhalter / Basic holder / Corpo utensile

Bezeichnung Designation Articolo	EB	L ₃	f	H	Capto	Kühlmitteldüse Coolant jet Ugello lubrorefrigerante	Schraube Kühlmitteldüse Screw coolant jet Vite ugello lubrorefrigerante
C4 2-3 R/L	2 – 3	45	27	20,5	C4	KMD0519	AS0020
C5 2-3 L	2 – 3	45	35	25,5	C5	KMD0519	AS0020
C6 2-3 R/L	2 – 3	60	45	32,0	C6	KMD0519	AS0020
C4 3-6 R/L*	3 – 6	58	27	24,0	C4	KMD0519	AS0020
C5 3-6 R/L*	3 – 6	58	35	25,0	C5	KMD0818	AS0020
C6 3-6 R/L*	3 – 6	60	45	32,0	C6	KMD0818	AS0020
C8 3-6 L*	3 – 6	80	42	40,5	C8	KMD0818	AS0020

*Bei Stechbreite 6 mm -> Maß „f“ + 0,5 mm
*For width of cut 6 mm -> Dimension “f” + 0.5 mm
*Per larghezza di taglio di 6 mm -> Dimensione “f” + 0,5 mm

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	ET ₂	Nut-Außen-Ø OD of groove Ø est. di gola	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave	
C4 2-3 R/L	2	8,0	8,0	25 – 30	102-2530 R/L	KAM2 R/L	212....	T 154	KS 1111	
	2	8,0	8,0	30 – 40	102-3040 R/L	KAM2 R/L	212....	T 154	KS 1111	
	2	8,0	8,0	40 – 50	102-4050 R/L	KAM2 R/L	212....	T 154	KS 1111	
	2	8,0	8,0	50 – 60	102-5060 R/L	KAM2 R/L	212....	T 154	KS 1111	
	2	8,0	8,0	60 – 75	102-6075 R/L	KAM2 R/L	212....	T 154	KS 1111	
	2	8,0	8,0	75 – 100	102-75100 R/L	KAM2 R/L	212....	T 154	KS 1111	
	2	8,0	8,0	100 – 150	102-100150 R/L	KAM2 R/L	212....	T 154	KS 1111	
	2	8,0	8,0	150 – 300	102-150300 R/L	KAM2 R/L	212....	T 154	KS 1111	
	2	8,0	8,0	300 – 500	102-300500 R/L	KAM2 R/L	212....	T 154	KS 1111	
	2	8,0	8,0	500 – ∞	10208 R/L*	KAM2 R/L	212....	T 154	KS 1111	
	C5 2-3 L	3	12,0	12,0	25 – 30	103-2530 R/L	KAM3 R/L	316....	T 154	KS 1111
		3	12,0	12,0	30 – 40	103-3040 R/L	KAM3 R/L	316....	T 154	KS 1111
		3	12,0	12,0	40 – 50	103-4050 R/L	KAM3 R/L	316....	T 154	KS 1111
		3	12,0	12,0	50 – 60	103-5060 R/L	KAM3 R/L	316....	T 154	KS 1111
		3	12,0	12,0	60 – 75	103-6075 R/L	KAM3 R/L	316....	T 154	KS 1111
		3	12,0	12,0	75 – 100	103-75100 R/L	KAM3 R/L	316....	T 154	KS 1111
		3	12,0	12,0	100 – 150	103-100150 R/L	KAM3 R/L	316....	T 154	KS 1111
		3	12,0	12,0	150 – 300	103-150300 R/L	KAM3 R/L	316....	T 154	KS 1111
3		12,0	12,0	300 – 500	103-300500 R/L	KAM3 R/L	316....	T 154	KS 1111	
C6 2-3 R/L	3	12,0	12,0	500 – ∞	10312 R/L*	KAM3 R/L	316....	T 154	KS 1111	

*Nacharbeit für Durchmesserbereich erforderlich!
*Minimum retouching work required!
*Potrebbe essere necessaria leggera modifica!

Achtung: Schwerverspannklemme für NC-Stechdrehen, bei unterbrochenen Schnitten oder Vibrationen, siehe Seite 104.
Attention: Heavy duty clamp for NC-Groove turning, at interrupted cuts or vibrations, please refer to page 104.
Attenzione: Staffa a serraggio rinforzata, per taglio interrotto o in caso di vibrazioni, vedere pagina 104.

Weiteres Zubehör auf der nächsten Seite
More accessories next page
Altri accessori nella pagina seguente

We have a passion for precision.

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

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Grundhalter Basic holder Corpo utensile	EB	ET	ET ₂	Nut-Außen-Ø OD of groove Ø est. di gola	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
C4 3-6 R/L C5 3-6 R/L C6 3-6 R/L C8 3-6 R/L	3	9,5	9,5	50 – 60	203-5060 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	60 – 75	203-6075 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	75 – 100	203-75100 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	100 – 150	203-100150 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	150 – 300	203-150300 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	300 – 500	203-300500 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	500 – ∞	203-500XX R/L	KA3 R/L	320....	T 205	T 5120
	3	16,0	18,5	50 – 60	UT3-5060 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	60 – 75	UT3-6075 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	75 – 100	UT3-75100 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	100 – 150	UT3-100150 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	150 – 300	UT3-150300 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	300 – 500	UT3-300500 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	500 – ∞	UT3-500XX R/L	KT3 R/L	320....	T 205	T 5120
	4	11,5	11,5	50 – 60	204-5060 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	60 – 75	204-6075 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	75 – 100	204-75100 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	100 – 150	204-100150 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	150 – 300	204-150300 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	300 – 500	204-300500 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	500 – ∞	204-500XX R/L	KA4 R/L	422....	T 205	T 5120
	4	19,0	21,5	50 – 60	UT4-5060 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	60 – 75	UT4-6075 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	75 – 100	UT4-75100 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	100 – 150	UT4-100150 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	150 – 300	UT4-150300 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	300 – 500	UT4-300500 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	500 – ∞	UT4-500XX R/L	KT4 R/L	422....	T 205	T 5120
	5	14,5	14,5	50 – 60	205-5060 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	60 – 75	205-6075 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	75 – 100	205-75100 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	100 – 150	205-100150 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	150 – 300	205-150300 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	300 – 500	205-300500 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	500 – ∞	205-500XX R/L	KA5 R/L	525....	T 205	T 5120
	5	22,0	24,5	50 – 60	UT5-5060 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	60 – 75	UT5-6075 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	75 – 100	UT5-75100 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	100 – 150	UT5-100150 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	150 – 300	UT5-150300 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	300 – 500	UT5-300500 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	500 – ∞	UT5-500XX R/L	KT5 R/L	525....	T 205	T 5120
6	19,5	19,5	50 – 60	206-5060 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	60 – 75	206-6075 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	75 – 100	206-75100 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	100 – 150	206-100150 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	150 – 300	206-150300 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	300 – 500	206-300500 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	500 – ∞	206-500XX R/L	KA6 R/L	630....	T 205	T 5120	
6	27,0	29,5	50 – 60	UT6-5060 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	60 – 75	UT6-6075 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	75 – 100	UT6-75100 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	100 – 150	UT6-100150 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	150 – 300	UT6-150300 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	300 – 500	UT6-300500 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	500 – ∞	UT6-500XX R/L	KT6 R/L	630....	T 205	T 5120	

ET₂ = Stechtiefe kann auf Maß „ET₂“ erhöht werden.
ET₂ = Grooving depth can be increased to measure "ET₂".
ET₂ = La profondità di scanalatura può essere aumentata alla dimensione "ET₂".

Grundhalter werden mit Schrauben und Schlüssel geliefert, jedoch ohne U-Platte und Klemme.
Basic holders will be supplied with screws and key, however without support blade and clamp.
Gli steli sono forniti completi di viti e una chiave ma senza staffa e lama.

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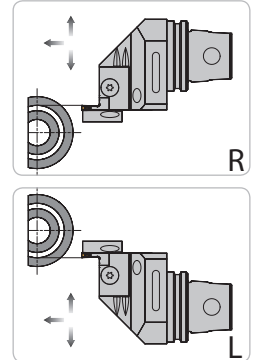
Axial-Stechedrehen

Axial groove turning

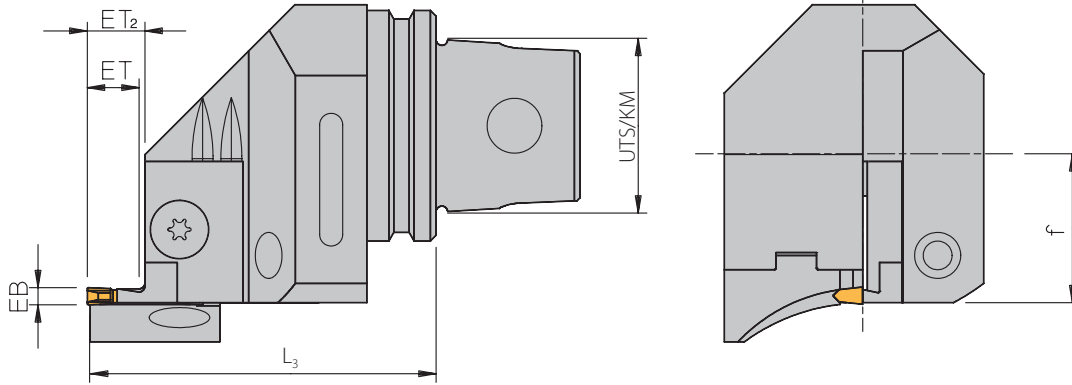
Scanalatura e copiatura assiale

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Right-hand execution shown
Versione destra in figura



Grundhalter / Basic holder / Corpo utensile

Bezeichnung Designation Articolo	UTS/KM	f	L ₃
UT32-2-3 R/L	32	25,0	40,0
UT32-3-6 L*	32	25,0	45,0
UT40-3-6 R/L*	40	31,0	50,5
UT50-2-3 R	50	25,0	45,0
UT50-3-6 R/L*	50	36,0	56,0
UT63-3-6 R/L*	63	42,0	57,0
UT63-8-10 R*	63	41,5	67,0

*Bei Stechbreite 6 mm -> Maß „f“ + 0,5 mm
*For width of cut 6 mm -> Dimension “f” + 0.5 mm
*Per larghezza di taglio di 6 mm -> Dimensione “f” + 0,5 mm

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	ET ₂	Nut-Außen-Ø OD of groove Ø est. di gola	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
UT32-2-3 R/L UT50-2-3 R	2	8,0	8,0	25 – 30	102-2530 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	30 – 40	102-3040 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	40 – 50	102-4050 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	50 – 60	102-5060 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	60 – 75	102-6075 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	75 – 100	102-75100 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	100 – 150	102-100150 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	150 – 300	102-150300 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	300 – 500	102-300500 R/L	KAM2 R/L	212....	T 154	KS 1111
	2	8,0	8,0	500 – ∞	10208 R/L*	KAM2 R/L	212....	T 154	KS 1111
	3	12,0	12,0	25 – 30	103-2530 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	30 – 40	103-3040 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	40 – 50	103-4050 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	50 – 60	103-5060 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	60 – 75	103-6075 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	75 – 100	103-75100 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	100 – 150	103-100150 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	150 – 300	103-150300 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	300 – 500	103-300500 R/L	KAM3 R/L	316....	T 154	KS 1111
	3	12,0	12,0	500 – ∞	10312 R/L*	KAM3 R/L	316....	T 154	KS 1111

*Nacharbeit für Durchmesserbereich erforderlich!
*Minimum retouching work required!
*Potrebbe essere necessaria leggera modifica!

Achtung: Schwerverspannklemme für NC-Stechedrehen, bei unterbrochenen Schnitten oder Vibrationen, siehe Seite 104.
Attention: Heavy duty clamp for NC-Groove turning, at interrupted cuts or vibrations, please refer to page 104.
Attenzione: Staffa a serraggio rinforzata, per taglio interrotto o in caso di vibrazioni, vedere pagina 104.

Weiteres Zubehör auf der nächsten Seite
More accessories next page
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Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

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Grundhalter Basic holder Corpo utensile	EB	ET	ET ₂	Nut-Außen-Ø OD of groove Ø est. di gola	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
UT32 3-6 L UT40 3-6 R/L UT50 3-6 R/L UT63 3-6 R/L	3	9,5	9,5	50 – 60	203-5060 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	60 – 75	203-6075 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	75 – 100	203-75100 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	100 – 150	203-100150 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	150 – 300	203-150300 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	300 – 500	203-300500 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	500 – ∞	203-500XX R/L	KA3 R/L	320....	T 205	T 5120
	3	16,0	18,5	50 – 60	UT3-5060 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	60 – 75	UT3-6075 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	75 – 100	UT3-75100 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	100 – 150	UT3-100150 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	150 – 300	UT3-150300 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	300 – 500	UT3-300500 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	500 – ∞	UT3-500XX R/L	KT3 R/L	320....	T 205	T 5120
	4	11,5	11,5	50 – 60	204-5060 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	60 – 75	204-6075 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	75 – 100	204-75100 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	100 – 150	204-100150 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	150 – 300	204-150300 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	300 – 500	204-300500 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	500 – ∞	204-500XX R/L	KA4 R/L	422....	T 205	T 5120
	4	19,0	21,5	50 – 60	UT4-5060 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	60 – 75	UT4-6075 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	75 – 100	UT4-75100 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	100 – 150	UT4-100150 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	150 – 300	UT4-150300 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	300 – 500	UT4-300500 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	500 – ∞	UT4-500XX R/L	KT4 R/L	422....	T 205	T 5120
	5	14,5	14,5	50 – 60	205-5060 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	60 – 75	205-6075 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	75 – 100	205-75100 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	100 – 150	205-100150 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	150 – 300	205-150300 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	300 – 500	205-300500 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	500 – ∞	205-500XX R/L	KA5 R/L	525....	T 205	T 5120
	5	22,0	24,5	50 – 60	UT5-5060 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	60 – 75	UT5-6075 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	75 – 100	UT5-75100 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	100 – 150	UT5-100150 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	150 – 300	UT5-150300 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	300 – 500	UT5-300500 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	500 – ∞	UT5-500XX R/L	KT5 R/L	525....	T 205	T 5120
6	19,5	19,5	50 – 60	206-5060 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	60 – 75	206-6075 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	75 – 100	206-75100 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	100 – 150	206-100150 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	150 – 300	206-150300 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	300 – 500	206-300500 R/L	KA6 R/L	630....	T 205	T 5120	
6	19,5	19,5	500 – ∞	206-500XX R/L	KA6 R/L	630....	T 205	T 5120	
6	27,0	29,5	50 – 60	UT6-5060 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	60 – 75	UT6-6075 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	75 – 100	UT6-75100 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	100 – 150	UT6-100150 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	150 – 300	UT6-150300 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	300 – 500	UT6-300500 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	500 – ∞	UT6-500XX R/L	KT6 R/L	630....	T 205	T 5120	

ET₂ = Stechtiefe kann auf Maß „ET₂“ erhöht werden.
ET₂ = Grooving depth can be increased to measure "ET₂".
ET₂ = La profondità di scanalatura può essere aumentata alla dimensione "ET₂".

Grundhalter werden mit Schrauben und Schlüssel geliefert, jedoch ohne U-Platte und Klemme.
Basic holders will be supplied with screws and key, however without support blade and clamp.
Gli steli sono forniti completi di viti e una chiave ma senza staffa e lama.

Weiteres Zubehör auf der nächsten Seite
More accessories next page
Altri accessori nella pagina seguente

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Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	ET ₂	Nut-Außen-Ø OD of groove Ø est. di gola	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
UT63-8-10 R	8	17,0	18,0	75 – 100	308-75100 R/L	KAK8 R/L	838....	T 206	T 5120
	8	17,0	18,0	100 – 150	308-100150 R/L	KAK8 R/L	838....	T 206	T 5120
	8	17,0	18,0	150 – 300	308-150300 R/L	KAK8 R/L	838....	T 206	T 5120
	8	17,0	18,0	300 – 500	308-300500 R/L	KAK8 R/L	838....	T 206	T 5120
	8	17,0	18,0	500 – ∞	308-500XX R/L	KAK8 R/L	838....	T 206	T 5120
	8	32,0	32,5	75 – 100	UT8-75100 R/L	KA8 R/L	838....	T 206	T 5120
	8	32,0	32,5	100 – 150	UT8-100150 R/L	KA8 R/L	838....	T 206	T 5120
	8	32,0	32,5	150 – 300	UT8-150300 R/L	KA8 R/L	838....	T 206	T 5120
	8	32,0	32,5	300 – 500	UT8-300500 R/L	KA8 R/L	838....	T 206	T 5120
	8	32,0	32,5	500 – ∞	UT8-500XX R/L	KA8 R/L	838....	T 206	T 5120
	10	25,0	26,0	75 – 100	310-75100 R/L	KAK10 R/L	1046....	T 206	T 5120
	10	25,0	26,0	100 – 150	310-100150 R/L	KAK10 R/L	1046....	T 206	T 5120
	10	25,0	26,0	150 – 300	310-150300 R/L	KAK10 R/L	1046....	T 206	T 5120
	10	25,0	26,0	300 – 500	310-300500 R/L	KAK10 R/L	1046....	T 206	T 5120
	10	25,0	26,0	500 – ∞	310-500XX R/L	KAK10 R/L	1046....	T 206	T 5120
	10	40,0	40,5	75 – 100	UT10-75100 R/L	KA10 R/L	1046....	T 206	T 5120
	10	40,0	40,5	100 – 150	UT10-100150 R/L	KA10 R/L	1046....	T 206	T 5120
	10	40,0	40,5	150 – 300	UT10-150300 R/L	KA10 R/L	1046....	T 206	T 5120
10	40,0	40,5	300 – 500	UT10-300500 R/L	KA10 R/L	1046....	T 206	T 5120	
10	40,0	40,5	500 – ∞	UT10-500XX R/L	KA10 R/L	1046....	T 206	T 5120	

ET₂ = Stechtiefe kann auf Maß „ET₂“ erhöht werden.
ET₂ = Grooving depth can be increased to measure "ET₂".
ET₂ = La profondità di scanalatura può essere aumentata alla dimensione "ET₂".

Grundhalter werden mit Schrauben und Schlüssel geliefert, jedoch ohne U-Platte und Klemme.
Basic holders will be supplied with screws and key, however without support blade and clamp.
Gli steli sono forniti completi di viti e una chiave ma senza staffa e lama.

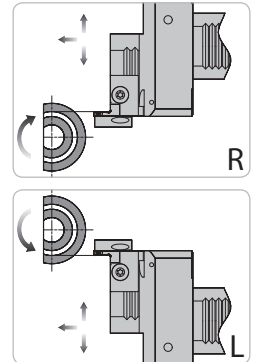


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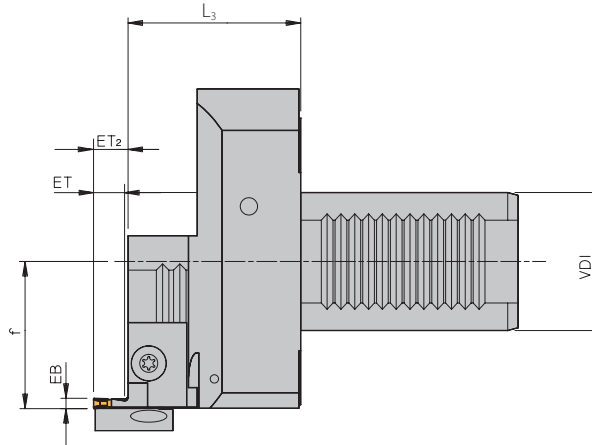
Axial-Stechedrehen

Axial groove turning

Scanalatura e copiatura assiale



Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura



Grundhalter / Basic holder / Corpo utensile

Bezeichnung Designation Articolo	VDI	L ₃	f
VDI30AX-R/L 7	30	50	35,0
VDI40AX-R/L 7	40	50	42,5
VDI50AX-R/L 7	50	50	42,5
VDI60AX-R/L 7	60	50	42,5
VDI40AX-R/L 3*	40	60	42,5
VDI50AX-R/L 3*	50	60	42,5
VDI60AX-R/L 3*	60	60	42,5

*Bei Stechbreite 6 mm -> Maß „L₃“ + 0,5 mm
*For width of cut 6 mm -> Dimension „L₃“ + 0,5 mm
*Per larghezza di taglio di 6 mm -> Dimensione „L₃“ + 0,5 mm

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	ET ₂	Nut-Außen-Ø OD of groove Ø est. di gola	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
VDI30AX-R/L 7 VDI40AX-R/L 7 VDI50AX-R/L 7 VDI60AX-R/L 7	3	9,5	9,5	50 – 60	203-5060 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	60 – 75	203-6075 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	75 – 100	203-75100 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	100 – 150	203-100150 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	150 – 300	203-150300 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	300 – 500	203-300500 R/L	KA3 R/L	320....	T 205	T 5120
	3	9,5	9,5	500 – ∞	203-500XX R/L	KA3 R/L	320....	T 205	T 5120
	3	16,0	18,5	50 – 60	UT3-5060 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	60 – 75	UT3-6075 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	75 – 100	UT3-75100 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	100 – 150	UT3-100150 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	150 – 300	UT3-150300 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	300 – 500	UT3-300500 R/L	KT3 R/L	320....	T 205	T 5120
	3	16,0	18,5	500 – ∞	UT3-500XX R/L	KT3 R/L	320....	T 205	T 5120
	4	11,5	11,5	50 – 60	204-5060 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	60 – 75	204-6075 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	75 – 100	204-75100 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	100 – 150	204-100150 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	150 – 300	204-150300 R/L	KA4 R/L	422....	T 205	T 5120
	4	11,5	11,5	300 – 500	204-300500 R/L	KA4 R/L	422....	T 205	T 5120

*Nacharbeit für Durchmesserbereich erforderlich!
*Minimum retouching work required!
*Potrebbe essere necessaria leggera modifica!

Achtung: Schwere Spannklemme für NC-Stechedrehen, bei unterbrochenen Schnitten oder Vibrationen, siehe Seite 104.
Attention: Heavy duty clamp for NC-Groove turning, at interrupted cuts or vibrations, please refer to page 104.
Attenzione: Staffa a serraggio rinforzata, per taglio interrotto o in caso di vibrazioni, vedere pagina 104.

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Grundhalter Basic holder Corpo utensile	EB	ET	ET ₂	Nut-Außen-Ø OD of groove Ø est. di gola	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
VDI30AX-R/L 7 VDI40AX-R/L 7 VDI50AX-R/L 7 VDI60AX-R/L 7	4	11,5	11,5	500 – ∞	204-500XX R/L	KA4 R/L	422....	T 205	T 5120
	4	19,0	21,5	50 – 60	UT4-5060 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	60 – 75	UT4-6075 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	75 – 100	UT4-75100 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	100 – 150	UT4-100150 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	150 – 300	UT4-150300 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	300 – 500	UT4-300500 R/L	KT4 R/L	422....	T 205	T 5120
	4	19,0	21,5	500 – ∞	UT4-500XX R/L	KT4 R/L	422....	T 205	T 5120
	5	14,5	14,5	50 – 60	205-5060 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	60 – 75	205-6075 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	75 – 100	205-75100 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	100 – 150	205-100150 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	150 – 300	205-150300 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	300 – 500	205-300500 R/L	KA5 R/L	525....	T 205	T 5120
	5	14,5	14,5	500 – ∞	205-500XX R/L	KA5 R/L	525....	T 205	T 5120
	5	22,0	24,5	50 – 60	UT5-5060 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	60 – 75	UT5-6075 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	75 – 100	UT5-75100 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	100 – 150	UT5-100150 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	150 – 300	UT5-150300 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	300 – 500	UT5-300500 R/L	KT5 R/L	525....	T 205	T 5120
	5	22,0	24,5	500 – ∞	UT5-500XX R/L	KT5 R/L	525....	T 205	T 5120
	6	19,5	19,5	50 – 60	206-5060 R/L	KA6 R/L	630....	T 205	T 5120
	6	19,5	19,5	60 – 75	206-6075 R/L	KA6 R/L	630....	T 205	T 5120
	6	19,5	19,5	75 – 100	206-75100 R/L	KA6 R/L	630....	T 205	T 5120
	6	19,5	19,5	100 – 150	206-100150 R/L	KA6 R/L	630....	T 205	T 5120
	6	19,5	19,5	150 – 300	206-150300 R/L	KA6 R/L	630....	T 205	T 5120
	6	19,5	19,5	300 – 500	206-300500 R/L	KA6 R/L	630....	T 205	T 5120
	6	19,5	19,5	500 – ∞	206-500XX R/L	KA6 R/L	630....	T 205	T 5120
	6	27,0	29,5	50 – 60	UT6-5060 R/L	KT6 R/L	630....	T 205	T 5120
	6	27,0	29,5	60 – 75	UT6-6075 R/L	KT6 R/L	630....	T 205	T 5120
	6	27,0	29,5	75 – 100	UT6-75100 R/L	KT6 R/L	630....	T 205	T 5120
6	27,0	29,5	100 – 150	UT6-100150 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	150 – 300	UT6-150300 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	300 – 500	UT6-300500 R/L	KT6 R/L	630....	T 205	T 5120	
6	27,0	29,5	500 – ∞	UT6-500XX R/L	KT6 R/L	630....	T 205	T 5120	
VDI40AX-R/L 3 VDI50AX-R/L 3 VDI60AX-R/L 3	8	17,0	18,0	75 – 100	308-75100 R/L	KAK8 R/L	838....	T 206	T 5120
	8	17,0	18,0	100 – 150	308-100150 R/L	KAK8 R/L	838....	T 206	T 5120
	8	17,0	18,0	150 – 300	308-150300 R/L	KAK8 R/L	838....	T 206	T 5120
	8	17,0	18,0	300 – 500	308-300500 R/L	KAK8 R/L	838....	T 206	T 5120
	8	17,0	18,0	500 – ∞	308-500XX R/L	KAK8 R/L	838....	T 206	T 5120
	8	32,0	32,5	75 – 100	UT8-75100 R/L	KA8 R/L	838....	T 206	T 5120
	8	32,0	32,5	100 – 150	UT8-100150 R/L	KA8 R/L	838....	T 206	T 5120
	8	32,0	32,5	150 – 300	UT8-150300 R/L	KA8 R/L	838....	T 206	T 5120
	8	32,0	32,5	300 – 500	UT8-300500 R/L	KA8 R/L	838....	T 206	T 5120
	8	32,0	32,5	500 – ∞	UT8-500XX R/L	KA8 R/L	838....	T 206	T 5120
	10	25,0	26,0	75 – 100	310-75100 R/L	KAK10 R/L	1046....	T 206	T 5120
	10	25,0	26,0	100 – 150	310-100150 R/L	KAK10 R/L	1046....	T 206	T 5120
	10	25,0	26,0	150 – 300	310-150300 R/L	KAK10 R/L	1046....	T 206	T 5120
	10	25,0	26,0	300 – 500	310-300500 R/L	KAK10 R/L	1046....	T 206	T 5120
	10	25,0	26,0	500 – ∞	310-500XX R/L	KAK10 R/L	1046....	T 206	T 5120
	10	40,0	40,5	75 – 100	UT10-75100 R/L	KA10 R/L	1046....	T 206	T 5120
	10	40,0	40,5	100 – 150	UT10-100150 R/L	KA10 R/L	1046....	T 206	T 5120
	10	40,0	40,5	150 – 300	UT10-150300 R/L	KA10 R/L	1046....	T 206	T 5120
10	40,0	40,5	300 – 500	UT10-300500 R/L	KA10 R/L	1046....	T 206	T 5120	
10	40,0	40,5	500 – ∞	UT10-500XX R/L	KA10 R/L	1046....	T 206	T 5120	

ET₂ = Stechtiefe kann auf Maß „ET₂“ erhöht werden.
ET₂ = Grooving depth can be increased to measure "ET₂".
ET₂ = La profondità di scanalatura può essere aumentata alla dimensione "ET₂".

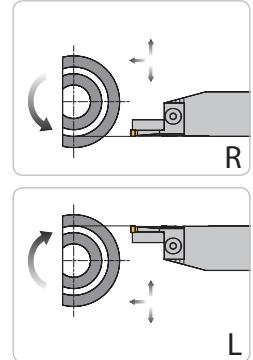
Grundhalter werden mit Schrauben und Schlüssel geliefert, jedoch ohne U-Platte und Klemme.
Basic holders will be supplied with screws and key, however without support blade and clamp.
Gli steli sono forniti completi di viti e una chiave ma senza staffa e lama.

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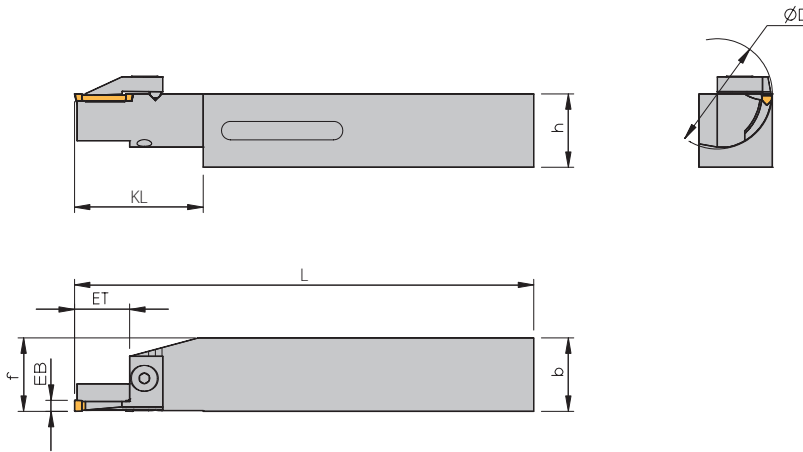
Axial-Stechedrehen gerade – Ø 20 – 300 mm

Axial groove turning straight – Ø 20 – 300 mm

Utensile dritto scanalatura e copiatura assiale – Ø 20 – 300 mm



Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura



2

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Bezeichnung Designation Articolo	Nut-Außen-Ø OD of groove Ø est. di gola	EB	ET	KL	h	b	L	f	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
72020-2-2025 R/L Kontra	20 – 25	2	7,5	30	20	20	125	20	KAM2 R/L Kontra	212...	T 154	KS 1111
72020-2-2530 R/L Kontra	25 – 30	2	10,5	35	20	20	125	20	KTM2 R/L Kontra	212...	T 154	KS 1111
72020-2-3035 R/L Kontra	30 – 35	2	10,5	35	20	20	125	20	KTM2 R/L Kontra	212...	T 154	KS 1111
72020-2-3540 R/L Kontra	35 – 40	2	10,5	35	20	20	125	20	KTM2 R/L Kontra	212...	T 154	KS 1111
72020-2-4050 R/L Kontra	40 – 50	2	10,5	35	20	20	125	20	KTM2 R/L Kontra	212...	T 154	KS 1111
72020-2-5060 R/L Kontra	50 – 60	2	10,5	35	20	20	125	20	KTM2 R/L Kontra	212...	T 154	KS 1111
72020-2-6075 R/L Kontra	60 – 75	2	10,5	35	20	20	125	20	KTM2 R/L Kontra	212...	T 154	KS 1111
72020-2-75100 R/L Kontra	75 – 100	2	10,5	35	20	20	125	20	KTM2 R/L Kontra	212...	T 154	KS 1111
72020-2-100150 R/L Kontra	100 – 150	2	10,5	35	20	20	125	20	KTM2 R/L Kontra	212...	T 154	KS 1111
72020-2-150300 R/L Kontra	150 – 300	2	10,5	35	20	20	125	20	KTM2 R/L Kontra	212...	T 154	KS 1111
72020-3-2025 R/L Kontra	20 – 25	3	11,5	30	20	20	125	20	KAM3 R/L Kontra	316...	T 154	KS 1111
72020-3-2530 R/L Kontra	25 – 30	3	14,5	35	20	20	125	20	KTM3 R/L Kontra	316...	T 154	KS 1111
72020-3-3035 R/L Kontra	30 – 35	3	14,5	35	20	20	125	20	KTM3 R/L Kontra	316...	T 154	KS 1111
72020-3-3540 R/L Kontra	35 – 40	3	14,5	35	20	20	125	20	KTM3 R/L Kontra	316...	T 154	KS 1111
72020-3-4050 R/L Kontra	40 – 50	3	14,5	35	20	20	125	20	KTM3 R/L Kontra	316...	T 154	KS 1111
72020-3-5060 R/L Kontra	50 – 60	3	14,5	35	20	20	125	20	KTM3 R/L Kontra	316...	T 154	KS 1111

Achtung: Diese Werkzeuge nur nach der Schafthöhe (Maß „h“) ausrichten, da die Schneidkante über der Drehmitte liegt!
Attention: These tools should be set up according to dimension "h" (shank-height), because the cutting edge is above centre height!
Attenzione: Questi utensili devono essere montati secondo l'altezza "h" del gambo, perchè il tagliente è sopra l'altezza del centro!

Grundhalter werden mit Schrauben und Schlüssel geliefert, jedoch ohne U-Platte und Klemme.
Basic holders will be supplied with screws and key, however without support blade and clamp.
Gli steli sono forniti completi di viti e una chiave ma senza staffa e lama.

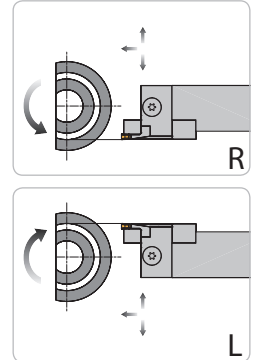
Hinweis: Kontra-Stechedrehwerkzeuge ab Stechbreite 3 mm und Außendurchmesser 50 mm, siehe Seite 123 – 124.
Remark: Contra-execution grooving tools from the grooving width of 3 mm and external diameter of 50 mm, please refer to page 123 – 124.
Nota: Utensili Kontra partono da una larghezza di taglio di 3 mm, e diametro esterno 50 mm, vedere pagina 123 – 124.

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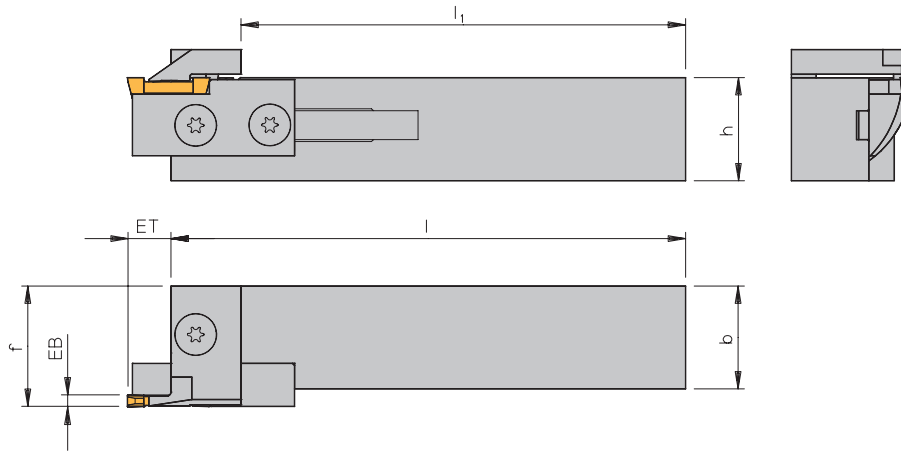
Axial-Steindreher gerade

Axial groove turning straight

Utensile dritto scanalatura e copiatura assiale



Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura



Grundhalter / Basic holder / Corpo utensile

Bezeichnung Designation Articolo	h	b	l	l ₁	f
72025 R/L*	20	25	125	113	29,65
72525 R/L*	25	25	150	138	29,65
73225 R/L*	32	25	170	158	29,65
373232 R/L	32	32	170	145	38,50

*Bei Stechbreite 6 mm -> f = b + 0,5; übrige Stechbreiten f = b
*For width of cut 6 mm -> f = b + 0.5; for all others f = b
*Per larghezza di taglio di 6 mm -> f = b + 0,5; altre larghezze f = b

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	Nut-Außen-Ø OD of groove Ø est. di gola	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
72025 R/L 72525 R/L 73225 R/L	3	10	50 – 60	203S-5060 R/L Kontra	KAS3 R/L Kontra	320...	T 205	T 5120
	3	10	60 – 75	203S-6075 R/L Kontra	KAS3 R/L Kontra	320...	T 205	T 5120
	3	10	75 – 100	203S-75100 R/L Kontra	KAS3 R/L Kontra	320...	T 205	T 5120
	3	10	100 – 150	203S-100150 R/L Kontra	KAS3 R/L Kontra	320...	T 205	T 5120
	3	10	150 – 300	203S-150300 R/L Kontra	KAS3 R/L Kontra	320...	T 205	T 5120
	3	10	300 – 500	203S-300500 R/L Kontra	KAS3 R/L Kontra	320...	T 205	T 5120
	3	10	500 – ∞	203S-500XX R/L Kontra	KAS3 R/L Kontra	320...	T 205	T 5120
	3	17	50 – 60	UT3S-5060 R/L Kontra	KTS3 R/L Kontra	320...	T 205	T 5120
	3	17	60 – 75	UT3S-6075 R/L Kontra	KTS3 R/L Kontra	320...	T 205	T 5120
	3	17	75 – 100	UT3S-75100 R/L Kontra	KTS3 R/L Kontra	320...	T 205	T 5120
	3	17	100 – 150	UT3S-100150 R/L Kontra	KTS3 R/L Kontra	320...	T 205	T 5120
	3	17	150 – 300	UT3S-150300 R/L Kontra	KTS3 R/L Kontra	320...	T 205	T 5120
	3	17	300 – 500	UT3S-300500 R/L Kontra	KTS3 R/L Kontra	320...	T 205	T 5120
	3	17	500 – ∞	UT3S-500XX R/L Kontra	KTS3 R/L Kontra	320...	T 205	T 5120
	4	12	50 – 60	204S-5060 R/L Kontra	KAS4 R/L Kontra	422...	T 205	T 5120
	4	12	60 – 75	204S-6075 R/L Kontra	KAS4 R/L Kontra	422...	T 205	T 5120
	4	12	75 – 100	204S-75100 R/L Kontra	KAS4 R/L Kontra	422...	T 205	T 5120
	4	12	100 – 150	204S-100150 R/L Kontra	KAS4 R/L Kontra	422...	T 205	T 5120
	4	12	150 – 300	204S-150300 R/L Kontra	KAS4 R/L Kontra	422...	T 205	T 5120
	4	12	300 – 500	204S-300500 R/L Kontra	KAS4 R/L Kontra	422...	T 205	T 5120

Weiteres Zubehör auf der nächsten Seite
More accessories next page
Altri accessori nella pagina seguente

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Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

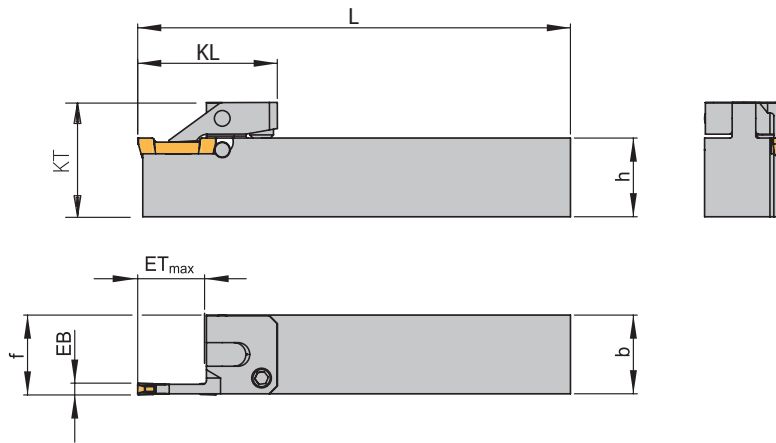
Grundhalter Basic holder Corpo utensile	EB	ET	Nut-Außen-Ø OD of groove Ø est. di gola	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
72025 R/L 72525 R/L 73225 R/L	4	12	500 – ∞	204S-500XX R/L Kontra	KAS4 R/L Kontra	422....	T 205	T 5120
	4	20	50 – 60	UT4S-5060 R/L Kontra	KTS4 R/L Kontra	422....	T 205	T 5120
	4	20	60 – 75	UT4S-6075 R/L Kontra	KTS4 R/L Kontra	422....	T 205	T 5120
	4	20	75 – 100	UT4S-75100 R/L Kontra	KTS4 R/L Kontra	422....	T 205	T 5120
	4	20	100 – 150	UT4S-100150 R/L Kontra	KTS4 R/L Kontra	422....	T 205	T 5120
	4	20	150 – 300	UT4S-150300 R/L Kontra	KTS4 R/L Kontra	422....	T 205	T 5120
	4	20	300 – 500	UT4S-300500 R/L Kontra	KTS4 R/L Kontra	422....	T 205	T 5120
	4	20	500 – ∞	UT4S-500XX R/L Kontra	KTS4 R/L Kontra	422....	T 205	T 5120
	5	15	50 – 60	205S-5060 R/L Kontra	KAS5 R/L Kontra	525....	T 205	T 5120
	5	15	60 – 75	205S-6075 R/L Kontra	KAS5 R/L Kontra	525....	T 205	T 5120
	5	15	75 – 100	205S-75100 R/L Kontra	KAS5 R/L Kontra	525....	T 205	T 5120
	5	15	100 – 150	205S-100150 R/L Kontra	KAS5 R/L Kontra	525....	T 205	T 5120
	5	15	150 – 300	205S-150300 R/L Kontra	KAS5 R/L Kontra	525....	T 205	T 5120
	5	15	300 – 500	205S-300500 R/L Kontra	KAS5 R/L Kontra	525....	T 205	T 5120
	5	15	500 – ∞	205S-500XX R/L Kontra	KAS5 R/L Kontra	525....	T 205	T 5120
	5	23	50 – 60	UT5S-5060 R/L Kontra	KTS5 R/L Kontra	525....	T 205	T 5120
	5	23	60 – 75	UT5S-6075 R/L Kontra	KTS5 R/L Kontra	525....	T 205	T 5120
	5	23	75 – 100	UT5S-75100 R/L Kontra	KTS5 R/L Kontra	525....	T 205	T 5120
	5	23	100 – 150	UT5S-100150 R/L Kontra	KTS5 R/L Kontra	525....	T 205	T 5120
	5	23	150 – 300	UT5S-150300 R/L Kontra	KTS5 R/L Kontra	525....	T 205	T 5120
	5	23	300 – 500	UT5S-300500 R/L Kontra	KTS5 R/L Kontra	525....	T 205	T 5120
	5	23	500 – ∞	UT5S-500XX R/L Kontra	KTS5 R/L Kontra	525....	T 205	T 5120
	6	20	50 – 60	206S-5060 R/L Kontra	KAS6 R/L Kontra	630....	T 205	T 5120
	6	20	60 – 75	206S-6075 R/L Kontra	KAS6 R/L Kontra	630....	T 205	T 5120
	6	20	75 – 100	206S-75100 R/L Kontra	KAS6 R/L Kontra	630....	T 205	T 5120
	6	20	100 – 150	206S-100150 R/L Kontra	KAS6 R/L Kontra	630....	T 205	T 5120
	6	20	150 – 300	206S-150300 R/L Kontra	KAS6 R/L Kontra	630....	T 205	T 5120
	6	20	300 – 500	206S-300500 R/L Kontra	KAS6 R/L Kontra	630....	T 205	T 5120
	6	20	500 – ∞	206S-500XX R/L Kontra	KAS6 R/L Kontra	630....	T 205	T 5120
	6	28	50 – 60	UT6S-5060 R/L Kontra	KTS6 R/L Kontra	630....	T 205	T 5120
	6	28	60 – 75	UT6S-6075 R/L Kontra	KTS6 R/L Kontra	630....	T 205	T 5120
	6	28	75 – 100	UT6S-75100 R/L Kontra	KTS6 R/L Kontra	630....	T 205	T 5120
6	28	100 – 150	UT6S-100150 R/L Kontra	KTS6 R/L Kontra	630....	T 205	T 5120	
6	28	150 – 300	UT6S-150300 R/L Kontra	KTS6 R/L Kontra	630....	T 205	T 5120	
6	28	300 – 500	UT6S-300500 R/L Kontra	KTS6 R/L Kontra	630....	T 205	T 5120	
6	28	500 – ∞	UT6S-500XX R/L Kontra	KTS6 R/L Kontra	630....	T 205	T 5120	
373232 R/L	8	25	75 – 100	308S-75100 R/L Kontra	KAS8 R/L Kontra	838....	T 206	T 5120
	8	25	100 – 150	308S-100150 R/L Kontra	KAS8 R/L Kontra	838....	T 206	T 5120
	8	25	150 – 300	308S-150300 R/L Kontra	KAS8 R/L Kontra	838....	T 206	T 5120
	8	25	300 – 500	308S-300500 R/L Kontra	KAS8 R/L Kontra	838....	T 206	T 5120
	8	25	500 – ∞	308S-500XX R/L Kontra	KAS8 R/L Kontra	838....	T 206	T 5120
	8	32	75 – 100	UT8S-75100 R/L Kontra	KTS8 R/L Kontra	838....	T 206	T 5120
	8	32	100 – 150	UT8S-100150 R/L Kontra	KTS8 R/L Kontra	838....	T 206	T 5120
	8	32	150 – 300	UT8S-150300 R/L Kontra	KTS8 R/L Kontra	838....	T 206	T 5120
	8	32	300 – 500	UT8S-300500 R/L Kontra	KTS8 R/L Kontra	838....	T 206	T 5120
	8	32	500 – ∞	UT8S-500XX R/L Kontra	KTS8 R/L Kontra	838....	T 206	T 5120
	10	35	75 – 100	310S-75100 R/L Kontra	KAS10 R/L Kontra	1046....	T 206	T 5120
	10	35	100 – 150	310S-100150 R/L Kontra	KAS10 R/L Kontra	1046....	T 206	T 5120
	10	35	150 – 300	310S-150300 R/L Kontra	KAS10 R/L Kontra	1046....	T 206	T 5120
	10	35	300 – 500	310S-300500 R/L Kontra	KAS10 R/L Kontra	1046....	T 206	T 5120
	10	35	500 – ∞	310S-500XX R/L Kontra	KAS10 R/L Kontra	1046....	T 206	T 5120
	10	42	75 – 100	UT10S-75100 R/L Kontra	KTS10 R/L Kontra	1046....	T 206	T 5120
	10	42	100 – 150	UT10S-100150 R/L Kontra	KTS10 R/L Kontra	1046....	T 206	T 5120
	10	42	150 – 300	UT10S-150300 R/L Kontra	KTS10 R/L Kontra	1046....	T 206	T 5120
	10	42	300 – 500	UT10S-300500 R/L Kontra	KTS10 R/L Kontra	1046....	T 206	T 5120
	10	42	500 – ∞	UT10S-500XX R/L Kontra	KTS10 R/L Kontra	1046....	T 206	T 5120

Grundhalter werden mit Schrauben und Schlüssel geliefert, jedoch ohne U-Platte und Klemme.
Basic holders will be supplied with screws and key, however without support blade and clamp.
Gli steli sono forniti completi di viti e una chiave ma senza staffa e lama.

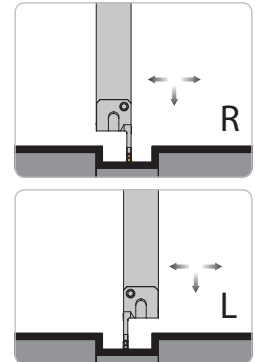
Radial-Stechdrehen gerade

Radial groove turning straight

Utensile dritto – Scanalatura e copiatura radiale



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Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

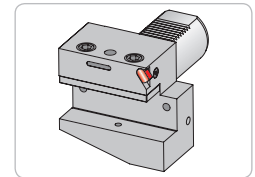
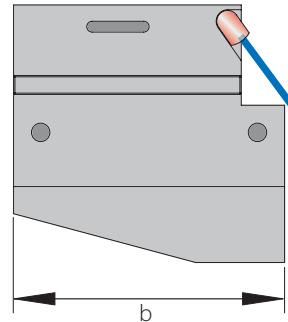
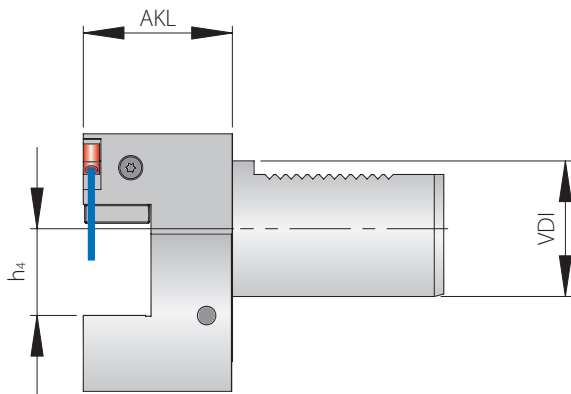
Grundhalter / Basic holder / Corpo utensile

Bezeichnung Designation Articolo	EB	ET _{max}	f	L	KL	KT	b	h	Schneideinsatz Insert Inserto
SAN01-0317-1616 R/L	3	17	16,3	100	35,5	25	16	16	320....
SAN01-0317-2020 R/L	3	17	20,3	110	35,5	29	20	20	320....
SAN01-0317-2525 R/L	3	17	25,3	125	35,5	34	25	25	320....
SAN01-0419-1616 R/L	4	19	16,3	100	37,6	25	16	16	422....
SAN01-0419-2020 R/L	4	19	20,3	110	37,6	29	20	20	422....
SAN01-0419-2525 R/L	4	19	25,3	125	37,6	34	25	25	422....
SAN01-0522-2020 R/L	5	22	20,3	110	40,6	29	20	20	525....
SAN01-0522-2525 R/L	5	22	25,3	125	40,6	34	25	25	525....
SAN01-0627-2020 R/L	6	27	20,3	110	45,7	29	20	20	630....
SAN01-0627-2525 R/L	6	27	25,3	125	45,7	34	25	25	630....

2

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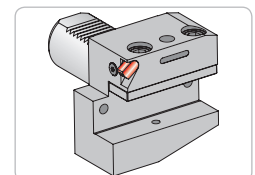
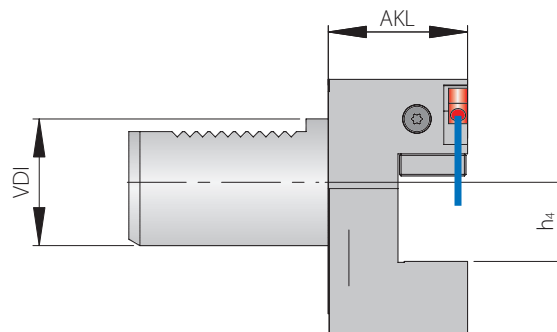
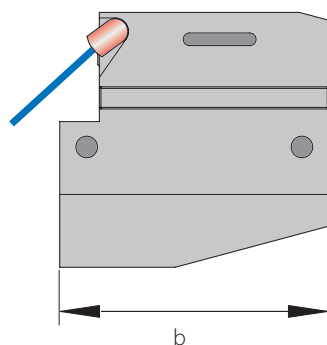
Form B1 – kurz / Form B1 – short / Forma B1 – corta



Grundhalter / Basic holder / Adattatore

Bezeichnung Designation Articolo	VDI	h4	AKL	b	Kühlmitteldüse Coolant jet Ugello refrigerante	Schraube für Kühlmitteldüse Screw for coolant jet Vite per ugello refrigerante
KMH01-B1-16X12X24	16	12	24	42	KMD0519	AS0020
KMH01-B1-20X16X30	20	16	30	55	KMD0519	AS0020
KMH01-B1-25X16X30	25	16	30	55	KMD0519	AS0020
KMH01-B1-30X20X40	30	20	40	70	KMD0830	AS0020
KMH01-B1-40X25X44	40	25	44	85	KMD0830	AS0020
KMH01-B1-50X32X55	50	32	55	100	KMD0830	AS0020

Form B2 – kurz / Form B2 – short / Forma B2 – corta

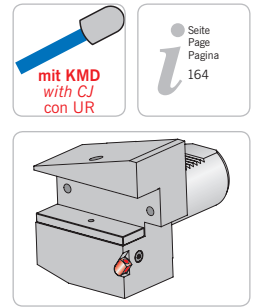
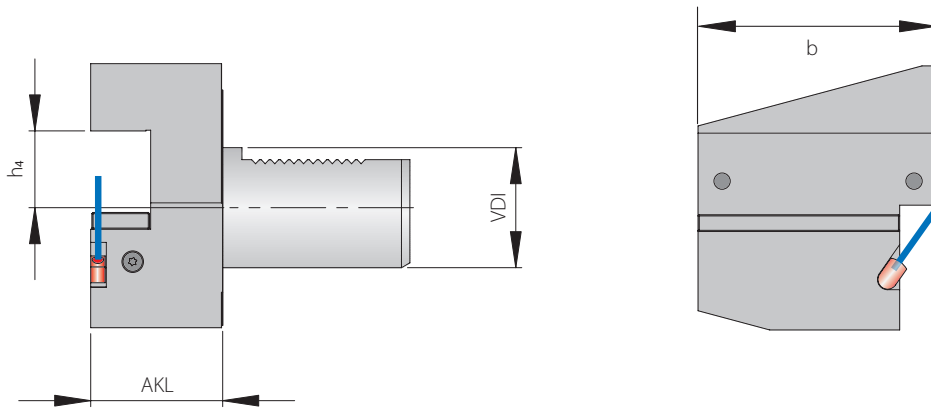


Grundhalter / Basic holder / Adattatore

Bezeichnung Designation Articolo	VDI	h4	AKL	b	Kühlmitteldüse Coolant jet Ugello refrigerante	Schraube für Kühlmitteldüse Screw for coolant jet Vite per ugello refrigerante
KMH01-B2-25X16X30	25	16	30	55	KMD0519	AS0020
KMH01-B2-30X20X40	30	20	40	70	KMD0830	AS0020
KMH01-B2-40X25X44	40	25	44	85	KMD0830	AS0020
KMH01-B2-40X25X70	40	25	70	85	KMD0830	AS0020

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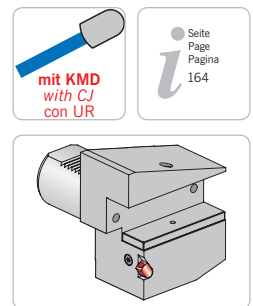
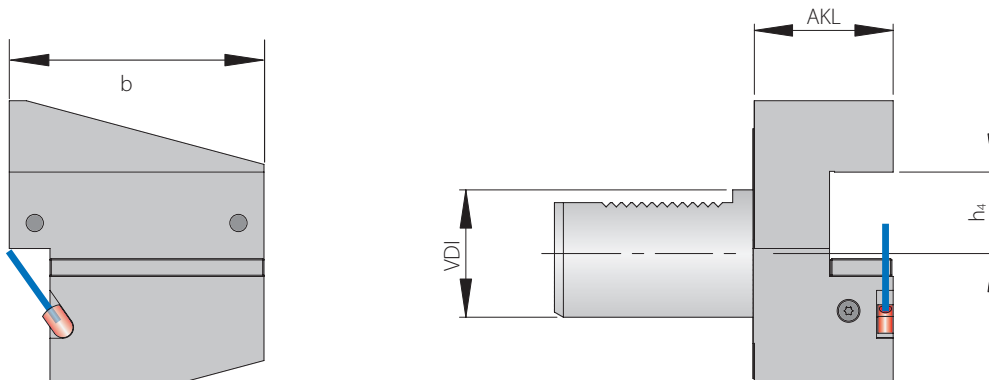
Form B3 – Überkopf – kurz / Form B3 – Overhead – short /
Forma B3 – Invertito – corta



Grundhalter / Basic holder / Adattatore

Bezeichnung Designation Articolo	VDI	h4	AKL	b	Kühlmitteldüse Coolant jet Ugello refrigerante	Schraube für Kühlmitteldüse Screw for coolant jet Vite per ugello refrigerante
KMH01-B3-16X12X24	16	12	24	42	KMD0519	AS0020
KMH01-B3-20X16X30	20	16	30	55	KMD0519	AS0020
KMH01-B3-25X16X30	25	16	30	55	KMD0519	AS0020
KMH01-B3-30X20X40	30	20	40	70	KMD0830	AS0020
KMH01-B3-40X25X44	40	25	44	85	KMD0830	AS0020
KMH01-B3-50X32X55	50	32	55	100	KMD0830	AS0020

Form B4 – Überkopf – kurz / Form B4 – Overhead – short /
Forma B4 – Invertito – corta

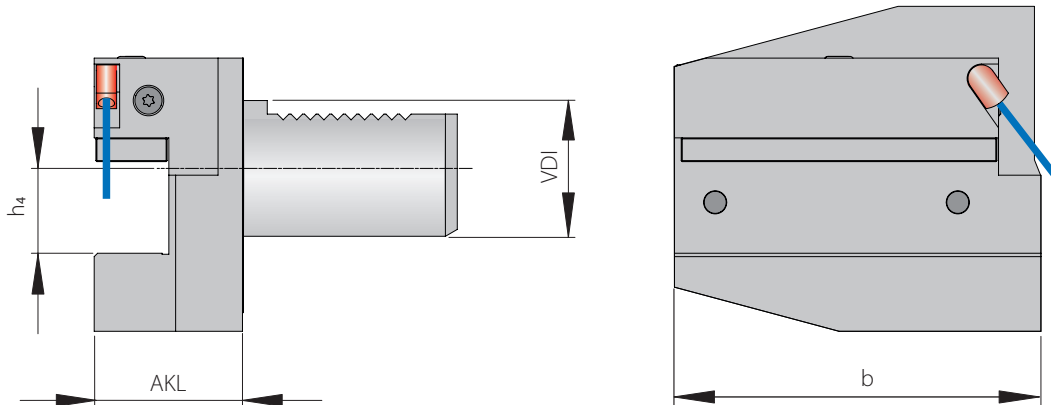
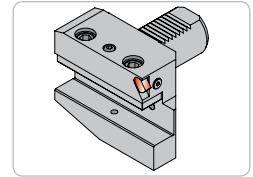


Grundhalter / Basic holder / Adattatore

Bezeichnung Designation Articolo	VDI	h4	AKL	b	Kühlmitteldüse Coolant jet Ugello refrigerante	Schraube für Kühlmitteldüse Screw for coolant jet Vite per ugello refrigerante
KMH01-B4-16X12X24	16	12	24	42	KMD0519	AS0020
KMH01-B4-20X16X30	20	16	30	55	KMD0519	AS0020
KMH01-B4-25X16X30	25	16	30	55	KMD0519	AS0020
KMH01-B4-30X20X40	30	20	40	70	KMD0830	AS0020
KMH01-B4-40X25X44	40	25	44	85	KMD0830	AS0020
KMH01-B4-50X32X55	50	32	55	100	KMD0830	AS0020

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Form B5 – lang / Form B5 – long / Forma B5 – lunga

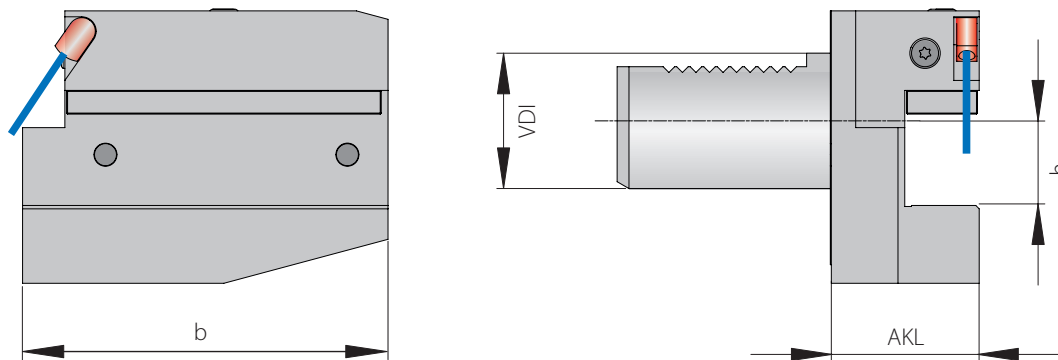
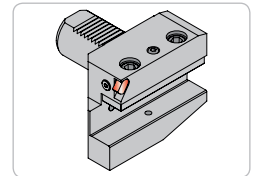


Grundhalter / Basic holder / Adattatore

Bezeichnung Designation Articolo	VDI	h4	AKL	b	Kühlmitteldüse Coolant jet Ugello refrigerante	Schraube für Kühlmitteldüse Screw for coolant jet Vite per ugello refrigerante
KMH01-B5-40X25X44	40	25	44	108	KMD0830	AS0020

2

Form B6 – lang / Form B6 – long / Forma B6 – lunga

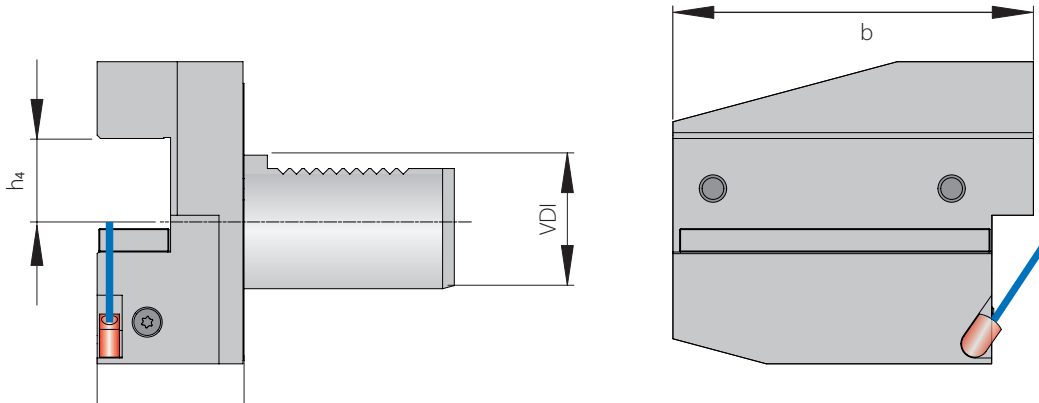
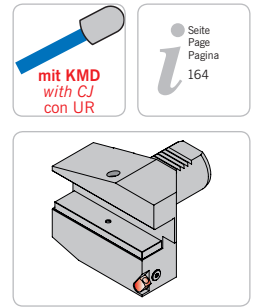


Grundhalter / Basic holder / Adattatore

Bezeichnung Designation Articolo	VDI	h4	AKL	b	Kühlmitteldüse Coolant jet Ugello refrigerante	Schraube für Kühlmitteldüse Screw for coolant jet Vite per ugello refrigerante
KMH01-B6-40X25X44	40	25	44	108	KMD0830	AS0020

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Form B7 – Überkopf – lang / Form B7 – Overhead – long /
Forma B7 – Invertito – lunga



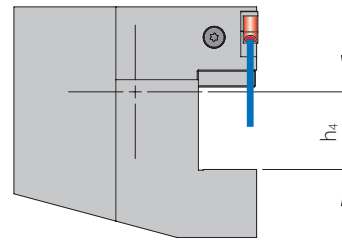
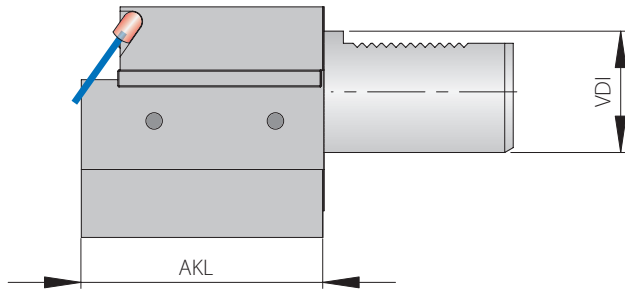
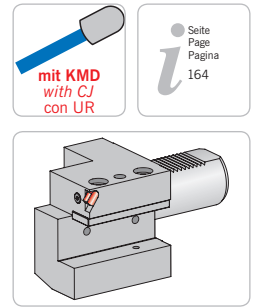
Grundhalter / Basic holder / Adattatore

Bezeichnung Designation Articolo	VDI	h4	AKL	b	Kühlmitteldüse Coolant jet Ugello refrigerante	Schraube für Kühlmitteldüse Screw for coolant jet Vite per ugello refrigerante
KMH01-B7-40X25X44	40	25	44	108	KMD0830	AS0020



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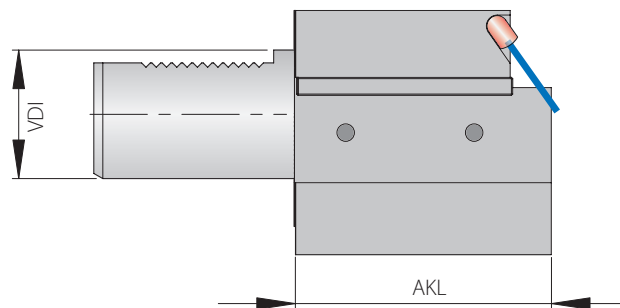
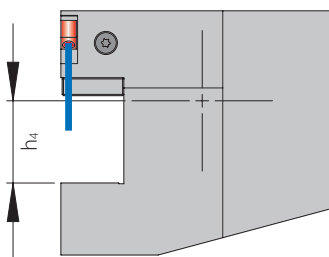
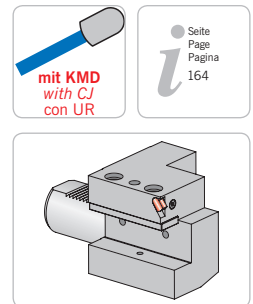
Form C1 / Form C1 / Forma C1



Grundhalter / Basic holder / Adattatore

Bezeichnung Designation Articolo	VDI	h4	AKL	Kühlmitteldüse Coolant jet Ugello refrigerante	Schraube für Kühlmitteldüse Screw for coolant jet Vite per ugello refrigerante
KMH01-C1-25X16	25	55	16	KMD0519	AS0020
KMH01-C1-25X20	25	55	20	KMD0519	AS0020
KMH01-C1-30X20	30	70	20	KMD0519	AS0020
KMH01-C1-40X25	40	85	25	KMD0519	AS0020
KMH01-C1-50X32	50	100	32	KMD0519	AS0020

Form C2 / Form C2 / Forma C2

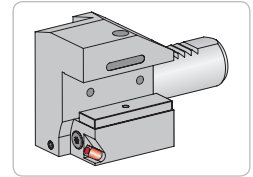
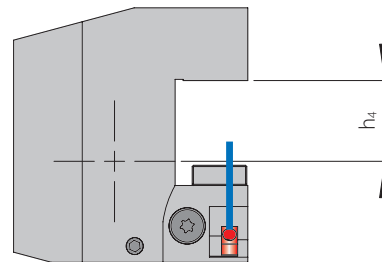
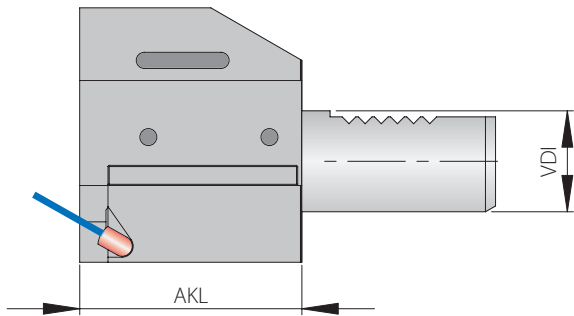


Grundhalter / Basic holder / Adattatore

Bezeichnung Designation Articolo	VDI	h4	AKL	Kühlmitteldüse Coolant jet Ugello refrigerante	Schraube für Kühlmitteldüse Screw for coolant jet Vite per ugello refrigerante
KMH01-C2-16X12	16	44	12	KMD0519	AS0020
KMH01-C2-20X16	20	50	16	KMD0519	AS0020
KMH01-C2-30X20	30	70	20	KMD0519	AS0020
KMH01-C2-40X25	40	85	25	KMD0519	AS0020
KMH01-C2-50X32	50	100	32	KMD0519	AS0020

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Form C3 – Überkopf / Form C3 – Overhead / Forma C3 – Invertito

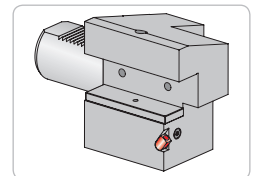
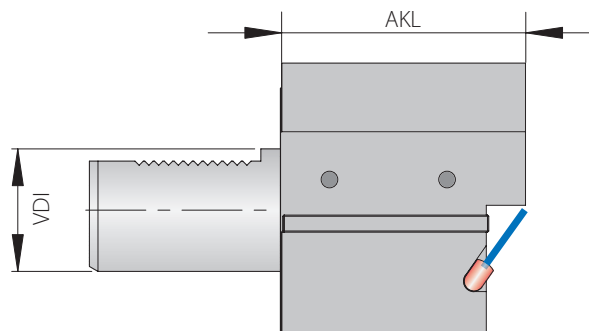
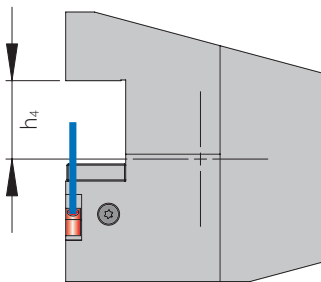


Grundhalter / Basic holder / Adattatore

Bezeichnung Designation Articolo	VDI	h4	AKL	Kühlmitteldüse Coolant jet Ugello refrigerante	Schraube für Kühlmitteldüse Screw for coolant jet Vite per ugello refrigerante
KMH01-C3-16X12	16	44	12	KMD0519	AS0020
KMH01-C3-20X16	20	50	16	KMD0519	AS0020
KMH01-C3-30X20	30	70	20	KMD0519	AS0020
KMH01-C3-40X25	40	85	25	KMD0519	AS0020
KMH01-C3-50X32	50	100	32	KMD0519	AS0020

2

Form C4 – Überkopf / Form C4 – Overhead / Forma C4 – Invertito



Grundhalter / Basic holder / Adattatore

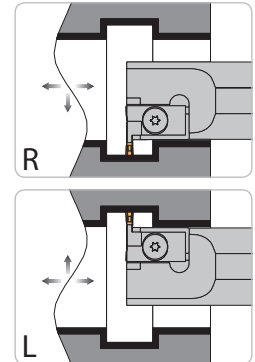
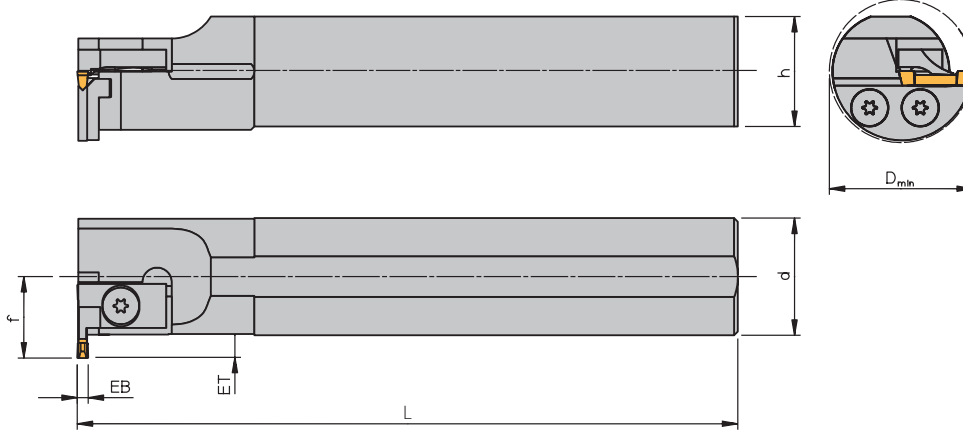
Bezeichnung Designation Articolo	VDI	h4	AKL	Kühlmitteldüse Coolant jet Ugello refrigerante	Schraube für Kühlmitteldüse Screw for coolant jet Vite per ugello refrigerante
KMH01-C4-16X12	16	44	12	KMD0519	AS0020
KMH01-C4-20X16	20	50	16	KMD0519	AS0020
KMH01-C4-25X16	25	55	16	KMD0519	AS0020
KMH01-C4-25X20	25	55	20	KMD0519	AS0020
KMH01-C4-30X20	30	70	20	KMD0519	AS0020
KMH01-C4-40X25	40	85	25	KMD0519	AS0020
KMH01-C4-50X32	50	100	32	KMD0519	AS0020

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Innenstechdrehen ab Ø 16 mm

Internal groove turning from Ø 16 mm

Scanalatura e copiatura interna da Ø 16 mm



Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

2

Grundhalter / Basic holder / Corpo utensile

Bezeichnung Designation Articolo	d	L	h
9-12 R/L	12	150	11
9-12.471 R/L	12	150	11
9-16.2 R/L	16	150	15
9-16.2.471 R/L	16	150	15
9-16.3 R/L	16	150	15
9-16.3.471 R/L	16	150	15
9-20 R/L	20	250	18
9-20.471 R/L	20	250	18
9-25 R/L	25	280	23
9-25.471 R/L	25	280	23
9-32 R/L	32	300	30

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	D _{min}	f	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
9-12 R/L	2,00	3	16	9,0	—*	KI2F R/L	212....	M 154	KS 1111
9-12.471 R/L	0,5 – 1,85	= EB	16	9,0	—*	KI2F R/L	2-./471 R/L	M 154	KS 1111
9-16.2 R/L	2,00	3	20	11,0	—*	KI2F R/L	212....	M 154	KS 1111
9-16.2.471 R/L	0,5 – 1,85	= EB	20	11,0	—*	KI2F R/L	2-./471 R/L	M 154	KS 1111
9-16.3 R/L	3,00	4	21	12,0	—*	MKI3F R/L	316....	M 154	KS 1111
9-16.3.471 R/L	0,5 – 3,08	= EB	21	12,0	—*	MKI3F R/L	3M-./471 R/L	M 154	KS 1111
9-20 R/L	3,00	4	25	14,3	—*	KI3F R/L	320....	T 154	KS 1111
9-20.471 R/L	0,5 – 3,08	= EB	25	14,3	—*	KI3F R/L	3-./471 R/L	T 154	KS 1111
9-25 R/L	3,00	4	30	16,8	—*	KI3F R/L	320....	T 154	KS 1111
9-25.471 R/L	0,5 – 3,08	= EB	30	16,8	—*	KI3F R/L	3-./471 R/L	T 154	KS 1111
9-32 R/L	0,5 – 3,08	= EB	39	22,0	UI 471 R/L	KI3W R/L	3-./471 R/L	T 205	T 5120
9-32 R/L	3,00	6	39	22,0	20306 R/L	KI3W R/L	320....	T 205	T 5120
9-32 R/L	4,00	8	41	24,0	20408 R/L	KI4W R/L	422....	T 205	T 5120
9-32 R/L	5,00	11	44	27,0	20511 R/L	KI5W R/L	525....	T 205	T 5120

*Monoblockhalter
*Monoblock holders
*Utensili monoblocco

Bitte beachten: Rechter Halter -> Linkes Zubehör
Linker Halter -> Rechtes Zubehör

Please note: Holder right-hand-design -> Left-hand spare parts
Holder left-hand-design -> Right-hand spare parts

Attenzione: Stelo destro -> accessori sinistri
Stelo sinistro -> accessori destri

Grundhalter werden mit Schrauben und Schlüssel geliefert, jedoch ohne U-Platte und Klemme.
Basic holders will be supplied with screws and key, however without support blade and clamp.
Gli steli sono forniti completi di viti e una chiave ma senza staffa e lama.

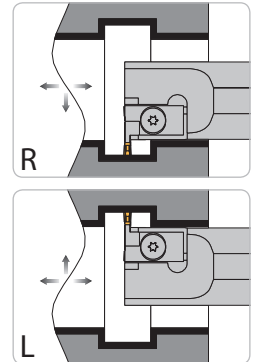
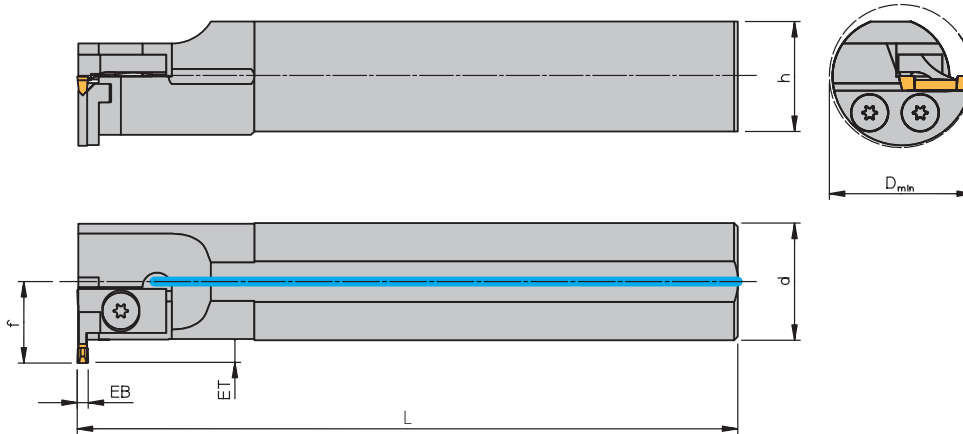
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Innenstechdrehen ab $\varnothing 25$ mm

Internal groove turning from $\varnothing 25$ mm

Scanalatura e copiatura interna da $\varnothing 25$ mm



Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

Grundhalter / Basic holder / Corpo utensile

Bezeichnung Designation Articolo	d	L	h
9-20 NC R/L	20	150	18
9-20.471 NC R/L	20	150	18
9-25 NC R/L	25	160	23
9-25.471 NC R/L	25	160	23
9-32 NC R/L	32	180	30
9-40 NC R/L	40	240	38
9-50 NC R/L	50	300	48
91-50 NC R/L	50	300	48

Weiteres Zubehör auf der nächsten Seite
More accessories next page
Altri accessori nella pagina seguente

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Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	D _{min}	f	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
9-20 NC R/L	3,00	4	25	14,3	—*	KI3F R/L	320....	T 154	KS 1111
9-20.471 NC R/L	0,5 – 3,08	= EB	25	14,3	—*	KI3F R/L	3-./471 R/L	T 154	KS 1111
9-25 NC R/L	3,00	4	30	16,8	—*	KI3F R/L	320....	T 154	KS 1111
9-25.471 NC R/L	0,5 – 3,08	= EB	30	16,8	—*	KI3F R/L	3-./471 R/L	T 154	KS 1111
9-32 NC R/L	0,5 – 3,08	= EB	39	22,0	UI 471 R/L	KI3W R/L	3-./471 R/L	T 205	T 5120
9-32 NC R/L	3,00	6	39	22,0	20306 R/L	KI3W R/L	320....	T 205	T 5120
9-32 NC R/L	4,00	8	41	24,0	20408 R/L	KI4W R/L	422....	T 205	T 5120
9-32 NC R/L	5,00	11	44	27,0	20511 R/L	KI5W R/L	525....	T 205	T 5120
9-40 NC R/L	0,5 – 3,08	= EB	47	26,0	UI 471 R/L	KI3W R/L	3-./471 R/L	T 205	T 5120
9-40 NC R/L	3,00	6	47	26,0	20306 R/L	KI3W R/L	320....	T 205	T 5120
9-40 NC R/L	4,00	8	49	28,0	20408 R/L	KI4W R/L	422....	T 205	T 5120
9-40 NC R/L	5,00	11	52	31,0	20511 R/L	KI5W R/L	525....	T 205	T 5120
9-50 NC R/L	0,5 – 3,08	= EB	57	31,0	UI 471 R/L	KI3W R/L	3-./471 R/L	T 205	T 5120
9-50 NC R/L	3,00	6	57	31,0	20306 R/L	KI3W R/L	320....	T 205	T 5120
9-50 NC R/L	4,00	8	59	33,0	20408 R/L	KI4W R/L	422....	T 205	T 5120
9-50 NC R/L	5,00	11	62	36,0	20511 R/L	KI5W R/L	525....	T 205	T 5120
91-50 NC R/L	3,00	9	61	35,0	9-20310 R/L	KA3 R/L	320....	T 205	T 5120
91-50 NC R/L	3,00	15	70	44,0	9-UT 316 R/L	KT3 R/L	320....	T 205	T 5120
91-50 NC R/L	4,00	10	63	37,0	9-20412 R/L	KA4 R/L	422....	T 205	T 5120
91-50 NC R/L	4,00	18	73	47,0	9-UT 419 R/L	KT4 R/L	422....	T 205	T 5120
91-50 NC R/L	5,00	13	66	40,0	9-20515 R/L	KA5 R/L	525....	T 205	T 5120
91-50 NC R/L	5,00	21	76	50,0	9-UT 522 R/L	KT5 R/L	525....	T 205	T 5120
91-50 NC R/L	6,00	18	71	45,0	9-20620 R/L	KA6 R/L	630....	T 205	T 5120
91-50 NC R/L	6,00	26	81	55,0	9-UT 627 R/L	KT6 R/L	630....	T 205	T 5120

*Monoblockhalter

*Monoblock holders

*Utensili monoblocco

Grundhalter werden mit Schrauben und Schlüssel geliefert, jedoch ohne U-Platte und Klemme.

Basic holders will be supplied with screws and key, however without support blade and clamp.

Gli steli sono forniti completi di viti e una chiave ma senza staffa e lama.

Bitte beachten: Rechter Halter -> Linkes Zubehör

Linker Halter -> Rechtes Zubehör

Please note: Holder right-hand-design -> Left-hand spare parts

Holder left-hand-design -> Right-hand spare parts

Attenzione: Stelo destro -> accessori sinistri

Stelo sinistro -> accessori destri

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Innenstechdrehen

Internal groove turning

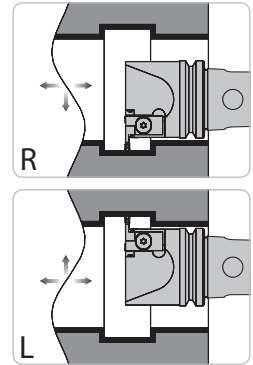
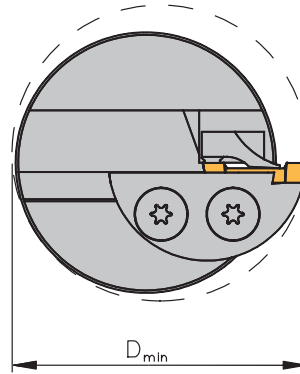
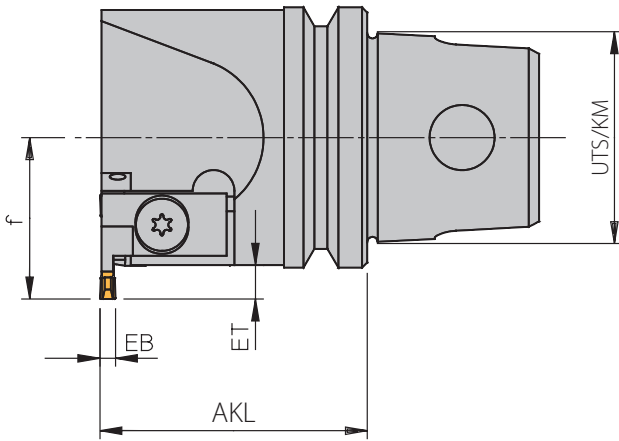
Scanalatura e copiatura interna

X

ohne IK
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senza ic

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Page
Pagina
152-164



Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

Grundhalter / Basic holder / Corpo utensile

Bezeichnung Designation Articolo	UTS/KM	AKL
UT3213-5 R/L	32	40,0
UT4013-5 R/L	40	45,5
UT5013-5 R/L	50	51,0
UT6313-5 R/L	63	52,0

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	D _{min}	f	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
UT3213-5 R/L	0,5 – 3,08	= EB	39	22,0	UI471 R/L	KI3W R/L	3-./471 R/L	T 205	T 5120
UT3213-5 R/L	3,00	6	39	22,0	20306 R/L	KI3W R/L	320....	T 205	T 5120
UT3213-5 R/L	4,00	8	41	24,0	20408 R/L	KI4W R/L	422....	T 205	T 5120
UT3213-5 R/L	5,00	11	44	27,0	20511 R/L	KI5W R/L	525....	T 205	T 5120
UT4013-5 R/L	0,5 – 3,08	= EB	47	26,0	UI471 R/L	KI3W R/L	3-./471 R/L	T 205	T 5120
UT4013-5 R/L	3,00	6	47	26,0	20306 R/L	KI3W R/L	320....	T 205	T 5120
UT4013-5 R/L	4,00	8	49	28,0	20408 R/L	KI4W R/L	422....	T 205	T 5120
UT4013-5 R/L	5,00	11	52	31,0	20511 R/L	KI5W R/L	525....	T 205	T 5120
UT5013-5 R/L	0,5 – 3,08	= EB	57	31,0	UI471 R/L	KI3W R/L	3-./471 R/L	T 205	T 5120
UT5013-5 R/L	3,00	6	57	31,0	20306 R/L	KI3W R/L	320....	T 205	T 5120
UT5013-5 R/L	4,00	8	59	33,0	20408 R/L	KI4W R/L	422....	T 205	T 5120
UT5013-5 R/L	5,00	11	62	36,0	20511 R/L	KI5W R/L	525....	T 205	T 5120
UT6313-5 R/L	0,5 – 3,08	= EB	70	37,5	UI471 R/L	KI3W R/L	3-./471 R/L	T 205	T 5120
UT6313-5 R/L	3,00	6	70	37,5	20306 R/L	KI3W R/L	320....	T 205	T 5120
UT6313-5 R/L	4,00	8	72	39,5	20408 R/L	KI4W R/L	422....	T 205	T 5120
UT6313-5 R/L	5,00	11	75	42,5	20511 R/L	KI5W R/L	525....	T 205	T 5120

Grundhalter werden mit Schrauben und Schlüssel geliefert, jedoch ohne U-Platte und Klemme.
Basic holders will be supplied with screws and key, however without support blade and clamp.
Gli steli sono forniti completi di viti e una chiave ma senza staffa e lama.

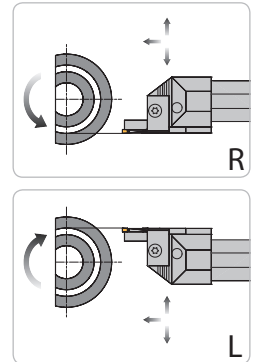
Bitte beachten: Rechter Halter -> Linkes Zubehör
Linker Halter -> Rechtes Zubehör
Please note: Holder right-hand-design -> Left-hand spare parts
Holder left-hand-design -> Right-hand spare parts
Attenzione: Stelo destro -> accessori sinistri
Stelo sinistro -> accessori destri

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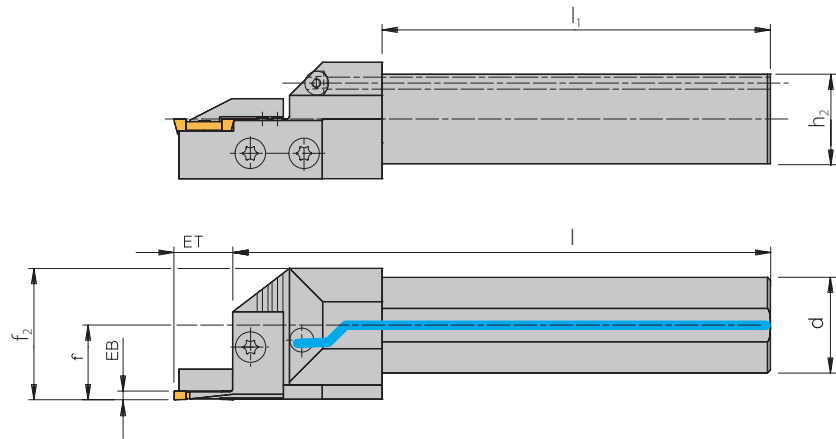
Axial-Steindreher gerade

Axial groove turning straight

Utensile dritto scanalatura e copiatura assiale



Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura



2

Grundhalter / Basic holder / Corpo utensile

Bezeichnung Designation Articolo	d	l	l ₁	f ₂	h ₂	f
732NC R/L*	32	180	130	44	30	25,0
740NC R/L*	40	240	190	45	38	25,0
750NC R/L*	50	300	250	55	48	30,0
37-50NC R/L**	50	300	240	56	48	31,5

*Bei Stechbreite 6 mm -> f = b + 0,5; übrige Stechbreiten f = b
*For width of cut 6 mm -> f = b + 0.5; for all others f = b
*Per larghezza di taglio di 6 mm -> f = b + 0,5; altre larghezze f = b

**Halter erst ab Durchmesser 60 mm verwendbar
**A holder can only be used with a diameter of 60 mm
**Questo utensile è previsto per un diametro minimo di lavoro di 60 mm

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	Nut-Außen-Ø OD of groove Ø est. di gola	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
732NC R/L 740NC R/L 750NC R/L	3	10	50 – 60	203S-5060 R/L Kontra	KAS3 R/L Kontra	320...	T 205	T 5120
	3	10	60 – 75	203S-6075 R/L Kontra	KAS3 R/L Kontra	320...	T 205	T 5120
	3	10	75 – 100	203S-75100 R/L Kontra	KAS3 R/L Kontra	320...	T 205	T 5120
	3	10	100 – 150	203S-100150 R/L Kontra	KAS3 R/L Kontra	320...	T 205	T 5120
	3	10	150 – 300	203S-150300 R/L Kontra	KAS3 R/L Kontra	320...	T 205	T 5120
	3	10	300 – 500	203S-300500 R/L Kontra	KAS3 R/L Kontra	320...	T 205	T 5120
	3	10	500 – ∞	203S-500XX R/L Kontra	KAS3 R/L Kontra	320...	T 205	T 5120
	3	17	50 – 60	UT3S-5060 R/L Kontra	KTS3 R/L Kontra	320...	T 205	T 5120
	3	17	60 – 75	UT3S-6075 R/L Kontra	KTS3 R/L Kontra	320...	T 205	T 5120
	3	17	75 – 100	UT3S-75100 R/L Kontra	KTS3 R/L Kontra	320...	T 205	T 5120
	3	17	100 – 150	UT3S-100150 R/L Kontra	KTS3 R/L Kontra	320...	T 205	T 5120
	3	17	150 – 300	UT3S-150300 R/L Kontra	KTS3 R/L Kontra	320...	T 205	T 5120
	3	17	300 – 500	UT3S-300500 R/L Kontra	KTS3 R/L Kontra	320...	T 205	T 5120
	3	17	500 – ∞	UT3S-500XX R/L Kontra	KTS3 R/L Kontra	320...	T 205	T 5120
	4	12	50 – 60	204S-5060 R/L Kontra	KAS4 R/L Kontra	422...	T 205	T 5120
	4	12	60 – 75	204S-6075 R/L Kontra	KAS4 R/L Kontra	422...	T 205	T 5120
	4	12	75 – 100	204S-75100 R/L Kontra	KAS4 R/L Kontra	422...	T 205	T 5120
	4	12	100 – 150	204S-100150 R/L Kontra	KAS4 R/L Kontra	422...	T 205	T 5120
4	12	150 – 300	204S-150300 R/L Kontra	KAS4 R/L Kontra	422...	T 205	T 5120	
4	12	300 – 500	204S-300500 R/L Kontra	KAS4 R/L Kontra	422...	T 205	T 5120	

Weiteres Zubehör auf der nächsten Seite
More accessories next page
Altri accessori nella pagina seguente

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Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	EB	ET	Nut-Außen-Ø OD of groove Ø est. di gola	U-Platte Support blade Lama	Klemme Clamp Staffa	Schneideinsatz Insert Inserto	Schraube Screw Vite	Schlüssel Key Chiave
732NC R/L 740NC R/L 750NC R/L	4	12	500 – ∞	204S-500XX R/L Kontra	KAS4 R/L Kontra	422....	T 205	T 5120
	4	20	50 – 60	UT4S-5060 R/L Kontra	KTS4 R/L Kontra	422....	T 205	T 5120
	4	20	60 – 75	UT4S-6075 R/L Kontra	KTS4 R/L Kontra	422....	T 205	T 5120
	4	20	75 – 100	UT4S-75100 R/L Kontra	KTS4 R/L Kontra	422....	T 205	T 5120
	4	20	100 – 150	UT4S-100150 R/L Kontra	KTS4 R/L Kontra	422....	T 205	T 5120
	4	20	150 – 300	UT4S-150300 R/L Kontra	KTS4 R/L Kontra	422....	T 205	T 5120
	4	20	300 – 500	UT4S-300500 R/L Kontra	KTS4 R/L Kontra	422....	T 205	T 5120
	4	20	500 – ∞	UT4S-500XX R/L Kontra	KTS4 R/L Kontra	422....	T 205	T 5120
	5	15	50 – 60	205S-5060 R/L Kontra	KAS5 R/L Kontra	525....	T 205	T 5120
	5	15	60 – 75	205S-6075 R/L Kontra	KAS5 R/L Kontra	525....	T 205	T 5120
	5	15	75 – 100	205S-75100 R/L Kontra	KAS5 R/L Kontra	525....	T 205	T 5120
	5	15	100 – 150	205S-100150 R/L Kontra	KAS5 R/L Kontra	525....	T 205	T 5120
	5	15	150 – 300	205S-150300 R/L Kontra	KAS5 R/L Kontra	525....	T 205	T 5120
	5	15	300 – 500	205S-300500 R/L Kontra	KAS5 R/L Kontra	525....	T 205	T 5120
	5	15	500 – ∞	205S-500XX R/L Kontra	KAS5 R/L Kontra	525....	T 205	T 5120
	5	23	50 – 60	UT5S-5060 R/L Kontra	KTS5 R/L Kontra	525....	T 205	T 5120
	5	23	60 – 75	UT5S-6075 R/L Kontra	KTS5 R/L Kontra	525....	T 205	T 5120
	5	23	75 – 100	UT5S-75100 R/L Kontra	KTS5 R/L Kontra	525....	T 205	T 5120
	5	23	100 – 150	UT5S-100150 R/L Kontra	KTS5 R/L Kontra	525....	T 205	T 5120
	5	23	150 – 300	UT5S-150300 R/L Kontra	KTS5 R/L Kontra	525....	T 205	T 5120
	5	23	300 – 500	UT5S-300500 R/L Kontra	KTS5 R/L Kontra	525....	T 205	T 5120
	5	23	500 – ∞	UT5S-500XX R/L Kontra	KTS5 R/L Kontra	525....	T 205	T 5120
	6	20	50 – 60	206S-5060 R/L Kontra	KAS6 R/L Kontra	630....	T 205	T 5120
	6	20	60 – 75	206S-6075 R/L Kontra	KAS6 R/L Kontra	630....	T 205	T 5120
	6	20	75 – 100	206S-75100 R/L Kontra	KAS6 R/L Kontra	630....	T 205	T 5120
	6	20	100 – 150	206S-100150 R/L Kontra	KAS6 R/L Kontra	630....	T 205	T 5120
	6	20	150 – 300	206S-150300 R/L Kontra	KAS6 R/L Kontra	630....	T 205	T 5120
	6	20	300 – 500	206S-300500 R/L Kontra	KAS6 R/L Kontra	630....	T 205	T 5120
	6	20	500 – ∞	206S-500XX R/L Kontra	KAS6 R/L Kontra	630....	T 205	T 5120
	6	28	50 – 60	UT6S-5060 R/L Kontra	KTS6 R/L Kontra	630....	T 205	T 5120
	6	28	60 – 75	UT6S-6075 R/L Kontra	KTS6 R/L Kontra	630....	T 205	T 5120
	6	28	75 – 100	UT6S-75100 R/L Kontra	KTS6 R/L Kontra	630....	T 205	T 5120
	6	28	100 – 150	UT6S-100150 R/L Kontra	KTS6 R/L Kontra	630....	T 205	T 5120
	6	28	150 – 300	UT6S-150300 R/L Kontra	KTS6 R/L Kontra	630....	T 205	T 5120
	6	28	300 – 500	UT6S-300500 R/L Kontra	KTS6 R/L Kontra	630....	T 205	T 5120
	6	28	500 – ∞	UT6S-500XX R/L Kontra	KTS6 R/L Kontra	630....	T 205	T 5120
37-50NC R/L	8	25	75 – 100	308S-75100 R/L Kontra	KAS8 R/L Kontra	838....	T 206	T 5120
	8	25	100 – 150	308S-100150 R/L Kontra	KAS8 R/L Kontra	838....	T 206	T 5120
	8	25	150 – 300	308S-150300 R/L Kontra	KAS8 R/L Kontra	838....	T 206	T 5120
	8	25	300 – 500	308S-300500 R/L Kontra	KAS8 R/L Kontra	838....	T 206	T 5120
	8	25	500 – ∞	308S-500XX R/L Kontra	KAS8 R/L Kontra	838....	T 206	T 5120
	8	32	75 – 100	UT8S-75100 R/L Kontra	KTS8 R/L Kontra	838....	T 206	T 5120
	8	32	100 – 150	UT8S-100150 R/L Kontra	KTS8 R/L Kontra	838....	T 206	T 5120
	8	32	150 – 300	UT8S-150300 R/L Kontra	KTS8 R/L Kontra	838....	T 206	T 5120
	8	32	300 – 500	UT8S-300500 R/L Kontra	KTS8 R/L Kontra	838....	T 206	T 5120
	8	32	500 – ∞	UT8S-500XX R/L Kontra	KTS8 R/L Kontra	838....	T 206	T 5120
	10	35	75 – 100	310S-75100 R/L Kontra	KAS10 R/L Kontra	1046....	T 206	T 5120
	10	35	100 – 150	310S-100150 R/L Kontra	KAS10 R/L Kontra	1046....	T 206	T 5120
	10	35	150 – 300	310S-150300 R/L Kontra	KAS10 R/L Kontra	1046....	T 206	T 5120
	10	35	300 – 500	310S-300500 R/L Kontra	KAS10 R/L Kontra	1046....	T 206	T 5120
	10	35	500 – ∞	310S-500XX R/L Kontra	KAS10 R/L Kontra	1046....	T 206	T 5120
	10	42	75 – 100	UT10S-75100 R/L Kontra	KTS10 R/L Kontra	1046....	T 206	T 5120
	10	42	100 – 150	UT10S-100150 R/L Kontra	KTS10 R/L Kontra	1046....	T 206	T 5120
	10	42	150 – 300	UT10S-150300 R/L Kontra	KTS10 R/L Kontra	1046....	T 206	T 5120
	10	42	300 – 500	UT10S-300500 R/L Kontra	KTS10 R/L Kontra	1046....	T 206	T 5120
	10	42	500 – ∞	UT10S-500XX R/L Kontra	KTS10 R/L Kontra	1046....	T 206	T 5120

Grundhalter werden mit Schrauben und Schlüssel geliefert, jedoch ohne U-Platte und Klemme.
Basic holders will be supplied with screws and key, however without support blade and clamp.
Gli steli sono forniti completi di viti e una chiave ma senza staffa e lama.

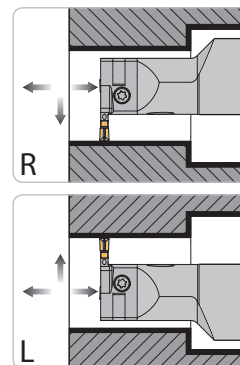


Innenstechdrehen

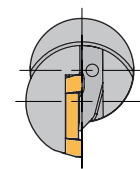
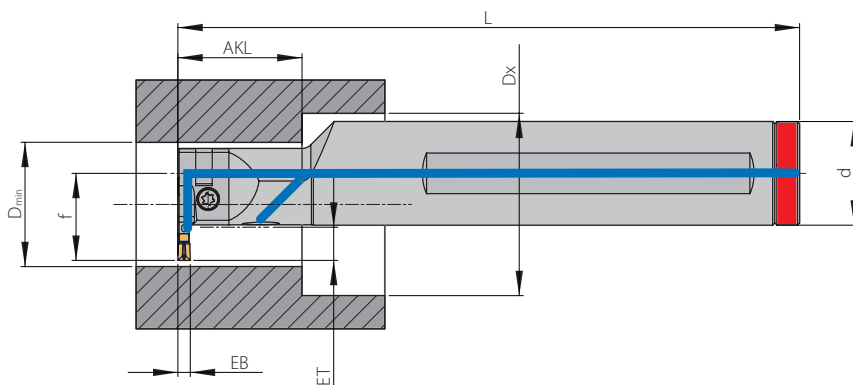
Internal groove turning

Scanalatura e copiatura interna

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Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura



Grundhalter / Basic holder / Corpo utensile

Bezeichnung Designation Articolo	D _{min}	EB	ET	AKL	d	L	f	D _x	Schneideinsatz Insert Inserto
SIN20M-045-20-16 R/L	16	2	4,5	20	16	110	13,0	27,5	212...
SIN20M-045-30-16 R/L	16	2	4,5	30	16	110	13,0	27,5	212...
SIN30M-055-27-20 R/L	20	3	5,5	27	20	135	16,5	33,0	316...
SIN30M-055-40-20 R/L	20	3	5,5	40	20	135	16,5	33,0	316...
SIN30-080-30-20 R/L	28	3	8,0	30	20	135	18,5	31,0	320...
SIN30-080-50-20 R/L	28	3	8,0	50	20	135	18,5	31,0	320...
SIN30-080-30-25 R/L	28	3	8,0	30	25	150	21,0	41,0	320...
SIN30-080-50-25 R/L	28	3	8,0	50	25	150	21,0	41,0	320...
SIN30-110-30-25 R/L	32	3	11,0	30	25	150	24,0	43,0	320...
SIN30-110-50-25 R/L	32	3	11,0	50	25	150	24,0	43,0	320...

Grundhalter und Zubehör / Basic holder and accessories / Corpo utensile e accessori

Grundhalter Basic holder Corpo utensile	Schraube Screw Vite	Verschlussring Locking Ring Anello di tenuta
SIN20M-....-16 R/L	AS 0018	KVR16
SIN30M-....-20 R/L	AS 0019	KVR20
SIN30-....-20 R/L	SS 1111	KVR20
SIN30-....-25 R/L	SS 1111	KVR25

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Standardausführung

- präzisionsgeschliffener Schneideinsatz
- zweiseitig
- spezielle Geometrie zur Spaneinschnürung
- zum Einstechen bei kleinen bis mittleren Spanquerschnitten
- geringe Schnittkräfte durch scharfe Schneidkante
- für eine Vielzahl von Werkstückstoffen
- für Innen- und Außenbearbeitung

Standard geometry

- precision ground insert
- two cutting edges
- special geometry with chip-contraction
- for grooving with small to medium chip-cross-section
- low cutting forces because of sharp cutting edges
- for a number of workpiece materials
- for internal and external machining

Esecuzione standard

- inserto rettificato di precisione
- 2 taglienti
- geometria speciale adatta alla contrazione del truciolo
- per una scanalatura di sezioni di truciolo piccole e medie
- taglio dolce per il tagliente affilato
- adatto ad un vasto numero di materiali
- uso interno ed esterno

Kopierausführung -12

- präzisionsgeschliffener Schneideinsatz
- zweiseitig
- spezielle Geometrie zur Spaneinschnürung
- mit 12° positivem Spanwinkel an allen drei Hauptschneiden
- Anwendung entspricht der Standardausführung, jedoch zusätzlich zum Kopierdrehen bei mittleren Spanquerschnitten
- für Innen- und Außenbearbeitung

Geometry for copying -12

- precision ground insert
- two cutting edges
- special geometry for chip-contraction
- 12° positive rake angle on all three cutting edges
- same application as standard execution, but also for copy-turning with medium chip-cross-section
- for internal and external machining

Geometria di copiatura -12

- inserto rettificato di precisione
- 2 taglienti
- geometria speciale adatta alla contrazione del truciolo
- angolo di taglio a 12° positivo, tri-direzionale
- medesima applicazione dell'esecuzione standard, ma adatto alla tornitura di sezioni di truciolo piccole e medie
- uso interno ed esterno

AM-Geometrie

- präzisionsgesinterter 2-seitiger Schneideinsatz
- Schneideinsatz zum Stechdrehen, Ein- und Abstechen
- hohe Zerspanungsleistung durch stabile Schneidkante
- geringe Schnittkräfte durch positive Schneidengeometrie
- für Innen- und Außenbearbeitung

AM geometry

- precision sintered twin edge inserts
- inserts for groove turning, cut in and withdraw
- considerable chip removal via stable cutting edge
- minimum cutting force via positive cutting geometry
- for internal and external machining

Geometria AM

- inserto sinterizzato a 2 tagli
- inserto per tornitura di scanalatura
- considerevole volume di truciolo grazie alla stabilità del tagliente
- taglio dolce per la geometria di taglio positiva
- uso interno ed esterno

Vollradiusausführung V

- präzisionsgeschliffener Schneideinsatz
- zweiseitig
- Vollradius
- für Einstiche und Nachkopieroperationen bei kleinen Spanquerschnitten
- Zerspanung kurzspanender Werkstoffe
- für Innen- und Außenbearbeitung

Full radius execution V

- precision ground insert
- two cutting edges
- full radius
- for grooving and copy-turning operations with small chip-cross-section
- machining of short chipping materials
- for internal and external machining

Esecuzione a raggio completo V

- inserto rettificato di precisione
- 2 taglienti
- raggio completo
- per scanalatura e copiatura di ridotte sezioni di taglio
- lavorazione di materiali a truciolo corto
- uso interno ed esterno

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Vollradiusausführung VK

- präzisionsgeschliffener Schneideinsatz
- zweiseitig, Vollradius
- für Einstiche und Nachkopieroperationen bei entsprechenden Konturen bis mittlere Spanquerschnitte

Besonderheit:

- spezielle Spanformgeometrie für kontrollierten Spanbruch auch bei langspanenden Werkstoffen
- für Innen- und Außenbearbeitung

Full radius execution VK

- precision ground insert
- two cutting edges, full radius
- for grooving and copy-turning operations up to medium chip-cross-section

Particularity:

- special chipbreaker for controlled-chipbreaking when machining long chipping materials
- for internal and external machining

Esecuzione a raggio completo VK

- inserto rettificato di precisione
- 2 taglienti, raggio completo
- per scanalatura e copiatura di sezioni di truciolo medie

Particolarità:

- geometria adatta al controllo del truciolo di materiali a truciolo lungo
- uso interno ed esterno

2



Aluminiumausführung -ALU

- präzisionsgeschliffener Schneideinsatz
- zweiseitig
- spezielle Geometrie zur Spaneinschnürung
- mit 25° positivem Spanwinkel an allen drei Hauptschneiden
- für Einstich- und Kopierarbeiten bei NE-Metallen und Kunststoff
- für Innen- und Außenbearbeitung

Aluminium type -ALU

- precision ground insert
- two cutting edges
- special geometry for chip-contraction
- 25° positive rake angle on all three cutting edges
- grooving and copy-turning of non-ferrous materials and plastics
- for internal and external machining

Geometria -ALU

- inserto rettificato di precisione
- 2 taglienti
- geometria adatta specificamente alla contrazione del truciolo
- angolo di taglio a 25° positivo, tri-direzionale
- per scanalatura e copiatura di materiali non ferrosi e plastici
- uso interno ed esterno



Ausführung für Sicherungsringeinstiche

- präzisionsgeschliffener Schneideinsatz
- zweiseitig
- für alle Einstiche nach DIN 471/472 unter Verwendung von nur einer Unterstützplatte
- für Innen- und Außenbearbeitung

Circlip grooves execution

- precision ground insert
- two cutting edges
- for all grooves to DIN 471/472 by using only one support blade for all widths
- for internal and external machining

Esecuzioni per canali

- inserto rettificato di precisione
- 2 taglienti
- per gole secondo norma DIN 471/472 usando una sola lama per tutti gli spessori
- uso interno ed esterno

Beschichtet / Coated / Rivestito

AM27C

CVD-Mehrlagenbeschichtung

Bearbeitung von Stahl, Stahlguss mit mittleren bis hohen Schnittgeschwindigkeiten, mittleren bis großen Spanquerschnitten und wechselnden Schnitttiefen. Speziell einsetzbar für Stähle mit starker Verklebneigung. Einsatz im Schlicht- und mittleren Schruppbereich.

CVD-multilayer coating

Machining steel, cast steel as well as grey cast iron, at medium to high cutting speeds, medium to large chip-cross-sections and varying depths of cut. Used for finishing and medium roughing.

Rivestimento multistrato CVD

Lavorazione di acciaio, acciaio da fusione con velocità di taglio da medie ad elevate, sezioni di truciolo medie e larghe e profondità di taglio varie. Per finitura e media sgrassatura.

AM35C

CVD-Mehrlagenbeschichtung

Bearbeitung von Stahl, rostfreiem Stahl sowie Stahlguss bei mittleren bis großen Spanquerschnitten und mittleren bis geringen Schnittgeschwindigkeiten unter ungünstigen Bearbeitungsbedingungen und hohen Zähigkeitsanforderungen.

CVD-multilayer coating

Machining steel, stainless steel and cast steel, at medium to large chip-cross-sections and medium to low cutting speeds under unfavourable machining conditions where good toughness is required.

Rivestimento multistrato CVD

Lavorazione di acciaio inossidabile e acciaio da fusione per sezioni di taglio medie e grandi e velocità di taglio medie e basse. In condizioni di lavorazione non favorevoli quando è richiesta una buona tenacità.

AM350

CVD-Mehrlagenbeschichtung

Zur Bearbeitung von Stahl und Stahlguss mit hohen Schnittgeschwindigkeiten, mittleren bis hohen Spanquerschnitten und wechselnden Schnitttiefen. Verschleißfeste Sorte durch speziell aufeinander abgestimmtes Substrat und Beschichtung. Einsatz im Schlicht- und mittleren Schruppbereich.

CVD-multilayer coating

Grade with a good combination of wear resistance and toughness for turning steel, stainless steel as well as cast steel at medium chip-cross-sections and medium to high cutting speeds. Can also be used under unfavourable machining conditions. Special grade for stainless steel (austenitic). Apply in finishing and medium roughing applications.

Rivestimento multistrato CVD

Grado resistente all'usura, buona tenacità per la tornitura dell'acciaio, acciaio inossidabile, sezioni di taglio medie, velocità di taglio medie ed elevate, in condizioni di lavoro non favorevoli. Grado particolarmente adatto a acciai austenitici ed acciai inossidabili.

AM5035

PVD-Mehrlagenbeschichtung

Eine verbesserte PVD-Beschichtung auf einem zähen und verschleißfesten Hartmetallsubstrat. Mit einem höheren Kobaltgehalt verfügt diese Sorte über die nötige Zähigkeit, um den Ansprüchen beim Ein- und Abstechen gerecht zu werden. AM5035 ist ausgezeichnet für die Bearbeitung der meisten Stähle, nichtrostenden Stählen und schwer zerspanbaren Stählen.

PVD-multilayer coating

An improved PVD coating on a tough and wear resistant carbide grade. Due to the higher cobalt content this grade contains all the required toughness for part-off and grooving applications. AM5035 is excellent at machining most steel, stainless steel and hard to machine materials.

Rivestimento multiplo PVD

Un rivestimento PVD di ultima generazione, su base di metallo duro resistente all'usura e con una buona tenacità. Grazie all'elevato contenuto di cobalto, questa qualità ha la tenacità necessaria per la lavorazione di gole e per la tronatura. La qualità AM5035 è indicata per la lavorazione della maggior parte degli acciai, dell'acciaio inossidabile, della ghisa e di materiali difficili da lavorare.

AR17C

CVD-Mehrlagenbeschichtung

Bearbeitung von Grauguss, Gusseisen mit Kugelgraphit und Hartguss. Auch geeignet für rostfreien Stahl, Stahl und Stahlguss bei mittleren bis höchsten Schnittgeschwindigkeiten. Einsatz im Schlicht- und unteren Schruppbereich.

CVD-multilayer coating

For machining grey cast iron, cast iron with graphite and hard cast material. Also suitable for stainless steel, steel and cast steel at medium to high cutting speed. Apply in finishing and lighter roughing applications.

Rivestimento multistrato CVD

Lavorazione della ghisa, ghisa sferoidale, ghisa temperata, acciaio, fusioni d'acciaio a velocità di taglio medie, elevate e molto elevate; per finitura e tagli medi.

AR27C

CVD-Mehrlagenbeschichtung

Bearbeitung von Stahl, Stahlguss, rostfreiem Stahl, Gusseisen mit Kugelgraphit sowie Grauguss mit hohen Schnittgeschwindigkeiten unter stabilen Bearbeitungsbedingungen.

CVD-multilayer coating

Machining of steel, stainless steel, spheroidal cast iron, cast steel and grey cast iron at high cutting speeds under stable machining conditions.

Rivestimento multistrato CVD

Lavorazione dell'acciaio, acciaio inossidabile, ghisa sferoidale, fusioni d'acciaio a velocità di taglio elevate in condizioni di taglio stabili.

Beschichtet / Coated / Rivestito

AT10

PVD-Mehrlagenbeschichtung

Zur Bearbeitung von Aluminium und Aluminiumlegierungen, Kupfer, Bronze, NE-Metallen und hochschmelzenden Werkstoffen bei mittleren Spanquerschnitten und unter ungünstigen Bearbeitungsbedingungen. Auch geeignet für rostfreie Stähle.

PVD-multilayer coating

Grade for machining aluminium and aluminium-alloy, copper, brass, non-ferrous materials and refractory metals at medium cutting and under unfavourable cutting conditions. Also suitable for stainless steel.

Rivestimento multistrato PVD

Per lavorare l'alluminio e sue leghe, il rame, il bronzo, materiali non ferrosi, e metalli refrattari (per esempio Niobio, Tantalio, Molibdeno, Wolframio) per sezioni di taglio medie e in condizioni di taglio non favorevoli.

Unbeschichtet / Uncoated / Non rivestito

AK10

Feinkorn-Hartmetall zur Bearbeitung von Gusswerkstoffen, Leicht- und Buntmetallen, hochschmelzenden Metallen und gehärteten Stählen bis 55 HRC. In Verbindung mit der Spanleitstufengeometrie-ALU besonders für das Stechdrehen von Al und Cu-Legierungen zu empfehlen.

Submicron carbide grade for machining cast materials, light and non-ferrous materials, refractory metals, hardened steels up to 55 HRC. In connection with chipbreaker-ALU specially suitable for machining Al- and Cu-alloys.

Metallo duro submicrograna per la lavorazione di fusioni, leghe leggere e non ferrose, metalli refrattari, metalli temprati fino a 55 HRC. Abbinato al rompitrucciolo-ALU è specificamente adatto per la lavorazione leghe di alluminio e rame.

CERMET

Bearbeitung von Stahl, Stählen mittlerer Festigkeit sowie rostfreiem Stahl und Gusseisen mit Kugelgraphit. Bedingt einsetzbar für Grauguss.

Machining of steel, steels with medium tensile strength as well as stainless steel and spheroidal cast iron. Limited use on grey cast iron.

Lavorazione dell'acciaio, acciai di durezza media come l'acciaio inossidabile e la ghisa sferoidale. Uso limitato sulla ghisa grigia.

AH7520 (CBN)

Bearbeitung von gehärteten Werkstoffen (sekundärharte Eisenwerkstoffe). Z. B.: Hartguss, gehärtete Stähle ab 50 HRC, Nihard und Stellite.

Machining of hardened materials (hardened steels). For example, hard cast iron, hardened steel from 50 HRC onwards, Nihard and stellite.

Lavorazione di materiali duri (acciai temprati). P.e. : ghisa temprata, acciaio temprato > 50 HRC, Nihard e stellite.

AN8020 (PKD)

Bearbeitung von NE-Metallen, Aluminiumlegierungen mit Siliziumanteilen, glas- und kohlefaserverstärkte Kunststoffe, Kugelgraphitguss bei hohen Schnittdaten. Durch die scharfe Schneidkante entstehen geringe Schnittdrücke und sehr gute Oberflächengüten bei extrem hoher Wärmeleitfähigkeit. Fein- und Feinstbearbeitung bei glattem und unterbrochenem Schnitt.

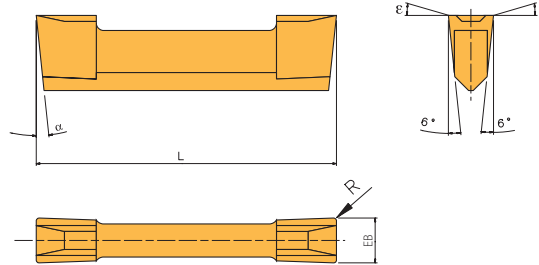
Machining of non-ferrous metals, aluminium alloys with silicon, glass- and coal-fiber reinforced materials, spheroidal cast iron, at high cutting speeds. Sharp cutting edges enable low cutting forces and extremely good surface finish. Finishing and super finishing even at interrupted cuts.

Lavorazione dei metalli non ferrosi, leghe d'alluminio con basso tenore di Silicio, materiali rinforzati al vetro e fibre di carbonio, a velocità di taglio elevate. Il tagliente affilato rende possibile bassi sforzi di taglio ed una finitura superficiale estremamente buona. Finitura e super finitura anche con taglio interrotto.

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NC-Standard

Standardausführung / Standard geometry / Esecuzione standard



Bezeichnung Designation Articolo	EB ± 0,02	L ± 0,02	α	R	ε	Anwendung Application Applicazione	Sorten / Grades / Gradi											
							beschichtet/ coated/rivestito					unbeschichtet uncoated non rivestito		hochhart ultra-hard extra duri				
							AM27C	AM35C	AM350	AM5035	AR17C	AR27C	AT10	AK10	CERMET	AH7520	AN8020	
21201	2,0	12,0	7/15°	0,1	12°	Außen und Innen External and internal Esterno ed interno	●	●	●	●	●			●		●		
21201FN	2,0	12,0	7/15°	0,1	0°												●	
21201TN	2,0	12,0	7/15°	0,1	0°												●	
21204	2,0	12,0	7/15°	0,4	12°			●		●								
31602	3,0	16,0	7/15°	0,2	12°			●	●	●	●	●			●			●
31602FN	3,0	16,0	7/15°	0,2	0°													●
31602TN	3,0	16,0	7/15°	0,2	0°													●
31604	3,0	16,0	7/15°	0,4	12°			●		●								
32002	3,0	20,0	6/16°	0,2	12°			●	●	●	●	●			●			●
32002FN	3,0	20,0	6/16°	0,2	0°													●
32002TN	3,0	20,0	6/16°	0,2	0°													●
32004	3,0	20,0	6/16°	0,4	12°			●		●								
42202	4,0	22,0	6/9,5°	0,2	12°			●	●	●	●	●			●			●
42202FN	4,0	22,0	6/9,5°	0,2	0°													●
42202TN	4,0	22,0	6/9,5°	0,2	0°													●
42204	4,0	22,0	6/9,5°	0,4	12°			●		●								
42210	4,0	22,0	6/9,5°	1,0	12°			●										
52502	5,0	25,0	6/8,5°	0,2	12°			●	●	●	●	●			●			●
52502FN	5,0	25,0	6/8,5°	0,2	0°													●
52502TN	5,0	25,0	6/8,5°	0,2	0°													●
52504	5,0	25,0	6/8,5°	0,4	12°		●		●									
63002	6,0	30,0	6°	0,2	12°		●	●	●	●	●			●			●	
63002FN	6,0	30,0	6°	0,2	0°												●	
63002TN	6,0	30,0	6°	0,2	0°												●	
63004	6,0	30,0	6°	0,4	12°		●		●									
63010	6,0	30,0	6°	1,0	12°		●											
83804	8,0	38,0	6°	0,4	12°		●	●	●	●				●			●	
83804FN	8,0	38,0	6°	0,4	0°												●	
83804TN	8,0	38,0	6°	0,4	0°												●	
104604	10,0	46,0	6°	0,4	12°		●	●	●	●				●			●	
104604FN	10,0	46,0	6°	0,4	0°												●	
104604TN	10,0	46,0	6°	0,4	0°												●	

Hinweis für AN8020 und AH7520: Einseitig bestückte Schneideinsätze mit einem Spanwinkel von 0°
Remark for AN8020 and AH7520 inserts: single-sided with a rake angle of 0°
Nota gli inserti AN8020 e AH7520 hanno un solo tagliente con un angolo di taglio di 0°

ε = Spanwinkel
Rake angle
Angolo di taglio

● Hauptanwendung
Main application
Applicazione principale
○ Nebenanwendung
Secondary application
Applicazione secondaria

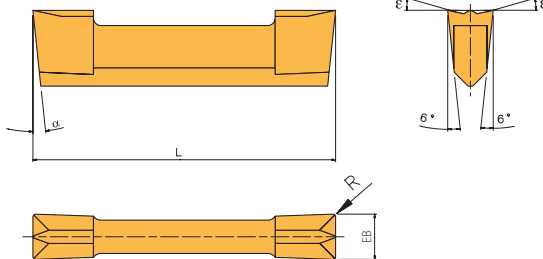
	P	M	K	N	S	H
AM27C	●	○	○	○	○	
AM35C	○	●	●	○	○	
AM350						
AM5035						
AR17C				●	●	
AR27C						
AT10						
AK10				●		
CERMET				●		
AH7520						●
AN8020						●



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NC-12

Kopierausführung / Geometry for copying / Geometria di copiatura



geschliffen
ground
rettificato

2

Bezeichnung Designation Articolo	EB ± 0,02	L ± 0,02	α	R	ε	Anwendung Application Applicazione	Sorten / Grades / Gradi										
							beschichtet/ coated/rivestito						unbeschichtet uncoated non rivestito		hochhart ultra-hard extra duri		
							AM27C	AM35C	AM350	AM5035	AR17C	AR27C	AT10	AK10	CERMET	AH7520	AN8020
21201-12	2,0	12,0	7/15°	0,1	12°	Außen und Innen External and internal Esterno ed interno	●	●	●						●		
21202-12	1,9	11,9	7/15°	0,2	12°		●	●							●		
31602-12	3,0	16,0	7/15°	0,2	12°		●	●		●					●		
31604-12	2,9	15,6	7/15°	0,4	12°										●		
32002-12	3,0	20,0	6/16°	0,2	12°		●	●		●					●		
32004-12	2,9	19,7	6/16°	0,4	12°										●		
42202-12	4,0	22,0	6/9,5°	0,2	12°		●	●		●					●		
42204-12	3,9	21,7	6/9,5°	0,4	12°										●		
52502-12	5,0	25,0	6/8,5°	0,2	12°		●	●		●					●		
52504-12	4,9	24,6	6/8,5°	0,4	12°										●		
63002-12	6,0	30,0	6°	0,2	12°	●	●		●								
83804-12	8,0	38,0	6°	0,4	12°	Nur Außen External only Solo esterno		●									
104604-12	10,0	46,0	6°	0,4	12°		●										

ε = Spanwinkel
Rake angle
Angolo di taglio

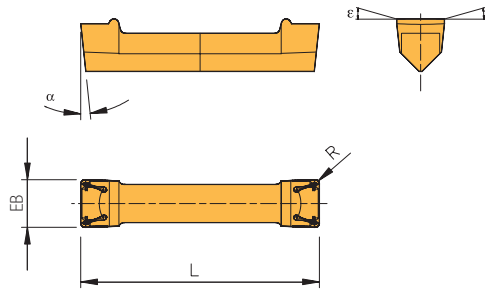
- Hauptanwendung
Main application
Applicazione principale
- Nebenanwendung
Secondary application
Applicazione secondaria

P	●	●		○		●	
M	○	○		●		○	
K						○	
N							
S	○	○		○			
H							

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NC-AM

Kopierausführung / Geometry for copying / Geometria di copiatura



gesintert
sintered
sinterizzato

Bezeichnung Designation Articolo	EB ± 0,05	L	α	R	ε	Anwendung Application Applicazione	Sorten / Grades / Gradi											
							beschichtet/ coated/rivestito						unbeschichtet uncoated non rivestito		hochhart ultra-hard extra duri			
							AM27C	AM35C	AM350	AM5035	AR17C	AR27C	AT10	AK10	CERMET	AH7520	AN8020	
21202-AM	2,06	12,0	6/15°	0,2	6°/20°	Außen und Innen External and internal Esterno ed interno	●	●	●	●								
31602-AM	3,06	16,0	6/15°	0,2	6°/20°		●	●	●	●								
32002-AM	3,06	20,0	6/15°	0,2	6°/20°		●	●	●	●								
42204-AM	4,06	22,0	6/9,5°	0,4	6°/20°		●	●	●	●								
52504-AM	5,06	25,0	6/8,5°	0,4	6°/20°		●	●	●	●								
63008-AM	6,06	30,0	6°	0,8	6°/20°	Nur Außen External only Solo esterno	●	●	●	●								
83808-AM	8,06	38,0	6°	0,8	6°/20°		●	●	●	●								
104608-AM	10,07	46,0	6°	0,8	6°/20°		●	●	●	●								

ε = Spanwinkel
Rake angle
Angolo di taglio

- **Hauptanwendung**
Main application
Applicazione principale
- **Nebenanwendung**
Secondary application
Applicazione secondaria

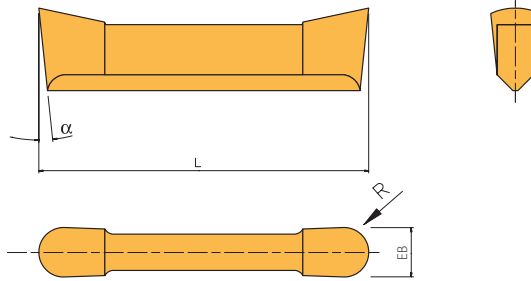
	P	M	K	N	S	H
AM27C	●	○				
AM35C	○	●				
AM350						
AM5035						
AR17C						
AR27C						
AT10						
AK10						
CERMET						
AH7520						
AN8020						



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NC-V

Vollradiusausführung / Full radius execution / Esecuzione a raggio completo



2

Bezeichnung Designation Articolo	EB ± 0,02	L ± 0,02	α	R	ε	Anwendung Application Applicazione	Sorten / Grades / Gradi											
							beschichtet/ coated/ripestito					unbeschichtet uncoated non rivestito		hochhart ultra-hard extra duri				
							AM27C	AM35C	AM350	AM5035	AR17C	AR27C	AT10	AK10	CERMET	AH7520	AN8020	
21210V	2,0	12,0	7/15°	1,0	12°	Außen und Innen External and internal Esterno ed interno		●						●			●	
21210V-FN	2,0	12,0	7/15°	1,0	0°													●
21210V-TN	2,0	12,0	7/15°	1,0	0°													●
31615V	3,0	16,0	7/15°	1,5	12°			●							●			●
31615V-FN	3,0	16,0	7/15°	1,5	0°													●
31615V-TN	3,0	16,0	7/15°	1,5	0°													●
32015V	3,0	20,0	6/16°	1,5	10°			●							●			●
32015V-FN	3,0	20,0	6/16°	1,5	0°													●
32015V-TN	3,0	20,0	6/16°	1,5	0°													●
42220V	4,0	22,0	6/9,5°	2,0	10°			●							●			●
42220V-FN	4,0	22,0	6/9,5°	2,0	0°													●
42220V-TN	4,0	22,0	6/9,5°	2,0	0°													●
52525V	5,0	25,0	6/8,5°	2,5	10°			●							●			●
52525V-FN	5,0	25,0	6/8,5°	2,5	0°													●
52525V-TN	5,0	25,0	6/8,5°	2,5	0°													●
63030V	6,0	30,0	6°	3,0	10°		●							●			●	
63030V-FN	6,0	30,0	6°	3,0	0°												●	
63030V-TN	6,0	30,0	6°	3,0	0°												●	
83840V	8,0	38,0	6°	4,0	10°		●							●			●	
83840V-FN	8,0	38,0	6°	4,0	0°												●	
83840V-TN	8,0	38,0	6°	4,0	0°												●	
104650V	10,0	46,0	6°	5,0	10°		●							●			●	
104650V-FN	10,0	46,0	6°	5,0	0°												●	
104650V-TN	10,0	46,0	6°	5,0	0°												●	

Achtung: Beim Einsatz von Schneideinsätzen in Vollradiusausführung muss die Unterstutzplatte abgeändert werden.
 Attention: The use of full radius inserts require a slightly modified support blade.
 Attenzione: l'utilizzo degli inserti a raggio completo rende necessaria una modifica della lama.

Hinweis für AN8020 und AH7520: Einseitig bestückte Schneideinsätze mit einem Spanwinkel von 0°
 Remark for AN8020 and AH7520 inserts: single-sided with a rank angle of 0°
 Nota gli inserti AN8020 e AH7520 hanno un solo tagliente con un angolo di taglio di 0°

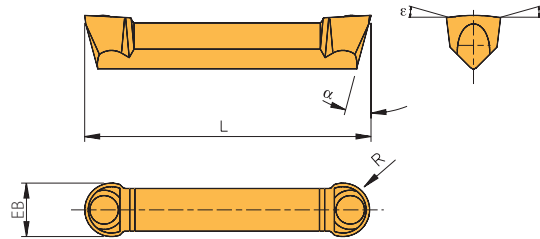
ε = Spanwinkel
 Rake angle
 Angolo di taglio

- Hauptanwendung
Main application
Applicazione principale
- Nebenanwendung
Secondary application
Applicazione secondaria

P	●		
M	○		
K		●	
N		●	●
S	○	○	
H			●

NC-VK

Vollradiusausführung / Full radius execution / Esecuzione a raggio completo



Bezeichnung Designation Articolo	EB ± 0,02	L ± 0,02	α	R	ε	Anwendung Application Applicazione	Sorten / Grades / Gradi											
							beschichtet/ coated/rivestito						unbeschichtet uncoated non rivestito		hochhart ultra-hard extra duri			
							AM27C	AM35C	AM350	AM5035	AR17C	AR27C	AT10	AK10	CERMET	AH7520	AN8020	
21210VK	2,0	12,0	7/15°	1,0	3°	Außen und Innen External and internal Esterno ed interno		●	●				●	●				
31615VK	3,0	16,0	7/15°	1,5	3°			●	●				●	●				
32015VK	3,0	20,0	6/16°	1,5	3°			●	●				●	●				
42220VK	4,0	22,0	6/9,5°	2,0	3°			●	●				●	●				
52525VK	5,0	25,0	6/8,5°	2,5	3°			●	●				●	●				
63030VK	6,0	30,0	6°	3,0	3°	Nur Außen External only Solo esterno		●	●				●	●				
83840VK	8,0	38,0	6°	4,0	3°			●	●				●	●				
104650VK	10,0	46,0	6°	5,0	3°			●	●				●	●				

Achtung: Beim Einsatz von Schneideinsätzen in Vollradiusausführung muss die Unterstutzplatte abgeändert werden.
 Attention: The use of full radius inserts require a slightly modified support blade.
 Attenzione: l'utilizzo degli inserti a raggio completo rende necessaria una modifica della lama.

ε = Spanwinkel
 Rake angle
 Angolo di taglio

- Hauptanwendung
Main application
Applicazione principale
- Nebenanwendung
Secondary application
Applicazione secondaria

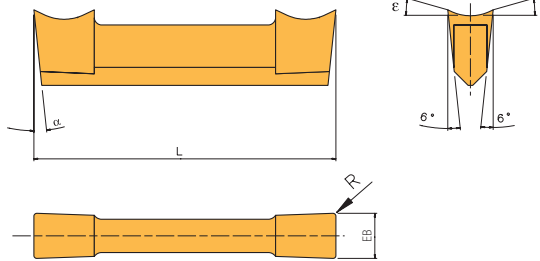
	P	M	K	N	S	H
AM27C	●	○				
AM35C	○	●				
AM350			●			
AM5035				○		
AR17C				●		
AR27C				●		
AT10				○		
AK10				●	●	
CERMET						
AH7520						
AN8020						



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NC-ALU

Aluminiumausführung / Aluminium geometry / Geometria alluminio



2

Bezeichnung Designation Articolo	EB ± 0,02	L ± 0,02	α	R	ε	Anwendung Application Applicazione	Sorten / Grades / Gradi											
							beschichtet/ coated/rivestito					unbeschichtet uncoated non rivestito		hochhart ultra-hard extra duri				
							AM27C	AM35C	AM350	AM5035	AR17C	AR27C	AT10	AK10	CERMET	AH7520	AN8020	
21201-ALU	2,0	12,0	8/15°	0,1	25°	Außen und Innen External and internal Esterno ed interno							●	●				
31602-ALU	3,0	16,0	8/15°	0,2	25°									●	●			
32002-ALU	3,0	20,0	8/16°	0,2	25°									●	●			
42202-ALU	4,0	22,0	8°	0,2	25°									●	●			
52502-ALU	5,0	25,0	8°	0,2	25°									●	●			
63002-ALU	6,0	30,0	8°	0,2	25°		●						●	●				
83804-ALU	8,0	38,0	8°	0,4	25°	Nur Außen External only Solo esterno							●	●				
104604-ALU	10,0	46,0	8°	0,4	25°									●	●			

ε = Spanwinkel
Rake angle
Angolo di taglio

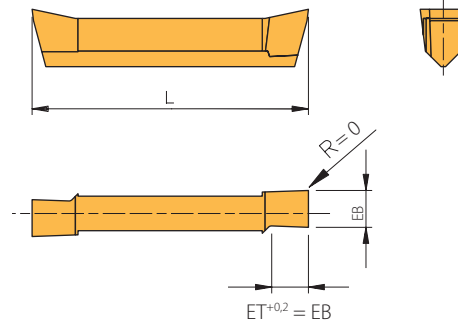
- Hauptanwendung
Main application
Applicazione principale
- Nebenanwendung
Secondary application
Applicazione secondaria

	P	M	K	N	S	H
	●	○				
				○		
				●		
				●		
				●	●	
				○	○	

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NC-DIN471

Ausführung für Sicherungsringeinstiche / Circlip inserts /
Inserti per sedi seeger



Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

Bezeichnung Designation Articolo	EB ± 0,05	L ± 0,03	ε	Anwendung Application Applicazione	Sorten / Grades / Gradi											
					beschichtet/ coated/rivestito					unbeschichtet uncoated non rivestito		hochhart ultra-hard extra duri				
					AM27C	AM35C	AM350	AM5035	AR17C	AR27C	AT10	AK10	CERMET	AH7520	AN8020	
2-04/471 R/L	0,55	12,0	12°	Außen- und Innenbearbeitung External and internal use Per uso esterno ed interno		●						●				
2-06/471 R/L	0,75	12,0	12°			●							●			
2-07/471 R/L	0,85	12,0	12°			●							●			
2-08/471 R/L	0,95	12,0	12°			●							●			
2-10/471 R/L	1,15	12,0	12°			●							●			
2-12/471 R/L	1,35	12,0	12°			●							●			
2-15/471 R/L	1,65	12,0	12°			●							●			
2-175/471 R/L	1,90	12,0	12°			●							●			
3-04/471 R/L	0,55	20,0	12°			●							●			
3-06/471 R/L	0,75	20,0	12°			●							●			
3-07/471 R/L	0,85	20,0	12°			●							●			
3-08/471 R/L	0,95	20,0	12°			●							●			
3-10/471 R/L	1,15	20,0	12°			●							●			
3-12/471 R/L	1,35	20,0	12°			●							●			
3-15/471 R/L	1,65	20,0	12°			●							●			
3-175/471 R/L	1,90	20,0	12°			●							●			
3-20/471 R/L	2,20	20,0	12°			●							●			
3-25/471 R/L	2,70	20,0	12°			●							●			
3-30/471 R/L	3,13	20,0	12°			●							●			
3M-04/471 R/L	0,55	16,0	12°			●										
3M-06/471 R/L	0,75	16,0	12°			●										
3M-07/471 R/L	0,85	16,0	12°			●										
3M-08/471 R/L	0,95	16,0	12°			●										
3M-10/471 R/L	1,15	16,0	12°			●										
3M-12/471 R/L	1,35	16,0	12°			●										
3M-15/471 R/L	1,65	16,0	12°			●										
3M-175/471 R/L	1,90	16,0	12°			●										
3M-20/471 R/L	2,20	16,0	12°			●										
3M-25/471 R/L	2,70	16,0	12°			●										
3M-30/471 R/L	3,13	16,0	12°			●										

ε = Spanwinkel
Rake angle
Angolo di taglio

- **Hauptanwendung**
Main application
Applicazione principale
- **Nebenanwendung**
Secondary application
Applicazione secondaria

P	●			
M	○			
K		●		
N		●		
S	○		○	
H				

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2

Artikel / Item / Articolo
U-Platte / Support blade / Spina staffa
10208 R/L
102-2530 R/L
102-3040 R/L
102-4050 R/L
102-5060 R/L
102-6075 R/L
102-75100 R/L
102-100150 R/L
102-150300 R/L
102-300500 R/L
10312 R/L
103-2530 R/L
103-3040 R/L
103-4050 R/L
103-5060 R/L
103-6075 R/L
103-75100 R/L
103-100150 R/L
103-150300 R/L
103-300500 R/L
20306 R/L
20310 R/L
203-5060 R/L
203-6075 R/L
203-75100 R/L
203-100150 R/L
203-150300 R/L
203-300500 R/L
203-500XX R/L
203S-5060 R/L Kontra
203S-6075 R/L Kontra
203S-75100 R/L Kontra
203S-100150 R/L Kontra
203S-150300 R/L Kontra
203S-300500 R/L Kontra
203S-500XX R/L Kontra
20408 R/L
20412 R/L
204-5060 R/L
204-6075 R/L
204-75100 R/L
204-100150 R/L
204-150300 R/L
204-300500 R/L
204-500XX R/L
204S-5060 R/L Kontra
204S-6075 R/L Kontra
204S-75100 R/L Kontra
204S-100150 R/L Kontra
204S-150300 R/L Kontra
204S-300500 R/L Kontra
204S-500XX R/L Kontra
20511 R/L
20515 R/L
205-5060 R/L
205-6075 R/L
205-75100 R/L
205-100150 R/L
205-150300 R/L
205-300500 R/L
205-500XX R/L
205S-5060 R/L Kontra
205S-6075 R/L Kontra
205S-75100 R/L Kontra
205S-100150 R/L Kontra
205S-150300 R/L Kontra
205S-300500 R/L Kontra
205S-500XX R/L Kontra
20620 R/L
206-5060 R/L
206-6075 R/L
206-75100 R/L
206-100150 R/L
206-150300 R/L
206-300500 R/L
206-500XX R/L
206S-5060 R/L Kontra
206S-6075 R/L Kontra

Artikel / Item / Articolo
U-Platte / Support blade / Spina staffa
206S-75100 R/L Kontra
206S-100150 R/L Kontra
206S-150300 R/L Kontra
206S-300500 R/L Kontra
206S-500XX R/L Kontra
30817 R/L
308-75100 R/L
308-100150 R/L
308-150300 R/L
308-300500 R/L
308-500XX R/L
308S-75100 R/L Kontra
308S-100150 R/L Kontra
308S-150300 R/L Kontra
308S-300500 R/L Kontra
308S-500XX R/L Kontra
31025 R/L
310-75100 R/L
310-100150 R/L
310-150300 R/L
310-300500 R/L
310-500XX R/L
310S-75100 R/L Kontra
310S-100150 R/L Kontra
310S-150300 R/L Kontra
310S-300500 R/L Kontra
310S-500XX R/L Kontra
9-20310 R/L
9-20412 R/L
9-20515 R/L
9-20620 R/L
9-UT 316 R/L
9-UT 419 R/L
9-UT 522 R/L
9-UT 627 R/L
UA2/471 R/L
UA3/471 R/L
UA471 R/L
UI 471 R/L
UT316 R/L
UT3-5060 R/L
UT3-6075 R/L
UT3-75100 R/L
UT3-100150 R/L
UT3-150300 R/L
UT3-300500 R/L
UT3-500XX R/L
UT3S-5060 R/L Kontra
UT3S-6075 R/L Kontra
UT3S-75100 R/L Kontra
UT3S-100150 R/L Kontra
UT3S-150300 R/L Kontra
UT3S-300500 R/L Kontra
UT3S-500XX R/L Kontra
UT419 R/L
UT4-5060 R/L
UT4-6075 R/L
UT4-75100 R/L
UT4-100150 R/L
UT4-150300 R/L
UT4-300500 R/L
UT4-500XX R/L
UT4S-5060 R/L Kontra
UT4S-6075 R/L Kontra
UT4S-75100 R/L Kontra
UT4S-100150 R/L Kontra
UT4S-150300 R/L Kontra
UT4S-300500 R/L Kontra
UT4S-500XX R/L Kontra
UT522 R/L
UT5-5060 R/L
UT5-6075 R/L
UT5-75100 R/L
UT5-100150 R/L
UT5-150300 R/L
UT5-300500 R/L
UT5-500XX R/L
UT5S-5060 R/L Kontra

Artikel / Item / Articolo
U-Platte / Support blade / Spina staffa
UT5S-6075 R/L Kontra
UT5S-75100 R/L Kontra
UT5S-100150 R/L Kontra
UT5S-150300 R/L Kontra
UT5S-300500 R/L Kontra
UT5S-500XX R/L Kontra
UT627 R/L
UT6-5060 R/L
UT6-6075 R/L
UT6-75100 R/L
UT6-100150 R/L
UT6-150300 R/L
UT6-300500 R/L
UT6-500XX R/L
UT6S-5060 R/L Kontra
UT6S-6075 R/L Kontra
UT6S-75100 R/L Kontra
UT6S-100150 R/L Kontra
UT6S-150300 R/L Kontra
UT6S-300500 R/L Kontra
UT6S-500XX R/L Kontra
UT832 R/L
UT8-75100 R/L
UT8-100150 R/L
UT8-150300 R/L
UT8-300500 R/L
UT8-500XX R/L
UT8S-75100 R/L Kontra
UT8S-100150 R/L Kontra
UT8S-150300 R/L Kontra
UT8S-300500 R/L Kontra
UT8S-500XX R/L Kontra
UT1040 R/L
UT10-75100 R/L
UT10-100150 R/L
UT10-150300 R/L
UT10-300500 R/L
UT10-500XX R/L
UT10S-75100 R/L Kontra
UT10S-100150 R/L Kontra
UT10S-150300 R/L Kontra
UT10S-300500 R/L Kontra
UT10S-500XX R/L Kontra

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Artikel / Item / Articolo
Klemme / Clamb / Staffa
KA3 R/L
KA4 R/L
KA5 R/L
KA6 R/L
KA8 R/L
KA10 R/L
KAK8 R/L
KAK10 R/L
KAM2 R/L
KAM2 R/L Kontra
KAM3 R/L
KAM3 R/L Kontra
KAML3 R/L
KAS3 R/L Kontra
KAS4 R/L Kontra
KAS5 R/L Kontra
KAS6 R/L Kontra
KAS8 R/L Kontra
KAS10 R/L Kontra
KI2F R/L
KI3F R/L
KI3W R/L
KI4W R/L
KI5W R/L
KT3 R/L
KT4 R/L
KT5 R/L
KT6 R/L
KTM2 R/L Kontra
KTM3 R/L Kontra
KTS3 R/L Kontra
KTS4 R/L Kontra
KTS5 R/L Kontra
KTS6 R/L Kontra
KTS8 R/L Kontra
KTS10 R/L Kontra
MKI3F R/L
Kühlmitteldüse / Coolant jet / Ugello refrigerante
KMD 0519
KMD 0830
KMD 0818

Artikel / Item / Articolo
Schraube / Screw / Vite
AS0018
AS0019
AS0020
M154
SS1111
T154
T205
T206
Schlüssel / Key / Chiave
KS1111
KVR16
KVR20
KVR25
T5120

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Stechen

2

ISO	Werkstoff	Zugfestigkeit (N/mm ²)	Schnittgeschwindigkeit V _c (m/min)											
			beschichtet							unbeschichtet		hochharte		
			AM27C	AM35C	AM350	AM5035	AR17C	AR27C	AT10	AK10	CERMET	AH7520	AN8020	
P	Unlegierter Stahl und Stahlguss	< 0,15 % C/vergütet	350	140-260	120-160	140-200	140-200	150-250	160-280	-	-	130-400	-	-
		0,15 - 0,45 % C/vergütet	650	110-190	60-140	110-150	110-150	110-180	120-200	-	-	100-325	-	-
		> 0,45 % C/vergütet	1000	100-160	70-110	90-120	90-120	90-160	100-130	-	-	80-275	-	-
	Niedrig legierter Stahl und Stahlguss	geglüht	600	130-220	70-100	130-180	130-180	100-170	150-230	-	-	100-250	-	-
		vergütet	900	120-160	70-100	100-150	100-150	80-150	130-180	-	-	90-300	-	-
			1200	100-160	60-90	90-120	90-120	70-120	100-150	-	-	60-150	-	-
	Hochlegierter Stahl	geglüht	700	120-150	60-80	90-150	90-150	90-130	140-170	-	-	80-180	-	-
Hochlegierter Werkzeugstahl und Stahlguss	gehärtet und angelassen	1100	90-120	60-80	70-120	70-120	70-110	90-130	-	-	60-140	-	-	
Nichtrostender Stahl	ferritisch, geglüht	700	140-250	90-120	110-180	110-180	110-170	140-240	-	-	80-220	-	-	
Stahlguss	martensitisch, vergütet	1000	120-150	60-90	60-90	60-90	90-140	60-100	-	-	70-180	-	-	
M	Nichtrostender Stahl	austenitisch und austenitisch/ ferritisch, abgeschreckt	450-600	130-200	100-180	110-200	110-200	80-140	130-200	-	-	100-250	-	-
		600-900	80-130	80-150	80-120	80-120	70-100	80-130	-	-	80-180	-	-	
K	Grauguss	perlitisch/ferritisch	500-700	-	-	-	-	120-160	130-220	140-200	120-160	-	-	
		perlitisch/martensitisch	700-850	-	-	-	-	120-150	100-160	120-170	100-140	-	-	
			800-1100	-	-	-	-	100-130	100-130	100-140	80-120	-	-	
	Gusseisen mit Kugelgraphit	ferritisch	550	-	-	-	-	160-200	160-230	110-180	90-150	220-300	-	-
		perlitisch	800	-	-	-	-	100-140	120-170	120-220	100-180	180-230	-	-
Temperguss	ferritisch	450	-	-	-	-	120-140	150-210	120-250	100-200	250-350	-	-	
	perlitisch	750	-	-	-	-	90-130	120-200	100-200	80-160	160-250	-	-	
N	Aluminium-Knetlegierungen	nicht aushärtbar	200	-	-	-	-	-	-	120-950	100-800	-	-	
		aushärtbar, ausgehärtet	350	-	-	-	-	-	-	100-950	80-800	-	350-3000	
	Aluminium-Gusslegierungen	≤ 12 % Si, ausgehärtet	250	-	-	-	-	-	-	100-600	80-500	-	350-3000	
		≤ 12 % Si, aushärtbar, ausgehärtet	300	-	-	-	-	-	-	-	-	-	350-3000	
		≤ 12 % Si, nicht aushärtbar	450	-	-	-	-	-	-	-	-	-	350-3000	
	Kupfer und Kupferlegierungen (Bronze/Messing)	Automatenlegierung, Pb > 1 %	400	-	-	-	-	-	-	120-300	100-250	-	350-3000	
Messing, Rotguss		300	-	-	-	-	-	-	250-600	200-500	-	600-1200		
Aluminiumbronze		500	-	-	-	-	-	-	300-600	250-500	-	600-1200		
Kupfer und Elektrolytkupfer		200	-	-	-	-	-	-	150-350	130-300	-	600-1200		
Nichtmetallische Werkstoffe	Duroplaste	-	-	-	-	-	-	-	120-600	100-500	-	600-1200		
	Faserverstärkte Kunststoffe	-	-	-	-	-	-	-	100-180	80-150	-	80-1500		
	Hartgummi	-	-	-	-	-	-	-	120-250	100-200	-	80-1500		
S	Warmfeste Legierungen	Fe-Basis, geglüht	700	30-50	-	-	-	30-50	25-45	-	-	-	80-1500	
		Fe-Basis, ausgehärtet	950	25-40	20-40	20-40	20-40	25-35	20-40	-	-	-	-	
		Ni- oder Co-Basis, geglüht	800	10-30	20-30	20-30	20-30	15-25	15-25	-	-	-	-	
		Ni- oder Co-Basis, gegossen	1100	10-20	-	-	-	10-20	10-20	-	-	-	-	
		Ni- oder Co-Basis, ausgehärtet	1200	10-15	-	-	-	10-25	10-20	-	-	-	-	
	Titanlegierungen	Rein-Titan	500-700	-	-	-	-	100-150	-	100-150	80-130	-	60-80	
Alpha+Beta-Legierungen	ausgehärtet	700-1000	-	-	-	-	40-60	-	50-80	40-70	-	50-70		
H	Gehärteter Stahl	gehärtet und angelassen	55 HRC	-	-	-	-	35-45	10-20	-	-	-	-	
			60 HRC	-	-	-	-	-	-	-	-	80-230	-	
	Hartguss	gegossen	41 HRC	-	-	-	-	10-20	10-20	-	-	-	60-180	
Gehärtetes Gusseisen	gehärtet und angelassen	55 HRC	-	-	-	-	35-45	10-20	-	-	-	80-230		

Die Tabellenwerte sind Richtwerte. Es kann notwendig sein, die Werte den jeweiligen Bearbeitungsumständen anzupassen.

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Grooving

ISO	Material	Tensile strength (N/mm ²)	Cutting speed V _c (m/min)											
			coated							uncoated		ultra-hard		
			AM27C	AM35C	AM350	AM5035	AR17C	AR27C	AT10	AK10	CERMET	AH7520	AN8020	
P	Unalloyed steel and cast steel	< 0.15% C/hardened and tempered	350	140-260	120-160	140-200	140-200	150-250	160-280	-	-	130-400	-	-
		0.15-0.45% C/hardened and tempered	650	110-190	60-140	110-150	110-150	110-180	120-200	-	-	100-325	-	-
		> 0.45% C/hardened and tempered	1000	100-160	70-110	90-120	90-120	90-160	100-130	-	-	80-275	-	-
	Low alloyed steel and cast steel	annealed	600	130-220	70-100	130-180	130-180	100-170	150-230	-	-	100-250	-	-
		hardened and tempered	900	120-160	70-100	100-150	100-150	80-150	130-180	-	-	90-300	-	-
			1200	100-160	60-90	90-120	90-120	70-120	100-150	-	-	60-150	-	-
	High alloyed steel	annealed	700	120-150	60-80	90-150	90-150	90-130	140-170	-	-	80-180	-	-
High alloyed tool steel and cast steel	hardened	1100	90-120	60-80	70-120	70-120	70-110	90-130	-	-	60-140	-	-	
Stainless steel	ferritic, annealed	700	140-250	90-120	110-180	110-180	110-170	140-240	-	-	80-220	-	-	
Cast steel	martensitic, hardened and tempered	1000	120-150	60-90	60-90	60-90	90-140	60-100	-	-	70-180	-	-	
M	Stainless steel	austenitic and austenitic/	450-600	130-200	100-180	110-200	110-200	80-140	130-200	-	-	100-250	-	-
		ferritic, chilled	600-900	80-130	80-150	80-120	80-120	70-100	80-130	-	-	80-180	-	-
K	Cast iron	pearlitic/ferritic	500-700	-	-	-	-	120-160	130-220	140-200	120-160	-	-	
		pearlitic/martensitic	700-850	-	-	-	-	120-150	100-160	120-170	100-140	-	-	
			800-1100	-	-	-	-	100-130	100-130	100-140	80-120	-	-	
	Cast iron with nodular graphite	ferritic	550	-	-	-	-	160-200	160-230	110-180	90-150	220-300	-	-
		pearlitic	800	-	-	-	-	100-140	120-170	120-220	100-180	180-230	-	-
Malleable cast iron	ferritic	450	-	-	-	-	120-140	150-210	120-250	100-200	250-350	-	-	
N	Aluminium alloys long chipping	not heat treatable	200	-	-	-	-	-	-	120-950	100-800	-	-	
		heat treatable, heat treated	350	-	-	-	-	-	-	100-950	80-800	-	350-3000	
	Casted aluminium alloys	≤ 12% Si, heat treated	250	-	-	-	-	-	-	100-600	80-500	-	-	350-3000
		≤ 12% Si, heat treatable, heat treated	300	-	-	-	-	-	-	-	-	-	-	350-3000
		≤ 12% Si, not heat treatable	450	-	-	-	-	-	-	-	-	-	-	350-3000
	Copper and copper alloys (Brass/Bronze)	Lead alloys, Pb > 1%	400	-	-	-	-	-	-	120-300	100-250	-	-	350-3000
		Brass, Bronze	300	-	-	-	-	-	-	250-600	200-500	-	-	600-1200
Aluminium bronze		500	-	-	-	-	-	-	300-600	250-500	-	-	600-1200	
Copper and elektrolyte copper		200	-	-	-	-	-	-	150-350	130-300	-	-	600-1200	
Non-ferrous materials	Duroplastic	-	-	-	-	-	-	-	120-600	100-500	-	-	600-1200	
	Re-inforced plastics	-	-	-	-	-	-	-	100-180	80-150	-	-	80-1500	
	Hard rubber	-	-	-	-	-	-	-	120-250	100-200	-	-	80-1500	
S	High temperature resistant alloys	Fe-alloyed, annealed	700	30-50	-	-	-	30-50	25-45	-	-	-	80-1500	
		Fe-alloyed, heat treated	950	25-40	20-40	20-40	20-40	25-35	20-40	-	-	-	-	
		Ni- or Co-alloyed, annealed	800	10-30	20-30	20-30	20-30	15-25	15-25	-	-	-	-	
		Ni- or Co-alloyed, casting	1100	10-20	-	-	-	10-20	10-20	-	-	-	-	-
		Ni- or Co-alloyed, heat treated	1200	10-15	-	-	-	10-25	10-20	-	-	-	-	-
	Titanium alloys	Pure titan	500-700	-	-	-	-	100-150	-	100-150	80-130	-	-	60-80
Alpha- and Beta-alloys	heat treated	700-1000	-	-	-	-	40-60	-	50-80	40-70	-	-	50-70	
H	Hardened steel	hardened	55 HRC	-	-	-	-	35-45	10-20	-	-	-	-	
		60 HRC	-	-	-	-	-	-	-	-	-	80-230	-	
	Hard cast iron	casting	41 HRC	-	-	-	-	10-20	10-20	-	-	-	60-180	
	Hardened cast iron	hardened	55 HRC	-	-	-	-	35-45	10-20	-	-	-	80-230	

The recommended cutting data are only approximate values. It may be necessary to adjust them to each individual machining application.



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Scanalatura

ISO	Materiale	Resistenza (N/mm ²)	Velocità di taglio Vc (m/min)											
			rivestito							non rivestito		extra duri		
			AM27C	AM35C	AM350	AM5035	AR17C	AR27C	AT10	AK10	CERMET	AH7520	AN8020	
P	Acciai non legati	< 0,15 % C/bonificato	350	140-260	120-160	140-200	140-200	150-250	160-280	-	-	130-400	-	-
		0,15 - 0,45 % C/bonificato	650	110-190	60-140	110-150	110-150	110-180	120-200	-	-	100-325	-	-
		> 0,45 % C/bonificato	1000	100-160	70-110	90-120	90-120	90-160	100-130	-	-	80-275	-	-
	Acciai debolmente legati e Ghise acciaiose	ricotto	600	130-220	70-100	130-180	130-180	100-170	150-230	-	-	100-250	-	-
		bonificato	900	120-160	70-100	100-150	100-150	80-150	130-180	-	-	90-300	-	-
			1200	100-160	60-90	90-120	90-120	70-120	100-150	-	-	60-150	-	-
	Acciai fortemente legati	ricotto	700	120-150	60-80	90-150	90-150	90-130	140-170	-	-	80-180	-	-
	Acciai da utensili e fusioni	temprato e rinvenuto	1100	90-120	60-80	70-120	70-120	70-110	90-130	-	-	60-140	-	-
Acciai inossidabili	ferritico, ricotto	700	140-250	90-120	110-180	110-180	110-170	140-240	-	-	80-220	-	-	
Ghisa acciaiosa	martensitico, bonificato	1000	120-150	60-90	60-90	60-90	90-140	60-100	-	-	70-180	-	-	
M	Acciai inossidabili	austenitico e autenitico/	450-600	130-200	100-180	110-200	110-200	80-140	130-200	-	-	100-250	-	-
		ferritico, trattato o temperato	600-900	80-130	80-150	80-120	80-120	70-100	80-130	-	-	80-180	-	-
K	Ghisa grigia	perlitica/ferritico	500-700	-	-	-	-	120-160	130-220	140-200	120-160	-	-	-
		perlitica/martensitico	700-850	-	-	-	-	120-150	100-160	120-170	100-140	-	-	-
			800-1100	-	-	-	-	100-130	100-130	100-140	80-120	-	-	-
	Ghisa sferoidale	ferritico	550	-	-	-	-	160-200	160-230	110-180	90-150	220-300	-	-
		perlitica	800	-	-	-	-	100-140	120-170	120-220	100-180	180-230	-	-
	Ghisa temprata	ferritico	450	-	-	-	-	120-140	150-210	120-250	100-200	250-350	-	-
perlitica		750	-	-	-	-	90-130	120-200	100-200	80-160	160-250	-	-	
N	Leghe di Alluminio stampato	non invecchiato	200	-	-	-	-	-	-	120-950	100-800	-	-	-
		invecchiato	350	-	-	-	-	-	-	100-950	80-800	-	-	350-3000
	Leghe di Alluminio da fusione	≤ 12 % Si, invecchiato	250	-	-	-	-	-	-	100-600	80-500	-	-	350-3000
		≤ 12 % Si, rinvenuto, invecchiato	300	-	-	-	-	-	-	-	-	-	-	350-3000
		≤ 12 % Si, non invecchiato	450	-	-	-	-	-	-	-	-	-	-	350-3000
	Rame e Leghe di Rame (Bronzo/Ottone)	Automatici, Pb > 1 %	400	-	-	-	-	-	-	120-300	100-250	-	-	350-3000
		Ottone, Bronzo	300	-	-	-	-	-	-	250-600	200-500	-	-	600-1200
Bronzoalluminio		500	-	-	-	-	-	-	300-600	250-500	-	-	600-1200	
Rame e Rame Elettrolitico		200	-	-	-	-	-	-	150-350	130-300	-	-	600-1200	
Materiali non metallici	Duroplastiche	-	-	-	-	-	-	-	120-600	100-500	-	-	600-1200	
	Plastiche rinforzate	-	-	-	-	-	-	-	100-180	80-150	-	-	80-1500	
	Gomme dure	-	-	-	-	-	-	-	120-250	100-200	-	-	80-1500	
S	Leghe resistenti al calore	Base-Fe, ricotto	700	30-50	-	-	-	30-50	25-45	-	-	-	-	80-1500
		Base-Fe, invecchiato	950	25-40	20-40	20-40	20-40	25-35	20-40	-	-	-	-	-
		Base Ni o Co, ricotto	800	10-30	20-30	20-30	20-30	15-25	15-25	-	-	-	-	-
		Base Ni o Co, da fusione	1100	10-20	-	-	-	10-20	10-20	-	-	-	-	-
		Base Ni o Co, invecchiato	1200	10-15	-	-	-	10-25	10-20	-	-	-	-	-
	Leghe di Titanio	Titanio puro	500-700	-	-	-	-	100-150	-	100-150	80-130	-	-	60-80
Leghe Alpha+Beta	invecchiato	700-1000	-	-	-	-	40-60	-	50-80	40-70	-	-	50-70	
H	Acciaio Temprato	temprato e rinvenuto	55 HRC	-	-	-	-	35-45	10-20	-	-	-	-	-
		60 HRC	-	-	-	-	-	-	-	-	-	-	80-230	-
	Getti Temprati	da fusione	41 HRC	-	-	-	-	10-20	10-20	-	-	-	60-180	-
	Ghisa Temprata	temprato e rinvenuto	55 HRC	-	-	-	-	35-45	10-20	-	-	-	80-230	-

I dati indicati in tabella sono valori approssimati. Può essere necessario adattarli alle singole applicazioni di lavorazione.

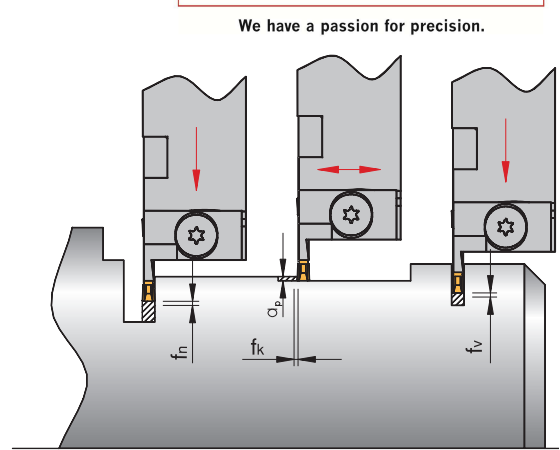
Recommended cutting data
Parametri di taglio suggeriti

Maximale Vorschübe und Spantiefen


Max. feed rate and depth of cut

Avanzamenti e profondità di taglio massimi

- f_v (mm/U) = **Vorschub ins Volle** / Feed rate into solid / Avanzamento nel pieno
- f_n (mm/U) = **Vorschub beim Einstechen** / Feed rate for re-grooving / Avanzamento di ripresa
- f_k (mm/U) = **Vorschub beim Kopieren** / Feed rate for copying / Avanzamento per copiatura
- a_p (mm) = **Spantiefe** / Depth of cut / Profondità di taglio




Standardausführung / Standard geometry / Esecuzione standard

	Schneideinsatz / Insert / Inserto							
	21201	31602	32002	42202	52502	63002	83804	104604
f_v	0,02–0,08	0,02–0,08	0,05–0,12	0,07–0,18	0,07–0,18	0,07–0,18	0,10–0,25	0,10–0,25
f_n	0,02–0,08	0,02–0,08	0,05–0,12	0,07–0,18	0,07–0,18	0,07–0,18	0,10–0,30	0,10–0,30
f_k	0,02–0,05	0,02–0,05	0,05–0,10	0,05–0,10	0,05–0,10	0,07–0,15	0,12–0,25	0,12–0,25
$a_p \text{ max}$	0,30	0,30	0,50	0,50	0,50	0,50	1,00	1,00


Kopierausführung / Geometry for copying / Geometria a copiare

-12

	Schneideinsatz / Insert / Inserto							
	21201-12	31602-12	32002-12	42202-12	52502-12	63002-12	83804-12	104604-12
f_v	0,02–0,08	0,02–0,08	0,05–0,15	0,07–0,18	0,07–0,18	0,07–0,18	0,10–0,18	0,10–0,18
f_n	0,02–0,08	0,02–0,08	0,05–0,15	0,07–0,18	0,07–0,18	0,07–0,18	0,10–0,30	0,10–0,30
f_k	0,02–0,05	0,02–0,05	0,05–0,10	0,07–0,18	0,07–0,18	0,07–0,18	0,10–0,30	0,10–0,40
$a_p \text{ max}$	0,50	0,50	1,50	2,00	2,50	2,50	3,50	4,00


Stechdrehen / Groove turning / Scanalatura di copiatura

-AM

	Schneideinsatz / Insert / Inserto							
	21202-AM	31602-AM	32002-AM	42204-AM	52504-AM	63008-AM	83808-AM	104608-AM
f_v	0,02–0,08	0,02–0,08	0,04–0,15	0,07–0,18	0,07–0,25	0,10–0,25	0,10–0,40	0,10–0,40
f_n	0,02–0,08	0,02–0,08	0,04–0,15	0,07–0,18	0,07–0,25	0,10–0,25	0,10–0,40	0,10–0,40
f_k	0,02–0,12	0,02–0,12	0,04–0,15	0,07–0,18	0,07–0,25	0,10–0,25	0,10–0,40	0,10–0,40
$a_p \text{ max}$	0,50	0,50	1,50	2,00	2,50	2,50	3,50	4,00

Vollradiusausführung / Full radius execution / Esecuzione a raggio completo

-V


	Schneideinsatz / Insert / Inserto							
	21210 V	31615 V	32015 V	42220 V	52525 V	63030 V	83840 V	104650 V
f_v	0,02–0,05	0,02–0,05	0,05–0,10	0,05–0,10	0,05–0,10	0,07–0,12	0,07–0,15	0,07–0,15
f_n	0,02–0,05	0,02–0,05	0,05–0,10	0,05–0,10	0,05–0,10	0,07–0,12	0,07–0,15	0,07–0,15
f_k	0,02–0,05	0,02–0,05	0,05–0,10	0,05–0,10	0,05–0,10	0,07–0,12	0,07–0,15	0,07–0,15
$a_p \text{ max}$	0,30	0,30	0,50	0,50	0,50	0,50	1,00	1,00

Die Tabellenwerte sind Richtwerte. Es kann notwendig sein, die Werte den jeweiligen Bearbeitungsumständen anzupassen.
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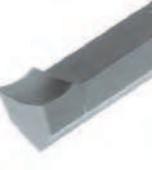
Vollradiusausführung / Full radius execution / Esecuzione a raggio completo

-VK

	Schneideinsatz / Insert / Insetto							
	21210 VK	31615 VK	32015 VK	42220 VK	52525 VK	63030 VK	83840 VK	104650 VK
f_v	0,02–0,05	0,02–0,05	0,05–0,12	0,05–0,12	0,05–0,12	0,07–0,12	0,07–0,15	0,07–0,15
f_n	0,02–0,05	0,02–0,05	0,05–0,12	0,05–0,12	0,05–0,12	0,07–0,25	0,07–0,30	0,07–0,30
f_k	0,02–0,05	0,02–0,05	0,05–0,15	0,05–0,12	0,08–0,12	0,07–0,30	0,07–0,30	0,07–0,40
$a_p \text{ max}$	0,50	0,50	1,50	2,00	2,50	3,00	4,00	5,00


Aluminiumausführung / Aluminium geometry / Geometria alluminio

-ALU

	Schneideinsatz / Insert / Insetto							
	21201-ALU	31602-ALU	32002-ALU	42202-ALU	52502-ALU	63002-ALU	83804-ALU	104604-ALU
f_v	0,02–0,08	0,02–0,12	0,05–0,18	0,05–0,18	0,05–0,18	0,05–0,18	0,10–0,25	0,10–0,25
f_n	0,02–0,08	0,02–0,12	0,05–0,18	0,05–0,18	0,05–0,18	0,05–0,18	0,10–0,30	0,10–0,30
f_k	0,02–0,10	0,02–0,15	0,05–0,20	0,05–0,20	0,05–0,20	0,05–0,20	0,10–0,35	0,10–0,35
$a_p \text{ max}$	0,50	0,50	2,00	2,50	3,00	3,00	4,00	5,00

2

Ausführung für Sicherungsringestiche / Circlip inserts / Insetti per sedi seeger

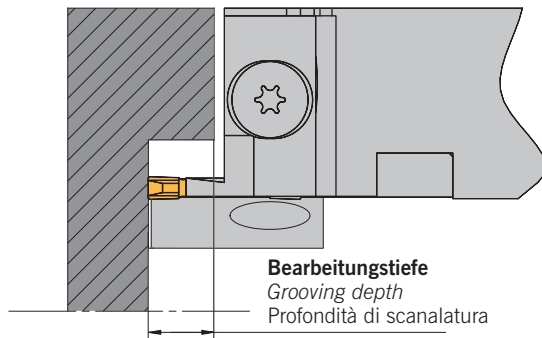
	Schneideinsatz / Insert / Insetto		
	2-...	3M-...	3-...
f_v	0,01–0,05	0,01–0,05	0,01–0,10

Die Tabellenwerte sind Richtwerte. Es kann notwendig sein, die Werte den jeweiligen Bearbeitungsumständen anzupassen.

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I dati indicati in tabella sono valori approssimati. Può essere necessario adattarli alle singole applicazioni di lavorazione.

Auswahl des Halters / Selecting the toolholder / Scelta dello stelo



Einsatz eines Halters mit maximalen Schaftabmessungen. Zur Vermeidung oder Minimierung von Vibrationen und Werkzeugauslenkung, Auswahl des Werkzeuges (Halter, Unterstützplatte) mit der geringsten Auskraglänge, entsprechend der geforderten Bearbeitungstiefe.

The maximum shank cross section should be used. In order to minimize vibration, the tool and support blade should be setup with minimum overhang.

Scegliere lo stelo dalla sezione massima di gambo. Per ridurre le vibrazioni, l'utensile e la lama devono essere montati con una sporgenza minima.

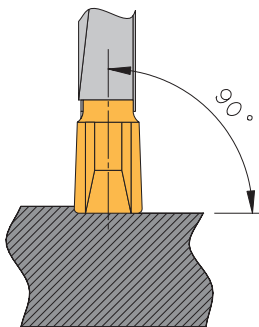
Auswahl des Schneideinsatzes / Selecting the inserts / Scelta dell'inserto

Die Breite des Schneideinsatzes sollte, bezogen auf die Abmessungen des Werkzeuges, so breit wie möglich gewählt werden, um eine optimale Stabilität zu erreichen. Die Breite des Schneideinsatzes hat unmittelbare Auswirkung auf die Auskraglänge des Werkzeuges. Es ist der größtmögliche Eckenradius zu wählen. Ein Schneideinsatz mit größerem Radius ist stabiler und garantiert längere Standzeit durch bessere Verteilung der Schnittkräfte. Ein größerer Radius erhöht in der Regel die Oberflächenqualität beim Drehen. Der Radius sollte größer sein als der maximal gewählte Vorschub. Die kleinste Schnitttiefe „ a_p “ sollte nicht kleiner sein als der Eckenradius des Schneideinsatzes.

In order to achieve maximum stability, the widest possible insert (depending on the size of the tool) should be selected. The grooving depth of the tool is depending on the width. The largest possible corner radius should be used. A insert with a larger corner radius gives more stability and better tool-life, as the cutting forces are equalized. A large corner radius improves the surface quality. The radius should be larger than the maximum feed rate. The smallest depth cut should not be less than the corner radius of the insert.

Per ottenere la massima stabilità, è consigliabile selezionare l'inserto più largo possibile (considerando la misura dell'utensile). La profondità di scanalatura dell'utensile dipende dalla larghezza. È suggerito scegliere raggi di punta più ampi possibili. Un inserto di scanalatura con raggio di punta ampio dà maggiore stabilità e durata, e le forze di taglio contenute. Un raggio di punta ampio permette una migliore qualità superficiale. Il raggio dovrebbe essere più largo dell'avanzamento massimo. La profondità di taglio più piccola non dovrebbe essere minore del raggio di punta dell'inserto di scanalatura.

Einrichten des Werkzeuges / Set up of the tool / Installazione dell'utensile



Optimale Bearbeitungsergebnisse sind nur zu erzielen, wenn das Werkzeug sachgemäß eingerichtet ist. Hierbei ist zu beachten, dass das Werkzeug (Schneidkante) stets rechtwinklig (bzw. parallel beim Axial-Stechedrehen) zur Werkstückrotationsachse ausgerichtet wird. Beim Kopierdrehen ist die zweite Schneidenecke um 0,05 mm freizustellen.

ACHTUNG: Bei unsachgemäßer Ausrichtung der Schneidkante können Vibrationen auftreten.

Optimal processing results can only be achieved if the tool is correctly mounted. Whereby it should be noted that the tool (cutting edge) must be always mounted at right angles to the work piece rotating axis (or respectively parallel with axial groove turning). With duplicating turning, the second corner is to be released 0.05 mm.

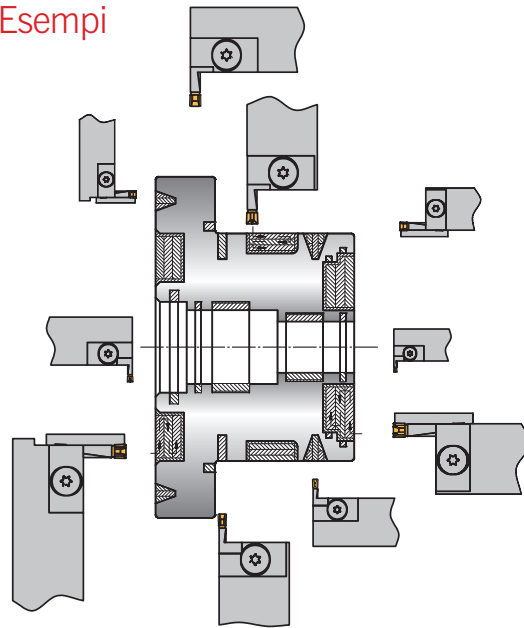
ATTENTION: If cutting edges are not set correctly, vibration can be caused.

I migliori risultati di lavorazione possono essere ottenuti solo se l'utensile è montato correttamente. Per cui bisogna considerare che l'utensile (il tagliente) deve essere sempre montato ai corretti angoli rispetto all'asse rotante del pezzo da lavorare (o rispettivamente parallelo alla tornitura assiale del canale). In tornitura di copiatura, il secondo tagliente deve arretrare di 0,05 mm.

ATTENZIONE: Se i taglienti non vengono impostati correttamente si possono originare vibrazioni.

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Beispiele / Examples / Esempi



Die Schraffur macht die Schnittaufteilung deutlich und zeigt gleichzeitig die abschließende Kopieroperation.

- Musterteil aus 16MnCr5
- durchschnittliche Schnittgeschwindigkeit 150 m/min
- Vorschübe von 0,1 bis 0,25 mm.

The shaded area shows the sequence of operations as well as the final profiling cut, with the Nprecision grooving tools.

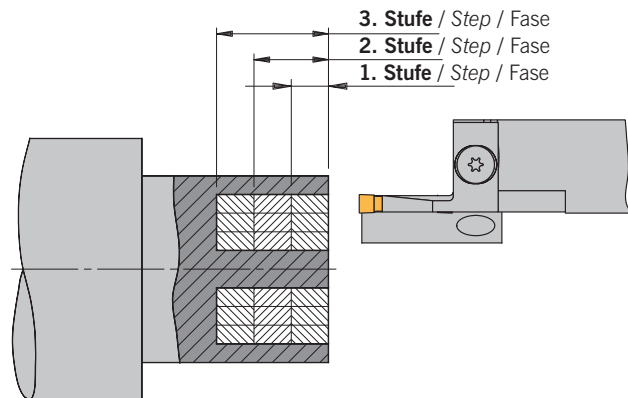
- A low tensile steel was used for this component
- Average cutting speed 150 m/min
- Feed rates 0.1 up to 0.25 mm/rev.

L'illustrazione mostra la sequenza delle operazioni la profilatura finale con l'uso degli utensili di scanalatura di precisione NC.

- Per questo esempio si utilizza un acciaio basso legato 16MnCr5
- Velocità di taglio 150 m/min
- Avanzamento da 0,1 a 0,25 mm.

2

Einstecken ins Volle / Grooving into solid / Scanalatura nel pieno

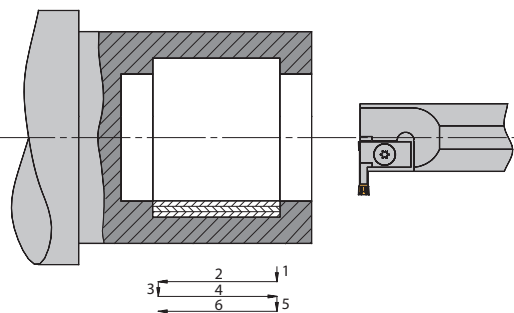


Bei großen Stechtiefen ist ein stufenweises Einstecken zu empfehlen, um Spanräume zu schaffen. Erst danach wird tiefer eingestochen.

If large groove depths are required, rough out in a series of plunges, before finishing the profile down each side and blending into the centre.

Se sono richieste scanalature profonde, procedere con una serie di passate al fine di creare uno spazio d'evacuazione del truciolo, poi scanalare più in profondità.

Innenstechen / Internal grooving / Scanalatura interna



Verwendung der Schneideinsätze – 12 oder -AM

Using insert type – 12 or -AM

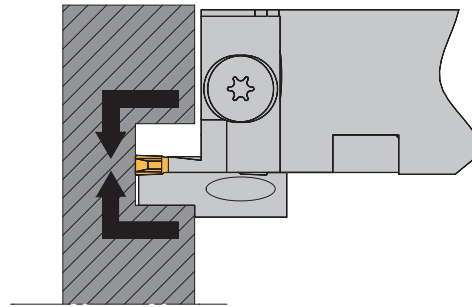
Utilizzo dell'inserto – 12 o -AM

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Ein- oder Auswärtskopieren

Inward- and outward copy-turning

Copiatura in entrata o in uscita



Einwärtskopieren bewirkt einen besseren, gleichmäßigeren Spanbruch und ist zur Minimierung des Werkzeugverschleißes zu empfehlen. Der Span fließt in den bearbeiteten Raum ab. Senkrecht / Rechtwinklig: Um eine gute Rechtwinkligkeit zwischen den Seitenwänden zu erhalten, empfiehlt sich das Einwärtskopieren.

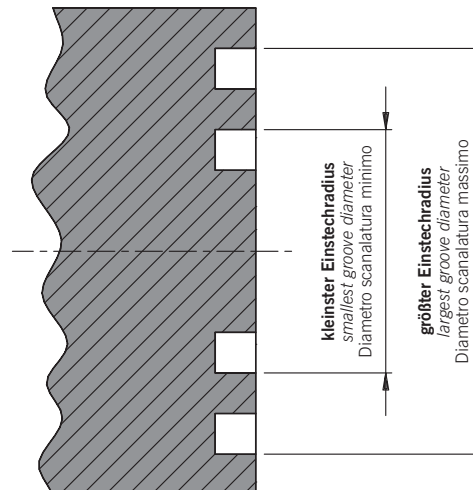
Inward copy-turning gives a more uniform chip-breaking and minimizes insert wear. In order to achieve rectangular faces, we recommend inward copy-turning.

La copiatura in uscita permette una rottura del truciolo uniforme e minimizza l'usura dell'inserto. Perpendicolarità/Parallelismo: per ottenere una buona perpendicolarità ed un buon parallelismo raccomandiamo la copiatura in uscita.

Axial-Stecken und Plandrehen

Axial grooving and facing

Scanalatura assiale e sfacciatura



Axial-Stecken ist nur innerhalb des festgelegten Durchmesserbereiches möglich (z. B. 50–60). Andernfalls kann es zur Beschädigung oder Zerstörung des Werkzeuges kommen.

Axial grooving is only possible within the diameter range (e. g. 50–60). If not, the tool can be damaged or destroyed.

La scanalatura assiale è possibile solo entro la gamma di diametri determinati (per es. 50–60). Una scelta scorretta causerebbe la collisione tra utensile e pezzo da lavorare.

ACHTUNG: Der angegebene Durchmesserbereich gilt immer für den Außendurchmesser der Nut!

ATTENTION: The specified diameter range in all cases refers to the outer diameter of the groove!

ATTENZIONE: La gamma dei diametri specifici si riferisce in ogni caso al diametro più esterno della gola in prima piantata.

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ACHTUNG / ATTENTION / ATTENZIONE

Beim Axial-Stechen immer am Nutaußendurchmesser starten.

Nutverbreiterungen über den angegebenen Durchmesserbereich hinaus sind nach oben und unten möglich.

Der erste Einstich muss im angegebenen Durchmesserbereich liegen. Die Tiefe der Einstiche zur Nutverbreiterung darf nicht größer als die des ersten Einstichs sein.

When axial grooving always begin at the groove outside diameter.

Once the first plunge is complete, it is possible to widen the groove above and below the diameter range quoted.

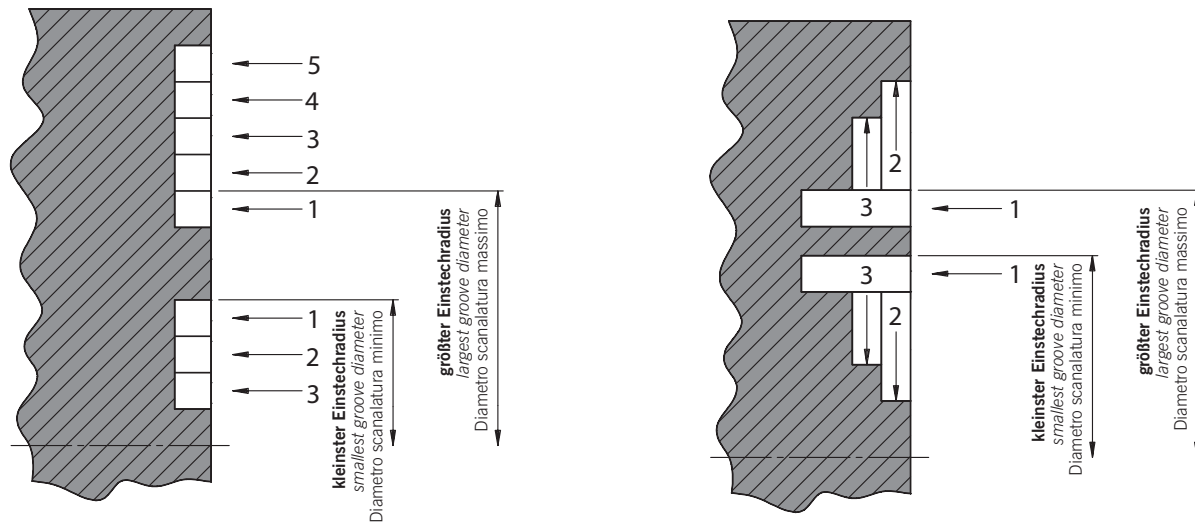
The first groove made must be within the quoted diameter range. The depth of the next cut must not be deeper than the depth of the first groove.

Nella scanalatura assiale occorre sempre iniziare con il diametro esterno.

Una volta completata la prima piantata è possibile allargare il canale al di sopra e al di sotto della gamma di diametro lavorato.

Il primo canale prodotto deve essere entro la gamma diametro indicato sulla lama. La profondità della gola successiva non deve essere più profonda della profondità della prima.

2



We have a passion for precision.



- Modulares NC-Steckdrehsystem für verschiedene Werkzeugvarianten mit einem Grundhalter durch einfachen Austausch von Unterst utzplatte und Klemme.
- Komplettes Programm f ur die axiale und radiale Au enbearbeitung in verschiedenen Stechbreiten.
- F ur die Innenbearbeitung besteht ein Programm in verschiedenen Haltergr o en (wahlweise mit oder ohne innere K uhlmittelzufuhr) und Stechbreiten.
- F ur gr o ere Bearbeitungstiefen stehen spezielle Klemmen und Unterst utzplatten zur Verf ugung.
- Kompakthalter mit VDI- und UTS-/KM und Capto®-Aufnahmen f ur erh ohte Stabilit at. Diese Halter k onnen ebenfalls mit dem gesamten Standardzubeh or kombiniert werden.

- A modular grooving and copy-turning system giving different tool variations from one basic holder by simply exchanging the support blade and clamp.
- A complete programme for external radial and axial grooves of various widths.
- For internal machining a range of boring bars with and without coolant feed and inserts in different widths are available.
- For deep grooving applications special support blades and clamps can be designed and manufactured.
- Toolholder with VDI or UTS/KM and Capto® shanks, which can give improved stability, along with their spares are stock items. These holders are used in conjunction with standard support blades, clamps and inserts.

- Un sistema di tornitura-scanalatura modulare permette differenti varianti d'utensile con il semplice cambio della lama e della staffa.
- Un programma completo per lavorazioni esterne assiali e radiali con larghezze di taglio differenti.
- Per la lavorazione interna, esiste un programma di steli con sezioni differenti (con un sistema di raffreddamento centrale) e larghezze di taglio differenti.
- Per profondit  di taglio non standard   possibile studiare apposite lame e staffe speciali.
- Sono disponibili attacchi VDI, UTS/KM e Capto® per una stabilit  superiore. Questi attacchi possono essere combinati con l'insieme degli accessori standard.

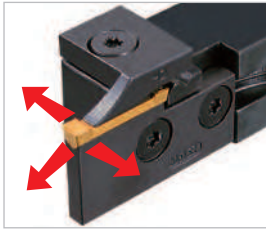


- Pr azisionsgeschliffene bzw. gesinterte, 2-schneidige Schneideins tze f ur die Innen- und Au enbearbeitung.
- Verschiedene Spanformgeometrien sowie eine Vielzahl von Schneidstoffen mit speziell abgestimmten Beschichtungen bieten eine optimale Auswahl f ur den jeweiligen Bearbeitungsfall.
- Lange Prismenf uhrung der Schneideins tze f ur optimale Kontrolle der Schnittkr afte beim L angsdrehen und Kopieren.
- Positive Schneidgeometrie erlaubt Programmkorrekturen im Bereich von 0,01 mm und eignet sich somit f ur Schlichtoperationen aller Art.

- Precision or sintered ground inserts with two cutting edges for use on internal and external grooving applications.
- A choice of chipbreaker geometries together with coated and uncoated carbide grades, combine to offer optimum cutting performance on a wide range of materials.
- Inserts have a ground vee seating for a positive location into the support blade. This ensures maximum stability when side turning or copying.
- The positive insert geometry minimises deflection (less than 0.01 mm) and is therefore particularly suitable for finishing operations.

- Inserti a due taglienti rettificati di precisione o sinterizzati per lavorazioni interne ed esterne.
- Le differenti geometrie di taglio insieme alla grande diversit  di gradi con rivestimenti specifici offrono una scelta ottimale per qualsiasi lavorazione.
- La lunghezza del prisma dell'inserto offre un controllo ottimale delle forze di taglio nella tornitura longitudinale e nella copiatura.
- La geometria di taglio positiva permette delle correzioni di programmazione nell'ordine di 0,01 mm e favorisce tutte le lavorazioni di finitura.

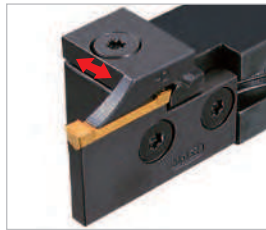
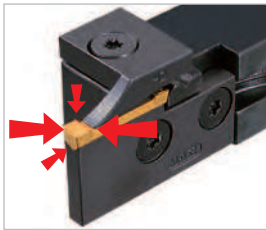
We have a passion for precision.



- **Stechdrehen in 3 verschiedene Hauptschnitt-richtungen. Dadurch Verbundoperationen mit nur einem Werkzeug möglich.**

- *Tools and operate in three directions offering the opportunity to consolidate several operations into one and reduce the number of tool changes.*

- La tornitura-copiatura tri-direzionale è ottenuta con un solo utensile.



- **Die Klemmtechnik in Verbindung mit der Prismenführung verhindert ein seitliches Abkippen der Schneideinsatz bei Längsdrehoperationen und sichert durch die breite axiale Auflage die hohe Wiederholgenauigkeit.**
- **Die freigestellte Unterstützplatte garantiert eine optimale Plattenauflage und sichert die Stabilität bei einseitigen Belastungen.**

- *The design of the insert clamping and the vee location provides for accurate indexing of insert edges and index repeatability is achievable.*
- *The relief in the support blade means the insert is supported under the ends to ensure high stability and optimum rigidity.*

- La tecnica di serraggio, associata al prisma dell'inserto permette di evitare il suo movimento all'interno della sede.
- Il sostegno della lama di supporto garantisce una stabilità ottimale dell'inserto nella sua sede e assicura la stabilità negli sforzi di taglio laterali.



- **Zur Komplettierung des Stechdrehprogrammes stehen weiterhin Monoblock-Halter im Axialbereich für Nut-Außendurchmesser ab D_{min} 15 mm und Mini-Innenstechdrehwerkzeuge ab D_{min} 11 mm zur Verfügung.**

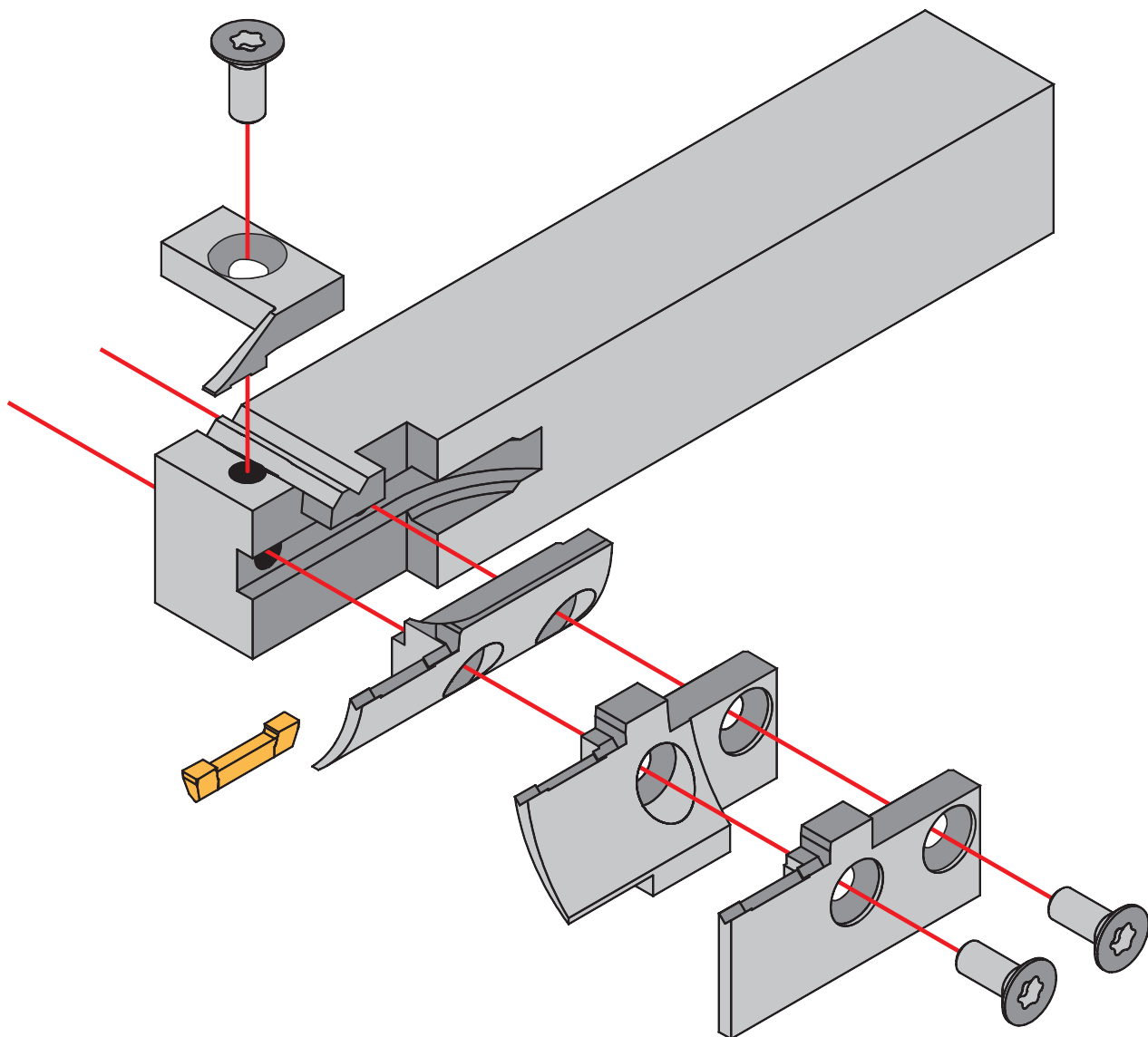
- *To complete the grooving programme, there are monoblock holders for axial grooving diameters of 15 mm upward. Also an internal boring bar for 11 mm minimum bore diameter are available.*

- Per completare il programma di tornitura-copiatura, esistono anche utensili monoblocco, per lavorazione assiale, per diametri esterni minimi di 15 mm. La gamma prevede inoltre utensili per interni come i sistemi AMS e SIM per diametri a partire da 2,5 mm.

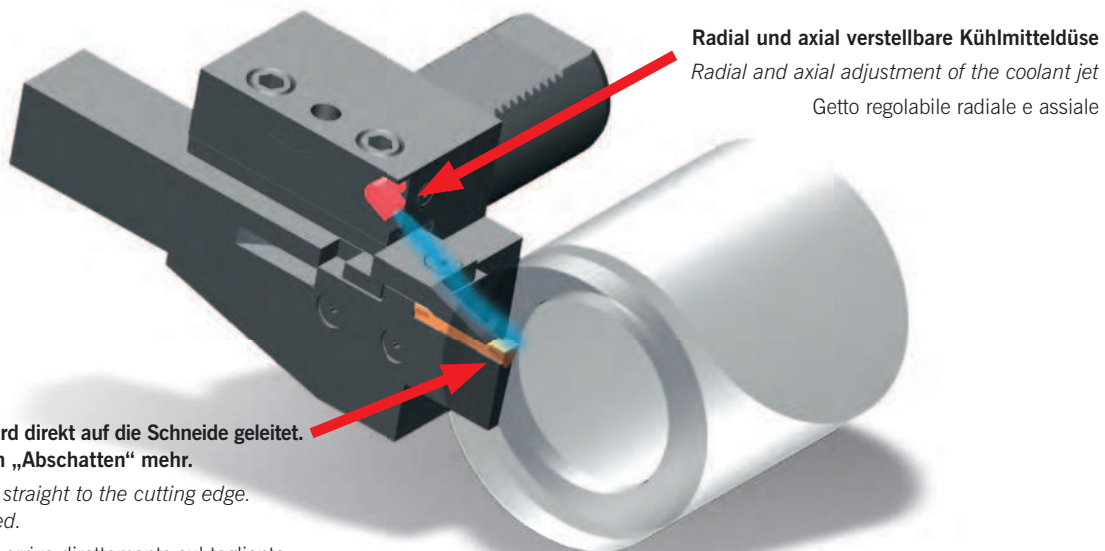
Montage ARNO-NC-Stechdrehsystem

Assembling of ARNO-Groove turning system

Montaggio del sistema ARNO di Scanalatura e copiatura



2

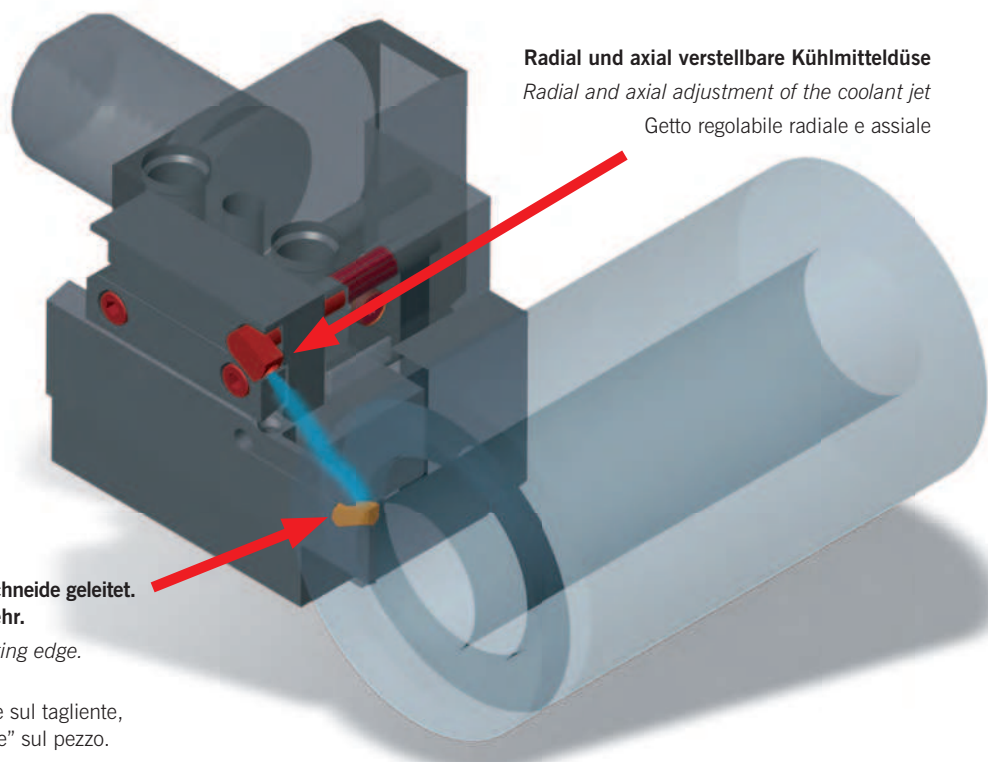
Systemübersicht SBN/KMH / System overview SBN/KMH /
Panoramica del sistema SBN e KMH**KMH – Werkzeughalter** / KMH tool holder / Adattatori KMH

Radial und axial verstellbare Kühlmitteldüse
Radial and axial adjustment of the coolant jet
Getto regolabile radiale e assiale

Kühlmittel wird direkt auf die Schneide geleitet. Dadurch kein „Abschatten“ mehr.

Coolant goes straight to the cutting edge. Not obstructed.

Il refrigerante arriva direttamente sul tagliente, quindi niente più “ombreggiature” sul pezzo.

SBN Spannblock / SBN Parting block / SBN Blocco portalama

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