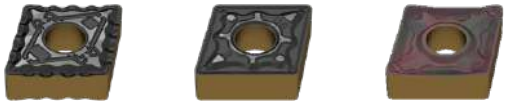
New products for machining technicians

NEW

Steel machining with the new ISO-P grades



Thanks to a CVD multilayer coating with the latest Dragonskin coating technology, the indexable inserts are ideally suited to versatile steel machining. In combination with a balanced carbide base substrate, the new grades in the ISO-P category boast a wide application area with improved wear resistance. Depending on the cutting conditions, the perfect cutting material can be selected from three grades.

NEW

Tool holder with square shank – MaxiLock-S DC for positive indexable inserts

The new MaxiLock-S DC tool holders improve both your process security and the service life of the tool cutting edges with targeted cooling. Suitable for a wide range of positive indexable inserts.

NEW

Tool holder with square shank – MaxiLock-N DC for negative indexable inserts

Improve your machining process with precision cooling on the tool cutting edge. The cooling has a particularly efficient effect on the flank of the tool. Suitable for a wide range of negative indexable inserts using toggle clamps.

Suitable adapters for our square rotating- and grooving holders can be found in **Chapter 16 Adapters and accessories**.
Available for machine interfaces VDI and BMT.
New: Adapters with HSK-T machine interface → **Chapter 16, pages 190+191**

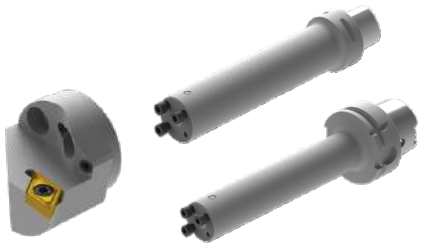
NEW

-M23 chip breaker

Weichschneidende Geometrie mit ausgezeichnetem Spanbruchverhalten bei geringen Schnitttiefen für die Stahlzerspanung. Verfügbar für positive Rundplatten in den ISO-P Hartmetallsorten.

NEW

Exchangeable head system



Der neue aktiv schwingungsgedämpfte Grundhalter für besonders anspruchsvolle Innendrehoperationen. Verfügbar mit dem Maschineninterface PSC und HSK-T.

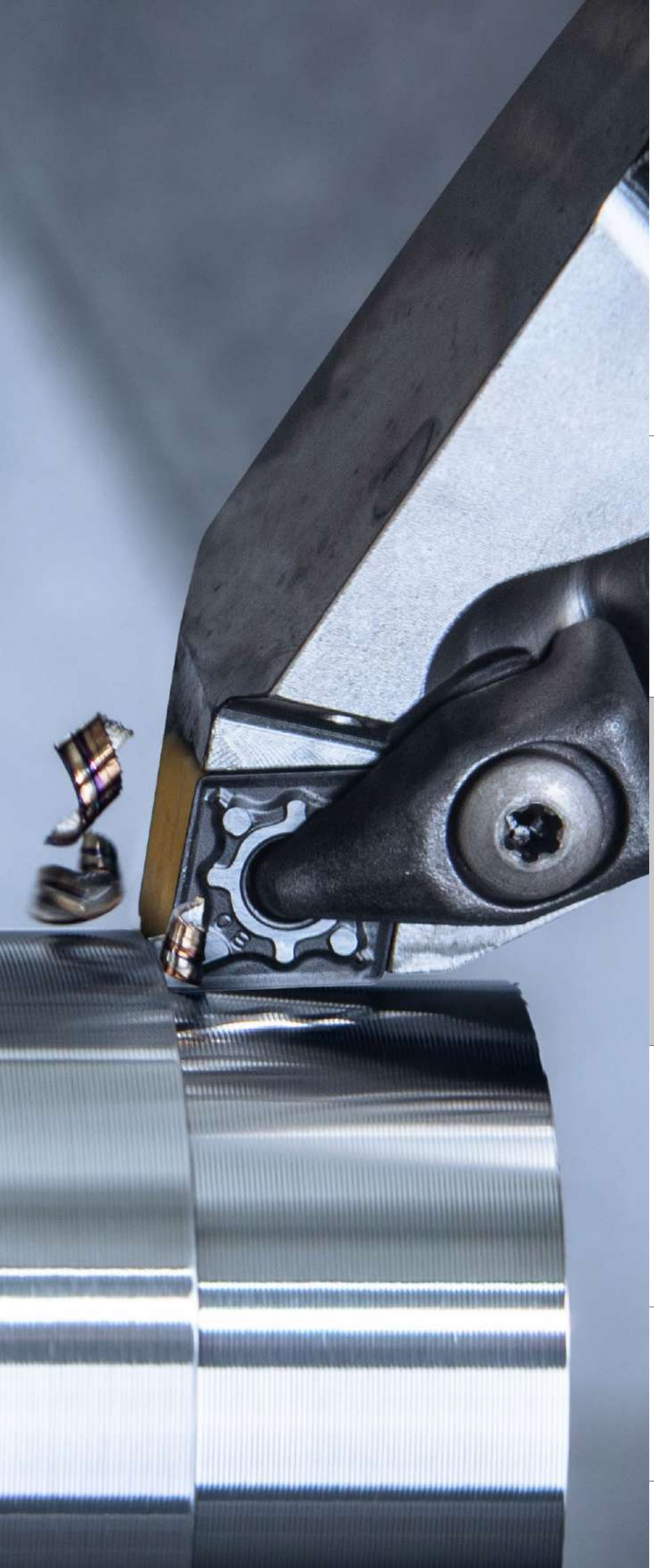


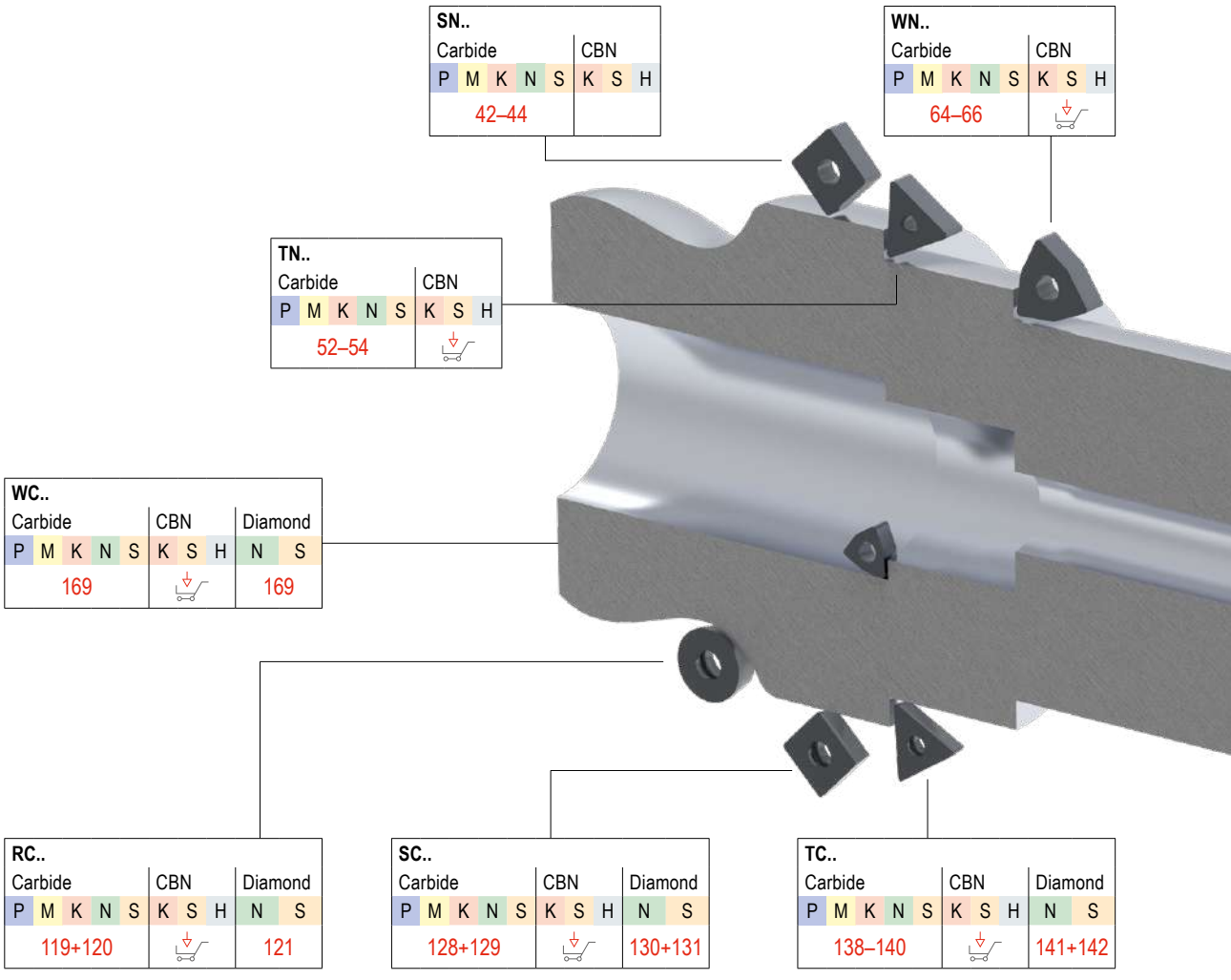
Table of contents

CERATIZIT \ Performance

Premium quality tools for high performance.

The premium quality tools from the **CERATIZIT Performance** product line have been designed for specific applications and are distinguished by their outstanding performance. If you make high demands on the performance of your production and want to achieve the very best results, we recommend the Premium tools in this product line.

Toolfinder – Application



Symbol explanation

CTCP125-P *Carbide Grade*

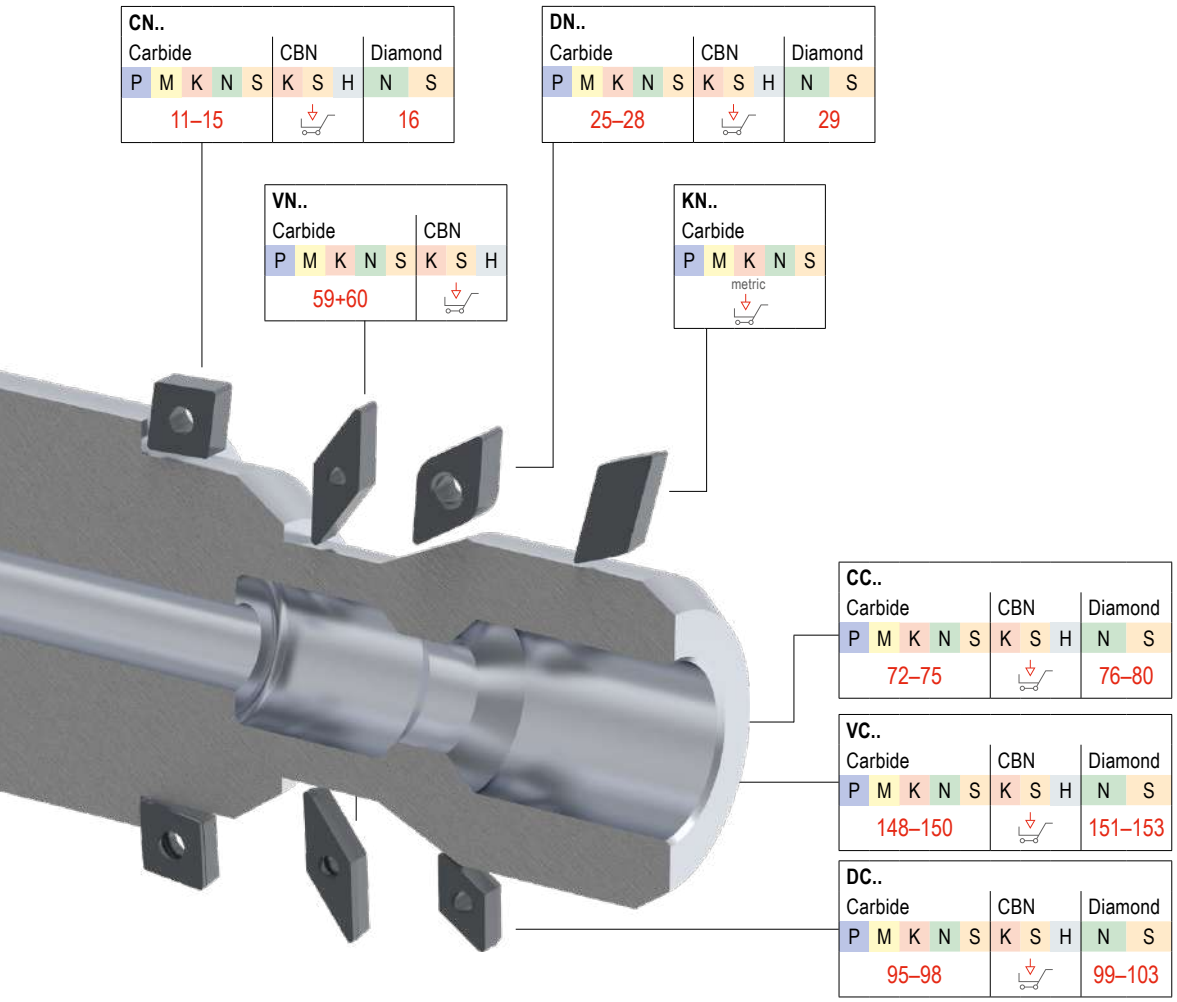
F	Fine Machining
M	Medium Machining
R	Rough Machining

Smooth cut
Irregular cutting depth
Interrupted cut

Int. coolant supply

Direct Cooling — DirectCooling

A detailed overview of grades can be found in the technical appendix on → **page PL**



CN..

Carbide						CBN			Diamond	
P	M	K	N	S	K	S	H		N	S
11–15									16	

DN..

Carbide						CBN			Diamond	
P	M	K	N	S	K	S	H		N	S
25–28									29	

VN..

Carbide					CBN		
P	M	K	N	S	K	S	H
59+60							

KN..

Carbide				
P	M	K	N	S
metric				

CC..

Carbide						CBN			Diamond	
P	M	K	N	S	K	S	H		N	S
72–75									76–80	

VC..

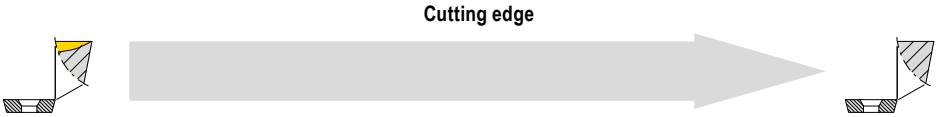
Carbide						CBN			Diamond	
P	M	K	N	S	K	S	H		N	S
148–150									151–153	

DC..

Carbide						CBN			Diamond	
P	M	K	N	S	K	S	H		N	S
95–98									99–103	

This article can be found in our online shop at cuttingtools.ceratizit.com

Chip Breakers Overview



			Sharp			medium		stable		
			5	10	20	30	40	50	60	70
increasing wedge angle	fine	F	-F05 -CF05	-SF -23P	-CF / -CF20	-F30 -SMF	-F34 -F40 -TFQ	-F50 -CF55		
	medium	M		-M23	-25P -25Q -M25	-XU -M30 -SM -SMQ	-M34 -M40 -TMQ	-M42 -M50 -M55	-M60	-M70 -NMA
	rough	R			-27	-29		-R28	-R58	-R88

Grade description

C T C P 1 2 5 -P (Example)

CT
CERATIZIT

-P
Performance

Degree of hardness

05	ISO 05
10	ISO 10
15	ISO 15
20	ISO 20
25	ISO 25
30	ISO 30
35	ISO 35
40	ISO 40

wear-resistant
tough

Application

1	Turning
2	Milling
3	Grooving
4	Drilling
5	Thread turning
6	Others
7	Several processes

Main application – material

P	Steel
M	Stainless steel
K	Cast iron
N	Non-ferrous metals
S	Heat-resistant
H	Tempered steel
O	Non-metal materials
X	Universal application

Coating

W	Uncoated carbide
C	CVD-coated carbide
P	PVD-coated carbide
T	Cermet, uncoated
E	Cermet, coated
N	Silicon nitride, uncoated
M	Silicon nitride, coated
S	Mixed ceramic
K	Whisker ceramic
I	SiAlON
D	PDC
B	PcBN
L	PcBN coated
H	HSS sintered

Toolfinder – negative inserts

				Steel	Stainless steel	Cast iron	Non-ferrous metals	Heat-resistant	Tempered steel	Non-metal materials	Geometry						
				P	M	K	N	S	H	O	CN..	DN..	KN..	SN..	TN..	VN..	WN..
Main application: **Steel and cast iron**	Sharp ↕ stable	Fine	-CF / -CF20	●	○	○					11	25			52		64
			-F40	●		○										59	
			-F50	●		○					11	25		42	52	59	64
			-TFQ	●	○	○					11+12	25+26					64
		Medium	-XU	●		○					12	26				59	65
			-M40	●		○										59	
			-M50	●	○	○					12	26+27		42	52	59	65
			-TMQ	●		○					12	27					65
			-M70 | -11, -12	●	○	○					12+13	27	↓	42+43	53		65
		Rough	.NMA	●	○						13	27		43	53		66
			-R28	●	○	○					13	27		43	53		
			-R58	●	○	○					13+14	27+28		44	53+54		
			-R88	●	○	○					14			44			
Main application: **Stainless**	Sharp ↕ stable	Fine	-F30	○	●			○			14	28		44	54	59	66
		Medium	-M30	○	●			○			14	28		44	54	59+60	66
			-M42	○	●			●			15	28		↓	↓		↓
			-M60	○	●			○			15	28		44	54		66
Main application: **Heat-resistant**	Sharp ↕ stable	Fine	-F32		●		○	●			↓	↓				↓	
			-F34 DUMMY	●	●		○	●			15						66
		Medium	-M34	●	●		○	●			15	28		44	54	60	66
			-M42	○	●		○	●			15	↓			↓		↓
			-M52		●		○	●			↓	↓		↓	↓		↓
Main application: **Non-ferrous metals**		Diamond	FN , FL, FR				●			●	16	29					

9

↓ This article can be found in our online shop at cuttingtools.ceratizit.com

Toolfinder – positive inserts

				Steel	Stainless steel	Cast iron	Non-ferrous metals	Heat-resistant	Tempered steel	Non-metal materials	Geometry								
				P	M	K	N	S	H	O	CC..	DC..	RC..	SC..	SP..	TC..	TP..	VC..	WC..
Main application: **Steel and cast iron**	Sharp	Fine	-CF05	●	○	○					72	95		2		128		148	
			-SF	●	○	○					72+73	95+96		2		128		148	169
		Medium	-CF55	●	○	○					72	95		2		128		148	
			-M23	●		○							120						
			-SMF	●	○	○					72+73	95+96	119	2		128		148+149	
			-SM	●	○	●					73	96	119+120	2		128		149	
			-SMQ	●		○					73+74	97							
	stable		-EN, -EL, -ER	●	○	●									🛒		🛒		
Main application: **Stainless**	Sharp	Fine	-F43	○	●			●			🛒	🛒				🛒			
			-M81	○	●			○			🛒	🛒						🛒	
		Medium	-M25	○	●			●			74	97		129		139		149	
	stable		-M55	○	●			●			74	97		129		139		149	
Main application: **Non-ferrous metals**	Sharp	Fine	-23P			○	●			○	74	97							
		Medium	-25P	●	●	○	●	●		○	74	97	120	129				150	
			-25Q	●	●	○	●	●		○	74	97						150	
			-27	●	●	○	●	●		○	74	98	120	129		140		150	
	stable		-29			○	●			○	75	98						150	
		Diamond	-FN , -FL, -FR				●			●	76–80	99–103	121	130+131		141+142		151–153	169
			CB1				●			●	77+80	100–103	121	130		141		152+153	
			CB2				●			●	77+80	100 102+103	121	131		142		152+153	
			CB3				●			●	79	102		131		142		153	
Main application: **Heat-resistant**	Sharp	Fine	-F05	●	●		●	●			75	98						150	
	stable		-F23		●	○	○	●			🛒	🛒						🛒	

🛒 This article can be found in our online shop at cuttingtools.ceratizit.com

Toolfinder – holders

Toolholders and boring bars for negative inserts

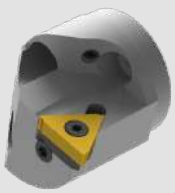
Geometry	Tool holder	Boring bars	HSK-T	PSC
CN..	17–20	23+24	21	22
DN..	30–33	40+41	33–35	36–39
SN..	45–50	51	50	
TN..	55–57	58		
VN..	61		62	62+63
WN..	67+68	70+71	69	69

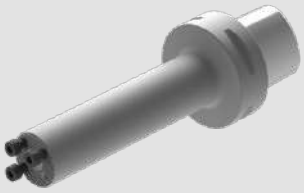
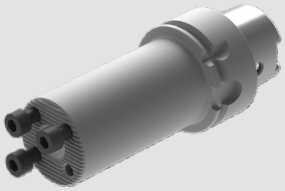
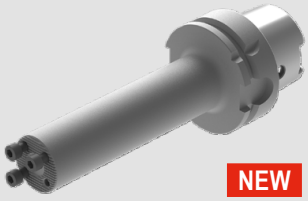
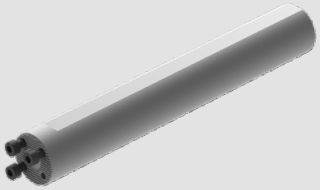
Toolholders and boring bars for positive inserts

Geometry	Tool holder	Boring bars	HSK-T	PSC
CC..	81–87	90–94	88	89
DC..	104–110	114–118	111	112+113
RC..	122–126		127	
SC..	132–136	137		
TC..	143–146	147		
VC..	154–162	166–168	162–164	164+165
WC..		170		

Passendes Kühlmittelzubehör finden Sie auf → **Seite 183–185.**

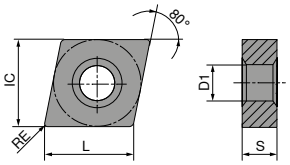
Overview of exchangeable head system

Exchangeable cutting heads		
PCLN 95° CN.. 1204		178
PDUN 93° DN.. 1104 DN.. 1506		178
PDQN 107,5° DN.. 1104		179
PWLN 95° WN.. 0804		179
SCLC 95° CC.. 1204		180
SDUC 93° DC.. 11T3		180
SDQC 107,5° DC.. 11T3		181
For internal thread 16 ..		182

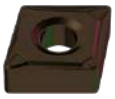
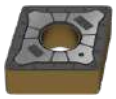
Basic holder		
PSC 40/50/63		171
PSC 63 Vibration damped		172
PSC 40/50/63 Actively vibration-damped NEW		173
HSK-T 40/63/100		174
HSK-T 63 Vibration damped NEW		175
HSK-T 63 Actively vibration-damped NEW		176
cylindrical 25 mm 32 mm 40 mm		177

CNMG / CNMA / CNMM

Designation	L mm	S mm	D1 mm	IC mm
CNMG 0903..	9.7	3.18	3.81	9.52
CNM. 1204..	12.9	4.76	5.16	12.70
CNM. 1606..	16.1	6.35	6.35	15.87
CNM. 1906..	19.3	6.35	7.94	19.05
CNMM 2509..	25.8	9.52	9.12	25.40

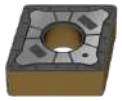
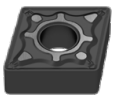
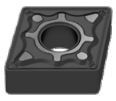
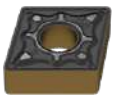
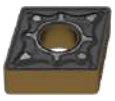


CNMG

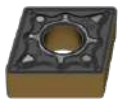
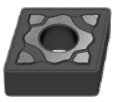
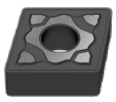
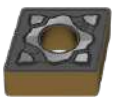
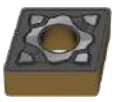
		NEW	NEW	NEW	NEW
	-CF TCM10	-CF20 CTEP110	-TFQ CTEP110	-F50 CTCP115-P	-F50 CTCP125-P	-F50 CTCP135-P	-TFQ CTCP115-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
	F	F	F	F	F	F	F
	CERMET CNMG	CERMET CNMG	CERMET CNMG	CNMG	CNMG	CNMG	CNMG
	70 101 ...	76 101 ...	76 110 ...	76 132 ...	76 132 ...	76 132 ...	76 110 ...
ISO / RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
090304EN 0.4				XX,YY 31601	XX,YY 51601	XX,YY 71601	
090308EN 0.8				XX,YY 31801	XX,YY 51801	XX,YY 71801	
120404EN 0.4	XX,YY 904	XX,YY 028	XX,YY 028	XX,YY 32801	XX,YY 52801	XX,YY 72801	XX,YY 32801
120408EN 0.8	XX,YY 908	XX,YY 030	XX,YY 030	XX,YY 33001	XX,YY 53001	XX,YY 73001	XX,YY 33001
120412EN 1.2			XX,YY 032	XX,YY 33201	XX,YY 53201	XX,YY 73201	XX,YY 32001
P	●	●	●	●	●	●	●
M	○	○	○			○	
K	○	○	○	○	○		○
N							
S							
H							
O							

9

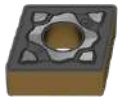
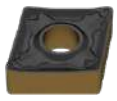
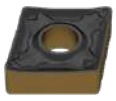
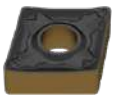
CNMG

		NEW	NEW	NEW			NEW	NEW
		-TFQ CTCP125-P	-XU CTCP115-P	-XU CTCP125-P	-M50 CTCK110	-M50 CTCK120	-M50 CTCP115-P	-M50 CTCP125-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		F	M	M	M	M	M	M
		CNMG	CNMG	CNMG	CNMG	CNMG	CNMG	CNMG
		76 110 ...	76 290 ...	76 290 ...	70 132 ...	70 132 ...	76 135 ...	76 135 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
120404EN	0.4	XX,YY 52801	XX,YY 32801	XX,YY 52801	XX,YY 028		XX,YY 32801	XX,YY 52801
120408EN	0.8	XX,YY 53001	XX,YY 33001	XX,YY 53001	XX,YY 030	XX,YY 530	XX,YY 33001	XX,YY 53001
120412EN	1.2	XX,YY 53201	XX,YY 33201	XX,YY 53201	XX,YY 032	XX,YY 532	XX,YY 32001	XX,YY 53201
120416EN	1.6						XX,YY 33401	XX,YY 53401
160608EN	0.8						XX,YY 34201	XX,YY 54201
160612EN	1.2						XX,YY 34401	XX,YY 54401
160616EN	1.6						XX,YY 34601	XX,YY 54601
P		●	●	●	○	○	●	●
M								
K		○	○	○	●	●	○	○
N								
S								
H								
O								

CNMG

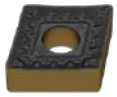
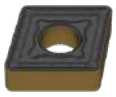
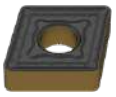
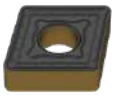
		NEW	NEW	NEW			NEW	NEW
		-M50 CTCP135-P	-TMQ CTCP115-P	-TMQ CTCP125-P	-M70 CTCK110	-M70 CTCK120	-M70 CTCP115-P	-M70 CTCP125-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		M	M	M	M	M	M	M
		CNMG	CNMG	CNMG	CNMG	CNMG	CNMG	CNMG
		76 135 ...	76 196 ...	76 196 ...	70 119 ...	70 119 ...	76 119 ...	76 119 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
120404EN	0.4	XX,YY 72801						
120408EN	0.8	XX,YY 73001	XX,YY 33001	XX,YY 53001	XX,YY 030	XX,YY 530	XX,YY 33001	XX,YY 53001
120412EN	1.2	XX,YY 73201	XX,YY 32001	XX,YY 53201	XX,YY 032	XX,YY 532	XX,YY 32001	XX,YY 53201
120416EN	1.6	XX,YY 73401			XX,YY 034	XX,YY 534	XX,YY 33401	XX,YY 53401
160608EN	0.8	XX,YY 74201			XX,YY 042	XX,YY 542	XX,YY 34201	XX,YY 54201
160612EN	1.2	XX,YY 74401			XX,YY 044	XX,YY 544	XX,YY 34401	XX,YY 54401
160616EN	1.6	XX,YY 74601			XX,YY 046	XX,YY 546	XX,YY 34601	XX,YY 54601
160624EN	2.4						XX,YY 34801	XX,YY 54801
190608EN	0.8						XX,YY 35401	XX,YY 55401
190612EN	1.2				XX,YY 056	XX,YY 556	XX,YY 35601	XX,YY 55601
190616EN	1.6				XX,YY 058	XX,YY 558	XX,YY 35801	XX,YY 55801
190624EN	2.4						XX,YY 36001	XX,YY 56001
P		●	●	●	○	○	●	●
M		○						
K			○	○	●	●	○	○
N								
S								
H								
O								

CNMG / CNMA / CNMM

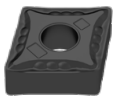
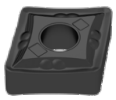
		NEW			NEW	NEW	NEW	NEW
		-M70 CTCP135-P	CTCK110	CTCK120	-R28 CTCP115-P	-R28 CTCP125-P	-R28 CTCP135-P	-R58 CTCP115-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		M	R	R	R	R	R	R
		CNMG	CNMA	CNMA	CNMM	CNMM	CNMM	CNMM
		76 119 ...	70 100 ...	70 100 ...	76 114 ...	76 114 ...	76 114 ...	76 115 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
120404EN	0.4		XX,YY 028	XX,YY 528				
120408EN	0.8	XX,YY 73001	XX,YY 030	XX,YY 530	XX,YY 33001	XX,YY 53001		XX,YY 33001
120412EN	1.2	XX,YY 73201	XX,YY 032	XX,YY 532	XX,YY 33201	XX,YY 53201	XX,YY 73201	XX,YY 33201
120416EN	1.6	XX,YY 73401	XX,YY 034	XX,YY 534	XX,YY 33401	XX,YY 53401	XX,YY 73401	XX,YY 33401
160608EN	0.8	XX,YY 74201	XX,YY 042	XX,YY 542				
160612EN	1.2	XX,YY 74401	XX,YY 044	XX,YY 544	XX,YY 34401	XX,YY 54401	XX,YY 74401	XX,YY 34401
160616EN	1.6	XX,YY 74601	XX,YY 046	XX,YY 546	XX,YY 34601	XX,YY 54601	XX,YY 74601	XX,YY 34601
160624EN	2.4	XX,YY 74801						XX,YY 34801
190608EN	0.8	XX,YY 75401						
190612EN	1.2	XX,YY 75601	XX,YY 056	XX,YY 556	XX,YY 35601	XX,YY 55601	XX,YY 75601	XX,YY 35601
190616EN	1.6	XX,YY 75801	XX,YY 058	XX,YY 558	XX,YY 35801	XX,YY 55801	XX,YY 75801	XX,YY 35801
190624EN	2.4	XX,YY 76001			XX,YY 36001	XX,YY 56001	XX,YY 76001	XX,YY 36001
250924EN	2.4				XX,YY 38401	XX,YY 58401	XX,YY 78401	XX,YY 38401
P		●	○	○	●	●	●	●
M		○					○	
K			●	●	○	○		○
N								
S								
H								
O								

9

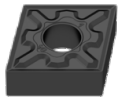
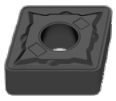
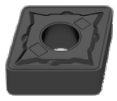
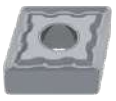
CNMM

		NEW	NEW	NEW	NEW	NEW
		-R58 CTCP125-P	-R58 CTCP135-P	-R88 CTCP115-P	-R88 CTCP125-P	-R88 CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
		R CNMM	R CNMM	R CNMM	R CNMM	R CNMM
		76 115 ...	76 115 ...	76 133 ...	76 133 ...	76 133 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
120408EN	0.8	XX,YY 53001	XX,YY 73001			
120412EN	1.2	XX,YY 53201	XX,YY 73201			
120416EN	1.6	XX,YY 53401	XX,YY 73401			
160612EN	1.2	XX,YY 54401	XX,YY 74401			
160616EN	1.6	XX,YY 54601	XX,YY 74601			
160624EN	2.4	XX,YY 54801	XX,YY 74801			
160624SN	2.4			XX,YY 34801	XX,YY 54801	XX,YY 74801
190612EN	1.2	XX,YY 55601	XX,YY 75601			
190616EN	1.6	XX,YY 55801	XX,YY 75801			
190616SN	1.6			XX,YY 35801	XX,YY 55801	XX,YY 75801
190624EN	2.4	XX,YY 52401	XX,YY 76001			
190624SN	2.4			XX,YY 36001	XX,YY 56001	XX,YY 76001
250924EN	2.4	XX,YY 58401	XX,YY 78401			
250924SN	2.4			XX,YY 38401	XX,YY 58401	XX,YY 78401
P		●	●	●	●	●
M			○			○
K		○		○	○	
N						
S						
H						
O						

CNMG

		-F30 CTCM120	-F30 CTPM125	-F30 CTCM130	-M30 CTCM120	-M30 CTPM125	-M30 CTCM130
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
		F CNMG	F CNMG	F CNMG	M CNMG	M CNMG	M CNMG
		75 010 ...	75 010 ...	75 010 ...	75 011 ...	75 011 ...	75 011 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
120404EN	0.4	XX,YY 12800	XX,YY 280	XX,YY 32800			
120408EN	0.8	XX,YY 13000	XX,YY 230	XX,YY 33000	XX,YY 13000	XX,YY 230	XX,YY 33000
120412EN	1.2				XX,YY 13200	XX,YY 232	XX,YY 33200
120416EN	1.6				XX,YY 13400	XX,YY 234	XX,YY 33400
P		○	○	○	○	○	○
M		●	●	●	●	●	●
K							
N							
S				○			○
H							
O							

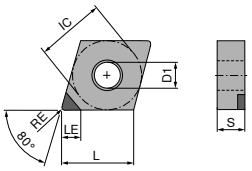
CNMG

		NEW				NEW		NEW
		-M42 CTCM130	-M60 CTCM120	-M60 CTPM125	-M60 CTCM130	-F34 CTPX710	-M34 CTPX710	-M42 CTPX710
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		M	M	M	M	F	M	M
		CNMG	CNMG	CNMG	CNMG	CNMG	CNMG	CNMG
		75 029 ...	75 012 ...	75 012 ...	75 012 ...	75 299 ...	75 003 ...	75 007 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
120404EN	0.4	XX,YY 32800				XX,YY 62800	XX,YY 62800	
120408EN	0.8	XX,YY 33000	XX,YY 13000	XX,YY 230	XX,YY 33000	XX,YY 63000	XX,YY 63000	XX,YY 63000
120412EN	1.2	XX,YY 33200	XX,YY 13200	XX,YY 232	XX,YY 33200	XX,YY 63200	XX,YY 63200	XX,YY 63200
120416EN	1.6		XX,YY 13400	XX,YY 234	XX,YY 33400		XX,YY 63400	
160612EN	1.2		XX,YY 14400	XX,YY 24400	XX,YY 34400			
P		○	○	○	○	●	●	●
M		●	●	●	●	●	●	●
K								
N						○	○	○
S		○			○	●	●	●
H								
O								

9

CNGA

Designation	L mm	S mm	D1 mm	IC mm
CNGA 1204..	12.9	4.76	5.13	12.7

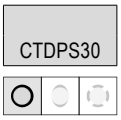


CNGA A

CNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners

F
DIAMOND
CNGA
71 127 ...
#CU#
PA

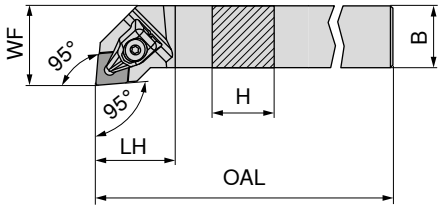


F
DIAMOND
CNGA
71 127 ...
#CU#
PA

ISO	RE mm	TCE (NOI)	LE mm		
120404FN	0.4	**A (1)**	6.3	XX,YY **10001**	XX,YY **20001**
120408FN	0.8	**A (1)**	6.0	XX,YY **10101**	XX,YY **20101**
120412FN	1.2	**A (1)**	5.7	XX,YY **10201**	XX,YY **20201**
P					
M					
K					
N				●	●
S					
H					
O				●	●

MaxiLock-D – DCLN 95° – Toolholder with top clamping

Scope of supply:
Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 509 ... #CU# *PA*		Right-hand 70 508 ... #CU# *PA*	
DCLN R/L 1616 H09	16	16	100	23	20	2	CN.. 0903	XX,YY	**516**	XX,YY	**516**
DCLN R/L 2020 K09	20	20	125	24	25	2	CN.. 0903	XX,YY	**520**	XX,YY	**520**
DCLN R/L 2020 K12	20	20	125	32	25	4	CN.. 1204	XX,YY	**620**	XX,YY	**620**
DCLN R/L 2525 M12	25	25	150	32	32	4	CN.. 1204	XX,YY	**625**	XX,YY	**625**
DCLN R/L 3225 P12	32	25	170	32	32	4	CN.. 1204	XX,YY	**632**	XX,YY	**632**
DCLN R/L 2525 M16	25	25	150	38	32	6,5	CN.. 1606	XX,YY	**725**	XX,YY	**725**
DCLN R/L 3232 P16	32	32	170	36	40	6,5	CN.. 1606	XX,YY	**732**	XX,YY	**732**
DCLN R/L 3232 P19	32	32	170	42	40	6,5	CN.. 1906	XX,YY	**832**	XX,YY	**832**
DCLN R/L 4040 S19	40	40	250	42	50	6,5	CN.. 1906	XX,YY	**940**	XX,YY	**940**
DCLN R/L 4040 S25	40	40	250	60	50	6,5	CN.. 2509	XX,YY	**440**	XX,YY	**440**


XPress type


Key D

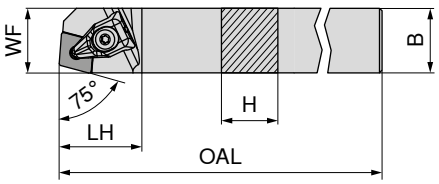

Clamping screw


Carbide type C

Spare parts for Article no.	XPress type 70 950 ... #CU# *PA*		Key D 80 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*		Carbide type C 70 950 ... #CU# *PA*	
70 508 516 / 70 509 516	XX,YY	**823**	T09 - IP	XX,YY **126**	M3x7 - IP	XX,YY **819**	XX,YY	**848**
70 508 520 / 70 509 520	XX,YY	**823**	T09 - IP	XX,YY **126**	M3x7 - IP	XX,YY **819**	XX,YY	**848**
70 508 620 / 70 509 620	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**810**
70 508 625 / 70 509 625	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**810**
70 508 632 / 70 509 632	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**810**
70 508 725 / 70 509 725	XX,YY	**825**	T20 - IP	XX,YY **129**	M5x14 - IP	XX,YY **821**	XX,YY	**814**
70 508 732 / 70 509 732	XX,YY	**825**	T20 - IP	XX,YY **129**	M5x14 - IP	XX,YY **821**	XX,YY	**814**
70 508 832 / 70 509 832	XX,YY	**826**	T20 - IP	XX,YY **129**	M5x14 - IP	XX,YY **821**	XX,YY	**816**
70 508 940 / 70 509 940	XX,YY	**826**	T20 - IP	XX,YY **129**	M5x14 - IP	XX,YY **821**	XX,YY	**816**
70 508 440 / 70 509 440	XX,YY	**827**	T25 - IP	XX,YY **122**	M6x16 - IP	XX,YY **822**	XX,YY	**625**

MaxiLock-D – DCBN 75° – Toolholder with top clamping

Scope of supply:
Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 501 ... #CU# *PA*		Right-hand 70 500 ... #CU# *PA*	
DCBN R/L 2525 M12	25	25	150	32	22	4	CN.. 1204	XX,YY	**825**	XX,YY	**825**


XPress type

Key D

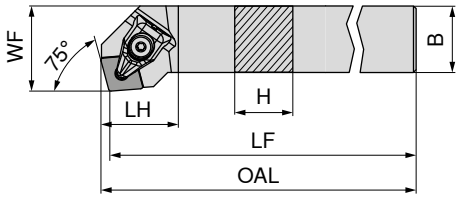

Clamping screw


Carbide type C

Spare parts for Article no.	XPress type 70 950 ... #CU# *PA*		Key D 80 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*		Carbide type C 70 950 ... #CU# *PA*	
70 501 825 / 70 500 825	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**810**

MaxiLock-D – DCKN 75° – Toolholder with top clamping

Scope of supply:
Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LF mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 505 ... #CU# *PA*		Right-hand 70 504 ... #CU# *PA*	
DCKN R/L 2525 M12	25	25	152.9	150	28.9	32	4	CN.. 1204	XX,YY	**825**	XX,YY	**825**


XPress type

Key D

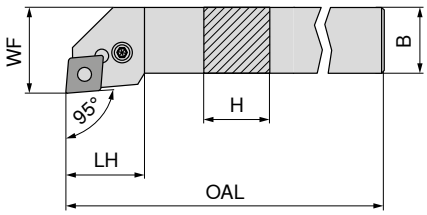

Clamping screw


Carbide type C

Spare parts for Article no.	70 950 ... #CU# *PA*		80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 505 825 / 70 504 825	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**810**

MaxiLock-N – PCLN 95° – Toolholder with lever clamping

Scope of supply:
Tool holder with allen key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 509 ... #CU# *PA*		Right-hand 70 508 ... #CU# *PA*	
PCLN R/L 1616 H12	16	16	100	26.2	20	4	CN.. 1204	XX,YY	**016**	XX,YY	**016**
PCLN R/L 2020 K12	20	20	125	27.5	25	4	CN.. 1204	XX,YY	**020**	XX,YY	**020**
PCLN R/L 2525 M12	25	25	150	28.1	32	4	CN.. 1204	XX,YY	**025**	XX,YY	**025**
PCLN R/L 3225 P12	32	25	170	28.1	32	4	CN.. 1204	XX,YY	**032**	XX,YY	**032**
PCLN R/L 2525 M16	25	25	150	32.7	32	4	CN.. 1606	XX,YY	**125**	XX,YY	**125**
PCLN R/L 3232 P16	32	32	170	32.6	40	4	CN.. 1606	XX,YY	**132**	XX,YY	**132**
PCLN R/L 3232 P19	32	32	170	38.0	40	8	CN.. 1906	XX,YY	**232**	XX,YY	**232**
PCLN R/L 4040 S19	40	40	250	38.0	50	8	CN.. 1906	XX,YY	**54000**	XX,YY	**54000**
PCLN R/L 4040 S25	40	40	250	50.0	50	8	CN.. 2509	XX,YY	**340**	XX,YY	**340**

Key I


Shim

Assembly pin


Lever

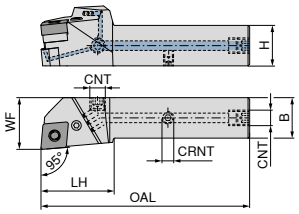

Clamping screw


Carbide type C

Spare parts for Article no.		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 508 016 / 70 509 016	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**209**	XX,YY	**233**
70 508 020 / 70 509 020	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**209**	XX,YY	**233**
70 508 025 / 70 509 025	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**209**	XX,YY	**233**
70 508 032 / 70 509 032	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**209**	XX,YY	**233**
70 508 125 / 70 509 125	SW3	XX,YY	**176**	XX,YY	**391**	XX,YY	**394**	XX,YY	**385**	XX,YY	**388**	XX,YY	**380**
70 508 132 / 70 509 132	SW3	XX,YY	**176**	XX,YY	**391**	XX,YY	**394**	XX,YY	**385**	XX,YY	**388**	XX,YY	**380**
70 508 232 / 70 509 232	SW4	XX,YY	**396**	XX,YY	**392**	XX,YY	**395**	XX,YY	**386**	XX,YY	**389**	XX,YY	**381**
70 508 54000 / 70 509 54000	SW4	XX,YY	**396**	XX,YY	**392**	XX,YY	**395**	XX,YY	**386**	XX,YY	**389**	XX,YY	**381**
70 508 340 / 70 509 340	SW5	XX,YY	**265**	XX,YY	**621**	XX,YY	**623**	XX,YY	**620**	XX,YY	**622**	XX,YY	**624**

MaxiLock-N – PCLN 95° DC – Toolholder with lever clamping

Scope of supply:
Tool holder with allen key



Illustrations show right-hand versions

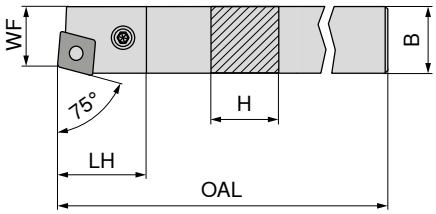
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CNT	CRNT	torque moment Nm	Insert	NEW Left-hand 70 592 ... #CU# *PA*	NEW Right-hand 70 592 ... #CU# *PA*
PCLN R/L 2020 X12-T DC	20	20	109	40	25	G1/8"	M6	4	CN.. 1204	XX,YY **02000**	XX,YY **02001**
PCLN R/L 2525 X12-T DC	25	25	124	40	32	G1/8"	M6	4	CN.. 1204	XX,YY **02500**	XX,YY **02501**
PCLN R/L 3225 X12-T DC	32	25	140	40	32	G1/8"	M6	4	CN.. 1204	XX,YY **03200**	XX,YY **03201**
PCLN R/L 2525 X16-T DC	25	25	129	45	32	G1/8"	M6	4	CN.. 1606	XX,YY **12500**	XX,YY **12501**
PCLN R/L 3232 X16-T DC	32	32	145	45	40	G1/8"	M6	4	CN.. 1606	XX,YY **13200**	XX,YY **13201**
PCLN R/L 3232 X19-T DC	32	32	150	50	40	G1/8"	M6	8	CN.. 1906	XX,YY **23200**	XX,YY **23201**
PCLN R/L 4040 X19-T DC	40	40	175	50	48	G1/8"	M6	8	CN.. 1906	XX,YY **04000**	XX,YY **04001**
PCLN R/L 4040 X25-T DC	40	40	185	60	48	G1/8"	M6	8	CN.. 2509	XX,YY **14000**	XX,YY **14001**

Spare parts for Article no.	Key I 70 950 ... #CU# *PA*	Shim 70 950 ... #CU# *PA*	Assembly pin 70 950 ... #CU# *PA*	Coolant screw plug 70 950 ... #CU# *PA*	Lever 70 950 ... #CU# *PA*	Clamping screw 70 950 ... #CU# *PA*	Carbide type C 70 950 ... #CU# *PA*	Grubscrew 70 950 ... #CU# *PA*
70 592 02000 / 70 592 02001	XX,YY **176**	XX,YY **198**	XX,YY **192**	XX,YY **294**	XX,YY **187**	XX,YY **209**	XX,YY **233**	XX,YY **86700**
70 592 02500 / 70 592 02501	XX,YY **176**	XX,YY **198**	XX,YY **192**	XX,YY **294**	XX,YY **187**	XX,YY **209**	XX,YY **233**	XX,YY **86700**
70 592 03200 / 70 592 03201	XX,YY **176**	XX,YY **198**	XX,YY **192**	XX,YY **294**	XX,YY **187**	XX,YY **209**	XX,YY **233**	XX,YY **86700**
70 592 12500 / 70 592 12501	XX,YY **176**	XX,YY **391**	XX,YY **394**	XX,YY **294**	XX,YY **385**	XX,YY **388**	XX,YY **380**	XX,YY **86700**
70 592 13200 / 70 592 13201	XX,YY **176**	XX,YY **391**	XX,YY **394**	XX,YY **294**	XX,YY **385**	XX,YY **388**	XX,YY **380**	XX,YY **86700**
70 592 23200 / 70 592 23201	XX,YY **396**	XX,YY **392**	XX,YY **395**	XX,YY **294**	XX,YY **386**	XX,YY **389**	XX,YY **381**	XX,YY **86700**
70 592 04000 / 70 592 04001	XX,YY **396**	XX,YY **392**	XX,YY **395**	XX,YY **294**	XX,YY **386**	XX,YY **389**	XX,YY **381**	XX,YY **86700**
70 592 14000 / 70 592 14001	XX,YY **265**	XX,YY **621**	XX,YY **623**	XX,YY **294**	XX,YY **620**	XX,YY **622**	XX,YY **624**	XX,YY **86700**

9

MaxiLock-N – PCBN 75° – Toolholder with lever clamping

Scope of supply:
Tool holder with allen key



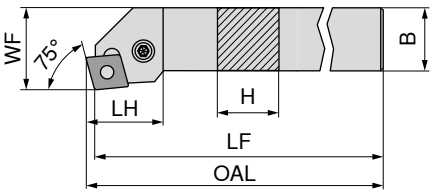
Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 501 ... #CU# *PA*	Right-hand 70 500 ... #CU# *PA*
PCBN R/L 2525 M12	25	25	150	27.70	22	4	CN.. 1204	XX,YY **025**	XX,YY **025**
PCBN R/L 2525 M16	25	25	150	31.81	22	4	CN.. 1606	XX,YY **12500**	XX,YY **125**
PCBN R/L 3232 P19	32	32	170	38.00	27	8	CN.. 1906	XX,YY **032**	XX,YY **032**

Spare parts for Article no.		Key I 70 950 ... #CU# *PA*	Shim 70 950 ... #CU# *PA*	Assembly pin 70 950 ... #CU# *PA*	Lever 70 950 ... #CU# *PA*	Clamping screw 70 950 ... #CU# *PA*	Carbide type C 70 950 ... #CU# *PA*
70 500 025 / 70 501 025	SW3	XX,YY **176**	XX,YY **198**	XX,YY **192**	XX,YY **187**	XX,YY **209**	XX,YY **233**
70 500 125 / 70 501 12500	SW3	XX,YY **176**	XX,YY **391**	XX,YY **394**	XX,YY **385**	XX,YY **388**	XX,YY **380**
70 500 032 / 70 501 032	SW4	XX,YY **396**	XX,YY **392**	XX,YY **395**	XX,YY **386**	XX,YY **389**	XX,YY **381**

MaxiLock-N – PCKN 75° – Toolholder with lever clamping

Scope of supply:
Tool holder with allen key



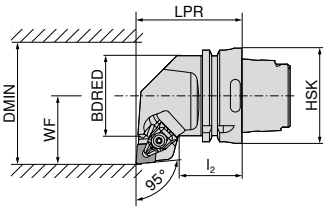
Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LF mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 505 ... #CU# *PA*		Right-hand 70 504 ... #CU# *PA*	
PCKN R/L 2525 M12	25	25	153.07	150	31.4	32	4	CN.. 1204	XX,YY	**025**	XX,YY	**025**

		Key I 70 950 ... #CU# *PA*		Shim 70 950 ... #CU# *PA*		Assembly pin 70 950 ... #CU# *PA*		Lever 70 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*		Carbide type C 70 950 ... #CU# *PA*	
Spare parts for Article no.													
70 505 025 / 70 504 025	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**209**	XX,YY	**233**

MaxiLock-D – DCLN 95° – Toolholder with top clamping

Scope of supply:
Tool holder with Torx key

Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	l_2 mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 504 ... #CU# *PA*		Right-hand 74 503 ... #CU# *PA*	
HSK T63 DCLN R/L 12	HSK-T 63	70	42	53	45	100	4	CN.. 1204	XX,YY	512	XX,YY	512
HSK T63 DCLN R/L 16	HSK-T 63	70	42	53	45	125	4	CN.. 1606	XX,YY	516	XX,YY	516
HSK T63 DCLN R/L 19	HSK-T 63	70	42	53	45	125	8	CN.. 1906	XX,YY	519	XX,YY	519
HSK T100 DCLN R/L 12	HSK-T 100	80	45	88	55	125	4	CN.. 1204	XX,YY	712	XX,YY	712
HSK T100 DCLN R/L 19	HSK-T 100	80	45	88	55	125	8	CN.. 1906	XX,YY	719	XX,YY	719


XPress type

Key D


Clamping screw

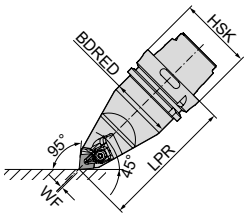

Carbide type C

Spare parts for Article no.	70 950 ... #CU# *PA*		80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
74 504 512 / 74 503 512	XX,YY	824	T15 - IP	XX,YY 128	M4,5x12 - IP	XX,YY 820	XX,YY	810
74 504 516 / 74 503 516	XX,YY	825	T20 - IP	XX,YY 129	M5x14 - IP	XX,YY 821	XX,YY	814
74 504 519 / 74 503 519	XX,YY	826	T20 - IP	XX,YY 129	M5x14 - IP	XX,YY 821	XX,YY	816
74 504 712 / 74 503 712	XX,YY	824	T15 - IP	XX,YY 128	M4,5x12 - IP	XX,YY 820	XX,YY	810
74 504 719 / 74 503 719	XX,YY	826	T20 - IP	XX,YY 129	M5x14 - IP	XX,YY 821	XX,YY	816

9

MaxiLock-D – DCMN 95° – Toolholder with top clamping

Scope of supply:
Tool holder with Torx key

ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert	Neutral 74 506 ... #CU# *PA*	
HSK T63 DCMN N 12	HSK-T 63	115	53	0	4	CN.. 1204	XX,YY	512
HSK T100 DCMN N 12	HSK-T 100	150	88	0	4	CN.. 1204	XX,YY	712


XPress type

Key D

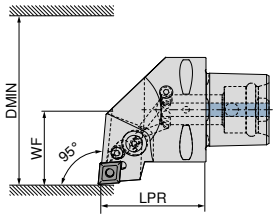

Clamping screw


Carbide type C

Spare parts for Article no.	70 950 ... #CU# *PA*		80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
74 506 512	XX,YY	824	T15 - IP	XX,YY 128	M4,5x12 - IP	XX,YY 820	XX,YY	810
74 506 712	XX,YY	824	T15 - IP	XX,YY 128	M4,5x12 - IP	XX,YY 820	XX,YY	810

MaxiLock-N – PCLN 95° – Toolholder with lever clamping

Scope of supply:
without high-performance coolant set

Illustrations show right-hand versions

								Left-hand		Right-hand	
								84 657 ...		**84 656 ...**	
ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Direct cooling compatible	#CU# *PA*		#CU# *PA*	
PSC40 PCLN R/L 50050-12	PSC 40	50	27	50	5	CN.. 1204	DC	XX,YY	**01295**	XX,YY	**01295**
PSC50 PCLN R/L 65060-12	PSC 50	60	35	65	5	CN.. 1204	DC	XX,YY	**01294**	XX,YY	**01294**
PSC63 PCLN R/L 80065-12	PSC 63	65	45	80	5	CN.. 1204	DC	XX,YY	**01293**	XX,YY	**01293**

The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page PL**.


Shim

Elbow lever screw

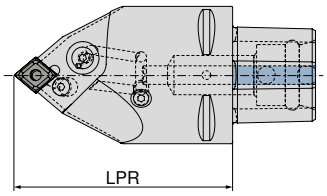
Lever

Carbide type C

	84 950 ...			**84 950 ...**		**84 950 ...**		**84 950 ...**	
Spare parts for Article no.	#CU# *PA*			#CU# *PA*		#CU# *PA*		#CU# *PA*	
84 656 01295 / 84 657 01295	XX,YY	**29200**	M8X1/L17 SW3	XX,YY	**28700**	XX,YY	**29000**	XX,YY	**27800**
84 656 01294 / 84 657 01294	XX,YY	**29200**	M8X1/L17 SW3	XX,YY	**28700**	XX,YY	**29000**	XX,YY	**27800**
84 656 01293 / 84 657 01293	XX,YY	**29200**	M8X1/L17 SW3	XX,YY	**28700**	XX,YY	**29000**	XX,YY	**27800**

MaxiLock-N – PCMN 50° – Toolholder with lever clamping

Scope of supply:
without high-performance coolant set

						Neutral
						84 675 ...
ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Direct cooling compatible	#CU# *PA*
PSC63 PCMN N 0100-12	PSC 63	100	5	CN.. 1204	DC	XX,YY **01293**
PSC63 PCMN N 0130-12	PSC 63	130	5	CN.. 1204	DC	XX,YY **11293**

The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page PL**.


Shim

Elbow lever screw

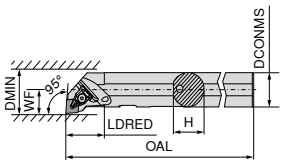
Lever

Carbide type C

	84 950 ...			**84 950 ...**		**84 950 ...**		**84 950 ...**	
Spare parts for Article no.	#CU# *PA*			#CU# *PA*		#CU# *PA*		#CU# *PA*	
84 675 01293	XX,YY	**29200**	M8X1/L17 SW3	XX,YY	**28700**	XX,YY	**29000**	XX,YY	**27800**
84 675 11293	XX,YY	**29200**	M8X1/L17 SW3	XX,YY	**28700**	XX,YY	**29000**	XX,YY	**27800**

MaxiLock-D – DCLN 95° – Boring bar with top clamping

Scope of supply:
Boring bar with Torx key



Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 557 ... #CU# *PA*		Right-hand 70 556 ... #CU# *PA*	
A20Q DCLN R/L 09	20	19	180	35	13	25	2	CN.. 0903	XX,YY	**720**	XX,YY	**720**
A25R DCLN R/L 12	25	24	200	36	17	32	4	CN.. 1204	XX,YY	**825**	XX,YY	**825**
A32S DCLN R/L 12	32	31	250	40	22	40	4	CN.. 1204	XX,YY	**832**	XX,YY	**832**
A40T DCLN R/L 12	40	39	300	45	27	50	4	CN.. 1204	XX,YY	**840**	XX,YY	**840**
A40U DCLN L 16	50	47	350	45	35	63	6,5	CN.. 1606	XX,YY	**85000**		


XPress type


Key D


Clamping screw


Carbide type C

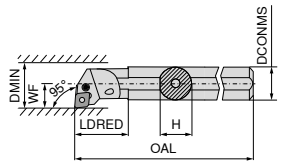
Spare parts for Article no.		70 950 ... #CU# *PA*			80 950 ... #CU# *PA*			70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 556 720 / 70 557 720	SW3	XX,YY	**823**	T09 - IP	XX,YY	**126**	M3x7 - IP	XX,YY	**819**	XX,YY	**848**
70 556 825 / 70 557 825	SW3	XX,YY	**824**	T15 - IP	XX,YY	**128**	M4,5x12 - IP	XX,YY	**820**		
70 556 832 / 70 557 832	SW3	XX,YY	**824**	T15 - IP	XX,YY	**128**	M4,5x12 - IP	XX,YY	**820**	XX,YY	**810**
70 556 840 / 70 557 840	SW3	XX,YY	**824**	T15 - IP	XX,YY	**128**	M4,5x12 - IP	XX,YY	**820**	XX,YY	**810**
70 557 85000	SW3	XX,YY	**825**	T20 - IP	XX,YY	**129**	M5x14 - IP	XX,YY	**821**	XX,YY	**814**

9

MaxiLock-N – PCLN 95° – Boring bar with lever clamping

▲ A... = with thro' coolant
▲ S... = without thro' coolant

Scope of supply:
Boring bar with Allen key



Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 557 ... #CU# *PA*		Right-hand 70 556 ... #CU# *PA*	
A25R PCLN R/L 12	25	23	200	36.0	17	32	4	CN.. 1204	XX,YY	**225**	XX,YY	**225**
S25T PCLN R/L 12	25	23	300	22.0	17	32	4	CN.. 1204	XX,YY	**025**	XX,YY	**025**
A32S PCLN R/L 12	32	30	250	50.0	22	40	4	CN.. 1204	XX,YY	**232**	XX,YY	**232**
S32U PCLN R/L 12	32	30	350	24.1	22	40	4	CN.. 1204	XX,YY	**032**	XX,YY	**032**
A40T PCLN R/L 12	40	38	300	60.0	27	50	4	CN.. 1204	XX,YY	**240**	XX,YY	**240**
S40V PCLN R/L 12	40	38	400	24.1	27	50	4	CN.. 1204	XX,YY	**040**	XX,YY	**04000** [1]
S50W PCLN R/L 16	50	47	450	31.0	35	63	4	CN.. 1606	XX,YY	**050**	XX,YY	**050**

1) nickel-plated


Key I


Shim

Assembly pin


Lever

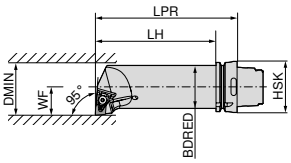

Clamping screw


Carbide type C

Spare parts for Article no.		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 556 225 / 70 557 225	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**205**	XX,YY	**233**
70 556 025 / 70 557 025	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**205**	XX,YY	**233**
70 556 232 / 70 557 232	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**205**	XX,YY	**233**
70 556 032 / 70 557 032	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**205**	XX,YY	**233**
70 556 240 / 70 557 240	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**209**	XX,YY	**233**
70 556 04000 / 70 557 040	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**209**	XX,YY	**233**
70 556 050 / 70 557 050	SW3	XX,YY	**176**	XX,YY	**391**	XX,YY	**394**	XX,YY	**385**	XX,YY	**388**	XX,YY	**380**

MaxiLock-D – DCLN 95° – Boring bar with top clamping

Scope of supply:
Boring bar with Torx key



Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 529 ... #CU# *PA*		Right-hand 74 528 ... #CU# *PA*	
HSK T63 50Q DCLN R/L 12	HSK-T 63	175	149	50	35	63	4	CN.. 1204	XX,YY	**512**	XX,YY	**512**

XPress type

Key D

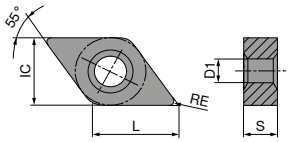
Clamping screw

Carbide type C

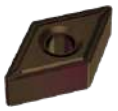
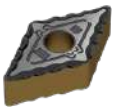
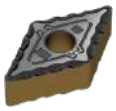
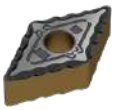
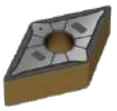
Spare parts for Article no.	70 950 ... #CU# *PA*		80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
74 528 512 / 74 529 512	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**810**

DNMG / DNMA / DNMM

Designation	L mm	S mm	D1 mm	IC mm
DNMG 1104..	11.6	4.76	3.81	9.52
DNMG 1504..	15.5	4.76	5.16	12.70
DNM. 1506..	15.5	6.35	5.16	12.70

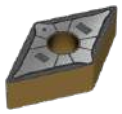
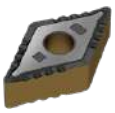
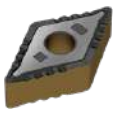
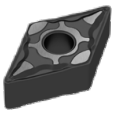
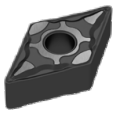
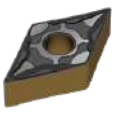
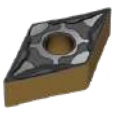


DNMG

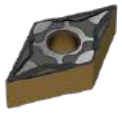
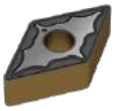
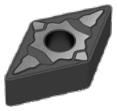
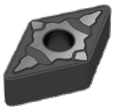
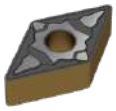
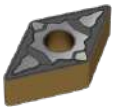
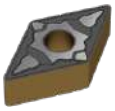
		NEW			NEW	NEW	NEW	NEW
		-CF TCM10	-CF20 CTEP110	-TFQ CTEP110	-F50 CTCP115-P	-F50 CTCP125-P	-F50 CTCP135-P	-TFQ CTCP115-P
			DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		F	F	F	F	F	F	F
		CERMET DNMG	CERMET DNMG	CERMET DNMG	DNMG	DNMG	DNMG	DNMG
		70 155 ...	76 102 ...	76 153 ...	76 134 ...	76 134 ...	76 134 ...	76 153 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
110402EN	0.2				XX,YY 30201	XX,YY 50201	XX,YY 70201	
110404EN	0.4	XX,YY 904	XX,YY 004		XX,YY 30401	XX,YY 50401	XX,YY 70401	
110408EN	0.8		XX,YY 006		XX,YY 30601	XX,YY 50601	XX,YY 70601	
110412EN	1.2				XX,YY 30801	XX,YY 50801	XX,YY 70801	
150404EN	0.4				XX,YY 31601	XX,YY 51601	XX,YY 71601	
150408EN	0.8				XX,YY 31801	XX,YY 51801	XX,YY 71801	
150412EN	1.2				XX,YY 32001	XX,YY 52001	XX,YY 72001	
150604EN	0.4	XX,YY 914	XX,YY 028	XX,YY 028	XX,YY 32801	XX,YY 52801	XX,YY 72801	XX,YY 32801
150608EN	0.8		XX,YY 030	XX,YY 030	XX,YY 33001	XX,YY 53001	XX,YY 73001	XX,YY 33001
150612EN	1.2		XX,YY 032		XX,YY 33201	XX,YY 53201	XX,YY 73201	
P		●	●	●	●	●	●	●
M		○	○	○			○	
K		○	○	○	○	○		○
N								
S								
H								
O								

9

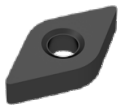
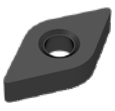
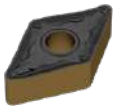
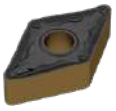
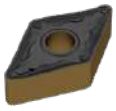
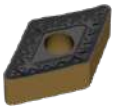
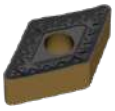
DNMG

		NEW	NEW	NEW			NEW	NEW
		-TFQ CTCP125-P	-XU CTCP115-P	-XU CTCP125-P	-M50 CTCK110	-M50 CTCK120	-M50 CTCP115-P	-M50 CTCP125-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		F	M	M	M	M	M	M
		DNMG	DNMG	DNMG	DNMG	DNMG	DNMG	DNMG
		76 153 ...	76 291 ...	76 291 ...	70 133 ...	70 133 ...	76 136 ...	76 136 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
110404EN	0.4						XX,YY 30401	XX,YY 50401
110408EN	0.8						XX,YY 30601	XX,YY 50601
110412EN	1.2						XX,YY 30801	XX,YY 50801
150404EN	0.4						XX,YY 31601	XX,YY 51401
150408EN	0.8				XX,YY 018	XX,YY 518	XX,YY 31801	XX,YY 51801
150412EN	1.2				XX,YY 020	XX,YY 520	XX,YY 32001	XX,YY 51601
150416EN	1.6						XX,YY 32201	XX,YY 52201
150604EN	0.4	XX,YY 52801	XX,YY 32801	XX,YY 52801			XX,YY 32801	XX,YY 52801
150608EN	0.8	XX,YY 53001	XX,YY 33001	XX,YY 53001	XX,YY 030	XX,YY 530	XX,YY 33001	XX,YY 53001
150612EN	1.2		XX,YY 33201	XX,YY 53201	XX,YY 032	XX,YY 532	XX,YY 33201	XX,YY 53201
150616EN	1.6						XX,YY 33401	XX,YY 53401
P		●	●	●	○	○	●	●
M								
K		○	○	○	●	●	○	○
N								
S								
H								
O								

DNMG

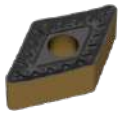
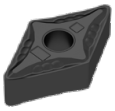
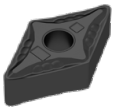
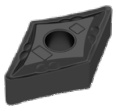
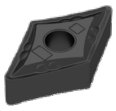
		NEW	NEW			NEW	NEW	NEW
		-M50 CTCP135-P	-TMQ CTCP125-P	-M70 CTCK110	-M70 CTCK120	-M70 CTCP115-P	-M70 CTCP125-P	-M70 CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		M	M	M	M	M	M	M
		DNMG	DNMG	DNMG	DNMG	DNMG	DNMG	DNMG
		76 136 ...	76 197 ...	70 263 ...	70 263 ...	76 263 ...	76 263 ...	76 263 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
110404EN	0.4	XX,YY 70401						
110408EN	0.8	XX,YY 70601				XX,YY 30601	XX,YY 50601	XX,YY 70601
110412EN	1.2	XX,YY 70801				XX,YY 30801	XX,YY 50801	XX,YY 70801
150404EN	0.4	XX,YY 71601						
150408EN	0.8	XX,YY 71801		XX,YY 018	XX,YY 518	XX,YY 31801	XX,YY 51801	XX,YY 71801
150412EN	1.2	XX,YY 72001		XX,YY 020	XX,YY 520	XX,YY 32001	XX,YY 52001	XX,YY 72001
150416EN	1.6	XX,YY 72201				XX,YY 32201	XX,YY 52201	XX,YY 72201
150604EN	0.4	XX,YY 72801						
150608EN	0.8	XX,YY 73001	XX,YY 53001	XX,YY 030	XX,YY 530	XX,YY 33001	XX,YY 53001	XX,YY 73001
150612EN	1.2	XX,YY 73201	XX,YY 53201	XX,YY 032	XX,YY 532	XX,YY 33201	XX,YY 53201	XX,YY 73201
150616EN	1.6	XX,YY 73401		XX,YY 034	XX,YY 534	XX,YY 33401	XX,YY 53401	XX,YY 73401
P		●	●	○	○	●	●	●
M		○						○
K			○	●	●	○	○	
N								
S								
H								
O								

DNMA / DNMM

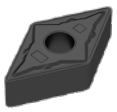
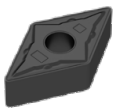
				NEW	NEW	NEW	NEW	NEW
		CTCK110	CTCK120	-R28 CTCP115-P	-R28 CTCP125-P	-R28 CTCP135-P	-R58 CTCP115-P	-R58 CTCP125-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		R	R	R	R	R	R	R
		DNMA	DNMA	DNMM	DNMM	DNMM	DNMM	DNMM
		70 156 ...	70 156 ...	76 165 ...	76 165 ...	76 165 ...	76 166 ...	76 166 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
150408EN	0.8	XX,YY 018	XX,YY 518					
150412EN	1.2	XX,YY 020	XX,YY 520					
150608EN	0.8	XX,YY 030	XX,YY 530					
150612EN	1.2	XX,YY 032	XX,YY 532	XX,YY 33201	XX,YY 53201	XX,YY 73201	XX,YY 33201	XX,YY 53201
150616EN	1.6			XX,YY 33401	XX,YY 53401	XX,YY 73401	XX,YY 33401	XX,YY 53401
P		○	○	●	●	●	●	●
M						○		
K		●	●	○	○		○	○
N								
S								
H								
O								

9

DNMM / DNMG

ISO	RE mm	NEW -R58 CTCP135-P DRAGONSKIN	-F30 CTCM120 DRAGONSKIN	-F30 CTPM125 DRAGONSKIN	-F30 CTCM130 DRAGONSKIN	-M30 CTCM120 DRAGONSKIN	-M30 CTPM125 DRAGONSKIN	-M30 CTCM130 DRAGONSKIN
								
		R DNMM 76 166 ...	F DNMG 75 013 ...	F DNMG 75 013 ...	F DNMG 75 013 ...	M DNMG 75 014 ...	M DNMG 75 014 ...	M DNMG 75 014 ...
		#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
110404EN	0.4		XX,YY 10400	XX,YY 204	XX,YY 30400			
110408EN	0.8		XX,YY 10600	XX,YY 206	XX,YY 30600	XX,YY 10600	XX,YY 206	XX,YY 30600
110412EN	1.2					XX,YY 10800	XX,YY 208	XX,YY 30800
150404EN	0.4		XX,YY 11600		XX,YY 31600			
150408EN	0.8		XX,YY 11800		XX,YY 31800	XX,YY 11800		XX,YY 31800
150412EN	1.2					XX,YY 12000		XX,YY 32000
150604EN	0.4		XX,YY 12800	XX,YY 228	XX,YY 32800			
150608EN	0.8		XX,YY 13000	XX,YY 230	XX,YY 33000	XX,YY 13000	XX,YY 230	XX,YY 33000
150612EN	1.2	XX,YY 73201				XX,YY 13200	XX,YY 232	XX,YY 33200
150616EN	1.6	XX,YY 73401						
P		●	○	○	○	○	○	○
M		○	●	●	●	●	●	●
K								
N								
S					○			○
H								
O								

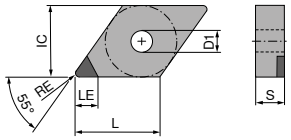
DNMG

ISO	RE mm	NEW -M60 CTCM120 DRAGONSKIN	-M60 CTPM125 DRAGONSKIN	NEW -M60 CTCM130 DRAGONSKIN	-M34 CTPX710 DRAGONSKIN	NEW -M42 CTPX710 DRAGONSKIN
						
		M DNMG 75 015 ...	M DNMG 75 015 ...	M DNMG 75 015 ...	M DNMG 75 004 ...	M DNMG 75 027 ...
		#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
150404EN	0.4				XX,YY 61600	
150408EN	0.8	XX,YY 11800		XX,YY 31800	XX,YY 61800	
150412EN	1.2	XX,YY 12000		XX,YY 32000	XX,YY 62000	
150608EN	0.8	XX,YY 13000	XX,YY 230	XX,YY 33000	XX,YY 63000	XX,YY 63000
150612EN	1.2	XX,YY 13200	XX,YY 232	XX,YY 33200	XX,YY 63200	
P		○	○	○	●	●
M		●	●	●	●	●
K						
N					○	○
S				○	●	●
H						
O						

→ vc Page 186–199

DNGA

Designation	L mm	S mm	D1 mm	IC mm
DNGA 1504..	15.5	4.76	5.16	12.7
DNGA 1506..	15.5	6.35	5.16	12.7

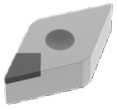


DNGA A

DNGA

▲ TCE(NOI) = Design and number of equipped cutting edge corners

CTDPD20



F
DIAMOND
DNGA

71 128 ...

ISO	RE mm	TCE (NOI)	LE mm	#CU# *PA*	
150404FN	0.4	**A (1)**	6.4	XX,YY	**10001**
150408FN	0.8	**A (1)**	6.0	XX,YY	**10101**
150412FN	1.2	**A (1)**	5.6	XX,YY	**10201**
150604FN	0.4	**A (1)**	6.4	XX,YY	**10301**
150608FN	0.8	**A (1)**	6.0	XX,YY	**10401**
150612FN	1.2	**A (1)**	5.6	XX,YY	**10501**

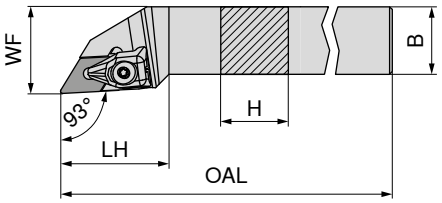
P	
M	
K	
N	●
S	
H	
O	●

9

MaxiLock-D – DDJN 93° – Toolholder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 541 ... #CU# *PA*		Right-hand 70 540 ... #CU# *PA*	
DDJN R/L 1616 H11	16	16	100	33	20	2	DN.. 1104	XX,YY	**816**	XX,YY	**816**
DDJN R/L 2020 K11	20	20	125	33	25	2	DN.. 1104	XX,YY	**820**	XX,YY	**820**
DDJN R/L 2525 M11	25	25	150	33	32	2	DN.. 1104	XX,YY	**825**	XX,YY	**825**
DDJN R/L 2020 K15	20	20	125	40	25	4	DN.. 1504 / 1506	XX,YY	**720**	XX,YY	**720**
DDJN R/L 2525 M15	25	25	150	40	32	4	DN.. 1504 / 1506	XX,YY	**725**	XX,YY	**725**
DDJN R/L 3225 P15	32	25	170	40	32	4	DN.. 1504 / 1506	XX,YY	**832**	XX,YY	**832**

When using DN.. 1504 indexable inserts, use insert seat article no. 70 950 40000.

XPress type

Key D

Clamping screw

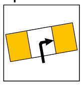
Solid Carbide Seat D

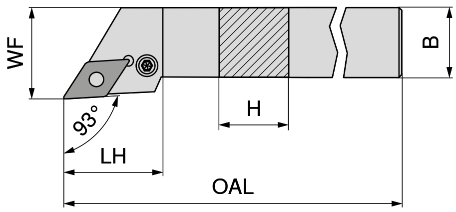
Spare parts for Article no.	70 950 ... #CU# *PA*		80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 541 816 / 70 540 816	XX,YY	**835**	T09 - IP	XX,YY **126**	M3x7 - IP	XX,YY **819**	XX,YY	**808**
70 541 820 / 70 540 820	XX,YY	**835**	T09 - IP	XX,YY **126**	M3x7 - IP	XX,YY **819**	XX,YY	**808**
70 541 825 / 70 540 825	XX,YY	**835**	T09 - IP	XX,YY **126**	M3x7 - IP	XX,YY **819**	XX,YY	**808**
70 541 720 / 70 540 720	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**811**
70 541 725 / 70 540 725	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**811**
70 541 832 / 70 540 832	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**811**

MaxiLock-N – PDJN 93° – Upínací držák s upínací páčkou

Rozsah dodávky:

Upínací držák s inbusovým klíčem





Obrázky zobrazují pravé provedení

Označení ISO	H mm	B mm	OAL mm	LH mm	WF mm	Utahovací moment Nm	Vyměnitelná destička	Levý 70 541 ... #CU# *PA*		Pravý 70 540 ... #CU# *PA*	
PDJN R/L 1616 H11	16	16	100	30,0	20	3	DN.. 1104	XX,YY	**116**	XX,YY	**116**
PDJN R/L 2020 K11	20	20	125	30,0	25	3	DN.. 1104	XX,YY	**12000** 1)	XX,YY	**12000** 1)
PDJN R/L 2525 M11	25	25	150	30,0	32	3	DN.. 1104	XX,YY	**12500** 1)	XX,YY	**12500** 1)
PDJN R/L 2020 K15	20	20	125	34,9	25	3,2	DN.. 1506	XX,YY	**020**	XX,YY	**020**
PDJN R/L 2525 M15	25	25	150	35,4	32	3,2	DN.. 1506	XX,YY	**025**	XX,YY	**025**
PDJN R/L 3225 P15	32	25	170	35,4	32	3,2	DN.. 1506	XX,YY	**032**	XX,YY	**032**
PDJN R/L 3232 P15	32	32	170	34,7	40	3,2	DN.. 1506	XX,YY	**13200**	XX,YY	**13200**

1) poniklováno


Key I


Shim


Assembly pin


Lever


Clamping screw


Solid Carbide Seat D

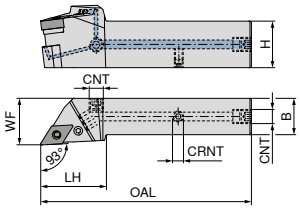
Spare parts for Article no.		Key I 70 950 ... #CU# *PA*		Shim 70 950 ... #CU# *PA*		Assembly pin 70 950 ... #CU# *PA*		Lever 70 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*		Solid Carbide Seat D 70 950 ... #CU# *PA*	
70 540 116 / 70 541 116	SW2,5	XX,YY	**175**	XX,YY	**122**	XX,YY	**191**	XX,YY	**121**	XX,YY	**208**	XX,YY	**120**
70 540 12000 / 70 541 12000	SW2,5	XX,YY	**175**	XX,YY	**122**	XX,YY	**191**	XX,YY	**121**	XX,YY	**208**	XX,YY	**120**
70 540 12500 / 70 541 12500	SW2,5	XX,YY	**175**	XX,YY	**122**	XX,YY	**191**	XX,YY	**121**	XX,YY	**208**	XX,YY	**120**
70 540 020 / 70 541 020	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**188**	XX,YY	**388**	XX,YY	**236**
70 540 025 / 70 541 025	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**188**	XX,YY	**388**	XX,YY	**236**
70 540 032 / 70 541 032	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**188**	XX,YY	**388**	XX,YY	**236**
70 540 13200 / 70 541 13200	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**188**	XX,YY	**388**	XX,YY	**236**

9

MaxiLock-N – PDJN 93° DC – Toolholder with lever clamping

Scope of supply:
Tool holder with allen key

Direct Cooling



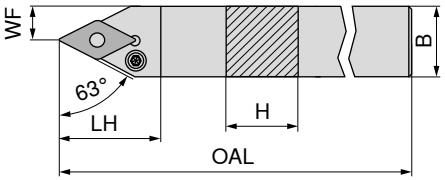
Illustrations show right-hand versions

										NEW Left-hand	NEW Right-hand
										70 593 ...	**70 593 ...**
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	#CU# *PA*	#CU# *PA*
PDJN R/L 2020 X11-T DC	20	20	104	35	25	M6	G1/8"	3	DN.. 1104	XX,YY **02000**	XX,YY **02001**
PDJN R/L 2525 X11-T DC	25	25	114	45	32	M6	G1/8"	3	DN.. 1104	XX,YY **02500**	XX,YY **02501**
PDJN R/L 2020 X15-T DC	20	20	114	45	25	M6	G1/8"	3,2	DN.. 1506	XX,YY **12000**	XX,YY **12001**
PDJN R/L 2525 X15-T DC	25	25	129	45	32	M6	G1/8"	3,2	DN.. 1506	XX,YY **12500**	XX,YY **12501**
PDJN R/L 3225 X15-T DC	32	25	145	45	32	M6	G1/8"	3,2	DN.. 1506	XX,YY **03200**	XX,YY **03201**
PDJN R/L 3232 X15-T DC	32	32	145	45	40	M6	G1/8"	3,2	DN.. 1506	XX,YY **13200**	XX,YY **13201**

	 Key I	 Shim	Assembly pin	 Coolant screw plug	 Lever	 Clamping screw	 Solid Carbide Seat D	 Grubscrew
	70 950 ...	**70 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**
Spare parts for Article no.	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
70 593 02001 / 70 593 02000	XX,YY **175**	XX,YY **122**	XX,YY **191**	XX,YY **294**	XX,YY **121**	XX,YY **208**	XX,YY **120**	XX,YY **86700**
70 593 02501 / 70 593 02500	XX,YY **175**	XX,YY **122**	XX,YY **191**	XX,YY **294**	XX,YY **121**	XX,YY **208**	XX,YY **120**	XX,YY **86700**
70 593 12001 / 70 593 12000	XX,YY **176**	XX,YY **198**	XX,YY **192**	XX,YY **294**	XX,YY **188**	XX,YY **209**	XX,YY **236**	XX,YY **86700**
70 593 12501 / 70 593 12500	XX,YY **176**	XX,YY **198**	XX,YY **192**	XX,YY **294**	XX,YY **188**	XX,YY **209**	XX,YY **236**	XX,YY **86700**
70 593 03201 / 70 593 03200	XX,YY **176**	XX,YY **198**	XX,YY **192**	XX,YY **294**	XX,YY **188**	XX,YY **209**	XX,YY **236**	XX,YY **86700**
70 593 13201 / 70 593 13200	XX,YY **176**	XX,YY **198**	XX,YY **192**	XX,YY **294**	XX,YY **188**	XX,YY **209**	XX,YY **236**	XX,YY **86700**

MaxiLock-N – PDNN 63° – Toolholder with lever clamping

Scope of supply:
Tool holder with allen key



Illustrations show right-hand versions

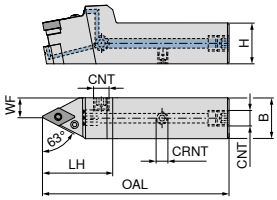
								Left-hand	Right-hand
								70 537 ...	**70 536 ...**
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	#CU# *PA*	#CU# *PA*
PDNN R/L 2525 M11	25	25	150	30.0	12.5	3	DN.. 1104	XX,YY **125**	XX,YY **125**
PDNN R/L 2525 M15	25	25	150	36.5	12.5	3,2	DN.. 1506	XX,YY **025**	XX,YY **025**

		 Key I	 Shim	Assembly pin	 Lever	 Clamping screw	 Solid Carbide Seat D
		70 950 ...	**70 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**
Spare parts for Article no.		#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
70 537 125 / 70 536 125	SW2,5	XX,YY **175**	XX,YY **122**	XX,YY **191**	XX,YY **121**	XX,YY **208**	XX,YY **120**
70 537 025 / 70 536 025	SW3	XX,YY **176**	XX,YY **198**	XX,YY **192**	XX,YY **188**	XX,YY **388**	XX,YY **236**

MaxiLock-N – PDNN 63° DC – Toolholder with lever clamping

Scope of supply:
Tool holder with allen key

Direct Cooling



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	NEW Left-hand 70 594 ... #CU# *PA*		NEW Right-hand 70 594 ... #CU# *PA*	
PDNN R/L 2525 X11-T DC	25	25	114	45	12.5	M6	G1/8"	3	DN.. 1104	XX,YY	**02500**	XX,YY	**02501**
PDNN R/L 2525 X15-T DC	25	25	119	50	12.5	M6	G1/8"	3,2	DN.. 1506	XX,YY	**12500**	XX,YY	**12501**


Key I


Shim

Assembly pin


Coolant screw plug


Lever


Clamping screw


Solid Carbide Seat D

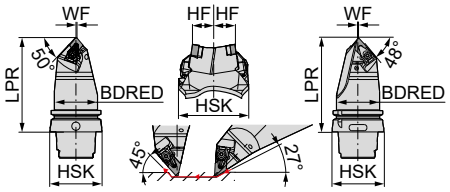

Grubscrew

Spare parts for Article no.	Key I 70 950 ... #CU# *PA*		Shim 70 950 ... #CU# *PA*		Assembly pin 70 950 ... #CU# *PA*		Coolant screw plug 70 950 ... #CU# *PA*		Lever 70 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*		Solid Carbide Seat D 70 950 ... #CU# *PA*		Grubscrew 70 950 ... #CU# *PA*	
70 594 02501 / 70 594 02500	XX,YY	**175**	XX,YY	**122**	XX,YY	**191**	XX,YY	**294**	XX,YY	**121**	XX,YY	**208**	XX,YY	**120**	XX,YY	**86700**
70 594 12501 / 70 594 12500	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**294**	XX,YY	**188**	XX,YY	**209**	XX,YY	**236**	XX,YY	**86700**

MaxiLock-D – DCMN + DDMN – Toolholder with top clamping

9

Scope of supply:
Tool holder with Torx key



ISO designation	Adapter	LPR mm	BDRED mm	WF mm	HF mm	torque moment Nm	Insert	Neutral 74 600 ... #CU# *PA*	
HSK T63 DCMN L 12 + DDMN L 15	HSK-T 63	115	53	0.5	20	4	CN.. 1204 / DN.. 1506	XX,YY	**501**
HSK T100 DCMN L 12 + DDMN L 15	HSK-T 100	150	88	0.5	20	4	CN.. 1204 / DN.. 1506	XX,YY	**701**

Face turning maximum 78 mm


XPress type


Key D


Clamping screw

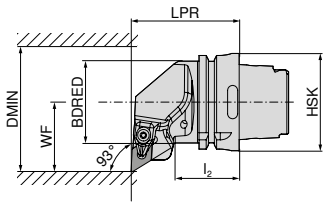

Solid Carbide Seat D


Carbide type C

Spare parts for Article no.	XPress type 70 950 ... #CU# *PA*			Key D 80 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*		Solid Carbide Seat D 70 950 ... #CU# *PA*		Carbide type C 70 950 ... #CU# *PA*	
74 600 501	XX,YY	**824**	T15 - IP	XX,YY	**128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**811**	XX,YY	**810**
74 600 701	XX,YY	**824**	T15 - IP	XX,YY	**128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**811**	XX,YY	**810**

MaxiLock-D – DDUN 93° – Toolholder with top clamping

Scope of supply:
Tool holder with Torx key

Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	l_2 mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 516 ... #CU# *PA*		Right-hand 74 515 ... #CU# *PA*	
HSK T63 DDUN R/L 15	HSK-T 63	70	42	53	45	125	4	DN.. 1506	XX,YY	**515**	XX,YY	**515**
HSK T100 DDUN R/L 15	HSK-T 100	80	45	88	55	125	4	DN.. 1506	XX,YY	**715**	XX,YY	**715**


XPress type

Key D

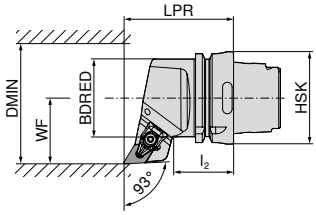

Clamping screw


Solid Carbide Seat D

Spare parts for Article no.	70 950 ... #CU# *PA*		80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
74 516 515 / 74 515 515	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**811**
74 516 715 / 74 515 715	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**811**

MaxiLock-D – DDJN 93° – Toolholder with top clamping

Scope of supply:
Tool holder with Torx key

Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	l_2 mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 512 ... #CU# *PA*		Right-hand 74 511 ... #CU# *PA*	
HSK T63 DDJN R/L 15	HSK-T 63	75	42	53	45	125	4	DN.. 1506	XX,YY	**515**	XX,YY	**515**
HSK T100 DDJN R/L 15	HSK-T 100	85	45	88	55	125	4	DN.. 1506	XX,YY	**715**	XX,YY	**715**


XPress type

Key D

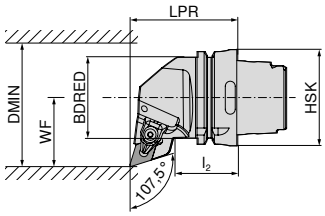

Clamping screw


Solid Carbide Seat D

Spare parts for Article no.	70 950 ... #CU# *PA*		80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
74 512 515 / 74 511 515	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**811**
74 512 715 / 74 511 715	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**811**

MaxiLock-D – DDHN 107.5° – Toolholder with top clamping

Scope of supply:
Tool holder with Torx key



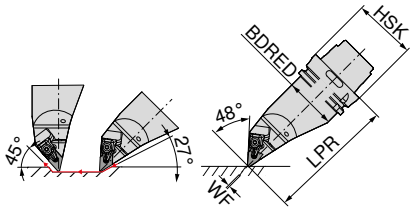
Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	l_2 mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 508 ... #CU# *PA*		Right-hand 74 507 ... #CU# *PA*	
HSK T63 DDHN R/L 15	HSK-T 63	70	42	53	45	125	4	DN.. 1506	XX,YY	**515**	XX,YY	**515**

Spare parts for Article no.	XPress type 70 950 ... #CU# *PA*		Key D 80 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*		Solid Carbide Seat D 70 950 ... #CU# *PA*	
74 508 515 / 74 507 515	XX,YY	**824**	T15 - IP XX,YY	**128**	M4,5x12 - IP XX,YY	**820**	XX,YY	**811**

MaxiLock-D – DDMN 48° – Toolholder with top clamping

Scope of supply:
Tool holder with Torx key



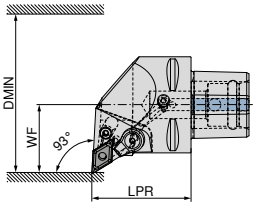
ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert	Left-hand 74 519 ... #CU# *PA*	
HSK T63 DDMN L 15	HSK-T 63	130	53	0	4	DN.. 1506	XX,YY	**515**
HSK T100 DDMN L 15	HSK-T 100	160	88	0	4	DN.. 1506	XX,YY	**715**

Spare parts for Article no.	XPress type 70 950 ... #CU# *PA*		Key D 80 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*		Solid Carbide Seat D 70 950 ... #CU# *PA*	
74 519 515	XX,YY	**824**	XX,YY	**128**	XX,YY	**820**	XX,YY	**811**
74 519 715	XX,YY	**824**	XX,YY	**128**	XX,YY	**820**	XX,YY	**811**

9

MaxiLock-N – PDUN 93° – Toolholder with lever clamping

Scope of supply:
without high-performance coolant set

Illustrations show right-hand versions

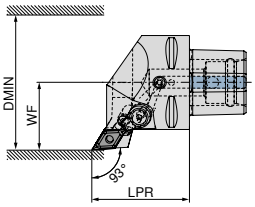
ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Direct cooling compatible	Left-hand 84 661 ... #CU# *PA*	Right-hand 84 660 ... #CU# *PA*
PSC40 PDUN R/L 50050-15	PSC 40	50	27	50	5	DN.. 1504 / 1506	DC	XX,YY **01595**	XX,YY **01595**
PSC50 PDUN R/L 65060-15	PSC 50	60	35	65	5	DN.. 1504 / 1506	DC	XX,YY **01594**	XX,YY **01594**
PSC63 PDUN R/L 80065-15	PSC 63	65	45	80	5	DN.. 1504 / 1506	DC	XX,YY **01593**	XX,YY **01593**




Spare parts for Article no.	Pružný čistící kolík 84 950 ... #CU# *PA*		Šroub páky 84 950 ... #CU# *PA*	Upínací páka 84 950 ... #CU# *PA*	Tělo destičky Seat D 84 950 ... #CU# *PA*
84 660 01593 / 84 660 01594	XX,YY **29200**	M8X1/L17 SW3	XX,YY **28700**	XX,YY **28900**	XX,YY **27900**
84 660 01595 / 84 661 01593	XX,YY **29200**	M8X1/L17 SW3	XX,YY **28700**	XX,YY **28900**	XX,YY **27900**
84 661 01594 / 84 661 01595	XX,YY **29200**	M8X1/L17 SW3	XX,YY **28700**	XX,YY **28900**	XX,YY **27900**

MaxiLock-N – PDJN 93° – Toolholder with lever clamping

Scope of supply:
without high-performance coolant set

Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Direct cooling compatible	Left-hand 84 665 ... #CU# *PA*	Right-hand 84 664 ... #CU# *PA*
PSC40 PDJN R/L 50050-15	PSC 40	50	27	50	5	DN.. 1504 / 1506	DC	XX,YY **01595**	XX,YY **01595**
PSC50 PDJN R/L 65060-15	PSC 50	60	35	65	5	DN.. 1504 / 1506	DC	XX,YY **01594**	XX,YY **01594**
PSC63 PDJN R/L 80065-15	PSC 63	65	45	80	5	DN.. 1504 / 1506	DC	XX,YY **01593**	XX,YY **01593**



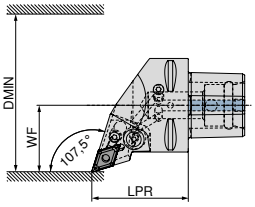

Spare parts Adapter	Shim 84 950 ... #CU# *PA*		Elbow lever screw 84 950 ... #CU# *PA*	Lever 84 950 ... #CU# *PA*	Solid Carbide Seat D 84 950 ... #CU# *PA*
PSC 40	XX,YY **29200**	M8X1/L17 SW3	XX,YY **28700**	XX,YY **28900**	XX,YY **27900**
PSC 50	XX,YY **29200**	M8X1/L17 SW3	XX,YY **28700**	XX,YY **28900**	XX,YY **27900**
PSC 63	XX,YY **29200**	M8X1/L17 SW3	XX,YY **28700**	XX,YY **28900**	XX,YY **27900**

The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page PL**.

Bei Verwendung von DN1504.. Wendeplatten Unterlegplatte Artikel-Nr. 84 950 28200 nutzen

MaxiLock-N – PDHN 107,5° – Toolholder with lever clamping

Scope of supply:
without high-performance coolant set

Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Direct cooling compatible	Left-hand 84 669 ... #CU# *PA*	Right-hand 84 668 ... #CU# *PA*
PSC40 PDHN R/L 50050-15	PSC 40	50	27	50	5	DN.. 1504 / 1506	DC	XX,YY **01595**	XX,YY **01595**
PSC50 PDHN R/L 65060-15	PSC 50	60	35	65	5	DN.. 1504 / 1506	DC	XX,YY **01594**	XX,YY **01594**
PSC63 PDHN R/L 80065-15	PSC 63	65	45	80	5	DN.. 1504 / 1506	DC	XX,YY **01593**	XX,YY **01593**


Shim


Elbow lever screw

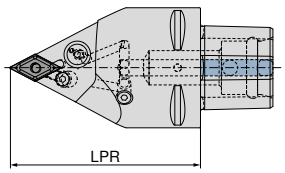

Lever


Solid Carbide Seat D

Spare parts for Article no.	Shim 84 950 ... #CU# *PA*	Elbow lever screw 84 950 ... #CU# *PA*	Lever 84 950 ... #CU# *PA*	Solid Carbide Seat D 84 950 ... #CU# *PA*
84 668 01595 / 84 669 01595	XX,YY **29200**	XX,YY **28700**	XX,YY **28900**	XX,YY **27900**
84 668 01594 / 84 669 01594	XX,YY **29200**	XX,YY **28700**	XX,YY **28900**	XX,YY **27900**
84 668 01593 / 84 669 01593	XX,YY **29200**	XX,YY **28700**	XX,YY **28900**	XX,YY **27900**

MaxiLock-N – PDNN 62,5° – Toolholder with lever clamping

Scope of supply:
without high-performance coolant set

ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Direct cooling compatible	Neutral 84 676 ... #CU# *PA*
PSC63 PDNN N 0100-15	PSC 63	100	5	DN.. 1504 / 1506	DC	XX,YY **01593**
PSC63 PDNN N 0130-15	PSC 63	130	5	DN.. 1504 / 1506	DC	XX,YY **11593**


Shim


Elbow lever screw


Lever


Solid Carbide Seat D

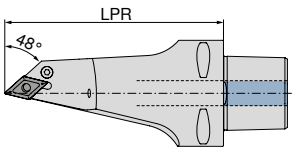
Spare parts for Article no.	Shim 84 950 ... #CU# *PA*	Elbow lever screw 84 950 ... #CU# *PA*	Lever 84 950 ... #CU# *PA*	Solid Carbide Seat D 84 950 ... #CU# *PA*
84 676 01593	XX,YY **29200**	XX,YY **28700**	XX,YY **28900**	XX,YY **27900**
84 676 11593	XX,YY **29200**	XX,YY **28700**	XX,YY **28900**	XX,YY **27900**

The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page PL**.

Bei Verwendung von DN1504.. Wendeplatten Unterlegplatte Artikel-Nr. 84 950 28200 nutzen

MaxiLock-N – PDMN 48° – Toolholder with lever clamping

Scope of supply:
without high-performance coolant set



Neutral

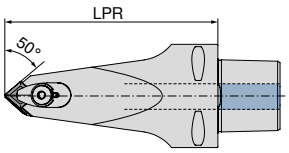
ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Direct cooling compatible	84 680 ... #CU# *PA*	
PSC63 PDMN L 0130-15	PSC 63	130	5	DN.. 1504 / 1506	DC	XX,YY	**11593**

	 Shim	 Elbow lever screw	 Lever	 Solid Carbide Seat D
	84 950 ...	**84 950 ...**	**84 950 ...**	**84 950 ...**
Spare parts for Article no.	**#CU# *PA***	**#CU# *PA***	**#CU# *PA***	**#CU# *PA***
84 680 11593	XX,YY **29200**	XX,YY **28700**	XX,YY **28900**	XX,YY **27900**

The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page PL**.

Bei Verwendung von DN1504.. Wendeplatten Unterlegplatte Artikel-Nr. 84 950 28200 nutzen

MaxiLock-D – DCMN + DDMN 50°/48° – Toolholder with top clamping



ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Neutral 84 683 ... #CU# *PA*
PSC63 DCMN-DDMN L 0130-12/15	PSC 63	130	10	CN.. 1204 / DN.. 1506	XX,YY **01293**

Spare parts for Article no.	 Clamping Screw 84 950 ... #CU# *PA*	 Clamping claw 84 950 ... #CU# *PA*	 Ring-shaped nozzle 84 950 ... #CU# *PA*	 Clamping screw 84 950 ... #CU# *PA*	 Solid Carbide Seat D 84 950 ... #CU# *PA*	 Carbide type C 84 950 ... #CU# *PA*
84 683 01293	XX,YY **28300**	XX,YY **28500**	XX,YY **28400**	XX,YY **27500**	XX,YY **27900**	XX,YY **27800**

High-performance coolant set

- ▲ Using the DC kit blocks the other coolant outlet so that all of the pressure is concentrated by the kit!
- ▲ Can be used up to 100 bar

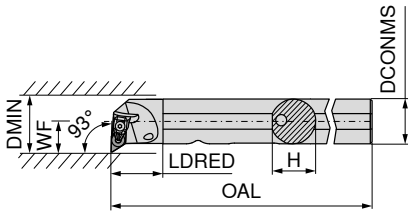
Scope of supply:
Direct cooling nozzle and O-ring

	84 950 ... #CU# *PA*
Coolant set	XX,YY **27400**

9

MaxiLock-D – DDUN 93° – Boring bar with top clamping

Scope of supply:
Boring bar with Torx key



Illustrations show right-hand versions

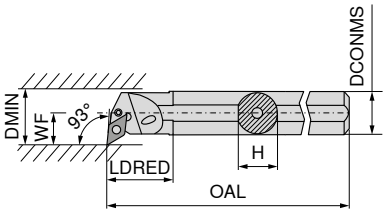
									Left-hand		Right-hand	
									70 569 ...		**70 568 ...**	
ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	#CU# *PA*		#CU# *PA*	
A25R DDUN R/L 11	25	24	200	30	17	32	2	DN.. 1104	XX,YY	**725**	XX,YY	**725**
A32S DDUN R/L 11	32	31	250	40	22	40	2	DN.. 1104	XX,YY	**732**	XX,YY	**732**
A40T DDUN R/L 15	40	39	300	45	27	50	4	DN.. 1506	XX,YY	**840**	XX,YY	**840**

	XPress type		Key D		Clamping screw		Solid Carbide Seat D	
	70 950 ...		**80 950 ...**		**70 950 ...**		**70 950 ...**	
Spare parts for Article no.	#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
70 568 725 / 70 569 725	XX,YY	**835**	T09 - IP	XX,YY **126**	M3x7 - IP	XX,YY **819**	XX,YY	**808**
70 568 732 / 70 569 732	XX,YY	**835**	T09 - IP	XX,YY **126**	M3x7 - IP	XX,YY **819**	XX,YY	**808**
70 568 840 / 70 569 840	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**811**

MaxiLock-N – PDUN 93° – Boring bar with lever clamping

▲ A... = with thro' coolant
▲ S... = without thro' coolant

Scope of supply:
Boring bar with Allen key



Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 569 ... #CU# *PA*		Right-hand 70 568 ... #CU# *PA*	
A20Q PDUN R/L 11	20	18.5	180	36	16.0	28	3	DN.. 1104	XX,YY	12000 [1]	XX,YY	12000 [1]
A25R PDUN R/L 11	25	23.0	200	36	18.5	32	3	DN.. 1104	XX,YY	125	XX,YY	12500 [1]
A32S PDUN R/L 11	32	30.0	250	36	22.0	40	3	DN.. 1104	XX,YY	13200 [1]	XX,YY	132
A32S PDUN R/L 15	32	30.0	250	50	22.0	40	3,2	DN.. 1506	XX,YY	232	XX,YY	232
A40T PDUN R/L 15	40	38.0	300	60	27.0	50	3,2	DN.. 1506	XX,YY	240	XX,YY	240
S50W PDUN R/L 15	50	47.0	450	31	35.0	63	3,2	DN.. 1506	XX,YY	050	XX,YY	050

1) nickel-plated


Key I


Shim

Assembly pin


Lever


Clamping screw

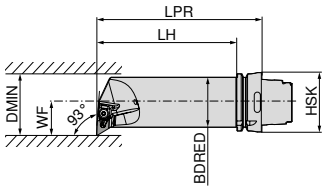

Solid Carbide Seat D

Spare parts for Article no.		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 568 12000 / 70 569 12000	SW2,5	XX,YY	175					XX,YY	125	XX,YY	126		
70 568 12500 / 70 569 125	SW2,5	XX,YY	175	XX,YY	122	XX,YY	191	XX,YY	121	XX,YY	208	XX,YY	120
70 568 132 / 70 569 13200	SW2,5	XX,YY	175	XX,YY	122	XX,YY	191	XX,YY	121	XX,YY	208	XX,YY	120
70 568 232 / 70 569 232	SW3	XX,YY	176	XX,YY	198	XX,YY	192	XX,YY	188	XX,YY	209	XX,YY	236
70 568 240 / 70 569 240	SW3	XX,YY	176	XX,YY	198	XX,YY	192	XX,YY	188	XX,YY	209	XX,YY	236
70 568 050 / 70 569 050	SW3	XX,YY	176	XX,YY	198	XX,YY	192	XX,YY	188	XX,YY	388	XX,YY	236

9

MaxiLock-D – DDUN 93° – Boring bar with top clamping

Scope of supply:
Boring bar with Torx key



Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 533 ... #CU# *PA*		Right-hand 74 532 ... #CU# *PA*	
HSK T63 50Q DDUN R/L 15	HSK-T 63	175	149	50	35	63	4	DN.. 1506	XX,YY	515	XX,YY	515


XPress type


Key D

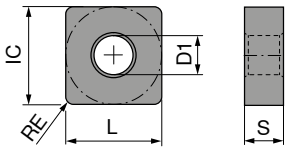

Clamping screw


Solid Carbide Seat D

Spare parts for Article no.		70 950 ... #CU# *PA*			80 950 ... #CU# *PA*			70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
74 533 515 / 74 532 515		XX,YY	824	T15 - IP	XX,YY	128	M4,5x12 - IP	XX,YY	820	XX,YY	811

SNMG / SNMA / SNMM

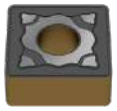
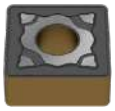
Designation	L mm	S mm	D1 mm	IC mm
SNMG 0903..	9.52	3.18	3.81	9.52
SNM. 1204..	12.70	4.76	5.16	12.70
SNM. 1506..	15.87	6.35	6.35	15.87
SNM. 1906..	19.05	6.35	7.94	19.05
SNMM 2507..	25.40	7.94	9.12	25.40
SNMM 2509..	25.40	9.52	9.12	25.40



SNMG

		NEW	NEW	NEW	NEW	NEW	NEW	
		-F50 CTCP115-P	-F50 CTCP125-P	-F50 CTCP135-P	-M50 CTCP115-P	-M50 CTCP125-P	-M50 CTCP135-P	-M70 CTCK110
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		F	F	F	M	M	M	M
		SNMG	SNMG	SNMG	SNMG	SNMG	SNMG	SNMG
		76 140 ...	76 140 ...	76 140 ...	76 137 ...	76 137 ...	76 137 ...	70 225 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
090308EN	0.8	XX,YY 30601	XX,YY 50601	XX,YY 70601				
120404EN	0.4	XX,YY 31601	XX,YY 51601	XX,YY 71601				
120408EN	0.8	XX,YY 31801	XX,YY 51801	XX,YY 71801	XX,YY 31801	XX,YY 51801	XX,YY 71801	XX,YY 018
120412EN	1.2	XX,YY 32001	XX,YY 52001	XX,YY 72001	XX,YY 32001	XX,YY 52001	XX,YY 72001	XX,YY 020
120416EN	1.6				XX,YY 32201	XX,YY 52201	XX,YY 72201	XX,YY 022
150608EN	0.8					XX,YY 53001	XX,YY 73001	
150608EN	1.6				XX,YY 33001			
150612EN	1.2				XX,YY 33201	XX,YY 53201	XX,YY 73201	XX,YY 032
150616EN	1.6				XX,YY 33401	XX,YY 53401	XX,YY 73401	XX,YY 034
190612EN	1.2							XX,YY 044
190616EN	1.6							XX,YY 046
P		●	●	●	●	●	●	○
M				○			○	
K		○	○		○	○		●
N								
S								
H								
O								

SNMG / SNMA

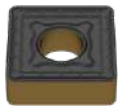
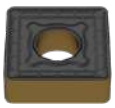
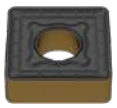
		NEW	NEW	NEW		
		-M70 CTCP115-P	-M70 CTCP125-P	-M70 CTCP135-P	CTCK110	-M70 CTCK120
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
		M	M	M	R	M
		SNMG	SNMG	SNMG	SNMA	SNMG
		76 225 ...	76 225 ...	76 225 ...	70 114 ...	70 225 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
120408EN	0.8	XX,YY 31801	XX,YY 51801	XX,YY 71801	XX,YY 018	XX,YY 518
120412EN	1.2	XX,YY 32001	XX,YY 52001	XX,YY 72001	XX,YY 020	XX,YY 520
120416EN	1.6	XX,YY 32201	XX,YY 52201	XX,YY 72201	XX,YY 022	XX,YY 522
150612EN	1.2	XX,YY 33201	XX,YY 53201	XX,YY 73201	XX,YY 032	XX,YY 532
150616EN	1.6	XX,YY 33401	XX,YY 53401	XX,YY 73401	XX,YY 034	XX,YY 534
190612EN	1.2	XX,YY 34401	XX,YY 54401	XX,YY 74401	XX,YY 044	XX,YY 544
190616EN	1.6	XX,YY 34601	XX,YY 54601	XX,YY 74601	XX,YY 046	XX,YY 546
190624EN	2.4	XX,YY 34801	XX,YY 54801	XX,YY 74801		
P		●	●	●	○	○
M				○		
K		○	○		●	●
N						
S						
H						
O						

SNMA / SNMM

			NEW	NEW	NEW	NEW	NEW	NEW
		CTCK120	-R28 CTCP115-P	-R28 CTCP125-P	-R28 CTCP135-P	-R58 CTCP115-P	-R58 CTCP125-P	-R58 CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		R	R	R	R	R	R	R
		SNMA	SNMM	SNMM	SNMM	SNMM	SNMM	SNMM
		70 114 ...	76 128 ...	76 128 ...	76 128 ...	76 129 ...	76 129 ...	76 129 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
120408EN	0.8	XX,YY 518				XX,YY 31801	XX,YY 51801	XX,YY 71801
120412EN	1.2	XX,YY 520				XX,YY 32001	XX,YY 52001	XX,YY 72001
120416EN	1.6	XX,YY 522						
150612EN	1.2	XX,YY 532	XX,YY 33201	XX,YY 53201	XX,YY 73201	XX,YY 33201	XX,YY 53201	XX,YY 73201
150616EN	1.6	XX,YY 534	XX,YY 33401	XX,YY 53401	XX,YY 73401	XX,YY 33401	XX,YY 53401	XX,YY 73401
190612EN	1.2	XX,YY 544				XX,YY 34401	XX,YY 54401	XX,YY 74401
190616EN	1.6	XX,YY 546	XX,YY 34601	XX,YY 54601	XX,YY 74601	XX,YY 34601	XX,YY 54601	XX,YY 74601
190624EN	2.4					XX,YY 34801	XX,YY 54801	XX,YY 74801
250724EN	2.4				XX,YY 76001	XX,YY 36001	XX,YY 56001	XX,YY 76001
250924EN	2.4		XX,YY 37001	XX,YY 57001	XX,YY 77001	XX,YY 37001	XX,YY 57001	XX,YY 77001
P		○	●	●	●	●	●	●
M					○			○
K		●	○	○		○	○	
N								
S								
H								
O								

9

SNMM / SNMG

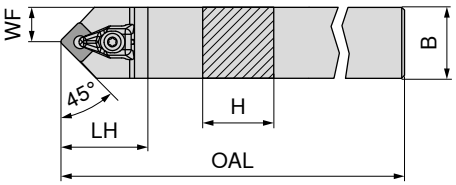
	NEW	NEW	NEW				
	-R88 CTCP115-P	-R88 CTCP125-P	-R88 CTCP135-P	-F30 CTCM120	-F30 CTPM125	-F30 CTCM130	-M30 CTCM120
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
	R	R	R	F	F	F	M
	SNMM	SNMM	SNMM	SNMG	SNMG	SNMG	SNMG
	76 130 ...	76 130 ...	76 130 ...	75 016 ...	75 016 ...	75 016 ...	75 017 ...
ISO / RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
120404EN 0.4				XX,YY 11600	XX,YY 216	XX,YY 31600	
120408EN 0.8				XX,YY 11800	XX,YY 218	XX,YY 31800	XX,YY 11800
120412EN 1.2							XX,YY 12000
190616SN 1.6	XX,YY 34601	XX,YY 54601	XX,YY 74601				
190624SN 2.4	XX,YY 34801	XX,YY 54801	XX,YY 74801				
250724SN 2.4	XX,YY 36001	XX,YY 56001	XX,YY 76001				
250924SN 2.4	XX,YY 37001	XX,YY 57001	XX,YY 77001				
P	●	●	●	○	○	○	○
M			○	●	●	●	●
K	○	○					
N							
S						○	
H							
O							

SNMG

	-M30 CTPM125	-M30 CTCM130	-M60 CTCM120	-M60 CTPM125	-M60 CTCM130	-M34 CTPX710
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
	M	M	M	M	M	M
	SNMG	SNMG	SNMG	SNMG	SNMG	SNMG
	75 017 ...	75 017 ...	75 018 ...	75 018 ...	75 018 ...	75 005 ...
ISO / RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
120408EN 0.8	XX,YY 218	XX,YY 31800	XX,YY 11800	XX,YY 218	XX,YY 31800	XX,YY 61800
120412EN 1.2		XX,YY 32000	XX,YY 12000	XX,YY 210	XX,YY 32000	XX,YY 62000
120416EN 1.6			XX,YY 12200	XX,YY 220	XX,YY 32200	
P	○	○	○	○	○	●
M	●	●	●	●	●	●
K						
N						○
S		○			○	●
H						
O						

MaxiLock-D – DSDN 45° – Toolholder with top clamping

Scope of supply:
Tool holder with Torx key



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Neutral 70 516 ... #CU# *PA*	
DSDN N 2020 K12	20	20	125	38	10.3	4	SN.. 1204	XX,YY	**620**
DSDN N 2525 M12	25	25	150	38	12.5	4	SN.. 1204	XX,YY	**625**


XPress type


Key D

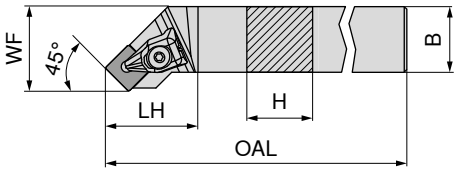

Clamping screw


Solid Carbide support S

Spare parts for Article no.	70 950 ... #CU# *PA*		80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 516 620	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**813**
70 516 625	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**813**

MaxiLock-D – DSSN 45° – Toolholder with top clamping

Scope of supply:
Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 513 ... #CU# *PA*		Right-hand 70 512 ... #CU# *PA*	
DSSN R/L 2020 K12	20	20	125	35	25	4	SN.. 1204	XX,YY	**620**	XX,YY	**620**
DSSN R/L 2525 M12	25	25	150	35	32	4	SN.. 1204	XX,YY	**625**	XX,YY	**625**
DSSN R/L 3225 P12	32	25	170	35	32	4	SN.. 1204	XX,YY	**632**	XX,YY	**632**


XPress type


Key D

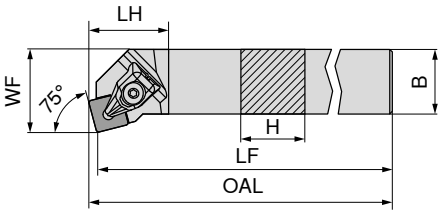

Clamping screw


Solid Carbide support S

Spare parts for Article no.	70 950 ... #CU# *PA*		80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 512 620 / 70 513 620	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**813**
70 512 625 / 70 513 625	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**813**
70 512 632 / 70 513 632	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**813**

MaxiLock-D – DSKN 75° – Toolholder with top clamping

Scope of supply:
Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LF mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 525 ... #CU# *PA*		Right-hand 70 524 ... #CU# *PA*	
DSKN R/L 2525 M12	25	25	153.3	150	28	32	4	SN.. 1204	XX,YY	625	XX,YY	625

XPress type

70 950 ...

Key D

80 950 ...

Clamping screw

70 950 ...

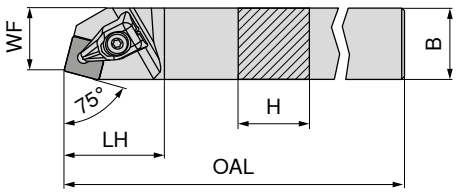
Solid Carbide support S

70 950 ...

Spare parts for Article no.										
70 525 625 / 70 524 625	XX,YY	824	T15 - IP	XX,YY	128	M4,5x12 - IP	XX,YY	820	XX,YY	813

MaxiLock-D – DSBN 75° – Toolholder with top clamping

Scope of supply:
Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Right-hand 70 520 ... #CU# *PA*	
DSBN R 2020 K12	20	20	125	35	17	4	SN.. 1204	XX,YY	620
DSBN R 2525 M12	25	25	150	35	22	4	SN.. 1204	XX,YY	625
DSBN R 2525 M15	25	25	150	42	22	6,5	SN.. 1506	XX,YY	725
DSBN R 3232 P15	32	32	170	42	27	6,5	SN.. 1506	XX,YY	832
DSBN R 3232 P19	32	32	170	48	27	6,5	SN.. 1906	XX,YY	732
DSBN R 4040 S19	40	40	250	48	35	6,5	SN.. 1906	XX,YY	840
DSBN R 4040 S25	40	40	250	57	35	6,5	SN.. 2507 / SN.. 2509	XX,YY	940

When using SN.. 2509 indexable inserts, use insert seat article no. 70 950 40100.

XPress type

70 950 ...

Key D

80 950 ...

Clamping screw

70 950 ...

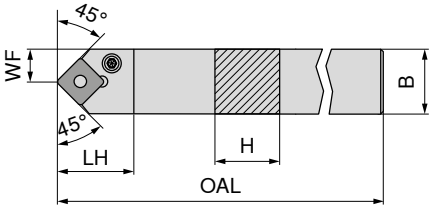
Solid Carbide support S

70 950 ...

Spare parts for Article no.										
70 520 620	XX,YY	824	T15 - IP	XX,YY	128	M4,5x12 - IP	XX,YY	820	XX,YY	813
70 520 625	XX,YY	824	T15 - IP	XX,YY	128	M4,5x12 - IP	XX,YY	820	XX,YY	813
70 520 725	XX,YY	825	T20 - IP	XX,YY	129	M5x14 - IP	XX,YY	821	XX,YY	833
70 520 832	XX,YY	825	T20 - IP	XX,YY	129	M5x14 - IP	XX,YY	821	XX,YY	833
70 520 732	XX,YY	826	T20 - IP	XX,YY	129	M5x14 - IP	XX,YY	821	XX,YY	817
70 520 840	XX,YY	826	T20 - IP	XX,YY	129	M5x14 - IP	XX,YY	821	XX,YY	817
70 520 940	XX,YY	827	T25 - IP	XX,YY	122	M6x16 - IP	XX,YY	822	XX,YY	818

MaxiLock-N – PSDN 45° – Toolholder with lever clamping

Scope of supply:
Tool holder with allen key



Neutral

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	70 516 ... #CU# *PA*	
PSDN N 2020 K12	20	20	125	27.6	10.3	4	SNM. 1204	XX,YY	020
PSDN N 2525 M12	25	25	150	27.6	12.8	4	SNM. 1204	XX,YY	025
PSDN N 3225 P19	32	25	170	40.4	12.5	8	SNM. 1906	XX,YY	03200
PSDN N 4040 S25	40	40	250	48.8	20.0	8	SNM. 2507 / 2509	XX,YY	04000


Key I


Shim

Assembly pin


Lever


Clamping screw

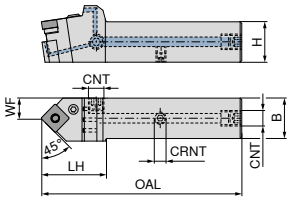

Solid Carbide support S

Spare parts for Article no.		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 516 020	SW3	XX,YY	176	XX,YY	198	XX,YY	192	XX,YY	187	XX,YY	209	XX,YY	230
70 516 025	SW3	XX,YY	176	XX,YY	198	XX,YY	192	XX,YY	187	XX,YY	209	XX,YY	230
70 516 03200	SW4	XX,YY	396	XX,YY	392	XX,YY	395	XX,YY	386	XX,YY	389	XX,YY	383
70 516 04000	SW5	XX,YY	265	XX,YY	621	XX,YY	623	XX,YY	620	XX,YY	622	XX,YY	27600

MaxiLock-N – PSDN 45° DC – Toolholder with lever clamping

Scope of supply:
Tool holder with allen key

Direct Cooling



NEW
Neutral

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	70 596 ... #CU# *PA*	
PSDN N 2020 X12-T DC	20	20	109	40	11.5	M6	G1/8"	4	SNM. 1204	XX,YY	02000
PSDN N 2525 X12-T DC	25	25	124	40	13.3	M6	G1/8"	4	SNM. 1204	XX,YY	02500
PSDN N 2525 X15-T DC	25	25	134	50	13.7	M6	G1/8"	4	SNM. 1506	XX,YY	12500
PSDN N 3225 X15-T DC	32	25	150	50	13.7	M6	G1/8"	4	SNM. 1506	XX,YY	03200
PSDN N 3225 X19-T DC	32	25	152	52	13.7	M6	G1/8"	8	SNM. 1906	XX,YY	13200
PSDN N 4040 X25-T DC	40	40	190	65	22.4	M6	G1/8"	8	SNM. 2507 / 2509	XX,YY	04000


Key I


Shim

Assembly pin


Coolant screw plug


Lever


Clamping screw


Solid Carbide support S


Grubscrew

Spare parts for Article no.		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 596 02000		XX,YY	176	XX,YY	198	XX,YY	192	XX,YY	294	XX,YY	187	XX,YY	209	XX,YY	230	XX,YY	86700
70 596 02500		XX,YY	176	XX,YY	198	XX,YY	192	XX,YY	294	XX,YY	187	XX,YY	209	XX,YY	230	XX,YY	86700
70 596 12500		XX,YY	176	XX,YY	391	XX,YY	394	XX,YY	294	XX,YY	385	XX,YY	388	XX,YY	382	XX,YY	86700
70 596 03200		XX,YY	176	XX,YY	391	XX,YY	394	XX,YY	294	XX,YY	385	XX,YY	388	XX,YY	382	XX,YY	86700
70 596 13200		XX,YY	396	XX,YY	392	XX,YY	395	XX,YY	294	XX,YY	386	XX,YY	389	XX,YY	383	XX,YY	86700
70 596 04000		XX,YY	265	XX,YY	621	XX,YY	623	XX,YY	294	XX,YY	620	XX,YY	622	XX,YY	27600	XX,YY	86700

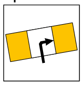
When using SN.. 2509 indexable inserts, use insert seat article no. 70 950 40200.

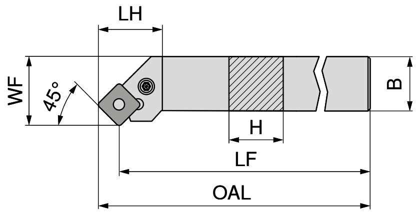
9

MaxiLock-N – PSSN 45° – Upínací držák s upínací pákou

Rozsah dodávky:

Upínací držák s imbusovým klíčem





Obrázky zobrazují pravé provedení

Označení ISO	H mm	B mm	OAL mm	LF mm	LH mm	WF mm	Utahovací moment Nm	Vyměnitelná destička	Levý 70 513 ... #CU# *PA*		Pravý 70 512 ... #CU# *PA*	
PSSN R/L 1616 H09	16	16	106,7	100	23,6	20	3	SNM. 0903	XX,YY	**016**	XX,YY	**01600** [1)]
PSSN R/L 2020 K12	20	20	134,0	125	27,3	25	4	SNM. 1204	XX,YY	**020**	XX,YY	**020**
PSSN R/L 2525 M12	25	25	159,0	150	29,3	32	4	SNM. 1204	XX,YY	**025**	XX,YY	**025**
PSSN R/L 3225 P12	32	25	179,0	170	29,3	32	4	SNM. 1204	XX,YY	**032**	XX,YY	**032**
PSSN R 2525 M15	25	25	161,2	150	32,5	32	4	SNM. 1506			XX,YY	**125**
PSSN R 3232 P15	32	32	181,2	170	38,9	40	4	SNM. 1506			XX,YY	**132**
PSSN R 3232 P19	32	32	183,5	170	41,2	40	8	SNM. 1906			XX,YY	**232**
PSSN L 3232 P19	32	32	183,5	170	40,2	40	8	SNM. 1906	XX,YY	**232**		
PSSN R 4040 S25	40	40	268,0	250	50,8	50	8	SNM. 2507 / 2509			XX,YY	**04000**

1) poniklovaný

When using SN.. 2509 indexable inserts, use insert seat article no. 70 950 40200.


Key I


Shim


Assembly pin


Lever


Clamping screw

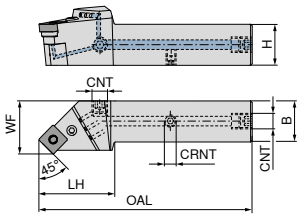

Solid Carbide support S

Spare parts for Article no.		Key I 70 950 ... #CU# *PA*		Shim 70 950 ... #CU# *PA*		Assembly pin 70 950 ... #CU# *PA*		Lever 70 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*		Solid Carbide support S 70 950 ... #CU# *PA*	
70 512 01600 / 70 513 016	SW2,5	XX,YY	**175**	XX,YY	**197**	XX,YY	**191**	XX,YY	**185**	XX,YY	**208**	XX,YY	**229**
70 512 020 / 70 513 020	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**209**	XX,YY	**230**
70 512 025 / 70 513 025	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**209**	XX,YY	**230**
70 512 032 / 70 513 032	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**209**	XX,YY	**230**
70 512 125	SW3	XX,YY	**176**	XX,YY	**391**	XX,YY	**394**	XX,YY	**385**	XX,YY	**388**	XX,YY	**382**
70 512 132	SW3	XX,YY	**176**	XX,YY	**391**	XX,YY	**394**	XX,YY	**385**	XX,YY	**388**	XX,YY	**382**
70 512 232	SW4	XX,YY	**396**	XX,YY	**392**	XX,YY	**395**	XX,YY	**386**	XX,YY	**389**	XX,YY	**383**
70 513 232	SW4	XX,YY	**396**	XX,YY	**392**	XX,YY	**395**	XX,YY	**386**	XX,YY	**389**	XX,YY	**383**
70 512 04000	SW5	XX,YY	**265**	XX,YY	**621**	XX,YY	**623**	XX,YY	**620**	XX,YY	**622**	XX,YY	**27600**

MaxiLock-N – PSSN 45° DC – Toolholder with lever clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	NEW Left-hand 70 597 ... #CU# *PA*		NEW Right-hand 70 597 ... #CU# *PA*	
PSSN R/L 2020 X12-T DC	20	20	111.9	42.9	25	M6	G1/8"	4	SNM. 1204	XX,YY	**02000**	XX,YY	**02001**
PSSN R/L 2525 X12-T DC	25	25	129.9	45.9	32	M6	G1/8"	4	SNM. 1204	XX,YY	**02500**	XX,YY	**02501**
PSSN R/L 3225 X12-T DC	32	25	145.9	45.9	32	M6	G1/8"	4	SNM. 1204	XX,YY	**03200**	XX,YY	**03201**
PSSN R 2525 X15-T DC	25	25	131.5	47.5	32	M6	G1/8"	4	SNM. 1506			XX,YY	**12501**
PSSN R 3232 X15-T DC	32	32	145.9	45.9	40	M6	G1/8"	4	SNM. 1506			XX,YY	**13201**
PSSN R/L 3232 X19-T DC	32	32	151.8	51.8	40	M6	G1/8"	8	SNM. 1906	XX,YY	**13200**	XX,YY	**23201**
PSSN R 4040 X25-T DC	40	40	189.6	64.6	50	M6	G1/8"	8	SNM. 2507 / 2509			XX,YY	**04001**

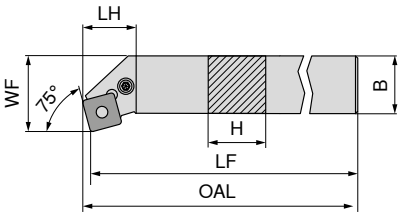
When using SN.. 2509 indexable inserts, use insert seat article no. 70 950 40200.

Spare parts for Article no.	Key I 70 950 ... #CU# *PA*		Shim 70 950 ... #CU# *PA*		Assembly pin 70 950 ... #CU# *PA*		Coolant screw plug 70 950 ... #CU# *PA*		Lever 70 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*		Solid Carbide support S 70 950 ... #CU# *PA*		Grubscrew 70 950 ... #CU# *PA*	
70 597 02001 / 70 597 02000	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**294**	XX,YY	**187**	XX,YY	**209**	XX,YY	**230**	XX,YY	**86700**
70 597 02501 / 70 597 02500	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**294**	XX,YY	**187**	XX,YY	**209**	XX,YY	**230**	XX,YY	**86700**
70 597 03201 / 70 597 03200	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**294**	XX,YY	**187**	XX,YY	**209**	XX,YY	**230**	XX,YY	**86700**
70 597 12501	XX,YY	**176**	XX,YY	**391**	XX,YY	**394**	XX,YY	**294**	XX,YY	**385**	XX,YY	**388**	XX,YY	**382**	XX,YY	**86700**
70 597 13201	XX,YY	**176**	XX,YY	**391**	XX,YY	**394**	XX,YY	**294**	XX,YY	**385**	XX,YY	**388**	XX,YY	**382**	XX,YY	**86700**
70 597 23201 / 70 597 13200	XX,YY	**396**	XX,YY	**392**	XX,YY	**395**	XX,YY	**294**	XX,YY	**386**	XX,YY	**389**	XX,YY	**383**	XX,YY	**86700**
70 597 04001	XX,YY	**265**	XX,YY	**621**	XX,YY	**623**	XX,YY	**294**	XX,YY	**620**	XX,YY	**622**	XX,YY	**27600**	XX,YY	**86700**

MaxiLock-N – PSKN 75° – Toolholder with lever clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions

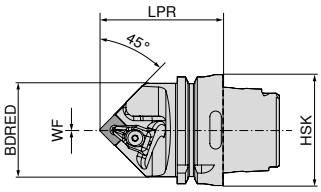
ISO designation	H mm	LF mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 525 ... #CU# *PA*		Right-hand 70 524 ... #CU# *PA*	
PSKN R/L 1616 H09	16	100	16	102.5	18.7	20	3	SNM. 0903	XX,YY	**016**	XX,YY	**016**
PSKN R/L 2020 K12	20	125	20	128.3	24.1	25	4	SNM. 1204	XX,YY	**020**	XX,YY	**020**
PSKN R/L 2525 M12	25	150	25	153.3	24.1	32	4	SNM. 1204	XX,YY	**025**	XX,YY	**025**
PSKN R/L 3225 P12	32	170	25	173.1	24.1	32	4	SNM. 1204	XX,YY	**03200**	XX,YY	**03200**
PSKN R 4040 S19	40	250	40	254.6	38.3	50	8	SNM. 1906			XX,YY	**04000**

Spare parts for Article no.		Key I 70 950 ... #CU# *PA*		Shim 70 950 ... #CU# *PA*		Assembly pin 70 950 ... #CU# *PA*		Lever 70 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*		Solid Carbide support S 70 950 ... #CU# *PA*	
70 524 016 / 70 525 016	SW2,5	XX,YY	**175**	XX,YY	**197**	XX,YY	**191**	XX,YY	**185**	XX,YY	**208**	XX,YY	**229**
70 524 020 / 70 525 020	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**209**	XX,YY	**230**
70 524 025 / 70 525 025	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**209**	XX,YY	**230**
70 524 03200 / 70 525 03200	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**209**	XX,YY	**230**
70 524 04000	SW4	XX,YY	**396**	XX,YY	**392**	XX,YY	**395**	XX,YY	**386**	XX,YY	**389**	XX,YY	**383**

MaxiLock-D – DSDN 45° – Toolholder with top clamping

Scope of supply:

Tool holder with Torx key

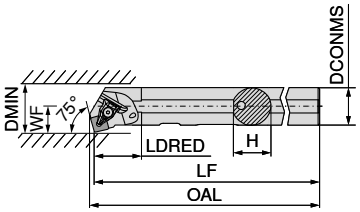


ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert	Neutral 74 522 ... #CU# *PA*	
HSK T63 DSDN N 12	HSK-T 63	70	53	0	4	SN.. 1204	XX,YY	**512**
HSK T63 DSDN N 15	HSK-T 63	75	53	0	4	SN.. 1506	XX,YY	**515**
HSK T100 DSDN N 12	HSK-T 100	80	88	0	4	SN.. 1204	XX,YY	**712**
HSK T100 DSDN N 19	HSK-T 100	85	88	0	8	SN.. 1906	XX,YY	**719**

Spare parts for Article no.	XPress type 70 950 ... #CU# *PA*		Key D 80 950 ... #CU# *PA*			Clamping screw 70 950 ... #CU# *PA*		Solid Carbide support S 70 950 ... #CU# *PA*	
74 522 512	XX,YY	**824**	T15 - IP	XX,YY	**128**	M4,5x12 - IP	XX,YY	**820**	XX,YY	**813**
74 522 515	XX,YY	**825**	T20 - IP	XX,YY	**129**	M5x14 - IP	XX,YY	**821**	XX,YY	**833**
74 522 712	XX,YY	**824**	T15 - IP	XX,YY	**128**	M4,5x12 - IP	XX,YY	**820**	XX,YY	**813**
74 522 719	XX,YY	**826**	T20 - IP	XX,YY	**129**	M5x14 - IP	XX,YY	**821**	XX,YY	**817**

MaxiLock-D – DSKN 75° – Boring bar with top clamping

Scope of supply:
Boring bar with Torx key



Illustrations show right-hand versions

										Left-hand		Right-hand	
										70 561 ...		70 560 ...	
Označení ISO	DCONMS mm	H mm	LF mm	OAL mm	LDRED mm	WF mm	DMIN mm	Utahovací moment Nm	Vyměnitelná destička	#CU# *PA*		#CU# *PA*	
A32S DSKN R/L 12	32	31	250	254,2	40	22	40	4	SN.. 1204	XX,YY	832	XX,YY	832

XPress type

Key D

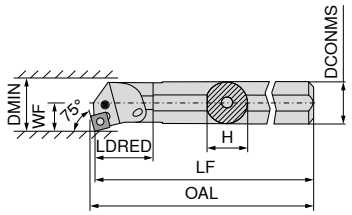
Clamping screw

Solid Carbide support S

										70 950 ...		80 950 ...		70 950 ...		70 950 ...	
Spare parts for Article no.										#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
70 560 832 / 70 561 832										XX,YY	824	T15 - IP	XX,YY	128	M4,5x12 - IP	XX,YY	820	XX,YY	813

MaxiLock-N – PSKN 75° – Boring bar with lever clamping

Scope of supply:
Boring bar with Allen key



Illustrations show right-hand versions

										Left-hand		Right-hand	
										70 561 ...		70 560 ...	
ISO designation	DCONMS mm	H mm	LF mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	#CU# *PA*		#CU# *PA*	
A25R PSKN R/L 12	25	23	200	203	36	17	32	4	SNM. 1204	XX,YY	225	XX,YY	225
A32S PSKN R/L 12	32	30	250	253	50	22	40	4	SNM. 1204	XX,YY	232	XX,YY	232
A40T PSKN R/L 12	40	38	300	303	60	27	50	4	SNM. 1204	XX,YY	240	XX,YY	240

Key I

Shim

Assembly pin

Lever

Clamping screw

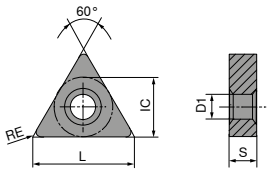
Solid Carbide support S

										70 950 ...		70 950 ...		70 950 ...		70 950 ...		70 950 ...	
Spare parts for Article no.										#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
70 561 225 / 70 560 225										SW3	XX,YY	176	XX,YY	198	XX,YY	192	XX,YY	187	XX,YY	205	XX,YY	230
70 561 232 / 70 560 232										SW3	XX,YY	176	XX,YY	198	XX,YY	192	XX,YY	187	XX,YY	205	XX,YY	230
70 561 240 / 70 560 240										SW3	XX,YY	176	XX,YY	198	XX,YY	192	XX,YY	187	XX,YY	209	XX,YY	230

9

TNMG / TNMA / TNMM

Designation	L mm	S mm	D1 mm	IC mm
TNMG 1103..	11.0	3.18	2.26	6.35
TNM. 1604..	16.5	4.76	3.81	9.52
TNM. 2204..	22.0	4.76	5.16	12.70



TNMG

		NEW	NEW	NEW	NEW	NEW	NEW
		-CF20 CTEP110	-F50 CTCP115-P	-F50 CTCP125-P	-F50 CTCP135-P	-M50 CTCP115-P	-M50 CTCP125-P	-M50 CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		F	F	F	F	M	M	M
		CERMET TNMG	TNMG	TNMG	TNMG	TNMG	TNMG	TNMG
		76 149 ...	76 146 ...	76 146 ...	76 146 ...	76 138 ...	76 138 ...	76 138 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
110304EN	0.4		XX,YY 30401	XX,YY 50401	XX,YY 70401			
110308EN	0.8		XX,YY 30601	XX,YY 50601	XX,YY 70601			
160404EN	0.4	XX,YY 016	XX,YY 31601	XX,YY 51601	XX,YY 71601	XX,YY 31601	XX,YY 51601	XX,YY 71601
160408EN	0.8	XX,YY 018	XX,YY 31801	XX,YY 51801	XX,YY 71801	XX,YY 31801	XX,YY 51801	XX,YY 71801
160412EN	1.2	XX,YY 020	XX,YY 32001	XX,YY 52001	XX,YY 72001	XX,YY 32001	XX,YY 52001	XX,YY 72001
220408EN	0.8					XX,YY 33001	XX,YY 53001	XX,YY 73001
220412EN	1.2					XX,YY 33201	XX,YY 53201	XX,YY 73201
P		●	●	●	●	●	●	●
M		○			○			○
K		○	○	○		○	○	
N								
S								
H								
O								

TNMG

					NEW		NEW		NEW		NEW		NEW		
		-M70 CTCK110		-M70 CTCK120		-M70 CTCP115-P		-M70 CTCP125-P		-M70 CTCP135-P		CTCP125-P		CTCP135-P	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
		M		M		M		M		M		M		M	
		TNMG		TNMG		TNMG		TNMG		TNMG		TNMG		TNMG	
		70 155 ...		70 155 ...		76 155 ...		76 155 ...		76 155 ...		76 142 ...		76 142 ...	
ISO	RE mm	#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
160404ER	0.4											XX,YY	51601	XX,YY	71601
160408EL	0.8											XX,YY	51801		
160408EN	0.8	XX,YY	018	XX,YY	518	XX,YY	31801	XX,YY	51801	XX,YY	71801				
160408ER	0.8											XX,YY	51701	XX,YY	71801
160412EN	1.2	XX,YY	020	XX,YY	520	XX,YY	32001	XX,YY	52001	XX,YY	72001				
220404EN	0.4							XX,YY	52801						
220408EN	0.8	XX,YY	030	XX,YY	530	XX,YY	33001	XX,YY	53001	XX,YY	73001				
220412EN	1.2	XX,YY	032	XX,YY	532	XX,YY	33201	XX,YY	53201	XX,YY	73201				
220416EN	1.6	XX,YY	034	XX,YY	534	XX,YY	33401	XX,YY	53401	XX,YY	73401				
P		○		○		●		●		●		●		●	
M										○				○	
K		●		●		○		○				○			
N															
S															
H															
O															

9

TNMA / TNMM

					NEW		NEW		NEW		NEW		NEW		
		CTCK110		CTCK120		-R28 CTCP115-P		-R28 CTCP125-P		-R28 CTCP135-P		-R58 CTCP115-P		-R58 CTCP125-P	
		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	
															
		R		M		R		R		R		R		R	
		TNMA		TNMA		TNMM		TNMM		TNMM		TNMM		TNMM	
		70 134 ...		70 134 ...		76 154 ...		76 154 ...		76 154 ...		76 152 ...		76 152 ...	
ISO	RE mm	#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
160408EN	0.8	XX,YY	018	XX,YY	518										
160412EN	1.2	XX,YY	020	XX,YY	520										
160416EN	1.6	XX,YY	022	XX,YY	522										
220408EN	0.8	XX,YY	030	XX,YY	530										
220412EN	1.2	XX,YY	032	XX,YY	532							XX,YY	33201	XX,YY	53201
220416EN	1.6	XX,YY	034	XX,YY	534	XX,YY	33401	XX,YY	53401	XX,YY	73401				
P		○		○		●		●		●		●		●	
M										○					
K		●		●		○		○				○		○	
N															
S															
H															
O															

TNMM / TNMG

		NEW						
		-R58 CTCP135-P	-F30 CTCM120	-F30 CTPM125	-F30 CTCM130	-M30 CTCM120	-M30 CTPM125	-M30 CTCM130
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		R	F	F	F	M	M	M
		TNMM	TNMG	TNMG	TNMG	TNMG	TNMG	TNMG
		76 152 ...	75 019 ...	75 019 ...	75 019 ...	75 020 ...	75 020 ...	75 020 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
160404EN	0.4		XX,YY 11600	XX,YY 216	XX,YY 31600			
160408EN	0.8		XX,YY 11800	XX,YY 218	XX,YY 31800	XX,YY 11800	XX,YY 218	XX,YY 31800
160412EN	1.2					XX,YY 12000	XX,YY 220	XX,YY 32000
220412EN	1.2	XX,YY 73201						
P		●	○	○	○	○	○	○
M		○	●	●	●	●	●	●
K								
N								
S					○			○
H								
O								

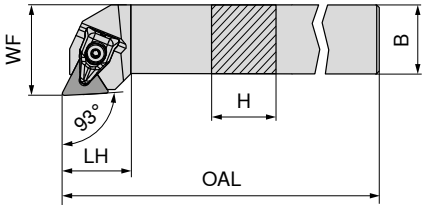
TNMG

		-M60 CTCM120	-M60 CTPM125	-M60 CTCM130	-M34 CTPX710
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		M	M	M	M
		TNMG	TNMG	TNMG	TNMG
		75 021 ...	75 021 ...	75 021 ...	75 006 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
160408EN	0.8	XX,YY 11800	XX,YY 218	XX,YY 31800	XX,YY 61800
160412EN	1.2	XX,YY 12000	XX,YY 220	XX,YY 32000	
220404EN	0.4				XX,YY 62800
220408EN	0.8				XX,YY 63000
220416EN	1.6				XX,YY 63400
P		○	○	○	●
M		●	●	●	●
K					
N					○
S				○	●
H					
O					

→ vc Page 186–199

MaxiLock-D – DTJN 93° – Toolholder with top clamping

Scope of supply:
Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 591 ... #CU# *PA*		Right-hand 70 590 ... #CU# *PA*	
DTJN R/L 2020 K16	20	20	125	23	25	2	TNM. 1604	XX,YY	**820**	XX,YY	**820**
DTJN R/L 2525 M16	25	25	150	24	32	2	TNM. 1604	XX,YY	**825**	XX,YY	**825**

XPress type

Key D

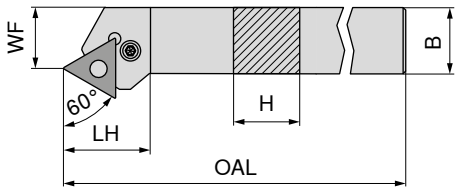
Clamping screw

Solid Carbide Seat T

Spare parts for Article no.	70 950 ... #CU# *PA*		80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 590 820 / 70 591 820	XX,YY	**823**	T09 - IP	XX,YY **126**	M3x7 - IP	XX,YY **819**	XX,YY	**847**
70 590 825 / 70 591 825	XX,YY	**823**	T09 - IP	XX,YY **126**	M3x7 - IP	XX,YY **819**	XX,YY	**847**

MaxiLock-N – PTTN 60° – Toolholder with lever clamping

Scope of supply:
Tool holder with allen key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 529 ... #CU# *PA*		Right-hand 70 528 ... #CU# *PA*	
PTTN R/L 2020 K16	20	20	125	25.9	17	3	TNM. 1604	XX,YY	**020**	XX,YY	**020**
PTTN R/L 2525 M22	25	25	150	32.7	22	4	TNM. 2204	XX,YY	**025**	XX,YY	**025**

Key I

Shim

Assembly pin

Lever

Clamping screw

Solid Carbide Seat T

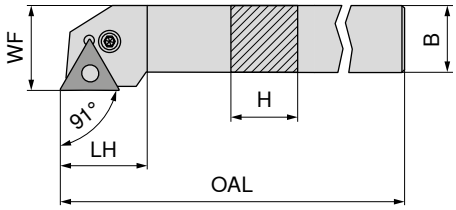
Spare parts for Article no.		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 529 020 / 70 528 020	SW2,5	XX,YY	**175**	XX,YY	**197**	XX,YY	**191**	XX,YY	**185**	XX,YY	**208**	XX,YY	**225**
70 529 025 / 70 528 025	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**209**	XX,YY	**226**

9

MaxiLock-N – PTGN 91° – Toolholder with lever clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 533 ... #CU# *PA*		Right-hand 70 532 ... #CU# *PA*	
PTGN R/L 1616 H16	16	16	100	20	20	3	TNM. 1604	XX,YY	**016**	XX,YY	**016**
PTGN R/L 2020 K16	20	20	125	20	25	3	TNM. 1604	XX,YY	**020**	XX,YY	**020**
PTGN R/L 2525 M16	25	25	150	22	32	3	TNM. 1604	XX,YY	**025**	XX,YY	**025**
PTGN R/L 3225 P16	32	25	170	22	32	3	TNM. 1604	XX,YY	**032**	XX,YY	**032**
PTGN R/L 2525 M22	25	25	150	29	32	4	TNM. 2204	XX,YY	**125**	XX,YY	**125**
PTGN R/L 3232 P22	32	32	170	29	40	4	TNM. 2204	XX,YY	**132**	XX,YY	**132**

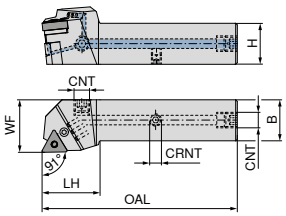
Spare parts for Article no.		Key I 70 950 ... #CU# *PA*		Shim 70 950 ... #CU# *PA*		Assembly pin 70 950 ... #CU# *PA*		Lever 70 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*		Solid Carbide Seat T 70 950 ... #CU# *PA*	
70 532 016 / 70 533 016	SW2,5	XX,YY	**175**	XX,YY	**197**	XX,YY	**191**	XX,YY	**185**	XX,YY	**208**	XX,YY	**225**
70 532 020 / 70 533 020	SW2,5	XX,YY	**175**	XX,YY	**197**	XX,YY	**191**	XX,YY	**185**	XX,YY	**208**	XX,YY	**225**
70 532 025 / 70 533 025	SW2,5	XX,YY	**175**	XX,YY	**197**	XX,YY	**191**	XX,YY	**185**	XX,YY	**208**	XX,YY	**225**
70 532 032 / 70 533 032	SW2,5	XX,YY	**175**	XX,YY	**197**	XX,YY	**191**	XX,YY	**185**	XX,YY	**208**	XX,YY	**225**
70 532 125 / 70 533 125	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**209**	XX,YY	**226**
70 532 132 / 70 533 132	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**209**	XX,YY	**226**

MaxiLock-N – PTGN 91° DC – Toolholder with lever clamping

Scope of supply:

Tool holder with allen key

Direct Cooling



Illustrations show right-hand versions

										NEW Left-hand	NEW Right-hand
										70 598 ...	70 598 ...
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	#CU# *PA*	#CU# *PA*
PTGN R/L 2020 X16-T DC	20	20	101	32	25	M6	G1/8"	3	TNM. 1604	XX,YY **02000**	XX,YY **02001**
PTGN R/L 2525 X16-T DC	25	25	119	35	32	M6	G1/8"	3	TNM. 1604	XX,YY **02500**	XX,YY **02501**
PTGN R/L 3225 X16-T DC	32	25	136	36	32	M6	G1/8"	3	TNM. 1604	XX,YY **03200**	XX,YY **03201**
PTGN R/L 2525 X22-T DC	25	25	122	38	32	M6	G1/8"	4	TNM. 2204	XX,YY **12500**	XX,YY **12501**
PTGN R/L 3232 X22-T DC	32	32	138	38	40	M6	G1/8"	4	TNM. 2204	XX,YY **13200**	XX,YY **13201**

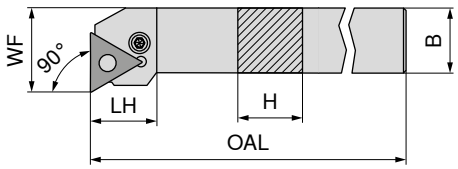
	 Key I	 Shim	Assembly pin	 Coolant screw plug	 Lever	 Clamping screw	 Solid Carbide Seat T	 Grubscrew
	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
Spare parts for Article no.	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
70 598 02001 / 70 598 02000	XX,YY **175**	XX,YY **197**	XX,YY **192**	XX,YY **294**	XX,YY **185**	XX,YY **208**	XX,YY **225**	XX,YY **86700**
70 598 02501	XX,YY **175**	XX,YY **197**	XX,YY **192**	XX,YY **294**	XX,YY **185**	XX,YY **208**	XX,YY **225**	XX,YY **86700**
70 598 02500	XX,YY **175**	XX,YY **197**	XX,YY **191**	XX,YY **294**	XX,YY **185**	XX,YY **208**	XX,YY **225**	XX,YY **86700**
70 598 03201 / 70 598 03200	XX,YY **175**	XX,YY **197**	XX,YY **192**	XX,YY **294**	XX,YY **185**	XX,YY **208**	XX,YY **225**	XX,YY **86700**
70 598 12501 / 70 598 12500	XX,YY **176**	XX,YY **198**	XX,YY **192**	XX,YY **294**	XX,YY **187**	XX,YY **209**	XX,YY **226**	XX,YY **86700**
70 598 13201 / 70 598 13200	XX,YY **176**	XX,YY **198**	XX,YY **192**	XX,YY **294**	XX,YY **187**	XX,YY **209**	XX,YY **226**	XX,YY **86700**

9

MaxiLock-N – PTFN 90° – Toolholder with lever clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions

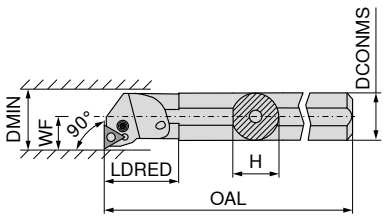
								Left-hand	Right-hand
								70 535 ...	70 534 ...
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	#CU# *PA*	#CU# *PA*
PTFN R/L 1616 H16	16	16	100	19.7	20	3	TNM. 1604	XX,YY **016**	XX,YY **016**
PTFN R/L 2020 K16	20	20	125	20.2	25	3	TNM. 1604	XX,YY **020**	XX,YY **020**
PTFN R/L 2525 M16	25	25	150	20.2	32	3	TNM. 1604	XX,YY **025**	XX,YY **025**
PTFN R/L 2525 M22	25	25	150	25.2	32	4	TNM. 2204	XX,YY **125**	XX,YY **125**
PTFN R/L 3225 P22	32	25	170	25.2	32	4	TNM. 2204	XX,YY **132**	XX,YY **132**

		 Key I	 Shim	Assembly pin	 Lever	 Clamping screw	 Solid Carbide Seat T
		70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...	70 950 ...
Spare parts for Article no.		#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
70 534 016 / 70 535 016	SW2,5	XX,YY **175**	XX,YY **197**	XX,YY **191**	XX,YY **185**	XX,YY **208**	XX,YY **225**
70 534 020 / 70 535 020	SW2,5	XX,YY **175**	XX,YY **197**	XX,YY **191**	XX,YY **185**	XX,YY **208**	XX,YY **225**
70 534 025 / 70 535 025	SW2,5	XX,YY **175**	XX,YY **197**	XX,YY **191**	XX,YY **185**	XX,YY **208**	XX,YY **225**
70 534 125 / 70 535 125	SW3	XX,YY **176**	XX,YY **198**	XX,YY **192**	XX,YY **187**	XX,YY **209**	XX,YY **226**
70 534 132 / 70 535 132	SW3	XX,YY **176**	XX,YY **198**	XX,YY **192**	XX,YY **187**	XX,YY **209**	XX,YY **226**

MaxiLock-N – PTFN 90° – Boring bar with lever clamping

▲ A... = with thro' coolant
▲ S... = without thro' coolant

Scope of supply:
Boring bar with Allen key



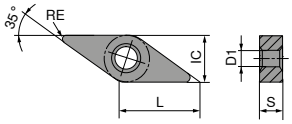
Illustrations show right-hand versions

									Left-hand		Right-hand	
									70 565 ...		**70 564 ...**	
ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	**#CU#** *PA*		**#CU#** *PA*	
S25T PTFN R 16	25	23	300	36	17	32	3	TNM. 1604			XX,YY	**02500**
A25R PTFN R/L 16	25	23	200	36	17	32	3	TNM. 1604	XX,YY	**225**	XX,YY	**225**
A32S PTFN R/L 16	32	30	250	50	22	40	3	TNM. 1604	XX,YY	**232**	XX,YY	**232**
A40T PTFN R/L 22	40	38	300	60	27	50	4	TNM. 2204	XX,YY	**240**	XX,YY	**240**
S50W PTFN R 22	50	47	450	35	35	63	4	TNM. 2204			XX,YY	**050**

	 Key I	 Shim	Assembly pin	 Lever	 Clamping screw	 Solid Carbide Seat T
	70 950 ...	**70 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**
Spare parts for Article no.	**#CU#** *PA*	**#CU#** *PA*	**#CU#** *PA*	**#CU#** *PA*	**#CU#** *PA*	**#CU#** *PA*
70 564 02500	XX,YY **175**	XX,YY **197**	XX,YY **191**	XX,YY **185**	XX,YY **208**	XX,YY **225**
70 564 225 / 70 565 225	XX,YY **175**	XX,YY **197**	XX,YY **191**	XX,YY **185**	XX,YY **208**	XX,YY **225**
70 564 232 / 70 565 232	XX,YY **175**	XX,YY **197**	XX,YY **191**	XX,YY **185**	XX,YY **208**	XX,YY **225**
70 564 240 / 70 565 240	XX,YY **176**	XX,YY **198**	XX,YY **192**	XX,YY **187**	XX,YY **209**	XX,YY **226**
70 564 050	XX,YY **176**	XX,YY **198**	XX,YY **192**	XX,YY **187**	XX,YY **209**	XX,YY **226**

VNMG

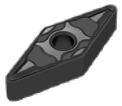
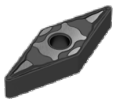
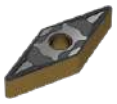
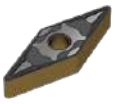
Designation	L mm	S mm	D1 mm	IC mm
VNMG 1604..	16.6	4.76	3.81	9.52



VNMG

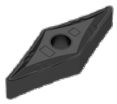
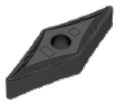
	NEW	NEW	NEW	NEW	NEW	NEW	NEW
	-F40 CTCP125-P	-F50 CTCP115-P	-F50 CTCP125-P	-F50 CTCP135-P	-XU CTCP115-P	-XU CTCP125-P	-M40 CTCP125-P
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
	F VNMG	F VNMG	F VNMG	F VNMG	M VNMG	M VNMG	M VNMG
	76 000 ...	76 156 ...	76 156 ...	76 156 ...	76 294 ...	76 294 ...	76 001 ...
ISO / RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
160404EN 0.4	XX,YY 51601	XX,YY 31601	XX,YY 51601	XX,YY 71601	XX,YY 31601	XX,YY 51601	XX,YY 51601
160408EN 0.8	XX,YY 51801	XX,YY 31801	XX,YY 51801	XX,YY 71801	XX,YY 31801	XX,YY 51801	XX,YY 51801
P	●	●	●	●	●	●	●
M				○			
K	○	○	○		○	○	○
N							
S							
H							
O							

VNMG

	NEW		NEW	NEW			
	-M50 CTCK110	-M50 CTCK120	-M50 CTCP115-P	-M50 CTCP125-P	-F30 CTCM120	-F30 CTPM125	-F30 CTCM130
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
	M VNMG	M VNMG	M VNMG	M VNMG	F VNMG	F VNMG	F VNMG
	70 190 ...	70 131 ...	76 131 ...	76 131 ...	75 022 ...	75 022 ...	75 022 ...
ISO / RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
160404EN 0.4			XX,YY 31601	XX,YY 51601	XX,YY 11600	XX,YY 216	XX,YY 31600
160408EN 0.8		XX,YY 518	XX,YY 31801	XX,YY 51801	XX,YY 11800	XX,YY 218	XX,YY 31800
160412EN 1.2	XX,YY 01200	XX,YY 520	XX,YY 32001	XX,YY 52001			
P	○	○	●	●	○	○	○
M					●	●	●
K	●	●	○	○			
N							
S							○
H							
O							

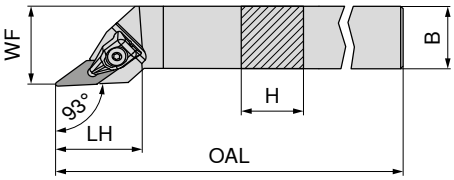
9

VNMG

	-M30 CTCM120	-M30 CTPM125	-M30 CTCM130	-M34 CTPX710
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
				
	M VNMG	**M** VNMG	**M** VNMG	**M** VNMG
	75 023 ...	**75 023 ...**	**75 023 ...**	**75 009 ...**
ISO RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
160404EN 0.4				XX,YY **61600**
160408EN 0.8	XX,YY **11800**	XX,YY **218**	XX,YY **31800**	XX,YY **61800**
160412EN 1.2				XX,YY **62000**
P	○	○	○	●
M	●	●	●	●
K				
N				○
S			○	●
H				
O				

MaxiLock-D – DVJN 93° – Toolholder with top clamping

Scope of supply:
Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 503 ... #CU# *PA*		Right-hand 70 502 ... #CU# *PA*	
DVJN R/L 2020 K16	20	20	125	39	25	2	VN.. 1604	XX,YY	**620**	XX,YY	**620**
DVJN R/L 2525 M16	25	25	150	39	32	2	VN.. 1604	XX,YY	**725**	XX,YY	**725**


XPress type

Key D

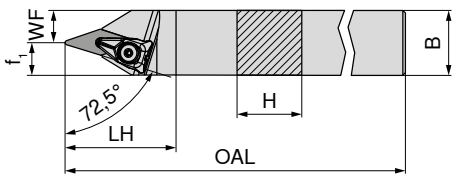

Clamping screw


Solid Carbide Seat V

Spare parts for Article no.	70 950 ... #CU# *PA*		80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 502 620 / 70 503 620	XX,YY	**835**	T09 - IP	XX,YY **126**	M3x7 - IP	XX,YY **819**	XX,YY	**806**
70 502 725 / 70 503 725	XX,YY	**835**	T09 - IP	XX,YY **126**	M3x7 - IP	XX,YY **819**	XX,YY	**806**

MaxiLock-D – DVVN 72.5° – Toolholder with top clamping

Scope of supply:
Tool holder with Torx key



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	f_1 mm	torque moment Nm	Insert	Neutral 70 506 ... #CU# *PA*	
DVVN N 2020 K16	20	20	125	43	7.5	12.5	2	VN.. 1604	XX,YY	**620**
DVVN N 2525 M16	25	25	150	43	12.5	12.5	2	VN.. 1604	XX,YY	**625**


XPress type

Key D


Clamping screw

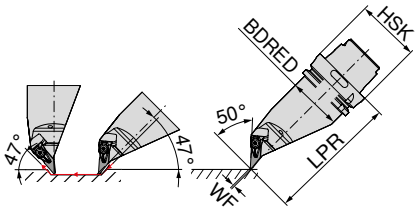

Solid Carbide Seat V

Spare parts for Article no.	70 950 ... #CU# *PA*		80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 506 620	XX,YY	**835**	T09 - IP	XX,YY **126**	M3x7 - IP	XX,YY **819**	XX,YY	**806**
70 506 625	XX,YY	**835**	T09 - IP	XX,YY **126**	M3x7 - IP	XX,YY **819**	XX,YY	**806**

9

MaxiLock-D – DVMN 50° – Toolholder with top clamping

Scope of supply:
Tool holder with Torx key

ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert	Left-hand 74 525 ... #CU# *PA*	
HSK T63 DVMN L 16	HSK-T 63	130	53	0	2	VN.. 1604	XX,YY	**516**
HSK T100 DVMN L 16	HSK-T 100	160	88	0	2	VN.. 1604	XX,YY	**716**


XPress type

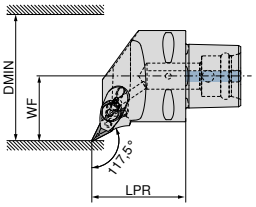

Key D


Clamping screw


Solid Carbide Seat V

Spare parts for Article no.	70 950 ... #CU# *PA*		80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
74 525 516	XX,YY	**835**	T09 - IP	XX,YY **126**	M3x7 - IP	XX,YY **819**	XX,YY	**806**
74 525 716	XX,YY	**835**	T09 - IP	XX,YY **126**	M3x7 - IP	XX,YY **819**	XX,YY	**806**

MaxiLock-D – DVPN 117,5° – Toolholder with top clamping

Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 84 673 ... #CU# *PA*		Right-hand 84 672 ... #CU# *PA*	
PSC40 DVPN R/L 50050-16	PSC 40	50	27	50	10	VN.. 1604	XX,YY	**01695**	XX,YY	**01695**
PSC50 DVPN R/L 65060-16	PSC 50	60	35	65	10	VN.. 1604	XX,YY	**01694**	XX,YY	**01694**
PSC63 DVPN R/L 80065-16	PSC 63	65	45	80	10	VN.. 1604	XX,YY	**01693**	XX,YY	**01693**


Clamping Screw


Clamping claw

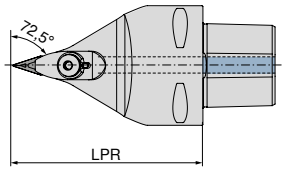

Ring-shaped nozzle


Clamping screw


Solid Carbide Seat V

Spare parts for Article no.		84 950 ... #CU# *PA*		84 950 ... #CU# *PA*		84 950 ... #CU# *PA*		84 950 ... #CU# *PA*	
84 672 01695 / 84 673 01695	M6X28 SW4	XX,YY	**28300**	XX,YY	**28500**	XX,YY	**28400**	XX,YY	**27600**	XX,YY	**28000**
84 672 01694 / 84 673 01694	M6X28 SW4	XX,YY	**28300**	XX,YY	**28500**	XX,YY	**28400**	XX,YY	**27600**	XX,YY	**28000**
84 672 01693 / 84 673 01693	M6X28 SW4	XX,YY	**28300**	XX,YY	**28500**	XX,YY	**28400**	XX,YY	**27600**	XX,YY	**28000**

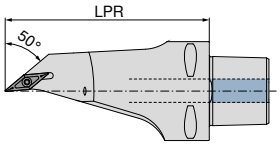
MaxiLock-D – DVVN 72,5° – Toolholder with top clamping

ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Neutral 84 679 ... #CU# *PA*
PSC63 DVVN N 0100-16	PSC 63	100	10	VN.. 1604	XX,YY **01693**
PSC63 DVVN N 0130-16	PSC 63	130	10	VN.. 1604	XX,YY **11693**

Spare parts for Article no.		Clamping Screw 84 950 ... #CU# *PA*	Clamping claw 84 950 ... #CU# *PA*	Ring-shaped nozzle 84 950 ... #CU# *PA*	Clamping screw 84 950 ... #CU# *PA*	Solid Carbide Seat V 84 950 ... #CU# *PA*
84 679 01693	M6X28 SW4	XX,YY **28300**	XX,YY **28500**	XX,YY **28400**	XX,YY **27600**	XX,YY **28000**
84 679 11693	M6X28 SW4	XX,YY **28300**	XX,YY **28500**	XX,YY **28400**	XX,YY **27600**	XX,YY **28000**

MaxiLock-D – DVMN 50° – Toolholder with top clamping

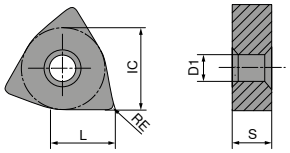
ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Neutral 84 682 ... #CU# *PA*
PSC63 DVMN L 0130-16	PSC 63	130	10	VN.. 1604	XX,YY **01693**

Spare parts for Article no.		Clamping Screw 84 950 ... #CU# *PA*	Clamping claw 84 950 ... #CU# *PA*	Ring-shaped nozzle 84 950 ... #CU# *PA*	Clamping screw 84 950 ... #CU# *PA*	Solid Carbide Seat V 84 950 ... #CU# *PA*
84 682 01693	M6X28 SW4	XX,YY **28300**	XX,YY **28600**	XX,YY **28400**	XX,YY **27600**	XX,YY **28000**

9

WNMG / WNMA

Designation	L mm	S mm	D1 mm	IC mm
WNMG 0604..	6.5	4.76	3.81	9.52
WNM. 0804..	8.6	4.76	5.16	12.70



WNMG

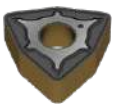
		NEW	NEW	NEW	NEW	NEW
	-CF20 CTEP110	-TFQ CTEP110	-F50 CTCP115-P	-F50 CTCP125-P	-F50 CTCP135-P	-TFQ CTCP115-P	-TFQ CTCP125-P
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
	F	F	F	F	F	F	F
	CERMET WNMG	CERMET WNMG	WNMG	WNMG	WNMG	WNMG	WNMG
	76 171 ...	76 177 ...	76 157 ...	76 157 ...	76 157 ...	76 177 ...	76 177 ...
ISO / RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
060404EN 0.4	XX,YY 004		XX,YY 30401	XX,YY 50401	XX,YY 70401	XX,YY 30401	XX,YY 51401
060408EN 0.8	XX,YY 006	XX,YY 006	XX,YY 30601	XX,YY 50601	XX,YY 70601	XX,YY 30601	XX,YY 50601
080404EN 0.4		XX,YY 016	XX,YY 31601	XX,YY 51601	XX,YY 71601		
080408EN 0.8	XX,YY 018	XX,YY 018	XX,YY 31801	XX,YY 51801	XX,YY 71801	XX,YY 31801	XX,YY 51801
080412EN 1.2			XX,YY 32001	XX,YY 52001	XX,YY 72001	XX,YY 32001	XX,YY 52001
P	●	●	●	●	●	●	●
M	○	○			○		
K	○	○	○	○		○	○
N							
S							
H							
O							

WNMG

		NEW	NEW			NEW	NEW	NEW
		-M50 CTCP115-P	-M50 CTCP125-P	-M50 CTCK110	-M50 CTCK120	-XU CTCP115-P	-XU CTCP125-P	-M50 CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		M	M	M	M	M	M	M
		WNMG	WNMG	WNMG	WNMG	WNMG	WNMG	WNMG
		76 139 ...	76 139 ...	70 139 ...	70 139 ...	76 295 ...	76 295 ...	76 139 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
060404EN	0.4	XX,YY 30401	XX,YY 50401					XX,YY 70401
060408EN	0.8	XX,YY 30601	XX,YY 50601					XX,YY 70601
060412EN	1.2	XX,YY 30801	XX,YY 50801					XX,YY 70801
080404EN	0.4	XX,YY 31601	XX,YY 51601			XX,YY 31601	XX,YY 51601	XX,YY 71601
080408EN	0.8	XX,YY 31801	XX,YY 51801	XX,YY 018	XX,YY 518	XX,YY 31801	XX,YY 51801	XX,YY 71801
080412EN	1.2	XX,YY 32001	XX,YY 52001	XX,YY 020	XX,YY 520	XX,YY 32001	XX,YY 52001	XX,YY 72001
080416EN	1.6	XX,YY 32201	XX,YY 52201					XX,YY 72201
P		●	●	○	○	●	●	●
M								○
K		○	○	●	●	○	○	
N								
S								
H								
O								

9

WNMG

		NEW	NEW			NEW	NEW	NEW
		-TMQ CTCP115-P	-TMQ CTCP125-P	-M70 CTCK110	-M70 CTCK120	-M70 CTCP115-P	-M70 CTCP125-P	-M70 CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		M	M	M	M	M	M	M
		WNMG	WNMG	WNMG	WNMG	WNMG	WNMG	WNMG
		76 198 ...	76 198 ...	70 273 ...	70 273 ...	76 273 ...	76 273 ...	76 273 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
060408EN	0.8					XX,YY 30601	XX,YY 50601	XX,YY 70601
060412EN	1.2					XX,YY 30801	XX,YY 50801	XX,YY 70801
080408EN	0.8	XX,YY 31801	XX,YY 51801	XX,YY 018	XX,YY 518	XX,YY 31801	XX,YY 51801	XX,YY 71801
080412EN	1.2	XX,YY 32001	XX,YY 52001	XX,YY 020	XX,YY 520	XX,YY 32001	XX,YY 52001	XX,YY 72001
080416EN	1.6			XX,YY 022	XX,YY 522	XX,YY 32201	XX,YY 52201	XX,YY 72201
P		●	●	○	○	●	●	●
M								○
K		○	○	●	●	○	○	
N								
S								
H								
O								

WNMA / WNMG

		CTCK110	CTCK120	-F30 CTCM120	-F30 CTPM125	-F30 CTCM130	-M30 CTCM120	-M30 CTPM125
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		R	R	F	F	F	M	M
		WNMA	WNMA	WNMG	WNMG	WNMG	WNMG	WNMG
		70 169 ...	70 169 ...	75 024 ...	75 024 ...	75 024 ...	75 025 ...	75 025 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
060404EN	0.4			XX,YY 10400	XX,YY 204	XX,YY 30400		
060408EN	0.8			XX,YY 10600	XX,YY 206	XX,YY 30600	XX,YY 10600	XX,YY 206
060412EN	1.2						XX,YY 10800	XX,YY 208
080404EN	0.4			XX,YY 11600	XX,YY 216	XX,YY 31600		
080408EN	0.8	XX,YY 018	XX,YY 518	XX,YY 11800	XX,YY 218	XX,YY 31800	XX,YY 11800	XX,YY 218
080412EN	1.2	XX,YY 020	XX,YY 520				XX,YY 12000	XX,YY 220
080416EN	1.6	XX,YY 022	XX,YY 522					
P		○	○	○	○	○	○	○
M				●	●	●	●	●
K		●	●					
N								
S						○		
H								
O								

WNMG

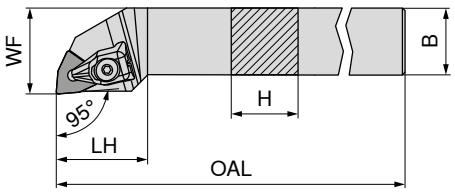
		NEW						
		-M30 CTCM130	-M60 CTCM120	-M60 CTPM125	-M60 CTCM130	-F34 CTPX710	-M34 CTPX710	
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	
								
		M	M	M	M	F	M	
		WNMG	WNMG	WNMG	WNMG	WNMG	WNMG	
		75 025 ...	75 026 ...	75 026 ...	75 026 ...	75 313 ...	75 008 ...	
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	
060408EN	0.8	XX,YY 30600	XX,YY 10600	XX,YY 206	XX,YY 30600			
060412EN	1.2	XX,YY 30800	XX,YY 10800	XX,YY 208	XX,YY 30800			
080408EN	0.8	XX,YY 31800	XX,YY 11800	XX,YY 218	XX,YY 31800	XX,YY 61800	XX,YY 61800	
080412EN	1.2	XX,YY 32000	XX,YY 12000	XX,YY 220	XX,YY 32000		XX,YY 62000	
P		○	○	○	○	●	●	
M		●	●	●	●	●	●	
K								
N						○	○	
S		○			○	●	●	
H								
O								

→ vc Page 186–199

MaxiLock-D – DWLN 95° – Toolholder with top clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 543 ... #CU#	*PA*	Right-hand 70 542 ... #CU#	*PA*
DWLN R/L 1616 H06	16	16	100	25	20	2	WN.. 0604	XX,YY	**716**	XX,YY	**716**
DWLN R/L 2020 K06	20	20	125	27	25	2	WN.. 0604	XX,YY	**720**	XX,YY	**720**
DWLN R/L 2525 M06	25	25	150	27	32	2	WN.. 0604	XX,YY	**725**	XX,YY	**725**
DWLN R/L 2020 K08	20	20	125	34	25	4	WN.. 0804	XX,YY	**620**	XX,YY	**620**
DWLN R/L 2525 M08	25	25	150	34	32	4	WN.. 0804	XX,YY	**625**	XX,YY	**625**

XPress type

Key D

Clamping screw

Solid Carbide Seat W

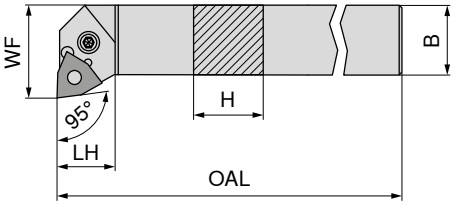
Spare parts for Article no.	70 950 ... #CU#	*PA*	80 950 ... #CU#	*PA*	70 950 ... #CU#	*PA*	70 950 ... #CU#	*PA*
70 543 716 / 70 542 716	XX,YY	**823**	T09 - IP	XX,YY **126**	M3x7 - IP	XX,YY **819**	XX,YY	**807**
70 543 720 / 70 542 720	XX,YY	**823**	T09 - IP	XX,YY **126**	M3x7 - IP	XX,YY **819**	XX,YY	**807**
70 543 725 / 70 542 725	XX,YY	**823**	T09 - IP	XX,YY **126**	M3x7 - IP	XX,YY **819**	XX,YY	**807**
70 543 620 / 70 542 620	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**812**
70 543 625 / 70 542 625	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY **820**	XX,YY	**812**

9

MaxiLock-N – PWLN 95° – Toolholder with lever clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 543 ... #CU#	*PA*	Right-hand 70 542 ... #CU#	*PA*
PWLN R/L 1616 H06	16	16	100	20	22.5	3	WNMG 0604	XX,YY	**116**	XX,YY	**11600** [1]
PWLN R/L 2020 K06	20	20	125	26	25.0	3	WNMG 0604	XX,YY	**12000** [1]	XX,YY	**12000** [1]
PWLN R/L 2525 M06	25	25	150	19	32.0	3	WNMG 0604	XX,YY	**125**	XX,YY	**12500** [1]
PWLN R/L 2020 K08	20	20	125	22	25.0	4	WNMG 0804	XX,YY	**020**	XX,YY	**020**
PWLN R/L 2525 M08	25	25	150	22	32.0	4	WNMG 0804	XX,YY	**025**	XX,YY	**025**
PWLN R/L 3225 P08	32	25	170	22	32.0	4	WNMG 0804	XX,YY	**032**	XX,YY	**032**

1) nickel-plated

Key I

Shim

Assembly pin

Lever

Clamping screw

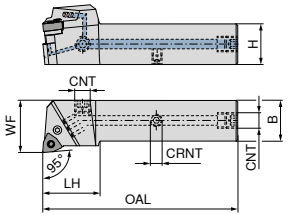
Solid Carbide Seat W

Spare parts for Article no.		70 950 ... #CU#	*PA*	70 950 ... #CU#	*PA*	70 950 ... #CU#	*PA*	70 950 ... #CU#	*PA*	70 950 ... #CU#	*PA*
70 542 11600 / 70 543 116	SW2,5	XX,YY	**175**	XX,YY	**122**	XX,YY	**191**	XX,YY	**185**	XX,YY	**208**	XX,YY	**127**
70 542 12000 / 70 543 12000	SW2,5	XX,YY	**175**	XX,YY	**122**	XX,YY	**191**	XX,YY	**185**	XX,YY	**208**	XX,YY	**127**
70 542 12500 / 70 543 125	SW2,5	XX,YY	**175**	XX,YY	**122**	XX,YY	**191**	XX,YY	**185**	XX,YY	**208**	XX,YY	**127**
70 542 020 / 70 543 020	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**209**	XX,YY	**235**
70 542 025 / 70 543 025	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**209**	XX,YY	**235**
70 542 032 / 70 543 032	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**209**	XX,YY	**235**

MaxiLock-N – PWLN 95° DC – Toolholder with lever clamping

Scope of supply:

Tool holder with allen key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	NEW Left-hand 70 599 ... #CU# *PA*	NEW Right-hand 70 599 ... #CU# *PA*
PWLN R/L 2020 X06-T DC	20	20	104	35	25	M6	G1/8"	3	WNMG 0604	XX,YY **02000**	XX,YY **02001**
PWLN R/L 2525 X06-T DC	25	25	120	35	32	M6	G1/8"	3	WNMG 0604	XX,YY **02500**	XX,YY **02501**
PWLN R/L 2020 X08-T DC	20	20	104	35	25	M6	G1/8"	4	WNMG 0804	XX,YY **12000**	XX,YY **12001**
PWLN R/L 2525 X08-T DC	25	25	120	35	32	M6	G1/8"	4	WNMG 0804	XX,YY **12500**	XX,YY **12501**
PWLN R/L 3225 X08-T DC	32	25	135	35	32	M6	G1/8"	4	WNMG 0804	XX,YY **03200**	XX,YY **03201**

Coolant screw plug

Lever

Clamping screw

Solid Carbide Seat W

Grubscrew

Spare parts for Article no.		70 950 ... #CU# *PA*	Coolant screw plug	70 950 ... #CU# *PA*	Lever	70 950 ... #CU# *PA*	Clamping screw	70 950 ... #CU# *PA*	Solid Carbide Seat W		70 950 ... #CU# *PA*	Grubscrew
70 599 02001 / 70 599 02000	G 1/8"	XX,YY	**294**	XX,YY	**185**	XX,YY	**208**	XX,YY	**127**	M6x6	XX,YY	**86700**
70 599 02501 / 70 599 02500	G 1/8"	XX,YY	**294**	XX,YY	**185**	XX,YY	**208**	XX,YY	**127**	M6x6	XX,YY	**86700**
70 599 12001 / 70 599 12000	G 1/8"	XX,YY	**294**	XX,YY	**187**	XX,YY	**209**	XX,YY	**235**	M6x6	XX,YY	**86700**
70 599 12501 / 70 599 12500	G 1/8"	XX,YY	**294**	XX,YY	**187**	XX,YY	**209**	XX,YY	**235**	M6x6	XX,YY	**86700**
70 599 03201 / 70 599 03200	G 1/8"	XX,YY	**294**	XX,YY	**187**	XX,YY	**209**	XX,YY	**235**	M6x6	XX,YY	**86700**

Key I

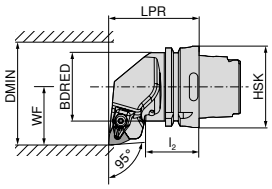
Shim

Assembly pin

Spare parts for Article no.		70 950 ... #CU# *PA*	Key I	70 950 ... #CU# *PA*	Shim	70 950 ... #CU# *PA*	Assembly pin
70 599 02001 / 70 599 02000	SW2,5	XX,YY	**175**	XX,YY	**122**	XX,YY	**191**
70 599 02501 / 70 599 02500	SW2,5	XX,YY	**175**	XX,YY	**122**	XX,YY	**191**
70 599 12001 / 70 599 12000	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**
70 599 12501 / 70 599 12500	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**
70 599 03201 / 70 599 03200	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**

MaxiLock-D – DWLN 95° – Toolholder with top clamping

Scope of supply:
Tool holder with Torx key

Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	l_2 mm	BDRED mm	WF mm	DMIN mm	Insert	Left-hand 74 529 ... #CU# *PA*		Right-hand 74 528 ... #CU# *PA*	
HSK T63 DWLN R/L 08	HSK-T 63	70	42.00	52.6	45	125	WN.. 0804	XX,YY	508	XX,YY	508
HSK T100 DWLN R 08	HSK-T 100	80	45.00	87.6	55	125	WN.. 0804			XX,YY	708
HSK T100 DWLN L 08	HSK-T 100	80	53.96	87.6	55	125	WN.. 0804	XX,YY	708		


XPress type

Key D


Clamping screw

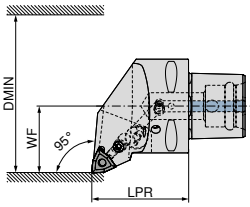

Solid Carbide Seat W

Spare parts for Article no.	70 950 ... #CU# *PA*		80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
74 528 508 / 74 529 508	XX,YY	824	T15 - IP	XX,YY 128	M4,5x12 - IP	XX,YY 820	XX,YY	812
74 528 708 / 74 529 708	XX,YY	824	T15 - IP	XX,YY 128	M4,5x12 - IP	XX,YY 820	XX,YY	812

MaxiLock-N – PWLN 95° – Toolholder with lever clamping

9

Scope of supply:
without high-performance coolant set

Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Direct cooling compatible	Left-hand 84 653 ... #CU# *PA*		Right-hand 84 652 ... #CU# *PA*	
PSC40 PWLN R/L 50050-08	PSC 40	50	27	50	5	WN.. 0804	DC	XX,YY	00895	XX,YY	00895
PSC50 PWLN R/L 65060-08	PSC 50	60	35	65	5	WN.. 0804	DC	XX,YY	00894	XX,YY	00894
PSC63 PWLN R/L 80065-08	PSC 63	65	45	80	5	WN.. 0804	DC	XX,YY	00893	XX,YY	00893

The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page PL**.


Pružný čistící kolík


Šroub upínací páky


Upínací páka

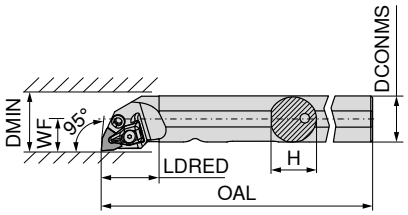

Solid Carbide Seat W

Spare parts for Article no.	84 950 ... #CU# *PA*			84 950 ... #CU# *PA*		84 950 ... #CU# *PA*		84 950 ... #CU# *PA*	
84 652 00895 / 84 653 00895	XX,YY	29200	M8X1/L17 SW3	XX,YY	28700	XX,YY	28900	XX,YY	27700
84 652 00894 / 84 653 00894	XX,YY	29200	M8X1/L17 SW3	XX,YY	28700	XX,YY	28900	XX,YY	27700
84 652 00893 / 84 653 00893	XX,YY	29200	M8X1/L17 SW3	XX,YY	28700	XX,YY	28900	XX,YY	27700

MaxiLock-D – DWLN 95° – Boring bar with top clamping

Scope of supply:

Boring bar with Torx key



Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 573 ... #CU# *PA*		Right-hand 70 572 ... #CU# *PA*	
A25R DWLN R/L 06	25	24	200	32	17	32	2	WN.. 0604	XX,YY	**725**	XX,YY	**725**
A32S DWLN R/L 08	32	31	250	40	22	44	4	WN.. 0804	XX,YY	**732**	XX,YY	**732**
A40T DWLN R/L 08	40	39	300	45	27	50	4	WN.. 0804	XX,YY	**64000**	XX,YY	**640**

XPress type

Key D

Clamping screw

Hydrant

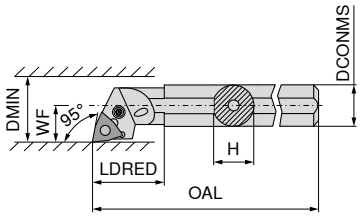
Solid Carbide Seat W

Spare parts for Article no.	70 950 ... #CU# *PA*		80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 572 725 / 70 573 725	XX,YY	**823**	T09 - IP	XX,YY **126**	M3x7 - IP	XX,YY	**819**	XX,YY	**834**	XX,YY **807**
70 572 732 / 70 573 732	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY	**820**	XX,YY	**834**	XX,YY **812**
70 572 640 / 70 573 64000	XX,YY	**824**	T15 - IP	XX,YY **128**	M4,5x12 - IP	XX,YY	**820**	XX,YY	**834**	XX,YY **812**

MaxiLock-N – PWLN 95° – Boring bar with lever clamping

Scope of supply:

Boring bar with Allen key



Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 573 ... #CU# *PA*		Right-hand 70 572 ... #CU# *PA*	
A16M PWLN R/L 06	16	15	150	20	11	20	3	WNMG 0604	XX,YY	**11600** [1]	XX,YY	**11600** [1]
A20Q PWLN R/L 06-1	20	19	180	30	13	25	3	WNMG 0604	XX,YY	**12100** [1]	XX,YY	**12100** [1]
A25R PWLN R/L 06	25	23	200	25	17	32	3	WNMG 0604	XX,YY	**12500** [1]	XX,YY	**12500** [1]
A32S PWLN R/L 06	32	30	250	50	22	40	3	WNMG 0604	XX,YY	**132**	XX,YY	**132**
A25R PWLN R/L 08	25	23	200	40	17	31	4	WNMG 0804	XX,YY	**225**	XX,YY	**225**
A32S PWLN R/L 08	32	30	250	50	22	40	4	WNMG 0804	XX,YY	**032**	XX,YY	**032**
A40T PWLN R/L 08	40	39	300	60	27	50	4	WNMG 0804	XX,YY	**040**	XX,YY	**040**

1) nickel-plated

Key I

Shim

Assembly pin

Lever

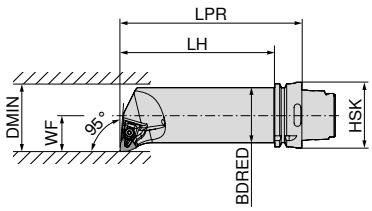
Clamping screw

Solid Carbide Seat W

Spare parts for Article no.		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 572 11600 / 70 573 11600	SW2	XX,YY	**177**					XX,YY	**129**	XX,YY	**217**		
70 572 12100 / 70 573 12100	SW2	XX,YY	**177**					XX,YY	**129**	XX,YY	**217**		
70 572 12500 / 70 573 12500	SW2,5	XX,YY	**175**	XX,YY	**122**	XX,YY	**191**	XX,YY	**185**	XX,YY	**208**	XX,YY	**127**
70 572 132 / 70 573 132	SW2,5	XX,YY	**175**	XX,YY	**122**	XX,YY	**191**	XX,YY	**185**	XX,YY	**208**	XX,YY	**127**
70 572 225 / 70 573 225	SW3	XX,YY	**176**					XX,YY	**187**	XX,YY	**205**		
70 572 032 / 70 573 032	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**209**	XX,YY	**235**
70 572 040 / 70 573 040	SW3	XX,YY	**176**	XX,YY	**198**	XX,YY	**192**	XX,YY	**187**	XX,YY	**209**	XX,YY	**235**

MaxiLock-D – DWLN 95° – Boring bar with top clamping

Scope of supply:
Boring bar with Torx key



Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 537 ... #CU# *PA*		Right-hand 74 536 ... #CU# *PA*	
HSK T63 50Q DWLN R/L 08	HSK-T 63	175	149	50	35	63	4	WN.. 0804	XX,YY	**508**	XX,YY	**508**

XPress type

Key D

Clamping screw

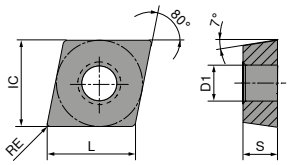
Solid Carbide Seat W

Spare parts for Article no.	70 950 ... #CU# *PA*		80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
74 536 508 / 74 537 508	XX,YY	**824**	T15 - IP XX,YY	**128**	M4,5x12 - IP XX,YY	**820**	XX,YY	**812**

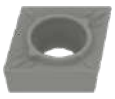
9

CCGT / CCMT / CCET

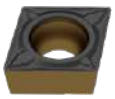
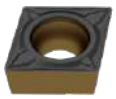
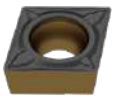
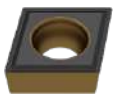
Designation	L mm	S mm	D1 mm	IC mm
CC.T 0602..	6.4	2.38	2.8	6.35
CC.T 09T3..	9.7	3.97	4.4	9.52
CC.T 1204..	12.9	4.76	5.5	12.70



CCGT / CCMT

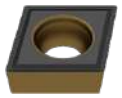
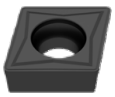
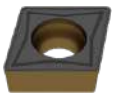
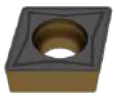
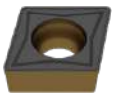
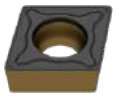
		NEW	NEW
	-CF05 CTEP110	-CF55 CTEP110	-SF TCM407	-SF TCM10	-SMF TCM10	-SF CTCP125-P	-SF CTCP135-P
	DRAGONSKIN	DRAGONSKIN				DRAGONSKIN	DRAGONSKIN
							
	F	F	F	F	F	F	F
	CERMET CCGT	CERMET CCMT	CERMET CCGT	CERMET CCGT	CERMET CCMT	CCGT	CCGT
	76 247 ...	76 248 ...	70 251 ...	70 251 ...	70 249 ...	76 251 ...	76 251 ...
ISO / RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
060202EN 0.2	XX,YY 002		XX,YY 850	XX,YY 900		XX,YY 50201	XX,YY 70201
060204EN 0.4	XX,YY 004	XX,YY 004	XX,YY 852	XX,YY 902	XX,YY 900		
09T302EN 0.2	XX,YY 014		XX,YY 854	XX,YY 904			
09T304EN 0.4	XX,YY 016	XX,YY 016		XX,YY 906	XX,YY 904		
09T308EN 0.8	XX,YY 018	XX,YY 018		XX,YY 908	XX,YY 906		
120404EN 0.4		XX,YY 028		XX,YY 910			
P	●	●	●	●	●	●	●
M	○	○	○	○	○		○
K	○	○	○	○	○	○	
N							
S							
H							
O							

CCMT / CCGT

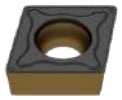
		NEW	NEW	NEW	NEW	NEW	NEW	NEW
		-SF CTCP115-P	-SF CTCP125-P	-SF CTCP135-P	-SMF CTCP115-P	-SMF CTCP125-P	-SMF CTCP135-P	-SM CTCP125-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		F	F	F	F	F	F	M
		CCMT	CCMT	CCMT	CCMT	CCMT	CCMT	CCGT
		76 253 ...	76 253 ...	76 253 ...	76 249 ...	76 249 ...	76 249 ...	76 250 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
060202EN	0.2							XX,YY 50201
060204EN	0.4	XX,YY 30401	XX,YY 50401	XX,YY 70401		XX,YY 50401	XX,YY 70401	
060208EN	0.8					XX,YY 50601		
09T304EN	0.4	XX,YY 31601	XX,YY 51601	XX,YY 71601	XX,YY 31601	XX,YY 51601	XX,YY 71601	
09T308EN	0.8	XX,YY 31801	XX,YY 51801		XX,YY 31801	XX,YY 51801		
120404EN	0.4		XX,YY 52801			XX,YY 52801		
120408EN	0.8		XX,YY 53001		XX,YY 33001		XX,YY 73001	
P		●	●	●	●	●	●	●
M				○			○	
K		○	○		○	○		○
N								
S								
H								
O								

9

CCGT / CCMT

		NEW			NEW	NEW	NEW	NEW
		-SM CTCP135-P	-SM CTCK110	-SM CTCK120	-SM CTCP115-P	-SM CTCP125-P	-SM CTCP135-P	-SMQ CTCP115-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		M	M	M	M	M	M	F
		CCGT	CCMT	CCMT	CCMT	CCMT	CCMT	CCMT
		76 250 ...	70 252 ...	70 252 ...	76 252 ...	76 252 ...	76 252 ...	76 194 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
060202EN	0.2	XX,YY 70201						
060204EN	0.4		XX,YY 004	XX,YY 554	XX,YY 30401	XX,YY 50401	XX,YY 70401	
060208EN	0.8		XX,YY 006	XX,YY 506	XX,YY 30601		XX,YY 70601	
09T304EN	0.4		XX,YY 016	XX,YY 516	XX,YY 31601	XX,YY 51601	XX,YY 71601	XX,YY 31601
09T308EN	0.8		XX,YY 018	XX,YY 518	XX,YY 31801	XX,YY 51801	XX,YY 71801	XX,YY 31801
09T312EN	1.2		XX,YY 020	XX,YY 520				
120404EN	0.4		XX,YY 028	XX,YY 528	XX,YY 32801	XX,YY 52801	XX,YY 72801	XX,YY 32801
120408EN	0.8		XX,YY 030	XX,YY 530	XX,YY 33001	XX,YY 53001	XX,YY 73001	XX,YY 33001
120412EN	1.2					XX,YY 53201		
P		●	○	○	●	●	●	●
M		○					○	
K			●	●	○	○		○
N								
S								
H								
O								

CCMT

ISO	RE mm	NEW -SMQ CTCP125-P	-M25 CTCM120	-M25 CTPM125	-M25 CTCM130	-M55 CTCM120	-M55 CTPM125	-M55 CTCM130
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		F	F	F	F	M	M	M
		CCMT	CCMT	CCMT	CCMT	CCMT	CCMT	CCMT
		76 194 ...	75 210 ...	75 210 ...	75 210 ...	75 211 ...	75 211 ...	75 211 ...
		#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
060204EN	0.4		XX,YY 10400	XX,YY 204	XX,YY 30400	XX,YY 10400	XX,YY 204	XX,YY 30400
09T304EN	0.4	XX,YY 51601	XX,YY 11600	XX,YY 216	XX,YY 31600	XX,YY 11600	XX,YY 216	XX,YY 31600
09T308EN	0.8	XX,YY 51801	XX,YY 11800	XX,YY 218	XX,YY 31800	XX,YY 11800	XX,YY 218	XX,YY 31800
120404EN	0.4	XX,YY 52801				XX,YY 12800	XX,YY 228	XX,YY 32800
120408EN	0.8	XX,YY 53001				XX,YY 13000	XX,YY 230	XX,YY 33000
P		●	○	○	○	○	○	○
M			●	●	●	●	●	●
K		○						
N								
S					○			○
H								
O								

CCGT

ISO	RE mm	-23P H216T	-25P H210T	-25P CTPX710	-25Q H210T	-25Q CTPX710	-27 H10T	-27 CTPX715
				DRAGONSKIN		DRAGONSKIN		DRAGONSKIN
								
		F	F	M	M	M	M	M
		CCGT	CCGT	CCGT	CCGT	CCGT	CCGT	CCGT
		70 255 ...	70 248 ...	70 248 ...	70 248 ...	70 248 ...	70 254 ...	70 254 ...
		#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
060202FN	0.2	XX,YY 652	XX,YY 636	XX,YY 70200			XX,YY 600	XX,YY 80200
060204FN	0.4	XX,YY 654	XX,YY 638	XX,YY 70400	XX,YY 678	XX,YY 75400	XX,YY 602	XX,YY 80400
09T302FN	0.2		XX,YY 639	XX,YY 71400			XX,YY 604	XX,YY 81400
09T304FN	0.4	XX,YY 656	XX,YY 640	XX,YY 71600	XX,YY 680	XX,YY 76600	XX,YY 606	XX,YY 81600
09T308FN	0.8	XX,YY 658	XX,YY 641	XX,YY 71800	XX,YY 681	XX,YY 76800	XX,YY 608	XX,YY 81800
09T316FN	1.6							XX,YY 72200
120402FN	0.2		XX,YY 643				XX,YY 610	XX,YY 82600
120404FN	0.4		XX,YY 642	XX,YY 72800	XX,YY 682	XX,YY 77800	XX,YY 612	XX,YY 82800
120408FN	0.8		XX,YY 644	XX,YY 73000	XX,YY 686	XX,YY 78000	XX,YY 614	XX,YY 83000
P				●		●		●
M				●		●		●
K		○	○		○		○	○
N		●	●	●	●	●	●	●
S			○	●	○	●		●
H								
O		○	○		○		○	○

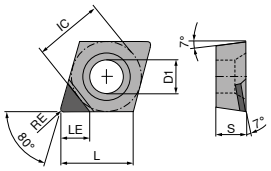
CCET / CCMT

		NEW		NEW
		-F05 CTPX710	-29 H216T	-29 CTPX715
		DRAGONSKIN		DRAGONSKIN
				
		F	M	M
		CCET	CCMT	CCMT
		76 243 ...	70 245 ...	70 245 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*
060201FN	0.1	XX,YY 10100		
060202FN	0.2	XX,YY 10200		
060204EN	0.4		XX,YY 60400	XX,YY 70400
060204FN	0.4	XX,YY 10400		
09T304EN	0.4		XX,YY 61600	XX,YY 71600
09T308EN	0.8		XX,YY 61800	XX,YY 71800
P		●		●
M		●		●
K			○	○
N		●	●	●
S		●		●
H				
O			○	○

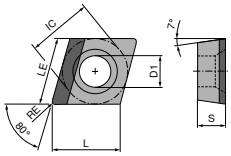
9

CCGW / CCGT

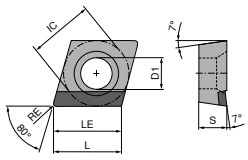
Designation	L mm	S mm	D1 mm	IC mm
CCG. 0602..	6.4	2.38	2.8	6.35
CCG. 09T3..	9.7	3.97	4.4	9.52
CCG. 1204..	12.9	4.76	5.5	12.70



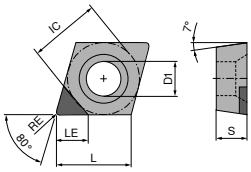
CCGT A



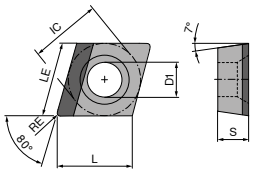
CCGT A LL



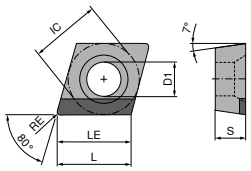
CCGT A RR



CCGW A



CCGW A LL



CCGW A RR

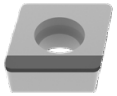
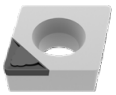
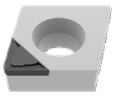
CCGW / CCGT

▲ TCE(NOI) = Design and number of equipped cutting edge corners

				CTDMD05		CTDPD20		CTDPD20		-Q CTDPD20		-Q CTDPD20	
				F		F		F		F		F	
				DIAMOND CCGW		DIAMOND CCGW		DIAMOND CCGT		DIAMOND CCGW		DIAMOND CCGT	
				71 120 ...		71 120 ...		71 124 ...		71 125 ...		71 126 ...	
ISO	RE mm	TCE (NOI)	LE mm	#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
060201FN	0.1	A (1)	3.4									XX,YY	101
060201FN	0.1	A (1)	3.5					XX,YY	10100				
060202FN	0.2	A (1)	2.5	XX,YY	050								
060202FN	0.2	A (1)	3.3							XX,YY	102	XX,YY	102
060202FN	0.2	A (1)	3.4			XX,YY	100	XX,YY	100				
060204FN	0.4	A (1)	2.5	XX,YY	052								
060204FN	0.4	A (1)	3.1									XX,YY	104
060204FN	0.4	A (1)	3.2			XX,YY	102	XX,YY	102	XX,YY	104		
060208FN	0.8	A (1)	2.5	XX,YY	05300								
060208FN	0.8	A (1)	3.0			XX,YY	10300	XX,YY	10300				
09T301FN	0.1	A (1)	4.5							XX,YY	111	XX,YY	111
09T302FN	0.2	A (1)	4.4							XX,YY	112	XX,YY	112
09T302FN	0.2	A (1)	4.5			XX,YY	10500	XX,YY	10500				
09T304FN	0.4	A (1)	2.5	XX,YY	054								
09T304FN	0.4	A (1)	4.2							XX,YY	114	XX,YY	114
09T304FN	0.4	A (1)	4.3			XX,YY	104	XX,YY	104				
09T308FN	0.8	A (1)	2.5	XX,YY	056								
09T308FN	0.8	A (1)	4.1			XX,YY	106	XX,YY	106				
120402FN	0.2	A (1)	4.4							XX,YY	122	XX,YY	122
120404FN	0.4	A (1)	4.2							XX,YY	124	XX,YY	124
120404FN	0.4	A (1)	4.3			XX,YY	108	XX,YY	108				
120408FN	0.8	A (1)	4.1			XX,YY	110	XX,YY	110				
P													
M													
K													
N				●		●		●		●		●	
S													
H													
O				●		●		●		●		●	

CCGW / CCGT

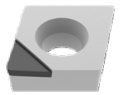
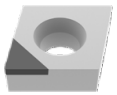
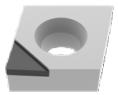
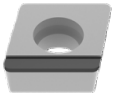
▲ TCE(NOI) = Design and number of equipped cutting edge corners

				CTDPD20		CTDPD20		-CB1 CTDPD20		-CB2 CTDPD20		-CB1 CTDPD20		-Q-CB2 CTDPD20	
															
				F		F		F		M		F		M	
				DIAMOND CCGW		DIAMOND CCGW		DIAMOND CCGT		DIAMOND CCGT		DIAMOND CCGT		DIAMOND CCGT	
				71 172 ...		71 172 ...		71 300 ...		71 168 ...		71 305 ...		71 169 ...	
ISO	RE mm	TCE (NOI)	LE mm	#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
060202FN	0.2	A (1)	3.40					XX,YY	102						
060204FN	0.4	A (1)	3.10									XX,YY	104		
060204FN	0.4	A (1)	3.20					XX,YY	104	XX,YY	10001				
060204FRR	0.4	A (1)	6.45			XX,YY	10101								
060204FLL	0.4	A (1)	6.45	XX,YY	10001										
060208FN	0.8	A (1)	3.00					XX,YY	10600						
09T302FN	0.2	A (1)	4.40											XX,YY	10001
09T302FN	0.2	A (1)	4.50					XX,YY	112						
09T304FN	0.4	A (1)	4.20									XX,YY	114	XX,YY	10101
09T304FN	0.4	A (1)	4.30					XX,YY	114						
09T308FN	0.8	A (1)	4.10					XX,YY	118						
09T308FRR	0.8	A (1)	9.70			XX,YY	10301								
09T308FLL	0.8	A (1)	9.70	XX,YY	10201										
09T312FLL	1.2	A (1)	9.70	XX,YY	10401										
120404FN	0.4	A (1)	4.20									XX,YY	124	XX,YY	10201
120404FN	0.4	A (1)	4.30					XX,YY	124						
120408FN	0.8	A (1)	4.10					XX,YY	128						
120412FRR	1.2	A (1)	12.90			XX,YY	10601								
120412FLL	1.2	A (1)	12.90	XX,YY	10501										
P															
M															
K															
N				●		●		●		●		●		●	
S															
H															
O				●		●		●		●		●		●	

9

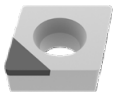
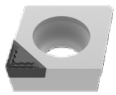
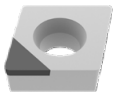
CCGT / CCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners

				CTDPS30	-Q CTDPS30	-Q CTDPS30	CTDPS30	CTDPS30	-CB2 CTDPS30
									
				F	F	F	F	F	M
				DIAMOND CCGT	DIAMOND CCGW	DIAMOND CCGT	DIAMOND CCGT	DIAMOND CCGT	DIAMOND CCGT
				71 166 ...	71 125 ...	71 126 ...	71 170 ...	71 170 ...	71 301 ...
ISO	RE mm	TCE (NOI)	LE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
060201FN	0.1	A (1)	3.50	XX,YY 20001					
060202FN	0.2	A (1)	3.30		XX,YY 152	XX,YY 152			
060202FN	0.2	A (1)	3.40	XX,YY 20101					XX,YY 202
060204FN	0.4	A (1)	3.20						XX,YY 204
060204FRR	0.4	A (1)	6.45					XX,YY 20101	
060204FLL	0.4	A (1)	6.45				XX,YY 20001		
060208FN	0.8	A (1)	3.00						XX,YY 208
060208FRR	0.8	A (1)	6.45					XX,YY 20301	
060208FLL	0.8	A (1)	6.45				XX,YY 20201		
09T301FN	0.1	A (1)	4.50		XX,YY 16300				
09T302FN	0.2	A (1)	4.40		XX,YY 162	XX,YY 162			
09T302FN	0.2	A (1)	4.50	XX,YY 20201					XX,YY 212
09T304FN	0.4	A (1)	4.30						XX,YY 214
09T308FN	0.8	A (1)	4.10						XX,YY 218
09T308FRR	0.8	A (1)	9.70					XX,YY 20501	
09T308FLL	0.8	A (1)	9.70				XX,YY 20401		
120402FN	0.2	A (1)	4.40			XX,YY 172			
120404FN	0.4	A (1)	4.20			XX,YY 174			
120404FN	0.4	A (1)	4.30	XX,YY 20301					XX,YY 224
120408FN	0.8	A (1)	4.10						XX,YY 228
120412FRR	1.2	A (1)	12.90					XX,YY 20701	
120412FLL	1.2	A (1)	12.90				XX,YY 20601		
P									
M									
K									
N				●	●	●	●	●	●
S									
H									
O				●	●	●	●	●	●

CCGT / CCGW

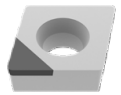
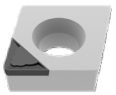
▲ TCE(NOI) = Design and number of equipped cutting edge corners

				-Q-CB2 CTDPS30		CTDPU20		-CB3 CTDPU20		CTDPS30	
											
				M DIAMOND CCGT		F DIAMOND CCGW		R DIAMOND CCGT		F DIAMOND CCGW	
				71 306 ...		71 171 ...		71 302 ...		71 171 ...	
ISO	RE mm	TCE (NOI)	LE mm	#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
060201FN	0.1	A (1)	3.5							XX,YY	20001
060202FN	0.2	A (1)	3.3	XX,YY	202						
060202FN	0.2	A (1)	3.4							XX,YY	20101
060204FN	0.4	A (1)	3.1	XX,YY	204						
060204FN	0.4	A (1)	3.2					XX,YY	204	XX,YY	20201
09T302FN	0.2	A (1)	4.4	XX,YY	212						
09T302FN	0.2	A (1)	4.5							XX,YY	20301
09T304FN	0.4	A (1)	4.2	XX,YY	214						
09T304FN	0.4	A (1)	4.3			XX,YY	30001	XX,YY	214	XX,YY	20401
09T308FN	0.8	A (1)	4.1			XX,YY	30101	XX,YY	218		
120402FN	0.2	A (1)	4.4	XX,YY	222						
120404FN	0.4	A (1)	4.2	XX,YY	224						
120404FN	0.4	A (1)	4.3							XX,YY	20501
P											
M											
K											
N					●		●		●		●
S											
H											
O					●		●		●		●

9

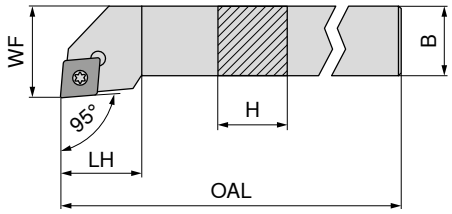
CCGW / CCGT

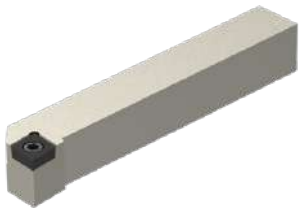
▲ TCE(NOI) = Design and number of equipped cutting edge corners

				CTDCD10	-CB1 CTDCD10	-Q-CB1 CTDCD10	-CB2 CTDCD10	-Q-CB2 CTDCD10
								
				F DIAMOND CCGW	F DIAMOND CCGT	F DIAMOND CCGT	M DIAMOND CCGT	M DIAMOND CCGT
				71 171 ...	71 300 ...	71 167 ...	71 301 ...	71 306 ...
ISO	RE mm	TCE (NOI)	LE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
060202FN	0.2	A (1)	2.3			XX,YY 40001		
060202FN	0.2	A (1)	2.4	XX,YY 40001	XX,YY 302		XX,YY 30200	
060204FN	0.4	A (1)	2.1			XX,YY 40101		XX,YY 304
060204FN	0.4	A (1)	2.2	XX,YY 40101	XX,YY 304		XX,YY 304	
060208FN	0.8	A (1)	2.0		XX,YY 30600			
09T302FN	0.2	A (1)	2.3					XX,YY 31200
09T302FN	0.2	A (1)	2.4	XX,YY 40201			XX,YY 31200	
09T304FN	0.4	A (1)	2.1			XX,YY 40201		XX,YY 314
09T304FN	0.4	A (1)	2.2	XX,YY 40301	XX,YY 314		XX,YY 314	
09T308FN	0.8	A (1)	2.0	XX,YY 40401			XX,YY 31600	
120404FN	0.4	A (1)	2.1			XX,YY 40301		XX,YY 324
120404FN	0.4	A (1)	2.2				XX,YY 32600	
120408FN	0.8	A (1)	2.0	XX,YY 40501				
120408FN	0.8	A (1)	2.1				XX,YY 328	
P								
M								
K								
N				●	●	●	●	●
S								
H								
O				●	●	●	●	●

MaxiLock-S – SCLC 95° – Toolholder with screw clamping

Scope of supply:
Tool holder with Torx key





Illustrations show right-hand versions

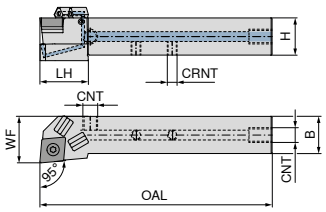
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	NEW Left-hand 70 636 ... #CU# *PA*		NEW Right-hand 70 636 ... #CU# *PA*	
SCLC R/L 0808 D06	8	8	60	9	10	1,2	CC.. 0602	XX,YY	**00800**	XX,YY	**00801**
SCLC R/L 1010 E06	10	10	70	9	12	1,2	CC.. 0602	XX,YY	**01000**	XX,YY	**01001**
SCLC R/L 1212 F09	12	12	80	15	16	3,2	CC.. 09T3	XX,YY	**01200**	XX,YY	**01201**
SCLC R/L 1616 H09	16	16	100	17	20	3,2	CC.. 09T3	XX,YY	**01600**	XX,YY	**01601**
SCLC R/L 2020 K09	20	20	125	17	25	3,2	CC.. 09T3	XX,YY	**02000**	XX,YY	**02001**
SCLC R/L 1616 H12	16	16	100	20	20	5	CC.. 1204	XX,YY	**11600**	XX,YY	**11601**
SCLC R/L 2020 K12	20	20	125	20	25	5	CC.. 1204	XX,YY	**12000**	XX,YY	**12001**
SCLC R/L 2525 M12	25	25	150	20	32	5	CC.. 1204	XX,YY	**12500**	XX,YY	**12501**
SCLC R/L 3225 P12	32	25	170	20	32	5	CC.. 1204	XX,YY	**13200**	XX,YY	**13201**

Spare parts for Article no.	Key D 80 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*		Carbide type C 70 950 ... #CU# *PA*		Threaded sleeve 70 950 ... #CU# *PA*	
70 636 00800 / 70 636 00801	XX,YY	**039**	XX,YY	**857**				
70 636 01000 / 70 636 01001	XX,YY	**039**	XX,YY	**857**				
70 636 01200 / 70 636 01201	XX,YY	**120**	XX,YY	**87900**				
70 636 01600 / 70 636 01601	XX,YY	**120**	XX,YY	**87900**				
70 636 02000 / 70 636 02001	XX,YY	**120**	XX,YY	**87900**				
70 636 11600 / 70 636 11601	XX,YY	**120**	XX,YY	**820**	XX,YY	**166**	XX,YY	**170**
70 636 12000 / 70 636 12001	XX,YY	**120**	XX,YY	**820**	XX,YY	**166**	XX,YY	**170**
70 636 12500 / 70 636 12501	XX,YY	**120**	XX,YY	**820**	XX,YY	**166**	XX,YY	**170**
70 636 13200 / 70 636 13201	XX,YY	**120**	XX,YY	**820**	XX,YY	**166**	XX,YY	**170**

MaxiLock-S – SCLC 95° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions

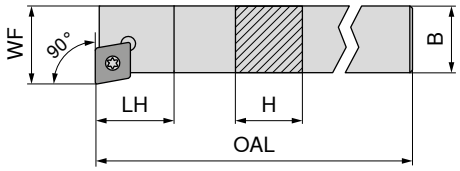
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	NEW Left-hand 70 770 ... #CU# *PA*	NEW Right-hand 70 770 ... #CU# *PA*
SCLC R/L 1010 E06 DC	10	10	70	14	12	M6	M6	1,2	CC.. 0602	XX,YY **01001**	XX,YY **01000**
SCLC R/L 1212 F09 DC	12	12	80	19	16	M6	M6	3,2	CC.. 09T3	XX,YY **01201**	XX,YY **01200**
SCLC R/L 1616 H09 DC	16	16	100	26	20	M6	G1/8"	3,2	CC.. 09T3	XX,YY **11601**	XX,YY **01600**
SCLC R/L 2020 K09 DC	20	20	125	28	25	M6	G1/8"	3,2	CC.. 09T3	XX,YY **12001**	XX,YY **02000**
SCLC R/L 1616 H12 DC	16	16	100	28	20	M6	G1/8"	5	CC.. 1204	XX,YY **01601**	XX,YY **11600**
SCLC R/L 2020 K12 DC	20	20	125	26	25	M6	G1/8"	5	CC.. 1204	XX,YY **02001**	XX,YY **12000**
SCLC R/L 2525 M12 DC	25	25	150	28	30	M6	G1/8"	5	CC.. 1204	XX,YY **02501**	XX,YY **02500**
SCLC R/L 3225 P12 DC	32	25	170	26	32	G1/8"	G1/8"	5	CC.. 1204	XX,YY **03201**	XX,YY **03200**

Spare parts for Article no.	 Clamping screw 70 950 ... #CU# *PA*	 Carbide type C 70 950 ... #CU# *PA*	 Grubscrew 70 950 ... #CU# *PA*	 Grubscrew 70 950 ... #CU# *PA*	 Threaded sleeve 70 950 ... #CU# *PA*
70 770 01000 / 70 770 01001	XX,YY **857**			XX,YY **86700**	
70 770 01200 / 70 770 01201	XX,YY **859**			XX,YY **86700**	
70 770 01600 / 70 770 11601	XX,YY **87900**	XX,YY **165**	XX,YY **88000**	XX,YY **86700**	XX,YY **171**
70 770 02000 / 70 770 12001	XX,YY **87900**	XX,YY **165**	XX,YY **88000**	XX,YY **86700**	XX,YY **171**
70 770 11600 / 70 770 01601	XX,YY **820**	XX,YY **166**	XX,YY **88000**	XX,YY **86700**	XX,YY **170**
70 770 12000 / 70 770 02001	XX,YY **820**	XX,YY **166**	XX,YY **88000**	XX,YY **86700**	XX,YY **170**
70 770 02500 / 70 770 02501	XX,YY **820**	XX,YY **166**	XX,YY **88000**	XX,YY **86700**	XX,YY **170**
70 770 03200 / 70 770 03201	XX,YY **820**	XX,YY **166**	XX,YY **88000**		XX,YY **170**

Spare parts for Article no.	 Sealing plugs DC 70 950 ... #CU# *PA*	 Key D 80 950 ... #CU# *PA*	 O-Ring 70 950 ... #CU# *PA*	 Coolant nozzle DC 70 950 ... #CU# *PA*	 Coolant screw plug 70 950 ... #CU# *PA*
70 770 01000 / 70 770 01001		XX,YY **039**			
70 770 01200 / 70 770 01201		XX,YY **120**			
70 770 01600 / 70 770 11601	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 770 02000 / 70 770 12001	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 770 11600 / 70 770 01601	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 770 12000 / 70 770 02001	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 770 02500 / 70 770 02501	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 770 03200 / 70 770 03201	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**

MaxiLock-S – SCFC 90° – Toolholder with screw clamping

Scope of supply:
Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	Left-hand 70 761 ... #CU# *PA*		Right-hand 70 760 ... #CU# *PA*	
SCFC R 0808 D06	8	8	60	10	10	1,2	CC.. 0602			XX,YY	**008**
SCFC R 1010 E06	10	10	70	10	12	1,2	CC.. 0602			XX,YY	**010**
SCFC R 1212 F09	12	12	80	13	16	3,2	CC.. 09T3			XX,YY	**012**
SCFC R 1616 H09	16	16	100	13	20	3,2	CC.. 09T3			XX,YY	**016**
SCFC R/L 2020 K12	20	20	125	17	25	5	CC.. 1204	XX,YY	**02000** [1]	XX,YY	**020**

1) nickel-plated


Key D


Combination Key


Clamping screw


Carbide type C

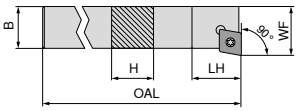

Threaded sleeve

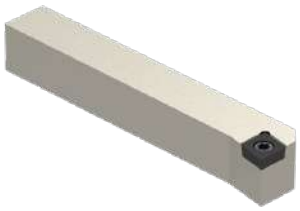
Spare parts for Article no.	80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 760 008	XX,YY	**110**			XX,YY	**13800**				
70 760 010	XX,YY	**110**			XX,YY	**13800**				
70 760 012	XX,YY	**113**			XX,YY	**113**				
70 760 016			XX,YY	**398**	XX,YY	**113**	XX,YY	**165**	XX,YY	**171**
70 760 020 / 70 761 02000			XX,YY	**398**	XX,YY	**114**	XX,YY	**166**	XX,YY	**170**

9

MaxiLock-S – SCFC 90° – Toolholder with screw clamping

Scope of supply:
Tool holder with Torx key





NEW
Left-hand

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	70 635 ... #CU# *PA*	
SCFC L 0808 D06	8	8	60	10	10	1,2	CC.. 0602	XX,YY	**00800**
SCFC L 1010 E06	10	10	70	10	12	1,2	CC.. 0602	XX,YY	**01000**
SCFC L 1212 F09	12	12	80	13	16	3,2	CC.. 09T3	XX,YY	**01200**
SCFC L 1616 H09	16	16	100	13	20	3,2	CC.. 09T3	XX,YY	**01600**

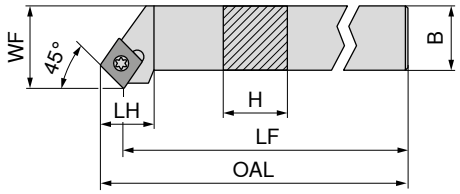

Key D

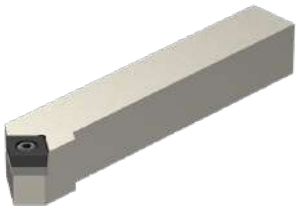

Clamping screw

for Article no.	80 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 635 00800	XX,YY	**039**	XX,YY	**857**
70 635 01000	XX,YY	**039**	XX,YY	**857**
70 635 01200	XX,YY	**120**	XX,YY	**87900**
70 635 01600	XX,YY	**120**	XX,YY	**87900**

MaxiLock-S – SCSC 45° – Toolholder with screw clamping

Scope of supply:
Tool holder with Torx key





Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	NEW Left-hand 70 638 ... #CU# *PA*	NEW Right-hand 70 638 ... #CU# *PA*
SCSC R 1616 H12	16	16	100	20	20	5	CC.. 1204		XX,YY **01601**
SCSC R/L 2020 K12	20	20	125	20	25	5	CC.. 1204	XX,YY **02000**	XX,YY **02001**
SCSC R/L 2525 M12	25	25	150	20	32	5	CC.. 1204	XX,YY **02500**	XX,YY **02501**


Key D


Clamping screw


Carbide type C

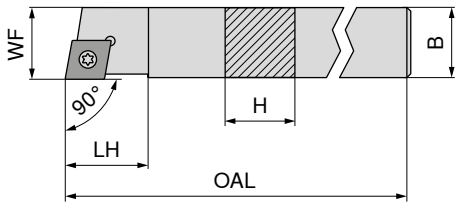

Threaded sleeve

Spare parts for Article no.		80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 638 01601	T15 - IP	XX,YY	**120**	M4,5x12 - IP	XX,YY **820**	XX,YY	**166**	M4,5	XX,YY **170**
70 638 02001 / 70 638 02000	T15 - IP	XX,YY	**120**	M4,5x12 - IP	XX,YY **820**	XX,YY	**166**	M4,5	XX,YY **170**
70 638 02501 / 70 638 02500	T15 - IP	XX,YY	**120**	M4,5x12 - IP	XX,YY **820**	XX,YY	**166**	M4,5	XX,YY **170**

MaxiLock-S – SCAC 90° – Toolholder with screw clamping

▲ for sliding head lathes

Scope of supply:
Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	NEW Left-hand 70 633 ... #CU# *PA*	NEW Right-hand 70 633 ... #CU# *PA*
SCAC R/L 0808 K06	8	8	125	9	8	1,2	CC.. 0602	XX,YY **10800**	XX,YY **10801**
SCAC R/L 0808 D06	8	8	60	9	8	1,2	CC.. 0602	XX,YY **00800**	XX,YY **00801**
SCAC R/L 1010 E06	10	10	70	9	10	1,2	CC.. 0602	XX,YY **01000**	XX,YY **01001**
SCAC R/L 1010 M06	10	10	150	9	10	1,2	CC.. 0602	XX,YY **11000**	XX,YY **11001**
SCAC R/L 1212 F09	12	12	80	13	12	3,2	CC.. 09T3	XX,YY **01200**	XX,YY **01201**
SCAC R/L 1212 M09	12	12	150	13	12	3,2	CC.. 09T3	XX,YY **11200**	XX,YY **11201**
SCAC R/L 1616 H09	16	16	100	13	16	3,2	CC.. 09T3	XX,YY **11600**	XX,YY **11601**
SCAC R/L 2020 K12	20	20	125	17	20	5	CC.. 1204	XX,YY **12000**	XX,YY **12001**


Key D


Clamping screw


Carbide type C


Threaded sleeve

Spare parts for Article no.	80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 633 10801 / 70 633 10800	XX,YY	**039**	XX,YY	**857**				
70 633 00801 / 70 633 00800	XX,YY	**039**	XX,YY	**857**				
70 633 01001 / 70 633 01000	XX,YY	**039**	XX,YY	**857**				
70 633 11001 / 70 633 11000	XX,YY	**039**	XX,YY	**857**				
70 633 01201 / 70 633 01200	XX,YY	**120**	XX,YY	**87900**				
70 633 11201 / 70 633 11200	XX,YY	**120**	XX,YY	**87900**				
70 633 11601 / 70 633 11600	XX,YY	**120**	XX,YY	**87900**				
70 633 12001 / 70 633 12000	XX,YY	**120**	XX,YY	**820**	XX,YY	**166**	XX,YY	**170**

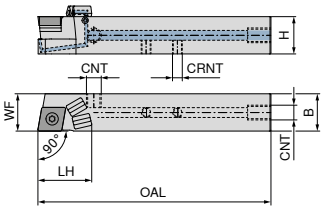
MaxiLock-S – SCAC 90° DC – Tool holder with screw clamping

▲ for sliding head lathes

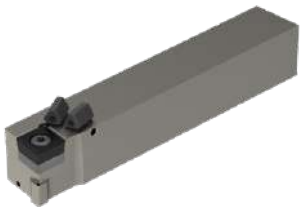
Scope of supply:

Tool holder with blind plug and Torx key

Direct Cooling



Illustrations show right-hand versions



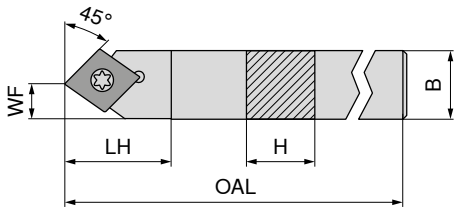
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	NEW Left-hand 70 766 ... #CU# *PA*	NEW Right-hand 70 766 ... #CU# *PA*
SCAC R/L 1212 M09 DC	12	12	150	21	12	M6	M6	3,2	CC.. 09T3	XX,YY **11201**	XX,YY **11200**
SCAC R/L 1212 F09 DC	12	12	80	22	12	M6	M6	3,2	CC.. 09T3	XX,YY **01201**	XX,YY **01200**
SCAC R/L 1616 H09 DC	16	16	100	30	16	M6	G1/8"	3,2	CC.. 09T3	XX,YY **01601**	XX,YY **01600**
SCAC R/L 2020 K12 DC	20	20	125	30	20	M6	G1/8"	5	CC.. 1204	XX,YY **02001**	XX,YY **02000**

Spare parts for Article no.	Clamping screw 70 950 ... #CU# *PA*	Carbide type C 70 950 ... #CU# *PA*	Grubscrew 70 950 ... #CU# *PA*	Grubscrew 70 950 ... #CU# *PA*	Threaded sleeve 70 950 ... #CU# *PA*
70 766 11200 / 70 766 11201	XX,YY **859**			XX,YY **86700**	
70 766 01200 / 70 766 01201	XX,YY **859**			XX,YY **86700**	
70 766 01600 / 70 766 01601	XX,YY **87900**	XX,YY **165**	XX,YY **88000**	XX,YY **86700**	XX,YY **171**
70 766 02000 / 70 766 02001	XX,YY **820**	XX,YY **166**	XX,YY **88000**	XX,YY **86700**	XX,YY **170**

Spare parts for Article no.	Sealing plugs DC 70 950 ... #CU# *PA*	Key D 80 950 ... #CU# *PA*	O-Ring 70 950 ... #CU# *PA*	Coolant nozzle DC 70 950 ... #CU# *PA*	Coolant screw plug 70 950 ... #CU# *PA*
70 766 11200 / 70 766 11201		XX,YY **120**			
70 766 01200 / 70 766 01201		XX,YY **120**			
70 766 01600 / 70 766 01601	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 766 02000 / 70 766 02001	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**

MaxiLock-S – SCDC 45° – Toolholder with screw clamping

Scope of supply:
Tool holder with Torx key



NEW
Left-hand

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	70 634 ... #CU# *PA*	
SCDC L 0808 K06	8	8	125	13	4	1,2	CC.. 0602	XX,YY	**00800**
SCDC L 1010 M06	10	10	150	13	5	1,2	CC.. 0602	XX,YY	**01000**
SCDC L 1212 M09	12	12	150	18	6	3,2	CC.. 09T3	XX,YY	**01200**
SCDC L 1414 M09	14	14	150	18	7	3,2	CC.. 09T3	XX,YY	**01400**


Key D

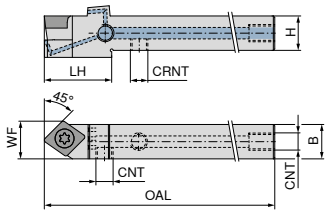

Clamping screw

Spare parts for Article no.		80 950 ... #CU# *PA*			70 950 ... #CU# *PA*	
70 634 00800	T08 - IP	XX,YY	**039**	M2,5x6 - IP	XX,YY	**857**
70 634 01000	T08 - IP	XX,YY	**039**	M2,5x6 - IP	XX,YY	**857**
70 634 01200	T15 - IP	XX,YY	**120**	M3,5x11	XX,YY	**87900**
70 634 01400	T15 - IP	XX,YY	**120**	M3,5x11	XX,YY	**87900**

MaxiLock-S – SCDC 45° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



NEW

Left-hand

70 767 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	#CU# *PA*	
SCDC L 0808 K06 DC	8	8	125	17	8.5	M5	M5	1,2	CC.. 0602	XX,YY	**00801**
SCDC L 1010 M06 DC	10	10	150	17	10.0	M6	M6	1,2	CC.. 0602	XX,YY	**01001**
SCDC L 1212 M09 DC	12	12	150	23	13.0	M6	M6	3,2	CC.. 09T3	XX,YY	**01201**
SCDC L 1414 M09 DC	14	14	150	25	14.0	M6	G1/8"	3,2	CC.. 09T3	XX,YY	**01401**

Coolant screw plug

Clamping screw

Grubscrew

	70 950 ...		**70 950 ...**		**70 950 ...**	
Spare parts for Article no.		**#CU# *PA***		**#CU# *PA***		**#CU# *PA***
70 767 00801			M2,5x6 - T08	XX,YY **13800**		
70 767 01001			M2,5x6 - T08	XX,YY **13800**	M6x6	XX,YY **86700**
70 767 01201			M3,5x11	XX,YY **113**	M6x6	XX,YY **86700**
70 767 01401	G 1/8"	XX,YY **294**	M3,5x11	XX,YY **113**	M6x6	XX,YY **86700**

Cylindrical screw

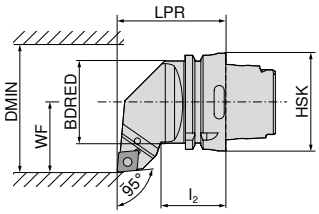
Key D

	83 950 ...		**80 950 ...**	
Spare parts for Article no.	**#CU# *PA***		**#CU# *PA***	
70 767 00801	M5x5 - SW2,5	XX,YY **157**	T08 - IP	XX,YY **039**
70 767 01001			T08 - IP	XX,YY **039**
70 767 01201			T15 - IP	XX,YY **120**
70 767 01401			T15 - IP	XX,YY **120**

9

MaxiLock-S – SCLC 95° – Toolholder with screw clamping

Scope of supply:
Tool holder with Torx key



Illustrations show right-hand versions

									Left-hand		Right-hand	
									74 541 ...		**74 540 ...**	
ISO designation	Adapter	LPR mm	l_2 mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	#CU# *PA*		#CU# *PA*	
HSK T63 SCLC R/L 12	HSK-T 63	70	42	53	45	100	5	CC.. 1204	XX,YY	**512**	XX,YY	**512**


Combination Key


Clamping screw

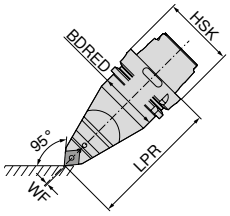

Carbide type C


Threaded sleeve

									70 950 ...		**70 950 ...**	
Spare parts for Article no.									#CU# *PA*		#CU# *PA*	
74 540 512 / 74 541 512		T15/SW	XX,YY	**398**	M4,5x12	XX,YY	**114**	XX,YY	**166**	M4,5	XX,YY	**170**

MaxiLock-S – SCMC 50° – Toolholder with screw clamping

Scope of supply:
Tool holder with Torx key



							Neutral	
							74 542 ...	
ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert	#CU# *PA*	
HSK T63 SCMC N 12	HSK-T 63	115	53	0	5	CC.. 1204	XX,YY	**512**


Combination Key


Clamping screw

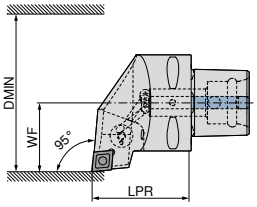

Carbide type C


Threaded sleeve

									70 950 ...		**70 950 ...**	
Spare parts for Article no.									#CU# *PA*		#CU# *PA*	
74 542 512		T15/SW	XX,YY	**398**	M4,5x12	XX,YY	**114**	XX,YY	**166**	M4,5	XX,YY	**170**

MaxiLock-S – SCLC 95° – Toolholder with screw clamping

Scope of supply:
without high-performance coolant set

Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Direct cooling compatible	Left-hand 84 655 ... #CU# *PA*		Right-hand 84 654 ... #CU# *PA*	
PSC40 SCLC R/L 50050-12	PSC 40	50	27	50	5	CC.. 1204	DC	XX,YY	**01295**	XX,YY	**01295**
PSC50 SCLC R/L 65060-12	PSC 50	60	35	65	5	CC.. 1204	DC	XX,YY	**01294**	XX,YY	**01294**
PSC63 SCLC R/L 80065-12	PSC 63	65	45	80	5	CC.. 1204	DC	XX,YY	**01293**	XX,YY	**01293**

The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page PL**.

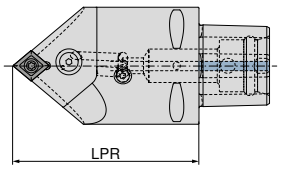

Clamping screw

Spare parts for Article no.	84 950 ... #CU# *PA*	
84 654 01295 / 84 655 01295	XX,YY	**27500**
84 654 01294 / 84 655 01294	XX,YY	**27500**
84 654 01293 / 84 655 01293	XX,YY	**27500**

9

MaxiLock-S – SCMC 50° – Toolholder with screw clamping

Scope of supply:
without high-performance coolant set

Neutral

ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Direct cooling compatible	84 674 ... #CU# *PA*	
PSC63 SCMC N 0100-12	PSC 63	100	5	CC.. 1204	DC	XX,YY	**01293**
PSC63 SCMC N 0130-12	PSC 63	130	5	CC.. 1204	DC	XX,YY	**11293**

The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page PL**.

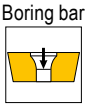

Clamping screw

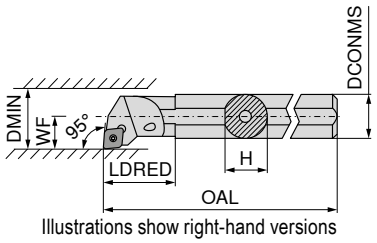
Spare parts for Article no.	84 950 ... #CU# *PA*	
84 674 01293	XX,YY	**27500**
84 674 11293	XX,YY	**27500**

MaxiLock-S – SCLC 95° – Boring bar with screw clamping

▲ A... = with thro' coolant
▲ S... = without thro' coolant

Scope of supply:
Boring bar with Torx key





Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 717 ... #CU# *PA*		Right-hand 70 716 ... #CU# *PA*	
S08H SCLC R/L 06	8	7.2	100	11.0	5	11	1,2	CC.. 0602	XX,YY	**008**	XX,YY	**008**
A08F SCLC R/L 06	8	7.6	80	17.0	5	11	1,2	CC.. 0602	XX,YY	**208**	XX,YY	**208**
S10K SCLC R/L 06	10	9.0	125	15.0	7	13	1,2	CC.. 0602	XX,YY	**010**	XX,YY	**010**
A10H SCLC R/L 06	10	9.5	100	19.0	7	13	1,2	CC.. 0602	XX,YY	**210**	XX,YY	**210**
S12Q SCLC R/L 06	12	11.0	180	18.8	9	16	1,2	CC.. 0602	XX,YY	**012**	XX,YY	**012**
A12K SCLC R/L 06	12	11.5	125	22.0	9	16	1,2	CC.. 0602	XX,YY	**212**	XX,YY	**212**
A16M SCLC R/L 06	16	14.0	150	50.0	9	18	1,2	CC.. 0602	XX,YY	**116**	XX,YY	**116**
S16R SCLC R/L 09	16	14.5	200	25.0	11	20	3,2	CC.. 09T3	XX,YY	**016**	XX,YY	**016**
A16M SCLC R/L 09	16	15.0	150	29.0	11	20	3,2	CC.. 09T3	XX,YY	**216**	XX,YY	**216**
S20S SCLC R/L 09	20	18.0	250	25.0	13	25	3,2	CC.. 09T3	XX,YY	**020**	XX,YY	**020**
A20Q SCLC R/L 09	20	18.5	180	32.0	13	25	3,2	CC.. 09T3	XX,YY	**220**	XX,YY	**220**
S25T SCLC R/L 09	25	23.0	300	20.0	17	32	3,2	CC.. 09T3	XX,YY	**025**	XX,YY	**025**
A25R SCLC R/L 09	25	23.0	200	36.0	17	32	3,2	CC.. 09T3	XX,YY	**225**	XX,YY	**225**
A32S SCLC R/L 12	32	30.0	250	50.0	22	40	5	CC.. 1204	XX,YY	**232**	XX,YY	**232**
A40T SCLC R/L 12	40	38.0	300	60.0	27	50	5	CC.. 1204	XX,YY	**240**	XX,YY	**240**


Key D


Combination Key


Clamping screw

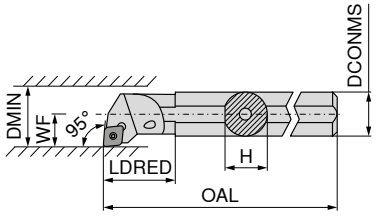

Carbide type C


Threaded sleeve

Spare parts for Article no.	80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 716 008 / 70 717 008	XX,YY	**110**			XX,YY	**116**				
70 716 208 / 70 717 208	XX,YY	**110**			XX,YY	**116**				
70 716 010 / 70 717 010	XX,YY	**110**			XX,YY	**116**				
70 716 210 / 70 717 210	XX,YY	**110**			XX,YY	**116**				
70 716 012 / 70 717 012	XX,YY	**110**			XX,YY	**116**				
70 716 212 / 70 717 212	XX,YY	**110**			XX,YY	**116**				
70 716 116 / 70 717 116	XX,YY	**110**			XX,YY	**116**				
70 716 016 / 70 717 016	XX,YY	**113**			XX,YY	**110**				
70 716 216 / 70 717 216	XX,YY	**113**			XX,YY	**110**				
70 716 020 / 70 717 020	XX,YY	**113**			XX,YY	**110**				
70 716 220 / 70 717 220	XX,YY	**113**			XX,YY	**304**				
70 716 025 / 70 717 025	XX,YY	**113**			XX,YY	**113**				
70 716 225 / 70 717 225	XX,YY	**113**			XX,YY	**304**				
70 716 232 / 70 717 232			XX,YY	**398**	XX,YY	**114**	XX,YY	**166**	XX,YY	**170**
70 716 240 / 70 717 240			XX,YY	**398**	XX,YY	**114**	XX,YY	**166**	XX,YY	**170**

MaxiLock-S – SCLC 95° – Boring bar with screw clamping

▲ with carbide core



Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 719 ... #CU# *PA*		Right-hand 70 718 ... #CU# *PA*	
E-A08F SCLC R/L 06	8	7.5	80	20.60	6	12	1,2	CC.. 0602	XX,YY	**208**	XX,YY	**208**
E-A10H SCLC R/L 06	10	9.0	100	31.75	7	14	1,2	CC.. 0602	XX,YY	**210**	XX,YY	**210**
E-A12K SCLC R/L 06	12	11.0	125	20.00	9	18	1,2	CC.. 0602	XX,YY	**212**	XX,YY	**212**
E-A16M SCLC R/L 09	16	15.0	150	45.30	11	22	3,2	CC.. 09T3	XX,YY	**216**	XX,YY	**216**
E-A20Q SCLC R/L 09	20	18.0	180	38.00	13	26	3,2	CC.. 09T3	XX,YY	**220**	XX,YY	**220**
E-A25R SCLC R/L 09	25	23.0	200	40.25	17	34	3,2	CC.. 09T3	XX,YY	**225**	XX,YY	**225**
E-A32S SCLC R/L 12	32	30.0	250	50.25	22	39	5	CC.. 1204	XX,YY	**232**	XX,YY	**232**

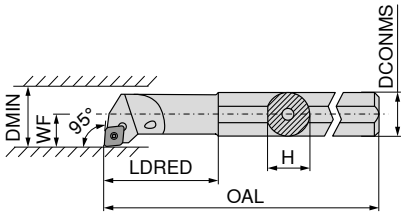
Key D

Clamping screw

Spare parts for Article no.		80 950 ... #CU# *PA*			70 950 ... #CU# *PA*	
70 718 208 / 70 719 208	T08	XX,YY	**110**	M2,5x5	XX,YY	**116**
70 718 210 / 70 719 210	T08	XX,YY	**110**	M2,5x5	XX,YY	**116**
70 718 212 / 70 719 212	T08	XX,YY	**110**	M2,5x5	XX,YY	**116**
70 718 216 / 70 719 216	T15	XX,YY	**113**	M4x9,5	XX,YY	**449**
70 718 220 / 70 719 220	T15	XX,YY	**113**	M4x9,5	XX,YY	**449**
70 718 225 / 70 719 225	T15	XX,YY	**113**	M4x9,5	XX,YY	**449**
70 718 232 / 70 719 232	T15	XX,YY	**113**	M4x11	XX,YY	**174**

MaxiLock-S – SCLC 95° – Boring bar with screw clamping

▲ with carbide core



Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 719 ... #CU# *PA*		Right-hand 70 718 ... #CU# *PA*	
E-A0608F SCLC R/L 06	8	7.5	100	25	4	8	1,2	CC.. 0602	XX,YY	**308**	XX,YY	**308**
E-A0810H SCLC R/L 06	10	9.0	110	32	6	12	1,2	CC.. 0602	XX,YY	**310**	XX,YY	**310**
E-A1012K SCLC R/L 06	12	11.0	125	38	7	14	1,2	CC.. 0602	XX,YY	**312**	XX,YY	**312**
E-A1216M SCLC R/L 06	16	15.0	150	50	9	18	1,2	CC.. 0602	XX,YY	**316**	XX,YY	**316**

Key D

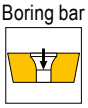
Clamping screw

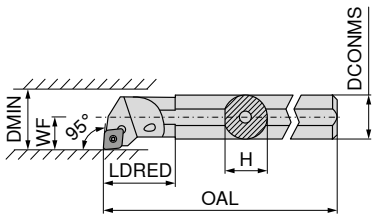
Spare parts for Article no.		80 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 718 308 / 70 719 308	T08	XX,YY	**110**	M2,5x5	XX,YY **116**
70 718 310 / 70 719 310	T08	XX,YY	**110**	M2,5x5	XX,YY **116**
70 718 312 / 70 719 312	T08	XX,YY	**110**	M2,5x5	XX,YY **116**
70 718 316 / 70 719 316	T08	XX,YY	**110**	M2,5x5	XX,YY **116**

MaxiLock-S – SCLC 95° – Boring bar with screw clamping

▲ Type: Solid carbide

Scope of supply:
Boring bar with Torx key





Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 719 ... #CU# *PA*		Right-hand 70 718 ... #CU# *PA*	
E08H SCLC R/L 06	8	7.6	100	20	6	11	1,2	CC.. 0602	XX,YY	**008**	XX,YY	**008**
E10K SCLC R/L 06	10	9.0	125	22	7	13	1,2	CC.. 0602	XX,YY	**010**	XX,YY	**010**
E12Q SCLC R/L 06	12	11.5	180	26	9	16	1,2	CC.. 0602	XX,YY	**012**	XX,YY	**012**
E16R SCLC R/L 09	16	15.0	200	34	11	20	3,2	CC.. 09T3	XX,YY	**016**	XX,YY	**016**
E20S SCLC R/L 09	20	18.5	250	38	13	25	3,2	CC.. 09T3	XX,YY	**020**	XX,YY	**020**
E25T SCLC R/L 09	25	23.0	300	43	17	32	3,2	CC.. 09T3	XX,YY	**025**	XX,YY	**025**

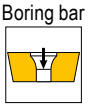
Key D

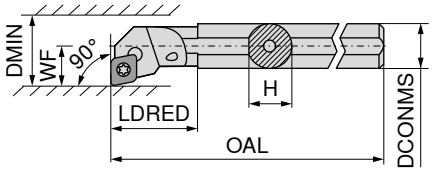
Clamping screw

Spare parts for Article no.		80 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 719 008 / 70 718 008	T08	XX,YY	**110**	M2,5x5	XX,YY **116**
70 719 010 / 70 718 010	T08	XX,YY	**110**	M2,5x5	XX,YY **116**
70 719 012 / 70 718 012	T08	XX,YY	**110**	M2,5x5	XX,YY **116**
70 719 016 / 70 718 016	T15	XX,YY	**113**	M3,5x7,2	XX,YY **110**
70 719 020 / 70 718 020	T15	XX,YY	**113**	M3,5x8,6	XX,YY **304**
70 719 025 / 70 718 025	T15	XX,YY	**113**	M3,5x11	XX,YY **113**

MaxiLock-S – SCFC 90° – Boring bar with screw clamping

Scope of supply:
Boring bar with Torx key





Illustrations show right-hand versions

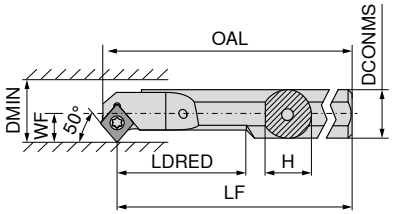
ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 793 ... #CU# *PA*		Right-hand 70 792 ... #CU# *PA*	
A08F SCFC R/L 06	8	7.6	80	17	5	11	1,2	CC.. 0602	XX,YY	**208**	XX,YY	**208**
A10H SCFC R/L 06	10	9.5	100	19	7	13	1,2	CC.. 0602	XX,YY	**210**	XX,YY	**210**
A12K SCFC R/L 06	12	11.5	125	22	9	16	1,2	CC.. 0602	XX,YY	**212**	XX,YY	**212**


Key D


Clamping screw

Spare parts for Article no.		80 950 ... #CU# *PA*			70 950 ... #CU# *PA*	
70 792 208 / 70 793 208	T08	XX,YY	**110**	M2,5x5	XX,YY	**116**
70 792 210 / 70 793 210	T08	XX,YY	**110**	M2,5x5	XX,YY	**116**
70 792 212 / 70 793 212	T08	XX,YY	**110**	M2,5x5	XX,YY	**116**

MaxiLock-S – SCMC 50° – Boring bar with screw clamping



Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	OAL mm	LF mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 723 ... #CU# *PA*		Right-hand 70 722 ... #CU# *PA*	
A08H SCMC R/L 06	8	7	104.15	100	20	5.5	10.5	1,2	CC.. 0602	XX,YY	**208**	XX,YY	**208**
A10H SCMC R/L 06	10	9	114.15	110	26	6.0	11.0	1,2	CC.. 0602	XX,YY	**210**	XX,YY	**210**
A12K SCMC R/L 06	12	11	129.15	125	32	7.0	13.0	1,2	CC.. 0602	XX,YY	**212**	XX,YY	**212**
A16M SCMC R/L 06	16	15	154.15	150	40	9.0	16.0	1,2	CC.. 0602	XX,YY	**216**	XX,YY	**216**

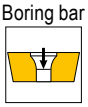

Key D

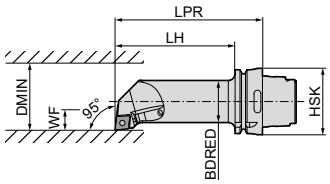

Clamping screw

Spare parts for Article no.		80 950 ... #CU# *PA*			70 950 ... #CU# *PA*	
70 723 208 / 70 722 208	T08	XX,YY	**110**	M2,5x5	XX,YY	**116**
70 723 210 / 70 722 210	T08	XX,YY	**110**	M2,5x5	XX,YY	**116**
70 723 212 / 70 722 212	T08	XX,YY	**110**	M2,5x5	XX,YY	**116**
70 723 216 / 70 722 216	T08	XX,YY	**110**	M2,5x5	XX,YY	**116**

MaxiLock-S – SCLC 95° – Boring bar with screw clamping

Scope of supply:
Boring bar with Torx key





Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 564 ... #CU# *PA*		Right-hand 74 563 ... #CU# *PA*	
HSK T63 40L SCLC R/L 12	HSK-T 63	140	114	40	27	50	5	CC.. 1204	XX,YY	**512**	XX,YY	**512**

Combination Key

Clamping screw

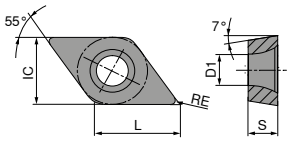
Carbide type C

Threaded sleeve

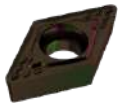
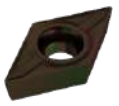
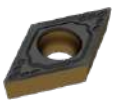
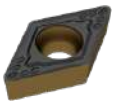
Spare parts for Article no.		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
74 563 512 / 74 564 512	T15/SW	XX,YY	**398**	M4,5x12	XX,YY	**114**	XX,YY	**166**	M4,5	XX,YY	**170**

DCGT / DCMT / DCET

Designation	L mm	S mm	D1 mm	IC mm
DC.T 0702..	7.75	2.38	2.8	6.35
DC.T 11T3..	11.60	3.97	4.4	9.52

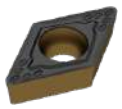
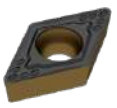
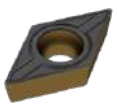
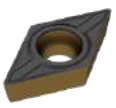
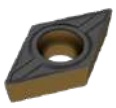
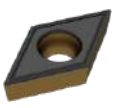
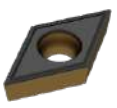


DCGT / DCMT

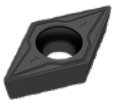
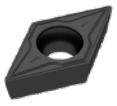
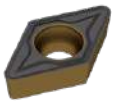
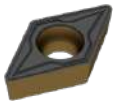
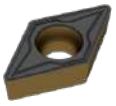
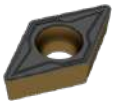
		-CF05 CTEP110	-CF55 CTEP110	-SF TCM407	-SF TCM10	-SMF TCM10	NEW -SF CTCP125-P	NEW -SF CTCP115-P
		DRAGONSKIN	DRAGONSKIN				DRAGONSKIN	DRAGONSKIN
								
		F	F	F	F	F	F	F
		CERMET DCGT	CERMET DCMT	CERMET DCGT	CERMET DCGT	CERMET DCMT	DCGT	DCMT
		76 245 ...	76 246 ...	70 257 ...	70 257 ...	70 265 ...	76 257 ...	76 259 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
070201EN	0.1				XX,YY 898			
070202EN	0.2	XX,YY 002	XX,YY 002		XX,YY 900	XX,YY 898	XX,YY 50201	
070204EN	0.4	XX,YY 004	XX,YY 004	XX,YY 852	XX,YY 902	XX,YY 900		XX,YY 30401
11T302EN	0.2	XX,YY 014		XX,YY 854	XX,YY 904			
11T304EN	0.4	XX,YY 016	XX,YY 016	XX,YY 856	XX,YY 906	XX,YY 904		XX,YY 31601
11T308EN	0.8	XX,YY 018	XX,YY 018	XX,YY 858	XX,YY 908	XX,YY 906		XX,YY 31801
P		●	●	●	●	●	●	●
M		○	○	○	○	○		
K		○	○	○	○	○	○	○
N								
S								
H								
O								

9

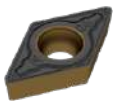
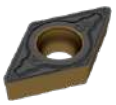
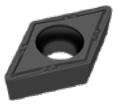
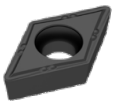
DCMT / DCGT

		NEW	NEW	NEW	NEW	NEW	NEW	NEW
		-SF CTCP125-P	-SF CTCP135-P	-SMF CTCP115-P	-SMF CTCP125-P	-SMF CTCP135-P	-SM CTCP125-P	-SM CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		F	F	F	F	F	M	M
		DCMT	DCMT	DCMT	DCMT	DCMT	DCGT	DCGT
		76 259 ...	76 259 ...	76 265 ...	76 265 ...	76 265 ...	76 256 ...	76 256 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
070202EN	0.2						XX,YY 50201	XX,YY 70201
070204EN	0.4	XX,YY 50401	XX,YY 70401		XX,YY 50401	XX,YY 70401		
070208EN	0.8					XX,YY 70601		
11T304EN	0.4	XX,YY 51601	XX,YY 71601	XX,YY 31601	XX,YY 51601	XX,YY 71601		
11T308EN	0.8	XX,YY 51801	XX,YY 71801	XX,YY 31801	XX,YY 51801	XX,YY 71801		
P		●	●	●	●	●	●	●
M			○			○		○
K		○		○	○		○	
N								
S								
H								
O								

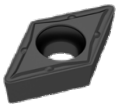
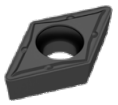
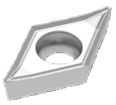
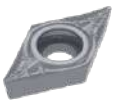
DCMT

				NEW	NEW	NEW	NEW
		-SM CTCK110	-SM CTCK120	-SM CTCP115-P	-SM CTCP115-P	-SM CTCP125-P	-SM CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
		M	M	M	M	M	M
		DCMT	DCMT	DCMT	DCMT	DCMT	DCMT
		70 258 ...	70 258 ...	76 183 ...	76 258 ...	76 258 ...	76 258 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
070204EN	0.4	XX,YY 004	XX,YY 554		XX,YY 30401	XX,YY 50401	XX,YY 70401
070208EN	0.8	XX,YY 006	XX,YY 506		XX,YY 30601	XX,YY 50601	XX,YY 70601
11T304EN	0.4	XX,YY 016	XX,YY 516		XX,YY 31601	XX,YY 51601	XX,YY 71601
11T308EN	0.8	XX,YY 018	XX,YY 518		XX,YY 31801	XX,YY 51801	XX,YY 71801
11T312EN	1.2			XX,YY 32001		XX,YY 52001	
P		○	○	●	●	●	●
M							○
K		●	●	○	○	○	
N							
S							
H							
O							

DCMT

		NEW	NEW			
		-SMQ CTCP115-P	-SMQ CTCP125-P	-M25 CTCM120	-M25 CTPM125	-M25 CTCM130
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
		M DCMT	M DCMT	F DCMT	F DCMT	F DCMT
		76 195 ...	76 195 ...	75 213 ...	75 213 ...	75 213 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
070202EN	0.2			XX,YY 10200	XX,YY 202	XX,YY 30200
070204EN	0.4	XX,YY 30401	XX,YY 50401	XX,YY 10400	XX,YY 204	XX,YY 30400
11T302EN	0.2			XX,YY 11400	XX,YY 214	XX,YY 31400
11T304EL	0.4	XX,YY 31601	XX,YY 51601			
11T304EN	0.4	XX,YY 31501	XX,YY 51501	XX,YY 11600	XX,YY 216	XX,YY 31600
11T304ER	0.4	XX,YY 31701	XX,YY 51701			
11T308EN	0.8	XX,YY 31801	XX,YY 51801	XX,YY 11800	XX,YY 218	XX,YY 31800
P		●	●	○	○	○
M				●	●	●
K		○	○			
N						
S						○
H						
O						

DCMT / DCGT

		-M55 CTCM120	-M55 CTPM125	-M55 CTCM130	-23P H216T	-25P H210T	-25P CTPX710	-25Q H210T
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN			DRAGONSKIN	
								
		M DCMT	M DCMT	M DCMT	F DCGT	F DCGT	M DCGT	M DCGT
		75 214 ...	75 214 ...	75 214 ...	70 261 ...	70 263 ...	70 263 ...	70 263 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
070202FN	0.2					XX,YY 632	XX,YY 70200	
070204EN	0.4	XX,YY 10400	XX,YY 204	XX,YY 30400				
070204FN	0.4				XX,YY 654	XX,YY 634	XX,YY 70400	
070208EN	0.8	XX,YY 10600	XX,YY 206	XX,YY 30600				
11T302FN	0.2					XX,YY 635	XX,YY 71400	
11T304EN	0.4	XX,YY 11600	XX,YY 216	XX,YY 31600				
11T304FL	0.4							XX,YY 670
11T304FN	0.4				XX,YY 664	XX,YY 636	XX,YY 71600	XX,YY 660
11T304FR	0.4							XX,YY 680
11T308EN	0.8	XX,YY 11800	XX,YY 218	XX,YY 31800				
11T308FL	0.8							XX,YY 672
11T308FN	0.8				XX,YY 666	XX,YY 638	XX,YY 71800	XX,YY 662
11T308FR	0.8							XX,YY 682
P		○	○	○			●	
M		●	●	●			●	
K					○	○		○
N					●	●	●	●
S				○		○	●	○
H								
O					○	○		○

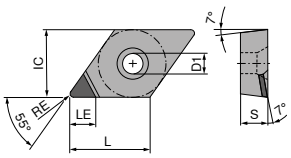
9

DCGT / DCET / DCMT

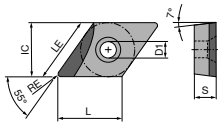
		-25P H210T	-27 H10T	-27 CTPX715 DRAGONSKIN	-F05 CTPX710 DRAGONSKIN	-29 H216T	NEW -29 CTPX715 DRAGONSKIN
							
		F	M	M	F	M	M
		DCGT	DCGT	DCGT	DCET	DCMT	DCMT
		70 263 ...	70 260 ...	70 260 ...	76 254 ...	70 246 ...	70 246 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
0702005FN	0.05				XX,YY 10200		
070201FN	0.10				XX,YY 10400		
0702015FN	0.15				XX,YY 10600		
070202FN	0.20	XX,YY 632	XX,YY 600	XX,YY 80200	XX,YY 10800		
070204FN	0.40	XX,YY 634	XX,YY 602	XX,YY 80400			
070204EN	0.40					XX,YY 60400	XX,YY 70400
11T3005FN	0.05				XX,YY 11400		
11T301FN	0.10				XX,YY 11600		
11T3015FN	0.15				XX,YY 11800		
11T302FN	0.20	XX,YY 635	XX,YY 604	XX,YY 81400	XX,YY 12000		
11T304FN	0.40	XX,YY 636	XX,YY 606	XX,YY 81600	XX,YY 12200		
11T304EN	0.40					XX,YY 61600	XX,YY 71600
11T308FN	0.80	XX,YY 638	XX,YY 608	XX,YY 81800			
11T308EN	0.80					XX,YY 61800	XX,YY 71800
P				●	●		●
M				●	●		●
K		○	○	○		○	○
N		●	●	●	●	●	●
S		○		●	●		●
H							
O		○	○	○		○	○

DCGW / DCGT

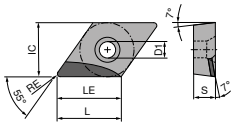
Designation	L mm	S mm	D1 mm	IC mm
DCG. 0702..	7.75	2.38	2.8	6.35
DCG. 11T3..	11.60	3.97	4.4	9.52



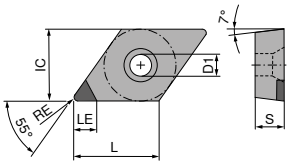
DCGT A



DCGT A L



DCGT A R



DCGW A

DCGW / DCGT

▲ TCE(NOI) = Design and number of equipped cutting edge corners

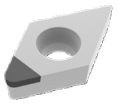
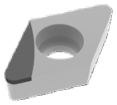
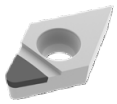
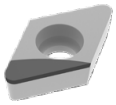
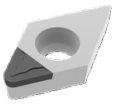
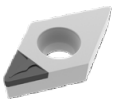
	CTDMD05	CTDMD05	-Q CTDMD05	-Q CTDMD05	CTDPD20	CTDPD20
	F DIAMOND DCGW	F DIAMOND DCGT	F DIAMOND DCGW	F DIAMOND DCGT	F DIAMOND DCGW	F DIAMOND DCGT
	71 130 ...	71 134 ...	71 178 ...	71 176 ...	71 130 ...	71 134 ...
ISO	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
070202FN	XX,YY 00200	XX,YY 050			XX,YY 100	XX,YY 100
070204FN	XX,YY 00400	XX,YY 052		XX,YY 50001	XX,YY 102	XX,YY 102
070204FR						
070204FN					XX,YY 104	XX,YY 104
070208FN	XX,YY 00600	XX,YY 054				
070208FN					XX,YY 106	XX,YY 106
11T302FN		XX,YY 056			XX,YY 108	XX,YY 108
11T302FN	XX,YY 056		XX,YY 50001		XX,YY 110	XX,YY 110
11T302FN						XX,YY 11200
11T304FN		XX,YY 058			XX,YY 11200	
11T304FL						
11T304FN	XX,YY 058					
11T308FN		XX,YY 060				
11T304FN						
11T308FN						
11T312FN						
11T312FN						

P						
M						
K						
N	●	●	●	●	●	●
S						
H						
O	●	●	●	●	●	●

9

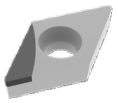
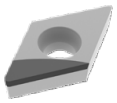
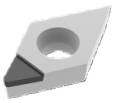
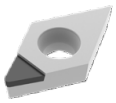
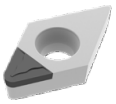
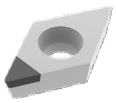
DCGW / DCGT

▲ TCE(NOI) = Design and number of equipped cutting edge corners

				CTDPS30	CTDPS30	CTDPS30	CTDPS30	-CB1 CTDPU20	-CB2 CTDPU20
									
				F	F	F	F	F	M
				DIAMOND DCGW	DIAMOND DCGT	DIAMOND DCGT	DIAMOND DCGT	DIAMOND DCGT	DIAMOND DCGT
				71 177 ...	71 173 ...	71 173 ...	71 173 ...	71 174 ...	71 175 ...
ISO	RE mm	TCE (NOI)	LE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
070201FN	0.1	A (1)	3.8	XX,YY 20001		XX,YY 20001			
070202FN	0.2	A (1)	3.7	XX,YY 20101		XX,YY 20101		XX,YY 30001	
070204FN	0.4	A (1)	3.4	XX,YY 20201				XX,YY 30101	XX,YY 30001
070204FL	0.4	A (1)	5.5		XX,YY 20201				
070208FN	0.8	A (1)	3.0	XX,YY 20301					
11T301FN	0.1	A (1)	4.8	XX,YY 20401		XX,YY 20301			
11T302FN	0.2	A (1)	4.7	XX,YY 20501		XX,YY 20401			
11T304FN	0.4	A (1)	4.3	XX,YY 20601				XX,YY 30201	XX,YY 30101
11T304FL	0.4	A (1)	7.5		XX,YY 20501				
11T308FN	0.8	A (1)	4.0	XX,YY 20701				XX,YY 30301	
11T308FL	0.8	A (1)	7.0		XX,YY 20601				
11T308FR	0.8	A (1)	7.0				XX,YY 20701		
11T312FN	1.2	A (1)	3.6	XX,YY 20801					
11T312FL	1.2	A (1)	6.5		XX,YY 20801				
11T312FR	1.2	A (1)	6.5				XX,YY 20901		
P									
M									
K									
N				●	●	●	●	●	●
S									
H									
O				●	●	●	●	●	●

DCGT / DCGW

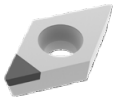
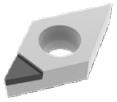
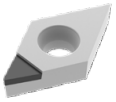
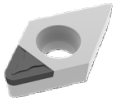
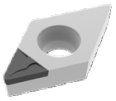
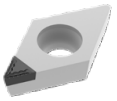
▲ TCE(NOI) = Design and number of equipped cutting edge corners

				CTDPD20		CTDPD20		-Q CTDPD20		-Q CTDPD20		-CB1 CTDPD20		-Q CTDPS30	
															
				F		F		F		F		F		F	
				DIAMOND DCGT		DIAMOND DCGT		DIAMOND DCGT		DIAMOND DCGT		DIAMOND DCGT		DIAMOND DCGW	
				71 136 ...		71 135 ...		71 144 ...		71 145 ...		71 310 ...		71 138 ...	
ISO	RE mm	TCE (NOI)	LE mm	#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
070201FN	0.1	A (1)	3.8									XX,YY	10100		
070202FN	0.2	A (1)	3.7									XX,YY	102		
070204FL	0.4	A (1)	3.0							XX,YY	104				
070204FR	0.4	A (1)	3.0					XX,YY	104						
070204FN	0.4	A (1)	3.4									XX,YY	104		
070204FRR	0.4	A (1)	5.5			XX,YY	102								
070204FLL	0.4	A (1)	5.5	XX,YY	102										
070208FN	0.8	A (1)	3.0									XX,YY	108		
070208FRR	0.8	A (1)	5.0			XX,YY	104								
070208FLL	0.8	A (1)	5.0	XX,YY	104										
11T301FN	0.1	A (1)	4.8									XX,YY	11100		
11T302FR	0.2	A (1)	4.0											XX,YY	162
11T302FN	0.2	A (1)	4.7									XX,YY	112		
11T304FL	0.4	A (1)	4.0							XX,YY	114				
11T304FR	0.4	A (1)	4.0					XX,YY	114					XX,YY	164
11T304FN	0.4	A (1)	4.3									XX,YY	114		
11T304FRR	0.4	A (1)	7.5			XX,YY	108								
11T304FLL	0.4	A (1)	7.5	XX,YY	108										
11T308FN	0.8	A (1)	4.0									XX,YY	118		
11T308FRR	0.8	A (1)	7.0			XX,YY	110								
11T308FLL	0.8	A (1)	7.0	XX,YY	110										
P															
M															
K															
N					●		●		●		●		●		●
S															
H															
O					●		●		●		●		●		●

9

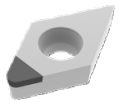
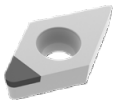
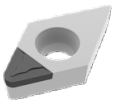
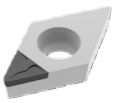
DCGW / DCGT

▲ TCE(NOI) = Design and number of equipped cutting edge corners

				-Q CTDPS30		-Q CTDPS30		-Q CTDPS30		-CB1 CTDPS30		-CB2 CTDPS30		-CB3 CTDPU20	
															
				F DIAMOND DCGW		F DIAMOND DCGT		F DIAMOND DCGT		F DIAMOND DCGT		M DIAMOND DCGT		R DIAMOND DCGT	
				71 139 ...		71 144 ...		71 145 ...		71 310 ...		71 311 ...		71 312 ...	
ISO	RE mm	TCE (NOI)	LE mm	#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
070201FL	0.1	A (1)	3.0					XX,YY	151						
070201FR	0.1	A (1)	3.0			XX,YY	15000								
070201FN	0.1	A (1)	3.8							XX,YY	20100				
070202FL	0.2	A (1)	3.0					XX,YY	152						
070202FR	0.2	A (1)	3.0			XX,YY	152								
070202FN	0.2	A (1)	3.7							XX,YY	202	XX,YY	202		
070204FN	0.4	A (1)	3.4							XX,YY	204	XX,YY	204	XX,YY	204
070208FN	0.8	A (1)	3.0									XX,YY	208		
11T301FR	0.1	A (1)	4.0			XX,YY	161								
11T301FL	0.1	A (1)	4.0					XX,YY	161						
11T301FN	0.1	A (1)	4.8							XX,YY	21100	XX,YY	21100		
11T302FL	0.2	A (1)	4.0					XX,YY	162						
11T302FR	0.2	A (1)	4.0			XX,YY	162								
11T302FN	0.2	A (1)	4.7							XX,YY	212	XX,YY	212		
11T304FL	0.4	A (1)	4.0	XX,YY	164										
11T304FN	0.4	A (1)	4.3							XX,YY	214	XX,YY	214	XX,YY	214
11T308FN	0.8	A (1)	4.0							XX,YY	218	XX,YY	218	XX,YY	218
P															
M															
K															
N					●		●		●		●		●		●
S															
H															
O					●		●		●		●		●		●

DCGW / DCGT

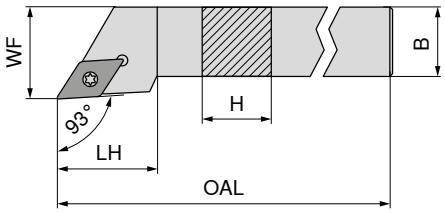
▲ TCE(NOI) = Design and number of equipped cutting edge corners

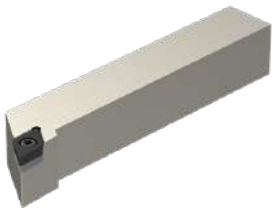
				CTDPU20		CTDCD10		-CB1 CTDCD10		-CB2 CTDCD10	
											
				F		F		F		M	
				DIAMOND DCGW		DIAMOND DCGW		DIAMOND DCGT		DIAMOND DCGT	
				71 177 ...		71 177 ...		71 310 ...		71 311 ...	
ISO	RE mm	TCE (NOI)	LE mm	#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
070202FN	0.2	A (1)	2.6			XX,YY	40001	XX,YY	302	XX,YY	30200
070204FN	0.4	A (1)	2.3			XX,YY	40101	XX,YY	304	XX,YY	304
070204FN	0.4	A (1)	3.4	XX,YY	30001						
070208FN	0.8	A (1)	2.0			XX,YY	40201			XX,YY	308
070208FN	0.8	A (1)	3.0	XX,YY	30101						
11T302FN	0.2	A (1)	2.6			XX,YY	40301	XX,YY	31200	XX,YY	31200
11T304FN	0.4	A (1)	2.3			XX,YY	40401	XX,YY	314	XX,YY	314
11T304FN	0.4	A (1)	4.3	XX,YY	30201						
11T308FN	0.8	A (1)	2.0			XX,YY	40501	XX,YY	318	XX,YY	318
11T308FN	0.8	A (1)	4.0	XX,YY	30301						
P											
M											
K											
N					●		●		●		●
S											
H											
O					●		●		●		●

9

MaxiLock-S – SDJC 93° – Toolholder with screw clamping

Scope of supply:
Tool holder with Torx key





Illustrations show right-hand versions

								NEW Left-hand		NEW Right-hand	
								70 643 ...		**70 643 ...**	
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	#CU# *PA*		#CU# *PA*	
SDJC R/L 0808 D07	8	8	60	13.0	10	1,2	DC.. 0702	XX,YY	**00800**	XX,YY	**00801**
SDJC R/L 1010 E07	10	10	70	13.0	12	1,2	DC.. 0702	XX,YY	**01000**	XX,YY	**01001**
SDJC R/L 1212 F07	12	12	80	14.3	16	1,2	DC.. 0702	XX,YY	**01200**	XX,YY	**01201**
SDJC R/L 1616 H11	16	16	100	19.3	20	3,2	DC.. 11T3	XX,YY	**01600**	XX,YY	**01601**
SDJC R/L 2020 K11	20	20	125	19.9	25	3,2	DC.. 11T3	XX,YY	**02000**	XX,YY	**02001**
SDJC R/L 2525 M11	25	25	150	21.2	32	3,2	DC.. 11T3	XX,YY	**02500**	XX,YY	**02501**
SDJC R/L 3225 P11	32	25	170	21.2	32	3,2	DC.. 11T3	XX,YY	**03200**	XX,YY	**03201**


Key D


Clamping screw


Solid Carbide Seat D

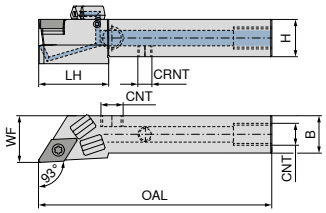

Threaded sleeve

			80 950 ...				**70 950 ...**			**70 950 ...**			**70 950 ...**
Spare parts for Article no.		#CU# *PA*				#CU# *PA*			#CU# *PA*			#CU# *PA*	
70 643 00800 / 70 643 00801	T08 - IP	XX,YY	**039**	M2,5x6 - IP	XX,YY	**857**							
70 643 01000 / 70 643 01001	T08 - IP	XX,YY	**039**	M2,5x6 - IP	XX,YY	**857**							
70 643 01200 / 70 643 01201	T08 - IP	XX,YY	**039**	M2,5x6 - IP	XX,YY	**857**							
70 643 01600 / 70 643 01601	T15 - IP	XX,YY	**120**	M3,5x11	XX,YY	**87900**	XX,YY	**106**	M3,5	XX,YY	**171**		
70 643 02000 / 70 643 02001	T15 - IP	XX,YY	**120**	M3,5x11	XX,YY	**87900**	XX,YY	**106**	M3,5	XX,YY	**171**		
70 643 02500 / 70 643 02501	T15 - IP	XX,YY	**120**	M3,5x11	XX,YY	**87900**	XX,YY	**106**	M3,5	XX,YY	**171**		
70 643 03200 / 70 643 03201	T15 - IP	XX,YY	**120**	M3,5x11	XX,YY	**87900**	XX,YY	**106**	M3,5	XX,YY	**171**		

MaxiLock-S – SDJC 93° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	NEW Left-hand 70 773 ... #CU# *PA*	NEW Right-hand 70 773 ... #CU# *PA*
SDJC R/L 1010 E07 DC	10	10	70	20	12	M6	M6	1,2	DC.. 0702	XX,YY **01001**	XX,YY **01000**
SDJC R/L 1212 F07 DC	12	12	80	21	16	M6	M6	1,2	DC.. 0702	XX,YY **01201**	XX,YY **01200**
SDJC R/L 1616 H11 DC	16	16	100	30	20	M6	G1/8"	3,2	DC.. 11T3	XX,YY **01601**	XX,YY **01600**
SDJC R/L 2020 K11 DC	20	20	125	30	25	M6	G1/8"	3,2	DC.. 11T3	XX,YY **02001**	XX,YY **02000**
SDJC R/L 2525 M11 DC	25	25	150	35	32	M6	G1/8"	3,2	DC.. 11T3	XX,YY **02501**	XX,YY **02500**

Clamping screw

Solid Carbide Seat D

Grubscrew

Grubscrew

Threaded sleeve

Spare parts for Article no.	70 950 ... #CU# *PA*	70 950 ... #CU# *PA*	70 950 ... #CU# *PA*	70 950 ... #CU# *PA*	70 950 ... #CU# *PA*
70 773 01000 / 70 773 01001	XX,YY **857**			XX,YY **86700**	
70 773 01200 / 70 773 01201	XX,YY **857**			XX,YY **86700**	
70 773 01600 / 70 773 01601	XX,YY **87900**	XX,YY **106**	XX,YY **88000**	XX,YY **86700**	XX,YY **171**
70 773 02000 / 70 773 02001	XX,YY **87900**	XX,YY **106**	XX,YY **88000**	XX,YY **86700**	XX,YY **171**
70 773 02500 / 70 773 02501	XX,YY **87900**	XX,YY **106**	XX,YY **88000**	XX,YY **86700**	XX,YY **171**

Sealing plugs DC

Key D

O-Ring

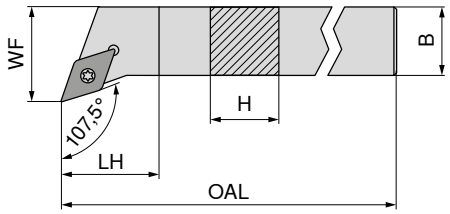
Coolant nozzle DC

Coolant screw plug

Spare parts for Article no.	70 950 ... #CU# *PA*	80 950 ... #CU# *PA*	70 950 ... #CU# *PA*	70 950 ... #CU# *PA*	70 950 ... #CU# *PA*
70 773 01000 / 70 773 01001		XX,YY **039**			
70 773 01200 / 70 773 01201		XX,YY **039**			
70 773 01600 / 70 773 01601	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 773 02000 / 70 773 02001	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 773 02500 / 70 773 02501	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**

MaxiLock-S – SDHC 107.5° – Toolholder with screw clamping

Scope of supply:
Tool holder with Torx key



Illustrations show right-hand versions

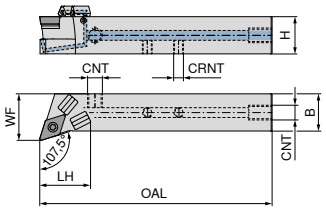
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	NEW Left-hand 70 642 ... #CU# *PA*	NEW Right-hand 70 642 ... #CU# *PA*
SDHC R/L 1010 E07	10	10	70	7.6	12	1,2	DC.. 0702	XX,YY **01000**	XX,YY **01001**
SDHC R/L 1212 F07	12	12	80	12.2	16	1,2	DC.. 0702	XX,YY **01200**	XX,YY **01201**
SDHC R/L 1616 H11	16	16	100	11.6	20	3,2	DC.. 11T3	XX,YY **01600**	XX,YY **01601**
SDHC R/L 2020 K11	20	20	125	14.1	25	3,2	DC.. 11T3	XX,YY **02000**	XX,YY **02001**
SDHC R/L 2525 M11	25	25	150	20.5	32	3,2	DC.. 11T3	XX,YY **02500**	XX,YY **02501**

Spare parts for Article no.	 Key D 80 950 ... #CU# *PA*	 Clamping screw 70 950 ... #CU# *PA*	 Solid Carbide Seat D 70 950 ... #CU# *PA*	 Threaded sleeve 70 950 ... #CU# *PA*
70 642 01000 / 70 642 01001	XX,YY **039**	XX,YY **857**		
70 642 01200 / 70 642 01201	XX,YY **039**	XX,YY **857**		
70 642 01600 / 70 642 01601	XX,YY **120**	XX,YY **87900**	XX,YY **106**	XX,YY **171**
70 642 02000 / 70 642 02001	XX,YY **120**	XX,YY **87900**	XX,YY **106**	XX,YY **171**
70 642 02500 / 70 642 02501	XX,YY **120**	XX,YY **87900**	XX,YY **106**	XX,YY **171**

MaxiLock-S – SDHC 107.5° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	NEW Left-hand 70 772 ... #CU# *PA*	NEW Right-hand 70 772 ... #CU# *PA*
SDHC R/L 1212 F07 DC	12	12	80	20	16	M6	M6	1,2	DC.. 0702	XX,YY **01201**	XX,YY **01200**
SDHC R/L 1616 H11 DC	16	16	100	25	20	M6	G1/8"	3,2	DC.. 11T3	XX,YY **01601**	XX,YY **01600**
SDHC R/L 2020 K11 DC	20	20	125	28	25	M6	G1/8"	3,2	DC.. 11T3	XX,YY **02001**	XX,YY **02000**
SDHC R/L 2525 M11 DC	25	25	150	27	32	M6	G1/8"	3,2	DC.. 11T3	XX,YY **02501**	XX,YY **02500**

Spare parts for Article no.	 Clamping screw 70 950 ... #CU# *PA*	 Solid Carbide Seat D 70 950 ... #CU# *PA*	 Grubscrew 70 950 ... #CU# *PA*	 Grubscrew 70 950 ... #CU# *PA*	 Threaded sleeve 70 950 ... #CU# *PA*
70 772 01201 / 70 772 01200	XX,YY **857**			XX,YY **86700**	
70 772 01601 / 70 772 01600	XX,YY **87900**	XX,YY **106**	XX,YY **88000**	XX,YY **86700**	XX,YY **171**
70 772 02001 / 70 772 02000	XX,YY **87900**	XX,YY **106**	XX,YY **88000**	XX,YY **86700**	XX,YY **171**
70 772 02501 / 70 772 02500	XX,YY **87900**	XX,YY **106**	XX,YY **88000**	XX,YY **86700**	XX,YY **171**

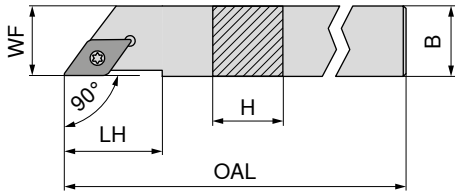
Spare parts for Article no.	 Sealing plugs DC 70 950 ... #CU# *PA*	 Key D 80 950 ... #CU# *PA*	 O-Ring 70 950 ... #CU# *PA*	 Coolant nozzle DC 70 950 ... #CU# *PA*	 Coolant screw plug 70 950 ... #CU# *PA*
70 772 01201 / 70 772 01200		XX,YY **039**			
70 772 01601 / 70 772 01600	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 772 02001 / 70 772 02000	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 772 02501 / 70 772 02500	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**

MaxiLock-S – SDAC 90° – Toolholder with screw clamping

▲ for sliding head lathes

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	NEW Left-hand 70 639 ... #CU# *PA*	NEW Right-hand 70 639 ... #CU# *PA*
SDAC R/L 0808 K07	8	8	125	14	8	1,2	DC.. 0702	XX,YY **00800**	XX,YY **00801**
SDAC R/L 1010 M07	10	10	150	14	10	1,2	DC.. 0702	XX,YY **01000**	XX,YY **01001**
SDAC R/L 1212 M07	12	12	150	14	12	1,2	DC.. 0702	XX,YY **01200**	XX,YY **01201**
SDAC R/L 1212 M11	12	12	150	21	12	3,2	DC.. 11T3	XX,YY **11200**	XX,YY **11201**
SDAC R/L 1414 M11	14	14	150	21	14	3,2	DC.. 11T3	XX,YY **01400**	XX,YY **01401**

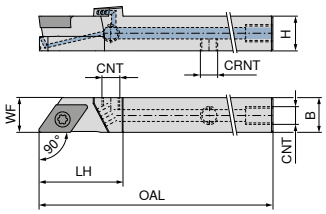
Spare parts for Article no.	Key D 80 950 ... #CU# *PA*	Clamping screw 70 950 ... #CU# *PA*
70 639 00800 / 70 639 00801	T08 - IP XX,YY **039**	M2,5x6 - IP XX,YY **857**
70 639 01000 / 70 639 01001	T08 - IP XX,YY **039**	M2,5x6 - IP XX,YY **857**
70 639 01200 / 70 639 01201	T08 - IP XX,YY **039**	M2,5x6 - IP XX,YY **857**
70 639 11200 / 70 639 11201	T15 - IP XX,YY **120**	M3,5x11 XX,YY **87900**
70 639 01400 / 70 639 01401	T15 - IP XX,YY **120**	M3,5x11 XX,YY **87900**

MaxiLock-S – SDAC 90° DC – Tool holder with screw clamping

▲ for sliding head lathes

Scope of supply:

Tool holder with blind plug and Torx key



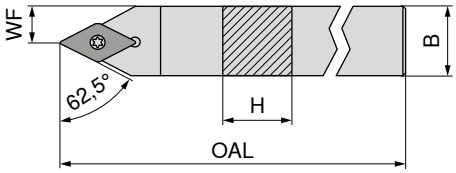
Illustrations show right-hand versions

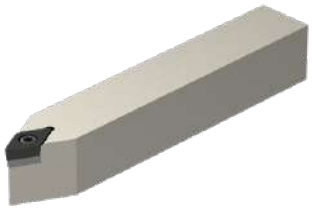
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	NEW Left-hand 70 771 ... #CU# *PA*	NEW Right-hand 70 771 ... #CU# *PA*
SDAC R/L 0808 K07 DC	8	8	125	21	8	M5	M5	1,2	DC.. 0702	XX,YY **00801**	XX,YY **00800**
SDAC R/L 1010 M07 DC	10	10	150	21	10	M6	M6	1,2	DC.. 0702	XX,YY **01001**	XX,YY **01000**
SDAC R/L 1212 M07 DC	12	12	150	21	12	M6	M6	1,2	DC.. 0702	XX,YY **01201**	XX,YY **01200**
SDAC R/L 1212 M11 DC	12	12	150	29	12	M6	M6	3,2	DC.. 11T3	XX,YY **11201**	XX,YY **11200**

Spare parts for Article no.	Cylindrical screw 83 950 ... #CU# *PA*	Key D 80 950 ... #CU# *PA*	Clamping screw 70 950 ... #CU# *PA*	Grubscrew 70 950 ... #CU# *PA*
70 771 00800 / 70 771 00801	XX,YY **157**	XX,YY **039**	XX,YY **13800**	
70 771 01000 / 70 771 01001		XX,YY **039**	XX,YY **13800**	XX,YY **86700**
70 771 01200 / 70 771 01201		XX,YY **039**	XX,YY **13800**	XX,YY **86700**
70 771 11200 / 70 771 11201		XX,YY **120**	XX,YY **113**	XX,YY **86700**

MaxiLock-S – SDNC 62.5° – Toolholder with screw clamping

Scope of supply:
Tool holder with Torx key





NEW
Neutral

ISO designation	H mm	B mm	OAL mm	WF mm	torque moment Nm	Insert	70 645 ... #CU# *PA*	
SDNC N 0808 K07	8	8	125	4.0	1,2	DC.. 0702	XX,YY	**00800**
SDNC N 1010 M07	10	10	150	5.0	1,2	DC.. 0702	XX,YY	**11000**
SDNC N 1010 E07	10	10	70	5.0	1,2	DC.. 0702	XX,YY	**01000**
SDNC N 1212 F07	12	12	80	6.0	1,2	DC.. 0702	XX,YY	**01200**
SDNC N 1212 M07	12	12	150	6.0	1,2	DC.. 0702	XX,YY	**11200**
SDNC N 1212 M11	12	12	150	6.0	3,2	DC.. 11T3	XX,YY	**21200**
SDNC N 1616 H11	16	16	100	8.0	3,2	DC.. 11T3	XX,YY	**01600**
SDNC N 2020 K11	20	20	125	10.0	3,2	DC.. 11T3	XX,YY	**02000**
SDNC N 2525 M11	25	25	150	12.5	3,2	DC.. 11T3	XX,YY	**02500**

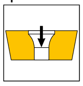
Spare parts for Article no.	Key D		80 950 ... #CU# *PA*		Clamping screw		70 950 ... #CU# *PA*		Solid Carbide Seat D		70 950 ... #CU# *PA*		Threaded sleeve		70 950 ... #CU# *PA*	
70 645 00800	T08 - IP		XX,YY	**039**	M2,5x6 - IP		XX,YY	**857**								
70 645 11000	T08 - IP		XX,YY	**039**	M2,5x6 - IP		XX,YY	**857**								
70 645 01000	T08 - IP		XX,YY	**039**	M2,5x6 - IP		XX,YY	**857**								
70 645 01200	T08 - IP		XX,YY	**039**	M2,5x6 - IP		XX,YY	**857**								
70 645 11200	T08 - IP		XX,YY	**039**	M2,5x6 - IP		XX,YY	**857**								
70 645 21200	T15 - IP		XX,YY	**120**	M3,5x11		XX,YY	**87900**								
70 645 01600	T15 - IP		XX,YY	**120**	M3,5x11		XX,YY	**87900**	XX,YY	**106**	M3,5		XX,YY	**171**		
70 645 02000	T15 - IP		XX,YY	**120**	M3,5x11		XX,YY	**87900**	XX,YY	**106**	M3,5		XX,YY	**171**		
70 645 02500	T15 - IP		XX,YY	**120**	M3,5x11		XX,YY	**87900**	XX,YY	**106**	M3,5		XX,YY	**171**		

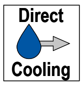
9

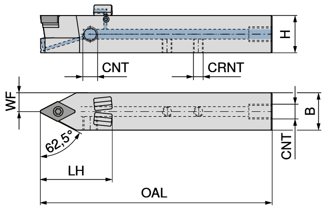
MaxiLock-S – SDNC 62,5° DC – Toolholder with screw clamping / Upínací držák s upínacím šroubem

Scope of delivery: / Rozsah dodávky:

Toolholder with seal plug and Torx key / Upínací držák se zátkou a Torx klíčem







NEW

Neutral / neutrální

Označení ISO	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	Utahovací moment Nm	Vyměnitelná destička	70 774 ... #CU# *PA*	
SDNC N 1212 M07 DC	12	12	150	24	6,0	M6	M6	1,2	DC.. 0702	XX,YY	**11200**
SDNC N 1212 F07 DC	12	12	80	24	6,0	M6	M6	1,2	DC.. 0702	XX,YY	**01200**
SDNC N 1212 M11 DC	12	12	150	31	6,0	M6	M6	3,2	DC.. 11T3	XX,YY	**21200**
SDNC N 1616 H11 DC	16	16	100	30	8,0	M6	G1/8"	3,2	DC.. 11T3	XX,YY	**01600**
SDNC N 2020 K11 DC	20	20	125	39	10,0	M6	G1/8"	3,2	DC.. 11T3	XX,YY	**02000**
SDNC N 2525 M11 DC	25	25	150	30	12,5	M6	G1/8"	3,2	DC.. 11T3	XX,YY	**02500**





Spare parts for Article no.	Clamping screw 70 950 ... #CU# *PA*		Solid Carbide Seat D 70 950 ... #CU# *PA*		Grubscrew 70 950 ... #CU# *PA*		Grubscrew 70 950 ... #CU# *PA*		Threaded sleeve 70 950 ... #CU# *PA*	
70 774 11200	XX,YY	**857**					XX,YY	**86700**		
70 774 01200	XX,YY	**857**					XX,YY	**86700**		
70 774 21200	XX,YY	**859**					XX,YY	**86700**		
70 774 01600	XX,YY	**87900**	XX,YY	**106**	XX,YY	**88000**	XX,YY	**86700**	XX,YY	**171**
70 774 02000	XX,YY	**87900**	XX,YY	**106**	XX,YY	**88000**	XX,YY	**86700**	XX,YY	**171**
70 774 02500	XX,YY	**87900**	XX,YY	**106**	XX,YY	**88000**	XX,YY	**86700**	XX,YY	**171**

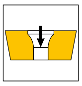
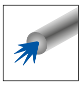


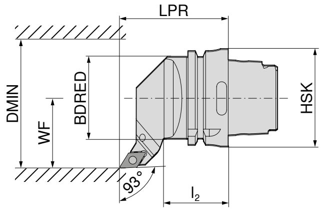


Spare parts for Article no.	Sealing plugs DC 70 950 ... #CU# *PA*		Key D 80 950 ... #CU# *PA*		O-Ring 70 950 ... #CU# *PA*		Coolant nozzle DC 70 950 ... #CU# *PA*		Coolant screw plug 70 950 ... #CU# *PA*	
70 774 11200			XX,YY	**039**						
70 774 01200			XX,YY	**039**						
70 774 21200			XX,YY	**120**						
70 774 01600	XX,YY	**87600**	XX,YY	**120**	XX,YY	**88100**	XX,YY	**87700**	XX,YY	**294**
70 774 02000	XX,YY	**87600**	XX,YY	**120**	XX,YY	**88100**	XX,YY	**87700**	XX,YY	**294**
70 774 02500	XX,YY	**87600**	XX,YY	**120**	XX,YY	**88100**	XX,YY	**87700**	XX,YY	**294**

MaxiLock-S – SDJC 93° – Toolholder with screw clamping

Scope of supply:
Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	l_2 mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 544 ... #CU# *PA*	Right-hand 74 543 ... #CU# *PA*
HSK T63 SDJC R/L 11	HSK-T 63	70	42	53	45	100	3.2	DC.. 11T3	XX,YY **511**	XX,YY **511**


Combination Key


Clamping screw

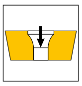
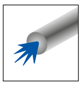

Solid Carbide Seat D

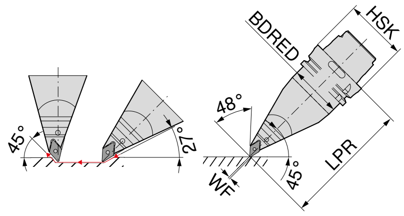

Threaded sleeve

Spare parts for Article no.		Combination Key 70 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*	Solid Carbide Seat D 70 950 ... #CU# *PA*		Threaded sleeve 70 950 ... #CU# *PA*
74 543 511 / 74 544 511	T15/SW	XX,YY **398**	M3,5x11	XX,YY **113**	XX,YY **106**	M3,5	XX,YY **171**

MaxiLock-S – SDMC 48° – Toolholder with screw clamping

Scope of supply:
Tool holder with Torx key



ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert	Left-hand 74 546 ... #CU# *PA*
HSK T63 SDMC L 11	HSK-T 63	130	53	0	3.2	DC.. 11T3	XX,YY **511**


Combination Key


Clamping screw

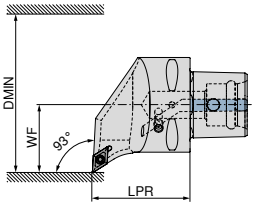

Solid Carbide Seat D


Threaded sleeve

Spare parts for Article no.		Combination Key 70 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*	Solid Carbide Seat D 70 950 ... #CU# *PA*		Threaded sleeve 70 950 ... #CU# *PA*
74 546 511	T15/SW	XX,YY **398**	M3,5x11	XX,YY **113**	XX,YY **106**	M3,5	XX,YY **171**

MaxiLock-S – SDUC 93° – Toolholder with screw clamping

Scope of supply:
Tool holder with Torx key

Illustrations show right-hand versions

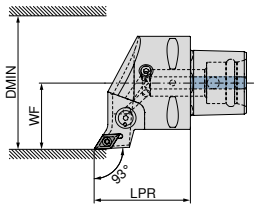
ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 84 659 ... #CU# *PA*		Right-hand 84 658 ... #CU# *PA*	
PSC40 SDUC R/L 50050-11	PSC 40	50	27	50	3	DC.. 11T3	XX,YY	**01195**	XX,YY	**01195**
PSC50 SDUC R/L 65060-11	PSC 50	60	35	65	3	DC.. 11T3	XX,YY	**01194**	XX,YY	**01194**
PSC63 SDUC R/L 80065-11	PSC 63	65	45	80	3	DC.. 11T3	XX,YY	**01193**	XX,YY	**01193**


Clamping screw

Spare parts for Article no.	84 950 ... #CU# *PA*	
84 658 01195 / 84 659 01195	XX,YY	**27600**
84 658 01194 / 84 659 01194	XX,YY	**27600**
84 658 01193 / 84 659 01193	XX,YY	**27600**

MaxiLock-S – SDJC 93° – Toolholder with screw clamping

Scope of supply:
without high-performance coolant set

Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Direct cooling compatible	Left-hand 84 663 ... #CU# *PA*		Right-hand 84 662 ... #CU# *PA*	
PSC40 SDJC R/L 50050-11	PSC 40	50	27	50	3	DC.. 11T3	DC	XX,YY	**01195**	XX,YY	**01195**
PSC50 SDJC R/L 65060-11	PSC 50	60	35	65	3	DC.. 11T3	DC	XX,YY	**01194**	XX,YY	**01194**
PSC63 SDJC R/L 80065-11	PSC 63	65	45	80	3	DC.. 11T3	DC	XX,YY	**01193**	XX,YY	**01193**

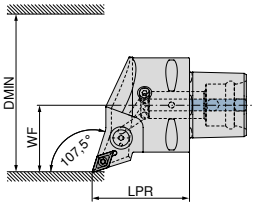
The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page PL**.


Clamping screw

Spare parts for Article no.	84 950 ... #CU# *PA*	
84 662 01195 / 84 663 01195	XX,YY	**27600**
84 662 01194 / 84 663 01194	XX,YY	**27600**
84 662 01193 / 84 663 01193	XX,YY	**27600**

MaxiLock-S – SDHC 107.5° – Toolholder with screw clamping

Scope of supply:
without high-performance coolant set



Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Direct cooling compatible	Left-hand 84 667 ... #CU# *PA*		Right-hand 84 666 ... #CU# *PA*	
PSC40 SDHC R/L 50050-11	PSC 40	50	27	50	3	DC.. 11T3	DC	XX,YY	**01195**	XX,YY	**01195**
PSC50 SDHC R/L 65060-11	PSC 50	60	35	65	3	DC.. 11T3	DC	XX,YY	**01194**	XX,YY	**01194**
PSC63 SDHC R/L 80065-11	PSC 63	65	45	80	3	DC.. 11T3	DC	XX,YY	**01193**	XX,YY	**01193**

The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page PL**.

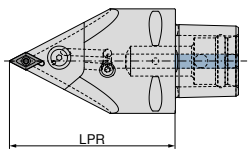
Clamping screw

Spare parts for Article no.	84 950 ... #CU# *PA*	
84 666 01195 / 84 667 01195	XX,YY	**27600**
84 666 01194 / 84 667 01194	XX,YY	**27600**
84 666 01193 / 84 667 01193	XX,YY	**27600**

9

MaxiLock-S – SDNC 62.5° – Toolholder with screw clamping

Scope of supply:
without high-performance coolant set



Neutral

ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Direct cooling compatible	84 677 ... #CU# *PA*	
PSC63 SDNC N 0100-11	PSC 63	100	3	DC.. 11T3	DC	XX,YY	**01193**
PSC63 SDNC N 0130-11	PSC 63	130	3	DC.. 11T3	DC	XX,YY	**11193**

The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page PL**.

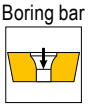
Clamping screw

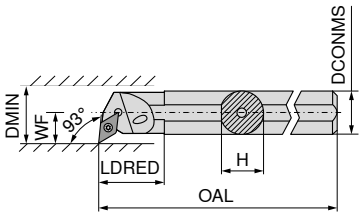
Spare parts for Article no.	84 950 ... #CU# *PA*	
84 677 01193	XX,YY	**27600**
84 677 11193	XX,YY	**27600**

MaxiLock-S – SDUC 93° – Boring bar with screw clamping

▲ A... = with thro' coolant
▲ S... = without thro' coolant

Scope of supply:
Boring bar with Torx key





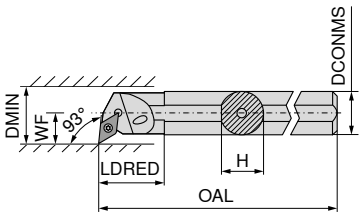
Illustrations show right-hand versions

									Left-hand		Right-hand	
									70 737 ...		**70 736 ...**	
ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	#CU# *PA*		#CU# *PA*	
S12Q SDUC R/L 07	12	11.0	180	12.5	9	17	1,2	DC.. 0702	XX,YY	**012**	XX,YY	**012**
A12K SDUC R/L 07	12	11.5	125	22.0	9	16	1,2	DC.. 0702	XX,YY	**212**	XX,YY	**212**
S16R SDUC R/L 07	16	15.0	200	13.0	11	21	1,2	DC.. 0702	XX,YY	**016**	XX,YY	**016**
A16M SDUC R/L 07	16	15.0	150	29.0	11	20	1,2	DC.. 0702	XX,YY	**216**	XX,YY	**216**
S20S SDUC R 07	20	18.0	250	20.0	13	25	1,2	DC.. 0702			XX,YY	**020**
A20Q SDUC R/L 07	20	18.5	180	32.0	13	25	1,2	DC.. 0702	XX,YY	**220**	XX,YY	**220**
S20S SDUC R 11	20	18.0	250	20.0	13	25	3,2	DC.. 11T3			XX,YY	**120**
A20Q SDUC R/L 11	20	19.0	180	32.0	13	25	3,2	DC.. 11T3	XX,YY	**320**	XX,YY	**320**
S25T SDUC R/L 11	25	23.0	300		17	32	3,2	DC.. 11T3	XX,YY	**125**	XX,YY	**125**
A25R SDUC R/L 11	25	24.0	200	36.0	17	32	3,2	DC.. 11T3	XX,YY	**325**	XX,YY	**325**
S32U SDUC R 11	32	30.0	350		22	40	3,2	DC.. 11T3			XX,YY	**132**
A32S SDUC R/L 11	32	31.0	250	50.0	22	40	3,2	DC.. 11T3	XX,YY	**332**	XX,YY	**332**
A40T SDUC R/L 11	40	39.0	300	60.0	27	50	3,2	DC.. 11T3	XX,YY	**340**	XX,YY	**340**

	 Key D		 Combination Key		 Clamping screw		 Solid Carbide Seat D		 Threaded sleeve	
	80 950 ...		**70 950 ...**		**70 950 ...**		**70 950 ...**		**70 950 ...**	
Spare parts for Article no.	#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
70 736 012 / 70 737 012	XX,YY	**110**			XX,YY	**13800**				
70 736 212 / 70 737 212	XX,YY	**110**			XX,YY	**13800**				
70 736 016 / 70 737 016	XX,YY	**110**			XX,YY	**13800**				
70 736 216 / 70 737 216	XX,YY	**110**			XX,YY	**13800**				
70 736 020	XX,YY	**110**			XX,YY	**13800**				
70 736 220 / 70 737 220	XX,YY	**110**			XX,YY	**13800**				
70 736 120	XX,YY	**113**			XX,YY	**110**				
70 736 320 / 70 737 320	XX,YY	**113**			XX,YY	**110**				
70 736 125 / 70 737 125			XX,YY	**398**	XX,YY	**113**	XX,YY	**106**	XX,YY	**171**
70 736 325 / 70 737 325	XX,YY	**113**			XX,YY	**113**				
70 736 132			XX,YY	**398**	XX,YY	**113**	XX,YY	**106**	XX,YY	**171**
70 736 332 / 70 737 332			XX,YY	**398**	XX,YY	**113**	XX,YY	**106**	XX,YY	**171**
70 736 340 / 70 737 340			XX,YY	**398**	XX,YY	**113**	XX,YY	**106**	XX,YY	**171**

MaxiLock-S – SDUC 93° – Boring bar with screw clamping

▲ with carbide core



Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 739 ... #CU# *PA*		Right-hand 70 738 ... #CU# *PA*	
E-A10H SDUC R/L 07	10	9	100	28.0	8	13	1,2	DC.. 0702	XX,YY	**210**	XX,YY	**210**
E-A12K SDUC R/L 07	12	11	125	18.0	9	18	1,2	DC.. 0702	XX,YY	**212**	XX,YY	**212**
E-A16M SDUC R/L 07	16	15	150	30.0	11	22	1,2	DC.. 0702	XX,YY	**216**	XX,YY	**216**
E-A20Q SDUC R/L 07	20	18	180	38.0	13	26	1,2	DC.. 0702	XX,YY	**220**	XX,YY	**220**
E-A20Q SDUC R/L 11	20	18	180	38.0	13	26	3,2	DC.. 11T3	XX,YY	**320**	XX,YY	**320**
E-A25R SDUC R/L 11	25	23	200	40.0	17	34	3,2	DC.. 11T3	XX,YY	**225**	XX,YY	**225**
E-A32S SDUC R/L 11	32	30	250	39.5	22	39	3,2	DC.. 11T3	XX,YY	**232**	XX,YY	**232**

Key D

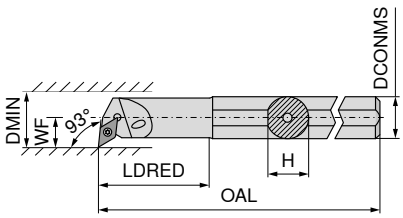
Clamping screw

Spare parts for Article no.	80 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 738 210 / 70 739 210	XX,YY	**110**	XX,YY	**13800**
70 738 212 / 70 739 212	XX,YY	**110**	XX,YY	**13800**
70 738 216 / 70 739 216	XX,YY	**110**	XX,YY	**13800**
70 738 220 / 70 739 220	XX,YY	**110**	XX,YY	**13800**
70 738 320 / 70 739 320	XX,YY	**113**	XX,YY	**449**
70 738 225 / 70 739 225	XX,YY	**113**	XX,YY	**449**
70 738 232 / 70 739 232	XX,YY	**113**	XX,YY	**449**

9

MaxiLock-S – SDUC 93° – Boring bar with screw clamping

▲ with carbide core



Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 739 ... #CU# *PA*		Right-hand 70 738 ... #CU# *PA*	
E-A0810H SDUC R/L 07	10	9	100	22	7	12.5	1,2	DC.. 0702	XX,YY	**410**	XX,YY	**410**
E-A1012K SDUC R/L 07	12	11	125	28	9	15.5	1,2	DC.. 0702	XX,YY	**412**	XX,YY	**412**
E-A1216M SDUC R/L 07	16	15	150	36	11	19.5	1,2	DC.. 0702	XX,YY	**416**	XX,YY	**416**

Key D

Clamping screw

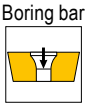
Spare parts for Article no.	80 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 738 410 / 70 739 410	XX,YY	**110**	XX,YY	**13800**
70 738 412 / 70 739 412	XX,YY	**110**	XX,YY	**13800**
70 738 416 / 70 739 416	XX,YY	**110**	XX,YY	**13800**

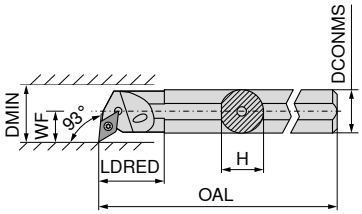
MaxiLock-S – SDUC 93° – Boring bar with screw clamping

▲ Type: Solid carbide

Scope of supply:

Boring bar with Torx key





Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 739 ... #CU# *PA*		Right-hand 70 738 ... #CU# *PA*	
E12Q SDUC R/L 07	12	11.5	180	26	9	16	1,2	DC.. 0702	XX,YY	012	XX,YY	012
E16R SDUC R/L 07	16	15.0	200	34	11	20	1,2	DC.. 0702	XX,YY	016	XX,YY	016
E20S SDUC R/L 11	20	18.5	250	38	13	25	3,2	DC.. 11T3	XX,YY	120	XX,YY	120
E25T SDUC R/L 11	25	23.0	300	43	17	32	3,2	DC.. 11T3	XX,YY	125	XX,YY	125

Key D

80 950 ...

Clamping screw

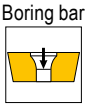
70 950 ...

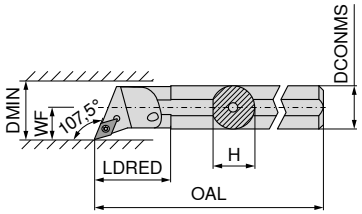
Spare parts for Article no.	#CU# *PA*		#CU# *PA*	
70 739 012 / 70 738 012	XX,YY	110	XX,YY	13800
70 739 016 / 70 738 016	XX,YY	110	XX,YY	13800
70 739 120 / 70 738 120	XX,YY	113	XX,YY	304
70 739 125 / 70 738 125	XX,YY	113	XX,YY	113

MaxiLock-S – SDQC 107.5° – Boring bar with screw clamping

Scope of supply:

Boring bar with Torx key





Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 741 ... #CU# *PA*		Right-hand 70 740 ... #CU# *PA*	
A10H SDQC R/L 07	10	9.0	100	22	7	12.5	1,2	DC.. 0702	XX,YY	210	XX,YY	210
A12K SDQC R/L 07	12	11.5	125	22	9	16.0	1,2	DC.. 0702	XX,YY	212	XX,YY	212
A16M SDQC R/L 07	16	15.0	150	29	11	20.0	1,2	DC.. 0702	XX,YY	216	XX,YY	216
A20Q SDQC R/L 07	20	18.5	180	32	13	25.0	1,2	DC.. 0702	XX,YY	220	XX,YY	220
A25R SDQC R/L 11	25	23.0	200	36	17	32.0	3,2	DC.. 11T3	XX,YY	225	XX,YY	225
A32S SDQC R/L 11	32	30.0	250	50	22	40.0	3,2	DC.. 11T3	XX,YY	232	XX,YY	232
A40T SDQC R/L 11	40	38.0	300	60	27	50.0	3,2	DC.. 11T3	XX,YY	240	XX,YY	240

Key D

80 950 ...

Combination Key

70 950 ...

Clamping screw

70 950 ...

Solid Carbide Seat D

70 950 ...

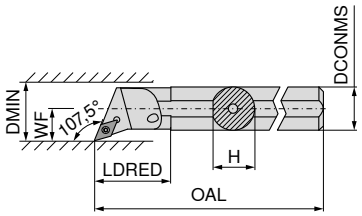
Threaded sleeve

70 950 ...

Spare parts for Article no.	#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
70 740 210 / 70 741 210	XX,YY	110			XX,YY	13800				
70 740 212 / 70 741 212	XX,YY	110			XX,YY	13800				
70 740 216 / 70 741 216	XX,YY	110			XX,YY	13800				
70 740 220 / 70 741 220	XX,YY	110			XX,YY	13800				
70 740 225 / 70 741 225			XX,YY	398	XX,YY	113				
70 740 232 / 70 741 232			XX,YY	398	XX,YY	113	XX,YY	106	XX,YY	171
70 740 240 / 70 741 240			XX,YY	398	XX,YY	113	XX,YY	106	XX,YY	171

MaxiLock-S – SDQC 107.5° – Boring bar with screw clamping

▲ with carbide core



Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 751 ... #CU# *PA*		Right-hand 70 750 ... #CU# *PA*	
E-A12K SDQC R/L 07	12	11	125	24	9	18	1,2	DC.. 0702	XX,YY	**012**	XX,YY	**012**
E-A16M SDQC R/L 07	16	15	150	30	11	22	1,2	DC.. 0702	XX,YY	**016**	XX,YY	**016**
E-A20Q SDQC R/L 07	20	18	180	38	13	26	1,2	DC.. 0702	XX,YY	**020**	XX,YY	**020**
E-A20Q SDQC R/L 11	20	18	180	45	13	26	3,2	DC.. 11T3	XX,YY	**120**	XX,YY	**120**
E-A25R SDQC R/L 11	25	23	200	38	17	34	3,2	DC.. 11T3	XX,YY	**025**	XX,YY	**025**
E-A32S SDQC R/L 11	32	30	250	43	22	39	3,2	DC.. 11T3	XX,YY	**032**	XX,YY	**032**

Key D

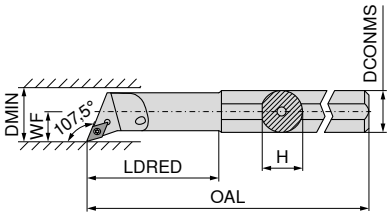
Clamping screw

Spare parts for Article no.	80 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 750 012 / 70 751 012	XX,YY	**110**	XX,YY	**13800**
70 750 016 / 70 751 016	XX,YY	**110**	XX,YY	**13800**
70 750 020 / 70 751 020	XX,YY	**110**	XX,YY	**13800**
70 750 120 / 70 751 120	XX,YY	**113**	XX,YY	**449**
70 750 025 / 70 751 025	XX,YY	**113**	XX,YY	**449**
70 750 032 / 70 751 032	XX,YY	**113**	XX,YY	**449**

9

MaxiLock-S – SDQC 107.5° – Boring bar with screw clamping

▲ with carbide core



Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 751 ... #CU# *PA*		Right-hand 70 750 ... #CU# *PA*	
E-A0810H SDQC R/L 07	10	9	100	22	7	12.5	1,2	DC.. 0702	XX,YY	**210**	XX,YY	**210**
E-A1012K SDQC R/L 07	12	11	125	28	9	15.5	1,2	DC.. 0702	XX,YY	**212**	XX,YY	**212**
E-A1216M SDQC R/L 07	16	15	150	36	11	19.5	1,2	DC.. 0702	XX,YY	**216**	XX,YY	**216**

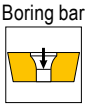
Key D

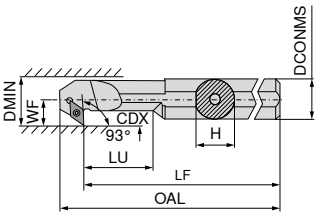
Clamping screw

Spare parts for Article no.	80 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 750 210 / 70 751 210	XX,YY	**110**	XX,YY	**13800**
70 750 212 / 70 751 212	XX,YY	**110**	XX,YY	**13800**
70 750 216 / 70 751 216	XX,YY	**110**	XX,YY	**13800**

MaxiLock-S – SDXC 93° – Boring bar with screw clamping

Scope of supply:
Boring bar with Torx key





Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	LF mm	OAL mm	LU mm	WF mm	DMIN mm	CDX mm	torque moment Nm	Insert	Left-hand 70 733 ... #CU# *PA*		Right-hand 70 732 ... #CU# *PA*	
A12K SDXC R/L 07	12	11.5	125	137.0	24	9	16	4.5	1,2	DC.. 0702	XX,YY	212	XX,YY	212
A16M SDXC R/L 07	16	15.0	150	162.0	36	11	20	4.5	1,2	DC.. 0702	XX,YY	216	XX,YY	216
A20Q SDXC R/L 11	20	18.5	180	196.5	40	13	25	6.5	3,2	DC.. 11T3	XX,YY	220	XX,YY	220
A25R SDXC R/L 11	25	23.0	200	216.8	50	17	32	9.5	3,2	DC.. 11T3	XX,YY	225	XX,YY	225

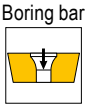

Key D

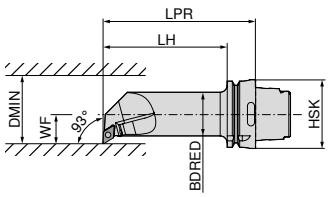

Clamping screw

Spare parts for Article no.	80 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 733 212 / 70 732 212	XX,YY	110	XX,YY	13800
70 733 216 / 70 732 216	XX,YY	110	XX,YY	13800
70 733 220 / 70 732 220	XX,YY	113	XX,YY	304
70 733 225 / 70 732 225	XX,YY	113	XX,YY	304

MaxiLock-S – SDUC 93° – Boring bar with screw clamping

Scope of supply:
Boring bar with Torx key





Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 566 ... #CU# *PA*		Right-hand 74 565 ... #CU# *PA*	
HSK T63 40L SDUC R/L 11	HSK-T 63	140	114	40	27	50	3.2	DC.. 11T3	XX,YY	511	XX,YY	511


Combination Key


Clamping screw

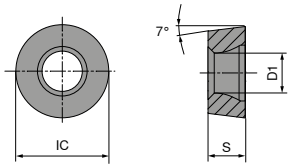

Solid Carbide Seat D


Threaded sleeve

Spare parts for Article no.		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
74 565 511 / 74 566 511	T15/SW	XX,YY	398	M3,5x11	XX,YY	113	XX,YY	106	M3,5	XX,YY	171

RCMT / RCGT / RCMX

Designation	S mm	D1 mm	IC mm
RCGT 0602..	2.38	2.8	6
RCGT 0803..	3.18	3.4	8
RC.T 1003..	3.18	4.0	10
RCMT 10T3..	3.97	4.4	10
RCMT 1204..	4.76	4.9	12
RCMT 1606..	6.35	5.3	16
RCMT 2006..	6.35	6.5	20
RCMT 2005..	6.35	6.5	20
RCMT 2507..	7.94	7.2	25
RCMX 2507..	7.94	10.5	25



RCMT / RCGT

			NEW	NEW	NEW	NEW	NEW	NEW
		-SMF CTCK110	-SM CTCP115-P	-SM CTCP115-P	-SM CTCP125-P	-SM CTCP125-P	-SM CTCP135-P	-SM CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
		F	M	M	M	M	M	M
		RCMT	RCMT	RCMT	RCGT	RCMT	RCGT	RCMT
		70 188 ...	76 186 ...	76 264 ...	76 262 ...	76 264 ...	76 262 ...	76 264 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
0602M0EN	3.0				XX,YY 50201		XX,YY 70201	
0803M0EN	4.0				XX,YY 51201		XX,YY 71201	
1003M0SN	5.0					XX,YY 51401		XX,YY 71401
1204M0SN	6.0			XX,YY 32801		XX,YY 52601		XX,YY 72601
1606M0EN	8.0	XX,YY 038						
1606M0SN	8.0			XX,YY 34001		XX,YY 53801		XX,YY 73801
2006M0SN	10.0		XX,YY 35001			XX,YY 55001		XX,YY 75001
2507M0SN	12.5			XX,YY 36201		XX,YY 56201		XX,YY 76201
P		○	●	●	●	●	●	●
M							○	○
K		●	○	○	○	○		
N								
S								
H								
O								

9

RCMT / RCMX

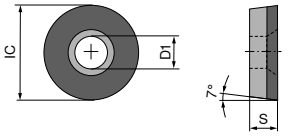
		NEW	NEW	NEW	NEW	NEW	NEW	NEW
		-SM CTPX710	-SM CTCM120	-SM CTPM125	-M23 CTCP115-P	-M23 CTCP115-P	-M23 CTCP115-P	-M23 CTCP125-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		M	M	M	M	M	M	M
		RCMT	RCMT	RCMT	RCMT	RCMX	RCMT	RCMT
		75 221 ...	75 221 ...	75 221 ...	74 117 ...	74 117 ...	74 121 ...	74 121 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
1003M0SN	5.0	XX,YY 61400	XX,YY 11400					
10T3M0SN	5.0						XX,YY 21400	
1204M0SN	6.0						XX,YY 22600	XX,YY 62600
1606M0SN	8.0						XX,YY 23800	XX,YY 63800
2005M0SN	10.0				XX,YY 25000			
2006M0SN	10.0			XX,YY 25000				XX,YY 65000
2507M0SN	12.5					XX,YY 25400		
P		●	○	○	●	●	●	●
M		●	●	●				
K					○	○	○	○
N		○						
S		●						
H								
O								

RCGT

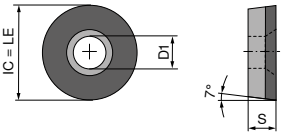
		-25P H210T	-27 H10T	-27 CTPX715
				DRAGONSKIN
				
		F	M	M
		RCGT	RCGT	RCGT
		70 241 ...	70 266 ...	70 266 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*
0602M0FN	3		XX,YY 600	XX,YY 70200
0803M0FN	4	XX,YY 60200	XX,YY 602	XX,YY 80200
1003M0FN	5		XX,YY 604	XX,YY 80400
P				●
M				●
K		○	○	○
N		●	●	●
S		○		●
H				
O		○	○	○

RCGW / RCGT

Designation	S mm	D1 mm	IC mm
RCG. 0602..	2.38	2.8	6
RCGW 0803..	3.18	3.4	8
RCGW 1003..	3.97	4.4	10
RCGT 10T3..	3.97	4.4	10
RCGW 1204..	4.76	4.4	12



RCGT F



RCGW F

RCGW / RCGT

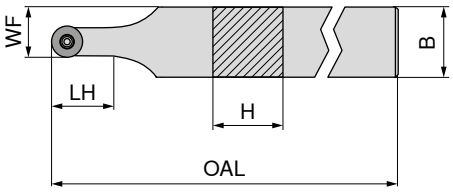
▲ TCE(NOI) = Design and number of equipped cutting edge corners

				CTDPD20		-CB1 CTDPD20		CTDPS30		-CB1 CTDPS30		-CB2 CTDPS30	
				F		F		F		F		M	
				DIAMOND RCGW		DIAMOND RCGT		DIAMOND RCGW		DIAMOND RCGT		DIAMOND RCGT	
				71 179 ...		71 315 ...		71 179 ...		71 315 ...		71 316 ...	
ISO	RE mm	TCE (NOI)	LE mm	#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
0602M0FN	3	F	6	XX,YY	10001	XX,YY	102	XX,YY	20001	XX,YY	202	XX,YY	202
0803M0FN	4	F	8	XX,YY	10101			XX,YY	20101				
1003M0FN	6	F	10	XX,YY	10201								
10T3M0FN	5	F	10			XX,YY	104			XX,YY	204	XX,YY	204
1204M0FN	6	F	12	XX,YY	10301								
P													
M													
K													
N				●		●		●		●		●	
S													
H													
O				●		●		●		●		●	

9

MaxiLock-S – SRDC 0° – Toolholder with screw clamping

Scope of supply:
Tool holder with Torx key



NEW
Neutral

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	70 646 ... #CU# *PA*	
SRDC N 1212 F06	12	12	80	12.0	9.0	1,2	RC.. 0602	XX,YY	**01200**
SRDC N 1616 H06	16	16	100	12.0	11.0	1,2	RC.. 0602	XX,YY	**01600**
SRDC N 2020 K06	20	20	125	12.0	13.0	1,2	RC.. 0602	XX,YY	**02000**
SRDC N 2525 M06	25	25	150	12.4	15.5	1,2	RC.. 0602	XX,YY	**02500**
SRDC N 1616 H08	16	16	100	16.0	12.0	1,8	RC.. 0803	XX,YY	**11600**
SRDC N 2020 K08	20	20	125	16.5	14.0	1,8	RC.. 0803	XX,YY	**12000**
SRDC N 2525 M08	25	25	150	16.5	16.5	1,8	RC.. 0803	XX,YY	**12500**
SRDC N 1616 H10	16	16	100	20.9	13.0	3,2	RC.. 1003 / RC.. 10T3	XX,YY	**21600**
SRDC N 2020 K10	20	20	125	20.0	15.0	3,2	RC.. 1003 / RC.. 10T3	XX,YY	**22000**
SRDC N 2525 M10	25	25	150	20.9	17.5	3,2	RC.. 1003 / RC.. 10T3	XX,YY	**22500**

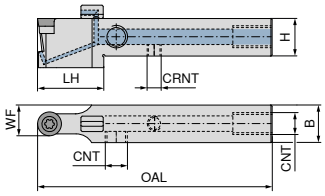
When using WSP RC .. 10T3 indexable inserts, use insert seat article no. 70 950 40000.

Spare parts for Article no.	Key D 80 950 ... #CU# *PA*		 Clamping screw 70 950 ... #CU# *PA*		 Solid carbide support R 70 950 ... #CU# *PA*		 Threaded sleeve 70 950 ... #CU# *PA*	
70 646 01200	XX,YY	**039**	XX,YY	**857**				
70 646 01600	XX,YY	**039**	XX,YY	**857**				
70 646 02000	XX,YY	**039**	XX,YY	**857**				
70 646 02500	XX,YY	**039**	XX,YY	**857**				
70 646 11600	XX,YY	**118**	XX,YY	**819**				
70 646 12000	XX,YY	**118**	XX,YY	**819**				
70 646 12500	XX,YY	**118**	XX,YY	**819**				
70 646 21600	XX,YY	**120**	XX,YY	**87900**	XX,YY	**117**	XX,YY	**171**
70 646 22000	XX,YY	**120**	XX,YY	**87900**	XX,YY	**117**	XX,YY	**171**
70 646 22500	XX,YY	**120**	XX,YY	**87900**	XX,YY	**117**	XX,YY	**171**

MaxiLock-S – SRDC 0° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



NEW

Neutral

70 775 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	#CU# *PA*	
SRDC N 1212 F06 DC	12	12	80	26	9.0	M6	M6	1,2	RC.. 0602	XX,YY	**01200**
SRDC N 1616 H06 DC	16	16	100	30	11.0	M6	G1/8"	1,2	RC.. 0602	XX,YY	**01600**
SRDC N 2020 K06 DC	20	20	125	30	13.0	M6	G1/8"	1,2	RC.. 0602	XX,YY	**02000**
SRDC N 2525 M06 DC	25	25	150	30	15.5	M6	G1/8"	1,2	RC.. 0602	XX,YY	**02500**
SRDC N 1616 H08 DC	16	16	100	30	12.0	M6	G1/8"	1,8	RC.. 0803	XX,YY	**11600**
SRDC N 2020 K08 DC	20	20	125	30	14.0	M6	G1/8"	1,8	RC.. 0803	XX,YY	**12000**
SRDC N 2525 M08 DC	25	25	150	31	16.5	M6	G1/8"	1,8	RC.. 0803	XX,YY	**12500**
SRDC N 1616 H10 DC	16	16	100	30	13.0	M6	G1/8"	3,2	RC.. 1003 / RC.. 10T3	XX,YY	**21600**
SRDC N 2020 K10 DC	20	20	125	30	15.0	M6	G1/8"	3,2	RC.. 1003 / RC.. 10T3	XX,YY	**22000**
SRDC N 2525 M10 DC	25	25	150	36	17.5	M6	G1/8"	3,2	RC.. 1003 / RC.. 10T3	XX,YY	**22500**

When using WSP RC .. 10T3 indexable inserts, use insert seat article no. 70 950 40000.

Clamping screw

Solid carbide support R

Grubscrew

Grubscrew

Threaded sleeve

Spare parts for Article no.	70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 775 01200	XX,YY	**857**					XX,YY	**86700**		
70 775 01600	XX,YY	**857**			XX,YY	**88000**	XX,YY	**86700**		
70 775 02000	XX,YY	**857**			XX,YY	**88000**	XX,YY	**86700**		
70 775 02500	XX,YY	**857**			XX,YY	**88000**	XX,YY	**86700**		
70 775 11600	XX,YY	**819**			XX,YY	**88000**	XX,YY	**86700**		
70 775 12000	XX,YY	**819**			XX,YY	**88000**	XX,YY	**86700**		
70 775 12500	XX,YY	**819**			XX,YY	**88000**	XX,YY	**86700**		
70 775 21600	XX,YY	**87900**	XX,YY	**117**	XX,YY	**88000**	XX,YY	**86700**	XX,YY	**171**
70 775 22000	XX,YY	**87900**	XX,YY	**117**	XX,YY	**88000**	XX,YY	**86700**	XX,YY	**171**
70 775 22500	XX,YY	**87900**	XX,YY	**117**	XX,YY	**88000**	XX,YY	**86700**	XX,YY	**171**

Sealing plugs DC

Key D

O-Ring

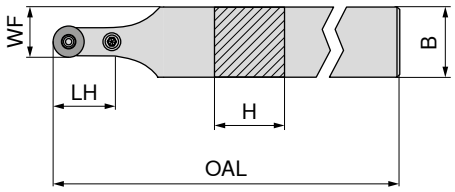
Coolant nozzle DC

Coolant screw plug

Spare parts for Article no.	70 950 ... #CU# *PA*		80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 775 01200			XX,YY	**039**						
70 775 01600	XX,YY	**87600**	XX,YY	**039**	XX,YY	**88100**	XX,YY	**87700**	XX,YY	**294**
70 775 02000	XX,YY	**87600**	XX,YY	**039**	XX,YY	**88100**	XX,YY	**87700**	XX,YY	**294**
70 775 02500	XX,YY	**87600**	XX,YY	**039**	XX,YY	**88100**	XX,YY	**87700**	XX,YY	**294**
70 775 11600	XX,YY	**87600**	XX,YY	**118**	XX,YY	**88100**	XX,YY	**87700**	XX,YY	**294**
70 775 12000	XX,YY	**87600**	XX,YY	**118**	XX,YY	**88100**	XX,YY	**87700**	XX,YY	**294**
70 775 12500	XX,YY	**87600**	XX,YY	**118**	XX,YY	**88100**	XX,YY	**87700**	XX,YY	**294**
70 775 21600	XX,YY	**87600**	XX,YY	**120**	XX,YY	**88100**	XX,YY	**87700**	XX,YY	**294**
70 775 22000	XX,YY	**87600**	XX,YY	**120**	XX,YY	**88100**	XX,YY	**87700**	XX,YY	**294**
70 775 22500	XX,YY	**87600**	XX,YY	**120**	XX,YY	**88100**	XX,YY	**87700**	XX,YY	**294**

MaxiLock-N – PRDC 0° – Toolholder with lever clamping

Scope of supply:
Tool holder with allen key



Neutral

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	70 544 ... #CU# *PA*	
PRDC N 2525 M12	25	25	150	24	18.5	3	RC.. 1204	XX,YY	**025**
PRDC N 3225 P12	32	25	170	24	18.5	3	RC.. 1204	XX,YY	**032**
PRDC N 3225 P16	32	25	170	28	20.5	4	RC.. 1606	XX,YY	**132**


Key I


Shim

Assembly pin


Lever

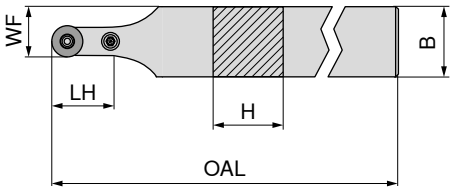

Clamping screw


Solid carbide support R

Spare parts for Article no.		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 544 025	SW2,5	XX,YY	**175**	XX,YY	**197**	XX,YY	**191**	XX,YY	**178**	XX,YY	**208**	XX,YY	**215**
70 544 032	SW2,5	XX,YY	**175**	XX,YY	**197**	XX,YY	**191**	XX,YY	**178**	XX,YY	**208**	XX,YY	**215**
70 544 132	SW3	XX,YY	**176**	XX,YY	**196**	XX,YY	**192**	XX,YY	**387**	XX,YY	**390**	XX,YY	**384**

MaxiLock-N – PRDC 0° – Toolholder with lever clamping

Scope of supply:
Tool holder with allen key



Neutral

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	70 545 ... #CU# *PA*	
PRDC N 3225 P20	32	32	170	32	26.0	5	RC.. 2006	XX,YY	**23200**
PRDC N 4040 S25	40	40	250	42	32.5	6	RCMT 2507 / RCMX 2507	XX,YY	**40400**


Key I


Shim

Assembly pin


Lever


Clamping screw

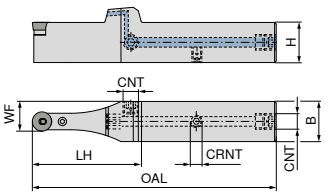

Solid carbide support R

Spare parts for Article no.	70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 545 23200	XX,YY	**177**	XX,YY	**391**	XX,YY	**394**	XX,YY	**28100**	XX,YY	**28500**	XX,YY	**27400**
70 545 40400	XX,YY	**396**	XX,YY	**392**	XX,YY	**395**	XX,YY	**28400**	XX,YY	**28600**	XX,YY	**27500**

MaxiLock-N – PRDC 0° DC – Toolholder with lever clamping

Scope of supply:

Tool holder with allen key



NEW

Neutral

70 595 ...

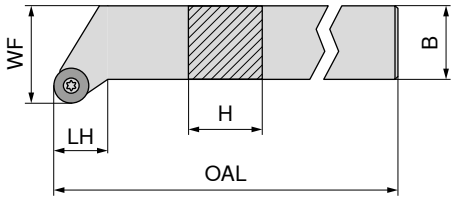
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	#CU# *PA*
PRDC N 2020 X12-T DC	20	20	132	63	16.0	M6	G1/8"	3	RC.. 1204	XX,YY **02000**
PRDC N 2525 X12-T DC	25	25	152	68	18.5	M6	G1/8"	3	RC.. 1204	XX,YY **02500**
PRDC N 3225 X12-T DC	32	25	168	68	18.5	M6	G1/8"	3	RC.. 1204	XX,YY **03200**
PRDC N 3225 X16-T DC	32	25	172	72	20.5	M6	G1/8"	4	RC.. 1606	XX,YY **13200**
PRDC N 3232 X20-T DC	32	32	176	76	26.0	M6	G1/8"	5	RC.. 2006	XX,YY **23200**
PRDC N 4040 X25-T DC	40	40	216	91	32.5	M6	G1/8"	6	RCMT 2507 / RCMX 2507	XX,YY **04000**

	 Key I	 Shim	Assembly pin	 Coolant screw plug	 Lever	 Clamping screw	 Solid carbide support R	 Grubscrew
	70 950 ...	**70 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**
Spare parts for Article no.	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
70 595 02000	XX,YY **175**	XX,YY **197**	XX,YY **191**	XX,YY **294**	XX,YY **178**	XX,YY **208**	XX,YY **215**	XX,YY **86700**
70 595 02500	XX,YY **175**	XX,YY **197**	XX,YY **191**	XX,YY **294**	XX,YY **178**	XX,YY **208**	XX,YY **215**	XX,YY **86700**
70 595 03200	XX,YY **175**	XX,YY **197**	XX,YY **191**	XX,YY **294**	XX,YY **178**	XX,YY **208**	XX,YY **215**	XX,YY **86700**
70 595 13200	XX,YY **175**	XX,YY **196**	XX,YY **192**	XX,YY **294**	XX,YY **387**	XX,YY **390**	XX,YY **384**	XX,YY **86700**
70 595 23200	XX,YY **177**	XX,YY **391**	XX,YY **394**	XX,YY **294**	XX,YY **28100**	XX,YY **28500**	XX,YY **27400**	XX,YY **86700**
70 595 04000	XX,YY **396**	XX,YY **392**	XX,YY **395**	XX,YY **294**	XX,YY **28400**	XX,YY **28600**	XX,YY **27500**	XX,YY **86700**

MaxiLock-S – SRGC – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	NEW Left-hand 70 647 ... #CU# *PA*		NEW Right-hand 70 647 ... #CU# *PA*	
SRGC R/L 1212 F06	12	12	80	12.5	16	1,2	RC.. 0602	XX,YY	**01200**	XX,YY	**01201**
SRGC R 1616 H06	16	16	100	12.5	20	1,2	RC.. 0602			XX,YY	**01601**
SRGC R/L 2020 K06	20	20	125	15.0	25	1,2	RC.. 0602	XX,YY	**02000**	XX,YY	**02001**
SRGC R/L 2525 M06	25	25	150	18.5	32	1,2	RC.. 0602	XX,YY	**02500**	XX,YY	**02501**
SRGC R/L 1616 H08	16	16	100	13.6	20	1,8	RC.. 0803	XX,YY	**11600**	XX,YY	**11601**
SRGC R 2020 K08	20	20	125	16.1	25	1,8	RC.. 0803			XX,YY	**12001**
SRGC R/L 2525 M08	25	25	150	19.6	32	1,8	RC.. 0803	XX,YY	**12500**	XX,YY	**12501**
SRGC R/L 2020 K10	20	20	125	16.1	25	3,2	RC.. 1003 / RC.. 10T3	XX,YY	**22000**	XX,YY	**22001**
SRGC R/L 2525 M10	25	25	150	19.6	32	3,2	RC.. 1003 / RC.. 10T3	XX,YY	**22500**	XX,YY	**22501**

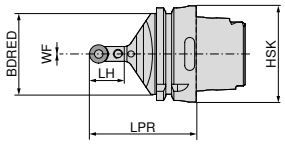
When using WSP RC .. 10T3 indexable inserts, use insert seat article no. 70 950 40000.

Spare parts for Article no.		Key D 80 950 ... #CU# *PA*			Clamping screw 70 950 ... #CU# *PA*		Solid carbide support R 70 950 ... #CU# *PA*			Threaded sleeve 70 950 ... #CU# *PA*	
70 647 01200 / 70 647 01201	T08 - IP	XX,YY	**039**	M2,5x6 - IP	XX,YY	**857**					
70 647 01601	T08 - IP	XX,YY	**039**	M2,5x6 - IP	XX,YY	**857**					
70 647 02000 / 70 647 02001	T08 - IP	XX,YY	**039**	M2,5x6 - IP	XX,YY	**857**					
70 647 02500 / 70 647 02501	T08 - IP	XX,YY	**039**	M2,5x6 - IP	XX,YY	**857**					
70 647 11600 / 70 647 11601	T09 - IP	XX,YY	**118**	M3x7 - IP	XX,YY	**819**					
70 647 12001	T09 - IP	XX,YY	**118**	M3x7 - IP	XX,YY	**819**					
70 647 12500 / 70 647 12501	T09 - IP	XX,YY	**118**	M3x7 - IP	XX,YY	**819**					
70 647 22000 / 70 647 22001	T15 - IP	XX,YY	**120**	M3,5x11	XX,YY	**87900**	XX,YY	**117**	M3,5	XX,YY	**171**
70 647 22500 / 70 647 22501	T15 - IP	XX,YY	**120**	M3,5x11	XX,YY	**87900**	XX,YY	**117**	M3,5	XX,YY	**171**

MaxiLock-N – PRDC 0° – Toolholder with lever clamping

Scope of supply:

Tool holder with allen key



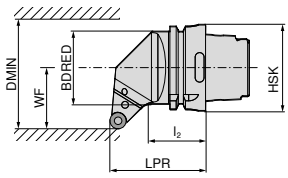
ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert	Neutral 74 548 ... #CU# *PA*	
HSK T63 PRDC N 12	HSK-T 63	70	53	0	3	RC.. 1204 M0	XX,YY	**512**
HSK T100 PRDC N 12	HSK-T 100	80	88	0	3	RC.. 1204 M0	XX,YY	**712**
HSK T100 PRDC N 16	HSK-T 100	80	88	0	4	RC.. 1606 M0	XX,YY	**716**

Spare parts for Article no.		Key I 70 950 ... #CU# *PA*		Shim 70 950 ... #CU# *PA*		Assembly pin 70 950 ... #CU# *PA*		Lever 70 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*		Solid carbide support R 70 950 ... #CU# *PA*	
74 548 512	SW2,5	XX,YY	**175**	XX,YY	**197**	XX,YY	**191**	XX,YY	**178**	XX,YY	**208**	XX,YY	**215**
74 548 712	SW2,5	XX,YY	**175**	XX,YY	**197**	XX,YY	**191**	XX,YY	**178**	XX,YY	**208**	XX,YY	**215**
74 548 716	SW3	XX,YY	**176**	XX,YY	**196**	XX,YY	**192**	XX,YY	**387**	XX,YY	**390**	XX,YY	**384**

MaxiLock-N – PRSC – Toolholder with lever clamping

Scope of supply:

Tool holder with allen key



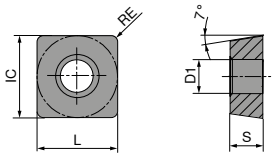
Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	l_2 mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 552 ... #CU# *PA*		Right-hand 74 551 ... #CU# *PA*	
HSK T63 PRSC R/L 12	HSK-T 63	70	44	53	45	100	3	RC.. 1204 M0	XX,YY	**512**	XX,YY	**512**
HSK T100 PRSC R/L 12	HSK-T 100	80	57	88	55	106	3	RC.. 1204 M0	XX,YY	**712**	XX,YY	**712**
HSK T100 PRSC R/L 16	HSK-T 100	80	55	88	55	125	4	RC.. 1606 M0	XX,YY	**716**	XX,YY	**716**

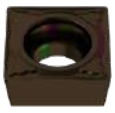
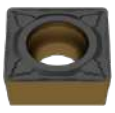
Spare parts for Article no.		Key I 70 950 ... #CU# *PA*		Shim 70 950 ... #CU# *PA*		Assembly pin 70 950 ... #CU# *PA*		Lever 70 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*		Solid carbide support R 70 950 ... #CU# *PA*	
74 551 512 / 74 552 512	SW2,5	XX,YY	**175**	XX,YY	**197**	XX,YY	**191**	XX,YY	**178**	XX,YY	**208**	XX,YY	**215**
74 551 712 / 74 552 712	SW2,5	XX,YY	**175**	XX,YY	**197**	XX,YY	**191**	XX,YY	**178**	XX,YY	**208**	XX,YY	**215**
74 551 716 / 74 552 716	SW3	XX,YY	**176**	XX,YY	**196**	XX,YY	**192**	XX,YY	**387**	XX,YY	**390**	XX,YY	**384**

SCGT / SCMT

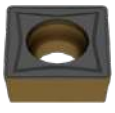
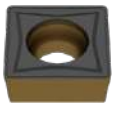
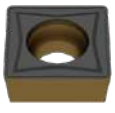
Designation	L mm	S mm	D1 mm	IC mm
SC.T 09T3..	9.52	3.97	4.4	9.52
SC.T 1204..	12.70	4.76	5.5	12.70



SCGT / SCMT

		-CF05 CTEP110	-CF55 CTEP110	-SF TCM10	NEW -SF CTCP115-P	NEW -SF CTCP125-P	NEW -SMF CTCP115-P	NEW -SMF CTCP135-P
		DRAGONSKIN	DRAGONSKIN		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		F	F	F	F	F	F	F
		CERMET SCGT	CERMET SCMT	CERMET SCGT	SCMT	SCMT	SCMT	SCMT
		76 261 ...	76 260 ...	70 271 ...	76 187 ...	76 269 ...	76 267 ...	76 267 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
09T304EN	0.4	XX,YY 004	XX,YY 004	XX,YY 902		XX,YY 50401	XX,YY 30401	
09T308EN	0.8	XX,YY 006	XX,YY 006	XX,YY 904	XX,YY 30601	XX,YY 50601	XX,YY 30601	
120408EN	0.8					XX,YY 51801		XX,YY 71801
P		●	●	●	●	●	●	●
M		○	○	○				○
K		○	○	○	○	○	○	
N								
S								
H								
O								

SCMT

		-SM CTCK110	-SM CTCK120	NEW -SM CTCP115-P	NEW -SM CTCP125-P	NEW -SM CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
						
		M	M	M	M	M
		SCMT	SCMT	SCMT	SCMT	SCMT
		70 268 ...	70 268 ...	76 268 ...	76 268 ...	76 268 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
09T304EN	0.4	XX,YY 004	XX,YY 504	XX,YY 30401	XX,YY 50401	XX,YY 70401
09T308EN	0.8	XX,YY 006	XX,YY 506	XX,YY 30601	XX,YY 50601	XX,YY 70601
120408EN	0.8	XX,YY 018	XX,YY 518	XX,YY 31801	XX,YY 51801	XX,YY 71801
120412EN	1.2	XX,YY 020	XX,YY 520		XX,YY 52001	
P		○	○	●	●	●
M						○
K		●	●	○	○	
N						
S						
H						
O						

SCMT

		NEW			
		-M25 CTPM125	-M55 CTCM120	-M55 CTPM125	-M55 CTCM130
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
					
		F	M	M	M
		SCMT	SCMT	SCMT	SCMT
		75 222 ...	75 216 ...	75 216 ...	75 216 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
09T304EN	0.4	XX,YY 70400			
09T308EN	0.8		XX,YY 10600	XX,YY 206	XX,YY 30600
120408EN	0.8		XX,YY 11800	XX,YY 218	XX,YY 31800
P		○	○	○	○
M		●	●	●	●
K					
N					
S					○
H					
O					

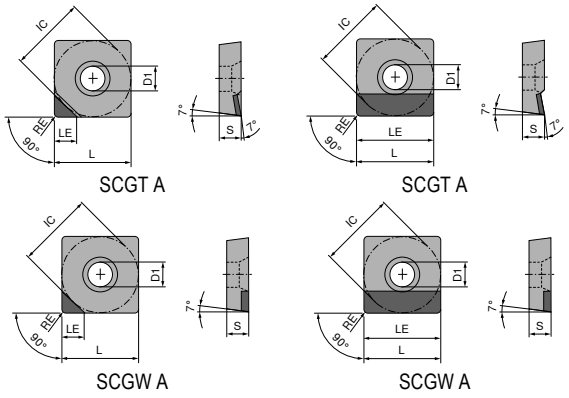
SCGT

		-25P H210T	-25P CTPX710	-27 CTPX715	-27 H10T
			DRAGONSKIN	DRAGONSKIN	
					
		F	M	M	M
		SCGT	SCGT	SCGT	SCGT
		70 283 ...	70 283 ...	70 270 ...	70 270 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
09T304FN	0.4			XX,YY 80400	XX,YY 600
09T308FN	0.8			XX,YY 80600	XX,YY 602
120408FN	0.8	XX,YY 634	XX,YY 71600	XX,YY 71800	XX,YY 604
P			●	●	
M			●	●	
K		○		○	○
N		●	●	●	●
S		○	●	●	
H					
O		○		○	○

9

SCGW / SCGT

Designation	L mm	S mm	D1 mm	IC mm
SCG. 09T3..	9.52	3.97	4.4	9.52
SCG. 1204..	12.70	4.76	5.5	12.70



SCGT A SCGT A SCGW A SCGW A

SCGW / SCGT

▲ TCE(NOI) = Design and number of equipped cutting edge corners

				CTDPD20	CTDPD20	-CB1 CTDPD20	CTDPS30	CTDPS30
				F	F	F	F	F
				DIAMOND SCGW	DIAMOND SCGW	DIAMOND SCGT	DIAMOND SCGW	DIAMOND SCGT
				71 182 ...	71 183 ...	71 320 ...	71 182 ...	71 180 ...
ISO	RE mm	TCE (NOI)	LE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
09T304FN	0.4	A (1)	9.52		XX,YY 10001			
09T304FN	0.4	A (1)	4.40	XX,YY 10001		XX,YY 114	XX,YY 20601	XX,YY 20001
09T308FN	0.8	A (1)	9.52		XX,YY 10101			
09T308FN	0.8	A (1)	4.30	XX,YY 10101		XX,YY 118		XX,YY 20101
09T312FN	1.2	A (1)	4.20	XX,YY 10201				XX,YY 20201
120404FN	0.4	A (1)	12.70		XX,YY 10201			
120404FN	0.4	A (1)	4.40	XX,YY 10301				
120408FN	0.8	A (1)	4.30	XX,YY 10401				
120408FN	0.8	A (1)	12.70		XX,YY 10301			
120412FN	1.2	A (1)	4.20	XX,YY 10501				
120412FN	1.2	A (1)	12.70		XX,YY 10401			
P								
M								
K								
N				●	●	●	●	●
S								
H								
O				●	●	●	●	●

SCGT

▲ TCE(NOI) = Design and number of equipped cutting edge corners

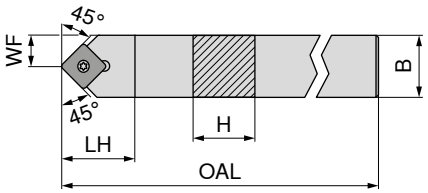
				CTDPS30		-CB2 CTDPS30		-CB3 CTDPU20	
									
				F DIAMOND SCGT		M DIAMOND SCGT		R DIAMOND SCGT	
				71 181 ...		71 321 ...		71 322 ...	
ISO	RE mm	TCE (NOI)	LE mm	#CU# *PA*		#CU# *PA*		#CU# *PA*	
09T304FN	0.4	A (1)	4.4			XX,YY	214	XX,YY	214
09T308FN	0.8	A (1)	9.5	XX,YY	20001				
09T308FN	0.8	A (1)	4.3			XX,YY	218	XX,YY	218
120408FN	0.8	A (1)	12.7	XX,YY	20101				
120412FN	1.2	A (1)	12.0	XX,YY	20201				
P									
M									
K									
N					●		●		●
S									
H									
O					●		●		●

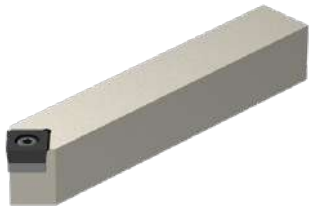
9

MaxiLock-S – SSDC 45° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key





NEW

Neutral

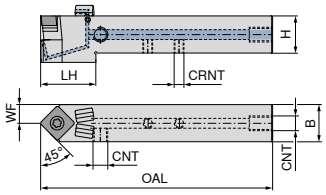
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	70 651 ... #CU# *PA*	
SSDC N 1212 F09	12	12	80	16	6.0	3,2	SC.. 09T3..	XX,YY	**01200**
SSDC N 1616 H09	16	16	100	20	8.0	3,2	SC.. 09T3..	XX,YY	**01600**
SSDC N 2020 K09	20	20	125	20	10.0	3,2	SC.. 09T3..	XX,YY	**02000**
SSDC N 1616 H12	16	16	100	25	8.0	5	SC.. 1204..	XX,YY	**11600**
SSDC N 2020 K12	20	20	125	25	10.0	5	SC.. 1204..	XX,YY	**12000**
SSDC N 2525 M12	25	25	150	25	12.5	5	SC.. 1204..	XX,YY	**12500**

Spare parts for Article no.	 Key D 80 950 ... #CU# *PA*		 Clamping screw 70 950 ... #CU# *PA*		 Solid Carbide support S 70 950 ... #CU# *PA*		 Threaded sleeve 70 950 ... #CU# *PA*	
70 651 01200	XX,YY	**120**	XX,YY	**87900**				
70 651 01600	XX,YY	**120**	XX,YY	**87900**				
70 651 02000	XX,YY	**120**	XX,YY	**87900**	XX,YY	**167**	XX,YY	**171**
70 651 11600	XX,YY	**120**	XX,YY	**820**	XX,YY	**168**	XX,YY	**170**
70 651 12000	XX,YY	**120**	XX,YY	**820**	XX,YY	**168**	XX,YY	**170**
70 651 12500	XX,YY	**120**	XX,YY	**820**	XX,YY	**168**	XX,YY	**170**

MaxiLock-S – SSDC 45° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



NEW

Neutral

70 776 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	#CU# *PA*
SSDC N 1212 F09 DC	12	12	80	25	12.8	M6	M6	3,2	SC.. 09T3..	XX,YY **01200**
SSDC N 1616 H09 DC	16	16	100	30	16.0	M6	G1/8"	3,2	SC.. 09T3..	XX,YY **01600**
SSDC N 2020 K09 DC	20	20	125	30	20.0	M6	G1/8"	3,2	SC.. 09T3..	XX,YY **02000**
SSDC N 1616 H12 DC	16	16	100	29	17.3	M6	G1/8"	5	SC.. 1204..	XX,YY **11600**
SSDC N 2020 K12 DC	20	20	125	30	20.0	M6	G1/8"	5	SC.. 1204..	XX,YY **12000**
SSDC N 2525 M12 DC	25	25	150	30	25.0	M6	G1/8"	5	SC.. 1204..	XX,YY **02500**

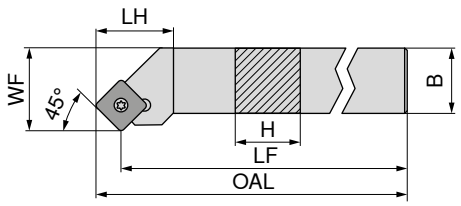
Spare parts for Article no.	 Clamping screw **70 950 ...** #CU# *PA*	 Solid Carbide support S **70 950 ...** #CU# *PA*	 Grubscrew **70 950 ...** #CU# *PA*	 Grubscrew **70 950 ...** #CU# *PA*	 Threaded sleeve **70 950 ...** #CU# *PA*
70 776 01200	XX,YY **87900**			XX,YY **86700**	
70 776 01600	XX,YY **87900**	XX,YY **167**	XX,YY **88000**	XX,YY **86700**	XX,YY **171**
70 776 02000	XX,YY **87900**	XX,YY **167**	XX,YY **88000**	XX,YY **86700**	XX,YY **171**
70 776 11600	XX,YY **820**	XX,YY **168**	XX,YY **88000**	XX,YY **86700**	XX,YY **170**
70 776 12000	XX,YY **820**	XX,YY **168**	XX,YY **88000**	XX,YY **86700**	XX,YY **170**
70 776 02500	XX,YY **820**	XX,YY **168**	XX,YY **88000**	XX,YY **86700**	XX,YY **170**

Spare parts for Article no.	 Sealing plugs DC **70 950 ...** #CU# *PA*	 Key D **80 950 ...** #CU# *PA*	 O-Ring **70 950 ...** #CU# *PA*	 Coolant nozzle DC **70 950 ...** #CU# *PA*	 Coolant screw plug **70 950 ...** #CU# *PA*
70 776 01200		XX,YY **120**			
70 776 01600	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 776 02000	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 776 11600	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 776 12000	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 776 02500	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**

MaxiLock-S – SSSC 45° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	NEW Left-hand 70 654 ... #CU# *PA*	NEW Right-hand 70 654 ... #CU# *PA*
SSSC R/L 1212 F09	12	12	80	18	16	3,2	SC.. 09T3..	XX,YY **01200**	XX,YY **01201**
SSSC R/L 1616 H09	16	16	100	20	20	3,2	SC.. 09T3..	XX,YY **01600**	XX,YY **01601**
SSSC R/L 2020 K09	20	20	125	20	25	3,2	SC.. 09T3..	XX,YY **02000**	XX,YY **02001**
SSSC R/L 1616 H12	16	16	100	25	20	5	SC.. 1204..	XX,YY **11600**	XX,YY **11601**
SSSC R/L 2020 K12	20	20	125	25	25	5	SC.. 1204..	XX,YY **12000**	XX,YY **12001**
SSSC R/L 2525 M12	25	25	150	25	32	5	SC.. 1204..	XX,YY **12500**	XX,YY **12501**
SSSC R 3225 P12	32	25	170	25	32	5	SC.. 1204..		XX,YY **13201**

Key D

Clamping screw

Solid Carbide support S

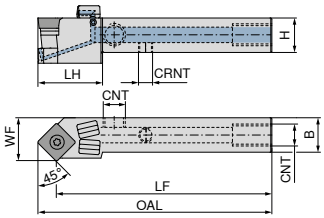
Threaded sleeve

Spare parts for Article no.	Key D 80 950 ... #CU# *PA*	Clamping screw 70 950 ... #CU# *PA*	Solid Carbide support S 70 950 ... #CU# *PA*	Threaded sleeve 70 950 ... #CU# *PA*
70 654 01201 / 70 654 01200	XX,YY **120**	XX,YY **87900**		
70 654 01601 / 70 654 01600	XX,YY **120**	XX,YY **87900**	XX,YY **167**	XX,YY **171**
70 654 02001 / 70 654 02000	XX,YY **120**	XX,YY **87900**	XX,YY **167**	XX,YY **171**
70 654 11601 / 70 654 11600	XX,YY **120**	XX,YY **820**	XX,YY **168**	XX,YY **170**
70 654 12001 / 70 654 12000	XX,YY **120**	XX,YY **820**	XX,YY **168**	XX,YY **170**
70 654 12501 / 70 654 12500	XX,YY **120**	XX,YY **820**	XX,YY **168**	XX,YY **170**
70 654 13201	XX,YY **120**	XX,YY **820**	XX,YY **168**	XX,YY **170**

MaxiLock-S – SSSC 45° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	NEW Left-hand 70 777 ... #CU# *PA*	NEW Right-hand 70 777 ... #CU# *PA*
SSSC R/L 1212 F09 DC	12	12	86.5	22	16.0	M6	M6	3,2	SC.. 09T3..	XX,YY **01201**	XX,YY **01200**
SSSC R/L 1616 H09 DC	16	16	106.5	30	20.0	M6	G1/8"	3,2	SC.. 09T3..	XX,YY **01601**	XX,YY **01600**
SSSC R/L 2020 K09 DC	20	20	131.5	30	25.0	M6	G1/8"	3,2	SC.. 09T3..	XX,YY **02001**	XX,YY **02000**
SSSC R/L 1616 H12 DC	16	16	108.5	30	20.0	M6	G1/8"	5	SC.. 1204..	XX,YY **11601**	XX,YY **11600**
SSSC R/L 2020 K12 DC	20	20	133.5	30	25.0	M6	G1/8"	5	SC.. 1204..	XX,YY **12001**	XX,YY **12000**
SSSC R/L 2525 M12 DC	25	25	158.5	32	32.0	M6	G1/8"	5	SC.. 1204..	XX,YY **02501**	XX,YY **02500**
SSSC L 3225 P 12 DC	32	25	178.5	32	32.1	G1/8"	G1/8"	5	SC.. 1204..	XX,YY **03201**	

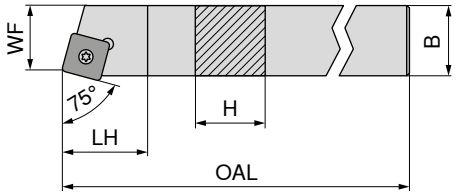
Spare parts for Article no.	 Clamping screw 70 950 ... #CU# *PA*	 Solid Carbide support S 70 950 ... #CU# *PA*	 Grubscrew 70 950 ... #CU# *PA*	 Grubscrew 70 950 ... #CU# *PA*	 Threaded sleeve 70 950 ... #CU# *PA*
70 777 01200 / 70 777 01201	XX,YY **859**			XX,YY **86700**	
70 777 01600 / 70 777 01601	XX,YY **87900**	XX,YY **167**	XX,YY **88000**	XX,YY **86700**	XX,YY **171**
70 777 02000 / 70 777 02001	XX,YY **87900**	XX,YY **167**	XX,YY **88000**	XX,YY **86700**	XX,YY **171**
70 777 11600 / 70 777 11601	XX,YY **820**	XX,YY **168**	XX,YY **88000**	XX,YY **86700**	XX,YY **170**
70 777 12000 / 70 777 12001	XX,YY **820**	XX,YY **168**	XX,YY **88000**	XX,YY **86700**	XX,YY **170**
70 777 02500 / 70 777 02501	XX,YY **820**	XX,YY **168**	XX,YY **88000**	XX,YY **86700**	XX,YY **170**
70 777 03201	XX,YY **820**	XX,YY **168**	XX,YY **88000**		XX,YY **170**

Spare parts for Article no.	 Sealing plugs DC 70 950 ... #CU# *PA*	Key D 80 950 ... #CU# *PA*	 O-Ring 70 950 ... #CU# *PA*	 Coolant nozzle DC 70 950 ... #CU# *PA*	 Coolant screw plug 70 950 ... #CU# *PA*
70 777 01200 / 70 777 01201		XX,YY **120**			
70 777 01600 / 70 777 01601	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 777 02000 / 70 777 02001	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 777 11600 / 70 777 11601	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 777 12000 / 70 777 12001	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 777 02500 / 70 777 02501	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 777 03201	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**

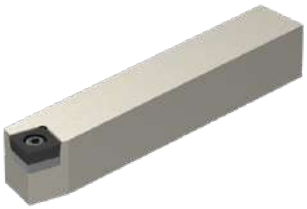
MaxiLock-S – SSBC 75° – Toolholder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions



NEW Left-hand **70 650 ...**

NEW Right-hand **70 650 ...**

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	#CU# *PA*		#CU# *PA*	
SSBC R/L 2020 K12	20	20	125	20	17	5	SC.. 1204..	XX,YY	**12000**	XX,YY	**12001**
SSBC R/L 2525 M12	25	25	150	20	22	5	SC.. 1204..	XX,YY	**12500**	XX,YY	**12501**


Key D


Clamping screw


Solid Carbide support S

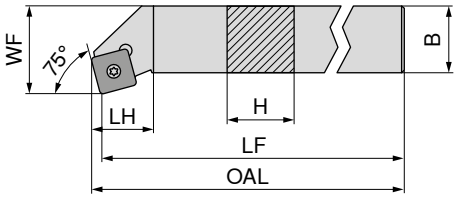

Threaded sleeve

Spare parts for Article no.	**80 950 ...** #CU# *PA*		**70 950 ...** #CU# *PA*		**70 950 ...** #CU# *PA*		**70 950 ...** #CU# *PA*	
70 650 12001 / 70 650 12000	XX,YY	**120**	XX,YY	**820**	XX,YY	**168**	XX,YY	**170**
70 650 12501 / 70 650 12500	XX,YY	**120**	XX,YY	**820**	XX,YY	**168**	XX,YY	**170**

MaxiLock-S – SSKC 75° – Toolholder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions

Left-hand **70 669 ...**

Right-hand **70 668 ...**

ISO designation	H mm	B mm	LF mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	#CU# *PA*		#CU# *PA*	
SSKC R/L 1616 H09	16	16	100	102.3	22	20	3,2	SC.. 09T3..	XX,YY	**016**	XX,YY	**016**
SSKC R/L 2020 K09	20	20	125	127.3	22	25	3,2	SC.. 09T3..	XX,YY	**020**	XX,YY	**020**
SSKC R 2020 K12	20	20	125	127.3	23	25	5	SC.. 1204..			XX,YY	**120**
SSKC R 2525 M12	25	25	150	153.3	23	32	5	SC.. 1204..			XX,YY	**125**


Key D


Combination Key


Clamping screw


Solid Carbide support S

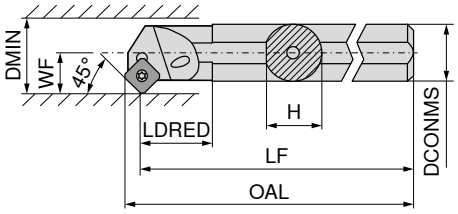

Threaded sleeve

Spare parts for Article no.	**80 950 ...** #CU# *PA*		**70 950 ...** #CU# *PA*		**70 950 ...** #CU# *PA*		**70 950 ...** #CU# *PA*		**70 950 ...** #CU# *PA*	
70 668 016 / 70 669 016	XX,YY	**113**	XX,YY	**398**	XX,YY	**113**	XX,YY	**167**	XX,YY	**171**
70 668 020 / 70 669 020	XX,YY	**113**	XX,YY	**398**	XX,YY	**113**	XX,YY	**167**	XX,YY	**171**
70 668 120	XX,YY	**113**	XX,YY	**398**	XX,YY	**114**	XX,YY	**168**	XX,YY	**170**
70 668 125	XX,YY	**113**	XX,YY	**398**	XX,YY	**114**	XX,YY	**168**	XX,YY	**170**

MaxiLock-S – SSSC 45° – Boring bar with screw clamping

▲ A... = with thro' coolant
▲ S... = without thro' coolant

Scope of supply:
Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	LF mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 721 ... #CU# *PA*		Right-hand 70 720 ... #CU# *PA*	
S16R SSSC R 09	16	15.00	200	206.0	13.97	11	20	3,2	SC.. 09T3..			XX,YY	**016**
A16M SSSC R/L 09	16	15.25	150	156.0	29.00	11	20	3,2	SC.. 09T3..	XX,YY	**216**	XX,YY	**216**
A20Q SSSC R/L 09	20	19.00	180	186.0	32.00	13	25	3,2	SC.. 09T3..	XX,YY	**220**	XX,YY	**220**
A25R SSSC R/L 09	25	24.50	200	206.0	36.00	17	32	3,2	SC.. 09T3..	XX,YY	**225**	XX,YY	**225**
A32S SSSC R/L 12	32	31.00	250	258.3	50.00	22	40	5	SC.. 1204..	XX,YY	**232**	XX,YY	**232**
A40T SSSC R/L 12	40	39.00	300	308.1	60.00	27	50	5	SC.. 1204..	XX,YY	**240**	XX,YY	**240**


Key D


Combination Key


Clamping screw

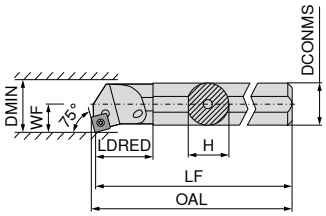

Solid Carbide support S


Threaded sleeve

Spare parts for Article no.	80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 720 016	XX,YY	**113**			XX,YY	**110**				
70 720 216 / 70 721 216	XX,YY	**113**			XX,YY	**110**				
70 720 220 / 70 721 220	XX,YY	**113**			XX,YY	**304**				
70 720 225 / 70 721 225	XX,YY	**113**			XX,YY	**304**				
70 720 232 / 70 721 232			XX,YY	**398**	XX,YY	**114**	XX,YY	**168**	XX,YY	**170**
70 720 240 / 70 721 240			XX,YY	**398**	XX,YY	**114**	XX,YY	**168**	XX,YY	**170**

MaxiLock-S – SSKC 75° – Boring bar with screw clamping

Scope of supply:
Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	LF mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 725 ... #CU# *PA*		Right-hand 70 724 ... #CU# *PA*	
A16M SSKC R/L 09	16	15.0	150	152.4	29	11	20	3,2	SC.. 09T3..	XX,YY	**216**	XX,YY	**216**
A20Q SSKC R/L 09	20	18.5	180	182.4	32	13	25	3,2	SC.. 09T3..	XX,YY	**220**	XX,YY	**220**
A25R SSKC R/L 09	25	23.0	200	202.4	36	17	32	3,2	SC.. 09T3..	XX,YY	**225**	XX,YY	**225**


Key D

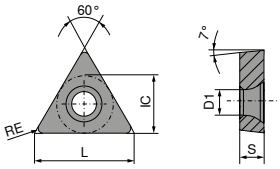

Clamping screw

Spare parts for Article no.		80 950 ... #CU# *PA*			70 950 ... #CU# *PA*	
70 724 216 / 70 725 216	T15	XX,YY	**113**	M3,5x7,2	XX,YY	**110**
70 724 220	T15	XX,YY	**113**	M3,5x8,6	XX,YY	**304**
70 725 220	T15	XX,YY	**113**	M3,5x8,6	XX,YY	**304**
70 724 225 / 70 725 225	T15	XX,YY	**113**	M3,5x8,6	XX,YY	**304**

9

TCGT / TCMT

Designation	L mm	S mm	D1 mm	IC mm
TCMT 0902..	9.6	2.38	2.50	5.56
TC.T 1102..	11.0	2.38	2.80	6.35
TC.T 16T3..	16.5	3.97	4.40	9.52
TCMT 2204..	22.0	4.76	5.16	12.70



TCGT / TCMT

		NEW	NEW	NEW
	-CF05 CTEP110	**-CF55** CTEP110	**-SF** TCM10	**-SMF** TCM10	**-SF** CTCP125-P	**-SMF** CTCP115-P	**-SMF** CTCP135-P
	DRAGONSKIN	DRAGONSKIN			DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
	F	**F**	**F**	**F**	**F**	**F**	**F**
	CERMET TCGT	**CERMET** TCMT	**CERMET** TCGT	**CERMET** TCMT	TCMT	TCMT	TCMT
	76 272 ...	**76 266 ...**	**70 273 ...**	**70 284 ...**	**76 275 ...**	**76 284 ...**	**76 284 ...**

ISO	RE mm	#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
110202EN	0.2	XX,YY	**014**			XX,YY	**900**								
110204EN	0.4	XX,YY	**016**	XX,YY	**016**	XX,YY	**902**	XX,YY	**902**	XX,YY	**51601**				
110208EN	0.8	XX,YY	**018**							XX,YY	**51801**	XX,YY	**31801**	XX,YY	**71801**
16T304EN	0.4	XX,YY	**028**			XX,YY	**906**			XX,YY	**52801**	XX,YY	**32801**		
16T308EN	0.8			XX,YY	**030**					XX,YY	**53001**	XX,YY	**33001**		
P		●		●		●		●		●		●		●	
M		○		○		○		○						○	
K		○		○		○		○		○		○			
N															
S															
H															
O															

TCGT / TCMT

		NEW			NEW	NEW	NEW	NEW
		-SM CTCP135-P	-SM CTCK110	-SM CTCK120	-SM CTCP115-P	-SM CTCP115-P	-SM CTCP125-P	-SM CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		M TCGT	M TCMT	M TCMT	M TCMT	M TCMT	M TCMT	M TCMT
		76 270 ...	70 274 ...	70 274 ...	76 189 ...	76 274 ...	76 274 ...	76 274 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
090204EN	0.4						XX,YY 50401	XX,YY 70401
110202EN	0.2	XX,YY 71401						
110204EN	0.4		XX,YY 016	XX,YY 516		XX,YY 31601	XX,YY 51601	XX,YY 71601
110208EN	0.8		XX,YY 018	XX,YY 518		XX,YY 31801		XX,YY 71801
16T304EN	0.4		XX,YY 028	XX,YY 528		XX,YY 32801	XX,YY 52801	XX,YY 72801
16T308EN	0.8		XX,YY 030	XX,YY 530		XX,YY 33001	XX,YY 53001	XX,YY 73001
16T312EN	1.2		XX,YY 032	XX,YY 532				
220408EN	0.8				XX,YY 34201		XX,YY 54201	XX,YY 74201
P		●	○	○	●	●	●	●
M		○						○
K			●	●	○	○	○	
N								
S								
H								
O								

9

TCMT

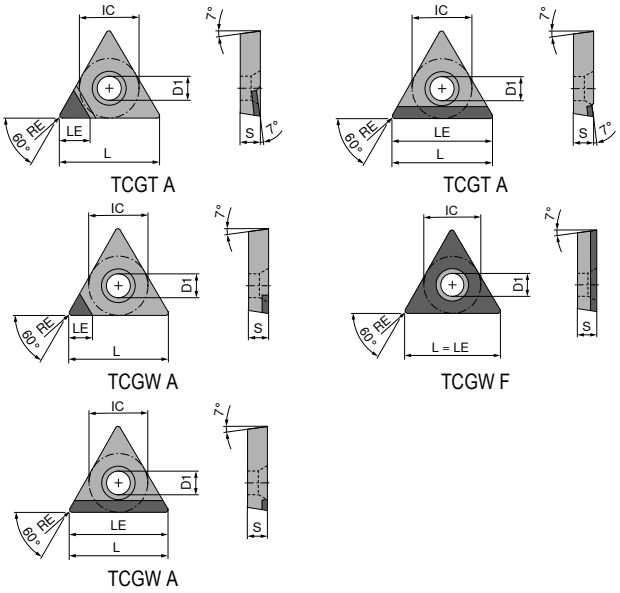
		-M25 CTCM120	-M25 CTPM125	-M25 CTCM130	-M55 CTCM120	-M55 CTPM125	-M55 CTCM130
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
		F TCMT	F TCMT	F TCMT	M TCMT	M TCMT	M TCMT
		75 217 ...	75 217 ...	75 217 ...	75 218 ...	75 218 ...	75 218 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
090204EN	0.4		XX,YY 20400		XX,YY 10400	XX,YY 204	XX,YY 30400
110204EN	0.4	XX,YY 11600	XX,YY 216	XX,YY 31600	XX,YY 11600	XX,YY 216	XX,YY 31600
16T304EN	0.4	XX,YY 12800	XX,YY 228	XX,YY 32800			
16T308EN	0.8	XX,YY 13000	XX,YY 230	XX,YY 33000	XX,YY 13000	XX,YY 230	XX,YY 33000
P		○	○	○	○	○	○
M		●	●	●	●	●	●
K							
N							
S				○			○
H							
O							

TCGT

		-27 H10T		-27 CTPX715	
				DRAGONSKIN	
					
		M		M	
		TCGT		TCGT	
		70 276 ...		70 276 ...	
ISO	RE mm	#CU# *PA*		#CU# *PA*	
110202FN	0.2	XX,YY	600	XX,YY	71400
110204FN	0.4	XX,YY	602	XX,YY	81600
16T302FN	0.2	XX,YY	604		
16T304FN	0.4	XX,YY	606	XX,YY	72800
16T308FN	0.8	XX,YY	608	XX,YY	83000
P					●
M					●
K			○		○
N			●		●
S					●
H					
O			○		○

TCGW / TCGT

Designation	L mm	S mm	D1 mm	IC mm
TCG. 0902..	9.6	2.38	2.5	5.56
TCG. 1102..	11.0	2.38	2.8	6.35
TCG. 16T3..	16.5	3.97	4.4	9.52



TCGW / TCGT

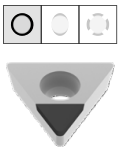
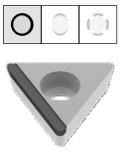
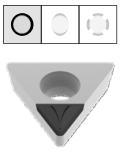
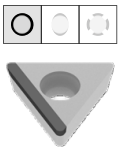
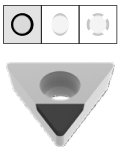
▲ TCE(NOI) = Design and number of equipped cutting edge corners

				CTDPD20		CTDPD20		CTDPD20		CTDPD20		-CB1 CTDPD20		CTDPS30	
				F		F		F		F		F		F	
				DIAMOND TCGW		DIAMOND TCGW		DIAMOND TCGW		DIAMOND TCGT		DIAMOND TCGT		DIAMOND TCGT	
				71 188 ...		71 187 ...		71 140 ...		71 184 ...		71 325 ...		71 184 ...	
ISO	RE mm	TCE (NOI)	LE mm	#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
090202FN	0.2	A (1)	3.7					XX,YY	100			XX,YY	112	XX,YY	20001
090204FN	0.4	A (1)	3.4					XX,YY	102			XX,YY	114	XX,YY	20101
090208FN	0.8	A (1)	3.0					XX,YY	104	XX,YY	10001				
090208FN	0.8	A (1)	9.6	XX,YY	10001										
110202FN	0.2	A (1)	3.7					XX,YY	106	XX,YY	10101	XX,YY	122		
110202FN	0.2	F	11.0			XX,YY	10001								
110204FN	0.4	A (1)	3.4					XX,YY	108	XX,YY	10201	XX,YY	124	XX,YY	20201
110204FN	0.4	F	11.0			XX,YY	10101								
110204FN	0.4	A (1)	11.0	XX,YY	10101										
110208FN	0.8	A (1)	3.0					XX,YY	110	XX,YY	10301				
110208FN	0.8	A (1)	11.0	XX,YY	10201										
16T304FN	0.4	A (1)	4.6					XX,YY	112	XX,YY	10401	XX,YY	134	XX,YY	20301
16T304FN	0.4	A (1)	16.5	XX,YY	10301										
16T308FN	0.8	A (1)	4.2					XX,YY	114	XX,YY	10501	XX,YY	13600		
16T308FN	0.8	A (1)	16.5	XX,YY	10401										
16T312FN	1.2	A (1)	3.8					XX,YY	11600						
P															
M															
K															
N				●		●		●		●		●		●	
S															
H															
O				●		●		●		●		●		●	

9

TCGW / TCGT

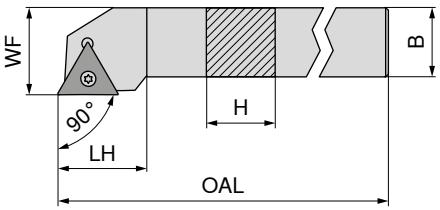
▲ TCE(NOI) = Design and number of equipped cutting edge corners

				CTDPS30		CTDPS30		-CB2 CTDPS30		CTDPU20		-CB3 CTDPU20		CTDCD10	
															
				F DIAMOND TCGW		F DIAMOND TCGT		M DIAMOND TCGT		F DIAMOND TCGW		R DIAMOND TCGT		F DIAMOND TCGW	
				71 186 ...		71 185 ...		71 326 ...		71 188 ...		71 327 ...		71 186 ...	
ISO	RE mm	TCE (NOI)	LE mm	#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
090202FN	0.2	A (1)	3.7	XX,YY	20001			XX,YY	212						
090204FN	0.4	A (1)	3.4					XX,YY	214						
090204FN	0.4	A (1)	9.6			XX,YY	20001								
110202FN	0.2	A (1)	2.6											XX,YY	40001
110202FN	0.2	A (1)	3.7	XX,YY	20101			XX,YY	222						
110204FN	0.4	A (1)	2.3											XX,YY	40101
110204FN	0.4	A (1)	3.4	XX,YY	20201			XX,YY	224			XX,YY	224		
110204FN	0.4	A (1)	11.0			XX,YY	20101			XX,YY	30001				
110208FN	0.8	A (1)	2.0											XX,YY	40201
110208FN	0.8	A (1)	11.0			XX,YY	20201								
16T304FN	0.4	A (1)	2.3											XX,YY	40301
16T304FN	0.4	A (1)	4.6					XX,YY	234						
16T304FN	0.4	A (1)	16.5			XX,YY	20301								
16T308FN	0.8	A (1)	2.0											XX,YY	40401
16T308FN	0.8	A (1)	4.2									XX,YY	238		
16T308FN	0.8	A (1)	16.5			XX,YY	20401								
P															
M															
K															
N				●		●		●		●		●		●	
S															
H															
O				●		●		●		●		●		●	

MaxiLock-S – STGC 90° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	NEW Left-hand 70 659 ... #CU# *PA*	NEW Right-hand 70 659 ... #CU# *PA*
STGC R/L 1212 F11	12	12	80	15	16	1,2	TC.. 1102	XX,YY **01200**	XX,YY **01201**
STGC R/L 1616 H16	16	16	100	22	20	3,2	TC.. 16T3	XX,YY **01600**	XX,YY **01601**
STGC R/L 2020 K16	20	20	125	22	25	3,2	TC.. 16T3	XX,YY **02000**	XX,YY **02001**
STGC R/L 2525 M16	25	25	150	22	32	3,2	TC.. 16T3	XX,YY **02500**	XX,YY **02501**

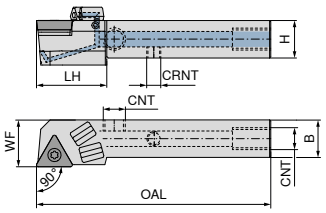
Spare parts for Article no.	 Key D 80 950 ... #CU# *PA*	 Clamping screw 70 950 ... #CU# *PA*	 Solid Carbide Seat T 70 950 ... #CU# *PA*	 Threaded sleeve 70 950 ... #CU# *PA*
70 659 01201 / 70 659 01200	XX,YY **039**	XX,YY **857**		
70 659 01601 / 70 659 01600	XX,YY **120**	XX,YY **87900**	XX,YY **169**	XX,YY **171**
70 659 02001 / 70 659 02000	XX,YY **120**	XX,YY **87900**	XX,YY **169**	XX,YY **171**
70 659 02501 / 70 659 02500	XX,YY **120**	XX,YY **87900**	XX,YY **169**	XX,YY **171**

9

MaxiLock-S – STGC 90° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	NEW Left-hand 70 778 ... #CU# *PA*	NEW Right-hand 70 778 ... #CU# *PA*
STGC R/L 1212 F11 DC	12	12	80	17.1	16	M6	M6	1,2	TC.. 1102	XX,YY **01201**	XX,YY **01200**
STGC R/L 1616 H16 DC	16	16	100	30.0	20	M6	G1/8"	3,2	TC.. 16T3	XX,YY **01601**	XX,YY **01600**
STGC R/L 2020 K16 DC	20	20	125	28.0	25	M6	G1/8"	3,2	TC.. 16T3	XX,YY **02001**	XX,YY **02000**
STGC R/L 2525 M16 DC	25	25	150	30.0	32	M6	G1/8"	3,2	TC.. 16T3	XX,YY **02501**	XX,YY **02500**

Spare parts for Article no.	Clamping screw 70 950 ... #CU# *PA*	Solid Carbide Seat T 70 950 ... #CU# *PA*	Grubscrew 70 950 ... #CU# *PA*	Grubscrew 70 950 ... #CU# *PA*	Threaded sleeve 70 950 ... #CU# *PA*
70 778 01200 / 70 778 01201	XX,YY **857**			XX,YY **86700**	
70 778 01600 / 70 778 01601	XX,YY **87900**	XX,YY **169**	XX,YY **88000**	XX,YY **86700**	XX,YY **171**
70 778 02000 / 70 778 02001	XX,YY **87900**	XX,YY **169**	XX,YY **88000**	XX,YY **86700**	XX,YY **171**
70 778 02500 / 70 778 02501	XX,YY **87900**	XX,YY **169**	XX,YY **88000**	XX,YY **86700**	XX,YY **171**

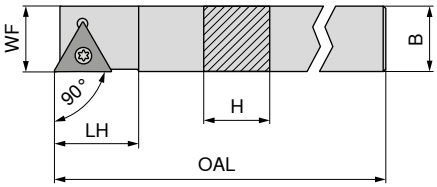
Spare parts for Article no.	Sealing plugs DC 70 950 ... #CU# *PA*	Key D 80 950 ... #CU# *PA*	O-Ring 70 950 ... #CU# *PA*	Coolant nozzle DC 70 950 ... #CU# *PA*	Coolant screw plug 70 950 ... #CU# *PA*
70 778 01200 / 70 778 01201		XX,YY **039**			
70 778 01600 / 70 778 01601	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 778 02000 / 70 778 02001	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 778 02500 / 70 778 02501	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**

MaxiLock-S – STAC 90° – Toolholder with screw clamping

▲ for sliding head lathes

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	NEW Left-hand 70 655 ... #CU# *PA*		NEW Right-hand 70 655 ... #CU# *PA*	
STAC R/L 1212 K11	12	12	125	15	12	1,2	TC.. 1102	XX,YY	**01200**	XX,YY	**01201**

Key D

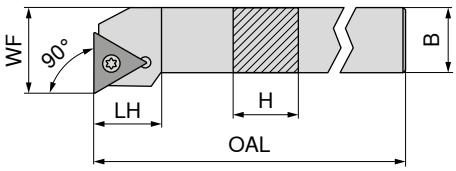
Clamping screw

Spare parts for Article no.	80 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 655 01201 / 70 655 01200	T08 - IP XX,YY	**039**	M2,5x6 - IP XX,YY	**857**

MaxiLock-S – STFC 90° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	NEW Left-hand 70 658 ... #CU# *PA*		NEW Right-hand 70 658 ... #CU# *PA*	
STFC R/L 1212 F11	12	12	80	15	16	1,2	TC.. 1102	XX,YY	**01200**	XX,YY	**01201**
STFC R/L 1616 H16	16	16	100	20	20	3,2	TC.. 16T3	XX,YY	**01600**	XX,YY	**01601**
STFC R/L 2020 K16	20	20	125	20	25	3,2	TC.. 16T3	XX,YY	**02000**	XX,YY	**02001**
STFC R/L 2525 M16	25	25	150	20	32	3,2	TC.. 16T3	XX,YY	**02500**	XX,YY	**02501**

Key D

Clamping screw

Solid Carbide Seat T

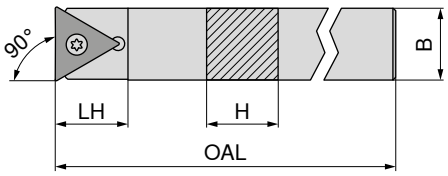
Threaded sleeve

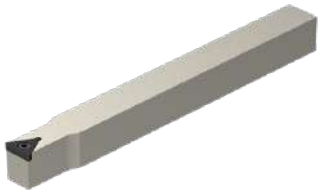
Spare parts for Article no.	80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 658 01200 / 70 658 01201	XX,YY	**039**	XX,YY	**857**				
70 658 01600 / 70 658 01601	XX,YY	**120**	XX,YY	**87900**	XX,YY	**169**	XX,YY	**171**
70 658 02000 / 70 658 02001	XX,YY	**120**	XX,YY	**87900**	XX,YY	**169**	XX,YY	**171**
70 658 02500 / 70 658 02501	XX,YY	**120**	XX,YY	**87900**	XX,YY	**169**	XX,YY	**171**

9

MaxiLock-S – STCC 90° – Toolholder with screw clamping

Scope of supply:
Tool holder with Torx key





NEW
Neutral

ISO designation	H mm	B mm	OAL mm	LH mm	torque moment Nm	Insert	70 657 ... #CU# *PA*	
STCC N 0808 K09	8	8	125	11	1	TC.. 0902	XX,YY	**00800**
STCC N 1010 K11	10	10	125	15	1,2	TC.. 1102	XX,YY	**01000**
STCC N 1212 K11	12	12	125	15	1,2	TC.. 1102	XX,YY	**01200**
STCC N 1414 K11	14	14	125	21	1,2	TC.. 1102	XX,YY	**01400**
STCC N 1616 K11	16	16	125	24	1,2	TC.. 1102	XX,YY	**01600**

Key D

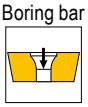
Clamping screw

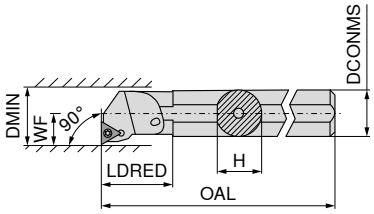
Spare parts for Article no.	80 950 ...	#CU# *PA*		70 950 ...	#CU# *PA*	
70 657 00800	T07 - IP	XX,YY	**117**	M2,2x5 - IP	XX,YY	**856**
70 657 01000	T08 - IP	XX,YY	**039**	M2,5x6 - IP	XX,YY	**857**
70 657 01200	T08 - IP	XX,YY	**039**	M2,5x6 - IP	XX,YY	**857**
70 657 01400	T08 - IP	XX,YY	**039**	M2,5x6 - IP	XX,YY	**857**
70 657 01600	T08 - IP	XX,YY	**039**	M2,5x6 - IP	XX,YY	**857**

MaxiLock-S – STFC 90° – Boring bar with screw clamping

▲ A... = with thro' coolant
▲ S... = without thro' coolant

Scope of supply:
Boring bar with Torx key





Illustrations show right-hand versions

									Left-hand		Right-hand	
									70 729 ...		**70 728 ...**	
ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	#CU# *PA*		#CU# *PA*	
A10H STFC R/L 09	10	9.5	100	19	7	13	1	TC.. 0902	XX,YY	**210**	XX,YY	**210**
A12K STFC R/L 11	12	11.5	125	22	9	16	1,2	TC.. 1102	XX,YY	**212**	XX,YY	**212**
A16M STFC R/L 11	16	15.0	150	29	11	20	1,2	TC.. 1102	XX,YY	**216**	XX,YY	**216**
S16R STFC R 11	16	15.0	200	21	11	21	1,2	TC.. 1102			XX,YY	**016**
S20S STFC R 11	20	18.0	250	15	13	25	1,2	TC.. 1102			XX,YY	**020**
A20Q STFC R/L 11	20	18.5	180	32	13	25	1,2	TC.. 1102	XX,YY	**220**	XX,YY	**220**
A25R STFC R/L 16	25	24.0	200	36	17	32	3,2	TC.. 16T3	XX,YY	**225**	XX,YY	**225**
A32S STFC R/L 16	32	31.0	250	50	22	40	3,2	TC.. 16T3	XX,YY	**232**	XX,YY	**232**
A40T STFC R/L 16	40	39.0	300	60	27	50	3,2	TC.. 16T3	XX,YY	**240**	XX,YY	**240**

Clamping screw

Solid Carbide Seat T

Threaded sleeve

			70 950 ...		**70 950 ...**			**70 950 ...**		
Spare parts for Article no.		#CU# *PA*			#CU# *PA*			#CU# *PA*	
70 728 020	M2,5x6 - T08	XX,YY	**13800**						
70 729 210 / 70 728 210	M2,2x5	XX,YY	**111**						
70 728 016	M2,5x6 - T08	XX,YY	**13800**						
70 729 212 / 70 728 212	M2,5x6 - T08	XX,YY	**13800**						
70 729 216 / 70 728 216	M2,5x6 - T08	XX,YY	**13800**						
70 729 220 / 70 728 220	M2,5x6 - T08	XX,YY	**13800**						
70 729 225 / 70 728 225	M3,5x11	XX,YY	**113**	XX,YY	**169**	M3,5	XX,YY	**171**
70 729 232 / 70 728 232	M3,5x11	XX,YY	**113**	XX,YY	**169**	M3,5	XX,YY	**171**
70 729 240 / 70 728 240	M3,5x11	XX,YY	**113**	XX,YY	**169**	M3,5	XX,YY	**171**

Key D

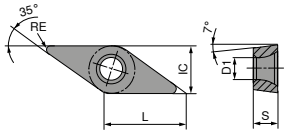
Combination Key

		80 950 ...			**70 950 ...**	
Spare parts for Article no.		#CU# *PA*			#CU# *PA*	
70 728 020	T08	XX,YY	**110**			
70 729 210 / 70 728 210	T07	XX,YY	**109**			
70 728 016	T08	XX,YY	**110**			
70 729 212 / 70 728 212	T08	XX,YY	**110**			
70 729 216 / 70 728 216	T08	XX,YY	**110**			
70 729 220 / 70 728 220	T08	XX,YY	**110**			
70 729 225 / 70 728 225				T15/SW	XX,YY	**398**
70 729 232 / 70 728 232				T15/SW	XX,YY	**398**
70 729 240 / 70 728 240				T15/SW	XX,YY	**398**

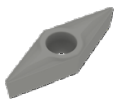
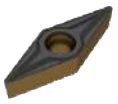
9

VCGT / VCMT / VCET

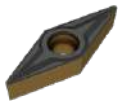
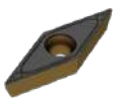
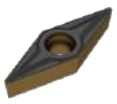
Designation	L mm	S mm	D1 mm	IC mm
VC.T 1103..	11.1	3.18	2.9	6.35
VC.T 1604..	16.6	4.76	4.4	9.52
VCGT 2205..	22.1	5.56	5.5	12.70



VCGT / VCMT

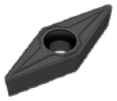
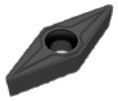
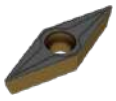
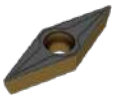
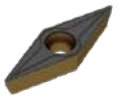
		-CF05 CTEP110	-CF55 CTEP110	-SF TCM407	-SF TCM10	-SMF TCM10	NEW -SF CTCP115-P	NEW -SF CTCP115-P
		DRAGONSKIN	DRAGONSKIN		DRAGONSKIN		DRAGONSKIN	DRAGONSKIN
								
		F	F	F	F	F	F	F
		CERMET VCGT	CERMET VCMT	CERMET VCGT	CERMET VCGT	CERMET VCMT	VCMT	VCGT
		76 276 ...	76 292 ...	70 277 ...	70 277 ...	70 288 ...	76 279 ...	76 277 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
110301EN	0,1				XX,YY 892			
110302EN	0,2	XX,YY 014		XX,YY 844	XX,YY 894			XX,YY 31401
110304EN	0,4	XX,YY 016	XX,YY 016	XX,YY 846	XX,YY 896	XX,YY 896		XX,YY 31601
110308EN	0,8							XX,YY 31801
160404EN	0,4	XX,YY 028	XX,YY 028	XX,YY 850	XX,YY 900	XX,YY 900	XX,YY 32801	
160408EN	0,8	XX,YY 030	XX,YY 030		XX,YY 902	XX,YY 902	XX,YY 33001	
P		●	●	●	●	●	●	●
M		○	○	○	○	○		
K		○	○	○	○	○	○	○
N								
S								
H								
O								

VCGT / VCMT

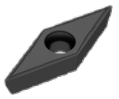
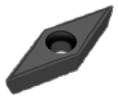
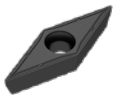
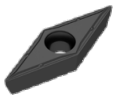
		NEW -SF CTCP125-P	NEW -SF CTCP125-P	NEW -SF CTCP135-P	NEW -SF CTCP135-P	NEW -SMF CTCP115-P	NEW -SMF CTCP125-P	NEW -SMF CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
								
		F	F	F	F	F	F	F
		VCGT	VCMT	VCGT	VCMT	VCMT	VCMT	VCGT
		76 277 ...	76 279 ...	76 277 ...	76 279 ...	76 288 ...	76 288 ...	76 285 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
110302EN	0.2	XX,YY 51401		XX,YY 71401				XX,YY 71401
110304EN	0.4	XX,YY 51601		XX,YY 71601		XX,YY 31601	XX,YY 51601	
110308EN	0.8	XX,YY 51801		XX,YY 71801				
160404EN	0.4		XX,YY 52801		XX,YY 72801	XX,YY 32801	XX,YY 52801	
160408EN	0.8		XX,YY 53001			XX,YY 33001	XX,YY 53001	
P		●	●	●	●	●	●	●
M				○	○			○
K		○	○			○	○	
N								
S								
H								
O								

→ vc Page 186–199

VCMT

		NEW			NEW	NEW	NEW
		-SMF CTCP135-P	-SM CTCK110	-SM CTCK120	-SM CTCP115-P	-SM CTCP125-P	-SM CTCP135-P
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
		F	M	M	M	M	M
		VCMT	VCMT	VCMT	VCMT	VCMT	VCMT
		76 288 ...	70 278 ...	70 278 ...	76 278 ...	76 278 ...	76 278 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
110304EN	0.4	XX,YY 71601					
160404EN	0.4	XX,YY 72801	XX,YY 028	XX,YY 528	XX,YY 32801	XX,YY 52801	XX,YY 72801
160406EN	0.6				XX,YY 32901		
160408EN	0.8	XX,YY 73001	XX,YY 030	XX,YY 530	XX,YY 33001	XX,YY 53001	XX,YY 73001
160412EN	1.2		XX,YY 032	XX,YY 532	XX,YY 33201	XX,YY 53201	XX,YY 73201
P		●	○	○	●	●	●
M		○					○
K			●	●	○	○	
N							
S							
H							
O							

VCMT

		-M25 CTCM120	-M25 CTPM125	-M25 CTCM130	-M55 CTCM120	-M55 CTPM125	-M55 CTCM130
		DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
							
		F	F	F	M	M	M
		VCMT	VCMT	VCMT	VCMT	VCMT	VCMT
		75 219 ...	75 219 ...	75 219 ...	75 220 ...	75 220 ...	75 220 ...
ISO	RE mm	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
160404EN	0.4	XX,YY 12800	XX,YY 228	XX,YY 32800	XX,YY 12800	XX,YY 228	XX,YY 32800
160408EN	0.8	XX,YY 13000	XX,YY 23000	XX,YY 33000	XX,YY 13000	XX,YY 230	XX,YY 33000
P		○	○	○	○	○	○
M		●	●	●	●	●	●
K							
N							
S				○			○
H							
O							

9

VCGT

ISO	RE mm	-25P H210T		-25P CTPX710		-25Q H210T		-25Q CTPX710 NEW		-27 H10T		-27 CTPX715	
				DRAGONSKIN								DRAGONSKIN	
													
		F VCGT 70 282 ...		M VCGT 70 282 ...		M VCGT 70 282 ...		M VCGT 70 282 ...		M VCGT 70 280 ...		M VCGT 70 280 ...	
		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
110302FN	0.2	XX,YY	638	XX,YY	71400					XX,YY	606	XX,YY	81400
110304FL	0.4					XX,YY	670	XX,YY	81600				
110304FN	0.4	XX,YY	640	XX,YY	71600					XX,YY	608	XX,YY	81600
110304FR	0.4					XX,YY	680	XX,YY	81700				
110308FN	0.8									XX,YY	610	XX,YY	71800
160404FN	0.4	XX,YY	642	XX,YY	72800					XX,YY	612	XX,YY	82800
160408FN	0.8	XX,YY	644	XX,YY	73000					XX,YY	614	XX,YY	83000
160412FN	1.2	XX,YY	646	XX,YY	73200					XX,YY	616		
220530FN	3.0	XX,YY	648	XX,YY	75000					XX,YY	618		
P				●				●				●	
M				●				●				●	
K		○				○				○		○	
N		●		●		●		●		●		●	
S		○		●		○		●				●	
H													
O		○				○				○		○	

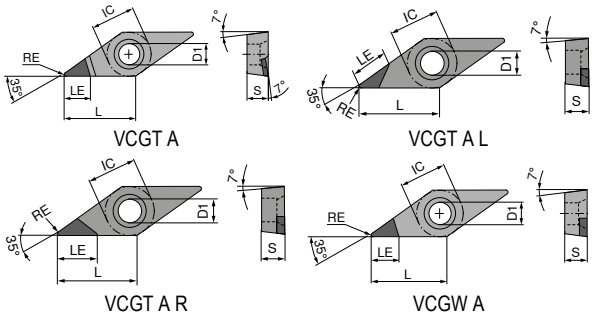
VCET / VCMT

ISO	RE mm	-F05 CTPX710		-29 H216T		-29 CTPX715 NEW	
		DRAGONSKIN				DRAGONSKIN	
							
		F VCET 76 255 ...		M VCMT 70 247 ...		M VCMT 70 247 ...	
		#CU# *PA*		#CU# *PA*		#CU# *PA*	
1103005FN	0.05	XX,YY	11400				
110301FN	0.10	XX,YY	11600				
1103015FN	0.15	XX,YY	11800				
110302FN	0.20	XX,YY	12000				
110304FN	0.40	XX,YY	12200				
160404EN	0.40			XX,YY	62800	XX,YY	72800
160408EN	0.80			XX,YY	63000	XX,YY	73000
160412EN	1.20			XX,YY	63200	XX,YY	73200
P		●				●	
M		●				●	
K				○		○	
N		●		●		●	
S		●				●	
H							
O				○		○	

→ vc Page 186–199

VCGT / VCGW

Designation	L mm	S mm	D1 mm	IC mm
VCG. 0702..	6.9	2.38	2.2	3.97
VCG. 1103..	11.1	3.18	2.9	6.35
VCG. 1303..	13.3	3.18	3.4	7.94
VCG. 1604..	16.6	4.76	4.4	9.52



VCGT / VCGW

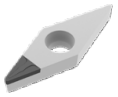
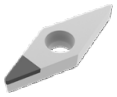
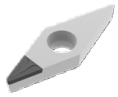
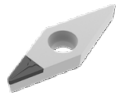
▲ TCE(NOI) = Design and number of equipped cutting edge corners

				CTDMD05		CTDMD05		CTDPD20		CTDPD20		CTDPD20		CTDPD20	
				F		F		F		F		F		F	
				DIAMOND VCGT		DIAMOND VCGW		DIAMOND VCGW		DIAMOND VCGT		DIAMOND VCGT		DIAMOND VCGT	
				71 189 ...		71 160 ...		71 160 ...		71 062 ...		71 063 ...		71 064 ...	
ISO	RE mm	TCE (NOI)	LE mm	#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
070202FN	0.2	A (1)		XX,YY	50001										
070204FN	0.4	A (1)		XX,YY	50101										
110301FN	0.1	A (1)	5.4							XX,YY	10100				
110302FN	0.2	A (1)	3.0			XX,YY	050								
110302FN	0.2	A (1)	4.6	XX,YY	50201			XX,YY	100	XX,YY	100				
110304FN	0.4	A (1)	3.0			XX,YY	052								
110304FN	0.4	A (1)	3.9	XX,YY	50301			XX,YY	102	XX,YY	102				
110304FR	0.4	A (1)	6.5									XX,YY	102		
110304FL	0.4	A (1)	6.5											XX,YY	102
110308FN	0.8	A (1)	3.3					XX,YY	104	XX,YY	104				
110308FR	0.8	A (1)	6.0									XX,YY	104		
110308FL	0.8	A (1)	6.0											XX,YY	104
160401FN	0.1	A (1)	6.0							XX,YY	10700				
160402FN	0.2	A (1)	5.9					XX,YY	105	XX,YY	105				
160402FN	0.2	A (1)		XX,YY	50401										
160404FN	0.4	A (1)	5.5					XX,YY	106	XX,YY	106				
160404FN	0.4	A (1)		XX,YY	50501										
160404FR	0.4	A (1)	7.5									XX,YY	106		
160404FL	0.4	A (1)	7.5											XX,YY	106
160408FN	0.8	A (1)	5.0			XX,YY	07800	XX,YY	108	XX,YY	108				
160408FR	0.8	A (1)	7.0									XX,YY	108		
160408FL	0.8	A (1)	7.0											XX,YY	108
160408FN	0.8	A (1)		XX,YY	50601										
160412FN	1.2	A (1)	4.5					XX,YY	110	XX,YY	110				
160412FR	1.2	A (1)	7.0									XX,YY	110		
160412FL	1.2	A (1)	7.0											XX,YY	110
P															
M															
K															
N				●		●		●		●		●		●	
S															
H															
O				●		●		●		●		●		●	

9

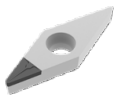
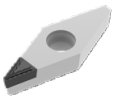
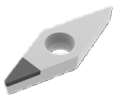
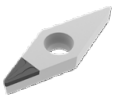
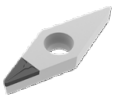
VCGT / VCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners

				-CB1 CTDPD20		CTDPS30		CTDPS30		-CB1 CTDPS30		-CB2 CTDPS30		CTDPU20	
															
				F		F		F		F		M		F	
				DIAMOND VCGT		DIAMOND VCGW		DIAMOND VCGT		DIAMOND VCGT		DIAMOND VCGT		DIAMOND VCGW	
				71 330 ...		71 191 ...		71 189 ...		71 330 ...		71 331 ...		71 191 ...	
ISO	RE mm	TCE (NOI)	LE mm	#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
070201FN	0.1	A (1)	3.8					XX,YY	20001						
070202FN	0.2	A (1)	3.6			XX,YY	20001								
070204FN	0.4	A (1)	3.2			XX,YY	20101								
110301FN	0.1	A (1)	5.4	XX,YY	11000	XX,YY	20201	XX,YY	20101						
110302FN	0.2	A (1)	4.6	XX,YY	112	XX,YY	20301	XX,YY	20201	XX,YY	21200	XX,YY	212		
110304FN	0.4	A (1)	3.9	XX,YY	114	XX,YY	20401	XX,YY	20301	XX,YY	214	XX,YY	214		
110308FN	0.8	A (1)	3.3									XX,YY	21800		
130302FN	0.2	A (1)	5.9			XX,YY	20501	XX,YY	20401						
160401FN	0.1	A (1)	6.0			XX,YY	20601	XX,YY	20501						
160402FN	0.2	A (1)	5.9	XX,YY	13200			XX,YY	20601			XX,YY	23200		
160404FN	0.4	A (1)	5.5	XX,YY	134	XX,YY	20701	XX,YY	20701	XX,YY	234	XX,YY	234	XX,YY	30001
160408FN	0.8	A (1)	5.0	XX,YY	138	XX,YY	20801			XX,YY	238	XX,YY	238		
160412FN	1.2	A (1)	4.5	XX,YY	14000	XX,YY	20901			XX,YY	24000	XX,YY	242		
P															
M															
K															
N				●		●		●		●		●		●	
S															
H															
O				●		●		●		●		●		●	

VCGT / VCGW

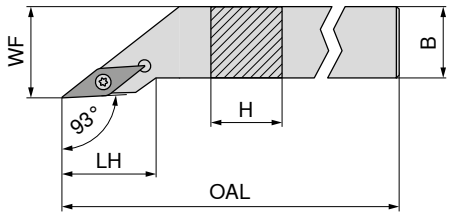
▲ TCE(NOI) = Design and number of equipped cutting edge corners

				-CB2 CTDPU20		-CB3 CTDPU20		CTDCD10		-CB1 CTDCD10		-CB2 CTDCD10	
													
				M		R		F		F		M	
				DIAMOND VCGT		DIAMOND VCGT		DIAMOND VCGW		DIAMOND VCGT		DIAMOND VCGT	
				71 190 ...		71 332 ...		71 191 ...		71 330 ...		71 331 ...	
ISO	RE mm	TCE (NOI)	LE mm	#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
110301FN	0.1	A (1)	3.0							XX,YY	31000		
110302FN	0.2	A (1)	3.0					XX,YY	40001	XX,YY	312	XX,YY	312
110304FN	0.4	A (1)	3.0					XX,YY	40101	XX,YY	314	XX,YY	314
110304FN	0.4	A (1)	3.9			XX,YY	214						
110308FN	0.8	A (1)	3.0					XX,YY	40201				
160402FN	0.2	A (1)	3.0					XX,YY	40301	XX,YY	32200	XX,YY	33200
160404FN	0.4	A (1)	3.0					XX,YY	40401	XX,YY	32400	XX,YY	334
160404FN	0.4	A (1)	5.5	XX,YY	30001	XX,YY	234						
160408FN	0.8	A (1)	3.0					XX,YY	40501	XX,YY	32600	XX,YY	338
160412FN	1.2	A (1)	3.0							XX,YY	32800	XX,YY	34000
P													
M													
K													
N					●		●		●		●		●
S													
H													
O					●		●		●		●		●

9

MaxiLock-S – SVJC 93° – Toolholder with screw clamping

Scope of supply:
Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	NEW Left-hand 70 663 ... #CU# *PA*	NEW Right-hand 70 663 ... #CU# *PA*
SVJC R/L 1212 F11	12	12	80	21.6	16	1,2	VC.. 1103	XX,YY **01200**	XX,YY **01201**
SVJC R/L 1616 H11	16	16	100	21.6	20	1,2	VC.. 1103	XX,YY **01600**	XX,YY **01601**
SVJC R/L 2020 K11	20	20	125	23.0	25	1,2	VC.. 1103	XX,YY **02000**	XX,YY **02001**
SVJC R/L 2525 M11	25	25	150	25.5	32	1,2	VC.. 1103	XX,YY **02500**	XX,YY **02501**
SVJC R/L 2020 K16	20	20	125	29.4	25	3,2	VC.. 1604	XX,YY **12000**	XX,YY **12001**
SVJC R/L 2525 M16	25	25	150	32.5	32	3,2	VC.. 1604	XX,YY **12500**	XX,YY **12501**
SVJC R/L 3225 P16	32	25	170	32.5	32	3,2	VC.. 1604	XX,YY **13200**	XX,YY **13201**

Key D

80 950 ...

Clamping screw

70 950 ...

Solid Carbide Seat V

70 950 ...

Threaded sleeve

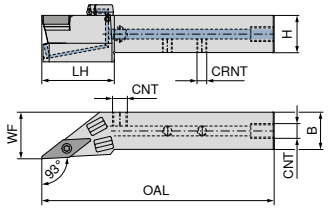
70 950 ...

Spare parts for Article no.	#CU# *PA*		#CU# *PA*		#CU# *PA*		#CU# *PA*	
70 663 01201 / 70 663 01200	XX,YY	**039**	XX,YY	**857**				
70 663 01601 / 70 663 01600	XX,YY	**039**	XX,YY	**857**				
70 663 02001 / 70 663 02000	XX,YY	**039**	XX,YY	**857**				
70 663 02501 / 70 663 02500	XX,YY	**039**	XX,YY	**857**				
70 663 12001 / 70 663 12000	XX,YY	**120**	XX,YY	**87900**	XX,YY	**107**	XX,YY	**171**
70 663 12501 / 70 663 12500	XX,YY	**120**	XX,YY	**87900**	XX,YY	**107**	XX,YY	**171**
70 663 13201 / 70 663 13200	XX,YY	**120**	XX,YY	**87900**	XX,YY	**107**	XX,YY	**171**

MaxiLock-S – SVJC 93° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions

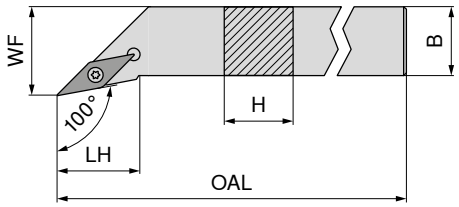
ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	NEW Left-hand 70 780 ... #CU# *PA*	NEW Right-hand 70 780 ... #CU# *PA*
SVJC R/L 1212 F11 DC	12	12	80	30	16	M6	M6	1,2	VC.. 1103	XX,YY **01201**	XX,YY **01200**
SVJC R/L 1616 H11 DC	16	16	100	27	20	M6	G1/8"	1,2	VC.. 1103	XX,YY **01601**	XX,YY **01600**
SVJC R/L 2020 K11 DC	20	20	125	39	25	M6	G1/8"	1,2	VC.. 1103	XX,YY **02001**	XX,YY **02000**
SVJC R/L 2525 M11 DC	25	25	150	41	32	M6	G1/8"	1,2	VC.. 1103	XX,YY **02501**	XX,YY **02500**
SVJC R/L 2020 K16 DC	20	20	125	39	25	M6	G1/8"	3,2	VC.. 1604	XX,YY **12001**	XX,YY **12000**
SVJC R/L 2525 M16 DC	25	25	150	41	32	M6	G1/8"	3,2	VC.. 1604	XX,YY **12501**	XX,YY **12500**
SVJC R/L 3225 P16 DC	32	25	170	41	32	G1/8"	G1/8"	3,2	VC.. 1604	XX,YY **03201**	XX,YY **03200**

Spare parts for Article no.	Clamping screw 70 950 ... #CU# *PA*	Solid Carbide Seat V 70 950 ... #CU# *PA*	Grubscrew 70 950 ... #CU# *PA*	Grubscrew 70 950 ... #CU# *PA*	Threaded sleeve 70 950 ... #CU# *PA*
70 780 01200 / 70 780 01201	XX,YY **857**			XX,YY **86700**	
70 780 01600 / 70 780 01601	XX,YY **857**		XX,YY **88000**	XX,YY **86700**	
70 780 02000 / 70 780 02001	XX,YY **857**		XX,YY **88000**	XX,YY **86700**	
70 780 02500 / 70 780 02501	XX,YY **857**		XX,YY **88000**	XX,YY **86700**	
70 780 12000 / 70 780 12001	XX,YY **87900**	XX,YY **107**	XX,YY **88000**	XX,YY **86700**	XX,YY **171**
70 780 12500 / 70 780 12501	XX,YY **87900**	XX,YY **107**	XX,YY **88000**	XX,YY **86700**	XX,YY **171**
70 780 03200 / 70 780 03201	XX,YY **87900**	XX,YY **107**	XX,YY **88000**		XX,YY **171**

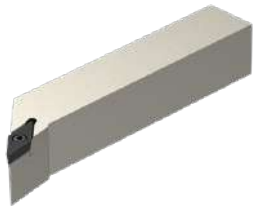
Spare parts for Article no.	Sealing plugs DC 70 950 ... #CU# *PA*	Key D 80 950 ... #CU# *PA*	O-Ring 70 950 ... #CU# *PA*	Coolant nozzle DC 70 950 ... #CU# *PA*	Coolant screw plug 70 950 ... #CU# *PA*
70 780 01200 / 70 780 01201		XX,YY **039**			
70 780 01600 / 70 780 01601	XX,YY **87600**	XX,YY **039**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 780 02000 / 70 780 02001	XX,YY **87600**	XX,YY **039**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 780 02500 / 70 780 02501	XX,YY **87600**	XX,YY **039**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 780 12000 / 70 780 12001	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 780 12500 / 70 780 12501	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 780 03200 / 70 780 03201	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**

MaxiLock-S – SVZC 100° – Toolholder with screw clamping

Scope of supply:
Tool holder with Torx key



Illustrations show right-hand versions



NEW Left-hand **70 667 ...** #CU# *PA*

NEW Right-hand **70 667 ...** #CU# *PA*

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert				
SVZC R/L 2525 M16	25	25	150	27.3	32	3,2	VC.. 1604	XX,YY	**02500**	XX,YY	**02501**

Key D **80 950 ...** #CU# *PA*

Clamping screw **70 950 ...** #CU# *PA*

Solid Carbide Seat V **70 950 ...** #CU# *PA*

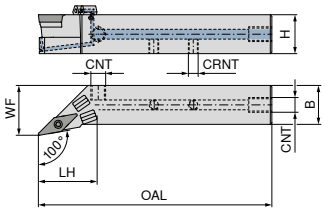
Threaded sleeve **70 950 ...** #CU# *PA*

Spare parts for Article no.											
70 667 02500 / 70 667 02501	T15 - IP	XX,YY	**120**	M3,5x11	XX,YY	**87900**	XX,YY	**107**	M3,5	XX,YY	**171**

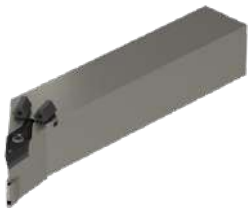
MaxiLock-S – SVZC 100° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions



ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	NEW Left-hand 70 783 ... #CU# *PA*	NEW Right-hand 70 783 ... #CU# *PA*
SVZC R/L 2525 M16 DC	25	25	150	38	32	M6	G1/8"	3,2	VC.. 1604	XX,YY **02501**	XX,YY **02500**

Clamping screw

Solid Carbide Seat V

Grubscrew

Grubscrew

Threaded sleeve

Spare parts for Article no.	70 950 ... #CU# *PA*	70 950 ... #CU# *PA*	70 950 ... #CU# *PA*	70 950 ... #CU# *PA*	70 950 ... #CU# *PA*
70 783 02500 / 70 783 02501	XX,YY **87900**	XX,YY **107**	XX,YY **88000**	XX,YY **86700**	XX,YY **171**

Sealing plugs DC

Key D

O-Ring

Coolant nozzle DC

Coolant screw plug

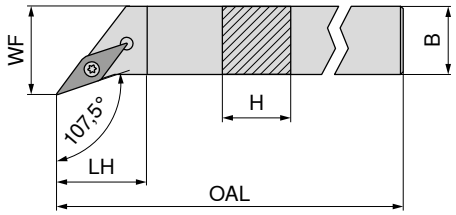
Spare parts for Article no.	70 950 ... #CU# *PA*	80 950 ... #CU# *PA*	70 950 ... #CU# *PA*	70 950 ... #CU# *PA*	70 950 ... #CU# *PA*
70 783 02500 / 70 783 02501	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**

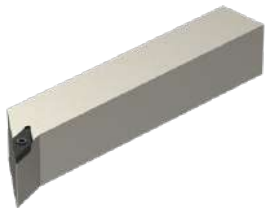
9

MaxiLock-S – SVHC 107.5° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key





Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	torque moment Nm	Insert	NEW Left-hand 70 662 ... #CU# *PA*	NEW Right-hand 70 662 ... #CU# *PA*
SVHC R/L 1212 F11	12	12	80	11.9	16	1,2	VC.. 1103	XX,YY **01200**	XX,YY **01201**
SVHC R/L 1616 H11	16	16	100	11.9	20	1,2	VC.. 1103	XX,YY **01600**	XX,YY **01601**
SVHC R/L 2020 K11	20	20	125	14.7	25	1,2	VC.. 1103	XX,YY **02000**	XX,YY **02001**
SVHC R/L 2525 M11	25	25	150	20.1	32	1,2	VC.. 1103	XX,YY **02500**	XX,YY **02501**
SVHC R/L 2020 K16	20	20	125	13.7	25	3,2	VC.. 1604	XX,YY **12000**	XX,YY **12001**
SVHC R/L 2525 M16	25	25	150	20.0	32	3,2	VC.. 1604	XX,YY **12500**	XX,YY **12501**
SVHC R/L 3225 P16	32	25	170	20.0	32	3,2	VC.. 1604	XX,YY **13200**	XX,YY **13201**
SVHC R/L 2525 M22	25	25	150	21.9	32	5	VC.. 2205	XX,YY **22500**	XX,YY **22501**

Key D

Clamping screw

Solid Carbide Seat V

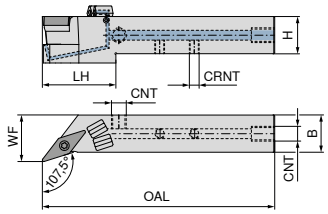
Threaded sleeve

Spare parts for Article no.	80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 662 01201 / 70 662 01200	XX,YY	**039**	XX,YY	**857**				
70 662 01601 / 70 662 01600	XX,YY	**039**	XX,YY	**857**				
70 662 02001 / 70 662 02000	XX,YY	**039**	XX,YY	**857**				
70 662 02501 / 70 662 02500	XX,YY	**039**	XX,YY	**857**				
70 662 12001 / 70 662 12000	XX,YY	**120**	XX,YY	**87900**	XX,YY	**107**	XX,YY	**171**
70 662 12501 / 70 662 12500	XX,YY	**120**	XX,YY	**87900**	XX,YY	**107**	XX,YY	**171**
70 662 13201 / 70 662 13200	XX,YY	**120**	XX,YY	**87900**	XX,YY	**107**	XX,YY	**171**
70 662 22501 / 70 662 22500	XX,YY	**120**	XX,YY	**820**	XX,YY	**109**	XX,YY	**170**

MaxiLock-S – SVHC 107.5° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	NEW Left-hand 70 779 ... #CU# *PA*		NEW Right-hand 70 779 ... #CU# *PA*	
SVHC R/L 1212 F11 DC	12	12	80	28	16	M6	M6	1,2	VC.. 1103	XX,YY	**01201**	XX,YY	**01200**
SVHC R/L 1616 H11 DC	16	16	100	27	20	M6	G1/8"	1,2	VC.. 1103	XX,YY	**01601**	XX,YY	**01600**
SVHC R/L 2020 K11 DC	20	20	125	37	27	M6	G1/8"	1,2	VC.. 1103	XX,YY	**02001**	XX,YY	**02000**
SVHC R/L 2525 M11 DC	25	25	150	38	32	M6	G1/8"	1,2	VC.. 1103	XX,YY	**02501**	XX,YY	**02500**
SVHC R/L 2020 K16 DC	20	20	125	38	25	M6	G1/8"	3,2	VC.. 1604	XX,YY	**12001**	XX,YY	**12000**
SVHC R/L 2525 M16 DC	25	25	150	38	32	M6	G1/8"	3,2	VC.. 1604	XX,YY	**12501**	XX,YY	**12500**
SVHC R/L 3225 P16 DC	32	25	170	38	32	M6	G1/8"	3,2	VC.. 1604	XX,YY	**03201**	XX,YY	**03200**
SVHC R/L 2525 M22 DC	25	25	150	41	32	M6	G1/8"	5	VC.. 2205	XX,YY	**22501**	XX,YY	**22500**

Spare parts for Article no.	Clamping screw 70 950 ... #CU# *PA*		Solid Carbide Seat V 70 950 ... #CU# *PA*		Grubscrew 70 950 ... #CU# *PA*		Grubscrew 70 950 ... #CU# *PA*		Threaded sleeve 70 950 ... #CU# *PA*	
70 779 01200 / 70 779 01201	XX,YY	**857**					XX,YY	**86700**		
70 779 01600 / 70 779 01601	XX,YY	**857**			XX,YY	**88000**	XX,YY	**86700**		
70 779 02000 / 70 779 02001	XX,YY	**857**			XX,YY	**88000**	XX,YY	**86700**		
70 779 02500 / 70 779 02501	XX,YY	**857**			XX,YY	**88000**	XX,YY	**86700**		
70 779 12000 / 70 779 12001	XX,YY	**87900**	XX,YY	**107**	XX,YY	**88000**	XX,YY	**86700**	XX,YY	**171**
70 779 12500 / 70 779 12501	XX,YY	**87900**	XX,YY	**107**	XX,YY	**88000**	XX,YY	**86700**	XX,YY	**171**
70 779 03200 / 70 779 03201	XX,YY	**87900**	XX,YY	**107**	XX,YY	**88000**	XX,YY	**86700**	XX,YY	**171**
70 779 22500 / 70 779 22501	XX,YY	**820**	XX,YY	**109**	XX,YY	**88000**	XX,YY	**86700**	XX,YY	**170**

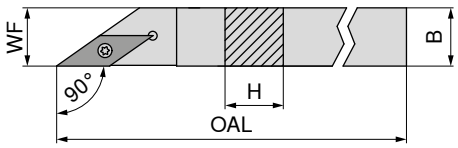
Spare parts for Article no.	Sealing plugs DC 70 950 ... #CU# *PA*		Key D 80 950 ... #CU# *PA*		O-Ring 70 950 ... #CU# *PA*		Coolant nozzle DC 70 950 ... #CU# *PA*		Coolant screw plug 70 950 ... #CU# *PA*	
70 779 01200 / 70 779 01201			XX,YY	**039**						
70 779 01600 / 70 779 01601	XX,YY	**87600**	XX,YY	**039**	XX,YY	**88100**	XX,YY	**87700**	XX,YY	**294**
70 779 02000 / 70 779 02001	XX,YY	**87600**	XX,YY	**039**	XX,YY	**88100**	XX,YY	**87700**	XX,YY	**294**
70 779 02500 / 70 779 02501	XX,YY	**87600**	XX,YY	**039**	XX,YY	**88100**	XX,YY	**87700**	XX,YY	**294**
70 779 12000 / 70 779 12001	XX,YY	**87600**	XX,YY	**120**	XX,YY	**88100**	XX,YY	**87700**	XX,YY	**294**
70 779 12500 / 70 779 12501	XX,YY	**87600**	XX,YY	**120**	XX,YY	**88100**	XX,YY	**87700**	XX,YY	**294**
70 779 03200 / 70 779 03201	XX,YY	**87600**	XX,YY	**120**	XX,YY	**88100**	XX,YY	**87700**	XX,YY	**294**
70 779 22500 / 70 779 22501	XX,YY	**87600**	XX,YY	**120**	XX,YY	**88100**	XX,YY	**87700**	XX,YY	**294**

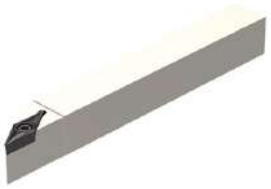
MaxiLock-S – SVAC 90° – Toolholder with screw clamping

▲ for sliding head lathes

Scope of supply:

Tool holder with Torx key





Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	WF mm	torque moment Nm	Insert	Left-hand 70 695 ... #CU# *PA*		Right-hand 70 694 ... #CU# *PA*	
SVAC R/L 0808 H11	8	8	100	8	1,2	VC.. 1103	XX,YY	**008**	XX,YY	**008**
SVAC R/L 1010 H11	10	10	100	10	1,2	VC.. 1103	XX,YY	**010**	XX,YY	**010**
SVAC R/L 1212 H11	12	12	100	12	1,2	VC.. 1103	XX,YY	**012**	XX,YY	**012**

Key D

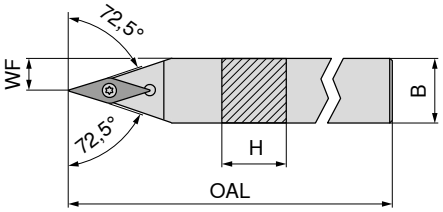
Clamping screw

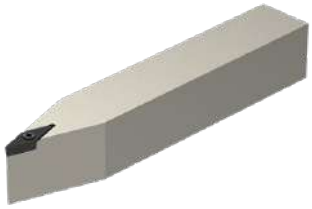
Spare parts for Article no.		80 950 ... #CU# *PA*			70 950 ... #CU# *PA*	
70 694 008 / 70 695 008	T08	XX,YY	**110**	M2,5x6 - T08	XX,YY	**13800**
70 694 010 / 70 695 010	T08	XX,YY	**110**	M2,5x6 - T08	XX,YY	**13800**
70 694 012 / 70 695 012	T08	XX,YY	**110**	M2,5x6 - T08	XX,YY	**13800**

MaxiLock-S – SVVC 72.5° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key





NEW

Neutral

ISO designation	H mm	B mm	OAL mm	WF mm	torque moment Nm	Insert	70 666 ... #CU# *PA*	
SVVC N 1212 F11	12	12	80	6.0	1,2	VC.. 1103	XX,YY	**01200**
SVVC N 1616 H11	16	16	100	8.0	1,2	VC.. 1103	XX,YY	**01600**
SVVC N 2020 K11	20	20	125	10.0	1,2	VC.. 1103	XX,YY	**02000**
SVVC N 2525 M11	25	25	150	12.5	1,2	VC.. 1103	XX,YY	**02500**
SVVC N 2020 K16	20	20	125	10.0	3,2	VC.. 1604	XX,YY	**12000**
SVVC N 2525 M16	25	25	150	12.5	3,2	VC.. 1604	XX,YY	**12500**
SVVC N 3225 P16	32	25	170	12.5	3,2	VC.. 1604	XX,YY	**13200**

Key D

Clamping screw

Solid Carbide Seat V

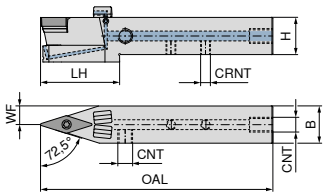
Threaded sleeve

Spare parts for Article no.	80 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 666 01200	XX,YY	**039**	XX,YY	**857**				
70 666 01600	XX,YY	**039**	XX,YY	**857**				
70 666 02000	XX,YY	**039**	XX,YY	**857**				
70 666 02500	XX,YY	**039**	XX,YY	**857**				
70 666 12000	XX,YY	**120**	XX,YY	**87900**	XX,YY	**107**	XX,YY	**171**
70 666 12500	XX,YY	**120**	XX,YY	**87900**	XX,YY	**107**	XX,YY	**171**
70 666 13200	XX,YY	**120**	XX,YY	**87900**	XX,YY	**107**	XX,YY	**171**

MaxiLock-S – SVVC 72.5° DC – Tool holder with screw clamping

Scope of supply:

Tool holder with blind plug and Torx key



NEW

Neutral

70 781 ...

ISO designation	H mm	B mm	OAL mm	LH mm	WF mm	CRNT	CNT	torque moment Nm	Insert	#CU# *PA*	
SVVC N 1212 F11 DC	12	12	80	29.0	12	M6	M6	1,2	VC.. 1103	XX,YY	**01200**
SVVC N 1616 H11 DC	16	16	100	29.5	16	M6	G1/8"	1,2	VC.. 1103	XX,YY	**01600**
SVVC N 2020 K11 DC	20	20	125	43.0	20	M6	G1/8"	1,2	VC.. 1103	XX,YY	**02000**
SVVC N 2525 M11 DC	25	25	150	43.0	25	M6	G1/8"	1,2	VC.. 1103	XX,YY	**02500**
SVVC N 2020 K16 DC	20	20	125	43.0	20	M6	G1/8"	3,2	VC.. 1604	XX,YY	**12000**
SVVC N 2525 M16 DC	25	25	150	43.0	25	M6	G1/8"	3,2	VC.. 1604	XX,YY	**12500**
SVVC N 3225 P16 DC	32	25	170	44.0	25	G1/8"	G1/8"	3,2	VC.. 1604	XX,YY	**03200**

	 Clamping screw	 Solid Carbide Seat V	 Grubscrew	 Grubscrew	 Threaded sleeve
	70 950 ...	**70 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**
Spare parts for Article no.	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
70 781 01200	XX,YY **857**			XX,YY **86700**	
70 781 01600	XX,YY **857**		XX,YY **88000**	XX,YY **86700**	
70 781 02000	XX,YY **857**		XX,YY **88000**	XX,YY **86700**	
70 781 02500	XX,YY **857**		XX,YY **88000**	XX,YY **86700**	
70 781 12000	XX,YY **87900**	XX,YY **107**	XX,YY **88000**	XX,YY **86700**	XX,YY **171**
70 781 12500	XX,YY **87900**	XX,YY **107**	XX,YY **88000**	XX,YY **86700**	XX,YY **171**
70 781 03200	XX,YY **87900**	XX,YY **107**	XX,YY **88000**		XX,YY **171**

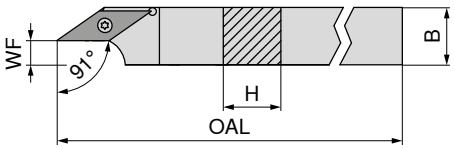
	 Sealing plugs DC	 Key D	 O-Ring	 Coolant nozzle DC	 Coolant screw plug
	70 950 ...	**80 950 ...**	**70 950 ...**	**70 950 ...**	**70 950 ...**
Spare parts for Article no.	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*	#CU# *PA*
70 781 01200		XX,YY **039**			
70 781 01600	XX,YY **87600**	XX,YY **039**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 781 02000	XX,YY **87600**	XX,YY **039**	XX,YY **88100**	XX,YY **87800**	XX,YY **294**
70 781 02500	XX,YY **87600**	XX,YY **039**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**
70 781 12000	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87800**	XX,YY **294**
70 781 12500	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87800**	XX,YY **294**
70 781 03200	XX,YY **87600**	XX,YY **120**	XX,YY **88100**	XX,YY **87700**	XX,YY **294**

MaxiLock-S – SVXC 91° – Toolholder with screw clamping

▲ for sliding head lathes

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	H mm	B mm	OAL mm	torque moment Nm	Insert	Left-hand 70 691 ... #CU# *PA*		Right-hand 70 690 ... #CU# *PA*	
SVXC R/L 1010 H11	10	10	100	1,2	VC.. 1103	XX,YY	**010**	XX,YY	**010**
SVXC R/L 1212 H11	12	12	100	1,2	VC.. 1103	XX,YY	**012**	XX,YY	**012**
SVXC R/L 1616 K11	16	16	125	1,2	VC.. 1103	XX,YY	**016**	XX,YY	**016**
SVXC R/L 2020 K16	20	20	125	3,2	VC.. 1604	XX,YY	**020**	XX,YY	**020**

Key D

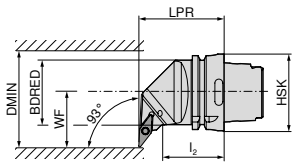
Clamping screw

Spare parts for Article no.		80 950 ... #CU# *PA*			70 950 ... #CU# *PA*	
70 690 010 / 70 691 010	T08	XX,YY	**110**	M2,5x6 - T08	XX,YY	**13800**
70 690 012 / 70 691 012	T08	XX,YY	**110**	M2,5x6 - T08	XX,YY	**13800**
70 690 016 / 70 691 016	T08	XX,YY	**110**	M2,5x6 - T08	XX,YY	**13800**
70 690 020 / 70 691 020	T15	XX,YY	**113**	M3,5x11	XX,YY	**113**

MaxiLock-S – SVUC 93° – Toolholder with screw clamping

Scope of supply:

Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	l_2 mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 557 ... #CU# *PA*		Right-hand 74 558 ... #CU# *PA*	
HSK T63 SVUC R/L 16	HSK-T 63	70	42	53	45	100	3.2	VC.. 1604	XX,YY	**516**	XX,YY	**516**

Combination Key

Clamping screw

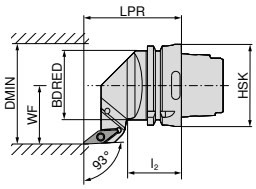
Solid Carbide Seat V

Threaded sleeve

Spare parts for Article no.		70 950 ... #CU# *PA*			70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
74 558 516 / 74 557 516	T15/SW	XX,YY	**398**	M3,5x11	XX,YY	**113**	XX,YY	**107**	M3,5	XX,YY	**171**

MaxiLock-S – SVJC 93° – Toolholder with screw clamping

Scope of supply:
Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	l_2 mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 556 ... #CU# *PA*		Right-hand 74 555 ... #CU# *PA*	
HSK T63 SVJC R/L 16	HSK-T 63	75	42	53	45	100	3.2	VC.. 1604	XX,YY	516	XX,YY	516


Combination Key


Clamping screw

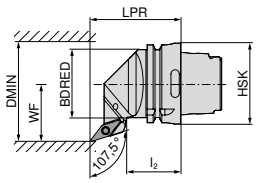

Solid Carbide Seat V


Threaded sleeve

Spare parts for Article no.		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
74 555 516 / 74 556 516	T15/SW	XX,YY	398	M3,5x11	XX,YY	113	XX,YY	107	M3,5	XX,YY	171

MaxiLock-S – SVHC 107.5° – Toolholder with screw clamping

Scope of supply:
Tool holder with Torx key



Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	l_2 mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 554 ... #CU# *PA*		Right-hand 74 553 ... #CU# *PA*	
HSK T63 SVHC R/L 16	HSK-T 63	70	42	53	45	100	3.2	VC.. 1604	XX,YY	516	XX,YY	516


Combination Key


Clamping screw


Solid Carbide Seat V

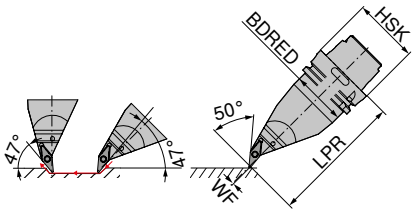

Threaded sleeve

Spare parts for Article no.		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
74 553 516 / 74 554 516	T15/SW	XX,YY	398	M3,5x11	XX,YY	113	XX,YY	107	M3,5	XX,YY	171

9

MaxiLock-S – SVMC 50° – Toolholder with screw clamping

Scope of supply:
Tool holder with Torx key

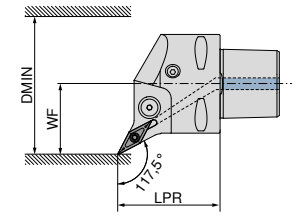



ISO designation	Adapter	LPR mm	BDRED mm	WF mm	torque moment Nm	Insert	Left-hand 74 560 ... #CU# *PA*	
HSK T63 SVMC L 16	HSK-T 63	130	53	0	3.2	VC.. 1604	XX,YY	**516**

Spare parts for Article no.		Combination Key 70 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*		Solid Carbide Seat V 70 950 ... #CU# *PA*		Threaded sleeve 70 950 ... #CU# *PA*	
74 560 516	T15/SW	XX,YY	**398**	M3,5x11	XX,YY	**113**	XX,YY	**107**	M3,5	XX,YY	**171**

MaxiLock-S – SVPC 117,5° – Toolholder with screw clamping

Scope of supply:
without high-performance coolant set

Illustrations show right-hand versions

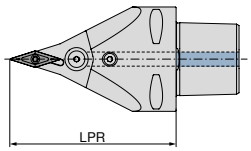
ISO designation	Adapter	LPR mm	WF mm	DMIN mm	torque moment Nm	Insert	Direct cooling compatible	Left-hand 84 671 ... #CU# *PA*		Right-hand 84 670 ... #CU# *PA*	
PSC40 SVPC R/L 50050-16	PSC 40	50	27	50	3	VC.. 1604	DC	XX,YY	**01695**	XX,YY	**01695**
PSC50 SVPC R/L 65060-16	PSC 50	60	35	65	3	VC.. 1604	DC	XX,YY	**01694**	XX,YY	**01694**
PSC63 SVPC R/L 80065-16	PSC 63	65	45	80	3	VC.. 1604	DC	XX,YY	**01693**	XX,YY	**01693**

The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page PL**.

Spare parts for Article no.	Clamping screw 84 950 ... #CU# *PA*	
84 670 01695 / 84 671 01695	XX,YY	**27600**
84 670 01694 / 84 671 01694	XX,YY	**27600**
84 670 01693 / 84 671 01693	XX,YY	**27600**

MaxiLock-S – SVVC 72.5° – Toolholder with screw clamping

Scope of supply:
without high-performance coolant set

Neutral

ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Direct cooling compatible	84 678 ... #CU# *PA*	
PSC63 SVVC N 0100-16	PSC 63	100	3	VC.. 1604	DC	XX,YY	**01693**
PSC63 SVVC N 0130-16	PSC 63	130	3	VC.. 1604	DC	XX,YY	**11693**

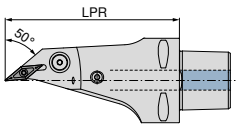
The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page PL**.

Clamping screw

Spare parts for Article no.	84 950 ... #CU# *PA*	
84 678 01693	XX,YY	**27600**
84 678 11693	XX,YY	**27600**

MaxiLock-S – SVMC 50° – Toolholder with screw clamping

Scope of supply:
without high-performance coolant set

Neutral

ISO designation	Adapter	LPR mm	torque moment Nm	Insert	Direct cooling compatible	84 681 ... #CU# *PA*	
PSC63 SVMC L 0130-16	PSC 63	130	3	VC.. 1604	DC	XX,YY	**11693**

The high-performance coolant set with article number 84 950 27400 can be ordered as an optional extra → **Page PL**.

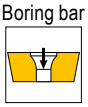
Clamping screw

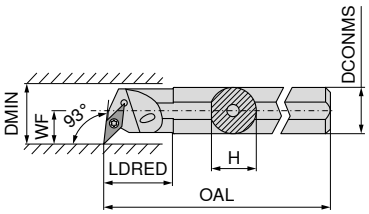
Spare parts for Article no.	84 950 ... #CU# *PA*	
84 681 11693	XX,YY	**27600**

9

MaxiLock-S – SVUC 93° – Boring bar with screw clamping

Scope of supply:
Boring bar with Torx key





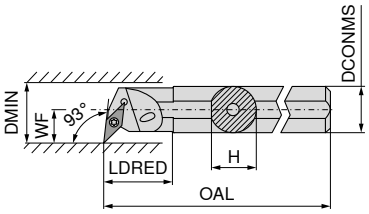
Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 745 ... #CU# *PA*		Right-hand 70 744 ... #CU# *PA*	
A16M SVUC R/L 11	16	15	150	29	11	20	1,2	VC.. 1103	XX,YY	216	XX,YY	216
A20Q SVUC R/L 11	20	19	180	43	13	25	1,2	VC.. 1103	XX,YY	220	XX,YY	220
A25R SVUC R/L 11	25	24	200	38	17	32	1,2	VC.. 1103	XX,YY	225	XX,YY	225
A32S SVUC R/L 16	32	31	250	50	22	40	3,2	VC.. 1604	XX,YY	232	XX,YY	232
A40T SVUC R/L 16	40	39	300	60	27	50	3,2	VC.. 1604	XX,YY	240	XX,YY	240

Spare parts for Article no.	Key D 80 950 ... #CU# *PA*		Combination Key 70 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*		Solid Carbide Seat V 70 950 ... #CU# *PA*		Threaded sleeve 70 950 ... #CU# *PA*	
70 744 216 / 70 745 216	XX,YY	110			XX,YY	13800				
70 744 220 / 70 745 220	XX,YY	110			XX,YY	13800				
70 744 225 / 70 745 225	XX,YY	110			XX,YY	13800				
70 744 232 / 70 745 232			XX,YY	398	XX,YY	113	XX,YY	107	XX,YY	171
70 744 240 / 70 745 240			XX,YY	398	XX,YY	113	XX,YY	107	XX,YY	171

MaxiLock-S – SVUC 93° – Boring bar with screw clamping

▲ with carbide core



Illustrations show right-hand versions

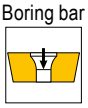
ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Right-hand 70 746 ... #CU# *PA*	
E-A16M SVUC R 11	16	15	150	16.5	11	21	1,2	VC.. 1103	XX,YY	216
E-A20Q SVUC R 11	20	18	180	20.5	13	25	1,2	VC.. 1103	XX,YY	220
E-A25R SVUC R 11	25	23	200	25.5	17	31	1,2	VC.. 1103	XX,YY	225
E-A25R SVUC R 16	25	23	200	25.5	17	31	3,2	VC.. 1604	XX,YY	325
E-A32S SVUC R 16	32	30	250	32.5	22	39	3,2	VC.. 1604	XX,YY	232

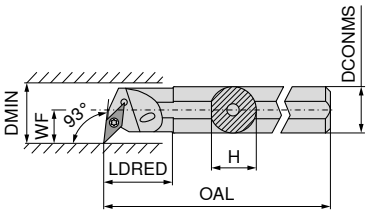
Spare parts for Article no.	Key D 80 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*	
70 746 216	XX,YY	110	XX,YY	13800
70 746 220	XX,YY	110	XX,YY	13800
70 746 225	XX,YY	110	XX,YY	13800
70 746 325	XX,YY	113	XX,YY	449
70 746 232	XX,YY	113	XX,YY	449

MaxiLock-S – SVUC 93° – Boring bar with screw clamping

▲ Type: Solid carbide

Scope of supply:
Boring bar with Torx key





Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 747 ... #CU# *PA*		Right-hand 70 746 ... #CU# *PA*	
E16R SVUC L 11	16	15.0	200	34	11	20	1,2	VC.. 1103	XX,YY	**016**		
E16R SVUC R 11	16	15.5	200	34	11	20	1,2	VC.. 1103			XX,YY	**016**
E20S SVUC L 11	20	18.5	250	38	13	25	1,2	VC.. 1103	XX,YY	**020**		
E20S SVUC R 11	20	19.0	250	38	13	25	1,2	VC.. 1103			XX,YY	**020**


Key D

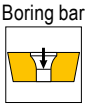

Clamping screw

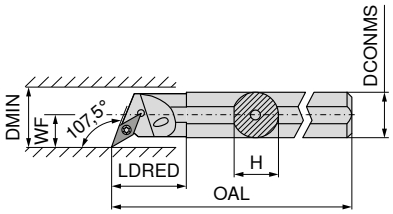
Spare parts for Article no.	Key D 80 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*	
70 747 016	T08	XX,YY **110**	M2,5x6 - T08	XX,YY **13800**
70 746 016	T08	XX,YY **110**	M2,5x6 - T08	XX,YY **13800**
70 747 020	T08	XX,YY **110**	M2,5x6 - T08	XX,YY **13800**
70 746 020	T08	XX,YY **110**	M2,5x6 - T08	XX,YY **13800**

9

MaxiLock-S – SVQC 107.5° – Boring bar with screw clamping

Scope of supply:
Boring bar with Torx key





Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 749 ... #CU# *PA*		Right-hand 70 748 ... #CU# *PA*	
A16M SVQC R/L 11	16	15.0	150	29	11	20	1,2	VC.. 1103	XX,YY	**216**	XX,YY	**216**
A20Q SVQC R/L 11	20	18.5	180	32	13	25	1,2	VC.. 1103	XX,YY	**220**	XX,YY	**220**
A25R SVQC R/L 11	25	23.0	200	36	17	32	1,2	VC.. 1103	XX,YY	**225**	XX,YY	**225**
A32S SVQC R/L 16	32	30.0	250	50	22	40	3,2	VC.. 1604	XX,YY	**232**	XX,YY	**232**
A40T SVQC R/L 16	40	38.0	300	60	27	50	3,2	VC.. 1604	XX,YY	**240**	XX,YY	**240**


Key D


Combination Key

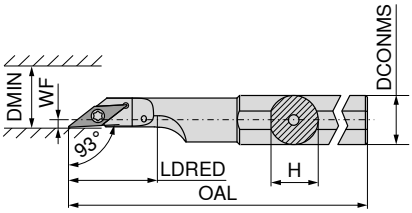

Clamping screw


Solid Carbide Seat V


Threaded sleeve

Spare parts for Article no.	Key D 80 950 ... #CU# *PA*		Combination Key 70 950 ... #CU# *PA*		Clamping screw 70 950 ... #CU# *PA*		Solid Carbide Seat V 70 950 ... #CU# *PA*		Threaded sleeve 70 950 ... #CU# *PA*	
70 748 216 / 70 749 216	XX,YY	**110**			XX,YY	**13800**				
70 748 220 / 70 749 220	XX,YY	**110**			XX,YY	**13800**				
70 748 225 / 70 749 225	XX,YY	**110**			XX,YY	**13800**				
70 748 232 / 70 749 232			XX,YY	**398**	XX,YY	**113**	XX,YY	**107**	XX,YY	**171**
70 748 240 / 70 749 240			XX,YY	**398**	XX,YY	**113**	XX,YY	**107**	XX,YY	**171**

MaxiLock-S – SVJC 93° – Boring bar with screw clamping



Illustrations show right-hand versions

ISO designation	DCONMS mm	H mm	OAL mm	LDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 727 ... #CU# *PA*		Right-hand 70 726 ... #CU# *PA*	
A16M SVJC R/L 11	16	15	150	50.0	2	22	1,2	VC.. 1103	XX,YY	216	XX,YY	216
A20M SVJC R/L 11	20	19	150	55.5	2	25	1,2	VC.. 1103	XX,YY	220	XX,YY	220
A25M SVJC R/L 16	25	24	150	58.0	5	28	3,2	VC.. 1604	XX,YY	225	XX,YY	225

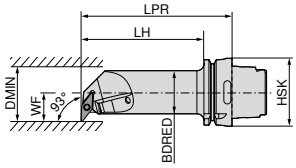
Key D

Clamping screw

Spare parts for Article no.	80 950 ... #CU# *PA*		70 950 ... #CU# *PA*	
70 727 216 / 70 726 216	XX,YY	110	XX,YY	13800
70 727 220 / 70 726 220	XX,YY	110	XX,YY	13800
70 727 225 / 70 726 225	XX,YY	113	XX,YY	174

MaxiLock-S – SVUC 93° – Boring bar with screw clamping

Scope of supply:
Boring bar with Torx key



Illustrations show right-hand versions

ISO designation	Adapter	LPR mm	LH mm	BDRED mm	WF mm	DMIN mm	torque moment Nm	Insert	Left-hand 74 568 ... #CU# *PA*		Right-hand 74 567 ... #CU# *PA*	
HSK T63 40L SVUC R/L 16	HSK-T 63	140	114	40	27	50	3.2	VC.. 1604	XX,YY	516	XX,YY	516

Combination Key

Clamping screw

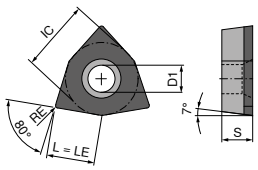
Solid Carbide Seat V

Threaded sleeve

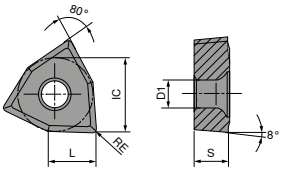
Spare parts for Article no.		70 950 ... #CU# *PA*			70 950 ... #CU# *PA*		70 950 ... #CU# *PA*			70 950 ... #CU# *PA*	
74 567 516 / 74 568 516	T15/SW	XX,YY	398	M3,5x11	XX,YY	113	XX,YY	107	M3,5	XX,YY	171

WCGT / WCGW

Designation	L mm	S mm	D1 mm	IC mm
WCGW 0201..	2.70	1.58	2.3	3.97
WCGT 0201..	2.71	1.59	2.1	3.97



CBN/PKD WCGW F



WCGT

WCGT

	-SF TCM10	-SF CTPP430 DRAGONSKIN	-SF H216T
			
	F	**F**	**F**
	CERMET WCGT	WCGT	WCGT
	70 287 ...	**70 287 ...**	**70 287 ...**
ISO / RE mm	**#CU#** *PA*	**#CU#** *PA*	**#CU#** *PA*
020102EN 0,2	XX,YY **900**	XX,YY **450**	XX,YY **600**
020104EN 0,4	XX,YY **902**	XX,YY **452**	XX,YY **602**
P	●	●	
M	○	●	
K	○	○	○
N		○	●
S		○	
H			
O			○

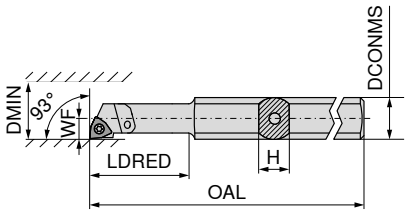
WCGW

▲ TCE(NOI) = Design and number of equipped cutting edge corners

	CTDPD20
	
	F
	DIAMOND WCGW
	71 154 ...
ISO / RE mm / **TCE (NOI)** / LE mm	**#CU#** *PA*
020102FN 0.2 **F** 2.7	XX,YY **100**
020104FN 0.4 **F** 2.7	XX,YY **102**
P	
M	
K	
N	●
S	
H	
O	●

9

MaxiLock-S – SWUC 93° – Boring bar with screw clamping



Illustrations show right-hand versions

ISO designation	H mm	OAL mm	LDRED mm	WF mm	DCONMS mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 731 ... #CU# *PA*		Right-hand 70 730 ... #CU# *PA*	
A0508H SWUC R/L 02	7	100	24	2.9	8	5.8	0,4	WC.. 0201..	XX,YY	**005**	XX,YY	**005**
A0608H SWUC R/L 02	7	100	24	3.9	8	7.8	0,4	WC.. 0201..	XX,YY	**006**	XX,YY	**006**

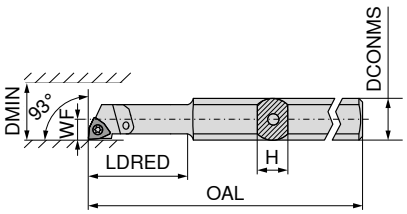
Key D

Clamping screw

Spare parts for Article no.		80 950 ... #CU# *PA*			70 950 ... #CU# *PA*	
70 731 005 / 70 730 005	T06	XX,YY	**108**	M1,8x3,4	XX,YY	**334**
70 731 006 / 70 730 006	T06	XX,YY	**108**	M1,8x3,4	XX,YY	**334**

MaxiLock-S – SWUC 93° – Boring bar with screw clamping

▲ with carbide core



Illustrations show right-hand versions

ISO designation	H mm	OAL mm	LDRED mm	WF mm	DCONMS mm	DMIN mm	torque moment Nm	Insert	Left-hand 70 743 ... #CU# *PA*		Right-hand 70 742 ... #CU# *PA*	
E-A0508H SWUC R/L 02	7	100	24	2.9	8	5.8	0,4	WC.. 0201..	XX,YY	**005**	XX,YY	**005**
E-A0608H SWUC R/L 02	7	100	24	3.9	8	7.8	0,4	WC.. 0201..	XX,YY	**006**	XX,YY	**006**
SET							0,4	WC.. 0201..	XX,YY	**999**	XX,YY	**999**

Set includes boring bars 70 743 005 and 70 743 006 or 70 742 005 and 70 742 006

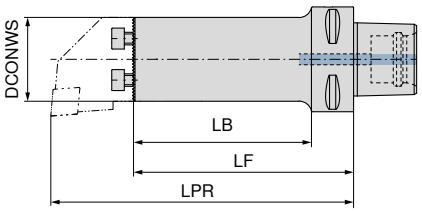
Key D

Clamping screw

Spare parts for Article no.		80 950 ... #CU# *PA*			70 950 ... #CU# *PA*	
70 743 005 / 70 742 005	T06	XX,YY	**108**	M1,8x3,4	XX,YY	**334**
70 743 006 / 70 742 006	T06	XX,YY	**108**	M1,8x3,4	XX,YY	**334**

Base holders for the exchangeable head system

Scope of supply:
Includes clamping screws



right / left

Adapter	LPR mm	LF mm	LB mm	DCONWS mm	84 192 ... #CU# *PA*	
PSC 40	90	55	35	25	XX,YY	**02595**
PSC 40	110	75	55	32	XX,YY	**03295**
PSC 40	120	80		40	XX,YY	**04095**
PSC 50	90	55	35	25	XX,YY	**02594**
PSC 50	110	75	55	32	XX,YY	**03294**
PSC 50	140	100	80	40	XX,YY	**04094**
PSC 63	100	65	43	25	XX,YY	**02593**
PSC 63	125	90	68	32	XX,YY	**03293**
PSC 63	160	125	103	32	XX,YY	**13293**
PSC 63	140	100	78	40	XX,YY	**04093**
PSC 63	180	140	118	40	XX,YY	**14093**

Clamping Screw

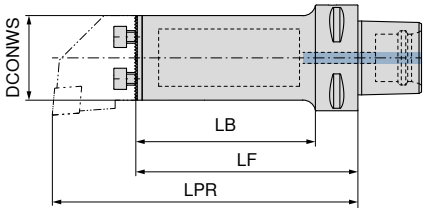
Spare parts for Article no.		84 950 ... #CU# *PA*	
84 192 02595	M4X12 (SW3)	XX,YY	**30000**
84 192 03295	M5X14 (SW4)	XX,YY	**29900**
84 192 04095	M6X16 (SW5)	XX,YY	**29800**
84 192 02594	M4X12 (SW3)	XX,YY	**30000**
84 192 03294	M5X14 (SW4)	XX,YY	**29900**
84 192 04094	M6X16 (SW5)	XX,YY	**29800**
84 192 02593	M4X12 (SW3)	XX,YY	**30000**
84 192 03293	M5X14 (SW4)	XX,YY	**29900**
84 192 04093	M6X16 (SW5)	XX,YY	**29800**
84 192 13293	M5X14 (SW4)	XX,YY	**29900**
84 192 14093	M6X16 (SW5)	XX,YY	**29800**

Base holders for the exchangeable head system – vibration-damped

▲ Reduzierung der Vibrationen durch Schwermetallkern

Scope of supply:

Includes clamping screws



right / left

Adapter	LPR mm	LF mm	LB mm	DCONWS mm	#CU# *PA* 84 195 ...
PSC 63	150	115	93	25	XX,YY **02593**
PSC 63	185	150	128	32	XX,YY **03293**
PSC 63	225	185	163	40	XX,YY **04093**

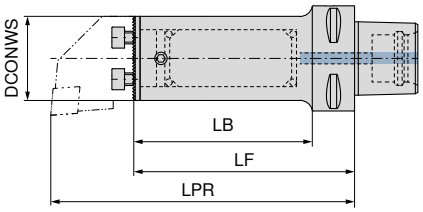
Clamping Screw

Spare parts for Article no.	#CU# *PA* 84 950 ...
84 195 02593	XX,YY **30000**
84 195 03293	XX,YY **29900**
84 195 04093	XX,YY **29800**

Base holders for the exchangeable head system – actively vibration-damped

▲ Reduzierung der Schwingungen durch aktiv gelagerten Dämpfer
▲ Verbesserung der Oberflächengüte und Spanabfuhr

Scope of supply:
Includes clamping screws



NEW
right / left

Adapter	LPR mm	LF mm	LB mm	DCONWS mm	84 198 ... #CU# *PA*	
PSC 40	167	132	112	25	XX,YY	**42595**[1)]
PSC 40	189	154	134	32	XX,YY	**43295**[1)]
PSC 40	213	173		40	XX,YY	**44095**[1)]
PSC 50	168	133	113	25	XX,YY	**32594**[1)]
PSC 50	215	180	160	25	XX,YY	**42594**[1)]
PSC 50	189	154	134	32	XX,YY	**33294**[1)]
PSC 50	259	224	204	32	XX,YY	**43294**[1)]
PSC 50	234	194	174	40	XX,YY	**34094**[1)]
PSC 50	328	288	268	40	XX,YY	**44094**[1)]
PSC 63	167	132	110	25	XX,YY	**32593**[1)]
PSC 63	215	180	158	25	XX,YY	**42593**[1)]
PSC 63	265	230	208	25	XX,YY	**52593**[1)]
PSC 63	194	159	137	32	XX,YY	**33293**[1)]
PSC 63	259	224	202	32	XX,YY	**43293**[1)]
PSC 63	323	288	266	32	XX,YY	**53293**[1)]
PSC 63	238	198	176	40	XX,YY	**34093**[1)]
PSC 63	328	288	266	40	XX,YY	**44093**[1)]
PSC 63	408	368	346	40	XX,YY	**54093**[1)]

1) Not ex-stock

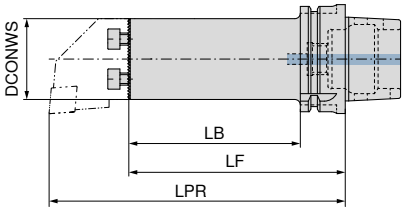

Clamping Screw

Spare parts for Article no.	84 950 ... #CU# *PA*	
84 198 42595	XX,YY	**30000**
84 198 43295	XX,YY	**29900**
84 198 44095	XX,YY	**29800**
84 198 32594	XX,YY	**30000**
84 198 33294	XX,YY	**29900**
84 198 42594	XX,YY	**30000**
84 198 34094	XX,YY	**29800**
84 198 43294	XX,YY	**29900**
84 198 44094	XX,YY	**29800**
84 198 32593	XX,YY	**30000**
84 198 33293	XX,YY	**29900**
84 198 42593	XX,YY	**30000**
84 198 34093	XX,YY	**29800**
84 198 43293	XX,YY	**29900**
84 198 52593	XX,YY	**30000**
84 198 53293	XX,YY	**29900**
84 198 44093	XX,YY	**29800**
84 198 54093	XX,YY	**29800**

9

Base holders for the exchangeable head system

Scope of supply:
Includes clamping screws



Adapter	LPR mm	LF mm	LB mm	DCONWS mm	right / left 84 193 ... #CU# *PA*	
HSK-T 40	90	55	35	25	XX,YY	**02539**
HSK-T 40	110	75	55	25	XX,YY	**12539**
HSK-T 40	115	80	60	32	XX,YY	**03239**
HSK-T 40	120	80		40	XX,YY	**04039**
HSK-T 63	105	70	44	25	XX,YY	**02537**
HSK-T 63	125	90	64	32	XX,YY	**03237**
HSK-T 63	140	100	74	40	XX,YY	**04037**
HSK-T 63	160	125	99	32	XX,YY	**13237**
HSK-T 63	180	140	114	40	XX,YY	**14037**
HSK-T 100	180	140	111	40	XX,YY	**04035**

Clamping Screw

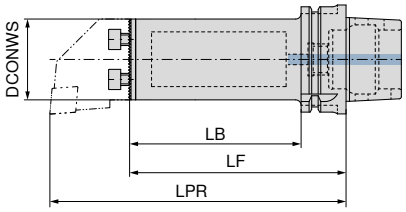
Spare parts for Article no.	84 950 ...	#CU# *PA*	
84 193 02539	M4X12 (SW3)	XX,YY	**30000**
84 193 12539	M4X12 (SW3)	XX,YY	**30000**
84 193 03239	M5X14 (SW4)	XX,YY	**29900**
84 193 04039	M6X16 (SW5)	XX,YY	**29800**
84 193 02537	M4X12 (SW3)	XX,YY	**30000**
84 193 03237	M5X14 (SW4)	XX,YY	**29900**
84 193 04037	M6X16 (SW5)	XX,YY	**29800**
84 193 13237	M5X14 (SW4)	XX,YY	**29900**
84 193 14037	M6X16 (SW5)	XX,YY	**29800**
84 193 04035	M6X16 (SW5)	XX,YY	**29800**

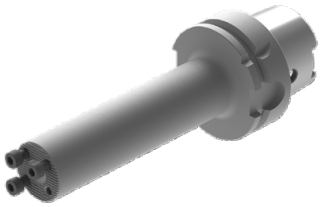
Base holders for the exchangeable head system – vibration-damped

▲ Reduzierung der Vibrationen durch Schwermetallkern

Scope of supply:

Includes clamping screws





Adapter	LPR mm	LF mm	LB mm	DCONWS mm	right / left 84 195 ... #CU# *PA*	
HSK-T 63	150	115	89	25	XX,YY	**02537**
HSK-T 63	185	150	124	32	XX,YY	**03237**
HSK-T 63	225	185	159	40	XX,YY	**04037**

Clamping Screw

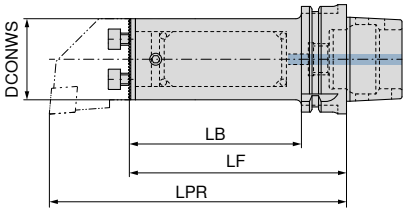
Spare parts for Article no.	84 950 ... #CU# *PA*	
84 195 02537	XX,YY	**30000**
84 195 03237	XX,YY	**30000**
84 195 04037	XX,YY	**30000**

9

Base holders for the exchangeable head system – actively vibration-damped

▲ Reduzierung der Schwingungen durch aktiv gelagerten Dämpfer
▲ Verbesserung der Oberflächengüte und Spanabfuhr

Scope of supply:
Includes clamping screws



NEW
right / left

Adapter	LPR mm	LF mm	LB mm	DCONWS mm	84 198 ... #CU# *PA*	
HSK-T 63	161	126	100	25	XX,YY	**32537**[1)]
HSK-T 63	186	151	125	25	XX,YY	**42537**[1)]
HSK-T 63	189	154	128	32	XX,YY	**33237**[1)]
HSK-T 63	221	186	160	32	XX,YY	**43237**[1)]
HSK-T 63	226	186	160	40	XX,YY	**34037**[1)]
HSK-T 63	266	226	200	40	XX,YY	**44037**[1)]

1) Not ex-stock

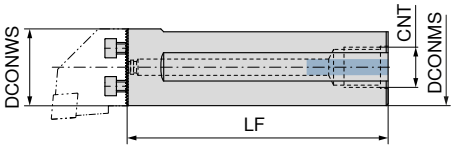
Clamping Screw

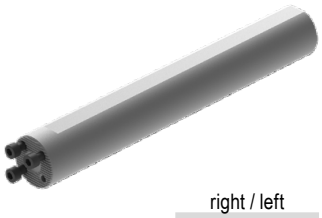
Spare parts for Article no.	84 950 ... #CU# *PA*	
84 198 42537	XX,YY	**30000**
84 198 32537	XX,YY	**30000**
84 198 43237	XX,YY	**29900**
84 198 33237	XX,YY	**29900**
84 198 44037	XX,YY	**29800**
84 198 34037	XX,YY	**29800**

Base holders for the exchangeable head system – cylindrical

▲ Connection thread for thro' coolant
▲ 3 clamping flats

Scope of supply:
Includes clamping screws





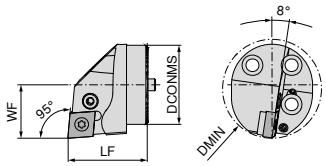
DCONWS mm	LF mm	DCONMS mm	CNT	right / left 84 194 ... #CU# *PA*	
25	200	25	1/4	XX,YY	**02599**
32	218	32	3/8	XX,YY	**03299**
40	283	40	1/2	XX,YY	**04099**

Clamping Screw

Spare parts for Article no.		84 950 ... #CU# *PA*	
84 194 02599	M4X12 (SW3)	XX,YY	**30000**
84 194 03299	M5X14 (SW4)	XX,YY	**29900**
84 194 04099	M6X16 (SW5)	XX,YY	**29800**

9

Exchangeable cutting head PCLN 95°



Illustrations show right-hand versions

DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert	Left-hand 84 159 ... #CU# *PA*	Right-hand 84 160 ... #CU# *PA*
25	35	32	17	5	CN.. 1204	XX,YY **02500**	XX,YY **02500**
32	35	40	22	5	CN.. 1204	XX,YY **03200**	XX,YY **03200**
40	40	50	27	5	CN.. 1204	XX,YY **04000**	XX,YY **04000**


Shim

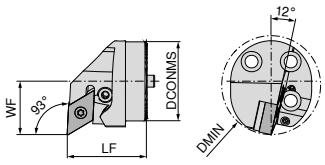

Elbow lever screw


Lever


Carbide type C

Spare parts for Article no.	Shim 84 950 ... #CU# *PA*		Elbow lever screw 84 950 ... #CU# *PA*	Lever 84 950 ... #CU# *PA*	Carbide type C 84 950 ... #CU# *PA*
84 160 02500 / 84 159 02500	XX,YY **29200**	M8X1/L17 SW3	XX,YY **28700**	XX,YY **29000**	XX,YY **27800**
84 160 03200 / 84 159 03200	XX,YY **29200**	M8X1/L17 SW3	XX,YY **28700**	XX,YY **29000**	XX,YY **27800**
84 160 04000 / 84 159 04000	XX,YY **29200**	M8X1/L17 SW3	XX,YY **28700**	XX,YY **29000**	XX,YY **27800**

Exchangeable cutting head PDUN 93°



Illustrations show right-hand versions

DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert	Left-hand 84 161 ... #CU# *PA*	Right-hand 84 162 ... #CU# *PA*
25	35	32	17	5	DN.. 1104	XX,YY **02500**	XX,YY **02500**
32	35	40	22	5	DN.. 1104	XX,YY **03200**	XX,YY **03200**
32	35	40	22	5	DN.. 1504 / 1506	XX,YY **13200**	XX,YY **13200**
40	40	50	27	5	DN.. 1104	XX,YY **04000**	XX,YY **04000**
40	40	50	27	5	DN.. 1504 / 1506	XX,YY **14000**	XX,YY **14000**

When using DN.. 1504 indexable inserts, use insert seat article no. 70 950 40000.


Shim

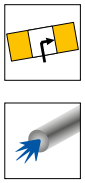

Elbow lever screw

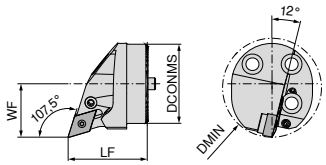

Lever


Solid Carbide Seat D

Spare parts for Article no.	Shim 84 950 ... #CU# *PA*		Elbow lever screw 84 950 ... #CU# *PA*	Lever 84 950 ... #CU# *PA*	Solid Carbide Seat D 84 950 ... #CU# *PA*
84 162 02500 / 84 161 02500	XX,YY **29300**	M6/ L14 SW2,5	XX,YY **28800**	XX,YY **29100**	XX,YY **28100**
84 162 03200 / 84 161 03200	XX,YY **29300**	M6/ L14 SW2,5	XX,YY **28800**	XX,YY **29100**	XX,YY **28100**
84 162 13200 / 84 161 13200	XX,YY **29200**	M8X1/L17 SW3	XX,YY **28700**	XX,YY **28900**	XX,YY **27900**
84 162 04000 / 84 161 04000	XX,YY **29300**	M6/ L14 SW2,5	XX,YY **28800**	XX,YY **29100**	XX,YY **28100**
84 162 14000 / 84 161 14000	XX,YY **29200**	M8X1/L17 SW3	XX,YY **28700**	XX,YY **28900**	XX,YY **27900**

Exchangeable cutting head PDQN 107.5°





Illustrations show right-hand versions

DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert	Left-hand 84 163 ... #CU# *PA*	Right-hand 84 164 ... #CU# *PA*
25	35	32	17	5	DN.. 1104	XX,YY **02500**	XX,YY **02500**
32	35	40	22	5	DN.. 1104	XX,YY **03200**	XX,YY **03200**
40	40	50	27	5	DN.. 1104	XX,YY **04000**	XX,YY **04000**


Shim

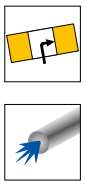

Elbow lever screw

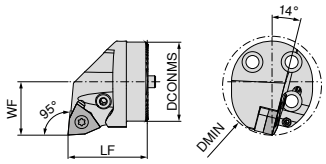

Lever


Solid Carbide Seat D

Spare parts for Article no.	#CU# *PA*		#CU# *PA*	#CU# *PA*	#CU# *PA*
	84 950 ...		84 950 ...	84 950 ...	84 950 ...
84 163 02500 / 84 164 02500	XX,YY **29300**	M6/ L14 SW2,5	XX,YY **28800**	XX,YY **29100**	XX,YY **28100**
84 163 03200 / 84 164 03200	XX,YY **29300**	M6/ L14 SW2,5	XX,YY **28800**	XX,YY **29100**	XX,YY **28100**
84 163 04000 / 84 164 04000	XX,YY **29300**	M6/ L14 SW2,5	XX,YY **28800**	XX,YY **29100**	XX,YY **28100**

Exchangeable cutting head PWLN 95°





Illustrations show right-hand versions

DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert	Left-hand 84 165 ... #CU# *PA*	Right-hand 84 166 ... #CU# *PA*
32	35	40	22	5	WN.. 0804	XX,YY **03200**	XX,YY **03200**
40	40	50	27	5	WN.. 0804	XX,YY **04000**	XX,YY **04000**


Shim

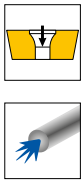

Elbow lever screw

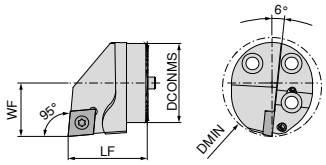

Lever

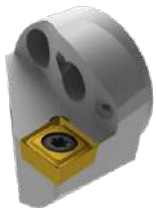

Solid Carbide Seat W

Spare parts for Article no.	#CU# *PA*		#CU# *PA*	#CU# *PA*	#CU# *PA*
	84 950 ...		84 950 ...	84 950 ...	84 950 ...
84 166 03200 / 84 165 03200	XX,YY **29200**	M8X1/L17 SW3	XX,YY **28700**	XX,YY **28900**	XX,YY **27700**
84 166 04000 / 84 165 04000	XX,YY **29200**	M8X1/L17 SW3	XX,YY **28700**	XX,YY **28900**	XX,YY **27700**

Exchangeable cutting head SCLC 95°







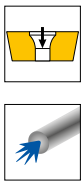
Illustrations show right-hand versions

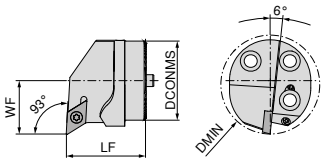
DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert	Left-hand 84 147 ... #CU# *PA*	Right-hand 84 148 ... #CU# *PA*
25	35	32	17	5	CC.. 1204	XX,YY **02500**	XX,YY **02500**
32	35	40	22	5	CC.. 1204	XX,YY **03200**	XX,YY **03200**
40	40	50	27	5	CC.. 1204	XX,YY **04000**	XX,YY **04000**

Clamping screw

Spare parts for Article no.	84 950 ... #CU# *PA*
84 148 02500 / 84 147 02500	XX,YY **27500**
84 148 03200 / 84 147 03200	XX,YY **27500**
84 148 04000 / 84 147 04000	XX,YY **27500**

Exchangeable cutting head SDUC 93°





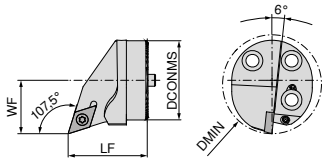
Illustrations show right-hand versions

DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert	Left-hand 84 143 ... #CU# *PA*	Right-hand 84 144 ... #CU# *PA*
25	35	32	17	3	DC.. 11T3	XX,YY **02500**	XX,YY **02500**
32	35	40	22	3	DC.. 11T3	XX,YY **03200**	XX,YY **03200**
40	40	50	27	3	DC.. 11T3	XX,YY **04000**	XX,YY **04000**

Clamping screw

Spare parts for Article no.	84 950 ... #CU# *PA*
84 144 02500 / 84 143 02500	XX,YY **27600**
84 144 03200 / 84 143 03200	XX,YY **27600**
84 144 04000 / 84 143 04000	XX,YY **27600**

Exchangeable cutting head SDQC 107.5°



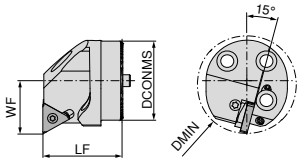
Illustrations show right-hand versions

DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert	Left-hand 84 145 ... #CU# *PA*	Right-hand 84 146 ... #CU# *PA*
25	35	32	17	3	DC.. 11T3	XX,YY **02500**	XX,YY **02500**
32	35	40	22	3	DC.. 11T3	XX,YY **03200**	XX,YY **03200**
40	40	50	27	3	DC.. 11T3	XX,YY **04000**	XX,YY **04000**

Clamping screw

Spare parts for Article no.	84 950 ... #CU# *PA*
84 146 02500 / 84 145 02500	XX,YY **27600**
84 146 03200 / 84 145 03200	XX,YY **27600**
84 146 04000 / 84 145 04000	XX,YY **27600**

Exchangeable cutting head for internal thread



Illustrations show right-hand versions

DCONMS mm	LF mm	DMIN mm	WF mm	torque moment Nm	Insert	Left-hand 84 167 ... #CU# *PA*	Right-hand 84 168 ... #CU# *PA*
25	35	32	17	2	16 ..	XX,YY **02500**	XX,YY **02500**
32	35	40	22	2	16 ..	XX,YY **03200**	XX,YY **03200**
40	40	50	27	2	16 ..	XX,YY **04000**	XX,YY **04000**

Suitable internal thread inserts can be found in → **Chapter 8 Thread Turning Tools, pages 6-30**

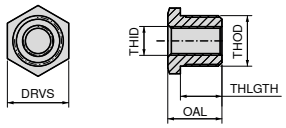
Spare parts for Article no.	Shim 84 950 ... #CU# *PA*		Screw-U 84 950 ... #CU# *PA*	Clamping screw 84 950 ... #CU# *PA*
84 168 02500	XX,YY **29500**	UNC5x7,3	XX,YY **29700**	XX,YY **29400**
84 167 02500	XX,YY **29600**	UNC5x7,3	XX,YY **29700**	XX,YY **29400**
84 168 03200	XX,YY **29500**	UNC5x7,3	XX,YY **29700**	XX,YY **29400**
84 167 03200	XX,YY **29600**	UNC5x7,3	XX,YY **29700**	XX,YY **29400**
84 168 04000	XX,YY **29500**	UNC5x7,3	XX,YY **29700**	XX,YY **29400**
84 167 04000	XX,YY **29600**	UNC5x7,3	XX,YY **29700**	XX,YY **29400**

Flexible coolant hoses

▲ incl. prefitted quick-coupler and coupler connector
▲ extremely flexible
▲ pressure-resistant up to 300 bar

Designation	BD mm	CND mm	OAL mm	72 990 ... #CU# *PA*	
MU.KSS-DN3-150	6.0	3	150	XX,YY	11005
MU.KSS-DN3-250	6.0	3	250	XX,YY	11006
MU.KSS-DN5-200	9.5	5	200	XX,YY	11001
MU.KSS-DN5-300	9.5	5	300	XX,YY	11002
MU.KSS-DN5-400	9.5	5	400	XX,YY	11003
MU.KSS-DN5-500	9.5	5	500	XX,YY	11004

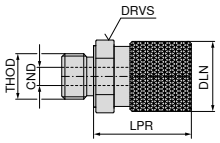
Threaded adapter



THID	THOD	THLGTH mm	DRVS mm	OAL mm	72 988 ... #CU# *PA*	
G1/8"	G1/4"	11.5	17	15.0	XX,YY	01005
G1/8"	M8x1	11.5	14	15.0	XX,YY	01006
G1/8"	M12x1	11.5	14	15.0	XX,YY	01007
G1/8"	M14x1	11.5	17	15.0	XX,YY	01008
M8x1	G1/4"	11.5	17	15.0	XX,YY	01003
M8x1	M12x1	11.5	14	15.0	XX,YY	01001
M8x1	M14x1	11.5	17	15.0	XX,YY	01002
M8x1	G1/8"	11.5	14	23.5	XX,YY	01004

Quick-coupler

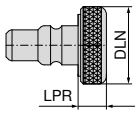
▲ pressure-resistant up to at least 400 bar
▲ rapid change of coolant distribution without screws thanks to click system



THOD	BD mm	DLN mm	LPR mm	CND mm	72 993 ... #CU# *PA*	
G1/8"	16	15.5	21.5	4	XX,YY	15001

Sealing plugs

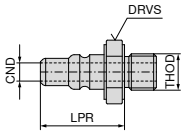
▲ for closing off the quick-coupler to protect against contamination



Designation	LPR mm	DLN mm	72 994 ... #CU# *PA*	
MU.KSVS	5.5	15.5	XX,YY	17001

Coupler connector

▲ pressure-resistant up to at least 400 bar



Designation	LPR mm	CND mm	DRVS mm	OAL mm	72 992 ... #CU# *PA*	
MU.KSKS-M8x1	18.5	4	12	19	XX,YY	13001

G1/8" screw plug

▲ Max. 200 bar/2900 psi
▲ No sealing ring required

Designation	THSZMS	72 950 ... #CU# *PA*	
VS.G1/8	G1/8"	XX,YY	010

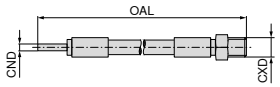
Angled coolant connection for distributor

Designation	THOD	THID	72 987 ... #CU# *PA*	
MU.KS-KA-KSV	G1/8"	G1/8"	XX,YY	18003

9

Hose (connecting piece/thread)

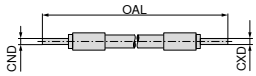
▲ Max. 200 bar/2900 psi
▲ No sealing ring required



Designation	THSZMS	CXD mm	OAL mm	72 305 ... #CU# *PA*	
HDKS.150.M5-4	M5	4	150	XX,YY	**010**
HDKS.200.M5-4	M5	4	200	XX,YY	**021**
HDKS.300.M5-4	M5	4	300	XX,YY	**033**
HDKS.500.M5-4	M5	4	500	XX,YY	**045**

Hose (connecting piece/connecting piece)

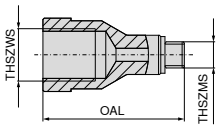
▲ Max. 200 bar/2900 psi



Designation	CND mm	CXD mm	OAL mm	72 305 ... #CU# *PA*	
HDKS.150.4-4	4	4	150	XX,YY	**003**
HDKS.200.4-4	4	4	200	XX,YY	**014**
HDKS.300.4-4	4	4	300	XX,YY	**025**
HDKS.500.4-4	4	4	500	XX,YY	**037**

Reducer fitting

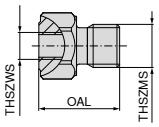
▲ Max. 200 bar/2900 psi
▲ Includes sealing ring



Designation	THSZWS	THSZMS	OAL mm	72 301 ... #CU# *PA*	
RV.100.M5-M6	M6	M5	15	XX,YY	**001**
RV.100.M5-M8x1	M8x1	M5	23	XX,YY	**003**
RV.100.M5-M10x1	M10x1	M5	27	XX,YY	**005**
RV.100.M5-G1/8	G1/8"	M5	27	XX,YY	**004**

Reducer fitting

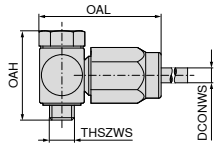
▲ Max. 200 bar/2900 psi
▲ No sealing ring required



Designation	THSZWS	THSZMS	OAL mm	72 301 ... #CU# *PA*	
RV.100.M6-M5	M5	M6	18	XX,YY	**002**
RV.100.M8x1-M5	M5	M8x1	15	XX,YY	**008**
RV.100.M10x1-M5	M5	M10x1	15	XX,YY	**007**
RV.100.G1/8-M5	M5	G1/8"	15	XX,YY	**006**

Swivel fitting

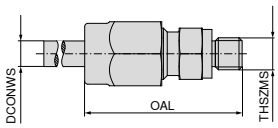
▲ Max. 200 bar/2900 psi



Designation	DCONWS mm	OAH mm	THSZMS	OAL mm	72 307 ... #CU# *PA*	
KA.SV.M5-4	4	21	M5	28	XX,YY	**017**
KA.SV.G1/8-4	4	30	G1/8"	37	XX,YY	**012**

Straight fitting

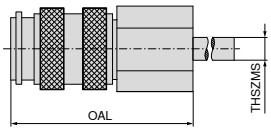
▲ Max. 200 bar/2900 psi



Designation	DCONWS mm	THSZMS	OAL mm	72 307 ... #CU# *PA*	
KA. M5-4	4	M5	27	XX,YY	**009**
KA. G1/8-4	4	G1/8"	32	XX,YY	**003**

Quick connection (coupling)

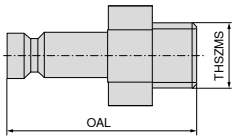
▲ Max. 200 bar/2900 psi



Designation	THSZMS	OAL mm	72 319 ... #CU# *PA*	
KIG.M5	M5	26	XX,YY	**001**

Quick connection (connector)

▲ Max. 200 bar/2900 psi
▲ No sealing ring required



Designation	THSZMS	OAL mm	72 320 ... #CU# *PA*	
SAG.M5	M5	20	XX,YY	**001**

9

Material examples for cutting data tables

	Material sub-group	Index	Composition / Structure / Heat treatment		Tensile strength N/mm²* / HB / HRC	Material number	Material designation	Material number	Material designation
P	Unalloyed steel	P.1.1	< 0,15 % C	Annealed	420 N/mm² / 125 HB	1.0401	C15	1.1141	Ck15
		P.1.2	< 0,45 % C	Annealed	640 N/mm² / 190 HB	1.1191	C45E	1.0718	9SMnPb28
		P.1.3		Tempered	840 N/mm² / 250 HB	1.1191	C45E	1.0535	C55
		P.1.4	< 0,75 % C	Annealed	910 N/mm² / 270 HB	1.1223	C60R	1.0535	C55
		P.1.5		Tempered	1010 N/mm² / 300 HB	1.1223	C60R	1.0727	45S20
	Low-alloy steel	P.2.1		Annealed	610 N/mm² / 180 HB	1.7131	16MnCr5	1.6587	17CrNiMo6
		P.2.2		Tempered	930 N/mm² / 275 HB	1.7131	16MnCr5	1.6587	17CrNiMo6
		P.2.3		Tempered	1010 N/mm² / 300 HB	1.7225	42CrMo4	1.3505	100Cr6
		P.2.4		Tempered	1200 N/mm² / 375 HB	1.7225	42CrMo4	1.3505	100Cr6
	High-alloy steel and high-alloy tool steel	P.3.1		Annealed	680 N/mm² / 200 HB	1.4021	X20Cr13	1.4034	X46Cr13
		P.3.2		Hardened and tempered	1100 N/mm² / 300 HB	1.2343	X38CrMoV5-1	1.4034	X46Cr13
		P.3.3		Hardened and tempered	1300 N/mm² / 400 HB	1.2343	X38CrMoV5-1	1.4034	X46Cr13
	Stainless steel	P.4.1	Ferritic / martensitic	Annealed	680 N/mm² / 200 HB	1.4016	X6Cr17	1.2316	X36CrMo16
		P.4.2	Martensitic	Tempered	1010 N/mm² / 300 HB	1.4112	X90CrMoV18	1.2316	X36CrMo16
M	Stainless steel	M.1.1	Austenitic / austenitic-ferritic	Quenched	610 N/mm² / 180 HB	1.4301	X5CrNi18-10	1.4571	X6CrNiMoTi17-12-2
		M.2.1	Austenitic	Tempered	300 HB	1.4841	X15CrNiSi25-21	1.4539	X1NiCrMoCu25-20-5
		M.3.1	Austenitic / ferritic (Duplex)		780 N/mm² / 230 HB	1.4462	X2CrNiMoN22-5-3	1.4501	X2CrNiMoCuWN25-7-4
K	Grey cast iron	K.1.1	Pearlitic / ferritic		350 N/mm² / 180 HB	0.6010	GG-10	0.6025	GG-25
		K.1.2	Pearlitic (martensitic)		500 N/mm² / 260 HB	0.6030	GG-30	0.6045	GG-45
	Spherulitic graphite cast iron	K.2.1	Ferritic		540 N/mm² / 160 HB	0.7040	GGG-40	0.7060	GGG-60
		K.2.2	Pearlitic		845 N/mm² / 250 HB	0.7070	GGG-70	0.7080	GGG-80
	Malleable iron	K.3.1	Ferritic		440 N/mm² / 130 HB	0.8035	GTW-35-04	0.8045	GTW-45
		K.3.2	Pearlitic		780 N/mm² / 230 HB	0.8165	GTS-65-02	0.8170	GTS-70-02
N	Aluminium wrought alloy	N.1.1	Non-hardenable		60 HB	3.0255	Al99,5	3.3315	AlMg1
		N.1.2	Hardenable	Age-hardened	340 N/mm² / 100 HB	3.1355	AlCuMg2	3.2315	AlMgSi1
	Cast aluminium alloy	N.2.1	≤ 12 % Si, non-hardenable		250 N/mm² / 75 HB	3.2581	G-AlSi12	3.2163	G-AlSi9Cu3
		N.2.2	≤ 12 % Si, hardenable	Age-hardened	300 N/mm² / 90 HB	3.2134	G-AlSi5Cu1Mg	3.2373	G-AlSi9Mg
		N.2.3	> 12 % Si, non-hardenable		440 N/mm² / 130 HB		G-AlSi17Cu4Mg		G-AlSi18CuNiMg
	Copper and copper alloys (bronze/brass)	N.3.1	Free-machining alloys, PB > 1 %		375 N/mm² / 110 HB	2.0380	CuZn39Pb2 (Ms58)	2.0410	CuZn44Pb2
		N.3.2	CuZn, CuSnZn		300 N/mm² / 90 HB	2.0331	CuZn15	2.4070	CuZn28Sn1As
		N.3.3	CuSn, lead-free copper and electrolytic copper		340 N/mm² / 100 HB	2.0060	E-Cu57	2.0590	CuZn40Fe
	Magnesium alloys	N.4.1	Magnesium and magnesium alloys		70 HB	3.5612	MgAl6Zn	3.5312	MgAl3Zn
S	Heat-resistant alloys	S.1.1	Fe - basis	Annealed	680 N/mm² / 200 HB	1.4864	X12NiCrSi 36-16	1.4865	G-X40NiCrSi38-18
		S.1.2		Age-hardened	950 N/mm² / 280 HB	1.4980	X6NiCrTiMoVB25-15-2	1.4876	X10NiCrAlTi32-20
		S.2.1	Ni or Co basis	Annealed	840 N/mm² / 250 HB	2.4631	NiCr20TiAl (Nimonic80A)	3.4856	NiCr22Mo9Nb
		S.2.2		Age-hardened	1180 N/mm² / 350 HB	2.4668	NiCr19Nb5Mo3 (Inconel 718)	2.4955	NiFe25Cr20NbTi
		S.2.3		Cast	1080 N/mm² / 320 HB	2.4765	CoCr20W15Ni	1.3401	G-X120Mn12
	Titanium alloys	S.3.1	Pure titanium		400 N/mm²	3.7025	Ti99,8	3.7034	Ti99,7
		S.3.2	Alpha + beta alloys	Age-hardened	1050 N/mm² / 320 HB	3.7165	TiAl6V4	Ti-6246	Ti-6Al-2Sn-4Zr-6Mo
		S.3.3	Beta alloys		1400 N/mm² / 410 HB	Ti555.3	Ti-5Al-5V-5Mo-3Cr	R56410	Ti-10V-2Fe-3Al
H	Hardened steel	H.1.1		Hardened and tempered	46–55 HRC				
		H.1.2		Hardened and tempered	56–60 HRC				
		H.1.3		Hardened and tempered	61–65 HRC				
		H.1.4		Hardened and tempered	66–70 HRC				
	Chilled iron	H.2.1		Cast	400 HB				
	Hardened cast iron	H.3.1		Hardened and tempered	55 HRC				
O	Non-metal materials	O.1.1	Plastics, duroplastic		≤ 150 N/mm²				
		O.1.2	Plastics, thermoplastic		≤ 100 N/mm²				
		O.2.1	Aramid fibre-reinforced		≤ 1000 N/mm²				
		O.2.2	Glass/carbon-fibre reinforced		≤ 1000 N/mm²				
		O.3.1	Graphite						

*** Tensile strength**

Cutting data standard values

Index			DRAGONSKIN													
	TCM407	TCM10	CTEP110	CTCP115-P	CTCP125-P	CTCP135-P	CTCK110	CTCK120	CTPM125	CTCM120	CTCM130	CTPX710 -F34 -M34 -M42	CTPX710 -25P -25Q	CTPX715 -27 -29	H210T	H10T H216T
	v_c in m/min															
P.1.1	380	310	460	370	295	210	395	330	200	230	185	325	340	275		
P.1.2	330	265	400	315	250	175	345	280	170	200	150	290	300	235		
P.1.3	280	230	350	270	210	145	300	240	140	175	125	250	260	200		
P.1.4	265	210	330	250	200	135	280	220	130	165	115	240	250	190		
P.1.5	240	190	300	230	180	120	260	200	120	150	100	220	235	170		
P.2.1	335	270	410	325	260	180	350	290	175	200	160	290	300	240		
P.2.2	260	210	325	250	195	130	280	220	130	160	110	235	250	185		
P.2.3	240	190	300	230	180	120	260	200	120	150	100	220	235	170		
P.2.4	180	145	230	170	130	85	200	150	80	115	60	175	190	125		
P.3.1	280	220	345	200	170	150	270	220	140	160	125	140	150	140		
P.3.2	225	170	280	140	105	95	225	175	100	115	80	85	95	80		
P.3.3	170	115	210	85	40	35	180	130	50	75	40	30	35	25		
P.4.1	280	220	345	200	170	155			140	160	125	140	155	140		
P.4.2	250	195	310	170	135	125			120	140	100	115	130	110		
M.1.1	280	220	345			155			140	160	125	140	150	140		
M.2.1						95			100	115	80	85	90	80		
M.3.1						135			130	150	110	125	130	120		
K.1.1			410	255	170		400	275						200	170	140
K.1.2			310	235	160		310	265						160	130	115
K.2.1	355	260	440	270	180		320	290						190	180	150
K.2.2	315	215	350	205	160		275	230						150	130	110
K.3.1	325	300	415	250	200		310	275						210	190	170
K.3.2	250	205	250	210	160		265	230						180	160	140
N.1.1												1840	1840	1750	1650	1400
N.1.2												1600	1600	1500	1350	1100
N.2.1												1250	1250	1200	1200	950
N.2.2												1250	1250	1200	1100	950
N.2.3												750	750	700	600	500
N.3.1												650	650	625	525	425
N.3.2												630	630	600	500	400
N.3.3												500	500	475	375	275
N.4.1												340	340	325	275	225
S.1.1											35	100	110	40	45	
S.1.2											25	80	85	30	35	
S.2.1											20	65	75	30	35	
S.2.2											20	40	45	25	25	
S.2.3											20	40	45	20	20	
S.3.1											110	95	100	110	110	
S.3.2											65	55	60	70	70	
S.3.3											45	40	45	50	50	
H.1.1																
H.1.2																
H.1.3																
H.1.4																
H.2.1																
H.3.1																
O.1.1														140	160	130
O.1.2																
O.2.1														150	140	105
O.2.2																
O.3.1																

The cutting data is strongly influenced by external conditions, such as the stability of the tool and workpiece clamping, material and type of machine. The specified values represent guideline cutting data that can be adjusted by approx. **±20%** according to the usage conditions.

9

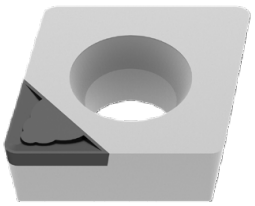
Cutting data standard values for diamond cutting materials CTD PD20 / PS30 / PU20 / CD10 / MD05

Index	Material group			a_p = 0,04–0,4 mm Surface roughness R_z in µm 2,5–5,0	a_p = 0,04–0,4 mm Surface roughness R_z in µm 5,0–10	a_p = 0,4–1,0 mm Surface roughness R_z in µm 2,5–5,0	a_p = 0,4–1,0 mm Surface roughness R_z in µm 5,0–10	a_p = 0,4–2,5 mm Surface roughness R_z in µm 2,5–5,0	a_p = 0,4–2,5 mm Surface roughness R_z in µm 5,0–10
				CTD ...	CTD ...	CTD ...	CTD ...	CTD ...	CTD ...
N.1.1 N.1.2	Aluminium wrought alloys without Si f=0.05–0.5 mm/rev.	○	Tool Material v_c in m/min	PD20 / PU20 / CD10 / MD05 **min. 400**	PD20 / PU20 / CD10 / MD05 **min. 400**	PD20 / PU20 / CD10 / MD05 **min. 400**	PD20 / PU20 / CD10 / MD05 **min. 400**	PD20 / PU20 / CD10 / MD05 **min. 400**	PD20 / PU20 / CD10 / MD05 **min. 400**
		◐	Tool Material v_c in m/min		PD20 / CD10 **min. 400**		PD20 / CD10 **min. 400**		PD20 / CD10 **min. 400**
		◌	Tool Material v_c in m/min	PD20 / PU20 **min. 400**	PD20 / PU20 **min. 400**	PD20 / PU20 **min. 400**	PD20 / PU20 **min. 400**	PD20 / PU20 **min. 400**	PD20 / PU20 **min. 400**
N.2.1	Cast Aluminium Alloys Si≤12 % – hardened or Si=12–20% – non hardened f=0,05–0,5 mm/rev.	○	Tool Material v_c in m/min	PS30 / PU20 / CD10 / MD05 **min. 600**	PS30 / PU20 / CD10 / MD05 **min. 600**	PS30 / PU20 / CD10 / MD05 **min. 600**	PS30 / PU20 / CD10 / MD05 **min. 600**	PS30 / PU20 / CD10 / MD05 **min. 600**	PS30 / PU20 / CD10 / MD05 **min. 600**
		◐	Tool Material v_c in m/min	PD20 / PU20 / CD10 **min. 400**	PD20 / PU20 / CD10 **min. 400**	PD20 / PU20 / CD10 **min. 400**	PS30 / PU20 / CD10 **min. 600**	PS30 / PU20 / CD10 **min. 400**	PS30 / PU20 / CD10 **min. 400**
		◌	Tool Material v_c in m/min	PS30 **min. 600**	PS30 **min. 600**	PS30 **min. 600**	PS30 **min. 600**	PS30 **min. 600**	
N.2.2 N.2.3	Aluminium cast alloys Si=12–20 % f=0.05–0.5 mm/rev.	○	Tool Material v_c in m/min	PU20 / CD10 / MD05 **min. 800**	PU20 / CD10 / MD05 **min. 400**	PU20 / CD10 / MD05 **min. 700**	PU20 / CD10 / MD05 **min. 400**	PU20 / CD10 / MD05 **min. 600**	PU20 / CD10 / MD05 **min. 400**
		◐	Tool Material v_c in m/min		PU20 / CD10 **min. 600**		PU20 / CD10 **min. 600**		PU20 / CD10 **min. 600**
		◌	Tool Material v_c in m/min		PU20 **min. 600**		PU20 **min. 600**		
N.3.1 N.3.2 N.3.3	Copper and copper wrought alloys f=0.05–0.5 mm/rev.	○	Tool Material v_c in m/min	PD20 / PU20 / CD10 / MD05 **min. 400**	PD20 / PU20 / CD10 / MD05 **min. 400**	PD20 / PU20 / CD10 / MD05 **min. 400**	PS30 / PU20 / CD10 / MD05 **300–1600**	PD20 / PU20 / CD10 / MD05 **min. 400**	PD20 / PU20 / CD10 / MD05 **min. 400**
		◐	Tool Material v_c in m/min	PU20 / CD10 **min. 300**	PD20 / PU20 / CD10 **min. 300**	PD20 / PU20 / CD10 **min. 400**	PS30 / PU20 / CD10 **min. 300**	PD20 / PU20 / CD10 **min. 400**	PD20 / PU20 / CD10 **min. 300**
		◌	Tool Material v_c in m/min		PD20 / PU20 **min. 300**		PS30 / PU20 **min. 300**	PD20 / PU20 **min. 300**	PS30 / PU20 **min. 200**
O.1.1 O.1.2	Plastic materials without reinforcement (acrylic glass) f=0.05–0.7 mm/rev.	○	Tool Material v_c in m/min		PD20 / CD10 / MD05 **min. 400**		PD20 / CD10 / MD05 **min. 300**		PS30 / CD10 / MD05 **min. 200**
		◐	Tool Material v_c in m/min		PD20 / CD10 **min. 300**		PD20 / CD10 **min. 200**		PS30 / CD10 **min. 200**
		◌	Tool Material v_c in m/min		PD20 / CD10 **min. 400**		PD20 / CD10 **min. 300**		PD20 / CD10 **min. 200**
O.2.1 O.2.2	Plastic materials with reinforcement (glass-fibre, carbon-fibre reinforced) f=0.05–0.7 mm/rev.	○	Tool Material v_c in m/min	PS30 / PU20 / CD10 / MD05 **min. 500**		PS30 / PU20 / CD10 / MD05 **min. 400**	PS30 / PU20 / CD10 / MD05 **min. 300**	PS30 / PU20 / CD10 / MD05 **min. 300**	PS30 / PU20 / CD10 / MD05 **min. 200**
		◐	Tool Material v_c in m/min	PS30 / PU20 / CD10 **min. 400**		PS30 / PU20 / CD10 **min. 300**	PS30 / PU20 / CD10 **min. 200**	PS30 / PU20 / CD10 **min. 200**	PS30 / PU20 / CD10 **min. 200**
		◌	Tool Material v_c in m/min	PU20 **min. 500**		PU20 **min. 400**	PU20 **min. 300**	PU20 **min. 300**	
O.3.1	Graphite		Tool Material v_c in m/min	PD20 / PS30 / PU20 / CD10 **min. 100**		PD20 / PS30 / PU20 / CD10 **min. 100**		PD20 / PS30 / PU20 / CD10 **min. 100**	

○ Smooth cut | ◐ Irregular cutting depth | ◌ Interrupted cut

Cutting data standard values for the CB chip breaker geometries

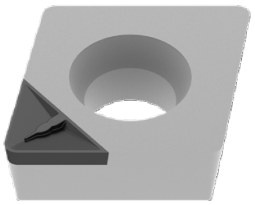
-CB1



3D-Chip Breaker -CB1				
Corner Radius	a_p in mm		f_z in mm/rev.	
	min.	max.	min.	max.
0,1 mm	0,05	0,30	0,02	0,05
0,2 mm	0,06	0,40	0,03	0,08
0,4 mm	0,10	0,80	0,04	0,15
0,8 mm	0,15	1,00	0,08	0,20
1,2 mm	0,30	1,50	0,12	0,25

- ▲ Finish and Superfinish
- ▲ Extremely sharp cutting edge geometry
- ▲ Depth of Cut a_p: 0.05–1.5 mm
- ▲ Smallest cutting pressure for highest accuracies
- ▲ For machining of thin-walled and unstable workpieces

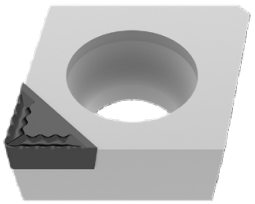
-CB2



3D-Chip Breaker -CB2				
Corner Radius	a_p in mm		f_z in mm/rev.	
	min.	max.	min.	max.
0,2 mm	0,50	0,80	0,08	0,12
0,4 mm	0,60	1,50	0,08	0,20
0,8 mm	0,70	1,50	0,15	0,30
1,2 mm	0,80	2,00	0,20	0,40

- ▲ Semi-finish and Finish machining
- ▲ Negative edge preperation
- ▲ Cutting Depth a_p: 0,5–2,0 mm
- ▲ High surface quality and tight tolerances
- ▲ Machining of solid workpieces under stable conditions

-CB3



3D-Chip Breaker -CB3				
Corner Radius	a_p in mm		f_z in mm/rev.	
	min.	max.	min.	max.
0,4 mm	1,00	3,00	0,10	0,20
0,8 mm	1,00	3,00	0,15	0,35

- ▲ Medium and rough machining
- ▲ Highly aggressive chip breaker
- ▲ Cutting depth a_p: 1,0–3,0 mm
- ▲ Stable component conditions necessary
- ▲ Cooling must be ensured

Cutting data standard values for negative inserts

	Designation	-CF20 (Cermet)						-F50					
		f			a_p			f			a_p		
		min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.
		mm/rev.			mm			mm/rev.			mm		
	CN.. 090304							0,06	**0,15**	0,25	0,2	**0,5**	1,5
	CN.. 090308							0,10	**0,20**	0,30	0,4	**1,0**	2,0
	CN.. 120404	0,05	**0,15**	0,25	0,3	**0,5**	1,5	0,06	**0,15**	0,25	0,2	**0,6**	1,5
	CN.. 120408	0,07	**0,15**	0,25	0,3	**0,5**	1,5	0,10	**0,20**	0,30	0,4	**1,0**	2,0
	CN.. 120412							0,14	**0,25**	0,35	0,6	**1,4**	2,6
	CN.. 120416												
	CN.. 160608												
	CN.. 160612												
	CN.. 160616												
	CN.. 160624												
	CN.. 190608												
	CN.. 190612												
	CN.. 190616												
	CN.. 190624												
	CN.. 250924												
	DN.. 110402							0,04	**0,10**	0,20	0,1	**0,4**	2,3
	DN.. 110404	0,05	**0,15**	0,25	0,3	**0,5**	1,5	0,06	**0,15**	0,25	0,2	**0,6**	1,5
	DN.. 110408	0,07	**0,15**	0,25	0,3	**0,5**	1,5	0,10	**0,20**	0,30	0,4	**1,0**	2,0
	DN.. 110412							0,14	**0,25**	0,35	0,6	**1,4**	2,6
	DN.. 150404							0,06	**0,15**	0,25	0,2	**0,6**	1,5
	DN.. 150408							0,10	**0,20**	0,30	0,4	**1,0**	2,0
	DN.. 150412							0,14	**0,25**	0,35	0,6	**1,4**	2,6
	DN.. 150416												
	DN.. 150604	0,05	**0,15**	0,25	0,3	**0,5**	1,5	0,06	**0,15**	0,25	0,2	**0,6**	1,5
	DN.. 150608	0,07	**0,15**	0,25	0,3	**0,5**	1,5	0,10	**0,20**	0,30	0,4	**1,0**	2,0
	DN.. 150612	0,10	**0,20**	0,30	0,5	**0,7**	1,5	0,14	**0,25**	0,35	0,6	**1,4**	2,6
	DN.. 150616												
	SN.. 090308							0,10	**0,20**	0,30	0,4	**1,0**	2,0
	SN.. 120404							0,06	**0,15**	0,25	0,2	**0,6**	1,5
	SN.. 120408							0,10	**0,20**	0,30	0,4	**1,0**	2,0
	SN.. 120412							0,14	**0,25**	0,35	0,6	**1,4**	2,6
	SN.. 120416												
	SN.. 150608												
	SN.. 150612												
	SN.. 150616												
	SN.. 190612												
	SN.. 190616												
	SN.. 190624												
	SN.. 250724												
	SN.. 250924												
	TN.. 110304							0,06	**0,15**	0,25	0,2	**0,6**	1,5
	TN.. 110308							0,10	**0,20**	0,30	0,4	**1,0**	2,0
	TN.. 160404	0,05	**0,15**	0,25	0,3	**0,5**	1,5	0,06	**0,15**	0,25	0,2	**0,6**	1,5
	TN.. 160408	0,07	**0,15**	0,25	0,3	**0,5**	1,5	0,10	**0,20**	0,30	0,4	**1,0**	2,0
	TN.. 160412	0,10	**0,20**	0,30	0,5	**0,7**	1,5	0,14	**0,25**	0,35	0,6	**1,4**	2,6
	TN.. 220404												
	TN.. 220408												
	TN.. 220412												
	TN.. 220416												
	VN.. 160404							0,06	**0,15**	0,25	0,2	**0,6**	1,5
	VN.. 160408							0,10	**0,20**	0,30	0,4	**1,0**	2,0
	VN.. 160412												
	WN.. 060404	0,05	**0,15**	0,25	0,3	**0,5**	1,5	0,06	**0,15**	0,25	0,2	**0,6**	1,5
	WN.. 060408	0,07	**0,15**	0,25	0,3	**0,5**	1,5	0,10	**0,20**	0,30	0,4	**1,0**	2,0
	WN.. 060412												
	WN.. 080404							0,06	**0,15**	0,25	0,2	**0,6**	1,5
	WN.. 080408	0,07	**0,15**	0,25	0,3	**0,5**	1,5	0,10	**0,20**	0,30	0,4	**1,0**	2,0
	WN.. 080412							0,14	**0,25**	0,35	0,6	**1,4**	2,6
	WN.. 080416												

Sharp ◄——————————————————————► stable

The data shows reference values. An adjustment to the actual conditions may be required.

Designation	-TFQ						-XU						-M50					
	f			a_p			f			a_p			f			a_p		
	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.
	mm/rev.			mm			mm/rev.			mm			mm/rev.			mm		
CN.. 090304																		
CN.. 090308																		
CN.. 120404	0,10	**0,15**	0,35	0,4	**1,0**	3,0	0,08	**0,15**	0,25	0,3	**1,5**	2,5	0,10	**0,20**	0,30	0,4	**2,0**	5,0
CN.. 120408	0,10	**0,25**	0,50	0,5	**1,5**	4,0	0,13	**0,25**	0,35	0,6	**2,0**	3,0	0,15	**0,25**	0,40	0,6	**2,0**	5,0
CN.. 120412	0,15	**0,30**	0,70	0,8	**2,0**	5,0	0,15	**0,30**	0,45	0,9	**2,0**	3,5	0,20	**0,30**	0,50	1,0	**2,0**	5,0
CN.. 120416													0,25	**0,40**	0,60	1,4	**2,0**	5,0
CN.. 160608													0,15	**0,25**	0,40	0,6	**3,0**	8,0
CN.. 160612													0,20	**0,30**	0,50	1,0	**3,0**	8,0
CN.. 160616													0,25	**0,40**	0,60	1,4	**3,0**	8,0
CN.. 160624																		
CN.. 190608																		
CN.. 190612																		
CN.. 190616																		
CN.. 190624																		
CN.. 250924																		
DN.. 110402																		
DN.. 110404													0,10	**0,20**	0,30	0,4	**1,5**	4,0
DN.. 110408													0,15	**0,25**	0,40	0,6	**1,5**	4,0
DN.. 110412													0,20	**0,30**	0,50	1,0	**1,5**	4,0
DN.. 150404													0,10	**0,20**	0,30	0,4	**2,0**	5,0
DN.. 150408													0,15	**0,25**	0,40	0,6	**2,0**	5,0
DN.. 150412													0,20	**0,30**	0,50	1,0	**2,0**	5,0
DN.. 150416													0,25	**0,40**	0,60	1,4	**2,0**	5,0
DN.. 150604	0,10	**0,15**	0,30	0,4	**1,0**	3,0	0,08	**0,15**	0,25	0,3	**1,5**	2,5	0,10	**0,20**	0,30	0,4	**2,0**	5,0
DN.. 150608	0,10	**0,25**	0,40	0,5	**1,5**	4,0	0,13	**0,25**	0,35	0,6	**2,0**	3,0	0,15	**0,25**	0,40	0,6	**2,0**	5,0
DN.. 150612							0,15	**0,25**	0,40	0,9	**2,0**	3,5	0,20	**0,30**	0,50	1,0	**2,0**	5,0
DN.. 150616													0,25	**0,40**	0,60	1,4	**2,0**	5,0
SN.. 090308																		
SN.. 120404																		
SN.. 120408													0,15	**0,25**	0,40	0,6	**2,0**	5,0
SN.. 120412													0,20	**0,30**	0,50	1,0	**2,0**	5,0
SN.. 120416													0,25	**0,40**	0,60	1,4	**2,0**	5,0
SN.. 150608													0,15	**0,25**	0,40	0,6	**3,0**	8,0
SN.. 150612													0,20	**0,30**	0,50	1,0	**3,0**	8,0
SN.. 150616													0,25	**0,40**	0,60	1,4	**3,0**	8,0
SN.. 190612																		
SN.. 190616																		
SN.. 190624																		
SN.. 250724																		
SN.. 250924																		
TN.. 110304																		
TN.. 110308																		
TN.. 160404													0,10	**0,20**	0,30	0,4	**2,0**	5,0
TN.. 160408													0,15	**0,25**	0,40	0,6	**2,0**	5,0
TN.. 160412													0,20	**0,30**	0,50	1,0	**2,0**	5,0
TN.. 220404																		
TN.. 220408													0,15	**0,25**	0,40	0,6	**3,0**	8,0
TN.. 220412													0,20	**0,30**	0,50	1,0	**3,0**	8,0
TN.. 220416																		
VN.. 160404							0,08	**0,15**	0,20	0,3	**1,0**	1,8	0,10	**0,20**	0,30	0,4	**1,0**	4,0
VN.. 160408							0,13	**0,20**	0,30	0,6	**1,5**	2,5	0,15	**0,25**	0,40	0,6	**1,0**	4,0
VN.. 160412													0,20	**0,30**	0,50	1,0	**1,0**	4,0
WN.. 060404	0,10	**0,18**	0,35	0,4	**0,8**	3,0							0,10	**0,20**	0,30	0,4	**1,0**	3,0
WN.. 060408	0,10	**0,20**	0,50	0,5	**1,5**	3,0							0,15	**0,25**	0,40	0,6	**1,0**	3,0
WN.. 060412													0,20	**0,30**	0,50	1,0	**1,0**	3,0
WN.. 080404							0,08	**0,15**	0,25	0,3	**1,5**	2,5	0,10	**0,20**	0,30	0,4	**1,5**	4,0
WN.. 080408	0,10	**0,25**	0,50	0,5	**1,5**	4,0	0,13	**0,22**	0,35	0,6	**2,0**	3,0	0,15	**0,25**	0,40	0,6	**1,5**	4,0
WN.. 080412	0,15	**0,30**	0,70	0,8	**2,0**	5,0	0,15	**0,25**	0,45	0,9	**2,0**	3,5	0,20	**0,30**	0,50	1,0	**1,5**	4,0
WN.. 080416													0,25	**0,40**	0,60	1,4	**1,5**	4,0

Sharp ◄——————————————————————► stable

Information on the cutting data of chip breakers not included in this overview, can be found on → **Page 201–207**

Cutting data standard values for negative inserts

	Designation	-TMQ						-M70					
		f			a_p			f			a_p		
		min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.
		mm/rev.			mm			mm/rev.			mm		
	CN.. 090304												
	CN.. 090308												
	CN.. 120404												
	CN.. 120408	0,20	**0,40**	0,65	0,8	**3,0**	5,0	0,20	**0,30**	0,45	0,8	**3,0**	6,0
	CN.. 120412	0,25	**0,50**	0,85	1,0	**3,0**	6,0	0,25	**0,40**	0,60	1,2	**3,0**	6,0
	CN.. 120416							0,30	**0,45**	0,70	1,6	**3,0**	6,0
	CN.. 160608							0,20	**0,30**	0,45	0,8	**4,0**	8,0
	CN.. 160612							0,25	**0,40**	0,60	1,2	**4,0**	8,0
	CN.. 160616							0,30	**0,45**	0,70	1,6	**4,0**	8,0
	CN.. 160624							0,40	**0,70**	1,20	2,4	**4,0**	8,0
	CN.. 190608							0,20	**0,30**	0,45	0,8	**4,5**	9,0
	CN.. 190612							0,25	**0,40**	0,60	1,2	**4,5**	9,0
	CN.. 190616							0,30	**0,45**	0,70	1,6	**4,5**	9,0
	CN.. 190624							0,40	**0,70**	1,20	2,4	**4,5**	9,0
	CN.. 250924							0,40	**0,70**	1,20	2,4	**6,0**	13,0
	DN.. 110402												
	DN.. 110404												
	DN.. 110408							0,20	**0,25**	0,45	0,8	**2,0**	5,0
	DN.. 110412							0,25	**0,35**	0,60	1,2	**2,0**	5,0
	DN.. 150404												
	DN.. 150408							0,20	**0,25**	0,45	0,8	**2,5**	6,0
	DN.. 150412							0,25	**0,35**	0,60	1,2	**2,5**	6,0
	DN.. 150416							0,30	**0,40**	0,70	1,6	**2,5**	6,0
	DN.. 150604												
	DN.. 150608	0,15	**0,30**	0,50	0,8	**2,5**	5,0	0,20	**0,25**	0,45	0,8	**2,5**	6,0
	DN.. 150612	0,20	**0,40**	0,60	1,0	**3,0**	5,0	0,25	**0,35**	0,60	1,2	**2,5**	6,0
	DN.. 150616							0,30	**0,40**	0,70	1,6	**2,5**	6,0
	SN.. 090308												
	SN.. 120404												
	SN.. 120408							0,20	**0,30**	0,50	0,8	**3,0**	6,0
	SN.. 120412							0,25	**0,40**	0,65	1,2	**3,0**	6,0
	SN.. 120416							0,30	**0,45**	0,70	1,6	**3,0**	6,0
	SN.. 150608												
	SN.. 150612							0,25	**0,40**	0,65	1,2	**4,0**	8,0
	SN.. 150616							0,30	**0,45**	0,75	1,6	**4,0**	8,0
	SN.. 190612							0,25	**0,40**	0,65	1,2	**4,5**	9,0
	SN.. 190616							0,30	**0,45**	0,75	1,6	**4,5**	9,0
	SN.. 190624							0,40	**0,70**	1,20	2,4	**4,5**	9,0
	SN.. 250724												
	SN.. 250924							0,40	**0,70**	1,20	2,4	**6,0**	13,0
	TN.. 110304												
	TN.. 110308												
	TN.. 160404												
	TN.. 160408							0,20	**0,25**	0,45	0,8	**2,5**	6,0
	TN.. 160412							0,25	**0,35**	0,60	1,2	**2,5**	6,0
	TN.. 220404							0,15	**0,20**	0,30	0,4	**3,0**	7,0
	TN.. 220408							0,20	**0,25**	0,45	0,8	**3,0**	7,0
	TN.. 220412							0,25	**0,35**	0,60	1,2	**3,0**	7,0
	TN.. 220416							0,30	**0,40**	0,70	1,6	**3,0**	7,0
	VN.. 160404												
	VN.. 160408												
	VN.. 160412												
	WN.. 060404												
	WN.. 060408							0,20	**0,30**	0,45	0,8	**2,0**	4,0
	WN.. 060412							0,25	**0,40**	0,60	1,2	**2,0**	4,0
	WN.. 080404												
	WN.. 080408	0,20	**0,30**	0,65	0,8	**3,0**	5,0	0,20	**0,30**	0,45	0,8	**2,5**	5,0
	WN.. 080412	0,25	**0,40**	0,85	1,0	**3,0**	6,0	0,25	**0,40**	0,60	1,2	**2,5**	5,0
	WN.. 080416							0,30	**0,45**	0,70	1,6	**2,5**	5,0

Sharp ◄——————————————————————► stable

The data shows reference values. An adjustment to the actual conditions may be required.

Designation	-R28						-R58						-R88					
	f			a_p			f			a_p			f			a_p		
	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.
	mm/rev.			mm			mm/rev.			mm			mm/rev.			mm		
CN.. 090304																		
CN.. 090308																		
CN.. 120404																		
CN.. 120408	0,25	**0,35**	0,55	0,8	**3,0**	7,0	0,25	**0,45**	0,70	1,0	**3,0**	7,0						
CN.. 120412	0,30	**0,45**	0,70	1,0	**3,0**	7,0	0,30	**0,55**	0,85	1,5	**3,0**	7,0						
CN.. 120416	0,30	**0,60**	0,90	1,5	**3,0**	7,0	0,35	**0,65**	1,00	2,0	**3,0**	7,0						
CN.. 160608																		
CN.. 160612	0,30	**0,45**	0,70	1,0	**4,0**	9,0	0,30	**0,55**	0,85	1,5	**4,0**	9,0						
CN.. 160616	0,35	**0,60**	0,90	1,5	**4,0**	9,0	0,35	**0,65**	1,00	2,0	**4,0**	9,0						
CN.. 160624							0,40	**0,75**	1,20	2,5	**4,0**	9,0	0,40	**0,70**	1,20	2,0	**5,0**	9,0
CN.. 190608																		
CN.. 190612	0,30	**0,45**	0,70	1,0	**5,5**	12,0	0,35	**0,55**	0,85	1,5	**5,5**	12,0						
CN.. 190616	0,35	**0,60**	0,90	1,5	**5,5**	12,0	0,40	**0,65**	1,00	2,0	**5,5**	12,0	0,40	**0,70**	1,00	2,0	**5,0**	12,0
CN.. 190624	0,35	**0,65**	1,00	2,0	**5,5**	12,0	0,40	**0,75**	1,20	2,5	**5,5**	12,0	0,40	**0,70**	1,20	2,0	**5,0**	12,0
CN.. 250924							0,45	**0,80**	1,30	2,5	**8,0**	16,0	0,60	**1,00**	1,50	3,5	**10,0**	18,0
DN.. 110402																		
DN.. 110404																		
DN.. 110408																		
DN.. 110412																		
DN.. 150404																		
DN.. 150408																		
DN.. 150412																		
DN.. 150416																		
DN.. 150604																		
DN.. 150608																		
DN.. 150612	0,25	**0,45**	0,70	1,0	**2,5**	6,0	0,30	**0,50**	0,80	1,5	**2,5**	6,0						
DN.. 150616	0,30	**0,60**	0,85	1,5	**2,5**	6,0	0,35	**0,60**	0,90	2,0	**2,5**	6,0						
SN.. 090308																		
SN.. 120404																		
SN.. 120408							0,25	**0,45**	0,70	1,0	**3,0**	7,0						
SN.. 120412							0,30	**0,55**	0,85	1,5	**3,0**	7,0						
SN.. 120416																		
SN.. 150608																		
SN.. 150612	0,30	**0,35**	0,70	1,0	**4,0**	9,0	0,30	**0,55**	0,85	1,5	**4,0**	9,0						
SN.. 150616	0,35	**0,60**	0,90	1,5	**4,0**	9,0	0,35	**0,65**	1,00	2,0	**4,0**	9,0						
SN.. 190612							0,35	**0,55**	0,85	1,5	**5,5**	12,0						
SN.. 190616	0,35	**0,60**	0,90	1,5	**5,5**	12,0	0,40	**0,65**	1,00	2,0	**5,5**	12,0	0,40	**0,70**	1,00	2,0	**5,0**	12,0
SN.. 190624							0,40	**0,75**	1,20	2,0	**5,5**	12,0	0,40	**0,70**	1,20	2,0	**5,0**	12,0
SN.. 250724	0,35	**0,65**	1,00	2,0	**7,0**	16,0	0,45	**0,80**	1,30	2,5	**8,0**	16,0	0,60	**1,00**	1,50	3,5	**10,0**	18,0
SN.. 250924	0,35	**0,65**	1,00	2,0	**7,0**	16,0	0,45	**0,80**	1,30	2,5	**8,0**	16,0	0,60	**1,00**	1,50	3,5	**10,0**	18,0
TN.. 110304																		
TN.. 110308																		
TN.. 160404																		
TN.. 160408																		
TN.. 160412																		
TN.. 220404																		
TN.. 220408																		
TN.. 220412							0,30	**0,50**	0,80	1,5	**3,0**	7,0						
TN.. 220416	0,30	**0,55**	0,85	1,5	**3,0**	7,0												
VN.. 160404																		
VN.. 160408																		
VN.. 160412																		
WN.. 060404																		
WN.. 060408																		
WN.. 060412																		
WN.. 080404																		
WN.. 080408																		
WN.. 080412																		
WN.. 080416																		

Sharp ◄——————————————————————► stable

Information on the cutting data of chip breakers not included in this overview, can be found on → **Page 201–207**

Cutting data standard values for negative inserts

	Designation	-F30						-M30					
		f			a_p			f			a_p		
		min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.
		mm/rev.			mm			mm/rev.			mm		
	CN.. 090304												
	CN.. 090308												
	CN.. 120404	0,05	**0,15**	0,25	0,4	**1,0**	2,0						
	CN.. 120408	0,10	**0,22**	0,35	0,8	**1,5**	2,5	0,15	**0,25**	0,40	1,0	**2,0**	4,5
	CN.. 120412							0,20	**0,30**	0,50	1,2	**2,5**	5,0
	CN.. 120416							0,25	**0,35**	0,55	1,6	**2,5**	5,0
	CN.. 160608												
	CN.. 160612												
	CN.. 160616												
	CN.. 160624												
	CN.. 190608												
	CN.. 190612												
	CN.. 190616												
	CN.. 190624												
	CN.. 250924												
	DN.. 110402												
	DN.. 110404	0,05	**0,15**	0,25	0,4	**1,0**	2,0						
	DN.. 110408	0,10	**0,20**	0,35	0,8	**1,5**	2,5	0,15	**0,25**	0,40	1,0	**2,0**	4,5
	DN.. 110412							0,20	**0,30**	0,50	1,2	**2,0**	4,5
	DN.. 150404												
	DN.. 150408												
	DN.. 150412												
	DN.. 150416												
	DN.. 150604	0,05	**0,15**	0,25	0,4	**1,0**	2,0						
	DN.. 150608	0,10	**0,20**	0,35	0,8	**1,5**	2,5	0,15	**0,25**	0,40	1,0	**2,0**	5,5
	DN.. 150612							0,20	**0,30**	0,50	1,2	**2,0**	5,5
	DN.. 150616												
	SN.. 090308												
	SN.. 120404	0,10	**0,15**	0,30	0,4	**1,0**	2,0						
	SN.. 120408	0,15	**0,20**	0,40	0,8	**1,5**	2,5	0,20	**0,25**	0,45	1,0	**2,0**	4,5
	SN.. 120412	0,15	**0,20**	0,40	1,2	**1,8**	2,5	0,25	**0,30**	0,50	1,2	**2,0**	5,0
	SN.. 120416												
	SN.. 150608												
	SN.. 150612												
	SN.. 150616												
	SN.. 190612												
	SN.. 190616												
	SN.. 190624												
	SN.. 250724												
	SN.. 250924												
	TN.. 110304												
	TN.. 110308												
	TN.. 160404	0,05	**0,15**	0,25	0,4	**1,0**	2,0						
	TN.. 160408	0,10	**0,15**	0,35	0,8	**1,5**	2,5	0,15	**0,25**	0,40	1,0	**2,0**	4,5
	TN.. 160412							0,20	**0,30**	0,50	1,2	**2,0**	4,5
	TN.. 220404												
	TN.. 220408												
	TN.. 220412												
	TN.. 220416												
	VN.. 160404	0,08	**0,10**	0,20	0,4	**1,0**	2,0						
	VN.. 160408	0,10	**0,15**	0,30	0,8	**1,5**	2,5	0,15	**0,25**	0,40	1,0	**1,5**	4,0
	VN.. 160412												
	WN.. 060404	0,05	**0,15**	0,25	0,4	**1,0**	2,0						
	WN.. 060408	0,10	**0,20**	0,30	0,8	**1,5**	2,5	0,15	**0,25**	0,40	1,0	**1,5**	3,5
	WN.. 060412							0,20	**0,30**	0,45	1,2	**1,5**	4,0
	WN.. 080404	0,05	**0,15**	0,25	0,4	**1,0**	2,0						
	WN.. 080408	0,10	**0,20**	0,35	0,8	**1,5**	2,5	0,15	**0,25**	0,40	1,0	**2,0**	4,5
	WN.. 080412							0,20	**0,30**	0,50	1,2	**2,0**	5,0
	WN.. 080416												

Sharp ◄——————————————————————► stable

The data shows reference values. An adjustment to the actual conditions may be required.

Designation	-M60						-M34					
	f			a_p			f			a_p		
	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.
	mm/rev.			mm			mm/rev.			mm		
CN.. 090304												
CN.. 090308												
CN.. 120404							0,08	**0,12**	0,18	1,0	**1,5**	3,0
CN.. 120408	0,25	**0,30**	0,50	1,5	**2,5**	6,0	0,10	**0,15**	0,35	1,0	**1,8**	3,5
CN.. 120412	0,30	**0,35**	0,55	2,0	**3,0**	6,0	0,13	**0,20**	0,40	1,5	**2,0**	4,0
CN.. 120416	0,30	**0,40**	0,60	2,0	**3,0**	6,0	0,15	**0,25**	0,45	2,0	**3,0**	4,5
CN.. 160608												
CN.. 160612	0,30	**0,35**	0,55	2,0	**3,0**	8,0						
CN.. 160616												
CN.. 160624												
CN.. 190608												
CN.. 190612												
CN.. 190616												
CN.. 190624												
CN.. 250924												
DN.. 110402												
DN.. 110404												
DN.. 110408												
DN.. 110412												
DN.. 150404							0,08	**0,12**	0,18	0,8	**1,2**	2,5
DN.. 150408							0,10	**0,15**	0,30	1,0	**1,8**	3,5
DN.. 150412							0,13	**0,20**	0,38	1,5	**2,0**	4,0
DN.. 150416												
DN.. 150604												
DN.. 150608	0,25	**0,30**	0,45	1,5	**2,5**	6,0	0,10	**0,15**	0,30	1,0	**1,8**	3,5
DN.. 150612	0,30	**0,40**	0,55	1,5	**2,5**	6,0	0,13	**0,20**	0,38	1,5	**2,0**	4,0
DN.. 150616												
SN.. 090308												
SN.. 120404												
SN.. 120408	0,30	**0,35**	0,50	1,5	**2,0**	6,0	0,15	**0,25**	0,40	1,0	**2,0**	4,0
SN.. 120412	0,30	**0,40**	0,55	2,0	**2,5**	6,0	0,15	**0,25**	0,45	1,5	**2,5**	4,5
SN.. 120416	0,30	**0,40**	0,60	2,0	**2,5**	6,0						
SN.. 150608												
SN.. 150612												
SN.. 150616												
SN.. 190612												
SN.. 190616												
SN.. 190624												
SN.. 250724												
SN.. 250924												
TN.. 110304												
TN.. 110308												
TN.. 160404												
TN.. 160408	0,25	**0,25**	0,45	1,5	**2,5**	5,0	0,10	**0,15**	0,35	1,0	**2,0**	4,0
TN.. 160412	0,30	**0,30**	0,55	2,0	**2,5**	5,5						
TN.. 220404							0,10	**0,15**	0,35	1,0	**2,0**	4,0
TN.. 220408							0,13	**0,20**	0,40	1,5	**2,5**	4,0
TN.. 220412												
TN.. 220416							0,15	**0,25**	0,45	2,0	**2,5**	4,5
VN.. 160404							0,07	**0,10**	0,18	0,8	**1,2**	2,0
VN.. 160408							0,10	**0,15**	0,20	1,0	**1,5**	2,5
VN.. 160412							0,13	**0,18**	0,25	1,5	**1,8**	3,0
WN.. 060404												
WN.. 060408	0,25	**0,30**	0,45	1,5	**2,0**	4,0						
WN.. 060412	0,30	**0,35**	0,50	2,0	**2,5**	4,5						
WN.. 080404												
WN.. 080408	0,25	**0,30**	0,50	1,5	**2,0**	5,0	0,10	**0,15**	0,35	1,0	**2,0**	4,0
WN.. 080412	0,30	**0,35**	0,55	2,0	**2,5**	5,5	0,13	**0,20**	0,40	1,5	**2,0**	4,0
WN.. 080416												

Sharp ◄——————————————————————► stable

Information on the cutting data of chip breakers not included in this overview, can be found on → **Page 201–207**

9

Cutting data values for positive inserts

	Designation	-CF05						-SF					
		f			a_p			f			a_p		
		min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.
		mm/rev.			mm			mm/rev.			mm		
	CC.. 060200							0,02	**0,035**	0,05	0,1	**0,4**	1,5
	CC.. 060201							0,02	**0,035**	0,05	0,2	**0,4**	1,5
	CC.. 060202	0,03	**0,08**	0,12	0,1	**0,3**	1,3	0,03	**0,1**	0,15	0,2	**0,4**	1,5
	CC.. 060204	0,05	**0,10**	0,12	0,1	**0,3**	1,3	0,05	**0,1**	0,2	0,2	**0,6**	1,5
	CC.. 060208							0,05	**0,125**	0,2	0,2	**1**	1,5
	CC.. 09T300							0,02	**0,035**	0,05	0,2	**0,75**	2
	CC.. 09T301							0,02	**0,035**	0,05	0,2	**0,75**	2
	CC.. 09T302	0,03	**0,08**	0,12	0,1	**0,3**	1,3	0,05	**0,075**	0,1	0,2	**0,75**	2
	CC.. 09T304	0,05	**0,10**	0,22	0,2	**0,4**	1,3	0,05	**0,12**	0,2	0,2	**0,75**	2
	CC.. 09T308	0,06	**0,13**	0,25	0,2	**0,4**	1,3	0,05	**0,125**	0,25	0,4	**1**	2
	CC.. 09T312												
	CC.. 120402							0,05	**0,075**	0,1	0,2	**0,8**	2,5
	CC.. 120404							0,05	**0,12**	0,2	0,2	**1**	2,5
	CC.. 120408							0,08	**0,15**	0,25	0,4	**1**	2,5
	CC.. 120412							0,08	**0,15**	0,25	0,4	**1,5**	2,5
	DC.. 0702005												
	DC.. 070201												
	DC.. 0702015												
	DC.. 070202	0,03	**0,08**	0,12	0,1	**0,3**	1,3	0,03	**0,1**	0,15	0,1	**0,4**	1,5
	DC.. 070204	0,05	**0,10**	0,22	0,2	**0,4**	1,3	0,05	**0,12**	0,2	0,2	**0,6**	1,5
	DC.. 070208												
	DC.. 11T3005												
	DC.. 11T301												
	DC.. 11T3015												
	DC.. 11T302	0,03	**0,08**	0,12	0,1	**0,3**	1,3						
	DC.. 11T304	0,05	**0,10**	0,22	0,2	**0,4**	1,3	0,05	**0,12**	0,2	0,2	**0,7**	2
	DC.. 11T308	0,06	**0,13**	0,25	0,2	**0,4**	1,3	0,08	**0,15**	0,25	0,4	**1**	2
	DC.. 11T312												
	RC.. 0602MO												
	RC.. 0803MO												
	RC.. 1003MO												
	RC.. 1204MO												
	RC.. 1606MO												
	RC.. 2006MO												
	RC.. 2507MO												
	SC.. 09T304	0,05	**0,10**	0,22	0,2	**0,4**	1,3	0,05	**0,12**	0,2	0,2	**0,7**	2
	SC.. 09T308	0,06	**0,13**	0,25	0,2	**0,4**	1,3	0,08	**0,15**	0,25	0,4	**1**	2
	SC.. 120408							0,08	**0,15**	0,25	0,4	**1**	2,5
	SC.. 120412												
	TC.. 090204												
	TC.. 110202	0,03	**0,08**	0,12	0,1	**0,3**	1,3						
	TC.. 110204	0,05	**0,10**	0,22	0,2	**0,4**	1,3	0,05	**0,12**	0,2	0,2	**0,7**	2
	TC.. 110208	0,06	**0,13**	0,25	0,2	**0,4**	1,3	0,08	**0,15**	0,25	0,4	**1**	2
	TC.. 16T302												
	TC.. 16T304	0,05	**0,10**	0,22	0,2	**0,4**	1,3	0,05	**0,12**	0,2	0,2	**0,8**	2,5
	TC.. 16T308							0,08	**0,15**	0,25	0,4	**1**	2,5
	TC.. 16T312												
	TC.. 220408												
	VC.. 1103005												
	VC.. 110301												
	VC.. 1103015												
	VC.. 110302	0,03	**0,06**	0,12	0,1	**0,3**	1,3	0,02	**0,08**	0,15	0,1	**0,4**	1,5
	VC.. 110304	0,05	**0,08**	0,22	0,2	**0,4**	1,3	0,05	**0,1**	0,2	0,2	**0,6**	1,5
	VC.. 110308							0,08	**0,12**	0,22	0,4	**1**	1,5
	VC.. 160402												
	VC.. 160404	0,05	**0,08**	0,22	0,2	**0,4**	1,3	0,05	**0,1**	0,2	0,2	**0,7**	2
	VC.. 160408	0,06	**0,10**	0,22	0,2	**0,4**	1,3	0,08	**0,12**	0,22	0,4	**1**	2
	VC.. 160412												
	VC.. 220530												
	WC.. 020102							0,02	**0,075**	0,1	0,1	**0,4**	1
	WC.. 020104							0,02	**0,1**	0,2	0,1	**0,6**	1,5

Sharp ◄——————————————————————► stable

The data shows reference values. An adjustment to the actual conditions may be required.

Designation	-CF55						-SMF						-SM					
	f			a_p			f			a_p			f			a_p		
	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.
	mm/rev.			mm			mm/rev.			mm			mm/rev.			mm		
CC.. 060200																		
CC.. 060201																		
CC.. 060202													0,04	**0,12**	0,2	0,2	**0,6**	2,5
CC.. 060204	0,05	**0,12**	0,22	0,2	**0,5**	1,3	0,07	**0,15**	0,25	0,3	**0,7**	2	0,08	**0,17**	0,3	0,4	**0,8**	2,5
CC.. 060208							0,1	**0,17**	0,27	0,6	**1**	2	0,12	**0,2**	0,35	0,8	**1**	2,5
CC.. 09T300																		
CC.. 09T301																		
CC.. 09T302																		
CC.. 09T304	0,05	**0,12**	0,22	0,2	**0,5**	1,3	0,07	**0,15**	0,25	0,3	**0,8**	2,5	0,08	**0,17**	0,3	0,4	**1**	3
CC.. 09T308	0,06	**0,15**	0,25	0,2	**0,5**	1,3	0,1	**0,17**	0,27	0,6	**1**	2,5	0,12	**0,2**	0,35	0,8	**1,2**	3
CC.. 09T312													0,15	**0,22**	0,4	1,2	**1,5**	3
CC.. 120402																		
CC.. 120404	0,05	**0,12**	0,22	0,2	**0,5**	1,3	0,07	**0,15**	0,25	0,3	**1**	3	0,08	**0,17**	0,3	0,4	**1,2**	3,5
CC.. 120408							0,1	**0,17**	0,27	0,6	**1,2**	3	0,12	**0,2**	0,35	0,8	**1,5**	3,5
CC.. 120412													0,15	**0,22**	0,4	1,2	**2**	3,5
DC.. 0702005																		
DC.. 070201																		
DC.. 0702015																		
DC.. 070202	0,03	**0,10**	0,12	0,1	**0,4**	1,3							0,04	**0,12**	0,2	0,2	**0,6**	2,5
DC.. 070204	0,05	**0,12**	0,22	0,2	**0,5**	1,3	0,07	**0,15**	0,25	0,3	**0,7**	2	0,08	**0,17**	0,3	0,4	**0,8**	2,5
DC.. 070208							0,1	**0,17**	0,27	0,6	**1**	2	0,12	**0,2**	0,3	0,8	**1**	2,5
DC.. 11T3005																		
DC.. 11T301																		
DC.. 11T3015																		
DC.. 11T302																		
DC.. 11T304	0,05	**0,12**	0,22	0,2	**0,5**	1,3	0,07	**0,15**	0,25	0,3	**0,8**	2,5	0,8	**0,17**	0,3	0,4	**1**	3
DC.. 11T308	0,06	**0,15**	0,25	0,2	**0,5**	1,3	0,1	**0,17**	0,27	0,6	**1,2**	2,5	0,12	**0,2**	0,35	0,8	**1,2**	3
DC.. 11T312													0,15	**0,22**	0,4	1,2	**1,7**	3
RC.. 0602MO													0,2	**0,3**	0,5	0,2	**0,5**	1,5
RC.. 0803MO													0,2	**0,3**	0,6	0,2	**0,6**	2
RC.. 1003MO													0,25	**0,4**	0,7	0,2	**0,7**	2,5
RC.. 1204MO													0,3	**0,5**	0,8	0,2	**0,8**	3
RC.. 1606MO							0,15	**0,3**	0,6	0,25	**2**	3,5	0,4	**0,6**	1	0,3	**1**	3,5
RC.. 2006MO													0,5	**0,8**	1,2	0,4	**1,2**	4
RC.. 2507MO													0,6	**0,9**	1,4	0,6	**2**	5
SC.. 09T304	0,05	**0,12**	0,22	0,2	**0,5**	1,3	0,07	**0,15**	0,25	0,3	**0,8**	2,5	0,08	**0,17**	0,3	0,4	**1**	3
SC.. 09T308	0,06	**0,15**	0,25	0,2	**0,5**	1,3	0,1	**0,17**	0,27	0,6	**1**	2,5	0,12	**0,2**	0,35	0,8	**1,2**	3
SC.. 120408							0,1	**0,17**	0,27	0,6	**1,2**	3	0,12	**0,2**	0,35	0,8	**1,5**	3,5
SC.. 120412													0,15	**0,22**	0,4	1,2	**2**	3,5
TC.. 090204													0,08	**0,12**	0,2	0,4	**0,8**	2
TC.. 110202													0,08	**0,1**	0,2	0,4	**0,6**	3
TC.. 110204	0,05	**0,12**	0,22	0,2	**0,5**	1,3							0,12	**0,2**	0,35	0,8	**1,2**	3
TC.. 110208							0,1	**0,17**	0,27	0,6	**1**	2,5	0,12	**0,2**	0,35	0,8	**1,2**	3
TC.. 16T302																		
TC.. 16T304							0,07	**0,15**	0,25	0,3	**1**	3	0,08	**0,17**	0,3	0,4	**1,2**	3,5
TC.. 16T308	0,06	**0,15**	0,25	0,2	**0,5**	1,3	0,1	**0,17**	0,27	0,6	**1,2**	3	0,12	**0,2**	0,35	0,8	**1,5**	3,5
TC.. 16T312													0,15	**0,22**	0,4	1,2	**1,7**	3,5
TC.. 220408													0,12	**0,2**	0,35	0,8	**2,5**	6
VC.. 1103005																		
VC.. 110301																		
VC.. 1103015																		
VC.. 110302							0,05	**0,1**	0,18	0,2	**0,5**	2						
VC.. 110304	0,05	**0,10**	0,22	0,2	**0,5**	1,3	0,07	**0,15**	0,23	0,3	**0,7**	2						
VC.. 110308																		
VC.. 160402																		
VC.. 160404	0,05	**0,10**	0,22	0,2	**0,5**	1,3	0,07	**0,15**	0,23	0,3	**0,8**	2,5	0,08	**0,17**	0,25	0,4	**1**	3
VC.. 160408	0,06	**0,12**	0,22	0,2	**0,5**	1,3	0,1	**0,17**	0,27	0,6	**1**	2,5	0,12	**0,2**	0,3	0,8	**1,2**	3
VC.. 160412													0,15	**0,22**	0,32	1,2	**1,5**	3
VC.. 220530																		
WC.. 020102																		
WC.. 020104																		

Sharp ◄——————————————————————————————► stable

Information on the cutting data of chip breakers not included in this overview, can be found on → **Page 201–207**

9

Cutting data values for positive inserts

Designation	-SMQ						-M25					
	f			a_p			f			a_p		
	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.
	mm/rev.			mm			mm/rev.			mm		
CC.. 060200												
CC.. 060201												
CC.. 060202												
CC.. 060204							0,06	**0,13**	0,20	0,2	**1,1**	2,0
CC.. 060208												
CC.. 09T300												
CC.. 09T301												
CC.. 09T302												
CC.. 09T304	0,10	**0,25**	0,4	0,4	**2**	4	0,06	**0,14**	0,22	0,2	**1,2**	2,2
CC.. 09T308	0,15	**0,30**	0,5	0,8	**2**	4	0,10	**0,20**	0,30	0,4	**1,8**	3,2
CC.. 09T312												
CC.. 120402												
CC.. 120404	0,10	**0,25**	0,4	0,4	**2**	4						
CC.. 120408	0,15	**0,30**	0,5	0,8	**2**	4						
CC.. 120412												
DC.. 0702005												
DC.. 070201												
DC.. 0702015												
DC.. 070202							0,04	**0,09**	0,13	0,1	**0,9**	1,6
DC.. 070204	0,10	**0,18**	0,25	0,4	**1,5**	3	0,06	**0,12**	0,18	0,2	**1,1**	2,0
DC.. 070208												
DC.. 11T3005												
DC.. 11T301												
DC.. 11T3015												
DC.. 11T302							0,04	**0,10**	0,16	0,1	**1,1**	2,0
DC.. 11T304	0,10	**0,25**	0,4	0,4	**2**	4	0,06	**0,14**	0,22	0,2	**1,2**	2,2
DC.. 11T308	0,15	**0,30**	0,5	0,8	**2**	4	0,10	**0,20**	0,30	0,4	**1,8**	3,2
DC.. 11T312												
RC.. 0602MO												
RC.. 0803MO												
RC.. 1003MO												
RC.. 1204MO												
RC.. 1606MO												
RC.. 2006MO												
RC.. 2507MO												
SC.. 09T304												
SC.. 09T308												
SC.. 120408												
SC.. 120412												
TC.. 090204												
TC.. 110202												
TC.. 110204							0,06	**0,13**	0,20	0,2	**1,2**	2,2
TC.. 110208												
TC.. 16T302												
TC.. 16T304							0,06	**0,14**	0,22	0,2	**1,6**	3,0
TC.. 16T308							0,10	**0,20**	0,30	0,4	**1,9**	3,4
TC.. 16T312												
TC.. 220408												
VC.. 1103005												
VC.. 110301												
VC.. 1103015												
VC.. 110302												
VC.. 110304												
VC.. 110308												
VC.. 160402												
VC.. 160404							0,06	**0,13**	0,20	0,2	**1,2**	2,2
VC.. 160408							0,10	**0,15**	0,25	0,4	**1,4**	3,0
VC.. 160412												
VC.. 220530												
WC.. 020102												
WC.. 020104												

Sharp ◄——————————————————————► stable

The data shows reference values. An adjustment to the actual conditions may be required.

Designation	-M55						-F05					
	f			a_p			f			a_p		
	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.	min.	Recommended	max.
	mm/rev.			mm			mm/rev.			mm		
CC.. 060200												
CC.. 060201							0,02	**0,03**	0,05	0,1	**1**	2
CC.. 060202							0,02	**0,05**	0,1	0,1	**1**	2
CC.. 060204	0,06	**0,13**	0,20	0,4	**1,5**	2,6	0,02	**0,1**	0,2	0,1	**1**	2
CC.. 060208												
CC.. 09T300												
CC.. 09T301												
CC.. 09T302												
CC.. 09T304	0,08	**0,16**	0,24	0,4	**1,7**	3,0						
CC.. 09T308	0,12	**0,24**	0,35	0,8	**2,4**	4,0						
CC.. 09T312												
CC.. 120402												
CC.. 120404	0,08	**0,18**	0,28	0,4	**2,2**	4,0						
CC.. 120408	0,12	**0,26**	0,40	0,8	**2,8**	4,8						
CC.. 120412												
DC.. 0702005							0,02	**0,025**	0,04	0,1	**1**	2
DC.. 070201							0,02	**0,03**	0,05	0,1	**1**	2
DC.. 0702015							0,02	**0,04**	0,075	0,1	**1**	2
DC.. 070202							0,02	**0,05**	0,1	0,1	**1**	2
DC.. 070204	0,06	**0,14**	0,22	0,4	**1,3**	2,2						
DC.. 070208	0,08	**0,16**	0,24	0,8	**1,6**	2,4						
DC.. 11T3005							0,02	**0,025**	0,04	0,1	**1,25**	2,5
DC.. 11T301							0,02	**0,03**	0,05	0,1	**1,25**	2,5
DC.. 11T3015							0,02	**0,04**	0,075	0,1	**1,25**	2,5
DC.. 11T302							0,02	**0,075**	0,1	0,1	**1,25**	2,5
DC.. 11T304	0,08	**0,16**	0,24	0,4	**1,7**	3,0	0,02	**0,1**	0,25	0,1	**1,25**	2,5
DC.. 11T308	0,12	**0,24**	0,35	0,8	**2,4**	4,0						
DC.. 11T312												
RC.. 0602MO												
RC.. 0803MO												
RC.. 1003MO												
RC.. 1204MO												
RC.. 1606MO												
RC.. 2006MO												
RC.. 2507MO												
SC.. 09T304	0,12	**0,24**	0,35	0,8	**2,4**	4,0						
SC.. 09T308	0,12	**0,26**	0,40	0,8	**2,8**	4,8						
SC.. 120408												
SC.. 120412												
TC.. 090204	0,06	**0,12**	0,18	0,4	**1,3**	2,2						
TC.. 110202												
TC.. 110204	0,06	**0,14**	0,22	0,4	**1,4**	2,4						
TC.. 110208												
TC.. 16T302												
TC.. 16T304												
TC.. 16T308	0,12	**0,24**	0,35	0,8	**2,6**	4,4						
TC.. 16T312												
TC.. 220408												
VC.. 1103005							0,02	**0,025**	0,04	0,1	**1,25**	2,5
VC.. 110301							0,02	**0,03**	0,05	0,1	**1,25**	2,5
VC.. 1103015							0,02	**0,04**	0,075	0,1	**1,25**	2,5
VC.. 110302							0,02	**0,075**	0,1	0,1	**1,25**	2,5
VC.. 110304							0,02	**0,15**	0,25	0,1	**1,25**	2,5
VC.. 110308												
VC.. 160402												
VC.. 160404	0,08	**0,14**	0,20	0,4	**1,7**	3,0						
VC.. 160408	0,12	**0,21**	0,30	0,8	**2,1**	3,4						
VC.. 160412												
VC.. 220530												
WC.. 020102												
WC.. 020104												

Sharp ◄——————————————————————► stable

Information on the cutting data of chip breakers not included in this overview, can be found on → **Page 201–207**

9

Diamond as a cutting material

Ensures

- ▲ Optimal surface quality
- ▲ burr-free workpieces
- ▲ high service lives
- ▲ lowest cutting forces
- ▲ High Process Security

Complete programme of roughing, finishing and Trailing edge inserts for machining aluminium, non ferrous metals, plastics, ...

The cutting materials

	CTD CD10 (CVD)	CTD PD20 (PKD)	CTD PU20 (PKD)	CTD PS30 (PKD)
	Fine grain Size (N10)	Fine grain grade (N20)	Coarse grain grade (N20)	Coarse grain Size (N30)
Properties	▲ perfect sharp edges ▲ no cutting pressure ▲ very close tolerances ▲ highest abrasion resistance with highest toughness ▲ very high heat conductivity	▲ high sharpness ▲ lower cutting pressure than PDC-S ▲ close tolerance ▲ lower abrasion resistance with increased toughness	▲ Very sharp cutting edge ▲ Reduced cutting pressure ▲ Tight tolerances ▲ Very high level of wear resistance and toughness	▲ high sharpness ▲ lower cutting pressure ▲ close tolerance ▲ lower abrasion resistance than with the PDC, with increased toughness
Material	suitable for superfinishing and semi-finishing of all non ferrous metals and NE-composite materials with small to high levels of abrasiveness	suitable for fine machining of all NE-materials with low abrasiveness	suitable for finishing to roughing non-ferrous metals and non-ferrous materials with highly abrasive alloying element. High chip removal on fibre-reinforced plastics such as CFRP and GFRP.	suitable for fine machining of all NE-materials and non-ferrous metals with low to very high levels of abrasiveness

Cutting Geometries

Neutral rake angle:

- ▲ higher cuting force
- ▲ higher temperature
- ▲ improved surface quality
- ▲ for stable workpieces

Positive rake angle:

- ▲ Lower cutting force
- ▲ Lower temperature
- ▲ reduction in surface quality
- ▲ for unstable workpieces
- ▲ improved accuracy

CB chip breaker geometries:

- ▲ Reliable chip control
- ▲ Ideal for low-alloy aluminium
- ▲ For F | M | R applications

Notes on diamond usage

- ▲ Coolant is not generally needed, however it facilitates chip removal
- ▲ Note the chemical reaction to carbide-forming elements (PCD)
- ▲ Note the thermal interaction and critical temperature:
  PCD: 600 °C, CVD: 700 °C
  Depending on the material, use cooling.

Standard chip breakers / application notes

Main application steel and cast iron, secondary application stainless steels

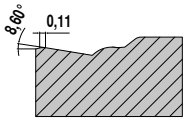
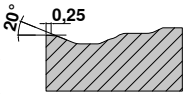
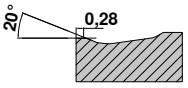
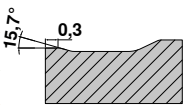
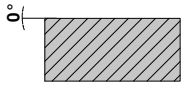
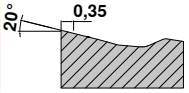
Negative

Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration a_p mm	Sectional illustration f mm	Geometry
-CF / -CF20 ▲ Fine finishing ▲ Sharp cutting edge for low cutting forces ▲ Good chip control even at small depths of cut	**CTEP110 / TCM10** CTEP110 / TCM10 CTEP110 / TCM10			0,30–1,50	0,07–0,25	CN.. DN.. TN.. WN..
-F40 ▲ Fine turning chip breaker for machining steels ▲ Good chip control ▲ Ideal for copy turning work	**CTCP125-P** CTCP125-P	**CTCP125-P** CTCP125-P		0,50–2,00	0,10–0,30	VN..
-F50 ▲ Fine turning chip breaker for fine machining ▲ Steel and stainless steels ▲ Excellent chip control ▲ High surface quality	**CTCP115-P / CTCP125-P**	**CTCP115-P / CTCP125-P / CTCP135-P** CTCP135-P	**CTCP135-P** CTCP135-P	0,10–2,60	0,06–0,35	CN.. DN.. SN.. TN.. VN.. WN..
-TFQ ▲ Wiper geometry ▲ Finishing to medium machining ▲ Very high feeds ▲ High surface quality	**CTEP110 / CTCP115-P** CTEP110 CTEP110 / CTCP115-P	**CTCP115-P / CTCP125-P** CTCP115-P / CTCP125-P		0,50–5,00	0,10–0,60	CN.. DN.. WN..
-XU ▲ Finishing to light roughing ▲ Universal chip breaker ▲ Copy turning ▲ Excellent chip formation ▲ Low cutting forces	**CTCP115-P / CTCP125-P** CTCP115-P	CTCP115-P / **CTCP125-P** CTCP115-P / CTCP125-P	CTCP125-P	0,40–4,50	0,12–0,40	CN.. DN.. VN.. WN..

Standard chip breakers / application notes

Main application steel and cast iron, secondary application stainless steels

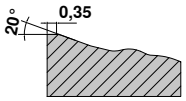
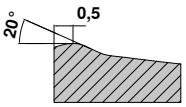
Negative

	Model	Smooth cut ○	Irregular cutting depth ◔	Interrupted cut ◌	Sectional illustration a_p mm	Sectional illustration f mm	Geometry
-M40 ▲ Stable geometry ▲ Medium feed rates ▲ Can be used for any application ▲ Good chip control	 **M**	**CTCP125-P** CTCP125-P	**CTCP125-P** CTCP125-P		 0,50–3,00	0,50–3,00	VN..
-M50 ▲ Medium machining ▲ First choice for steel machining ▲ Universal application ▲ Wide range of applications	 **M**	**CTCP115-P / CTCP125-P / CTCK110 / CTCK120** CTCP115-P CTCP115-P / CTCP125-P / **CTCK110 / CTCK120**	CTCP115-P / **CTCP125-P** CTCP125-P CTCP115-P / CTCP125-P / **CTCK110 / CTCK120**	CTCP125-P / **CTCP135-P** CTCP135-P CTCP125-P / **CTCK120**	 0,50–5,00	0,12–0,40	CN.. DN.. SN.. TN.. VN.. WN..
-TMQ ▲ Wiper geometry ▲ Light to medium rough machining ▲ Very high feeds ▲ High surface quality	 **M**	**CTCP115-P** CTCP125-P CTCP125-P	**CTCP125-P** CTCP125-P CTCP125-P		 0,80–6,00	0,20–0,85	CN.. DN.. WN..
-M70 ▲ Light to medium rough machining ▲ Cast crust and forging skin ▲ Stable cutting edge ▲ Interrupted cut ▲ Raw materials and forgings	 **M** **R**	**CTCK110 / CTCK120 / CTCP115-P** CTCP115-P **CTCK110 / CTCK120 /** CTCP115-P / CTCP125-P	CTCP115-P / **CTCP125-P** CTCP125-P **CTCK120** / CTCP125-P	**CTCP125-P / CTCP135-P** CTCP135-P CTCP125-P / **CTCK120**	 1,50–4,50	0,20–0,80	CN.. DN.. SN.. TN.. WN..
-NMA ▲ Rough machining ▲ Stable cutting edge ▲ For short-chipping materials ▲ First choice for grey cast iron	 **R**	**CTCK110**	**CTCK110 / CTCK120**	**CTCK120**	 1,50–4,50	0,20–0,80	CN.. DN.. SN.. TN.. WN..
-R28 ▲ Single sided roughing geometry ▲ Longitudinal, face and copy turning ▲ Varying depths of cut ▲ Steels with low tensile strength (800 N / mm²) ▲ Good chip control	 **R**	**CTCP115-P** / CTCP125-P CTCP115-P / CTCP125-P CTCP115-P	**CTCP115-P / CTCP125-P / CTCP135-P** CTCP125-P / CTCP135-P CTCP125-P	**CTCP135-P** CTCP135-P CTCP135-P	 1,00–12,00	0,25–0,80	CN.. DN.. SN..

Standard chip breakers / application notes

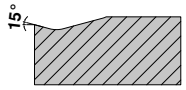
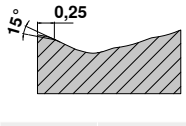
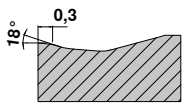
Negative

Main application steel and cast iron, secondary application stainless steels

Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration a_p mm	Sectional illustration f mm	Geometry
-R58 ▲ Single sided roughing geometry ▲ Longitudinal and face turning ▲ Light interrupted cut ▲ Low cutting forces ▲ Unstable machines	**CTCP115-P / CTCP125-P** CTCP115-P / CTCP125-P CTCP115-P	**CTCP115-P / CTCP125-P / CTCP135-P** CTCP125-P / CTCP135-P CTCP115-P / CTCP125-P	**CTCP135-P** CTCP135-P CTCP125-P			CN.. DN.. SN.. TN..
 **R**				1,50–12,00	0,30–1,20	
-R88 ▲ Single sided roughing geometry ▲ Longitudinal and face turning ▲ High feedrate ▲ Large depths of cut ▲ Heavily interrupted cut	**CTCP115-P / CTCP125-P** CTCP115-P / CTCP125-P CTCP115-P	**CTCP115-P / CTCP125-P / CTCP135-P** CTCP115-P / CTCP125-P CTCP115-P / CTCP125-P	**CTCP135-P** CTCP135-P CTCP125-P			SN..
 **R**				3,50–16,00	0,50–1,50	

Negative

Main application stainless steels, secondary application steel and super alloys

Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration a_p mm	Sectional illustration f mm	Geometry
-F30 ▲ Finishing of stainless steels ▲ Continous cut ▲ High surface quality ▲ Good swarf control	CTCM120 / CTPM125 **CTCM120 / CTPM125**	CTCM120 / CTPM125 / CTCM130 **CTCM120 / CTPM125 / CTCM130**	CTCM130 **CTCM130**			CN.. DN.. SN.. TN.. VN.. WN..
 **F**				0,08–2,5	0,10–0,35	
-M30 ▲ Option for stainless steel machining ▲ Good swarf control ▲ Little edg build up ▲ Low cutting forces ▲ Little built-up edge ▲ Applicable on unstable machines	CTCM120 / CTPM125 **CTCM120 / CTPM125**	CTCM120 / CTPM125 / CTCM130 **CTCM120 / CTPM125 / CTCM130**	CTCM130 **CTCM130**			CN.. DN.. SN.. TN.. VN.. WN..
 **F** **M**				1,00-4,50	0,15-0,40	
-M60 ▲ Light to medium roughing ▲ Stable cutting edge ▲ Interrupted cut ▲ Forged skin and cast crust	CTCM120 / CTPM125 **CTCM120 / CTPM125**	CTCM120 / CTPM125 / CTCM130 **CTCM120 / CTPM125 / CTCM130**	CTCM130 **CTCM130**			CN.. DN.. SN.. TN.. WN..
 **M** **R**				1,50–6,00	0,25–0,50	

9

Standard chip breakers / application notes

Negative

Main application super alloys, secondary application stainless steels	Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration	a_p mm	f mm	Geometry
-F34 ▲ Stable, positive cutting edge ▲ Also for slightly interrupted cuts	Dummy F	**CTPX710** CTPX710	**CTPX710** CTPX710		15°, 0,25, Dummy	0,50–2,50	0,08–0,25	CN.. WN..
-M34 ▲ First choice for superalloys ▲ Light cutting geometry ▲ Little built-up edge ▲ Low cutting forces	M	**CTPX710** **CTPX710** CTPX710 **CTPX710**	**CTPX710** **CTPX710** CTPX710 **CTPX710**		15°, 0,25	0,80–3,0	0,10–0,30	CN.. DN.. SN.. VN.. WN..
-M42 ▲ For medium machining on stainless steels ▲ As a secondary application for general steels and super alloys	M	**CTCM130** **CTPX710**	**CTCM130** **CTPX710**	**CTCM130**	20°, 0,3	1,0–3,50	0,15–0,40	CN.. DN..

Positive

Main application steel and cast iron, secondary application stainless steels and super alloys	Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration	a_p mm	f mm	Geometry
-CF05 ▲ Fine finishing ▲ For all common steel materials, stainless steels and GGG ▲ Good swarf control ▲ High surface quality	F	**CTEP110 / TCM407** CTEP110 CTEP110	TCM10 / TCM407 TCM10 / TCM407		15°	0,20–1,30	0,06–0,25	CC.. DC.. SC.. TC.. VC..
-SF ▲ Finishing / contour turning ▲ Good swarf control ▲ High surface quality ▲ Low cutting forces	F	**CTCP115-P**	**CTCP125-P** CTCP125-P	CTCP125-P / CTCP135-P CTCP125-P	15°	0,05–2,50	0,05–0,25	CC.. DC.. SC.. TC.. VC.. WC..
-CF55 ▲ Finishing to medium machining ▲ Suitable for general and stainless steels ▲ Low cutting forces ▲ Good swarf control ▲ High surface quality	F M	**CTEP110** CTEP110 CTEP110	**TCM10** / CTEP110 CTEP110 CTEP110		13°	0,20–1,30	0,06–0,25	CC.. DC.. SC.. TC.. VC..

Standard chip breakers / application notes

Positive

Main application steel and cast iron, secondary application stainless steels and super alloys

Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration a_p mm	Sectional illustration f mm	Geometrie
-SMF ▲ Finishing to medium machining ▲ Low cutting forces ▲ Good swarf control ▲ High surface quality	**CTEP110 / CTCP115-P** CTEP110 CTEP110	**TCM10 / CTCP125-P / CTCP115-P** CTCP135-P	**CTCP135-P** CTCP135-P	0,20–1,30	0,06–0,25	CC.. DC.. SC.. TC.. VC..
-M23 ▲ Soft cutting geometry with outstanding chip breaking behaviour at low cutting depths in finish machining	**CTCP115-P / CTCP125-P** CTCP115-P / CTCP125-P	**CTCP125-P** CTCP125-P	**CTCP125-P** CTCP125-P	0,30–4,0	1,0–0,45	RC..
-SM ▲ Medium machining ▲ Universal application ▲ Stable cutting edge ▲ Varying depths of cut ▲ Wide range of applications	**CTCP115-P / CTCP125-P** CTCP115-P / **CTCK110 / CTCK120**	**CTCP125-P / CTCP135-P / CTCP115-P** CTCP135-P CTCP125-P / **CTCK110 / CTCK120**	**CTCP125-P / CTCP135-P** CTCP135-P CTCK120	0,05–5,00	0,15–0,45	CC.. DC.. RC.. SC.. TC.. VC..
-SMQ ▲ Positive wiper geometry ▲ Finishing to medium machining ▲ Very high feeds ▲ High surface quality	**CTCP115-P** CTCP125-P / CTCP115-P	**CTCP125-P** CTCP125-P	**CTCP125-P** CTCP125-P	1,00–4,00	0,15–0,45	CC.. DC..

Positive

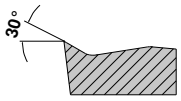
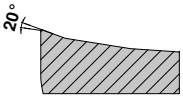
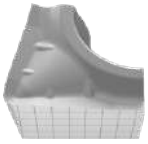
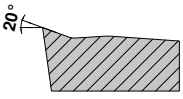
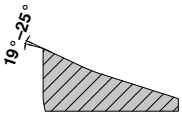
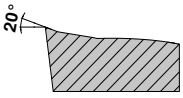
Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration a_p mm	Sectional illustration f mm	Geometrie
-M25 ▲ First choice for medium machining of stainless steels ▲ High surface quality ▲ Little built-up edge	CTCM120 / CTPM125 **CTCM120 / CTPM125**	CTCM120 / CTPM125 / CTCM130 **CTCM120 / CTPM125 / CTCM130**	CTCM130 **CTCM130**	0,40–3,20	0,10–0,30	CC.. DC.. TC.. VC..
-M55 ▲ First choice for medium machining to roughing of stainless steels ▲ Smooth to lightly interrupted cut ▲ Good swarf control ▲ Stable cutting edge	CTCM120 / CTPM125 **CTCM120 / CTPM125**	CTCM120 / CTPM125 / CTCM130 **CTCM120 / CTPM125 / CTCM130**	CTCM130 **CTCM130**	0,40–4,80	0,06–0,35	CC.. DC.. SC.. TC.. VC..

9

Standard chip breakers / application notes

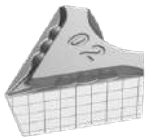
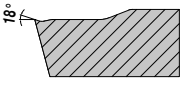
Positive

Main application non-ferrous metals, secondary application stainless steels, steels, super alloys, cast iron

Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration a_p mm	Sectional illustration f mm	Geometry
-23P ▲ Low adhesion ▲ Good chip control with soft aluminium alloys						
	H216T	H216T				CC.. DC..
	H216T	**H216T**	**H216T**			
F	H216T	H216T	H216T	0,2–4,0	0,05–0,3	
-25P ▲ Sharp cutting edge ▲ Good swarf control on soft aluminium alloys ▲ Low adhesion	**CTPX710**	CTPX710				
	**CTPX710**	CTPX710				CC.. DC.. SC.. VC..
	CTPX710 / H216T	**CTPX710 / H216T**	**CTPX710 / H216T**			
F **M**	**CTPX710**	CTPX710		0,50–4,50	0,05–0,60	
	CTPX710	CTPX710				
-25Q ▲ Wiper geometry ▲ High feeds ▲ High surface quality ▲ Good chip control with softer aluminium alloys ▲ Low adhesion	**CTPX710**	CTPX710				
	**CTPX710**	CTPX710				CC.. DC.. VC..
	H210T	H210T				
	H210T / CTPX710	**H210T / CTPX710**	**H210T / CTPX710**			
M	H210T / **CTPX710**	H210T / CTPX710		0,05–6,50	0,05–0,60	
	H210T	H210T	H210T			
-27 ▲ The universal Alu geometry ▲ Sharp cutting edge ▲ Extremely positive rake angle ▲ Low adhesion ▲ High feed rates	**CTPX715**	CTPX715				
	**CTPX715**	CTPX715				CC.. DC.. RC.. SC.. TC.. VC..
	CTPX715 / H216T	CTPX715 / H216T				
	CTPX715 / H216T	**CTPX715 / H216T**	**CTPX715 / H216T**			
M **R**	**CTPX715**	CTPX715		1,00–10,00	0,10–0,75	
	CTPX715 / H216T	CTPX715 / H216T	CTPX715 / H216T			
-29 ▲ Direct sintered aluminium geometry ▲ Positive rake angle ▲ Good chip control ▲ For medium to rough machining	CTPX710	CTPX710				
	CTPX710	CTPX710				CC.. DC.. VC..
	CTPX710	**CTPX710**				
	H216T	**H216T**	**H216T**			
M **R**	CTPX710	CTPX710		1,00–6,00	0,25–0,60	

Positive

Main application super alloys and stainless steels, secondary application steels and non-ferrous metals

Model	Smooth cut	Irregular cutting depth	Interrupted cut	Sectional illustration a_p mm	Sectional illustration f mm	Geometry
-F05 ▲ Maximum tolerance class ▲ Outstanding chip control, even with the smallest cutting depths ▲ Very low cutting forces	**CTPX710**	CTPX710				
	**CTPX710**	CTPX710				DC.. VC..
	CTPX710	CTPX710				
	CTPX710	**CTPX710**				
	CTPX710	**CTPX710**				
F	CTPX710	CTPX710		0,10–2,50	0,02–0,25	

Supplementary chip breakers / application notes

	Model	Smooth cut	Irregular cutting depth	Interrupted cut
-EN ▲ Universal chip breaker for general steels	 M	**CTCP115-P** CTCP125-P **CTCK110**	**CTCP125-P** CTCP135-P **CTCK120**	**CTCP135-P** CTCP135-P CTCP125-P
-ER | -EL ▲ A problem solver for unstable conditions ▲ Can be used on less powerful machines ▲ Can be used for general steels and on stainless materials as a secondary application	 M		**CTCP125-P**	**CTCP135-P**

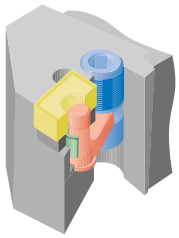
Clamping systems

MaxiLock D

- Clamping element
- Inserts
- Insert seat
- Pin
- Screw

The first-choice tool for machining with negative centre-hole inserts. Secure and precise positioning of the indexable insert thanks to the double clamping effect of the clamping element.

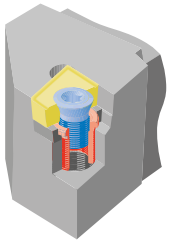
MaxiLock N



- Clamping element
- Inserts
- Insert seat
- Shim
- Lever

This clamping system is suitable for all centre-hole inserts with a negative basic shape. The clamping screw is easy to access from the top and bottom of the holder. When the clamping system is released, there are no loose spare parts.

MaxiLock S

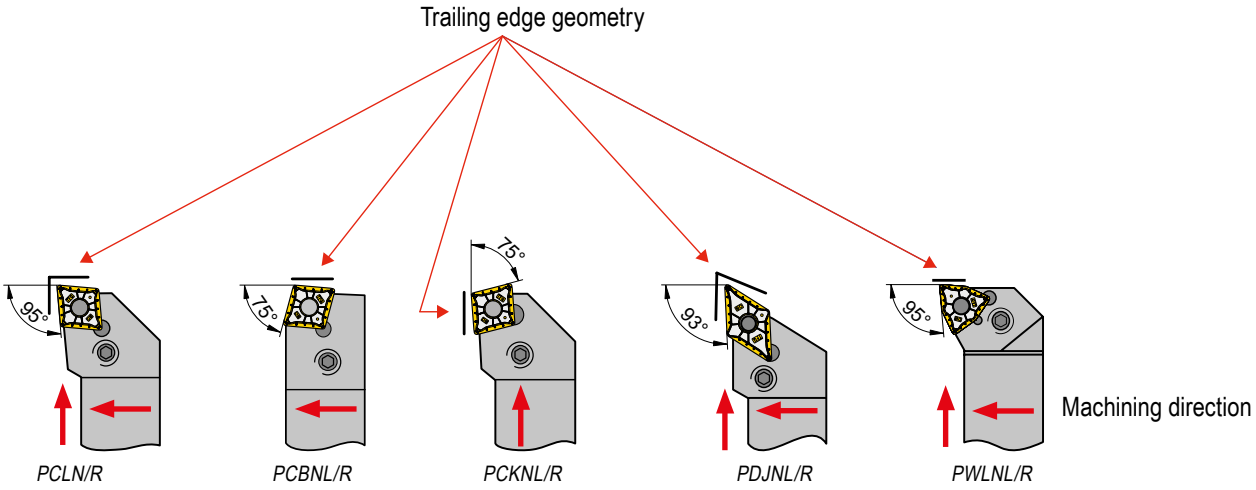


- Clamping element
- Inserts
- Insert seat
- Threaded sleeve

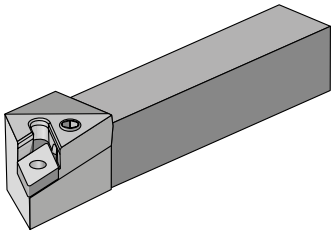
The positive screw clamping guarantees a secure connection between the indexable insert and the tool holder. The chip flow is not disrupted by protruding clamping elements. Thanks to the neutral insert position, the effective available rake angle is identical to the rake angle of the indexable insert.

Trailing edge geometry – information

High-quality surfaces can be produced inexpensively using indexable inserts with wiper geometry (-TFQ; -TMQ; -SMQ; -25Q).

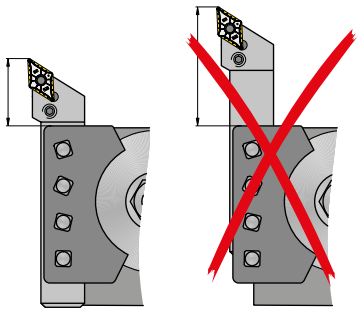


All turning inserts with trailing edge are clamped in standard ISO tool holders

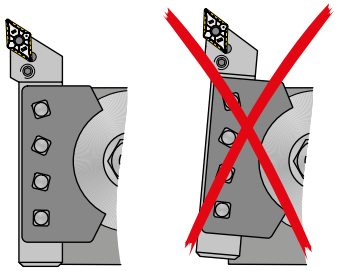


Check toolholder:

- ▲ Insert seat
- ▲ Shim
- ▲ Clamping Lever



Short tool overhang



Ensure correct tool alignment

Feed rate guide values for surface finish quality

Roughness range R_z in µm	R_{th}	Corresponds to R_a	Roughness index	ISO 1302	Corner radius r_ε in mm and feed rate f in mm/rev.						
					RE = 0,1	RE = 0,2	RE = 0,4	RE = 0,8	RE = 1,2	RE = 1,6	RE = 2,4
63–100	$R_{th}63$	12,5–25	N11	25	0,22*	0,32*	0,45*	0,63	0,78	0,9	1,1
40–63	$R_{th}40$	6,3–12,5	N10	12,5	0,18*	0,25*	0,36	0,51	0,62	0,72	0,88
31,5–40	$R_{th}31,5$	4,9–6,3	N9	6,3	0,16*	0,22*	0,32	0,45	0,55	0,63	0,78
25–31,5	$R_{th}25$	4,0–4,9			0,14*	0,2*	0,28	0,4	0,49	0,57	0,69
16–25	$R_{th}16$	2,5–4,0	N8	3,2	0,11*	0,16	0,23	0,32	0,39	0,45	0,55
10–16	$R_{th}10$	1,6–2,5			0,09	0,13	0,18	0,25	0,31	0,36	0,44
6,3–10	$R_{th}6,3$	1,0–1,6	N7	1,6	0,07	0,1	0,14	0,2	0,25	0,28	0,35
4–6,3	$R_{th}4$	0,8–1,0	N6	0,8	0,06	0,08	0,11	0,16	0,2	0,23	0,28
2,5–4	$R_{th}2,5$	0,4–0,8	N5	0,4	0,04	0,06	0,09	0,13	0,15	0,18	0,22
1,6–2,5	$R_{th}1,6$	0,2–0,4	N4	0,2	0,04	0,05	0,07	0,1	0,12	0,14	0,18
1–1,6	$R_{th}1$	0,1–0,2	N3	0,1	0,03	0,04	0,06	0,08	0,1	0,11	0,14

*Bitte vermeiden Sie, dass die angewendeten Vorschubswerte den Eckenradius (RE) übersteigen.

Trailing edge geometry – operating principle

Relationship of feed rate to surface roughness

Improved Surface Quality

Given identical feed rates, the indexable insert with wiper geometry attains an R_t value that is many times better than a conventional indexable insert.

Shorter machining time

If the same R_t value is achieved as with a standard indexable insert, the indexable insert with the wiper geometry can be moved at twice the feed speed **(= lower cycle times!)**

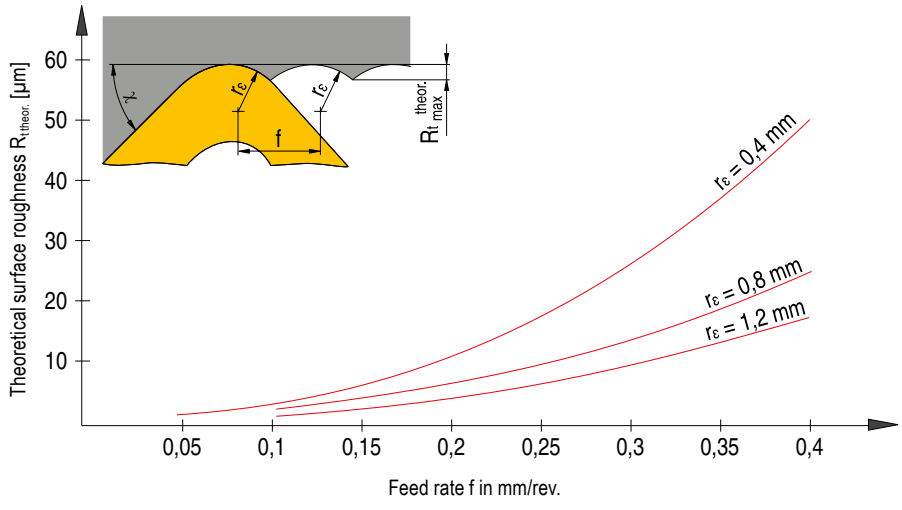
Theoretical Surface Quality

The maximum theoretical surface roughness with turning $Rt_{theor.}$ is the combination of feed rate and corner radius:

$$Rt_{theor.} = \left(r_\varepsilon - \sqrt{r_\varepsilon^2 - \frac{f^2}{4}}\right) \cdot 1000$$

or approximately:

$$Rt_{theor.} = \frac{125 \cdot f^2}{r\varepsilon} \quad [\mu m]$$



9

ISO designation system for inserts

Indexable inserts – metric

C	N	M	G	12	04	08	E	N	-	M50
1	2	3	4	5	6	7	8	9		13

Indexable inserts – inch

C	N	M	G	4	3	2	E	N	-	M50
1	2	3	4	5	6	7	8	9		13

Indexable inserts, CBN, ceramic – metric

C	N	G	A	12	04	08	S	N	-	020D	_	B	3	-	Q
1	2	3	4	5	6	7	8	9		10		11	12		13

Indexable inserts, CBN, ceramic – inch

C	N	G	A	4	3	2	S	N	-	020D	_	B	3	-	Q
1	2	3	4	5	6	7	8	9		10		11	12		13

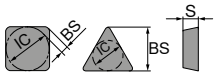
1 Insert shape

V	35°	Included angle
D	55°	
E	75°	
C	80°	
M	86°	
K	55°	Included angle
B	82°	
A	85°	
L	90°	Other shapes
P	108°	
H	120°	
O	135°	
R	-	
S	90°	
T	60°	
W	80°	

2 Clearance angle

	α		α
A	3°	F	25°
B	5°	G	30°
C	7°	N	0°
D	15°	P	11°
E	20°		
O	Clearance angles not included within the standard for which particular information is necessary.		

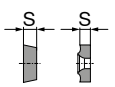
3 Tolerances



	IC±		BS		S	
	mm	inch	mm	inch	mm	inch
A	0,025	.0010	0,005	.0002	0,025	.001
F	0,013	.0005	0,005	.0002	0,025	.001
C	0,025	.0010	0,013	.0005	0,025	.001
H	0,013	.0005	0,013	.0005	0,025	.001
E	0,025	.0010	0,025	.0010	0,025	.001
G	0,025	.0010	0,025	.0010	0,13	.005
J	0,05-0,15*	.002-.006*	0,005	.0002	0,025	.001
K	0,05-0,15*	.002-.006*	0,013	.0005	0,025	.001
L	0,05-0,15*	.002-.006*	0,025	.0010	0,025	.001
M	0,05-0,15*	.002-.006*	0,05-0,20*	.003-.008*	0,13	.005
N	0,05-0,15*	.002-.006*	0,05-0,20*	.003-.008*	0,025	.001
U	0,08-0,25*	.003-.010*	0,13-0,38*	.005-.015*	0,13	.005

* Depends on insert size

6 Insert thickness



Code			
mm	inch	mm	inch
1,59	1/16	01	1
2,38	3/32	02	1.5
3,18	1/8	03	2
3,97	5/32	T3	2.5
4,76	3/16	04	3
5,56	7/32	05	3.5
6,35	1/4	06	4
7,94	5/16	07	5
9,52	3/8	09	6

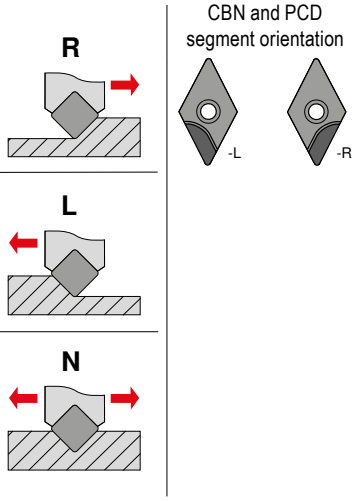
7 Corner radius

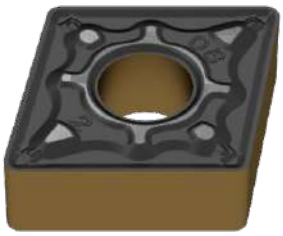
Code				RN 00 RC MO
mm	inch	mm	inch	
≤ 0,05	.0015	00	X0	
0,1	.004	01	0	
0,2	.008	02	.5	
0,4	1/64	04	1	
0,8	1/32	08	2	
1,2	3/64	12	3	
1,6	1/16	16	4	
2,0	5/64	20	5	
2,4	3/32	24	6	
2,8	7/64	28	7	
3,2	1/8	32	8	

8 Cutting edge

F	Sharp
E	rounded
T	chamfered
S	Chamfered and honed
K	Double-chamfered
P	Double-chamfered and honed
R	Round chamfer

9 Direction of cut





4 Characteristics

N	
R	
F	
A	
M, P	
G, P	
W	
T	
Q	
U	
B	
H	
C	
J	
X	Special version

inch
Change at inscribed circle
IK < 1/4"

IK > 1/4“	IK < 1/4“
N / R / F	E
A / M / G	D
X	X

5 Cutting length

Type	ISO	ANSI	L mm	L inch	IC mm	IC inch
C	06	2	6,4	.250	6,35	.250
	09	3	9,7	.382	9,525	.375
	12	4	12,9	.508	12,70	.500
	16	5	16,1	.634	15,875	.625
	19	6	19,3	.760	19,05	.750
	25	8	25,8	1.016	25,4	1.000
	32	12	35,24	1.269	31,75	1.250
S	06	2	6,35	.250	6,35	.250
	09	3	9,525	.375	9,525	.375
	12	4	12,7	.500	12,7	.500
	15	5	15,875	.625	15,875	.625
	19	6	19,05	.750	19,05	.750
	25	8	25,4	1.000	25,4	1.000
	31	10	31,75	1.250	31,75	1.250
D	07	2	7,7	.303	6,35	.250
	11	3	11,6	.457	9,525	.375
	15	4	15,5	.610	12,70	.500
V	11	2	11,1	.437	6,35	.250
	16	3	16,6	.653	9,525	.375
	22	4	22,10	.870	12,70	.500

Type	ISO	ANSI	L mm	L inch	IC mm	IC inch
T	06	1.2	6,9	.272	3,97	.156
	09	1.8	9,6	.378	5,56	.219
	11	2	11,0	.433	6,35	.250
	16	3	16,5	.650	9,525	.375
	22	4	22,	.079	12,70	.039
	27	5	27,5	1.083	15,875	.625
	33	6	33,0	1.299	19,05	.750
W	06	3	6,5	.256	9,525	.375
	08	4	8,7	.331	12,70	.039
	10	5	10,9	.429	15,875	.625
R	06	2	6,35	.250	6,35	.250
	08	-	8,0	.315	8,0	.315
	09	3	9,52	.375	9,52	.375
	10	-	10,0	.394	10,0	.394
	12*	-	12,0	.472	12,0	.472
	12	4	12,7	.488	12,70	.488
	15	5	15,875	.625	15,875	.625
	16	-	16,0	.630	16,0	.630
	19	6	19,05	.750	19,05	.750
	25	8	25,0	.984	25,0	.984
	25*	-	25,4	1.000	25,4	1.000
	31	10	31,75	1.250	31,75	1.250
	32	-	32,0	1.260	32,0	1.260

* inch version

10 Chamfer type

	mm	inch		
015	0,15	.006	A	05°
020	0,20	.008	B	10°
025	0,25	.010	C	15°
050	0,50	.020	D	20°
075	0,75	.030	E	25°
100	1,00	.040	F	30°
			G	35°

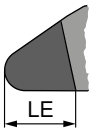
1) Two letters are assigned for double-chamfered cutting edges
e.g. BE =
chamfer angle 1 (y_1) = 10°
chamfer angle 2 (y_2) = 25°

11 Number of cutting edges

Single sided		Complete insert thickness	
A		T	
B		U	
C		V	
D		W	
G		X	
H		Y	

Double sided		Entire clamping flat	
K		S	
L		F	
M		E	
N			
P			
Q			

12 Segment length



Approx. specification in mm

13 Chip breaker designation

You can find a comprehensive chip breaker overview on → **page 201–207**

9

ISO designation system for tool holders

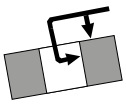
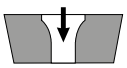
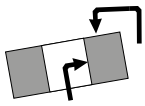
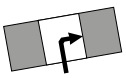
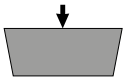
	P	C	L	N	R	20	20	K	12	-	T
	1	2	3	4	5	6	7	8	9		10
UT50	-	P	C	L	N	R			-12		
0		1	2	3	4	5	6	7	8	9	10
HSK-T63	-	D	C	L	N	R			-12		
0		1	2	3	4	5	6	7	8	9	10

0 System/size

UT = UTS
according to ISO 26622
UT40 = UTS 40 mm
UT50 = UTS 50 mm
UT63 = UTS 63 mm

HSK-T
according to ISO 12164
HSK-T63 = 63 mm
HSK-T100 = 100 mm

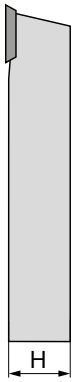
1 Tool holder

D		Retained from above and via bore	
S		Retained via centre screw	
M		Retained from above and via bore	
P		Retained via the bore	
C		Retained from above	
X		Special version	

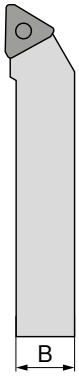
2 Insert shape

V	35°	Included angle	
D	55°		
E	75°		
C	80°		
M	86°		
K	55°	Included angle	
B	82°		
A	85°		
L	90°		Other shapes
P	108°		
H	120°		
O	135°		
R	-		
S	90°		
T	60°		
W	80°		

6 Shank height

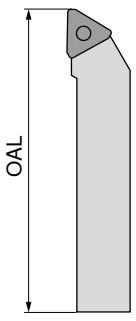


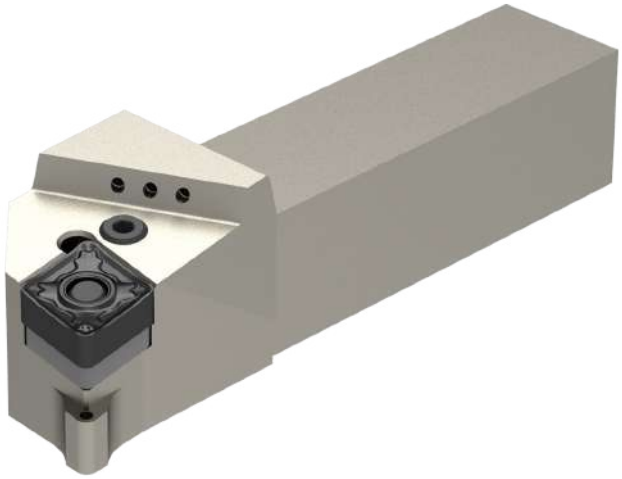
7 Shank width



8 Tool length

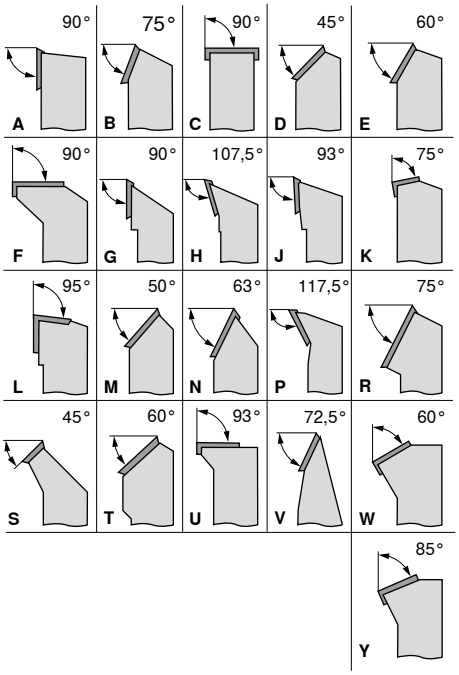
OAL mm	OAL inch		OAL mm	OAL inch	
32	4.000	**A**	160	4.500	**N**
40	4.500	**B**	170	5.500	**P**
50	5.000	**C**	180	–	**Q**
60	6.000	**D**	200	6.000	**R**
70	7.000	**E**	250	7.000	**S**
80	8.000	**F**	300	8.000	**T**
90	5.500	**G**	350	5.500	**U**
100	5.625	**H**	400	3.500	**V**
110	5.300	**J**	450	3.500	**W**
125	14.000	**K**	500	3.750	**Y**
140	6.800	**L**	Special version		**X**
150	4.400	**M**			





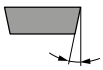
3

Style



4

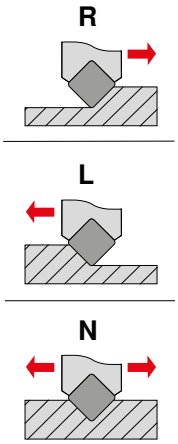
Clearance angle



	α		α
A	3°	F	25°
B	5°	G	30°
C	7°	N	0°
D	15°	P	11°
E	20°		
O	Clearance angles not included within the standard for which particular information is necessary.		

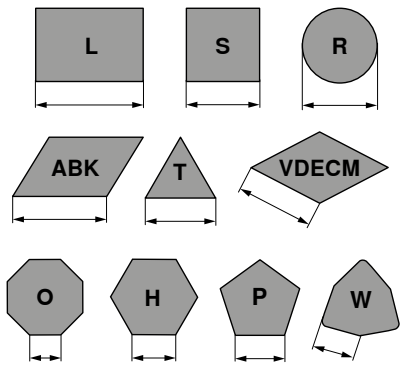
5

Direction of cut



9

Cutting length



10

Manufacturer specification

T = Toggle
Special length (mm)
Insert thickness (deviating from standard)
Special version (X..)
Machine manufacturer (specific)
DC = DirectCooling

ISO designation system for boring bars

		A	25	R		P	C	L	N	R	12	
		1	2	3		4	5	6	7	8	9	10
UT40	-		25	G	-	P	C	L	N	R	- 12	
0		1	2	3		4	5	6	7	8	9	10
HSK-T63	-		50	Q	-	D	C	L	N	R	- 12	
0		1	2	3		4	5	6	7	8	9	10

0 System/size

UT = UTS
according to ISO 26622
UT40 = UTS 40 mm
UT50 = UTS 50 mm
UT63 = UTS 63 mm

HSK-T
according to ISO 12164
HSK-T63 = 63 mm
HSK-T100 = 100 mm

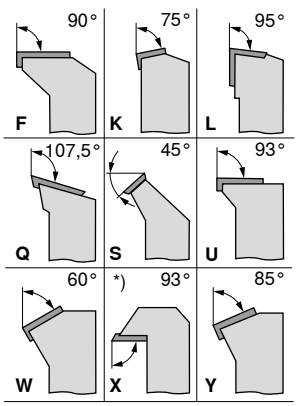
1 Shank type

S	Steel shank	**E**	As C with coolant hole
A	Steel shank with coolant hole	**F**	As C with antivibration system
B	Steel shank with antivibration system	**G**	As C with coolant hole and antivibration system
D	Steel shank with coolant hole and antivibration system	**H**	Heavy metal
C	Carbide shank with steel head	**J**	Heavy metal with coolant hole

5 Insert shape

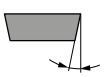
V	35°	Included angle	
D	55°		
E	75°		
C	80°		
M	86°		
K	55°	Included angle	
B	82°		
A	85°		
L	90°		Other shapes
P	108°		
H	120°		
O	135°		
R	-		
S	90°		
T	60°		
W	80°		

6 Style



*) CERATIZIT factory standard

7 Clearance angle

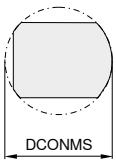


	α		α
A	3°	**F**	25°
B	5°	**G**	30°
C	7°	**N**	0°
D	15°	**P**	11°
E	20°		
O	Clearance angles not included within the standard for which particular information is necessary.		

2

Shank type & size

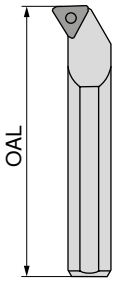
DCONMS mm	DCONMS inch
08	A two-digit figure indicating the boring bar diameter in 1/16 of an inch.
10	
12	
16	
20	
25	
32	
40	
50	
60	



3

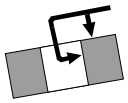
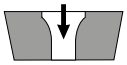
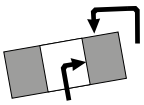
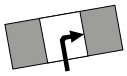
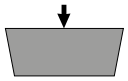
Tool length

OAL mm	OAL inch	
80	3	F
100	3,5	H
110	4	J
125	4,5	K
140	5	L
150	5,5	M
160	6	N
170	6,5	P
180	6,75	Q
200	7	R
250	8	S
300	10	T
350	12	U
400	14	V
450	16	W
500	18	Y
	20	
Special version		X



4

Clamping method

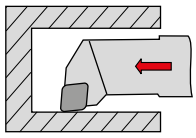
D  Retained from above and via bore	**S**  Retained via centre screw
M  Retained from above and via bore	**P**  Retained via the bore
C  Retained from above	**X** Special version

9

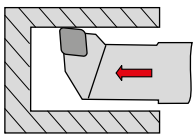
8

Direction of cut

R

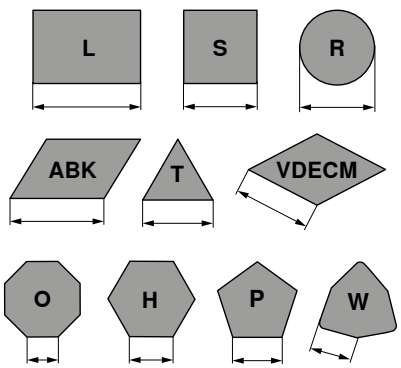


L



9

Cutting length



10

Manufacturer specification

T = Toggle
Special length (mm)
Insert thickness (deviating from standard)
Special version (X..)
Machine manufacturer (specific)

Types of wear

Wear on clearance face

Abrasion on flank: normal wear after a certain machining time

Cause
- Too high cutting speed
- Carbide grade with too low wear resistance
- Feed rate not adapted

Remedy
- Reduce cutting speed
- Use grade with higher wear resistance
- Adapt feed rate to cutting speed and cutting depth

Edge chipping

Through excessive mechanical stress at the cutting edge fracture and chipping can occur.

Cause
- Grade with too high wear resistance
- Vibration
- Too high cutting speed and / or feed rate
- Interrupted cut
- Swarf damage

Remedy
- Use tougher grade
- Use negative cutting edge geometry with chip groove
- Improve stability (tool, work piece)

Cratering

The hot chip which is being evacuated causes cratering at the rake face of the cutting edge.

Cause
- Too high cutting speed and / or feed rate
- Rake angle too shallow
- Grade with insufficient wear resistance
- Insufficient coolant supply

Remedy
- Reduce cutting speed and / or feed rate
- Use grade with higher wear resistance
- Increase coolant quantity and / or pressure, optimise coolant supply
- Use grade which is more resistant to cratering

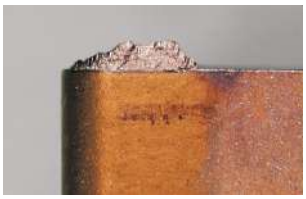
Plastic deformation

High machining temperature and simultaneous mechanical stress can lead to plastic deformation.

Cause
- Too high machining temperature resulting in softening of substrate
- Damage of coating
- Grade with insufficient wear resistance
- Insufficient coolant supply

Remedy
- Reduce cutting speed
- Use grade with higher wear resistance
- Provide cooling

Built-up edge



Built-up material / edges occur when the chip is not evacuated properly due to insufficient cutting temperature.

Cause
- Insufficient cutting speed
- Rake angle too shallow
- Wrong cutting material
- Lack of cooling / lubrication

Remedy
- Increase cutting speed
- Increase rake angle
- Apply TiN coating
- Use emulsion with higher concentration

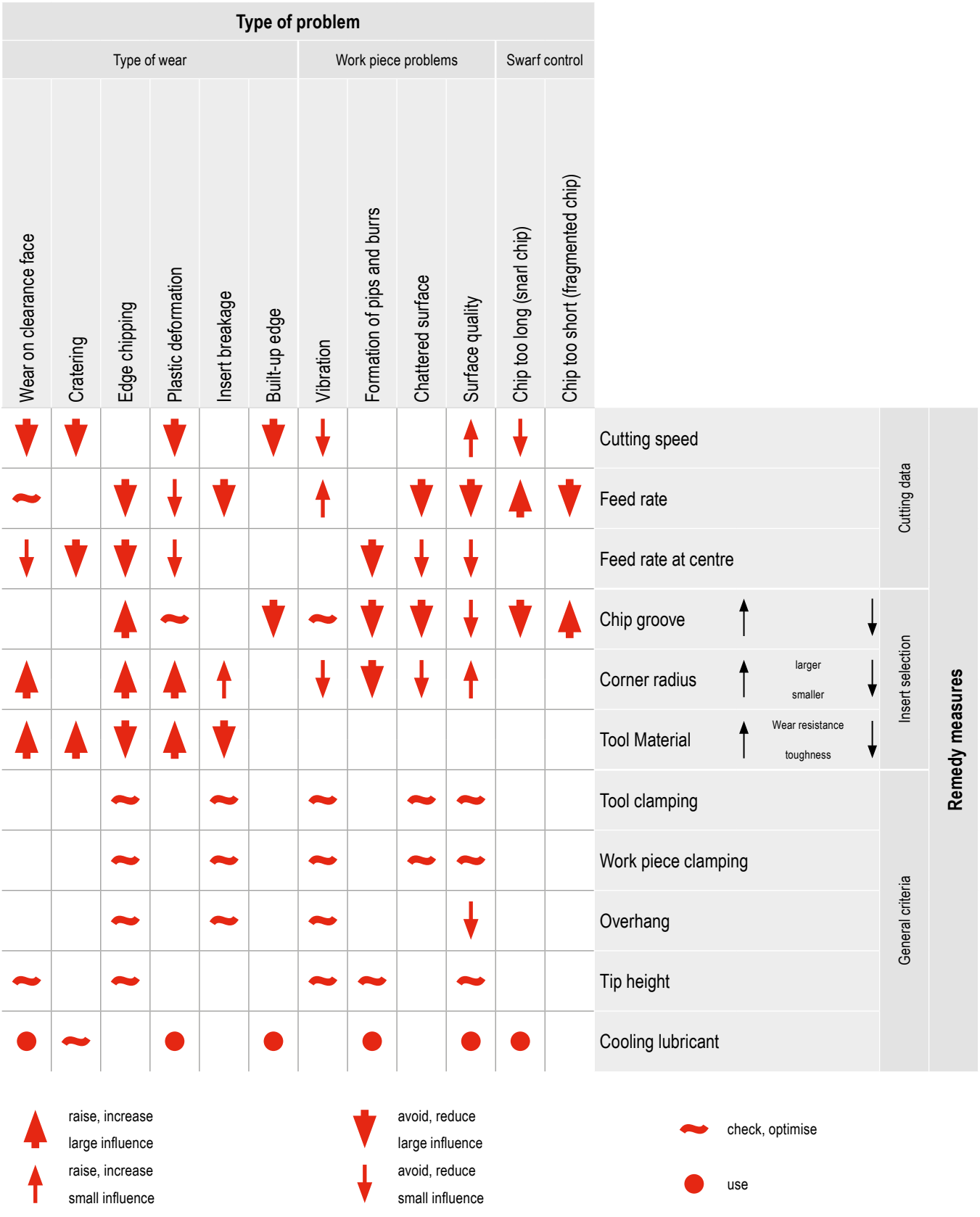
Insert breakage

Excessive stress of the insert causes breakage.

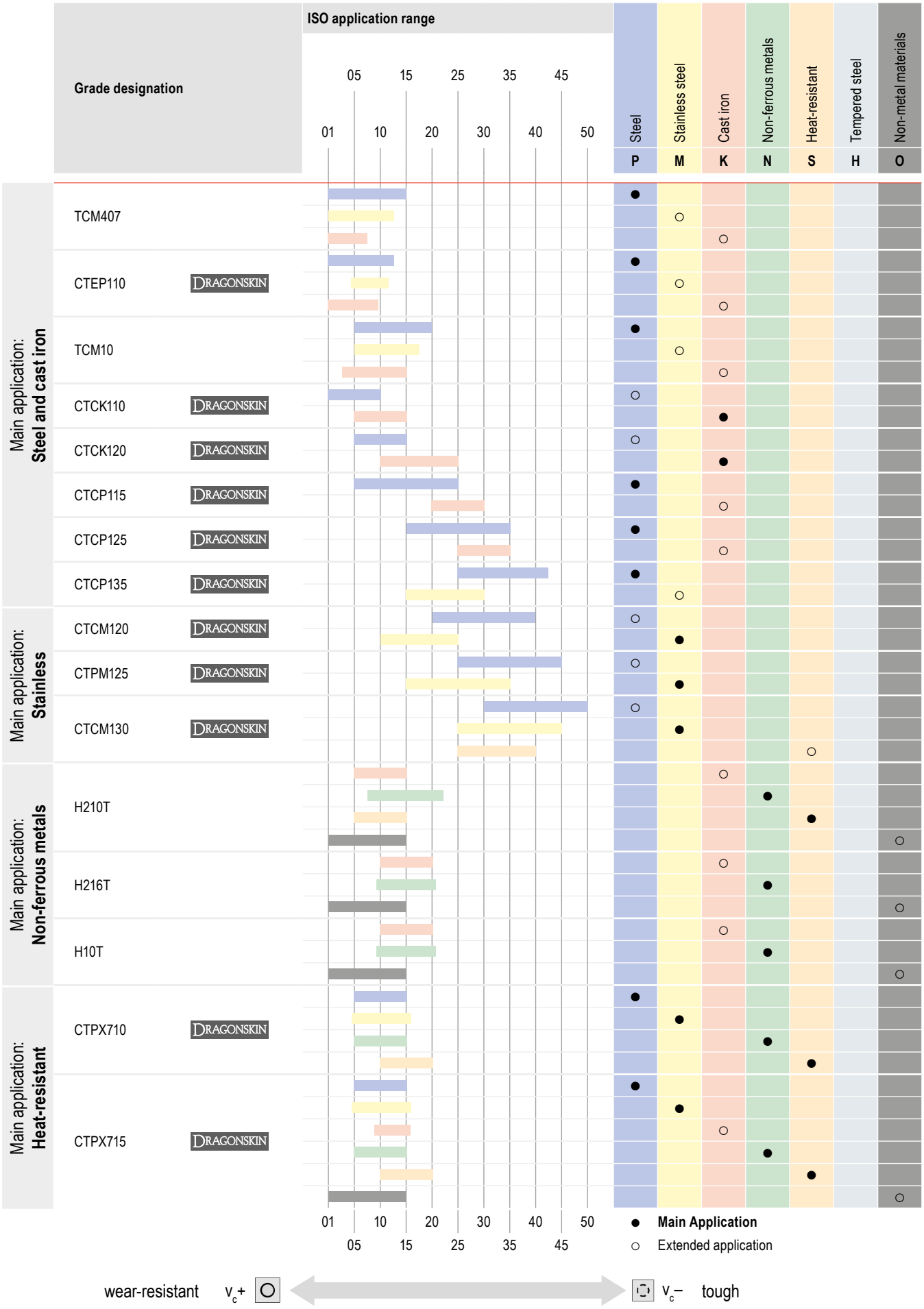
Cause
- Excessive stress of cutting material
- Lack of stability
- Clearance angle too small

Remedy
- Use tougher grade
- Use protective edge chamfer
- Increase edge hone
- Use geometry with higher stability

Recommendation for Optimum Results



Grades Overview



Grade description

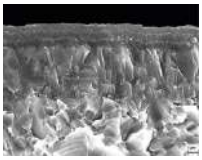
TCM407

ISO | **P10** | M05 | K05

Specification:
Composition: Co 8.0%; WC 16.0%; TaNbC 10.0%; TiCN balance | Grain size: 2-3 µm | Hardness: HV30 1760

Usage recommendation:
The uncoated cermet grade for fine finishing steel materials.

CTEP110



ISO | **P10** | M10 | K05

Specification:
Composition: Co/Ni 12.2%; WC 15.0%; TaNbC 10.0%; TiCN balance | Grain size: 2-3 µm | Hardness: HV30 1650 | Layer system: CVD TiCN-Al2O3 Multilayer

Usage recommendation:
The cermet grade with toughness reserves for finish machining at high cutting speeds.

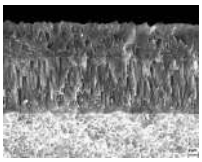
TCM10

P15 | K10

Spezifikation:
Zusammensetzung: Cermet Co/Ni 12,2%; WC 15,0%; TaNbC 10,0%; TiCN Rest | Korngröße: 2-3 µm | Härte: HV30 1650

Einsatzempfehlung:
Die unbeschichtete Cermet-Sorte zum Schlichten von Stahl, rostfreiem Stahl und gehärtetem Stahl.

CTCK110

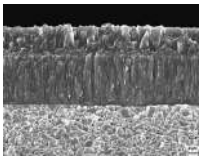


ISO | **P05 | K10**

Specification:
Composition: Co 5.0%, mixed carbides 2.0%, WC balance | Grain size: 1-2 µm | Hardness: HV30 1730 | Layer system: CVD TiCN-Al2O3

Usage recommendation:
The wear-resistant grade for machining cast iron materials and steels at high cutting speeds with a continuous cut.

CTCK120

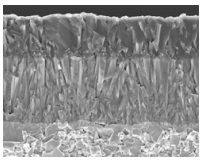


ISO | **P10 | K20**

Specification:
Composition: Co 6.0%, mixed carbides 2.0%, WC balance | Grain size: 1 µm | Hardness: HV_{30} 1630 | Layer system: CVD TiCN-Al_2O_3

Usage recommendation:
The grade for cast iron machining with high toughness reserves for difficult conditions and interrupted cuts.

CTCP115-P

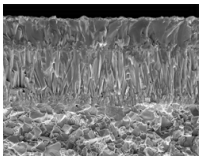


ISO | **P15** | K25

Specification:
Composition: Co 5.5%; mixed carbides 6.4%; WC balance | Grain size: 1 µm | Hardness: HV_{30} 1530 | Layer system: CVD TiCN-Al_2O_3

Usage recommendation:
The wear-resistant high-performance grade for steel machining with stable conditions and a continuous cut.

CTCP125-P

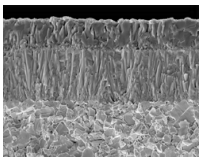


ISO | **P25** | K30

Specification:
Composition: Co 7.0%, mixed carbides 6.0%, WC balance | Grain size: 1-2 µm | Hardness: HV_{30} 1500 | Layer system: CVD TiCN-Al_2O_3

Usage recommendation:
The first choice for the universal machining of steels.

CTCP135-P



ISO | **P35** | M25

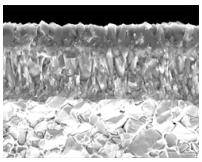
Specification:
Composition: Co 9.6%, mixed carbides 7.8%, WC balance | Grain size: 1-2 µm | Hardness: HV_{30} 1460 | Layer system: CVD TiCN-Al_2O_3

Usage recommendation:
The tough alternative for extremely interrupted cutting conditions.

9

Grade description

CTCM120

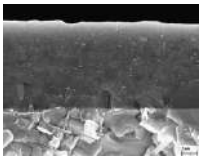


ISO | P15 | **M20**

Specification:
Composition: Co 7%, mixed carbides 6%, WC balance | Grain size: 1-2 µm | Hardness: HV_{30} 1500 | Layer system: CVD TiCN-Al_2O_3

Usage recommendation:
Wear-resistant carbide grade for austenitic, stainless steel with the best levels of performance with a smooth cut.

CTPM125

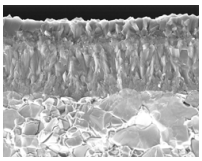


ISO | P35 | **M25**

Specification:
Composition: Co 9.6%; mixed carbides 7.8%; others 0.4%; WC balance | Grain size: 1 - 2 µm | Hardness: HV_{30} 1460 | Coating specification: PVD TiAlTaN

Recommended application:
The first choice for the machining of austenitic steels

CTCM130

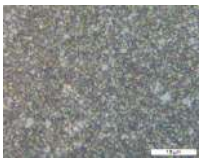


ISO | P25 | **M30** | S30

Specification:
Composition: Co 9.6%, mixed carbides 7.8%, WC balance | Grain size: 1-2 µm | Hardness: HV_{30} 1460 | Layer system: CVD TiCN-Al_2O_3

Usage recommendation:
Robust turning grade for austenitic stainless steel with interrupted cuts.

H210T



ISO | K10 | **N10 | S10** | O10

Specification:
Composition: Co 6.0%; WC balance | Grain size: 0.8 µm | Hardness: HV_{30} 1850

Recommended application:
The wear-resistant uncoated carbide grade for the machining of aluminium and other non-ferrous metals.

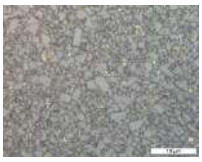
H10T

ISO | K15 | **N15** | S15 | O10

Specification:
Composition: Co 6.0%; WC balance | Grain size: 1 µm | Hardness: HV_{30} 1630

Recommended application:
The uncoated carbide grade for the machining of aluminium and other non-ferrous metals

H216T

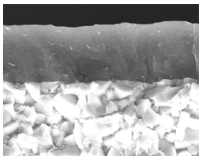


ISO | K15 | **N15** | S15 | O10

Specification:
Composition: Co 6.0%; WC balance | Grain size: 1 µm | Hardness: HV_{30} 1630

Recommended application:
The uncoated carbide grade for the machining of aluminium and other non-ferrous metals

CTPX710

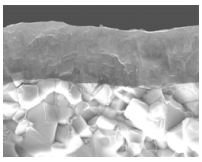


ISO | **P10 | M10** | K10 | **N10 | S15**

Specification:
Composition: Co 6.0%; WC balance | Grain size: 0.8 µm | Hardness: HV_{30} 1820 | Layer system: PVD AlTiN

Usage recommendation:
The universal carbide grade for the most demanding machining requirements on multiple materials.

CTPX715



ISO | **P15 | M15** | K15 | **N15 | S20** | O10

Specification:
Composition: Co 6.0%; WC balance | Grain size: 1 µm | Hardness: HV_{30} 1650 | Layer system: PVD AlTiN

Usage recommendation:
The universal carbide grade for the most demanding machining requirements on multiple materials.

Grade description