

1 edge cutting system

Parting off and grooving



1-edge cutting system

Parting off and grooving

The striking beauty of Flex Fix products

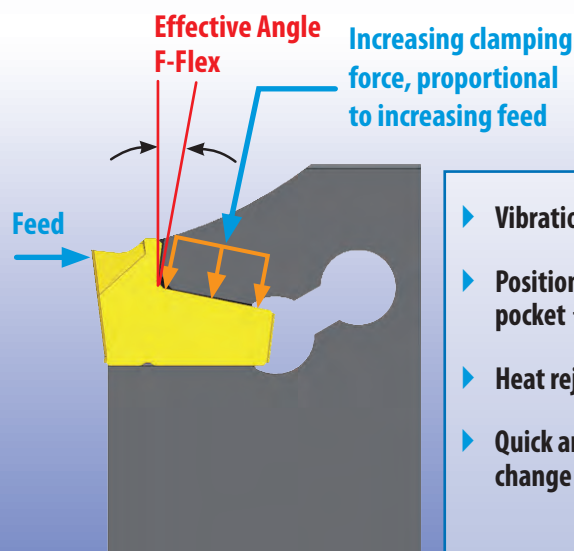


Construction and the way, these perfect grooving and parting off tools fit together

Just a few degrees in the right direction, lead to a new technique, which solves the old and well known system problems like

- ▶ Loss of center height
- ▶ Opening of insert pocket
- ▶ Fatigue of material
- ▶ Insert creeping

and increase tool life by **120 %**, stated by absolute authentic test series, compared with the system passt perfekt.



- ▶ Vibrations → 0
- ▶ Positioning in insert pocket → perfect
- ▶ Heat rejection improved
- ▶ Quick and defined insert change

Authentic tests: Parting off

Testmaterial	Quantity Flex Fix	Quantity passt perfekt	Result in %
1.0277 (hexagonal)	220	180	22 % more
1.7227 (Ø 45mm)	265	130	103 % more
1.4301 (Ø 45mm)	85	25	240 % more

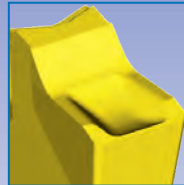
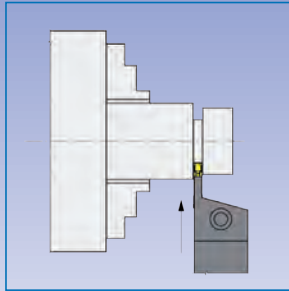
Increased
tool life by
120 %

1-edge cutting system

Parting off and grooving

One-edge cutting system for grooving and parting off

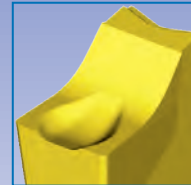
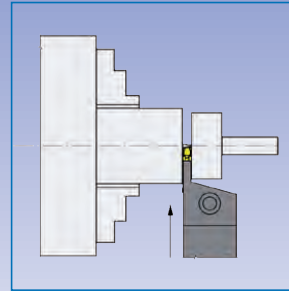
Grooving



Parting off and grooving IFN

Grooving, the major edge cuts a groove

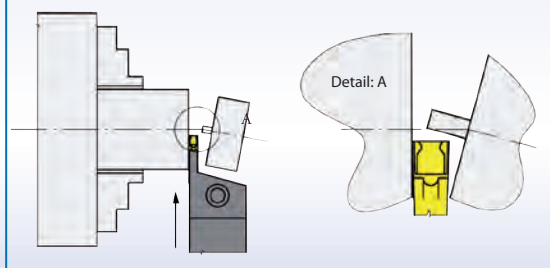
Parting off



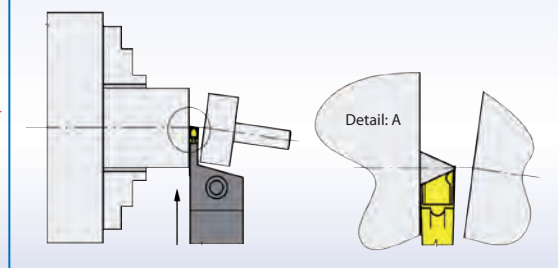
Parting off BFN

The major edge **parts off** a component.

Parting off components leaving a bur



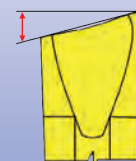
Parting off components without leaving a bur



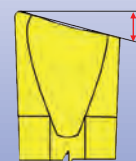
Neutral inserts, inserts with lead angel right and lead angel left



Neutral



Right



Left

Definition of rotation



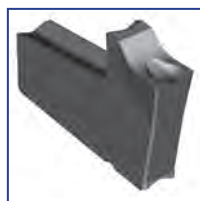
CCW and CW rotation

View into the spindle:

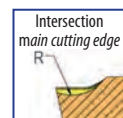
RH or CCW: Workpiece or bar rotates counter clockwise (german: „Rechtslauf“)

LH or CW: Workpiece or bar rotates clockwise (german: „Linkslauf“)

Parting off and grooving inserts

**BF N/R/L**

FLEX FIX



WG0022 Ref.	KM TILOX ID-Nr.	KM NANOSPEED ID-Nr.	KM HYPER SPEED ID-Nr.	KM CARBOSPEED ID-Nr.	(C)	R	$s \pm 0,05$	α°
BFN 2	43199	43201	43202	43200	N	0,2	2,0	0
BFN 3	43203	43204	41172	41173	N	0,2	3,0	0
BFN 4	43205	43207	43208	43206	N	0,2	4,0	0
BFL 2 8D	43233	43235	43236	43234	L	0,2	2,0	8
BFL 3 8D	43237	43239	43240	43238	L	0,2	3,0	8
BFL 4 8D	43241	43243	43244	43242	L	0,2	4,0	8
BFL 2 12D	43245	43247	43248	43246	L	0,2	2,0	12
BFL 3 12D	43249	43251	43253	43250	L	0,2	3,0	12
BFL 4 12D	43252	43255	43256	43254	L	0,2	4,0	12
BFR 2 8D	43209	43211	43212	43210	R	0,2	2,0	8
BFR 3 8D	43213	43215	43216	43214	R	0,2	3,0	8
BFR 4 8D	43217	43219	43220	43218	R	0,2	4,0	8
BFR 2 12D	43221	43223	43224	43222	R	0,2	2,0	12
BFR 3 12D	43225	43227	43228	43226	R	0,2	3,0	12
BFR 4 12D	43229	43231	43232	43230	R	0,2	4,0	12

BF-Parting off geometry

Grooved parting off edge with reinforced flanks. The deep and spacious **chip-trough** gives excellent chip control. To be used on almost all materials.

Fitting tool holder

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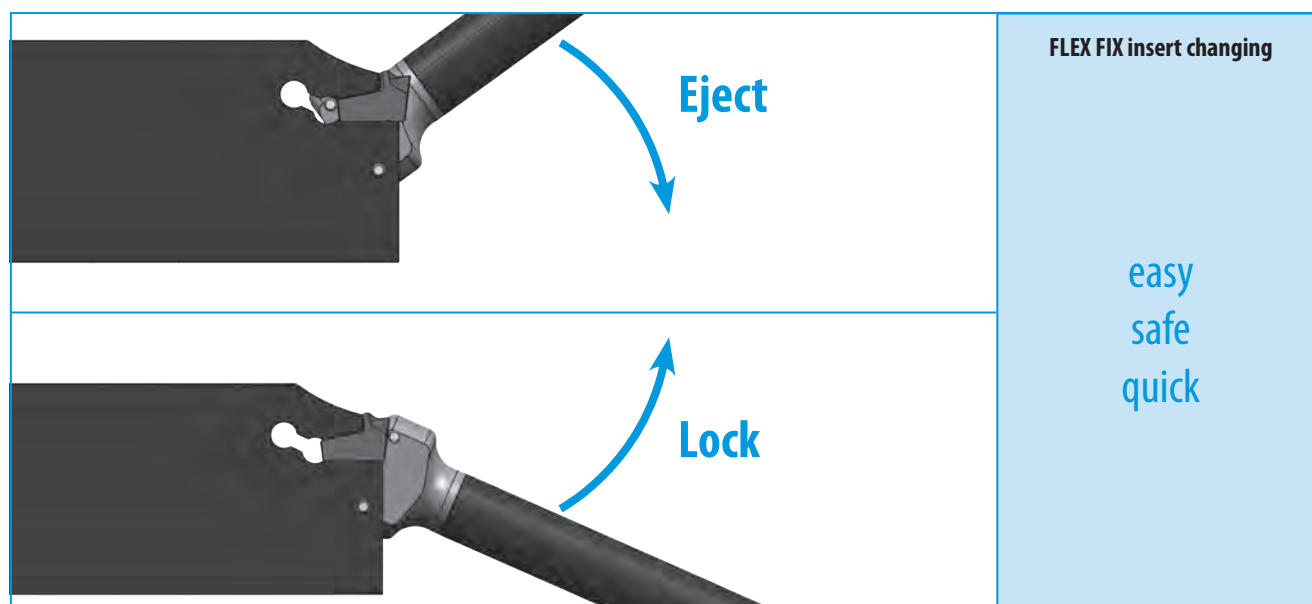
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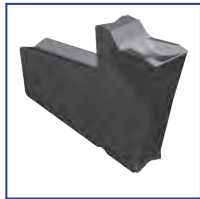


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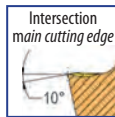


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Parting off and grooving inserts



**IF N/R/L
FLEX FIX**



WG0022 Ref.	KM TILOX	KM NANOSPEED	KM HYPERSPEED	KM CARBOSPEED	⌀	R	$s \pm 0,05$	α°
	ID-Nr.	ID-Nr.	ID-Nr.	ID-Nr.				
IFN 2	43260	43262	43263	43261	N	0,2	2,0	0
IFN 3	39203	43259	41153	40017	N	0,2	3,0	0
IFN 4	43264	43266	43267	43265	N	0,2	4,0	0
IFL 2 4D	43290	43292	43293	43291	L	0,2	2,0	4
IFL 3 4D	39204	43295	43296	43294	L	0,2	3,0	4
IFL 4 4D	43297	43299	43300	43298	L	0,2	4,0	4
IFL 2 8D	43301	43303	43304	43302	L	0,2	2,0	8
IFL 3 8D	39205	43306	43307	43305	L	0,2	3,0	8
IFL 4 8D	43308	43310	43311	43309	L	0,2	4,0	8
IFR 2 4D	43268	43270	43271	43269	R	0,2	2,0	4
IFR 3 4D	39853	43273	43274	43272	R	0,2	3,0	4
IFR 4 4D	43275	43277	43278	43276	R	0,2	4,0	4
IFR 2 8D	43279	43281	43282	43280	R	0,2	2,0	8
IFR 3 8D	39851	43284	43285	43283	R	0,2	3,0	8
IFR 4 8D	43286	43288	43289	43287	R	0,2	4,0	8

IF Geometry

IF Geometry with its cutting edge strengthening, ground chamfer is recommended for:

- Alloy steels
- Stainless steels
- Interrupted cuts

Fitting tool holder



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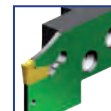
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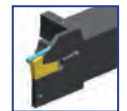
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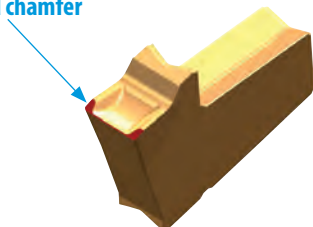


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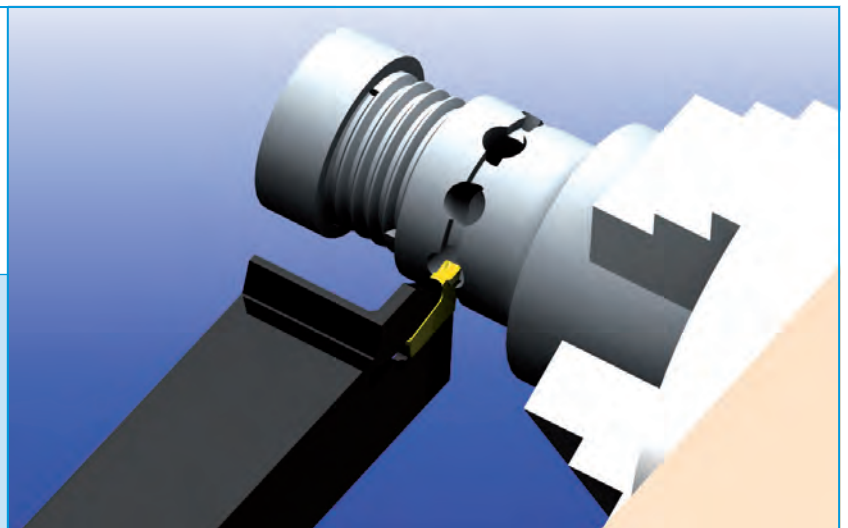


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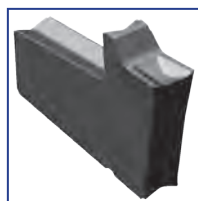
Ground chamfer



IFN in action on interrupted cutting.
Negative chamfer reinforces the cutting edge.

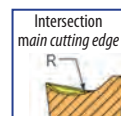


Parting off and grooving inserts



SF N/R/L

FLEX FIX



WG0022 Ref.	KM TILOX ID-Nr.	KM NANOSPEED ID-Nr.	KM HYPERSPEED ID-Nr.	KM CARBOSPEED ID-Nr.	(C)	R	S ±0,05	α°
SFN 2	43087	43169	43174	43168	N	0,2	2,0	0
SFN 3	38635	43170	41155	40018	N	0,2	3,0	0
SFN 4	43171	43173	43175	43172	N	0,2	4,0	0
SFL 2 6D	43187	43189	43190	43188	L	0,2	2,0	6
SFL 3 6D	14270	43192	43193	43191	L	0,2	3,0	6
SFL 4 6D	43194	43196	43197	43195	L	0,2	4,0	6
SFR 2 6D	43176	43178	43179	43177	R	0,2	2,0	6
SFR 3 6D	14272	43181	43182	43180	R	0,2	3,0	6
SFR 4 6D	43183	43185	43186	43184	R	0,2	4,0	6

SF-Geometry SUPERNOVA

The arc shaped cutting edge with its reinforced flanks achieves ideal chips. Recommended for free cutting and low alloy steels and stainless steels, also to be used on unstable machine tools.

Fitting tool holder



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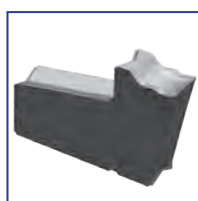
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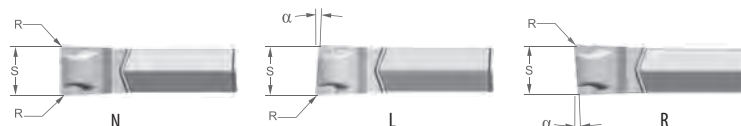
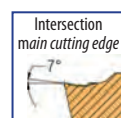


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IF N/R/L ALU

Flex Fix



WG0022 Ref.	KM ID-Nr.	KM ALUSPEED ID-Nr.	(C)	R	S ±0,05	α°
IFN 2 ALU	47727	47730	N	0,2	2,0	0
IFN 3 ALU	47728	47731	N	0,2	3,0	0
IFN 4 ALU	47729	47732	N	0,2	4,0	0
IFL 2 4D ALU	47739	47742	L	0,2	2,0	4
IFL 3 4D ALU	47740	47743	L	0,2	3,0	4
IFL 4 4D ALU	47741	47744	L	0,2	4,0	4
IFR 2 4D ALU	47733	47736	R	0,2	2,0	4
IFR 3 4D ALU	47734	47737	R	0,2	3,0	4
IFR 4 4D ALU	47735	47738	R	0,2	4,0	4

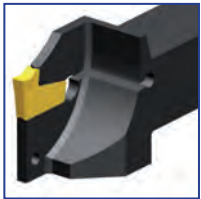
The new IF Alu geometry

The new IF Alu geometry has got a horizontally ground cutting edge with a flat chip breaker for high speed chip removal. The geometry is positive and sharply ground and is recommended for **nonferrous heavy metals, pipes, thinwalled parts, unstable components, free cutting materials and titanium.**



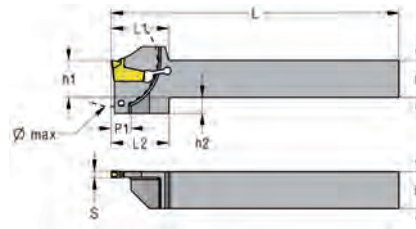
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Parting off holders for FLEX FIX inserts



F16 L 42
FLEX FIX

LH holder



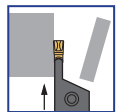
F16 R 42
FLEX FIX

RH holder



WG3201 Ref.	ID-Nr.	()	Ø max	h	h1	h2	b	P1	S	L	L1	L2	
F16 L 1616 K20 42	43330	L	42	16	16	7	16	8	2,0	125	25	25	AWF16
F16 L 1616 K30 42	43331	L	42	16	16	7	16	8	3,0	125	25	25	AWF16
F16 L 1616 K40 42	43332	L	42	16	16	7	16	8	4,0	125	25	25	AWF16
F16 L 2020 K20 42	43333	L	42	20	20	3	20	8	2,0	125	25	25	AWF16
F16 L 2020 K30 42	43334	L	42	20	20	3	20	8	3,0	125	25	25	AWF16
F16 L 2020 K40 42	43335	L	42	20	20	3	20	8	4,0	125	25	25	AWF16
F16 L 2525 M20 42	43336	L	42	25	25	0	25	8	2,0	150	25	25	AWF16
F16 L 2525 M30 42	43337	L	42	25	25	0	25	8	3,0	150	25	25	AWF16
F16 L 2525 M40 42	49376	L	42	25	25	0	25	8	4,0	150	25	25	AWF16
F16 R 1616 K20 42	43322	R	42	16	16	7	16	8	2,0	125	25	25	AWF16
F16 R 1616 K30 42	43323	R	42	16	16	7	16	8	3,0	125	25	25	AWF16
F16 R 1616 K40 42	43324	R	42	16	16	7	16	8	4,0	125	25	25	AWF16
F16 R 2020 K20 42	43325	R	42	20	20	3	20	8	2,0	125	25	25	AWF16
F16 R 2020 K30 42	43326	R	42	20	20	3	20	8	3,0	125	25	25	AWF16
F16 R 2020 K40 42	43327	R	42	20	20	3	20	8	4,0	125	25	25	AWF16
F16 R 2525 M20 42	43328	R	42	25	25	0	25	8	2,0	150	25	25	AWF16
F16 R 2525 M30 42	43329	R	42	25	25	0	25	8	3,0	150	25	25	AWF16
F16 R 2525 M40 42	49377	R	42	25	25	0	25	8	4,0	150	25	25	AWF16

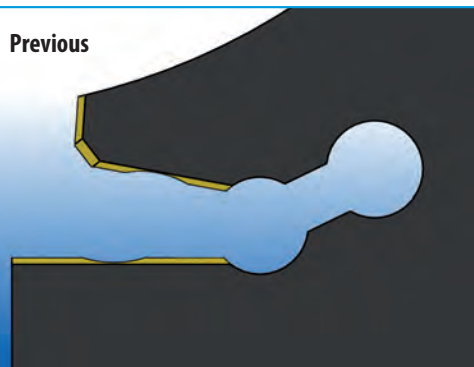
Fitting inserts



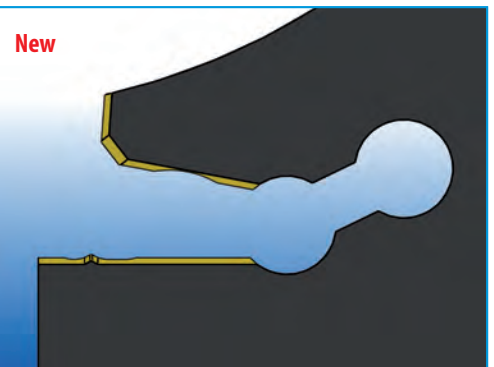
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Insert pocket **UPGRADE** Flex Fix

Previous



New

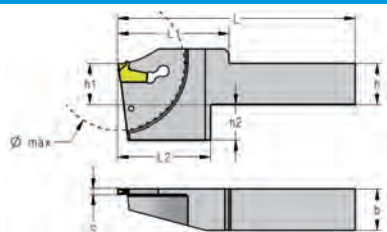


Tailor made hi pressure cooling
system available.
More information at page192

Parting off holders for FLEX FIX inserts


F16 L 65
 FLEX FIX

LH holder

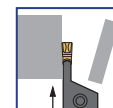

F16 R 65
 FLEX FIX

RH holder



WG3201 Ref.	ID-Nr.	()	Ø max	h	h1	h2	b	S	L	L1	L2	
F16 L 2020 X30 65	38875	L	65	20	20	17	20	3,0	115	54	45	AWF16
F16 L 2020 X40 65	43319	L	65	20	20	17	20	4,0	115	54	45	AWF16
F16 L 2525 X30 65	43320	L	65	25	25	12	25	3,0	140	54	45	AWF16
F16 L 2525 X40 65	43321	L	65	25	25	12	25	4,0	140	54	45	AWF16
F16 R 2020 X30 65	38878	R	65	20	20	17	20	3,0	115	54	45	AWF16
F16 R 2020 X40 65	43316	R	65	20	20	17	20	4,0	115	54	45	AWF16
F16 R 2525 X30 65	43317	R	65	25	25	12	25	3,0	140	54	45	AWF16
F16 R 2525 X40 65	43318	R	65	25	25	12	25	4,0	140	54	45	AWF16

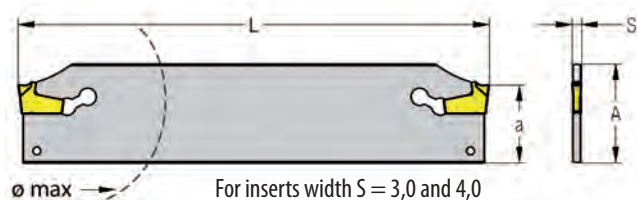
Fitting inserts



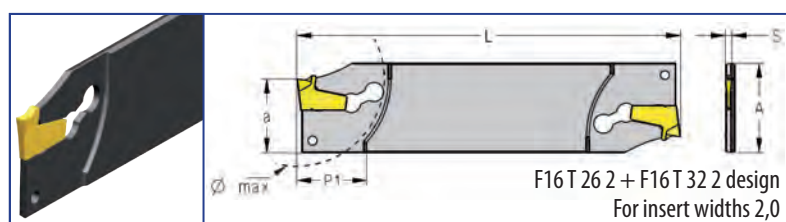
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Tailor made hi pressure cooling system available.
More information at page192

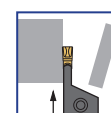
Parting off blades for FLEX FIX inserts


F16 T
 FLEX FIX


WG3101 Ref.	ID-Nr.	a	Ø max.	A	P1	S	L	
F16 T 26 2	41093	21,4	42	26	15	2	110	AWF 16
F16 T 26 3	38743	21,4	75	26	-	3	110	AWF 16
F16 T 26 4	41096	21,4	80	26	-	4	110	AWF 16
F16 T 32 2	41094	25	42	32	15	2	150	AWF 16
F16 T 32 3	35217	25	100	32	-	3	150	AWF 16
F16 T 32 4	41095	25	100	32	-	4	150	AWF 16



Fitting inserts



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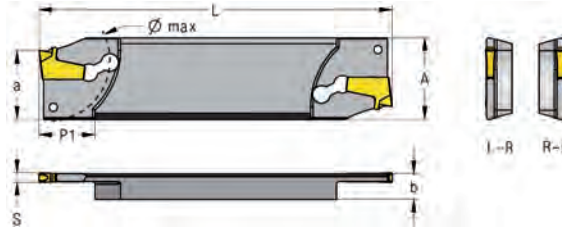
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Reinforced parting off blades for FLEX FIX inserts



F16 L 2608
FLEX FIX

LH Blades



F16 R 2608
FLEX FIX

RH Blades



WG3101 Ref.	ID-Nr.	()	A	a	Ø max	b	P1	S	L	
F16 L 2608 J30 R 50	43313	L	26	21,4	50	8	17	3,0	110	AWF16
F16 R 2608 J30 L 50	43312	R	26	21,4	50	8	17	3,0	110	AWF16

Fitting inserts see below



F16 L 3208
FLEX FIX

LH Blades



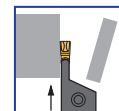
F16 R 3208
FLEX FIX

RH Blades



WG3101 Ref.	ID-Nr.	()	A	a	Ø max	b	P1	S	L	
F16 L 3208 J30 R 65	43315	L	32	25	65	8	24,5	3,0	110	AWF16
F16 R 3208 J30 L 65	43314	R	32	25	65	8	24,5	3,0	110	AWF16

Fitting inserts



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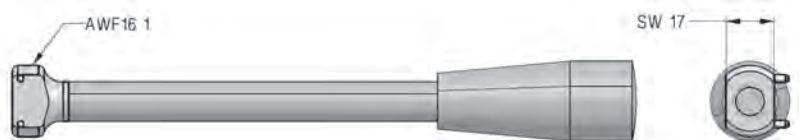
Example for application you will find on pag 72

Key for FLEX FIX tools



AW F16
FLEX FIX

LH holder



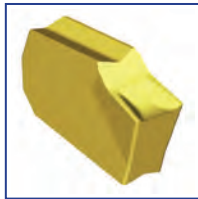
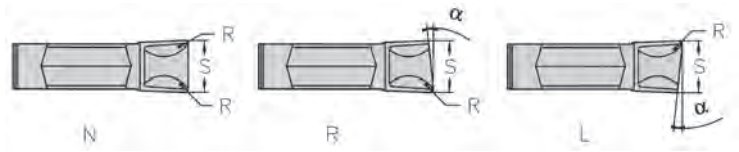
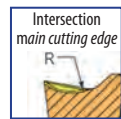
WG355 Ref.	ID-Nr.	
AW F16	39880	AW F16 1
AW F16 1	39881	

Remark:

The key is added to each FLEX FIX tool delivery.



Parting off and grooving inserts

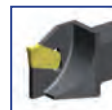

SNP N/R/L
passt perfekt


WG3251 Ref.	GF110 TILOX	PM NANOSPEED	()	R	$s \pm 0,1$	α°
	ID-Nr.					
SNPN 20	47978	20418	N	0,2	2,0	0
SNPN 3	22695	11244	N	0,2	3,1	0
SNPN 4	40623	11252	N	0,2	4,1	0
SNPN 5	11257	47979	N	0,2	5,1	0
SNPL 20 6D	47975	20420	L	0,2	2,0	6
SNPL 20 12D	47973	20422	L	0,2	2,0	12
SNPL 20 16D	47974	20424	L	0,2	2,0	16
SNPL 3 6D	47976	11282	L	0,2	3,1	6
SNPL 4 6D	47977	11294	L	0,2	4,1	6
SNPL 5 6D	11304	-	L	0,2	5,1	6
SNPR 20 6D	47984	20419	R	0,2	2,0	6
SNPR 20 12D	47982	20421	R	0,2	2,0	12
SNPR 20 16D	47983	20423	R	0,2	2,0	16
SNPR 3 6D	31746	11281	R	0,2	3,1	6
SNPR 4 6D	31747	11293	R	0,2	4,1	6
SNPR 5 6D	11303	-	R	0,2	5,1	6

SUPERNOVA

The arc shaped cutting edge with its reinforced flanks achieves ideal chips. Recommended for free cutting and low alloy steels and stainless steels, also to be used on unstable machine tools.

Fitting tool holder



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p. 138



p. 138



p. 139 - 140

Technical section page 205 onwards

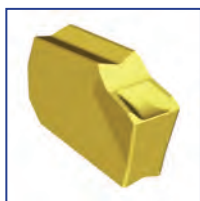
SNP N/R/L-20

ITP N/R/L-20

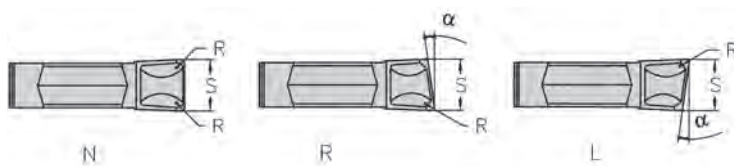
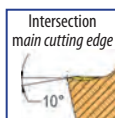
The new pocket
 Comparison between the old SNTN-2 types and the new SNPN-20 types.

- Long guide surfaces transfer high gripping power
- Reduced cutting edge width to 2,0 mm
- Vibration free, straight run

Parting off and grooving inserts



ITP N/R/L
passt perfekt



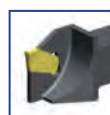
WG0021 Ref.	PM NANOSPEED ID-Nr.	GF110 TILOX ID-Nr.	()	R	S ±0,1	α°
ITPN 20	20400	47936	N	0,2	2,0	0
ITPN 3	10562	19854	N	0,2	3,1	0
ITPN 4	10594	19810	N	0,2	4,1	0
ITPN 5	47938	10599	N	0,2	5,1	0
ITPL 20 4D	20402	47931	L	0,2	2,0	4
ITPL 20 8D	20404	47932	L	0,2	2,0	8
ITPL 20 12D	20406	47929	L	0,2	2,0	12
ITPL 20 16D	20408	47930	L	0,2	2,0	16
ITPL 3 4D	10654	19859	L	0,2	3,1	4
ITPL 3 8D	10666	19858	L	0,2	3,1	8
ITPL 4 4D	10684	47933	L	0,2	4,1	4
ITPL 4 8D	10696	47934	L	0,2	4,1	8
ITPL 5 4D	-	10706	L	0,2	5,1	4
ITPL 5 8D	-	10718	L	0,2	5,1	8
ITPR 20 4D	20401	47941	R	0,2	2,0	4
ITPR 20 8D	20403	47942	R	0,2	2,0	8
ITPR 20 12D	20405	47939	R	0,2	2,0	12
ITPR 20 16D	20407	47940	R	0,2	2,0	16
ITPR 3 4D	10653	19856	R	0,2	3,1	4
ITPR 3 8D	10665	19857	R	0,2	3,1	8
ITPR 4 4D	10683	47943	R	0,2	4,1	4
ITPR 4 8D	10695	47944	R	0,2	4,1	8
ITPR 5 4D	-	10705	R	0,2	5,1	4
ITPR 5 8D	-	10717	R	0,2	5,1	8

IT Geometry

IT Geometry with its cutting edge strengthening, ground chamfer is recommended for:

- Alloy steels
- Stainless steels
- Interrupted cuts

Fitting tool holder



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p. 138



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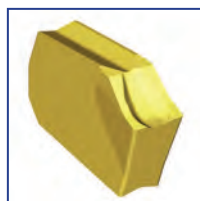
"passt perfekt" - autolock System

- ✓ No creeping of insert
- ✓ No vibrations
- ✓ Rigid tool unit
- ✓ Clean faces
- ✓ Constant tool life
- ✓ Reliable machining

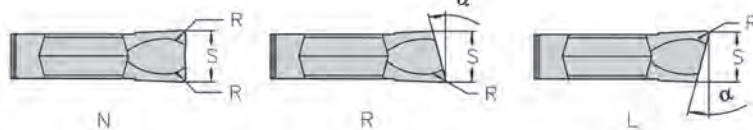
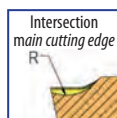
The TRADE MARK „passt perfekt“ marks a technique: the fit between insert and insert pocket is simply perfect.



Parting off inserts



BGP N/R/L F
passt perfekt



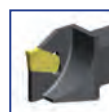
WG0021 Ref.	PM NANOSPEED	GF110 TILOX	PM RED SPEED	()	R	S ±0,1	α°
	ID-Nr.	ID-Nr.	ID-Nr.				
BGPN 3	20439	48201	26004	N	0,2	3,1	0
BGPNF 3	23663	48203	-	N	0,0	3,1	0
BGPN 4	26289	48202	27961	N	0,2	4,1	0
BGPNF 4	26232	48204	-	N	0,0	4,1	0
BGPL 3 8D	20441	48194	27957	L	0,2	3,1	8
BGPLF 3 8D	23669	48198	-	L	0,0	3,1	8
BGPL 3 12D	20443	48193	-	L	0,2	3,1	12
BGPLF 3 12D	23671	48197	-	L	0,0	3,1	12
BGPL 4 8D	26319	48196	27960	L	0,2	4,1	8
BGPLF 4 8D	26320	48200	-	L	0,0	4,1	8
BGPL 4 12D	26321	48195	-	L	0,2	4,1	12
BGPLF 4 12D	26322	48199	-	L	0,0	4,1	12
BGPR 3 8D	20440	48206	27958	R	0,2	3,1	8
BGPRF 3 8D	23665	48210	-	R	0,0	3,1	8
BGPR 3 12D	20442	48205	-	R	0,2	3,1	12
BGPRF 3 12D	23667	48209	-	R	0,0	3,1	12
BGPR 4 8D	26313	48208	27959	R	0,2	4,1	8
BGPRF 4 8D	26316	48212	-	R	0,0	4,1	8
BGPR 4 12D	26317	48207	-	R	0,2	4,1	12
BGPRF 4 12D	26318	48211	-	R	0,0	4,1	12

BGP-Parting off Geometry

Grooved parting off edge with reinforced flanks. The deep and spacious **chip-trough** gives excellent chip control. To be used on almost all materials.

Inserts marked with "F" like BGPNF-3 are ground with R = 0 mm..

Fitting tool holder



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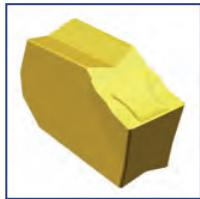


Coating RED SPEED:

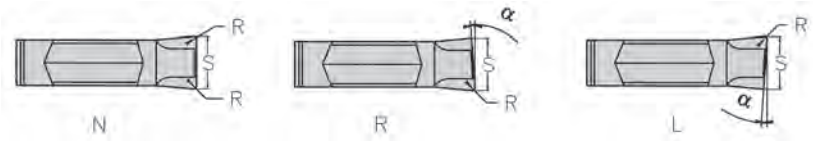
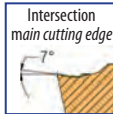
Special coating for machining stainless steels.



Parting off inserts



ITP ALU
passt perfekt



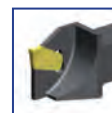
WG0021 Ref.	GF 110 ID-Nr.	PM NANOSPEED ID-Nr.	()	R	$s \pm 0,1$	α°
ITPN 20 ALU	26229	23675	N	0,2	2,0	0
ITPN 3 ALU	10550	10554	N	0,2	3,1	0
ITPN 4 ALU	10563	10567	N	0,2	4,1	0
ITPL 20 4D ALU	26231	23679	L	0,2	2,0	4
ITPL 3 4D ALU	10636	10640	L	0,2	3,1	4
ITPL 4 4D ALU	10668	10672	L	0,2	4,1	4
ITPR 20 4D ALU	26230	23677	R	0,2	2,0	4
ITPR 3 4D ALU	10635	10639	R	0,2	3,1	4
ITPR 4 4D ALU	10667	10671	R	0,2	4,1	4

ALU Geometry

ALU Geometry with sharply ground, positive cutting edge is recommended for:

- Nonferrous heavy metals
- Machining steels
- **Thinwalled parts**
- Unstable components
- Pipes

Fitting tool holder



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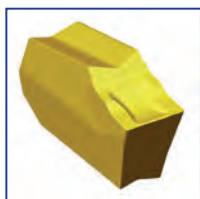


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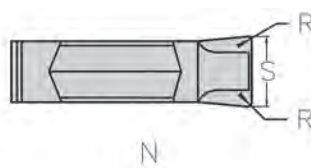
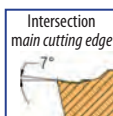


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Inserts for face grooving



PPTNL
passt perfekt



PPTNR
passt perfekt



WG0031 Ref.	PM NANOSPEED ID-Nr.	GF110 CARBOSPEED ID-Nr.	()	R	$s \pm 0,1$
PPTNL 4	28858	47968	L	0,2	4,1
PPTNL 5	47969	47970	L	0,2	5,1
PPTNR 4	11209	47971	R	0,2	4,1
PPTNR 5	11212	47972	R	0,2	5,1



PPTN R/L - Face grooving inserts

Special chip breaker and ground side clearances.
Both features achieve efficient chip flow.

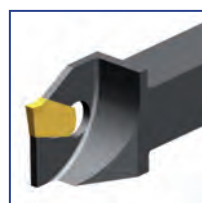


Fitting blades

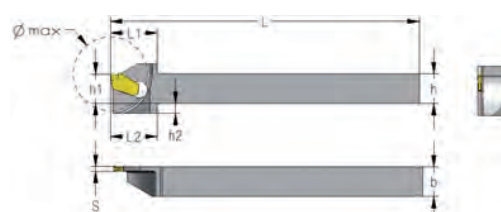
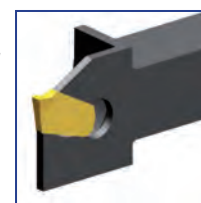


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Parting off holders with autolock pocket


HPPL
passt perfekt

LH holder


HPPR
passt perfekt


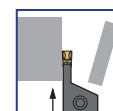
RH holder

WG3201 Ref.	ID-Nr.	()	Ø max	h	h1	h2	b	S	L	L1	L2	
HPPL 1010 20X	19736	L	30	10	10	6	10	2,0	125	18,5	18,5	16
HPPL 1010 3	10230	L	30	10	10	6	10	3,0	125	18,5	18,5	16
HPPL 1212 20X	24252	L	30	12	12	4	12	2,0	125	18,5	18,5	16
HPPL 1212 3	10234	L	36	12	12	5	12	3,0	125	22,0	22,0	16
HPPL 1612 20X	24253	L	30	16	16	0	12	2,0	125	18,5	-	16
HPPL 1612 3	10238	L	36	16	16	5	12	3,0	125	22,0	22,0	16
HPPL 1612 4	10240	L	42	16	16	5	12	4,0	125	25,0	25,0	16
HPPL 1616 3	10242	L	42	16	16	5	16	3,0	125	25,0	25,0	16
HPPL 2020 20X	24254	L	42	20	20	0	20	2,0	125	25,0	-	16
HPPL 2020 3	10246	L	42	20	20	0	20	3,0	125	25,0	-	16
HPPL 2020 4	10248	L	42	20	20	0	20	4,0	125	25,0	-	16
HPPL 2525 20X	24255	L	42	25	25	0	25	2,0	150	25,0	-	16
HPPL 2525 3	10252	L	42	25	25	0	25	3,0	150	25,0	-	16
HPPL 2525 4	10254	L	50	25	25	0	25	4,0	150	30,0	-	16
HPPL 2525 5	10256	L	80	25	25	0	25	5,0	150	45,0	-	16
HPPR 1010 20X	19735	R	30	10	10	6	10	2,0	125	18,5	18,5	16
HPPR 1010 3	10229	R	30	10	10	6	10	3,0	125	18,5	18,5	16
HPPR 1212 20X	19737	R	30	12	12	4	12	2,0	125	18,5	18,5	16
HPPR 1212 3	10233	R	36	12	12	5	12	3,0	125	22,0	22,0	16
HPPR 1612 20X	19738	R	30	16	16	0	12	2,0	125	18,5	-	16
HPPR 1612 3	10237	R	36	16	16	5	12	3,0	125	22,0	22,0	16
HPPR 1612 4	10239	R	42	16	16	5	12	4,0	125	25,0	25,0	16
HPPR 1616 3	10241	R	42	16	16	5	16	3,0	125	25,0	25,0	16
HPPR 2020 20X	24250	R	42	20	20	0	20	2,0	125	25,0	-	16
HPPR 2020 3	10245	R	42	20	20	0	20	3,0	125	25,0	-	16
HPPR 2020 4	10247	R	42	20	20	0	20	4,0	125	25,0	-	16
HPPR 2525 20X	24251	R	42	25	25	0	25	2,0	150	25,0	-	16
HPPR 2525 3	10251	R	42	25	25	0	25	3,0	150	25,0	-	16
HPPR 2525 4	10253	R	50	25	25	0	25	4,0	150	30,0	-	16
HPPR 2525 5	10255	R	80	25	25	0	25	5,0	150	45,0	-	16

Remark

Holder and inserts with the same "S" dimension fit together.

Fitting inserts



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Key 1856 (Spare part 16) is added to the delivery

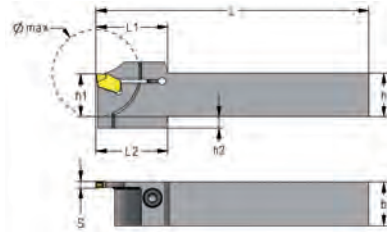


Parting off tool holders



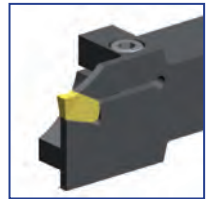
CLPPL
passt perfekt

LH holder



CLPPR
passt perfekt

RH holder



WG3801 Ref.	ID-Nr.	()	Ø max	h	h1	h2	b	S	L	L1	L2	
CLPPL 1010 K20X	24248	L	28	10	10	10	10	2,0	125	26	36	11
CLPPL 1212 K20X	19741	L	28	12	12	8	12	2,0	125	26	33	11
CLPPL 1212 K30	10336	L	34	12	12	8	12	3,0	125	29	33	11
CLPPL 1612 K20X	19743	L	28	16	16	4	12	2,0	125	26	31	11
CLPPL 1612 K30	10340	L	34	16	16	4	12	3,0	125	29	34	11
CLPPL 1612 K40	10342	L	40	16	16	8	12	4,0	125	33	34	11
CLPPL 2020 K20X	19745	L	40	20	20	5	20	2,0	125	33	33	5
CLPPL 2020 K30	10346	L	40	20	20	5	20	3,0	125	33	33	5
CLPPL 2020 K40	10348	L	53	20	20	5	20	4,0	125	40	40	5
CLPPL 2525 M20X	24249	L	40	25	25	0	25	2,0	150	36	-	2
CLPPL 2525 M30	10356	L	40	25	25	0	25	3,0	150	36	-	2
CLPPL 2525 M40	10358	L	53	25	25	0	25	4,0	150	40	-	2
CLPPL 2525 P50	10360	L	80	25	25	15	25	5,0	170	56	62	2
CLPPR 1010 K20X	19739	R	28	10	10	10	10	2,0	125	26	36	11
CLPPR 1212 K20X	19740	R	28	12	12	8	12	2,0	125	26	33	11
CLPPR 1212 K30	10335	R	34	12	12	8	12	3,0	125	29	33	11
CLPPR 1612 K20X	19742	R	28	16	16	4	12	2,0	125	26	31	11
CLPPR 1612 K30	10339	R	34	16	16	4	12	3,0	125	29	34	11
CLPPR 1612 K40	10341	R	40	16	16	8	12	4,0	125	33	34	11
CLPPR 2020 K20X	19744	R	40	20	20	5	20	2,0	125	33	33	5
CLPPR 2020 K30	10345	R	40	20	20	5	20	3,0	125	33	33	5
CLPPR 2020 K40	10347	R	53	20	20	5	20	4,0	125	40	40	5
CLPPR 2525 M20X	24247	R	40	25	25	0	25	2,0	150	36	-	2
CLPPR 2525 M30	10355	R	40	25	25	0	25	3,0	150	36	-	2
CLPPR 2525 M40	10357	R	53	25	25	0	25	4,0	150	40	-	2
CLPPR 2525 P50	10359	R	80	25	25	15	25	5,0	170	56	62	2

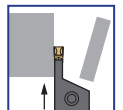
Remark

Holder and inserts with the same "S" dimension fit together.

Fitting inserts



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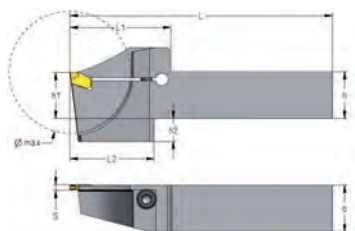


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Reinforced parting off holders


CLPPL..X
passt perfekt

LH holder


CLPPR..X
passt perfekt


RH holder

WG3801 Ref.	ID-Nr.	()	Ø max	h	h1	h2	b	S	L	L1	L2	
CLPPL 2020 X30 65	10350	L	65	20	20	17	20	3,0	115	54	45	12
CLPPL 2020 X40 65	10352	L	65	20	20	17	20	4,0	115	54	45	12
CLPPL 2525 X30 65	10362	L	65	25	25	12	25	3,0	140	54	45	12
CLPPL 2525 X40 65	10364	L	65	25	25	12	25	4,0	140	54	45	12
CLPPR 2020 X30 65	10349	R	65	20	20	17	20	3,0	115	54	45	12
CLPPR 2020 X40 65	10351	R	65	20	20	17	20	4,0	115	54	45	12
CLPPR 2525 X30 65	10361	R	65	25	25	12	25	3,0	140	54	45	12
CLPPR 2525 X40 65	10363	R	65	25	25	12	25	4,0	140	54	45	12

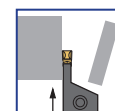
Remark

Holder and inserts with the same "S" dimension fit together.

Fitting inserts



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Parting off blades with autolock pocket


TMSPP
with insert stopping face
passt perfekt

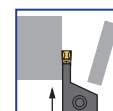

WG3101 Ref.	ID-Nr.	()	A	a	S	L	
TMSPP 26 20X	19732	N	26	21,4	2,0	110	16
TMSPP 26 3	10024	N	26	21,4	3,0	110	16
TMSPP 26 4	10025	N	26	21,4	4,0	110	16
TMSPP 32 20X	24245	N	32	25,0	2,0	150	16
TMSPP 32 3	10026	N	32	25,0	3,0	150	16
TMSPP 32 4	10027	N	32	25,0	4,0	150	16
TMSPP 32 5	10028	N	32	25,0	5,0	150	16

Remark

Blades and tool blocks with the same "A" dimension fit together.

Holder and inserts with the same "S" dimension fit together.

Fitting inserts and tool blocks



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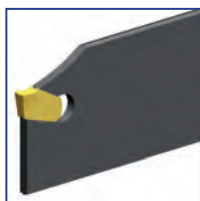
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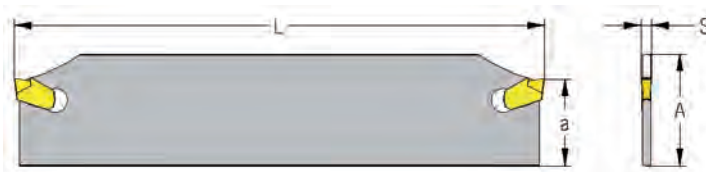
Key 1856 (Spare part 16) is added to the delivery



Parting off blades with autolock pocket



TPP
passt perfekt

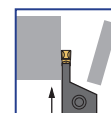


WG3101 Ref.	ID-Nr.	()	A	a	S	L	
TPP 19 20X	19733	N	19	15,5	2,0	86	16
TPP 26 20X	19734	N	26	21,4	2,0	110	16
TPP 26 3	10042	N	26	21,4	3,0	110	16
TPP 26 4	10043	N	26	21,4	4,0	110	16
TPP 26 5	10044	N	26	21,4	5,0	110	16
TPP 32 20X	24246	N	32	25,0	2,0	150	16
TPP 32 3	10046	N	32	25,0	3,0	150	16
TPP 32 4	10047	N	32	25,0	4,0	150	16
TPP 32 5	10048	N	32	25,0	5,0	150	16

Remark

Blades and tool blocks with the same "A" dimension fit together.
Holder and inserts with the same "S" dimension fit together.

Fitting inserts and tool blocks



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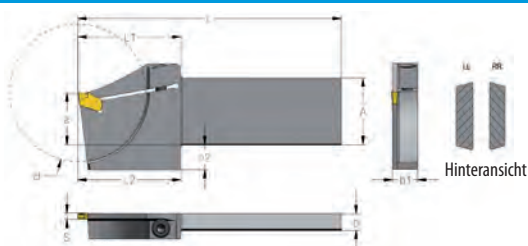
Key 1856 (Spare part 16) is added to the delivery

Reinforced parting off blades



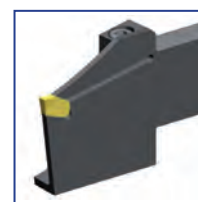
CLPPL..L
passt perfekt

LH Blades



CLPPR..R
passt perfekt

RH Blades



WG3801 Ref.	ID-Nr.	()	a	Ø max	A	h2	b	b1	S	L	L1	L2	
CLPPL 3208 X30 65L	10366	L	25	65	32,0	11,7	8	12	3	125	49	49	5
CLPPL 3208 X40 65L	10368	L	25	65	32,0	11,7	8	12	4	125	49	49	5
CLPPR 3208 X30 65R	10365	R	25	65	32,0	11,7	8	12	3	125	49	49	5
CLPPR 3208 X40 65R	10367	R	25	65	32,0	11,7	8	12	4	125	49	49	5

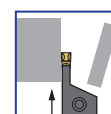
Remark

Blades and tool blocks with the same "A" dimension fit together.
Holder and inserts with the same "S" dimension fit together.

Fitting inserts and tool blocks



p.227-228,238



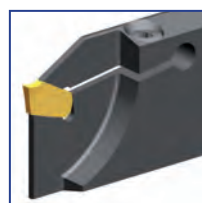
p. 132-135



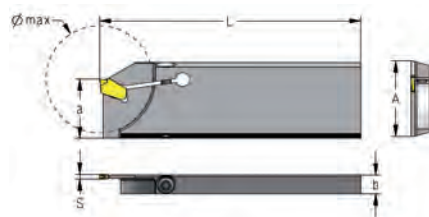
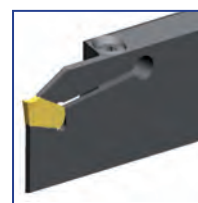
p. 149

Example for application you will find on page 72

Reinforced parting off blades

TMSPL
passt perfekt

LH Blades

TMSPR
passt perfekt

RH Blades

WG3801 Ref.	ID-Nr.	()	A	a	Ø max	b	S	L	
TMSPL 2608 J20X R	29534	L	26	21,4	46	8	2,0	110	10
TMSPL 2608 J30 R	10032	L	26	21,4	46	8	3,0	110	10
TMSPL 2608 J40 R	10034	L	26	21,4	46	8	4,0	110	10
TMSPL 3208 J20X R	29535	L	32	25,0	46	8	2,0	110	10
TMSPL 3208 J30 R	10038	L	32	25,0	46	8	3,0	110	10
TMSPL 3208 J40 R	10040	L	32	25,0	46	8	4,0	110	10
TMSPR 2608 J30 L	10031	R	26	21,4	46	8	3,0	110	10
TMSPR 2608 J40 L	10033	R	26	21,4	46	8	4,0	110	10
TMSPR 3208 J30 L	32383	R	32	25,0	46	8	3,0	110	10
TMSPR 3208 J40 L	10039	R	32	25,0	46	8	4,0	110	10
TMSPR 2608 J20X R	29532	R	26	21,4	46	8	2,0	110	10
TMSPR 3208 J20X R	29533	R	32	25,0	46	8	2,0	110	10
TMSPR 3208 J30 R	10037	R	32	25,0	46	8	3,0	110	10

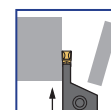
Remark

Blades and tool blocks with the same "A" dimension fit together.
Holder and inserts with the same "S" dimension fit together.

Fitting inserts and tool blocks



p.227-228,238



p. 132-135

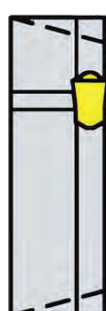


p. 149

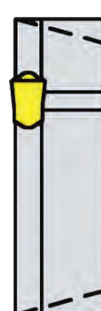
Example for application you will find on page 72



TMSPR...L



TMSPR...R



TMSPL...R

Different models
TMSPR/L...R/L

How to write an order:

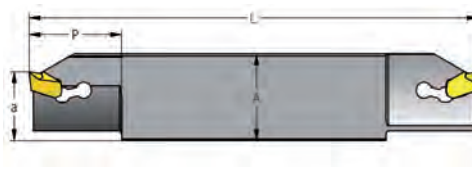
1 St.	TMSPL 3208 J40 R	or:	1 St.	recommended ID-Nr. 10040
10 St.	ITPL 4 4D ALU NANOSPEED	or:	10 St.	ID-Nr. 10672
1 St.	TS 32 32	or:	1 St.	ID-Nr. 10053

Face grooving blades with autolock pocket



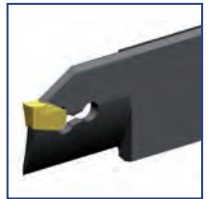
PPSMS L
with insert
stopping face
passt perfekt

LH blade



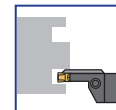
PPSMS R
with insert
stopping face
passt perfekt

RH blade



WG3151 Ref.	ID-Nr.	()	A	a	Ø min-max	P	S	L	
PPSMS 85 4 L	28859	L	32	25	85-160	32	4,0	160	16
PPSMS 140 4 L	38491	L	32	25	140-260	32	4,0	160	16
PPSMS 240 4 L	38493	L	32	25	240-∞	32	4,0	160	16
PPSMS 85 5 L	26194	L	32	25	85-160	32	5,0	160	16
PPSMS 140 5 L	38492	L	32	25	140-260	32	5,0	160	16
PPSMS 240 5 L	38494	L	32	25	240-∞	32	5,0	160	16
PPSMS 85 4 R	10209	R	32	25	85-160	32	4,0	160	16
PPSMS 140 4 R	10207	R	32	25	140-260	32	4,0	160	16
PPSMS 240 4 R	38495	R	32	25	240-∞	32	4,0	160	16
PPSMS 85 5 R	10210	R	32	25	85-160	32	5,0	160	16
PPSMS 140 5 R	10208	R	32	25	140-260	32	5,0	160	16
PPSMS 240 5 R	38496	R	32	25	240-∞	32	5,0	160	16

Fitting inserts and tool blocks



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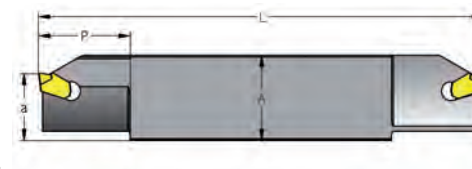


Key 1856 (Spare part 16) is added to the delivery



PPST R
passt perfekt

RH blade for RH inserts



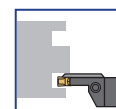
WG3151 Ref.	ID-Nr.	()	A	a	Ø min-max	P	S	L	
PPST 85 4 R	10215	R	32	25	85-160	32	4,0	160	16
PPST 140 4 R	10211	R	32	25	140-260	32	4,0	160	16
PPST 240 4 R	10213	R	32	25	240-∞	32	4,0	160	16
PPST 85 5 R	10216	R	32	25	85-160	32	5,0	160	16
PPST 140 5 R	10212	R	32	25	140-260	32	5,0	160	16
PPST 240 5 R	10214	R	32	25	240-∞	32	5,0	160	16

Remark

Blades and tool blocks with the same "A" dimension fit together.

Holder and inserts with the same "S" dimension fit together.

Fitting inserts and tool blocks



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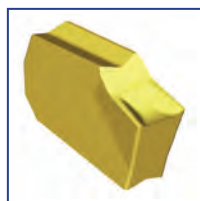
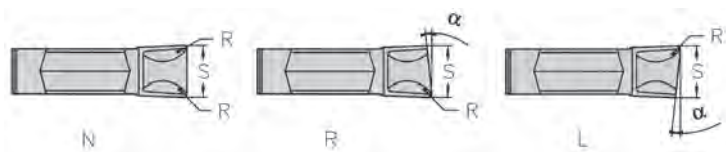
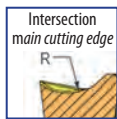
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Key 1856 (Spare part 16) is added to the delivery



Parting off and grooving inserts

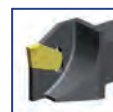

SNT N/R/L
 Standard Design


WG325 Ref.	PM NANOSPEED	GF110 CARBOSPEED	()	R	$S \pm 0,1$	α°
	ID-Nr.	ID-Nr.				
SNTN 2	47916	47917	N	0,2	2,2	0
SNTN 3	11330	47918	N	0,2	3,1	0
SNTN 4	11342	47919	N	0,2	4,1	0
SNTN 5	47920	47921	N	0,2	5,1	0
SNTR 2 6D	47922	47923	R	0,2	2,2	6
SNTR 3 6D	11391	47924	R	0,2	3,1	6
SNTR 4 6D	11411	47925	R	0,2	4,1	6
SNTR 5 6D	47926	47927	R	0,2	5,1	6
SNTL 2 6D	47910	47911	L	0,2	2,2	6
SNTL 3 6D	11392	47912	L	0,2	3,1	6
SNTL 4 6D	11412	47913	L	0,2	4,1	6
SNTL 5 6D	47914	47915	L	0,2	5,1	6

SUPERNOVA

The arc-shaped cutting edge with its reinforced flanks forms ideal chips. Recommended for free cutting and low alloy steels and stainless steels, also to be used on unstable machine tools.

Fitting tool holder



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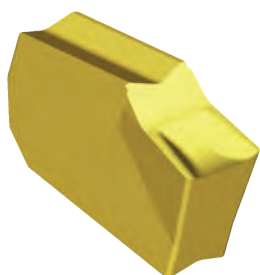
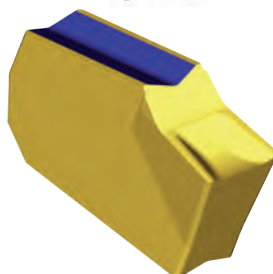


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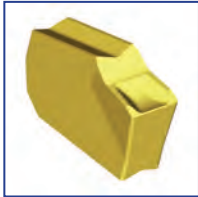
The difference!

Standard
Design...
„Standard Design” Inserts
 precision sintered top guide

„passt perfekt” Inserts
 ground top guide

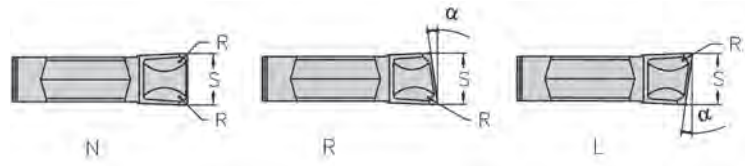
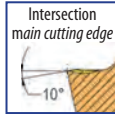
Attention!

The two systems are
**not interchange-
 able!**

Parting off and grooving inserts



IT N/R/L
Standard Design



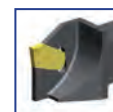
WG002 Ref.	PM NANOSPEED	GF110 CARBOSPEED	()	R	S ±0,1	α°
	ID-Nr.	ID-Nr.				
ITN 2	47890	47892	N	0,2	2,2	0
ITN 3	10497	47893	N	0,2	3,1	0
ITN 4	10515	47894	N	0,2	4,1	0
ITN 5	47896	47895	N	0,2	5,1	0
ITN 6	10527	-	N	0,2	6,35	0
ITR 2 4D	47898	47899	R	0,2	2,2	4
ITR 2 8D	47900	47901	R	0,2	2,2	8
ITR 3 4D	10791	47902	R	0,2	3,1	4
ITR 3 8D	10811	47903	R	0,2	3,1	8
ITR 4 4D	10837	47904	R	0,2	4,1	4
ITR 4 8D	10857	47905	R	0,2	4,1	8
ITR 5 4D	47906	47907	R	0,2	5,1	4
ITR 5 8D	47908	47909	R	0,2	5,1	8
ITL 2 4D	47877	47878	L	0,2	2,2	4
ITL 2 8D	47879	47880	L	0,2	2,2	8
ITL 3 4D	10792	47881	L	0,2	3,1	4
ITL 3 8D	10812	47882	L	0,2	3,1	8
ITL 4 4D	10838	47883	L	0,2	4,1	4
ITL 4 8D	10858	47884	L	0,2	4,1	8
ITL 5 4D	47885	47886	L	0,2	5,1	4
ITL 5 8D	47887	47888	L	0,2	5,1	8

IT Geometry

IT Geometry with its cutting edge strengthening, ground chamfer is recommended for:

- Alloy steels
- Stainless steels
- Interrupted cuts

Fitting tool holder



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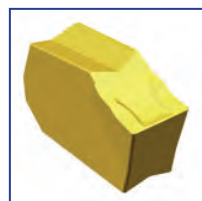
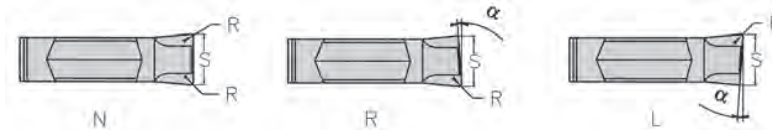
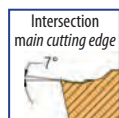


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Parting off and grooving inserts


IT ALU N/R/L
 Standard Design


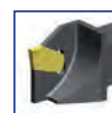
WG002 Ref.	GF 110	PM NANOSPEED	()	R	$s \pm 0,1$	α°
	ID-Nr.	ID-Nr.				
ITN 2 ALU	29338	47891	N	0,2	2,2	0
ITN 3 ALU	10480	10485	N	0,2	3,1	0
ITN 4 ALU	10498	10503	N	0,2	4,1	0
ITR 2 4D ALU	29602	47897	R	0,2	2,2	4
ITR 3 4D ALU	20692	10771	R	0,2	3,1	4
ITR 4 4D ALU	29215	10817	R	0,2	4,1	4
ITL 2 4D ALU	32370	47876	L	0,2	2,2	4
ITL 3 4D ALU	21489	10772	L	0,2	3,1	4
ITL 4 4D ALU	29212	10818	L	0,2	4,1	4

ALU Geometry

ALU Geometry with sharply ground, positive cutting edge is recommended for:

- Nonferrous heavy metals
- Machining steels
- **Thinwalled parts**
- Unstable components
- Pipes

Fitting tool holder



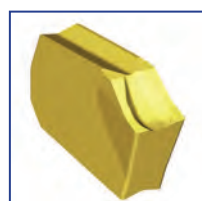
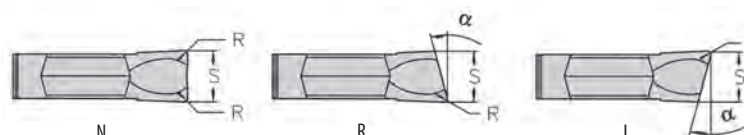
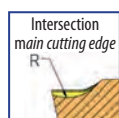
p. 145



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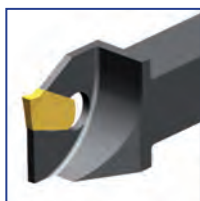


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 Technical section page 205 onwards

BGN /R/L
 Standard Design


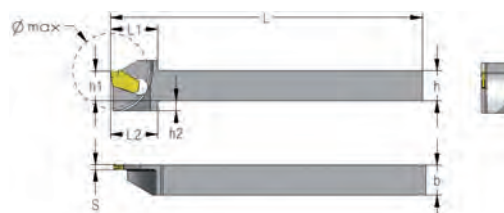
WG002 Ref.	PM NANOSPEED	GF110 CARBOSPEED	()	R	$s \pm 0,1$	α°
	ID-Nr.	ID-Nr.				
BGN 3	30874	48181	N	0,2	3,1	0
BGN 4	48183	48182	N	0,2	4,1	0
BGR 3 4D	48185	48184	R	0,2	3,1	4
BGR 3 8D	48187	48186	R	0,2	3,1	8
BGR 4 4D	48189	48188	R	0,2	4,1	4
BGR 4 8D	48191	48190	R	0,2	4,1	8
BGL 3 4D	48174	48173	L	0,2	3,1	4
BGL 3 8D	48176	48175	L	0,2	3,1	8
BGL 4 4D	48178	48177	L	0,2	4,1	4
BGL 4 8D	48180	48179	L	0,2	4,1	8

Parting off holders with autolock pocket

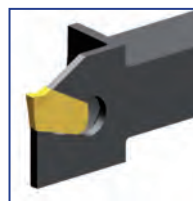


HL
Standard Design

LH holder



HR
Standard Design



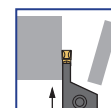
RH holder

WG320 Ref.	ID-Nr.	()	Ø max	h	h1	h2	b	S	L	L1	L2	
HL 1010 2	10258	L	30	10	10	6	10	2,2	125	18,5	18,5	16
HL 1010 3	10260	L	30	10	10	6	10	3,0	125	18,5	18,5	16
HL 1212 2	10262	L	30	12	12	4	12	2,2	125	18,5	18,5	16
HL 1212 3	10264	L	36	12	12	5	12	3,0	125	22,0	22,0	16
HL 1612 2	10266	L	30	16	16	0	12	2,2	125	18,5	-	16
HL 1612 3	10268	L	36	16	16	5	12	3,0	125	22,0	22,0	16
HL 1612 4	10270	L	42	16	16	5	12	4,0	125	25,0	25,0	16
HL 1616 3	10272	L	42	16	16	5	16	3,0	125	25,0	25,0	16
HL 1616 4	10274	L	42	16	16	5	16	4,0	125	25,0	25,0	16
HL 2020 2	10276	L	42	20	20	0	20	2,2	125	25,0	-	16
HL 2020 3	10278	L	42	20	20	0	20	3,0	125	25,0	-	16
HL 2020 4	10280	L	42	20	20	0	20	4,0	125	25,0	-	16
HL 2525 2	10282	L	42	25	25	0	25	2,2	150	25,0	-	16
HL 2525 3	10284	L	42	25	25	0	25	3,0	150	25,0	-	16
HR 1010 2	10257	R	30	10	10	6	10	2,2	125	18,5	18,5	16
HR 1010 3	10259	R	30	10	10	6	10	3,0	125	18,5	18,5	16
HR 1212 2	10261	R	30	12	12	4	12	2,2	125	18,5	18,5	16
HR 1212 3	10263	R	36	12	12	5	12	3,0	125	22,0	22,0	16
HR 1612 2	10265	R	30	16	16	0	12	2,2	125	18,5	-	16
HR 1612 3	10267	R	36	16	16	5	12	3,0	125	22,0	22,0	16
HR 1616 3	10271	R	42	16	16	5	16	3,0	125	25,0	25,0	16
HR 1616 4	10273	R	42	16	16	5	16	4,0	125	25,0	25,0	16
HR 2020 2	10275	R	42	20	20	0	20	2,2	125	25,0	-	16
HR 2020 3	10277	R	42	20	20	0	20	3,0	125	25,0	-	16
HR 2020 4	10279	R	42	20	20	0	20	4,0	125	25,0	-	16
HR 2525 2	10281	R	42	25	25	0	25	2,2	150	25,0	-	16
HR 2525 3	10283	R	42	25	25	0	25	3,0	150	25,0	-	16
HR 2525 4	10285	R	50	25	25	0	25	4,0	150	30,0	-	16
HR 2525 5	10287	R	80	25	25	0	25	5,0	150	45,0	-	16

Remark

Holder and inserts with the same "S" dimension fit together.

Fitting inserts



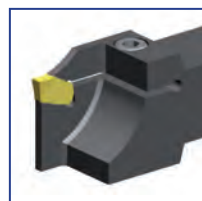
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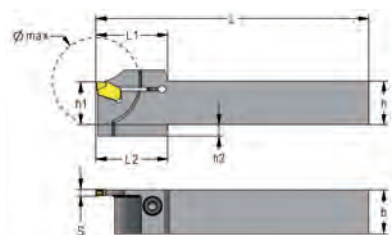
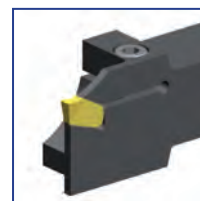
Key 1856 (Spare part 16) is added to the delivery



Parting off holders


CLCBL
 Standard Design

LH holder


CLCBR
 Standard Design


RH holder

WG380 Ref.	ID-Nr.	()	Ø max	h	h1	h2	b	S	L	L1	L2	
CLCBL 1010 K20	10290	L	28	10	10	10	10	2,2	125	26	36	11
CLCBL 1212 K20	10292	L	28	12	12	8	12	2,2	125	26	33	11
CLCBL 1212 K30	10294	L	34	12	12	8	12	3,0	125	29	33	11
CLCBL 1612 K20	10298	L	28	16	16	4	12	2,2	125	26	31	11
CLCBL 1612 K30	10300	L	34	16	16	4	12	3,0	125	29	34	11
CLCBL 1612 K40	10302	L	40	16	16	8	12	4,0	125	33	34	11
CLCBL 2020 K20	10304	L	40	20	20	5	20	2,2	125	33	33	5
CLCBL 2020 K30	10306	L	40	20	20	5	20	3,0	125	33	33	5
CLCBL 2020 K40	10308	L	53	20	20	5	20	4,0	125	40	40	5
CLCBL 2525 M20	10316	L	40	25	25	0	25	2,2	150	36	-	2
CLCBL 2525 M30	10318	L	40	25	25	0	25	3,0	150	36	-	2
CLCBL 2525 M40	10320	L	53	25	25	0	25	4,0	150	40	-	2
CLCBL 2525 P50	10322	L	80	25	25	15	25	5,0	170	56	62	2
CLCBR 1010 K20	10289	R	28	10	10	10	10	2,2	125	26	36	11
CLCBR 1212 K20	10291	R	28	12	12	8	12	2,2	125	26	33	11
CLCBR 1212 K30	10293	R	34	12	12	8	12	3,0	125	29	33	11
CLCBR 1612 K20	10297	R	28	16	16	4	12	2,2	125	26	31	11
CLCBR 1612 K30	10299	R	34	16	16	4	12	3,0	125	29	34	11
CLCBR 1612 K40	10301	R	40	16	16	8	12	4,0	125	33	34	11
CLCBR 2020 K20	10303	R	40	20	20	5	20	2,2	125	33	33	5
CLCBR 2020 K30	10305	R	40	20	20	5	20	3,0	125	33	33	5
CLCBR 2020 K40	10307	R	53	20	20	5	20	4,0	125	40	40	5
CLCBR 2525 M20	10315	R	40	25	25	0	25	2,2	150	36	-	2
CLCBR 2525 M30	10317	R	40	25	25	0	25	3,0	150	36	-	2
CLCBR 2525 M40	10319	R	53	25	25	0	25	4,0	150	40	-	2
CLCBR 2525 P50	10321	R	80	25	25	15	25	5,0	170	56	62	2

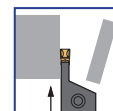
Remark

Holder and inserts with the same "S" dimension fit together.

Fitting inserts

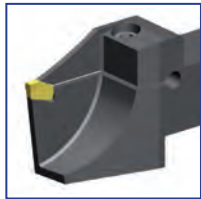


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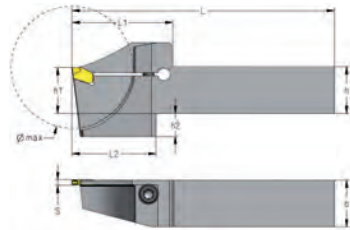
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Reinforced parting off holders



CLCBL..X
Standard Design

LH holder



CLCBR..X
Standard Design

RH holder



WG380 Ref.	ID-Nr.	()	Ø max	h	h1	h2	b	S	L	L1	L2	
CLCBL 2020 X20 65	10310	L	65	20	20	17	20	2,2	115	54	45	12
CLCBL 2020 X30 65	10312	L	65	20	20	17	20	3,0	115	54	45	12
CLCBL 2020 X40 65	10314	L	65	20	20	17	20	4,0	115	54	45	12
CLCBL 2525 X30 65	10324	L	65	25	25	12	25	3,0	140	54	45	12
CLCBL 2525 X40 65	10326	L	65	25	25	12	25	4,0	140	54	45	12
CLCBR 2020 X20 65	10309	R	65	20	20	17	20	2,2	115	54	45	12
CLCBR 2020 X30 65	10311	R	65	20	20	17	20	3,0	115	54	45	12
CLCBR 2020 X40 65	10313	R	65	20	20	17	20	4,0	115	54	45	12
CLCBR 2525 X30 65	10323	R	65	25	25	12	25	3,0	140	54	45	12
CLCBR 2525 X40 65	10325	R	65	25	25	12	25	4,0	140	54	45	12

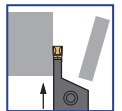
Remark

Holder and inserts with the same "S" dimension fit together.

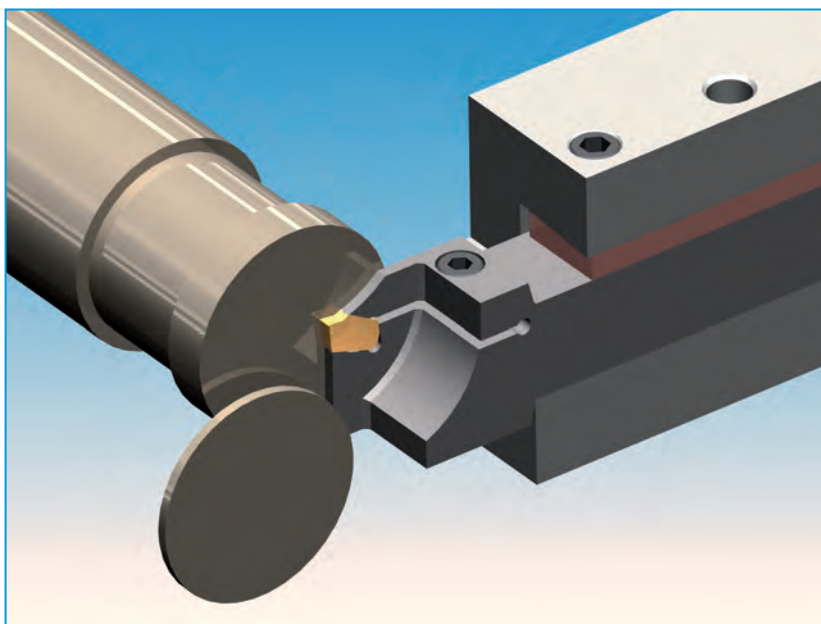
Fitting inserts



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Parting off basics

Always select the strongest tool holder with the most powerful clamping system and the appropriate inserts:

- True and straight run
- Clean faces
- Plane-parallel faces
- Good tool life
- Don't compromise!

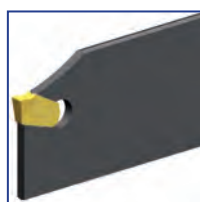
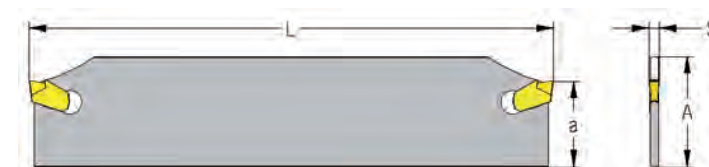
Parting off blades with autolock pocket


TMS
 with insert stopping face
 Standard Design


WG310 Ref.	ID-Nr.	(C)	A	a	S	L	
TMS 26 2	10016	N	26	21,4	2,2	110	16
TMS 26 3	10017	N	26	21,4	3,0	110	16
TMS 26 4	10018	N	26	21,4	4,0	110	16
TMS 32 3	10019	N	32	25,0	3,0	150	16
TMS 32 4	10020	N	32	25,0	4,0	150	16
TMS 32 5	10021	N	32	25,0	5,0	150	16
TMS 32 6	10022	N	32	25,0	6,0	150	16

Fitting inserts and tool blocks see below

7


T
 Standard Design


WG310 Ref.	ID-Nr.	(C)	A	a	S	L	
T 19 2	10001	N	19	15,5	2,2	86	16
T 26 2	10002	N	26	21,4	2,2	110	16
T 26 3	10003	N	26	21,4	3,0	110	16
T 26 3 90	10004	N	26	21,4	3,0	90	16
T 26 4	10005	N	26	21,4	4,0	110	16
T 26 5	10007	N	26	21,4	5,0	110	16
T 26 6	10008	N	26	21,4	6,35	110	16
T 32 2	10009	N	32	25,0	2,2	150	16
T 32 3	10010	N	32	25,0	3,0	150	16
T 32 3 100	10011	N	32	25,0	3,0	100	16
T 32 4	10012	N	32	25,0	4,0	150	16
T 32 5	10014	N	32	25,0	5,0	150	16
T 32 6	10015	N	32	25,0	6,35	150	16

Remark

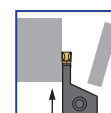
Blades and tool blocks with the same "A" dimension fit together.
 Holder and inserts with the same "S" dimension fit together.



Key 1856 (Spare part 16) is added to the delivery



Fitting inserts and tool blocks



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Tool blocks for parting off blades



TS



WG330 Ref.	ID-Nr.	()	A	a	h	h1	h2	B	b	b1	L	
TS 26 16	10049	N	26	21,4	16	16	3	34	16	5	90	3
TS 26 20	10050	N	26	21,4	20	20	9	38	20	5	90	3
TS 32 20	10051	N	32	25,0	20	20	13	38	20	6	120	3
TS 32 25	10052	N	32	25,0	25	25	8	38	20	6	120	3
TS 32 32	10053	N	32	25,0	32	32	1	44	25	6	120	3

Remark

Tool blocks KL and TS are recommended for the dovetail shaft tools on
page 73, 89, 131, 139 und 140

Blades and tool blocks with the same "A" dimension fit together.

Fitting blades



Torque
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p. 73 + 89



p. 74



p. 103



p. 130



p. 139



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p. 138 + 148



KL



WG330 Ref.	ID-Nr.	()	A	a	h	h1	h2	B	b	b1	L	
KL 26 16	10054	N	26	21,4	16	16	13	34	16	5	90	2+17
KL 26 20	10055	N	26	21,4	20	20	9	38	20	5	90	2+17
KL 32 20	10056	N	32	25,0	20	20	13	38	20	6	120	2+31
KL 32 25	10057	N	32	25,0	25	25	8	38	20	6	120	2+31

Remark

Dismountable wedge lock (26L) for KL 26...
Dismountable wedge lock (32L) for KL 32...

Tool blocks KL and TS are recommended for the dovetail shaft tools on
page 73, 89, 131, 139 und 140

Blades and tool blocks with the same "A" dimension fit together.

Fitting blades



Torque
p.227-228,238



p. 73 + 89



p. 74



p. 103



p. 130



p. 139

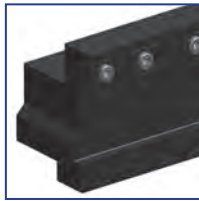
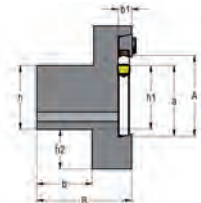
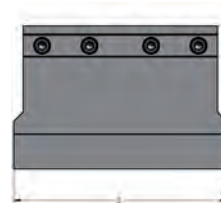


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Tool block for parting off blades


KL 52


WG330 Ref.	ID-Nr.	()	A	a	h	h1	h2	B	b	b1	L	
KL 52 40	45128	N	52,6	45	40	90	25	60	35	8,5	135	2+38
KL 52 50	45129	N	52,6	45	50	90	15	63	38	8,5	135	2+38

Attention!

Short blade extension will create best results. The shorter the better!



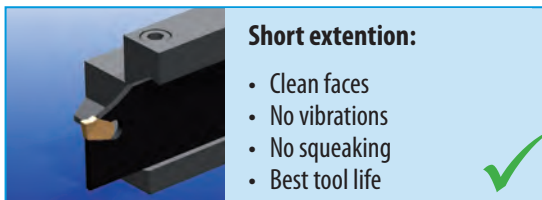
Fitting Blades



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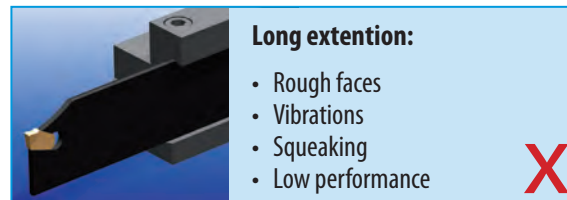


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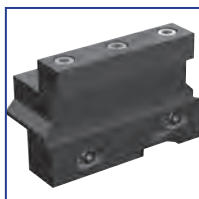
Short extension:

- Clean faces
- No vibrations
- No squeaking
- Best tool life

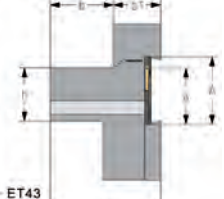
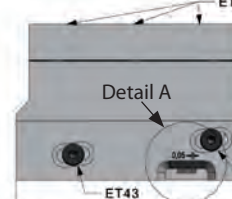


Long extension:

- Rough faces
- Vibrations
- Squeaking
- Low performance


KLV

Height adjustable tool block for parting off blades



WG330 Ref.	ID-Nr.	()	A	a	h	B	b	b1	L	shim plate	
KLV 26 20	10058	N	26	21,4	20	42	24	6	90	-	2+43+44
KLV 32 20	10059	N	32	25,0	20	42	24	6	120	-	2+43+44
KLV 32 25	10060	N	32	25,0	20	42	24	6	120	X	2+43+44
Shim plate 20x5x120	54556		-	-	5	-	20	-	120	-	-



Detail A



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p. 130



p. 139



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Delivering state of KLV 32-25 corresponds to KLV 32-20.
KLV 32-20 + shim plate 20x5x120.