



Solid drilling and bore machining

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2 Solid carbide drilling
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WNT \ Performance

Premium quality tools for high performance.

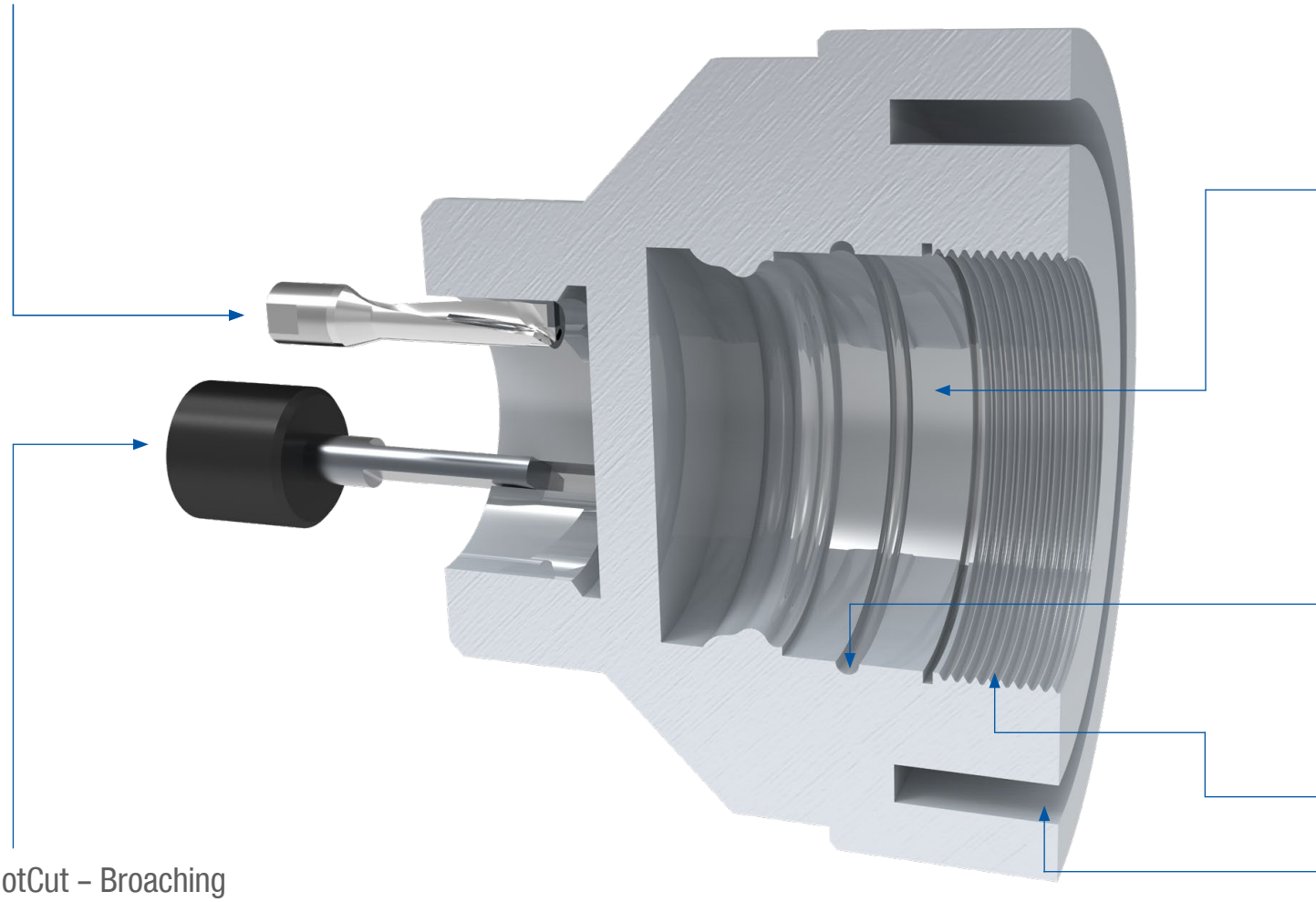
The premium quality tools from the **WNT Performance** product line have been designed for specific applications and are distinguished by their outstanding performance. If you make high demands on the performance of your production and want to achieve the very best results, we recommend the Premium tools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

Toolfinder

EcoCut Mini

From Ø 2 mm

Inserts and tool holders can be found in → **Chapter 10 – EcoCut**



SlotCut – Broaching

Inserts + Holder DIN138 55–58

System overview

UltraMini



- from Ø 0.5 mm
- flexible system
- ground inserts
- high repeatability
- coolant supply to the cutting edge

MiniCut



- from Ø 7.8 mm
- stable three-rib interface
- easy handling
- coolant supply to the cutting edge
- precise cutting edge position

SlotCut

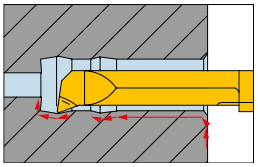


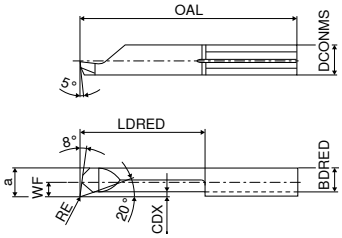
- broaching directly on the machine
- usable from Ø 6 mm
- low machine load
- variety of tolerance classes

Hole diameter in mm		UltraMini										MiniCut					
			≥ 0,5	≥ 2	≥ 2,4	≥ 2,8	≥ 3	≥ 4	≥ 5	≥ 6	≥ 8	≥ 16		≥ 8	≥ 9	≥ 11	≥ 14	≥ 16
Internal turning and profiling			4–7	4–7	4–7	4–7		4–7	4–7	4–7				36	36	36	36	36
Internal turning and profiling – hard turning				8		8		8	8	8				37		37	37	37
High-feed turning				10			10	10	10	10								
Turning and profile turning – super alloys				9		9		9	9	9								
Internal turning						11		11	11					38	38	38	38	38
Back boring							12	12	12	12				39	39	39	39	
Turning and chamfering									13	13				39	39	39	39	
Pre-parting and chamfering								13	13	13				40	40	40	40	40
Groove turning				14–16			14–16	14–16	14–16	14–16				41+42	40	40	40	40
Internal Undercuts				17		17		17	17	17				43	43	43	43	43
Groove and profile turning								18	18	18				44	44	44	44	44
Internal thread turning					19–22			19–22	19–22	19–22				45–48	45–48	45–48	45–48	45–48
Axial grooving									23–28	23–28	23–28	23–28		49+50	49+50	49+50	49+50	49+50
Suitable holder								31–35								51–54		
Sets								29+30								50		

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UltraMini – Inserts for internal turning and profiling













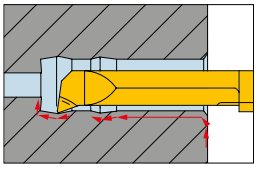
Illustrations show right-hand versions

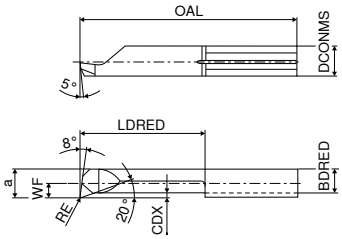
Designation	DCONMS h6	WF	DMIN	a	OAL	LDRED	CDX	BDRED	RE	Standard tool holder	Left-hand Y5 Article no. 73 005 ...		Right-hand Y5 Article no. 73 004 ...		Left-hand Y5 Article no. 73 005 ...		Right-hand Y5 Article no. 73 004 ...	
	mm	mm	mm	mm	mm	mm	mm	mm	mm		£		£		£		£	
R/L 050.05-2	4		0.5	0.4	20	2	0.03	0.32	0.02	645.00..-D	61.71	500	61.71	500				
R/L 050.06-2	4		0.6	0.5	20	2	0.05	0.40	0.04	645.00..-D	61.71	510	61.71	510				
R/L 050.06-3	4		0.6	0.5	20	3	0.05	0.40	0.04	645.00..-D	63.71	511	63.71	511				
R/L 050.08-4	4		0.8	0.7	20	4	0.05	0.60	0.04	645.00..-D					62.10	812	62.10	812
R/L 050.1-8	4		1.0	0.9	22	8	0.10	0.75	0.05	645.00..-D					61.51	813	61.51	813
R/L 050.15-5	4		1.5	1.3	19	5	0.10	1.15	0.05	645.00..-D	58.86	515	58.86	515				
R/L 050.15-10	4		1.5	1.3	24	10	0.10	1.15	0.05	645.00..-D	59.42	516	59.42	516				
R/L 050.15-12	4		1.5	1.3	26	12	0.10	1.15	0.05	645.00..-D					61.51	818	61.51	818
R/L 050.2-5	4		2.0	1.7	19	5	0.10	1.50	0.05	645.00..-D	50.02	520	45.89	520				
R/L 050.2-10	4		2.0	1.7	24	10	0.10	1.50	0.05	645.00..-D	50.60	521	50.02	521				
R/L 050.2-15	4		2.0	1.7	29	15	0.10	1.50	0.05	645.00..-D	54.32	522	49.60	522				
R/L 050.3-10	4	0.6	2.8	2.6	24	10	0.20	2.30	0.10	645.00..-D	54.32	531	52.74	531				
R/L 050.3-16	4	0.6	2.8	2.6	30	16	0.20	2.30	0.10	645.00..-D	59.57	530	57.86	530				
R/L 050.3-20	4	0.6	2.8	2.6	34	20	0.20	2.30	0.10	645.00..-D	56.58	532	57.78	532				
R/L 050.35-10	4	1.1	3.5	3.1	24	10	0.25	2.80	0.10	645.00..-D					48.65	835	48.65	835
R/L 050.35-16	4	1.1	3.5	3.1	30	16	0.25	2.80	0.10	645.00..-D					51.28	836	51.28	836
R/L 050.35-20	4	1.1	3.5	3.1	34	20	0.25	2.80	0.10	645.00..-D					61.62	837	61.62	837
R/L 050.35-24	4	1.1	3.5	3.1	38	24	0.25	2.80	0.10	645.00..-D					67.50	838	67.50	838
R/L 050.4-10	4	1.5	4.0	3.5	24	10	0.30	3.00	0.10	645.00..-D	54.59	541	52.01	541	49.89	841	49.89	841
R/L 050.4-16	4	1.5	4.0	3.5	30	16	0.30	3.00	0.10	645.00..-D	54.59	540	52.01	540	52.74	840	52.74	840
R/L 050.4-20	4	1.5	4.0	3.5	34	20	0.30	3.00	0.10	645.00..-D	55.78	542	55.44	542	58.99	842	58.99	842
R/L 050.4-24	4	1.5	4.0	3.5	38	24	0.30	3.00	0.10	645.00..-D	66.97	545	64.98	545	66.97	845	66.97	845
R/L 050.4-28	4	1.5	4.0	3.5	42	28	0.30	3.00	0.10	645.00..-D	74.54	546	71.16	546	74.54	846	74.54	846
R/L 050.5-10	5	1.9	5.0	4.4	25	10	0.50	3.80	0.15	645.00..-D	53.97	551	49.21	551	46.74	851	46.74	851
R/L 050.5-15	5	1.9	5.0	4.4	30	15	0.50	3.80	0.15	645.00..-D	54.80	552	52.43	552	49.89	852	49.89	852
R/L 050.5-20	5	1.9	5.0	4.4	35	20	0.50	3.80	0.15	645.00..-D	55.23	550	53.82	550	57.43	850	57.43	850
R/L 050.5-25	5	1.9	5.0	4.4	40	25	0.50	3.80	0.15	645.00..-D	63.61	553	60.80	553	64.98	853	64.98	853
R/L 050.5-30	5	1.9	5.0	4.4	45	30	0.50	3.80	0.15	645.00..-D	68.55	554	66.84	554	73.26	854	73.26	854
R/L 050.5-35	5	1.9	5.0	4.4	50	35	0.50	3.80	0.15	645.00..-D	81.23	556	77.59	556	81.23	856	81.23	856
R/L 050.5-40	5	1.9	5.0	4.4	55	40	0.50	3.80	0.15	645.00..-D					88.29	857	88.29	857
R/L 050.6-15	6	2.3	6.0	5.3	30	15	0.50	4.50	0.15	676.00..-D	56.14	561	51.46	561	49.89	861	49.89	861
R/L 050.6-22	6	2.3	6.0	5.3	37	22	0.50	4.50	0.15	676.00..-D	57.57	560	56.02	560	57.43	860	57.43	860
R/L 050.6-25	6	2.3	6.0	5.3	40	25	0.50	4.50	0.15	676.00..-D	65.15	562	59.57	562	64.98	862	64.98	862
R/L 050.6-30	6	2.3	6.0	5.3	45	30	0.50	4.50	0.15	676.00..-D	69.57	563	67.70	563	73.26	863	73.26	863
R/L 050.6-35	6	2.3	6.0	5.3	50	35	0.50	4.50	0.15	676.00..-D	81.23	564	77.59	564	81.23	864	81.23	864
R/L 050.6-42	6	2.3	6.0	5.3	57	42	0.50	4.50	0.15	676.00..-D	90.79	565	88.23	565	90.79	865	90.79	865
R/L 050.7-20	7	2.8	6.8	6.3	35	20	0.60	5.50	0.15	676.00..-D	58.86	572	57.16	572	56.62	872	56.62	872
R/L 050.7-25	7	2.8	6.8	6.3	40	25	0.60	5.50	0.15	676.00..-D	73.67	573	70.68	573	65.70	873	65.70	873
R/L 050.7-30	7	2.8	6.8	6.3	45	30	0.60	5.50	0.15	676.00..-D	73.40	574	71.68	574	72.96	874	72.96	874
R/L 050.7-35	7	2.8	7.0	6.3	50	35	0.60	5.50	0.15	676.00..-D	82.64	575	82.64	575	82.64	875	82.64	875
R/L 050.7-40	7	2.8	7.0	6.3	55	40	0.60	5.50	0.15	676.00..-D	92.06	576	92.06	576	92.06	876	92.06	876
R/L 050.7-45	7	2.8	7.0	6.3	60	45	0.60	5.50	0.15	676.00..-D	95.76	577	95.76	577	95.76	877	95.76	877
R/L 050.7-50	7	2.8	7.0	6.3	65	50	0.60	5.50	0.15	676.00..-D	105.02	578	105.02	578	105.02	878	105.02	878

Steel	●	●	●	●
Stainless steel	●	●	●	●
Cast iron	○	○	●	●
Non ferrous metals	○	○	●	●
Heat resistant alloys	○	○	●	●
hardened materials				

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UltraMini – Inserts for internal turning and profiling









Illustrations show right-hand versions

Designation	DCONMS h6	WF	DMIN	a	OAL	LDRED	CDX	BDRED	RE	Standard tool holder	Left-hand Y5 Article no. 73 005 ... £		Right-hand Y5 Article no. 73 004 ... £	
	mm	mm	mm	mm	mm	mm	mm	mm	mm					
R/L 050.2-5	4		2.0	1.7	19	5	0.1	1.5	0.05	645.00..-D	39.99	020	39.99	020
R/L 050.2-10	4		2.0	1.7	24	10	0.1	1.5	0.05	645.00..-D	41.91	021	41.91	021
R/L 050.2-15	4		2.0	1.7	29	15	0.1	1.5	0.05	645.00..-D	44.75	022	44.75	022
R/L 050.3-10	4	0.6	2.8	2.6	24	10	0.2	2.3	0.10	645.00..-D	42.34	031	42.34	031
R/L 050.3-16	4	0.6	2.8	2.6	30	16	0.2	2.3	0.10	645.00..-D	48.79	030	48.79	030
R/L 050.3-20	4	0.6	2.8	2.6	34	20	0.2	2.3	0.10	645.00..-D	50.00	032	50.00	032
R/L 050.4-10	4	1.5	4.0	3.5	24	10	0.3	3.0	0.10	645.00..-D	42.47	041	42.47	041
R/L 050.4-16	4	1.5	4.0	3.5	30	16	0.3	3.0	0.10	645.00..-D	44.05	040	44.05	040
R/L 050.4-20	4	1.5	4.0	3.5	34	20	0.3	3.0	0.10	645.00..-D	46.74	042	46.16	042
R/L 050.5-10	5	1.9	5.0	4.4	25	10	0.5	3.8	0.15	645.00..-D	42.77	051	42.77	051
R/L 050.5-15	5	1.9	5.0	4.4	30	15	0.5	3.8	0.15	645.00..-D	45.03	052	45.03	052
R/L 050.5-20	5	1.9	5.0	4.4	35	20	0.5	3.8	0.15	645.00..-D	46.60	050	46.60	050
R/L 050.5-25	5	1.9	5.0	4.4	40	25	0.5	3.8	0.15	645.00..-D	53.97	053	53.97	053
R 050.5-30	5	1.9	5.0	4.4	45	30	0.5	3.8	0.05	645.00..-D			59.21	054
L 050.5-30	5	1.9	5.0	4.4	45	30	0.5	3.8	0.15	645.00..-D	58.43	054		
R/L 050.6-15	6	2.3	6.0	5.3	30	15	0.5	4.5	0.15	676.00..-D	46.16	061	46.16	061
R/L 050.6-22	6	2.3	6.0	5.3	37	22	0.5	4.5	0.15	676.00..-D	46.97	060	46.97	060
R/L 050.6-25	6	2.3	6.0	5.3	40	25	0.5	4.5	0.15	676.00..-D	55.78	062	55.78	062
R/L 050.6-30	6	2.3	6.0	5.3	45	30	0.5	4.5	0.15	676.00..-D	60.14	063	59.28	063
R/L 050.7-20	7	2.8	6.8	6.3	35	20	0.6	5.5	0.15	676.00..-D	49.60	072	49.60	072
R/L 050.7-25	7	2.8	6.8	6.3	40	25	0.6	5.5	0.15	676.00..-D	56.62	073	56.62	073
R/L 050.7-30	7	2.8	6.8	6.3	45	30	0.6	5.5	0.15	676.00..-D	66.12	074	60.80	074

Steel	○	○
Stainless steel		
Cast iron	○	○
Non ferrous metals	●	●
Heat resistant alloys		
hardened materials		

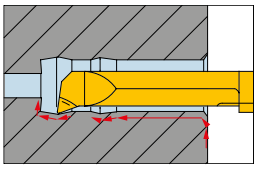
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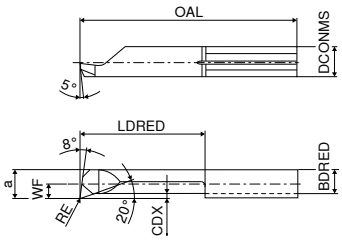
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UltraMini – Inserts for internal turning and profiling

▲ with corner radius ≤ 0.05 mm









Illustrations show right-hand versions

Designation	DCONMS h6	WF	DMIN	a	OAL	LDRED	CDX	BDRED	RE	Standard tool holder	Left-hand Y5 Article no. 73 021 ...		Right-hand Y5 Article no. 73 020 ...		Left-hand Y5 Article no. 73 023 ...		Right-hand Y5 Article no. 73 022 ...	
	mm	mm	mm	mm	mm	mm	mm	mm	mm		£		£		£		£	
R/L 053.3-10	4	0.6	2.8	2.6	24	10	0.2	2.3	0.03	645.00..-D	53.87	**310**	53.87	**310**				
R/L 053.3-16	4	0.6	2.8	2.6	30	16	0.2	2.3	0.03	645.00..-D	56.71	**316**	56.71	**316**				
R/L 053.3-20	4	0.6	2.8	2.6	34	20	0.2	2.3	0.03	645.00..-D	65.99	**320**	65.99	**320**				
R/L 053.4-10	4	1.5	4.0	3.5	24	10	0.3	3.0	0.03	645.00..-D	53.87	**410**	53.87	**410**				
R/L 053.4-16	4	1.5	4.0	3.5	30	16	0.3	3.0	0.03	645.00..-D	56.71	**416**	56.71	**416**				
R/L 053.4-20	4	1.5	4.0	3.5	34	20	0.3	3.0	0.03	645.00..-D	64.14	**420**	64.14	**420**				
R/L 053.4-24	4	1.5	4.0	3.5	38	24	0.3	3.0	0.03	645.00..-D	70.98	**424**	70.98	**424**				
R/L 053.4-28	4	1.5	4.0	3.5	42	28	0.3	3.0	0.03	645.00..-D	77.17	**428**	77.17	**428**				
R/L 055.2-10	4		2.0	1.7	24	10	0.1	1.5	0.05	645.00..-D					54.39	**210**	54.39	**210**
R/L 055.2-15	4		2.0	1.7	29	15	0.1	1.5	0.05	645.00..-D					58.14	**215**	58.14	**215**
R/L 055.2-5	4		2.0	1.7	19	5	0.1	1.5	0.05	645.00..-D					53.87	**205**	53.87	**205**
R/L 055.3-10	4	0.6	2.8	2.6	24	10	0.2	2.3	0.05	645.00..-D					53.87	**310**	53.87	**310**
R/L 055.3-16	4	0.6	2.8	2.6	30	16	0.2	2.3	0.05	645.00..-D					56.71	**316**	56.71	**316**
R/L 055.3-20	4	0.6	2.8	2.6	34	20	0.2	2.3	0.05	645.00..-D					67.41	**320**	67.41	**320**
R/L 055.4-10	4	1.5	4.0	3.5	24	10	0.3	3.0	0.05	645.00..-D					53.87	**410**	53.87	**410**
R/L 055.4-16	4	1.5	4.0	3.5	30	16	0.3	3.0	0.05	645.00..-D					56.71	**416**	56.71	**416**
R/L 055.4-20	4	1.5	4.0	3.5	34	20	0.3	3.0	0.05	645.00..-D					64.14	**420**	64.14	**420**
R/L 055.4-24	4	1.5	4.0	3.5	38	24	0.3	3.0	0.05	645.00..-D					70.98	**424**	70.98	**424**
R/L 055.4-28	4	1.5	4.0	3.5	42	28	0.3	3.0	0.05	645.00..-D					77.17	**428**	77.17	**428**
R/L 055.5-10	5	1.9	5.0	4.4	25	10	0.5	3.8	0.05	645.00..-D					50.86	**510**	48.47	**510**
R/L 055.5-15	5	1.9	5.0	4.4	30	15	0.5	3.8	0.05	645.00..-D					53.87	**515**	53.87	**515**
R/L 055.5-20	5	1.9	5.0	4.4	35	20	0.5	3.8	0.05	645.00..-D					61.29	**520**	61.29	**520**
R/L 055.5-25	5	1.9	5.0	4.4	40	25	0.5	3.8	0.05	645.00..-D					67.80	**525**	67.80	**525**
R/L 055.5-30	5	1.9	5.0	4.4	45	30	0.5	3.8	0.05	645.00..-D					77.11	**530**	77.11	**530**
R/L 055.5-35	5	1.9	5.0	4.4	50	35	0.5	3.8	0.05	645.00..-D					85.22	**535**	85.22	**535**
R/L 055.6-15	6	2.3	6.0	5.3	30	15	0.5	4.5	0.05	676.00..-D					53.87	**615**	53.87	**615**
R/L 055.6-22	6	2.3	6.0	5.3	37	22	0.5	4.5	0.05	676.00..-D					59.98	**622**	59.98	**622**
R/L 055.6-25	6	2.3	6.0	5.3	40	25	0.5	4.5	0.05	676.00..-D					67.80	**625**	67.80	**625**
R/L 055.6-30	6	2.3	6.0	5.3	45	30	0.5	4.5	0.05	676.00..-D					77.11	**630**	77.11	**630**
R/L 055.6-35	6	2.3	6.0	5.3	50	35	0.5	4.5	0.05	676.00..-D					85.22	**635**	85.22	**635**
R/L 055.6-42	6	2.3	6.0	5.3	57	42	0.5	4.5	0.05	676.00..-D					92.97	**642**	92.97	**642**

Steel	●	●	●	●
Stainless steel	●	●	●	●
Cast iron	●	●	●	●
Non ferrous metals	●	●	●	●
Heat resistant alloys	●	●	●	●
hardened materials				

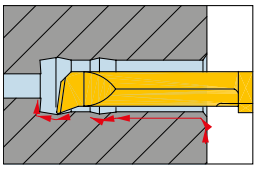
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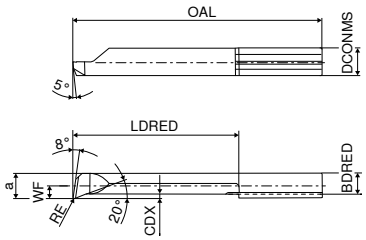
UltraMini – Inserts for internal turning and profiling

▲ with chip former



TiAlN TiAlN









Illustrations show right-hand versions

Designation	DCONMS h6	WF	DMIN	a	OAL	LDRED	CDX	BDRED	RE	Standard tool holder	Left-hand Y5 Article no. 73 017 ...		Right-hand Y5 Article no. 73 016 ...	
	mm	mm	mm	mm	mm	mm	mm	mm	mm		£		£	
R/L 050.4-10C	4	1.5	4	3.5	24	10	0.3	3.0	0.2	645.00..-D	49.89	**410**	49.89	**410**
R/L 050.4-16C	4	1.5	4	3.5	30	16	0.3	3.0	0.2	645.00..-D	52.74	**416**	52.74	**416**
R/L 050.4-20C	4	1.5	4	3.5	34	20	0.3	3.0	0.2	645.00..-D	58.99	**420**	58.99	**420**
R/L 050.4-24C	4	1.5	4	3.5	38	24	0.3	3.0	0.2	645.00..-D	66.97	**424**	66.97	**424**
R/L 050.4-28C	4	1.5	4	3.5	42	28	0.3	3.0	0.2	645.00..-D	74.54	**428**	74.54	**428**
R/L 050.5-10C	5	1.9	5	4.4	25	10	0.5	3.8	0.2	645.00..-D	46.74	**510**	46.74	**510**
R/L 050.5-15C	5	1.9	5	4.4	30	15	0.5	3.8	0.2	645.00..-D	49.89	**515**	49.89	**515**
R/L 050.5-20C	5	1.9	5	4.4	35	20	0.5	3.8	0.2	645.00..-D	57.43	**520**	57.43	**520**
R/L 050.5-25C	5	1.9	5	4.4	40	25	0.5	3.8	0.2	645.00..-D	64.98	**525**	64.98	**525**
R/L 050.5-30C	5	1.9	5	4.4	45	30	0.5	3.8	0.2	645.00..-D	73.26	**530**	73.26	**530**
R/L 050.5-35C	5	1.9	5	4.4	50	35	0.5	3.8	0.2	645.00..-D	81.23	**535**	81.23	**535**
R/L 050.6-15C	6	2.3	6	5.3	30	15	0.5	4.5	0.2	676.00..-D	49.89	**615**	49.89	**615**
R/L 050.6-22C	6	2.3	6	5.3	37	22	0.5	4.5	0.2	676.00..-D	57.43	**622**	57.43	**622**
R/L 050.6-25C	6	2.3	6	5.3	40	25	0.5	4.5	0.2	676.00..-D	64.98	**625**	64.98	**625**
R/L 050.6-30C	6	2.3	6	5.3	45	30	0.5	4.5	0.2	676.00..-D	73.26	**630**	73.26	**630**
R/L 050.6-35C	6	2.3	6	5.3	50	35	0.5	4.5	0.2	676.00..-D	81.23	**635**	81.23	**635**
R/L 050.6-42C	6	2.3	6	5.3	57	42	0.5	4.5	0.2	676.00..-D	90.79	**642**	90.79	**642**
R/L 050.7-20C	7	2.8	7	6.3	35	20	0.6	5.5	0.2	676.00..-D	56.62	**720**	56.62	**720**
R/L 050.7-25C	7	2.8	7	6.3	40	25	0.6	5.5	0.2	676.00..-D	65.70	**725**	65.70	**725**
R/L 050.7-30C	7	2.8	7	6.3	45	30	0.6	5.5	0.2	676.00..-D	72.96	**730**	72.96	**730**
R/L 050.7-35C	7	2.8	7	6.3	50	35	0.6	5.5	0.2	676.00..-D	82.64	**735**	82.64	**735**
R/L 050.7-40C	7	2.8	7	6.3	55	40	0.6	5.5	0.2	676.00..-D	92.06	**740**	92.06	**740**
R/L 050.7-45C	7	2.8	7	6.3	60	45	0.6	5.5	0.2	676.00..-D	95.76	**745**	95.76	**745**
R/L 050.7-50C	7	2.8	7	6.3	65	50	0.6	5.5	0.2	676.00..-D	105.02	**750**	105.02	**750**

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

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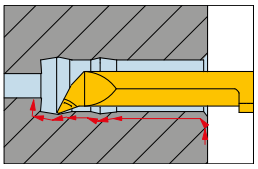
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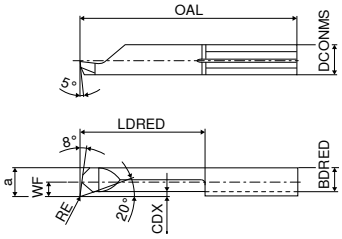
UltraMini – Inserts for internal turning and profiling – hard turning

▲ 46 to 65 HRC



TiAlN+ TiAlN+









Illustrations show right-hand versions

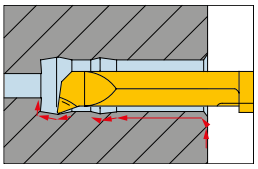
Designation	DCONMS h6 mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm	Standard tool holder	Left-hand Y5 Article no. 73 025 ... £		Right-hand Y5 Article no. 73 024 ... £	
R/L 050.2-5	4		2.0	1.7	19	5	0.1	1.5	0.05	645.00..-D	74.22	**920**	74.22	**920**
R/L 050.2-10	4		2.0	1.7	24	10	0.1	1.5	0.05	645.00..-D	75.59	**921**	75.59	**921**
R/L 050.2-15	4		2.0	1.7	29	15	0.1	1.5	0.05	645.00..-D	78.43	**922**	78.43	**922**
R/L 050.3-10	4	0.6	2.8	2.6	24	10	0.2	2.3	0.10	645.00..-D	73.97	**931**	73.97	**931**
R/L 050.3-16	4	0.6	2.8	2.6	30	16	0.2	2.3	0.10	645.00..-D	77.09	**930**	77.09	**930**
R/L 050.3-20	4	0.6	2.8	2.6	34	20	0.2	2.3	0.10	645.00..-D	88.21	**932**	88.21	**932**
R/L 050.4-10	4	1.5	4.0	3.5	24	10	0.3	3.0	0.10	645.00..-D	73.97	**941**	73.97	**941**
R/L 050.4-16	4	1.5	4.0	3.5	30	16	0.3	3.0	0.10	645.00..-D	77.09	**940**	77.09	**940**
R/L 050.4-20	4	1.5	4.0	3.5	34	20	0.3	3.0	0.10	645.00..-D	84.87	**942**	84.87	**942**
R/L 050.4-24	4	1.5	4.0	3.5	38	24	0.3	3.0	0.10	645.00..-D	92.30	**945**	92.30	**945**
R/L 050.4-28	4	1.5	4.0	3.5	42	28	0.3	3.0	0.10	645.00..-D	100.20	**946**	100.20	**946**
R/L 050.5-10	5	1.9	5.0	4.4	25	10	0.5	3.8	0.15	645.00..-D	71.74	**951**	71.74	**951**
R/L 050.5-15	5	1.9	5.0	4.4	30	15	0.5	3.8	0.15	645.00..-D	75.09	**952**	75.09	**952**
R/L 050.5-20	5	1.9	5.0	4.4	35	20	0.5	3.8	0.15	645.00..-D	83.14	**950**	83.14	**950**
R/L 050.5-25	5	1.9	5.0	4.4	40	25	0.5	3.8	0.15	645.00..-D	91.30	**953**	91.30	**953**
R/L 050.5-30	5	1.9	5.0	4.4	45	30	0.5	3.8	0.15	645.00..-D	100.09	**954**	100.09	**954**
R/L 050.5-35	5	1.9	5.0	4.4	50	35	0.5	3.8	0.15	645.00..-D	108.50	**956**	108.50	**956**
R/L 050.6-15	6	2.3	6.0	5.3	30	15	0.5	4.5	0.15	676.00..-D	76.19	**961**	76.19	**961**
R/L 050.6-22	6	2.3	6.0	5.3	37	22	0.5	4.5	0.15	676.00..-D	84.24	**960**	84.24	**960**
R/L 050.6-25	6	2.3	6.0	5.3	40	25	0.5	4.5	0.15	676.00..-D	92.41	**962**	92.41	**962**
R/L 050.6-30	6	2.3	6.0	5.3	45	30	0.5	4.5	0.15	676.00..-D	101.19	**963**	101.19	**963**
R/L 050.6-35	6	2.3	6.0	5.3	50	35	0.5	4.5	0.15	676.00..-D	109.86	**964**	109.86	**964**
R/L 050.6-42	6	2.3	6.0	5.3	57	42	0.5	4.5	0.15	676.00..-D	119.64	**965**	119.64	**965**
R/L 050.7-20	7	2.8	6.8	6.3	35	20	0.6	5.5	0.15	676.00..-D	85.12	**972**	85.12	**972**
R/L 050.7-25	7	2.8	6.8	6.3	40	25	0.6	5.5	0.15	676.00..-D	93.77	**973**	93.77	**973**
R/L 050.7-30	7	2.8	6.8	6.3	45	30	0.6	5.5	0.15	676.00..-D	102.94	**974**	102.94	**974**
R/L 050.7-35	7	2.8	6.8	6.3	50	35	0.6	5.5	0.15	676.00..-D	111.60	**975**	111.60	**975**
R/L 050.7-40	7	2.8	6.8	6.3	55	40	0.6	5.5	0.15	676.00..-D	121.86	**976**	121.86	**976**
R/L 050.7-45	7	2.8	6.8	6.3	60	45	0.6	5.5	0.15	676.00..-D	127.68	**977**	127.68	**977**
R/L 050.7-50	7	2.8	6.8	6.3	65	50	0.6	5.5	0.15	676.00..-D	135.72	**978**	135.72	**978**

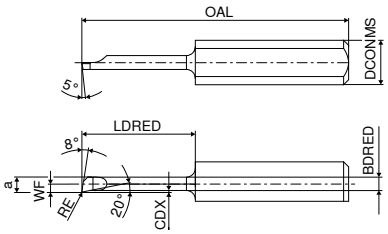
Steel		
Stainless steel		
Cast iron		
Non ferrous metals		
Heat resistant alloys		
hardened materials	●	●

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UltraMini – Inserts for internal turning and profiling

▲ Specially designed for super alloys





DPX 57S DRAGONSKIN



DPX 57S DRAGONSKIN



Illustrations show right-hand versions

Designation	DCONMS h6 mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm	Standard tool holder	Left-hand Y5 Article no. 73 027 ... £		Right-hand Y5 Article no. 73 026 ... £	
R/L M050.05-2	4	0.20	0.5	0.40	20	2	0.02	0.02	0.02	645.00..-D	51.90	**052**	51.90	**052**
R/L M050.08-4	4	0.35	0.8	0.70	20	4	0.08	0.03	0.02	645.00..-D	52.98	**082**	52.98	**082**
R/L M050.1-5	4	0.40	1.0	0.90	20	5	0.05	0.05	0.02	645.00..-D	48.66	**102**	48.66	**102**
R/L M050.1-7	4	0.40	1.0	0.90	22	7	0.05	0.05	0.02	645.00..-D	50.82	**103**	50.82	**103**
R/L M050.15-5	4	0.60	1.5	1.15	19	5	0.08	0.08	0.02	645.00..-D	48.66	**151**	48.66	**151**
R/L M050.15-10	4	0.60	1.5	1.15	24	10	0.08	0.08	0.02	645.00..-D	50.82	**154**	50.82	**154**
R/L M050.2-5	4	0.80	2.0	1.70	19	5	0.08	0.08	0.02	645.00..-D	42.17	**201**	42.17	**201**
R/L M050.2-10	4	0.80	2.0	1.70	24	10	0.08	0.08	0.02	645.00..-D	43.25	**204**	43.25	**204**
R/L M050.25-5	4	0.20	2.5	2.20	19	5	0.10	0.10	0.02	645.00..-D	42.17	**251**	42.17	**251**
R/L M050.25-10	4	0.20	2.5	2.20	24	10	0.10	0.10	0.02	645.00..-D	43.25	**254**	43.25	**254**
R/L M050.3-10	4	0.60	3.0	2.60	24	10	0.15	0.15	0.02	645.00..-D	42.17	**304**	42.17	**304**
R/L M050.3-16	4	0.60	3.0	2.60	30	16	0.15	0.15	0.02	645.00..-D	44.33	**307**	44.33	**307**
R/L M050.35-10	4	1.10	3.5	3.10	24	10	0.17	0.17	0.02	645.00..-D	42.17	**350**	42.17	**350**
R/L M050.35-16	4	1.10	3.5	3.10	30	16	0.17	0.17	0.02	645.00..-D	44.33	**353**	44.33	**353**
R/L M050.35-20	4	1.10	3.5	3.10	34	20	0.17	0.17	0.02	645.00..-D	52.98	**354**	52.98	**354**
R/L M050.4-10	4	1.50	4.0	3.50	24	10	0.20	0.20	0.02	645.00..-D	42.17	**400**	42.17	**400**
R/L M050.4-16	4	1.50	4.0	3.50	30	16	0.20	0.20	0.02	645.00..-D	44.33	**403**	44.33	**403**
R/L M050.4-20	4	1.50	4.0	3.50	34	20	0.20	0.20	0.02	645.00..-D	49.74	**404**	49.74	**404**
R/L M050.4-24	4	1.50	4.0	3.50	38	24	0.20	0.20	0.02	645.00..-D	56.23	**406**	56.23	**406**

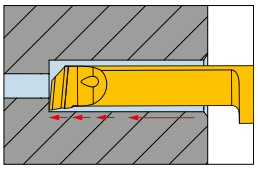
Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

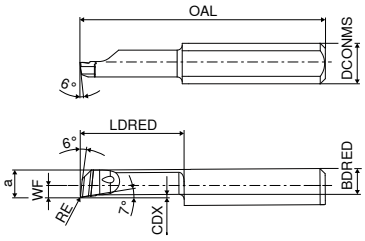
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UltraMini – Inserts for internal turning

- ▲ with chip breaker
- ▲ high feed boring







DPX77S DRAGONSKIN



DPX77S DRAGONSKIN



Illustrations show right-hand versions

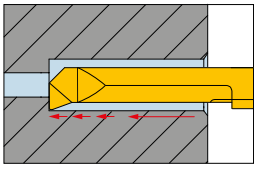
Designation	DCONMS h6 mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm	Standard tool holder	Left-hand Y5 Article no. 73 001 ... £		Right-hand Y5 Article no. 73 000 ... £	
R/L X050.1-5	4		1.0	0.90	20	5	0.03	0.85	0.05	645.00..-D	44.66	**121**	44.66	**121**
R/L X050.15-7	4		1.5	1.35	22	7	0.05	1.25	0.10	645.00..-D	51.04	**233**	51.04	**233**
R/L X050.2-5	4		2.0	1.80	19	5	0.10	1.60	0.15	645.00..-D	38.83	**245**	38.83	**245**
R/L X050.2-10	4		2.0	1.80	24	10	0.10	1.60	0.05	645.00..-D	39.85	**215**	39.85	**215**
R/L X050.2-10	4		2.0	1.80	24	10	0.10	1.60	0.15	645.00..-D	39.85	**241**	39.85	**241**
R/L X050.3-10	4	0.7	3.0	2.70	24	10	0.15	2.55	0.05	645.00..-D	38.72	**341**	38.72	**341**
R/L X050.3-10	4	0.7	3.0	2.70	24	10	0.15	2.55	0.20	645.00..-D	38.72	**347**	38.72	**347**
R/L X050.3-16	4	0.7	3.0	2.70	30	16	0.15	2.55	0.05	645.00..-D	40.85	**371**	40.85	**371**
R/L X050.3-16	4	0.7	3.0	2.70	30	16	0.15	2.55	0.10	645.00..-D	40.85	**373**	40.85	**373**
R/L X050.3-16	4	0.7	3.0	2.70	30	16	0.15	2.55	0.20	645.00..-D	40.85	**377**	40.85	**377**
R/L X050.4-10	4	1.6	4.0	3.60	24	10	0.20	3.20	0.10	645.00..-D	38.72	**403**	38.72	**403**
R/L X050.4-10	4	1.6	4.0	3.60	24	10	0.20	3.20	0.20	645.00..-D	38.72	**407**	38.72	**407**
R/L X050.4-16	4	1.6	4.0	3.60	30	16	0.20	3.20	0.05	645.00..-D	40.85	**431**	40.85	**431**
R/L X050.4-16	4	1.6	4.0	3.60	30	16	0.20	3.20	0.10	645.00..-D	40.85	**433**	40.85	**433**
R/L X050.4-16	4	1.6	4.0	3.60	30	16	0.20	3.20	0.20	645.00..-D	40.85	**437**	40.85	**437**
R/L X050.4-24	4	1.6	4.0	3.60	38	24	0.20	3.20	0.10	645.00..-D	51.92	**463**	51.92	**463**
R/L X050.4-24	4	1.6	4.0	3.60	38	24	0.20	3.20	0.20	645.00..-D	51.92	**467**	51.92	**467**
R/L X050.5-15	5	2.1	5.0	4.60	30	15	0.30	4.05	0.05	645.00..-D	38.72	**511**	38.72	**511**
R/L X050.5-15	5	2.1	5.0	4.60	30	15	0.30	4.05	0.10	645.00..-D	38.72	**513**	38.72	**513**
R/L X050.5-15	5	2.1	5.0	4.60	30	15	0.30	4.05	0.20	645.00..-D	38.72	**517**	38.72	**517**
R/L X050.5-25	5	2.1	5.0	4.60	40	25	0.30	4.05	0.10	645.00..-D	50.47	**543**	50.47	**543**
R/L X050.5-25	5	2.1	5.0	4.60	40	25	0.30	4.05	0.20	645.00..-D	50.47	**547**	50.47	**547**
R/L X050.5-30	5	2.1	5.0	4.60	45	30	0.30	4.05	0.10	645.00..-D	57.08	**553**	57.08	**553**
R/L X050.5-30	5	2.1	5.0	4.60	45	30	0.30	4.05	0.20	645.00..-D	57.08	**557**	57.08	**557**
R/L X050.6-15	6	2.5	6.0	5.50	30	15	0.40	4.90	0.05	676.00..-D	38.72	**611**	38.72	**611**
R/L X050.6-15	6	2.5	6.0	5.50	30	15	0.40	4.90	0.10	676.00..-D	38.72	**613**	38.72	**613**
R/L X050.6-15	6	2.5	6.0	5.50	30	15	0.40	4.90	0.20	676.00..-D	38.72	**617**	38.72	**617**
R/L X050.6-22	6	2.5	6.0	5.50	37	22	0.40	4.90	0.20	676.00..-D	44.54	**637**	44.54	**637**
R/L X050.6-30	6	2.5	6.0	5.50	45	30	0.40	4.90	0.20	676.00..-D	57.08	**657**	57.08	**657**
R/L X050.6-35	6	2.5	6.0	5.50	50	35	0.40	4.90	0.20	676.00..-D	63.11	**667**	63.11	**667**
R/L X050.6-50	6	2.5	6.0	5.50	65	50	0.40	4.90	0.20	676.00..-D	78.57	**697**	78.57	**697**
R/L X050.7-25	7	3.0	7.0	6.50	40	25	0.50	5.90	0.20	676.00..-D	51.25	**747**	51.25	**747**
R/L X050.7-30	7	3.0	7.0	6.50	45	30	0.50	5.90	0.20	676.00..-D	57.75	**757**	57.75	**757**

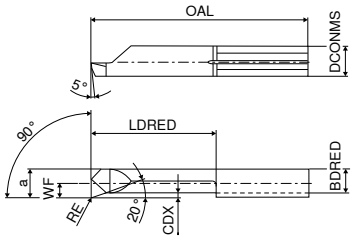
Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

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UltraMini – Inserts for internal turning







TiN



TiN



Illustrations show right-hand versions

Designation	DCONMS h6 mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm	Standard tool holder	Left-hand Y5 Article no. 73 015 ... £		Right-hand Y5 Article no. 73 014 ... £	
R/L 090.3-10	4	0.6	2.8	2.6	24	10	0.2	2.3	0.2	645.00..-D	49.89	**541**	49.89	**541**
R/L 090.3-16	4	0.6	2.8	2.6	30	16	0.2	2.3	0.2	645.00..-D	52.87	**542**	52.87	**542**
R/L 090.4-10	4	1.5	4.0	3.5	24	10	0.3	3.0	0.2	645.00..-D	49.89	**545**	49.89	**545**
R/L 090.4-16	4	1.5	4.0	3.5	30	16	0.3	3.0	0.2	645.00..-D	52.87	**546**	52.87	**546**
R/L 090.5-10	5	1.9	5.0	4.4	25	10	0.5	3.8	0.2	645.00..-D	49.89	**550**	49.89	**550**
R/L 090.5-15	5	1.9	5.0	4.4	30	15	0.5	3.8	0.2	645.00..-D	52.87	**551**	52.87	**551**
R/L 090.5-20	5	1.9	5.0	4.4	35	20	0.5	3.8	0.2	645.00..-D	57.43	**552**	57.43	**552**

Steel	●	●
Stainless steel	●	●
Cast iron	○	○
Non ferrous metals	○	○
Heat resistant alloys	○	○
hardened materials		

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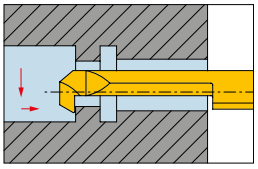
12

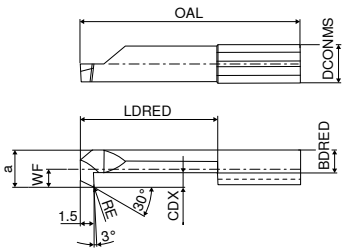
UltraMini – Inserts for back boring



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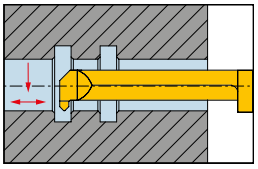
Illustrations show right-hand versions

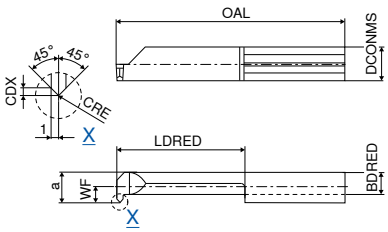
Designation	DCONMS h6 mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	RE mm	Standard tool holder	Left-hand Y5 Article no. 73 013 ... £		Right-hand Y5 Article no. 73 012 ... £	
R/L 080.0003-15	4	0.6	3	2.6	29	15	0.5	2.0	0.10	645.00..-D	60.99	**542**	60.99	**542**
R/L 080.0003-20	4	0.6	3	2.6	34	20	0.5	2.0	0.10	645.00..-D	72.69	**544**	72.69	**544**
R/L 080.0004-15	4	1.5	4	3.5	29	15	0.8	2.4	0.15	645.00..-D	60.99	**546**	60.99	**546**
R/L 080.0004-25	4	1.5	4	3.5	39	25	0.8	2.4	0.15	645.00..-D	68.37	**548**	68.37	**548**
R/L 080.0005-20	5	1.9	5	4.4	35	20	1.0	3.3	0.20	645.00..-D	62.30	**554**	62.30	**554**
R/L 080.0005-30	5	1.9	5	4.4	45	30	1.0	3.3	0.20	645.00..-D	64.71	**558**	64.71	**558**
R/L 080.0006-20	6	2.3	6	5.3	35	20	1.8	3.4	0.20	676.00..-D	64.98	**564**	64.98	**564**
R/L 080.0006-30	6	2.3	6	5.3	45	30	1.8	3.4	0.20	676.00..-D	77.80	**568**	77.80	**568**
R/L 080.0007-20	7	2.7	7	6.3	35	20	2.5	3.8	0.20	676.00..-D	64.98	**574**	64.98	**574**
R/L 080.0007-30	7	2.7	7	6.3	45	30	2.5	3.8	0.20	676.00..-D	77.80	**578**	77.80	**578**

Steel	●	●
Stainless steel	●	●
Cast iron	○	○
Non ferrous metals	○	○
Heat resistant alloys	○	○
hardened materials		

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UltraMini – Inserts for internal turning and chamfering





TiN



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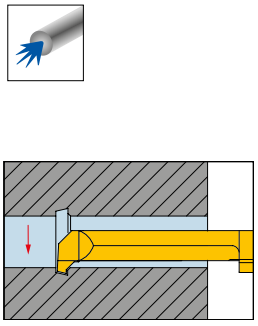
Illustrations show right-hand versions

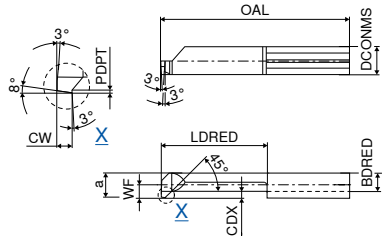
Designation	DCONMS h6	WF	DMIN	a	OAL	LDRED	CDX	BDRED	CRE	Standard tool holder	Left-hand Y5 Article no. 73 007 ...		Right-hand Y5 Article no. 73 006 ...	
	mm	mm	mm	mm	mm	mm	mm	mm	mm		£		£	
R/L 060.5-15	5	1.9	5.0	4.4	30	15	0.7	3.3	0.2	645.00..-D	50.60	**551**	47.01	**551**
R/L 060.5-20	5	1.9	5.0	4.4	35	20	0.7	3.3	0.2	645.00..-D	52.55	**550**	52.32	**550**
R/L 060.7-20	7	2.7	6.8	6.3	35	20	0.7	3.8	0.2	676.00..-D	58.99	**570**	54.59	**570**

Steel	●	●
Stainless steel	●	●
Cast iron	○	○
Non ferrous metals	○	○
Heat resistant alloys	○	○
hardened materials		

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UltraMini – Inserts for internal chamfering for subsequent parting off





TiN



TiN



Illustrations show right-hand versions

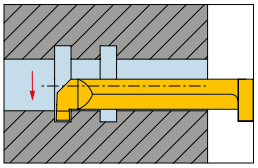
Designation	DCONMS h6	WF	DMIN	a	OAL	LDRED	CDX	BDRED	CW	PDPT	Standard tool holder	Left-hand Y5 Article no. 73 009 ...		Right-hand Y5 Article no. 73 008 ...	
	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm		£		£	
R/L 070.4-10	4	1.5	4	3.5	25	10	0.8	2.4	1	0.2	645.00..-D	52.37	**410**	52.37	**410**
R/L 070.4-16	4	1.5	4	3.5	30	16	0.8	2.4	1	0.2	645.00..-D	53.94	**416**	53.94	**416**
R/L 070.5-15	5	1.9	5	4.4	30	15	1.0	3.3	1	0.2	645.00..-D	51.73	**551**	51.73	**551**
R/L 070.5-20	5	1.9	5	4.4	35	20	1.0	3.3	1	0.2	645.00..-D	54.59	**550**	54.59	**550**
R/L 070.5-30	5	1.9	5	4.4	45	30	1.0	3.3	1	0.2	645.00..-D	72.91	**530**	72.91	**530**
R/L 070.6-30	6	2.3	6	5.3	45	30	1.0	4.2	1	0.2	676.00..-D	72.91	**630**	72.91	**630**
R/L 070.6-42	6	2.3	6	5.3	57	42	1.0	4.2	1	0.2	676.00..-D	85.29	**642**	85.29	**642**

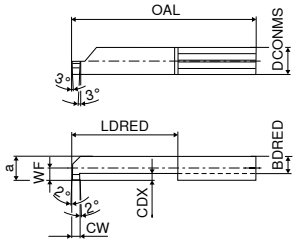
Steel	●	●
Stainless steel	●	●
Cast iron	○	○
Non ferrous metals	○	○
Heat resistant alloys	○	○
hardened materials		

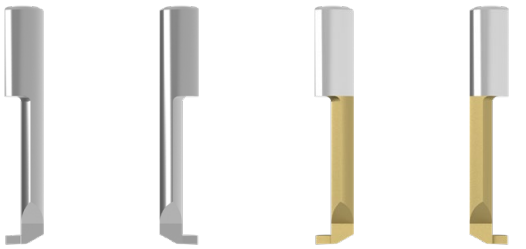
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UltraMini – Inserts for Internal Grooving









Illustrations show right-hand versions

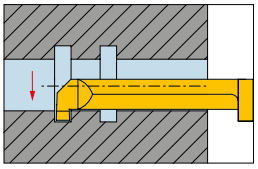
Designation	DCONMS h6	WF	DMIN	a	OAL	LDRED	CDX	BDRED	CW	Standard tool holder	Left-hand Y5 Article no. 73 003 ...		Right-hand Y5 Article no. 73 002 ...		Left-hand Y5 Article no. 73 003 ...		Right-hand Y5 Article no. 73 002 ...	
	mm	mm	mm	mm	mm	mm	mm	mm	mm		£		£		£		£	
R/L 004.0100-10	4	1.5	4.0	3.5	24	10	0.8	2.4	1.0	645.00..-D	38.91	040	38.91	040	47.39	540	46.33	540
R/L 004.0100-16	4	1.5	4.0	3.5	30	16	0.8	2.4	1.0	645.00..-D	48.60	041	48.60	041	58.14	541	56.58	541
R/L 004.0100-20	4	1.5	4.0	3.5	34	20	0.8	2.4	1.0	645.00..-D	52.45	042	52.45	042	62.72	542	60.99	542
R/L 005.0100-10	5	1.9	5.0	4.4	25	10	1.0	3.3	1.0	645.00..-D	38.59	150	38.59	150	48.47	650	45.58	650
R/L 005.0150-10	5	1.9	5.0	4.4	25	10	1.0	3.3	1.5	645.00..-D	38.59	154	38.59	154	48.47	654	47.18	654
R/L 005.0200-10	5	1.9	5.0	4.4	25	10	1.0	3.3	2.0	645.00..-D	38.59	158	38.59	158	48.47	658	47.18	658
R/L 005.0100-15	5	1.9	5.0	4.4	30	15	1.0	3.3	1.0	645.00..-D	45.58	151	45.58	151	56.02	651	53.40	651
R/L 005.0150-15	5	1.9	5.0	4.4	30	15	1.0	3.3	1.5	645.00..-D	45.58	155	45.58	155	56.02	655	53.40	655
R/L 005.0200-15	5	1.9	5.0	4.4	30	15	1.0	3.3	2.0	645.00..-D	45.58	159	45.58	159	56.02	659	53.40	659
R/L 005.0100-20	5	1.9	5.0	4.4	35	20	1.0	3.3	1.0	645.00..-D	52.45	051	52.45	051	60.80	551	60.45	551
R/L 005.0150-20	5	1.9	5.0	4.4	35	20	1.0	3.3	1.5	645.00..-D	52.45	052	52.45	052	60.80	552	60.45	552
R/L 005.0200-20	5	1.9	5.0	4.4	35	20	1.0	3.3	2.0	645.00..-D	52.45	053	52.45	053	60.80	553	60.45	553
R/L 005.0100-25	5	1.9	5.0	4.4	40	25	1.0	3.3	1.0	645.00..-D	58.99	152	58.99	152	68.84	652	66.97	652
R/L 005.0150-25	5	1.9	5.0	4.4	40	25	1.0	3.3	1.5	645.00..-D	58.99	156	58.99	156	68.84	656	66.97	656
R/L 005.0200-25	5	1.9	5.0	4.4	40	25	1.0	3.3	2.0	645.00..-D	58.99	250	58.99	250	69.26	750	67.41	750
R/L 005.0100-30	5	1.9	5.0	4.4	45	30	1.0	3.3	1.0	645.00..-D	66.56	153	66.56	153	76.67	653	74.54	653
R/L 005.0150-30	5	1.9	5.0	4.4	45	30	1.0	3.3	1.5	645.00..-D	66.56	157	66.56	157	76.67	657	74.54	657
R/L 005.0200-30	5	1.9	5.0	4.4	45	30	1.0	3.3	2.0	645.00..-D	66.56	251	66.56	251	77.11	751	75.11	751
R/L 005.0100-35	5	1.9	5.0	4.4	50	35	1.0	3.3	1.0	645.00..-D					85.22	680	81.36	680
R/L 006.0100-10	6	2.3	6.0	5.3	25	10	1.8	3.4	1.0	676.00..-D	40.47	160	40.47	160	47.82	660	46.42	660
R/L 006.0150-10	6	2.3	6.0	5.3	25	10	1.8	3.4	1.5	676.00..-D	40.47	164	40.47	164	47.82	664	44.46	664
R/L 006.0200-10	6	2.3	6.0	5.3	25	10	1.8	3.4	2.0	676.00..-D	40.47	168	40.47	168	47.82	668	46.42	668
R/L 006.0100-15	6	2.3	6.0	5.3	30	15	1.8	3.4	1.0	676.00..-D	48.16	161	48.16	161	55.23	661	53.82	661
R/L 006.0150-15	6	2.3	6.0	5.3	30	15	1.8	3.4	1.5	676.00..-D	48.16	165	48.16	165	55.23	665	53.82	665
R/L 006.0200-15	6	2.3	6.0	5.3	30	15	1.8	3.4	2.0	676.00..-D	48.16	169	48.16	169	55.23	669	53.82	669
R/L 006.0100-22	6	2.3	6.0	5.3	37	22	1.8	3.4	1.0	676.00..-D	52.87	061	52.87	061	61.37	561	60.87	561
R/L 006.0150-22	6	2.3	6.0	5.3	37	22	1.8	3.4	1.5	676.00..-D	52.87	062	52.87	062	61.37	562	60.87	562
R/L 006.0200-22	6	2.3	6.0	5.3	37	22	1.8	3.4	2.0	676.00..-D	52.87	063	52.87	063	61.37	563	60.87	563
R/L 006.0100-25	6	2.3	6.0	5.3	40	25	1.8	3.4	1.0	676.00..-D	60.87	162	60.87	162	69.26	662	67.41	662
R/L 006.0150-25	6	2.3	6.0	5.3	40	25	1.8	3.4	1.5	676.00..-D	60.87	166	60.87	166	69.26	666	67.41	666
R/L 006.0200-25	6	2.3	6.0	5.3	40	25	1.8	3.4	2.0	676.00..-D	60.87	260	60.87	260	69.26	760	67.41	760
R/L 006.0100-30	6	2.3	6.0	5.3	45	30	1.8	3.4	1.0	676.00..-D	68.84	163	68.84	163	77.11	663	75.11	663
R/L 006.0150-30	6	2.3	6.0	5.3	45	30	1.8	3.4	1.5	676.00..-D	68.84	167	68.84	167	77.11	667	75.11	667
R/L 006.0200-30	6	2.3	6.0	5.3	45	30	1.8	3.4	2.0	676.00..-D	68.84	261	68.84	261	77.11	761	75.11	761
R/L 006.0100-35	6	2.3	6.0	5.3	50	35	1.8	3.4	1.0	676.00..-D					85.22	682	81.36	682
R/L 006.0150-35	6	2.3	6.0	5.3	50	35	1.8	3.4	1.5	676.00..-D					85.22	684	81.36	684
R/L 006.0100-42	6	2.3	6.0	5.3	57	42	1.8	3.4	1.0	676.00..-D					94.05	685	91.35	685
R/L 007.0100-10	7	2.7	6.8	6.3	25	10	2.5	3.8	1.0	676.00..-D	40.89	070	40.89	070	48.24	570	47.18	570
R/L 007.0150-10	7	2.7	6.8	6.3	25	10	2.5	3.8	1.5	676.00..-D	40.89	075	40.89	075	48.24	575	47.18	575
R/L 007.0200-10	7	2.7	6.8	6.3	25	10	2.5	3.8	2.0	676.00..-D	40.89	170	40.89	170	48.24	670	47.18	670
R/L 007.0100-15	7	2.7	6.8	6.3	30	15	2.5	3.8	1.0	676.00..-D	48.60	071	48.60	071	55.78	571	54.39	571
R/L 007.0150-15	7	2.7	6.8	6.3	30	15	2.5	3.8	1.5	676.00..-D	48.60	076	48.60	076	55.78	576	54.39	576
R/L 007.0200-15	7	2.7	6.8	6.3	30	15	2.5	3.8	2.0	676.00..-D	48.60	171	48.60	171	55.78	671	52.02	671
R/L 007.0100-22	7	2.7	6.8	6.3	37	22	2.5	3.8	1.0	676.00..-D	55.59	072	55.59	072	62.77	572	62.13	572
R/L 007.0150-22	7	2.7	6.8	6.3	37	22	2.5	3.8	1.5	676.00..-D	55.59	077	55.59	077	62.77	577	62.13	577
R/L 007.0200-22	7	2.7	6.8	6.3	37	22	2.5	3.8	2.0	676.00..-D	55.59	172	55.59	172	62.77	672	62.13	672
R/L 007.0100-25	7	2.7	6.8	6.3	40	25	2.5	3.8	1.0	676.00..-D	59.98	073	59.98	073	69.99	573	68.12	573
R/L 007.0150-25	7	2.7	6.8	6.3	40	25	2.5	3.8	1.5	676.00..-D	59.98	078	59.98	078	69.99	578	68.12	578
R/L 007.0200-25	7	2.7	6.8	6.3	40	25	2.5	3.8	2.0	676.00..-D	59.98	173	59.98	173	69.99	673	67.13	673
R/L 007.0100-30	7	2.7	6.8	6.3	45	30	2.5	3.8	1.0	676.00..-D	69.99	074	69.99	074	77.17	574	76.38	574
R/L 007.0150-30	7	2.7	6.8	6.3	45	30	2.5	3.8	1.5	676.00..-D	69.99	079	69.99	079	77.17	579	73.94	579
R/L 007.0200-30	7	2.7	6.8	6.3	45	30	2.5	3.8	2.0	676.00..-D	70.41	174	62.59	174	77.17	674	71.68	674
R/L 007.0100-35	7	2.7	7.0	6.3	50	35	2.5	3.8	1.0	676.00..-D					86.07	688	83.66	688
R/L 007.0150-35	7	2.7	7.0	6.3	50	35	2.5	3.8	1.5	676.00..-D					86.07	690	83.66	690
R/L 007.0200-35	7	2.7	7.0	6.3	50	35	2.5	3.8	2.0	676.00..-D					86.07	692	83.66	692
R/L 007.0100-40	7	2.7	7.0	6.3	55	40	2.5	3.8	1.0	676.00..-D					95.48	700	92.77	700
R/L 007.0150-40	7	2.7	7.0	6.3	55	40	2.5	3.8	1.5	676.00..-D					95.48	702	92.77	702
R/L 007.0100-45	7	2.7	7.0	6.3	60	45	2.5	3.8	1.0	676.00..-D					103.60	712	100.77	712
R/L 007.0100-50	7	2.7	7.0	6.3	65	50	2.5	3.8	1.0	676.00..-D					111.01	714	107.73	714

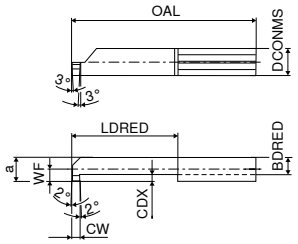
Steel	○	○	●	●
Stainless steel			●	●
Cast iron	○	○	○	○
Non ferrous metals	●	●	○	○
Heat resistant alloys			○	○
hardened materials				

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UltraMini – Inserts for Internal Grooving







TiAlN



TiAlN



Illustrations show right-hand versions

Designation	DCONMS $_{h6}$ mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	CW mm	Standard tool holder	Left-hand Y5 Article no. 73 003 ... £		Right-hand Y5 Article no. 73 002 ... £	
R/L 002.0050-5	4		2	1.8	19	5	0.4	1.2	0.5	645.00..-D	59.57	**820**	59.57	**820**
R/L 002.0050-10	4		2	1.8	24	10	0.4	1.2	0.5	645.00..-D	59.98	**821**	59.98	**821**
R/L 002.0050-15	4		2	1.8	29	15	0.4	1.2	0.5	645.00..-D	65.99	**822**	65.99	**822**
R/L 003.0070-5	4	0.7	3	2.7	19	5	0.6	1.9	0.7	645.00..-D	55.23	**830**	55.23	**830**
R/L 003.0070-10	4	0.7	3	2.7	24	10	0.6	1.9	0.7	645.00..-D	63.71	**831**	63.71	**831**
R/L 003.0070-16	4	0.7	3	2.7	30	16	0.6	1.9	0.7	645.00..-D	70.98	**832**	70.98	**832**

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

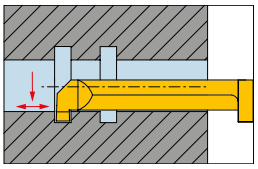
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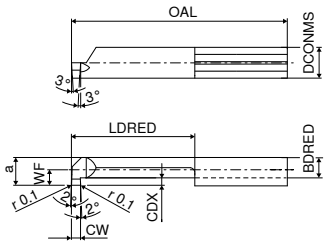
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UltraMini – Inserts for Internal Grooving

▲ with corner radius







TiAlN



TiAlN



Illustrations show right-hand versions

Left-hand

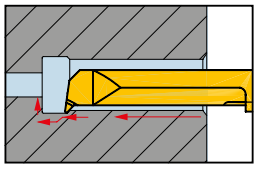
Right-hand

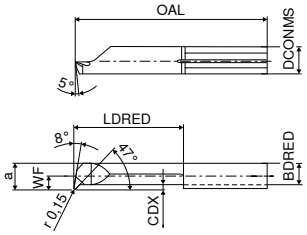
Designation	DCONMS h6	WF	DMIN	a	OAL	LDRED	CDX	BDRED	CW	Standard tool holder	Y5 Article no. 73 203 ...		Y5 Article no. 73 202 ...	
	mm	mm	mm	mm	mm	mm	mm	mm	mm		£		£	
R/L 004M0100-10	4	1.5	4.0	3.5	24	10	0.8	2.4	1.0	645.00..-D	50.93	800	50.93	800
R/L 004M0100-16	4	1.5	4.0	3.5	30	16	0.8	2.4	1.0	645.00..-D	58.14	802	58.14	802
R/L 004M0100-20	4	1.5	4.0	3.5	34	20	0.8	2.4	1.0	645.00..-D	64.04	804	64.04	804
R/L 005M0100-10	5	1.9	5.0	4.4	25	10	1.0	3.3	1.0	645.00..-D	48.07	806	48.07	806
R/L 005M0150-10	5	1.9	5.0	4.4	25	10	1.0	3.3	1.5	645.00..-D	48.07	816	48.07	816
R/L 005M0200-10	5	1.9	5.0	4.4	25	10	1.0	3.3	2.0	645.00..-D	48.07	826	48.07	826
R/L 005M0100-15	5	1.9	5.0	4.4	30	15	1.0	3.3	1.0	645.00..-D	55.10	808	55.10	808
R/L 005M0150-15	5	1.9	5.0	4.4	30	15	1.0	3.3	1.5	645.00..-D	55.10	818	55.10	818
R/L 005M0200-15	5	1.9	5.0	4.4	30	15	1.0	3.3	2.0	645.00..-D	55.10	828	55.10	828
R/L 005M0100-20	5	1.9	5.0	4.4	35	20	1.0	3.3	1.0	645.00..-D	61.57	810	61.57	810
R/L 005M0150-20	5	1.9	5.0	4.4	35	20	1.0	3.3	1.5	645.00..-D	61.57	820	61.57	820
R/L 005M0200-20	5	1.9	5.0	4.4	35	20	1.0	3.3	2.0	645.00..-D	61.57	830	61.57	830
R/L 005M0100-25	5	1.9	5.0	4.4	40	25	1.0	3.3	1.0	645.00..-D	66.88	812	66.88	812
R/L 005M0150-25	5	1.9	5.0	4.4	40	25	1.0	3.3	1.5	645.00..-D	66.88	822	66.88	822
R/L 005M0200-25	5	1.9	5.0	4.4	40	25	1.0	3.3	2.0	645.00..-D	66.88	832	66.88	832
R/L 005M0100-30	5	1.9	5.0	4.4	45	30	1.0	3.3	1.0	645.00..-D	74.12	814	74.12	814
R/L 005M0150-30	5	1.9	5.0	4.4	45	30	1.0	3.3	1.5	645.00..-D	74.12	824	74.12	824
R/L 005M0200-30	5	1.9	5.0	4.4	45	30	1.0	3.3	2.0	645.00..-D	74.12	834	74.12	834
R/L 006M0100-10	6	2.3	6.0	5.3	25	10	1.8	3.4	1.0	676.00..-D	48.07	836	48.07	836
R/L 006M0150-10	6	2.3	6.0	5.3	25	10	1.8	3.4	1.5	676.00..-D	48.07	846	48.07	846
R/L 006M0200-10	6	2.3	6.0	5.3	25	10	1.8	3.4	2.0	676.00..-D	48.07	856	48.07	856
R/L 006M0100-15	6	2.3	6.0	5.3	30	15	1.8	3.4	1.0	676.00..-D	55.10	838	55.10	838
R/L 006M0150-15	6	2.3	6.0	5.3	30	15	1.8	3.4	1.5	676.00..-D	55.10	848	55.10	848
R/L 006M0200-15	6	2.3	6.0	5.3	30	15	1.8	3.4	2.0	676.00..-D	55.10	858	55.10	858
R/L 006M0100-20	6	2.3	6.0	5.3	35	22	1.8	3.4	1.0	676.00..-D	61.57	840	61.57	840
R/L 006M0150-20	6	2.3	6.0	5.3	37	22	1.8	3.4	1.5	676.00..-D	61.57	850	61.57	850
R/L 006M0200-20	6	2.3	6.0	5.3	37	22	1.8	3.4	2.0	676.00..-D	61.57	860	61.57	860
R/L 006M0100-25	6	2.3	6.0	5.3	40	25	1.8	3.4	1.0	676.00..-D	66.88	842	66.88	842
R/L 006M0150-25	6	2.3	6.0	5.3	40	25	1.8	3.4	1.5	676.00..-D	66.88	852	66.88	852
R/L 006M0200-25	6	2.3	6.0	5.3	40	25	1.8	3.4	2.0	676.00..-D	66.88	862	66.88	862
R/L 006M0100-30	6	2.3	6.0	5.3	45	30	1.8	3.4	1.0	676.00..-D	74.12	844	74.12	844
R/L 006M0150-30	6	2.3	6.0	5.3	45	30	1.8	3.4	1.5	676.00..-D	74.12	854	74.12	854
R/L 006M0200-30	6	2.3	6.0	5.3	45	30	1.8	3.4	2.0	676.00..-D	74.12	864	74.12	864
R/L 007M0100-10	7	2.7	6.8	6.3	25	10	2.5	3.7	1.0	676.00..-D	48.07	866	48.07	866
R/L 007M0150-10	7	2.7	6.8	6.3	25	10	2.5	3.7	1.5	676.00..-D	48.07	876	48.07	876
R/L 007M0200-10	7	2.7	6.8	6.3	25	10	2.5	3.7	2.0	676.00..-D	48.07	886	48.07	886
R/L 007M0100-15	7	2.7	6.8	6.3	30	15	2.5	3.7	1.0	676.00..-D	55.10	868	55.10	868
R/L 007M0150-15	7	2.7	6.8	6.3	30	15	2.5	3.7	1.5	676.00..-D	55.10	878	55.10	878
R/L 007M0200-15	7	2.7	6.8	6.3	30	15	2.5	3.7	2.0	676.00..-D	55.10	888	55.10	888
R/L 007M0100-22	7	2.7	6.8	6.3	37	22	2.5	3.7	1.0	676.00..-D	61.57	870	61.57	870
R/L 007M0150-22	7	2.7	6.8	6.3	37	22	2.5	3.7	1.5	676.00..-D	61.57	880	61.57	880
R/L 007M0200-22	7	2.7	6.8	6.3	37	22	2.5	3.7	2.0	676.00..-D	61.57	890	61.57	890
R/L 007M0100-25	7	2.7	6.8	6.3	40	25	2.5	3.7	1.0	676.00..-D	66.88	872	66.88	872
R/L 007M0150-25	7	2.7	6.8	6.3	40	25	2.5	3.7	1.5	676.00..-D	66.88	882	66.88	882
R/L 007M0200-25	7	2.7	6.8	6.3	40	25	2.5	3.7	2.0	676.00..-D	66.88	892	66.88	892
R/L 007M0100-30	7	2.7	6.8	6.3	45	30	2.5	3.7	1.0	676.00..-D	74.68	874	74.68	874
R/L 007M0150-30	7	2.7	6.8	6.3	45	30	2.5	3.7	1.5	676.00..-D	74.68	884	74.68	884
R/L 007M0200-30	7	2.7	6.8	6.3	45	30	2.5	3.7	2.0	676.00..-D	74.68	894	74.68	894

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

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UltraMini – Inserts for internal undercuts













Illustrations show right-hand versions

Designation	DCONMS h6 mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	Standard tool holder	Left-hand Y5 Article no. 73 011 ... £		Right-hand Y5 Article no. 73 010 ... £		Left-hand Y5 Article no. 73 011 ... £		Right-hand Y5 Article no. 73 010 ... £	
R/L 047.2-10	4		2.0	1.7	24	10	0.4	1.2	645.00..-D					56.09	**221**	56.09	**221**
R/L 047.3-15	4	0.6	2.8	2.6	29	15	0.6	1.9	645.00..-D					58.38	**231**	58.38	**231**
R/L 047.4-10	4	1.5	4.0	3.5	24	10	0.6	2.8	645.00..-D					53.46	**241**	53.46	**241**
R/L 047.T4-20	4	1.5	4.0	3.5	34	20	0.6	2.8	645.00..-D					62.70	**242**	62.70	**242**
R/L 047.4-20	4	1.5	4.0	3.5	34	20	0.3	3.0	645.00..-D	60.29	**542**	59.43	**542**				
R/L 047.5-15	5	1.9	5.0	4.4	30	15	0.8	3.5	645.00..-D					60.17	**251**	60.17	**251**
R/L 047.T5-25	5	1.9	5.0	4.4	40	25	0.8	3.5	645.00..-D					63.66	**252**	63.66	**252**
R/L 047.5-25	5	1.9	5.0	4.4	40	25	0.5	3.8	645.00..-D	59.98	**552**	59.98	**552**				
R/L 047.T6-22	6	2.3	6.0	5.3	37	22	1.8	3.4	676.00..-D					61.62	**262**	61.62	**262**
R/L 047.T6-30	6	2.3	6.0	5.3	45	30	1.8	3.4	676.00..-D					82.04	**263**	65.11	**263**
R/L 047.6-30	6	2.3	6.0	5.3	45	30	0.5	4.5	676.00..-D	61.37	**562**	62.30	**562**				

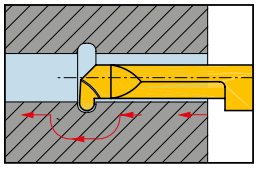
Steel	●	●	●	●
Stainless steel	●	●	●	●
Cast iron	○	○	●	●
Non ferrous metals	○	○	●	●
Heat resistant alloys	○	○	●	●
hardened materials				

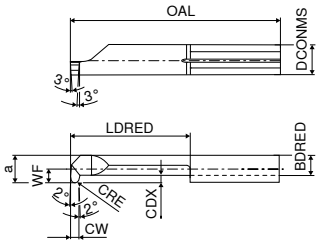
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UltraMini – Inserts for internal grooving and turning







TiN



TiN



Illustrations show right-hand versions

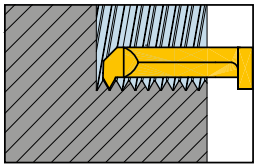
Designation	DCONMS h6 mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	CDX mm	BDRED mm	CW mm	CRE mm	Standard tool holder	Left-hand Y5 Article no. 73 019 ... £		Right-hand Y5 Article no. 73 018 ... £	
R/L 006-0.75-25	6	2.3	6.0	5.3	40	25	1.8	3.4	1.5	0.75	676.00..-D	63.28	**564**	63.28	**564**
R/L 006-0.50-25	6	2.3	6.0	5.3	40	25	1.8	3.4	1.0	0.50	676.00..-D	63.28	**562**	63.28	**562**
R/L 006-1.00-25	6	2.3	6.0	5.3	40	25	1.8	3.4	2.0	1.00	676.00..-D	63.28	**566**	62.30	**566**
R/L 005-1.00-20	5	1.9	5.0	4.4	35	20	1.0	3.3	2.0	1.00	645.00..-D	61.86	**556**	61.86	**556**
R/L 007-0.50-30	7	2.7	6.8	6.3	45	30	2.5	3.8	1.0	0.50	676.00..-D	65.26	**572**	62.22	**572**
R/L 005-0.75-20	5	1.9	5.0	4.4	35	20	1.0	3.3	1.5	0.75	645.00..-D	61.86	**554**	61.86	**554**
R/L 007-0.75-30	7	2.7	6.8	6.3	45	30	2.5	3.8	1.5	0.75	676.00..-D	65.26	**574**	65.26	**574**
R/L 005-0.50-20	5	1.9	5.0	4.4	35	20	1.0	3.3	1.0	0.50	645.00..-D	61.86	**552**	61.86	**552**
R/L 007-1.00-30	7	2.7	6.8	6.3	45	30	2.5	3.8	2.0	1.00	676.00..-D	65.26	**576**	65.26	**576**
R/L 004-0.50-16	4	1.5	4.0	3.5	30	16	0.8	2.4	1.0	0.50	645.00..-D	58.56	**541**	56.02	**541**

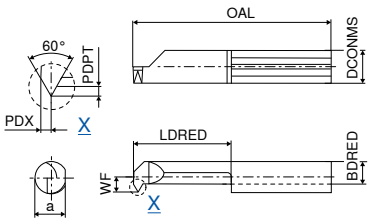
Steel	●	●
Stainless steel	●	●
Cast iron	○	○
Non ferrous metals	○	○
Heat resistant alloys	○	○
hardened materials		

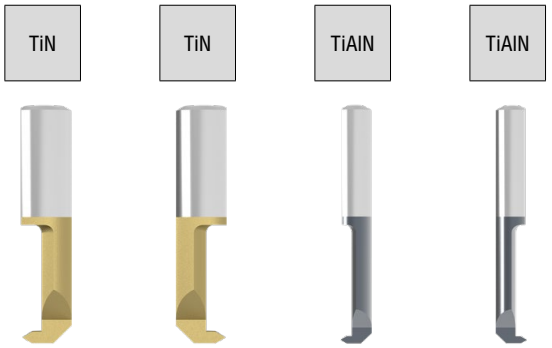
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UltraMini – Inserts for internal threading (Partial profile)









Left-hand | Right-hand | Left-hand | Right-hand

Illustrations show right-hand versions

Designation	DCONMS h6	TP	WF	DMIN	a	OAL	LDRED	BDRED	PDPT	PDX	Standard tool holder	Y5 Article no. 73 101 ...		Y5 Article no. 73 100 ...		Y5 Article no. 73 101 ...		Y5 Article no. 73 100 ...	
	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm		£		£		£		£	
R/L 003.0105-8	4	0.50	0.30	2.4	2.3	22	8	1.8	0.27	0.33	645.00..-D					56.69	**551**	56.69	**551**
R/L 004.0408-15	4	0.80	1.75	4.0	3.5	30	15	2.4	0.43	0.45	645.00..-D					59.10	**552**	59.10	**552**
R/L 005.0510-15	5	1.00	1.90	4.8	4.4	30	15	3.3	0.55	0.55	645.00..-D	53.91	**545**	52.26	**545**				
R/L 005.0510-20	5	1.00	1.90	4.8	4.4	35	20	3.3	0.55	0.55	645.00..-D	54.66	**544**	54.44	**544**				
R/L 006.0612-15	6	1.25	2.30	6.0	5.3	30	15	3.4	0.68	0.65	676.00..-D	52.85	**547**	52.26	**547**				
R/L 006.0612-22	6	1.25	2.30	6.0	5.3	37	22	3.4	0.68	0.65	676.00..-D	55.38	**546**	54.04	**546**				
R/L 006.0815-15	6	1.50	2.30	6.0	5.3	30	15	3.4	0.81	0.75	676.00..-D	53.91	**549**	52.93	**549**				
R/L 006.0815-22	6	1.50	2.30	6.0	5.3	37	22	3.4	0.81	0.75	676.00..-D	55.38	**548**	54.04	**548**				
R/L 007.0815-15	7	1.50	2.70	7.0	6.3	30	15	3.8	0.81	0.75	676.00..-D	53.59	**550**	54.04	**550**				

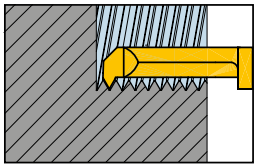
Steel	●	●	●	●
Stainless steel	●	●	●	●
Cast iron	○	○	●	●
Non ferrous metals	○	○	●	●
Heat resistant alloys	○	○	●	●
hardened materials				

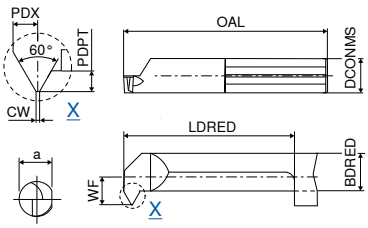
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UltraMini – Inserts for Internal thread turning (Full profile)







TiAlN



Left-hand

TiAlN



Right-hand

Illustrations show right-hand versions

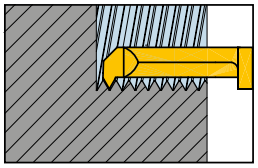
Designation	DCONMS h6 mm	TP mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	BDRED mm	PDPT mm	PDX mm	CW mm	Standard tool holder	Y5 Article no. 73 209 ... £		Y5 Article no. 73 208 ... £	
R/L 105.0408-15	5	0.80	1.9	4.8	4.4	30	15	3.3	0.43	0.50	0.10	645.00..-D	61.27	**799**	61.27	**799**
R/L 105.510-15	5	1.00	1.9	4.8	4.4	30	15	3.3	0.54	0.55	0.12	645.00..-D	56.62	**800**	56.62	**800**
R/L 106.612-15	6	1.25	2.3	6.0	5.3	30	15	3.4	0.67	0.65	0.15	676.00..-D	56.62	**802**	56.62	**802**
R/L 106.815-15	6	1.50	2.3	6.0	5.3	30	15	3.4	0.81	0.75	0.18	676.00..-D	56.62	**804**	56.62	**804**
R/L 106.815-15	7	1.50	2.7	7.0	6.3	30	15	3.8	0.81	0.75	0.18	676.00..-D	56.62	**806**	56.62	**806**

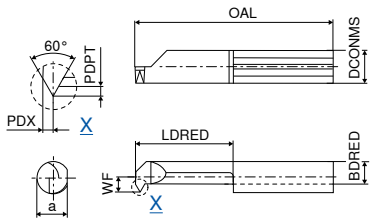
Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

→ v_c Page 60

UltraMini – Inserts for internal thread turning (Partial profile)









Left-hand | Right-hand | Left-hand | Right-hand

Illustrations show right-hand versions

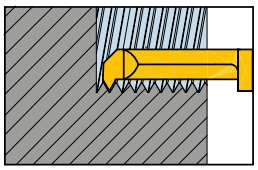
Designation	DCONMS h6	TP	WF	DMIN	a	OAL	LDRED	BDRED	PDPT	PDX	Standard tool holder	Y5 Article no. 73 103 ...		Y5 Article no. 73 102 ...		Y5 Article no. 73 103 ...		Y5 Article no. 73 102 ...	
	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm		£		£		£		£	
R/L 004.0105-10	4	0.50	1.0	3.2	3.0	24	10	2.3	0.27	0.44	645.00..-D					55.86	509	55.86	509
R/L 004.0205-15	4	0.50	1.5	4.0	3.5	30	15	2.4	0.27	0.35	645.00..-D	55.83	510	55.83	510				
R/L 005.0205-15	5	0.50	1.9	5.0	4.4	30	15	3.3	0.27	0.35	645.00..-D	53.91	539	53.91	539				
R/L 005.0205-20	5	0.50	1.9	5.0	4.4	35	20	3.3	0.27	0.35	645.00..-D	54.66	540	54.66	540				
R/L 005.0407-15	5	0.75	1.9	5.0	4.4	30	15	3.3	0.40	0.45	645.00..-D	53.91	541	53.91	541				
R/L 005.0407-20	5	0.75	1.9	5.0	4.4	35	20	3.3	0.40	0.45	645.00..-D	54.66	542	54.66	542				
R/L 006.0510-15	6	1.00	2.3	6.0	5.3	30	15	3.4	0.55	0.55	676.00..-D	53.91	543	53.91	543				
R/L 006.0510-22	6	1.00	2.3	6.0	5.3	37	22	3.4	0.55	0.55	676.00..-D	55.38	544	55.38	544				

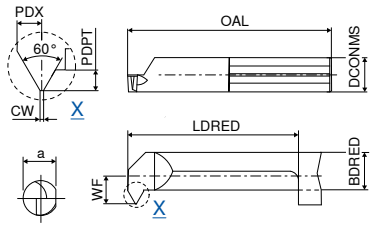
Steel	●	●	●	●
Stainless steel	●	●	●	●
Cast iron	○	○	●	●
Non ferrous metals	○	○	●	●
Heat resistant alloys	○	○	●	●
hardened materials				

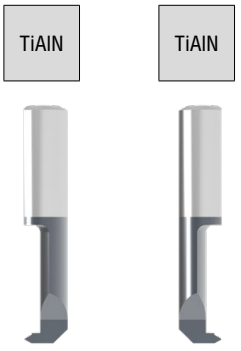
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UltraMini – Inserts for Internal thread turning (Full profile)









Left-hand | Right-hand

Illustrations show right-hand versions

Designation	DCONMS h6	TP	WF	DMIN	a	OAL	LDRED	BDRED	PDPT	PDX	CW	Standard tool holder	Y5 Article no. 73 207 ...		Y5 Article no. 73 206 ...	
	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm		£		£	
R/L 104.0205-15	5	0.50	1.5	4	3.5	30	15	2.4	0.27	0.35	0.06	645.00..-D	59.68	800	59.68	800
R/L 105.0205-15	5	0.50	1.9	5	4.4	30	15	3.3	0.27	0.35	0.06	645.00..-D	56.62	802	56.62	802
R/L 105.0407-15	5	0.75	1.9	5	4.4	30	15	3.3	0.40	0.45	0.09	645.00..-D	56.62	804	56.62	804
R/L 106.0510-15	6	1.00	2.3	6	5.3	30	15	3.4	0.54	0.55	0.12	676.00..-D	56.62	806	56.62	806

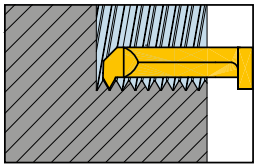
Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

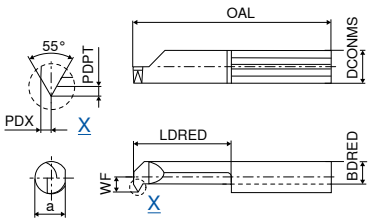
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UltraMini – Inserts for internal thread turning (Partial profile)







TiN



Left-hand

TiN



Right-hand

Illustrations show right-hand versions

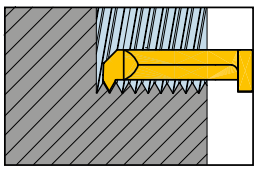
Designation	DCONMS h6 mm	TPI 1/"	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	BDRED mm	PDPT mm	PDX mm	Standard tool holder	Y5 Article no. 73 105 ... £		Y5 Article no. 73 104 ... £	
R/L 005.5548-15	5	48 - 24	1.9	4.8	4.4	30	15	3.3	0.40	0.45	645.00..-D	57.60	**552**	57.60	**552**
R/L 006.5548-15	6	48 - 24	2.3	6.0	5.3	30	15	3.4	0.40	0.45	676.00..-D	57.60	**562**	57.60	**562**
R/L 006.5524-15	6	24 - 16	2.3	6.0	5.3	30	15	3.4	0.81	0.75	676.00..-D	57.60	**563**	57.60	**563**
R/L 007.5524-15	7	24 - 16	2.7	7.0	6.3	30	15	3.8	0.81	0.75	676.00..-D	57.60	**572**	57.60	**572**
Steel													●		●
Stainless steel													●		●
Cast iron													○		○
Non ferrous metals													○		○
Heat resistant alloys													○		○
hardened materials															

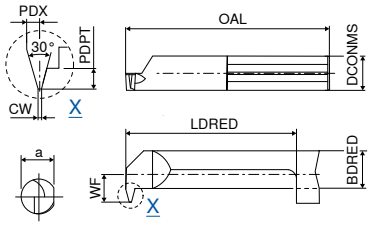
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UltraMini – Inserts for internal thread turning (Partial profile)

▲ Trapezoidal thread DIN 103







TiAlN



Left-hand

TiAlN



Right-hand

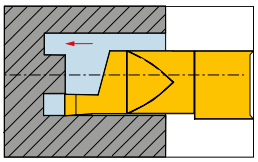
Illustrations show right-hand versions

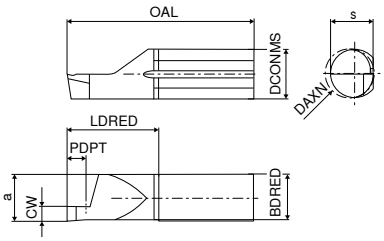
Designation	DCONMS h6 mm	TP mm	WF mm	DMIN mm	a mm	OAL mm	LDRED mm	BDRED mm	PDPT mm	PDX mm	CW mm	Standard tool holder	Y5 Article no. 73 211 ... £		Y5 Article no. 73 210 ... £	
R/L 007.1220-22	7	2	2.8	7	6.3	37	22	3.8	1.25	0.75	0.6	676.00..-D	76.64	**222**	76.64	**222**
R/L 007.1220-30	7	2	2.8	7	6.3	45	30	3.8	1.25	0.75	0.6	676.00..-D	92.61	**230**	92.61	**230**
R/L 007.1730-22	7	3	2.8	7	6.3	37	22	3.8	1.75	1.10	1.0	676.00..-D	76.64	**322**	76.64	**322**
R/L 007.1730-30	7	3	2.8	7	6.3	45	30	3.8	1.75	1.10	1.0	676.00..-D	92.61	**330**	92.61	**330**
Steel														●		●
Stainless steel														●		●
Cast iron														●		●
Non ferrous metals														●		●
Heat resistant alloys														●		●
hardened materials																

→ v_c Page 60

UltraMini – Inserts for axial grooving















Illustrations show right-hand versions

Designation	DCONMS h6	a	DAXN	s	OAL	LDRED	PDPT	BDRED	CW	Standard tool holder	Left-hand Y5 Article no. 73 051 ...		Right-hand Y5 Article no. 73 050 ...		Left-hand Y5 Article no. 73 053 ...		Right-hand Y5 Article no. 73 052 ...	
	mm	mm	mm	mm	mm	mm	mm	mm	mm		£		£		£		£	
R/L 010.1006-10	6	5.2	6	5.3	26	11	1.5	4.9	1.0	676.00..-D	59.85	**561**	58.14	**561**	59.57	**561**	59.57	**561**
R/L 010.1506-10	6	5.2	6	5.3	26	11	2.0	4.9	1.5	676.00..-D	59.85	**563**	58.14	**563**	59.57	**563**	59.57	**563**
R/L 010.1008-10	7	5.9	8	6.3	26	11	1.5	5.6	1.0	676.00..-D	59.98	**571**	59.43	**571**	60.99	**571**	60.99	**571**
R/L 010.1008-20	7	5.9	8	6.3	35	20	1.5	5.6	1.0	676.00..-D	65.26	**671**	63.55	**671**	65.15	**671**	65.15	**671**
R/L 010.1008-30	7	5.9	8	6.3	45	30	1.5	5.6	1.0	676.00..-D	68.84	**771**	66.97	**771**	67.39	**771**	67.39	**771**
R/L 010.1508-10	7	5.9	8	6.3	26	11	2.5	5.6	1.5	676.00..-D	59.98	**573**	57.60	**573**	60.99	**573**	60.99	**573**
R/L 010.1508-20	7	5.9	8	6.3	35	20	2.5	5.6	1.5	676.00..-D	65.26	**673**	61.37	**673**	65.15	**673**	65.15	**673**
R/L 010.1508-30	7	5.9	8	6.3	45	30	2.5	5.6	1.5	676.00..-D	68.84	**773**	66.97	**773**	67.39	**773**	67.39	**773**
R/L 010.2008-10	7	5.9	8	6.3	26	11	3.0	5.6	2.0	676.00..-D	59.98	**575**	57.60	**575**	60.99	**575**	60.99	**575**
R/L 010.2008-20	7	5.9	8	6.3	35	20	3.0	5.6	2.0	676.00..-D	65.26	**675**	61.37	**675**	65.15	**675**	65.15	**675**
R/L 010.2008-30	7	5.9	8	6.3	45	30	3.0	5.6	2.0	676.00..-D	68.84	**775**	66.97	**775**	67.39	**775**	67.39	**775**
R/L 010.2508-10	7	5.9	8	6.3	26	11	3.5	5.6	2.5	676.00..-D	59.98	**577**	59.43	**577**	60.99	**577**	60.99	**577**
R/L 010.2508-20	7	5.9	8	6.3	35	20	3.5	5.6	2.5	676.00..-D	65.26	**677**	63.55	**677**	65.15	**677**	65.15	**677**
R/L 010.2508-30	7	5.9	8	6.3	45	30	3.5	5.6	2.5	676.00..-D	68.84	**777**	66.97	**777**	67.39	**777**	67.39	**777**
R/L 010.3008-10	7	5.9	8	6.3	26	11	3.5	5.6	3.0	676.00..-D	59.98	**579**	59.43	**579**	60.99	**579**	60.99	**579**
R/L 010.3008-20	7	5.9	8	6.3	35	20	3.5	5.6	3.0	676.00..-D	65.26	**679**	61.37	**679**	65.15	**679**	65.15	**679**
R/L 010.3008-30	7	5.9	8	6.3	45	30	3.5	5.6	3.0	676.00..-D	68.84	**779**	66.97	**779**	67.39	**779**	67.39	**779**

Steel	●	●	●	●
Stainless steel	●	●	●	●
Cast iron	○	○	●	●
Non ferrous metals	○	○	●	●
Heat resistant alloys	○	○	●	●
hardened materials				

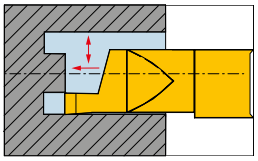
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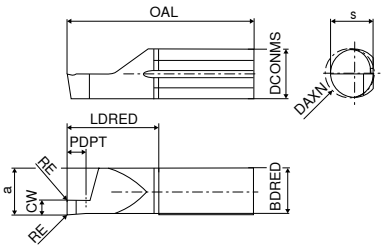
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UltraMini – Inserts for axial grooving

▲ with corner radius







TiAlN



TiAlN



Illustrations show right-hand versions

Designation	DCONMS h6	a	DAXN	s	OAL	LDRED	PDPT	BDRED	CW	RE	Standard tool holder	Left-hand Y5 Article no. 73 253 ... £		Right-hand Y5 Article no. 73 252 ... £	
	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm					
R/L 510M1008-10	5	4.3	5	6.3	26	11	2	4.0	1.0	0.05	645.00..-D	72.68	**510**	72.68	**510**
R/L 510M1008-20	5	4.3	5	6.3	35	20	2	4.0	1.0	0.05	645.00..-D	76.75	**610**	76.75	**610**
R/L 510M1508-10	5	4.3	5	6.3	26	11	3	4.0	1.5	0.05	645.00..-D	72.68	**515**	72.68	**515**
R/L 510M1508-20	5	4.3	5	6.3	35	20	3	4.0	1.5	0.05	645.00..-D	76.75	**615**	76.75	**615**
R/L 510M2008-10	5	4.3	5	6.3	26	11	4	4.0	2.0	0.05	645.00..-D	72.68	**520**	72.68	**520**
R/L 510M2008-20	5	4.3	5	6.3	35	20	4	4.0	2.0	0.05	645.00..-D	76.75	**620**	76.75	**620**
R/L 010M1008-10	7	5.9	8	6.3	26	11	2	5.6	1.0	0.10	676.00..-D	67.26	**800**	67.26	**800**
R/L 010M1008-20	7	5.9	8	6.3	35	20	2	5.6	1.0	0.10	676.00..-D	71.05	**810**	71.05	**810**
R/L 010M1008-30	7	5.9	8	6.3	45	30	2	5.6	1.0	0.10	676.00..-D	74.29	**820**	74.29	**820**
R/L 010M1508-10	7	5.9	8	6.3	26	11	3	5.6	1.5	0.10	676.00..-D	67.26	**802**	67.26	**802**
R/L 010M1508-20	7	5.9	8	6.3	35	20	3	5.6	1.5	0.10	676.00..-D	71.05	**812**	71.05	**812**
R/L 010M1508-30	7	5.9	8	6.3	45	30	3	5.6	1.5	0.10	676.00..-D	74.29	**822**	74.29	**822**
R/L 010M2008-10	7	5.9	8	6.3	26	11	4	5.6	2.0	0.10	676.00..-D	67.26	**804**	67.26	**804**
R/L 010M2008-20	7	5.9	8	6.3	35	20	4	5.6	2.0	0.10	676.00..-D	71.05	**814**	71.05	**814**
R/L 010M2008-30	7	5.9	8	6.3	45	30	4	5.6	2.0	0.10	676.00..-D	74.29	**824**	74.29	**824**
R/L 010M2508-10	7	5.9	8	6.3	26	11	5	5.6	2.5	0.10	676.00..-D	67.26	**806**	67.26	**806**
R/L 010M2508-20	7	5.9	8	6.3	35	20	5	5.6	2.5	0.10	676.00..-D	71.05	**816**	71.05	**816**
R/L 010M2508-30	7	5.9	8	6.3	45	30	5	5.6	2.5	0.10	676.00..-D	74.29	**826**	74.29	**826**
R/L 010M3008-10	7	5.9	8	6.3	26	11	6	5.6	3.0	0.10	676.00..-D	67.26	**808**	67.26	**808**
R/L 010M3008-20	7	5.9	8	6.3	35	20	6	5.6	3.0	0.10	676.00..-D	71.05	**818**	71.05	**818**
R/L 010M3008-30	7	5.9	8	6.3	45	30	6	5.6	3.0	0.10	676.00..-D	74.29	**828**	74.29	**828**

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

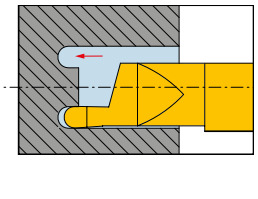
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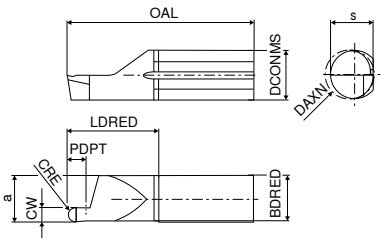
UltraMini – Inserts for axial grooving (Full radius)



TiAlN

TiAlN









Illustrations show right-hand versions

Designation	DCONMS h6 mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	BDRED mm	CW mm	CRE mm	Standard tool holder	Left-hand Y5 Article no. 73 059 ... £		Right-hand Y5 Article no. 73 058 ... £	
R/L 610.1005-10	6	5.2	6	5.3	26	11	2	4.9	1.0	0.50	676.00..-D	73.98	**071**	73.98	**071**
R/L 610.1005-20	6	5.2	6	5.3	35	20	2	4.9	1.0	0.50	676.00..-D	78.32	**171**	78.32	**171**
R/L 610.1608-10	6	5.2	6	5.3	26	11	3	4.9	1.6	0.80	676.00..-D	73.98	**073**	73.98	**073**
R/L 610.1608-20	6	5.2	6	5.3	35	20	3	4.9	1.6	0.80	676.00..-D	78.32	**173**	78.32	**173**
R/L 610.2010-10	6	5.2	6	5.3	26	11	4	4.9	2.0	1.00	676.00..-D	73.98	**075**	73.98	**075**
R/L 610.2010-20	6	5.2	6	5.3	35	20	4	4.9	2.0	1.00	676.00..-D	78.32	**175**	78.32	**175**
R/L 610.2512-10	6	5.2	6	5.3	26	11	5	4.9	2.5	1.25	676.00..-D	73.98	**077**	73.98	**077**
R/L 610.2512-20	6	5.2	6	5.3	35	20	5	4.9	2.5	1.25	676.00..-D	78.32	**177**	78.32	**177**
R/L 610.3015-10	6	5.2	6	5.3	26	11	6	4.9	3.0	1.50	676.00..-D	73.98	**079**	73.98	**079**
R/L 610.3015-20	6	5.2	6	5.3	35	20	6	4.9	3.0	1.50	676.00..-D	78.32	**179**	78.32	**179**
R/L 010.1005-10	7	5.9	8	6.3	26	11	2	5.6	1.0	0.50	676.00..-D	70.98	**571**	70.98	**571**
R/L 010.1005-20	7	5.9	8	6.3	35	20	2	5.6	1.0	0.50	676.00..-D	75.11	**671**	75.11	**671**
R/L 010.1608-10	7	5.9	8	6.3	26	11	3	5.6	1.6	0.80	676.00..-D	70.98	**573**	70.98	**573**
R/L 010.1608-20	7	5.9	8	6.3	35	20	3	5.6	1.6	0.80	676.00..-D	75.11	**673**	75.11	**673**
R/L 010.2010-10	7	5.9	8	6.3	26	11	4	5.6	2.0	1.00	676.00..-D	70.98	**575**	70.98	**575**
R/L 010.2010-20	7	5.9	8	6.3	35	20	4	5.6	2.0	1.00	676.00..-D	75.11	**675**	75.11	**675**
R/L 010.2512-10	7	5.9	8	6.3	26	11	5	5.6	2.5	1.25	676.00..-D	70.98	**577**	70.98	**577**
R/L 010.2512-20	7	5.9	8	6.3	35	20	5	5.6	2.5	1.25	676.00..-D	75.11	**677**	75.11	**677**
R/L 010.3015-10	7	5.9	8	6.3	26	11	6	5.6	3.0	1.50	676.00..-D	70.98	**579**	70.98	**579**
R/L 010.3015-20	7	5.9	8	6.3	35	20	6	5.6	3.0	1.50	676.00..-D	75.11	**679**	75.11	**679**

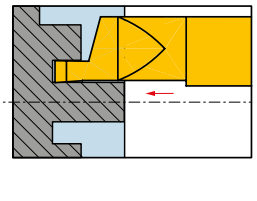
Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

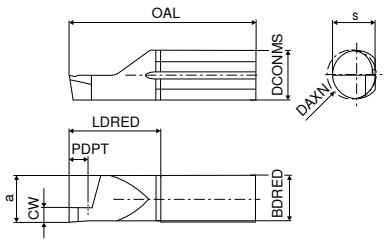
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UltraMini – Inserts for axial grooving over a spigot







TiAlN



TiAlN



Illustrations show right-hand versions

Designation	DCONMS h6 mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	BDRED mm	CW mm	Standard tool holder	Left-hand Y5 Article no. 73 061 ... £		Right-hand Y5 Article no. 73 060 ... £	
R/L 620.1006-20	6	5.2	6	5.3	35	20	2	4.9	1.0	676.00..-D	75.11	**561**	75.11	**561**
R/L 620.1506-20	6	5.2	6	5.3	35	20	3	4.9	1.5	676.00..-D	75.11	**563**	75.11	**563**
R/L 620.2006-20	6	5.2	6	5.3	35	20	4	4.9	2.0	676.00..-D	75.11	**565**	75.11	**565**
R/L 620.2506-20	6	5.2	6	5.3	35	20	5	4.9	2.5	676.00..-D	75.11	**567**	75.11	**567**
R/L 620.3006-20	6	5.2	6	5.3	35	20	6	4.9	3.0	676.00..-D	75.11	**569**	75.11	**569**

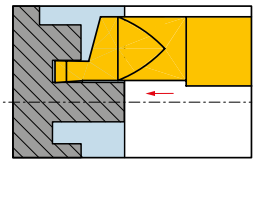
Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

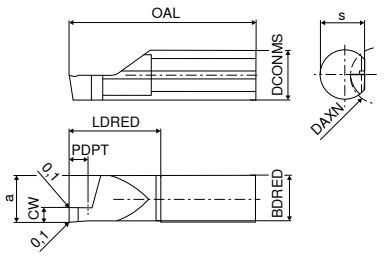
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UltraMini – Inserts for axial grooving over a spigot

▲ with corner radius







TiAlN



TiAlN



Illustrations show right-hand versions

Designation	DCONMS h6 mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	BDRED mm	CW mm	Standard tool holder	Left-hand Y5 Article no. 73 261 ... £		Right-hand Y5 Article no. 73 260 ... £	
R/L 620M1006-20	6	5.2	6	5.3	35	20	2	4.9	1.0	676.00..-D	71.83	**800**	71.83	**800**
R/L 620M1506-20	6	5.2	6	5.3	35	20	3	4.9	1.5	676.00..-D	71.83	**802**	71.83	**802**
R/L 620M2006-20	6	5.2	6	5.3	35	20	4	4.9	2.0	676.00..-D	71.83	**804**	71.83	**804**
R/L 620M2506-20	6	5.2	6	5.3	35	20	5	4.9	2.5	676.00..-D	71.83	**806**	71.83	**806**
R/L 620M3006-20	6	5.2	6	5.3	35	20	6	4.9	3.0	676.00..-D	71.83	**808**	71.83	**808**

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

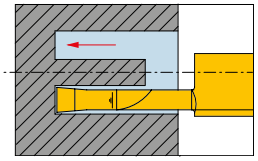
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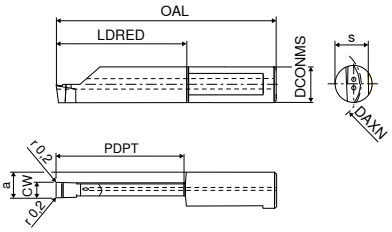
UltraMini – Inserts for axial grooving

- up to 100 bar
- dual cooling channel



TiAlN TiAlN









Illustrations show right-hand versions

Designation	DCONMS h6 mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	CW mm	Standard tool holder	Left-hand Y5 Article no. 73 263 ... £		Right-hand Y5 Article no. 73 262 ... £	
R/L 012.0200-10	8	5.00	12	7.3	30	10	10	2.0	687.00..-D	66.46	**700**	66.46	**700**
R/L 012.0200-15	8	5.00	12	7.3	35	15	15	2.0	687.00..-D	67.75	**702**	67.75	**702**
R/L 012.0250-10	8	5.25	12	7.3	30	10	10	2.5	687.00..-D	66.46	**704**	66.46	**704**
R/L 012.0250-20	8	5.25	12	7.3	40	20	20	2.5	687.00..-D	68.96	**706**	68.96	**706**
R/L 016.0300-10	8	5.50	16	7.3	30	10	10	3.0	687.00..-D	94.23	**800**	94.23	**800**
R/L 016.0300-20	8	5.50	16	7.3	40	20	20	3.0	687.00..-D	96.73	**802**	96.73	**802**
R/L 020.0300-25	8	5.50	20	7.3	45	25	25	3.0	687.00..-D	98.05	**804**	98.05	**804**
R/L 020.0300-30	8	5.50	20	7.3	50	30	30	3.0	687.00..-D	98.05	**806**	98.05	**806**
R/L 020.0300-35	8	5.50	20	7.3	55	35	35	3.0	687.00..-D	100.32	**808**	100.32	**808**
R/L 020.0300-40	8	5.50	20	7.3	60	40	40	3.0	687.00..-D	100.32	**810**	100.32	**810**
R/L 016.0400-10	8	6.00	16	7.3	30	10	10	4.0	687.00..-D	94.23	**812**	94.23	**812**
R/L 016.0400-20	8	6.00	16	7.3	40	20	20	4.0	687.00..-D	96.73	**814**	96.73	**814**
R/L 020.0400-25	8	6.00	20	7.3	45	25	25	4.0	687.00..-D	98.05	**816**	98.05	**816**
R/L 020.0400-30	8	6.00	20	7.3	50	30	30	4.0	687.00..-D	98.05	**818**	98.05	**818**
R/L 020.0400-35	8	6.00	20	7.3	55	35	35	4.0	687.00..-D	100.32	**820**	100.32	**820**
R/L 020.0400-40	8	6.00	20	7.3	60	40	40	4.0	687.00..-D	100.32	**822**	100.32	**822**
R/L 020.0500.20	8	6.50	20	7.3	40	20	20	5.0	687.00..-D	94.23	**824**	94.23	**824**
R/L 020.0500.25	8	6.50	20	7.3	45	25	25	5.0	687.00..-D	95.38	**826**	95.38	**826**
R/L 020.0500.30	8	6.50	20	7.3	50	30	30	5.0	687.00..-D	95.38	**828**	95.38	**828**
R/L 020.0500.35	8	6.50	20	7.3	55	35	35	5.0	687.00..-D	98.05	**830**	98.05	**830**
R/L 020.0500.40	8	6.50	20	7.3	60	40	40	5.0	687.00..-D	95.34	**832**	95.34	**832**

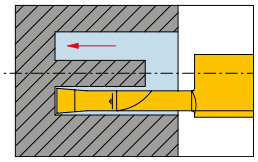
Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

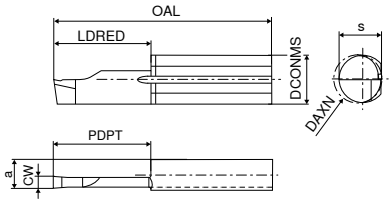
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UltraMini – Inserts for axial grooving







TiN | TiN | TiAlN | TiAlN



Illustrations show right-hand versions

Designation	DCONMS h6 mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	CW mm	Standard tool holder	Left-hand Y5 Article no. 73 055 ... £		Right-hand Y5 Article no. 73 054 ... £		Left-hand Y5 Article no. 73 057 ... £		Right-hand Y5 Article no. 73 056 ... £	
R/L 015.2515-20	7	5.9	15	6.3	35	20	20	2.5	676.00..-D	82.08	572	76.96	572	81.80	572	81.80	572
R/L 015.3015-20	7	5.9	15	6.3	35	20	20	3.0	676.00..-D	76.96	574	76.96	574	81.80	574	81.80	574
R/L 015.3015-30	7	5.9	15	6.3	45	30	30	3.0	676.00..-D	90.36	674	90.36	674	90.20	674	90.20	674

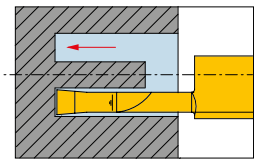
Steel	●	●	●	●
Stainless steel	●	●	●	●
Cast iron	○	○	●	●
Non ferrous metals	○	○	●	●
Heat resistant alloys	○	○	●	●
hardened materials				

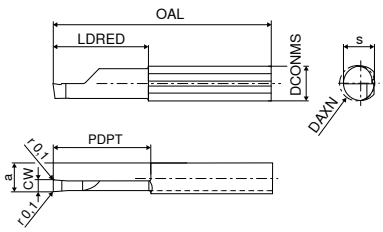
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UltraMini – Inserts for axial grooving

▲ with corner radius







TiAlN | TiAlN



Illustrations show right-hand versions

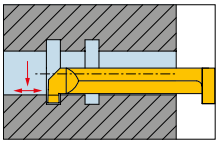
Designation	DCONMS h6 mm	a mm	DAXN mm	s mm	OAL mm	LDRED mm	PDPT mm	CW mm	Standard tool holder	Left-hand Y5 Article no. 73 257 ... £		Right-hand Y5 Article no. 73 256 ... £	
R/L 015M2515-20	7	5.9	8	6.3	35	20	20	2.5	676.00..-D	78.67	800	78.67	800
R/L 015M3015-20	7	5.9	8	6.3	35	20	20	3.0	676.00..-D	78.67	802	78.67	802
R/L 015M3015-30	7	5.9	8	6.3	45	30	30	3.0	676.00..-D	86.07	804	86.07	804

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

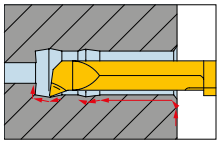
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Set 1: Internal turning, grooving and chamfering, right hand

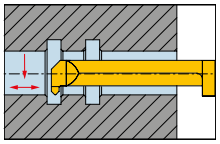
- extensive assortment of right-hand tools
- K10F – TiN



Grooving (E)



Profile turn (A)



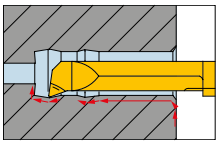
Chamfers (F)



Tool	Designation	Article No.	Bore Ø mm	Boring depth mm	Grooving depth mm	Groove width mm	Piece	fig.	Y5 Article no. 73 085 ... £	
Inserts	**R 004.0100-16**	**73 002 541**	4	16	0,8	1,0	1	E		
Inserts	**R 005.0150-20**	**73 002 552**	5	20	1,0	1,5	1	E		
Inserts	**R 005.0200-20**	**73 002 553**	5	20	1,0	2,0	1	E		
Inserts	**R 006.0150-22**	**73 002 562**	6	22	1,8	1,5	1	E		
Inserts	**R 006.0200-22**	**73 002 563**	6	22	1,8	2,0	1	E		
Inserts	**R 050.3-16**	**73 004 530**	3	16			1	A	953.18	999
Inserts	**R 050.4-16**	**73 004 540**	4	16			1	A		
Inserts	**R 050.5-20**	**73 004 550**	5	20			1	A		
Inserts	**R 050.6-22**	**73 004 560**	6	22			1	A		
Inserts	**R 060.5-20**	**73 006 550**	5	20			1	F		
Tool holder	**645.0016-D**	**73 080 164**					1			
Tool holder	**676.0016-D**	**73 080 166**					1			
Tightening Key	**110.645**	**70 950 175**					1			

Set 3: Internal Turning

- extensive assortment of right-hand tools
- K10F – TiN





Tool	Designation	Article No.	Bore Ø mm	Boring depth mm	Piece	Y5 Article no. 73 085 ... £	
Inserts	R 050.3-16	73 004 530	3	16	1		
Inserts	R 050.4-16	73 004 540	4	16	1		
Inserts	R 050.5-20	73 004 550	5	20	1	599.07	994
Inserts	R 050.6-22	73 004 560	6	22	1		
Tool holder	645.0016-D	73 080 164			1		
Tool holder	676.0016-D	73 080 166			1		
Tightening Key	110.645	70 950 175			1		

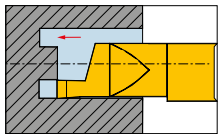
Set 4: Holder



Tool	Designation	Article No.	for cutting insert Ø mm	Piece	Y5 Article no. 73 085 ... £	
Tool holder	**645.0016-D**	**73 080 164**	3 / 4 / 5	1		
Tool holder	**676.0016-D**	**73 080 166**	6 / 7	1	373.50	990
Tightening Key	**110.645**	**70 950 175**		1		

Set 6: Axial Grooving

- extensive assortment of right-hand tools
- K10F – TiN



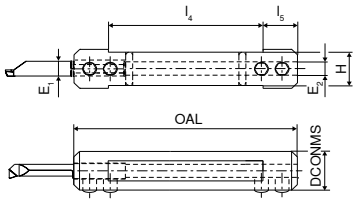


Tool	Designation	Article No.	Bore Ø mm	Boring depth mm	Grooving depth mm	Groove width mm	Piece	Y5 Article no. 73 085 ... £	
Inserts	**R 010.1008-10**	**73 050 571**	8	10	1,5	1,0	1		
Inserts	**R 010.1508-10**	**73 050 573**	8	10	2,5	1,5	1		
Inserts	**R 010.2008-10**	**73 050 575**	8	10	3,0	2,0	1	483.64	**996**
Inserts	**R 010.2508-20**	**73 050 677**	8	20	3,5	2,5	1		
Inserts	**R 010.3008-20**	**73 050 679**	8	20	3,5	3,0	1		
Tool holder	**676.0016-D**	**73 080 166**					1		
Tightening Key	**110.645**	**70 950 175**					1		

UltraMini – Standard tool holder for cutting inserts

- ▲ double ended
- ▲ Machining diameter from Ø 0.2 mm

Scope of supply:
Tool holder with allen key





Designation	Ø E_1 mm	Ø E_2 mm	DCONMS mm	OAL mm	l_4 mm	l_5 mm	H mm	Y5 Article no. 73 080 ... £	
645.0012-D	4	5	12.00	75	55	10	10.3	172.99	**163**
645.0016-D	4	5	16.00	75	55	10	14.0	181.70	**164**
645.001905-D	4	5	19.05	90	70	10	17.2	151.38	**170**
645.0020-D	4	5	20.00	90	70	10	18.0	195.67	**165**
645.0022-D	4	5	22.00	90	70	10	20.0	157.87	**171**
645.00254-D	4	5	25.40	95	75	10	23.4	167.60	**172**
676.0016-D	6	7	16.00	75	55	10	14.0	181.70	**166**
676.001905-D	6	7	19.05	90	70	10	17.2	151.38	**173**
676.0020-D	6	7	20.00	90	70	10	18.0	195.67	**167**
676.0022-D	6	7	22.00	90	70	10	20.0	157.87	**174**
676.00254-D	6	7	25.40	95	75	10	23.4	167.60	**175**
687.0016-D	7	8	16.00	75	55	10	14.0	210.72	**168**
687.0020-D	7	8	20.00	90	70	10	18.0	225.53	**169**

Spare parts


Key I


Clamping screw

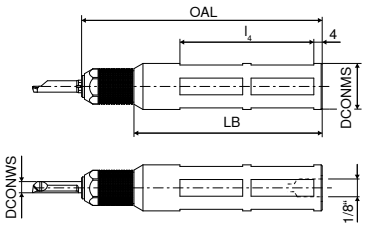
for Article no.		2A/28 Article no. 70 950 ... £			Y5 Article no. 73 082 ... £	
73 080 163	SW2,5	2.23	**175**	M5x4	6.99	**013**
73 080 164	SW2,5	2.23	**175**	M5x6	5.74	**001**
73 080 170	SW2,5	2.23	**175**	M5x6	5.74	**001**
73 080 165	SW2,5	2.23	**175**	M5x8	6.96	**008**
73 080 171	SW2,5	2.23	**175**	M5x8	6.96	**008**
73 080 172	SW2,5	2.23	**175**	M5x8	6.96	**008**
73 080 166	SW2,5	2.23	**175**	M5x6	5.74	**001**
73 080 173	SW2,5	2.23	**175**	M5x6	5.74	**001**
73 080 167	SW2,5	2.23	**175**	M5x8	6.96	**008**
73 080 174	SW2,5	2.23	**175**	M5x8	6.96	**008**
73 080 175	SW2,5	2.23	**175**	M5x8	6.96	**008**
73 080 168	SW2,5	2.23	**175**	M6x6	8.17	**014**
73 080 169	SW2,5	2.23	**175**	M6x6	8.17	**014**

UltraMini – Quick change tool holder for cutting inserts

Scope of supply:

Tool holder, lock nut and clamping wedge







Designation	DCONWS mm	DCONMS g6 mm	OAL mm	LB mm	l_4 mm	Y5 Article no. 73 089 ... £	
UM600H.0012.4	4	12.00	115	90	64	326.55	124
UM600H.0016.4	4	16.00	115	90	64	296.27	164
UM600H.001905.4	4	19.05	115	90	64	317.90	194
UM600H.0020.4	4	20.00	115	90	64	313.58	204
UM600H.0022.4	4	22.00	115	90	64	318.98	224
UM600H.0025.4	4	25.00	115	90	64	325.47	254
UM600H.00254.4	4	25.40	115	90	64	331.96	264
UM600H.0028.4	4	28.00	115	90	64	331.96	284
UM600H.0012.5	5	12.00	115	90	64	326.55	125
UM600H.0016.5	5	16.00	115	90	64	296.27	165
UM600H.001905.5	5	19.05	115	90	64	317.90	195
UM600H.0020.5	5	20.00	115	90	64	313.58	205
UM600H.0022.5	5	22.00	115	90	64	318.98	225
UM600H.0025.5	5	25.00	115	90	64	325.47	255
UM600H.00254.5	5	25.40	115	90	64	331.96	265
UM600H.0028.5	5	28.00	115	90	64	331.96	285
UM600H.0012.6	6	12.00	115	90	64	326.55	126
UM600H.0016.6	6	16.00	115	90	64	296.27	166
UM600H.001905.6	6	19.05	115	90	64	317.90	196
UM600H.0020.6	6	20.00	115	90	64	313.58	206
UM600H.0022.6	6	22.00	115	90	64	318.98	226
UM600H.0025.6	6	25.00	115	90	64	325.47	256
UM600H.00254.6	6	25.40	115	90	64	331.96	266
UM600H.0028.6	6	28.00	115	90	64	331.96	286
UM600H.0012.7	7	12.00	115	90	64	326.55	127
UM600H.0016.7	7	16.00	115	90	64	296.27	167
UM600H.001905.7	7	19.05	115	90	64	317.90	197
UM600H.0020.7	7	20.00	115	90	64	313.58	207
UM600H.0022.7	7	22.00	115	90	64	318.98	227
UM600H.0025.7	7	25.00	115	90	64	325.47	257
UM600H.00254.7	7	25.40	115	90	64	331.96	267
UM600H.0028.7	7	28.00	115	90	64	331.96	287

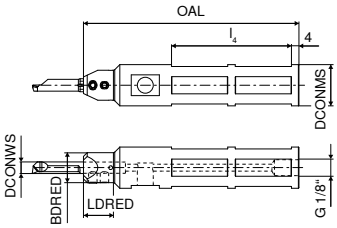
Avoid pulling cuts. Ensure a suitable clamping force is used when using thro' coolant supply. Can be tightened using a key.

Spare parts DCONWS		Y5  Lock nut UM600H Article no. 73 950 ... £		Y5  Clamping wedge UM600H Article no. 73 950 ... £	
4	M4	73.53	104	47.58	111
5	M5	73.53	105	47.58	111
6	M6	73.53	106	47.58	111
7	M7	73.53	107	47.58	111

UltraMini – Toolholder for inserts

▲ Tool holder suitable for high coolant pressures







Designation	DCONWS mm	BDRED mm	DCONMS g6 mm	OAL mm	LDRED mm	l_4 mm	Y5 Article no. 73 088 ... £	
UMST.0016.4	4	16	16.00	115	24	42	349.26	**164**
UMST.001905.4	4	16	19.05	115	24	42	378.45	**194**
UMST.0020.4	4	16	20.00	115	24	42	356.83	**204**
UMST.0022.4	4	16	22.00	115	24	42	367.64	**224**
UMST.00254.4	4	16	25.40	115	24	42	378.45	**264**
UMST.0028.4	4	16	28.00	115	24	42	378.45	**284**
UMST.0016.5	5	16	16.00	115	24	42	349.26	**165**
UMST.001905.5	5	16	19.05	115	24	42	378.45	**195**
UMST.0020.5	5	16	20.00	115	24	42	356.83	**205**
UMST.0022.5	5	16	22.00	115	24	42	367.64	**225**
UMST.00254.5	5	16	25.40	115	24	42	378.45	**265**
UMST.0028.5	5	16	28.00	115	24	42	378.45	**285**
UMST.0016.6	6	16	16.00	115	24	42	349.26	**166**
UMST.001905.6	6	16	19.05	115	24	42	378.45	**196**
UMST.0020.6	6	16	20.00	115	24	42	356.83	**206**
UMST.0022.6	6	16	22.00	115	24	42	367.64	**226**
UMST.00254.6	6	16	25.40	115	24	42	378.45	**266**
UMST.0028.6	6	16	28.00	115	24	42	378.45	**286**
UMST.0016.7	7	16	16.00	115	24	42	349.26	**167**
UMST.001905.7	7	16	19.05	115	24	42	378.45	**197**
UMST.0020.7	7	16	20.00	115	24	42	356.83	**207**
UMST.0022.7	7	16	22.00	115	24	42	367.64	**227**
UMST.00254.7	7	16	25.40	115	24	42	378.45	**267**
UMST.0028.7	7	16	28.00	115	24	42	378.45	**287**
UMST.0016.8	8	16	16.00	115	24	42	349.26	**168**
UMST.001905.8	8	16	19.05	115	24	42	378.45	**198**
UMST.0020.8	8	16	20.00	115	24	42	356.83	**208**
UMST.0022.8	8	16	22.00	115	24	42	367.64	**228**
UMST.00254.8	8	16	25.40	115	24	42	378.45	**268**
UMST.0028.8	8	16	28.00	115	24	42	378.45	**288**

12

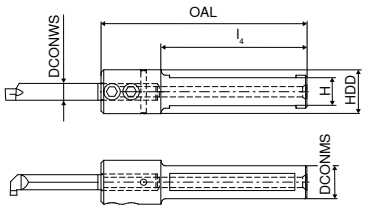
up to 150 bar

Spare parts DCONWS		Y7 Key D Article no. 80 950 ... £		Y5 Clamping screw Article no. 73 950 ... £	
4	T10	9.09	**104**	M5x0,5x6T10	10.81 **050**
5	T10	9.09	**104**	M5x0,5x6T10	10.81 **050**
6	T10	9.09	**104**	M5x0,5x6T10	10.81 **050**
7	T10	9.09	**104**	M5x0,5x6T10	10.81 **050**
8	T10	9.09	**104**	M5x0,5x6T10	10.81 **050**

UltraMini – Toolholder for inserts

▲ single ended

Scope of supply:
Tool holder with allen key





Designation	DCONWS mm	HDD mm	DCONMS mm	OAL mm	l_4 mm	H mm	Y5 Article no. 73 081 ... £	
640.0012-D	4	16	12	75	53	10.2	178.41	**264**
650.0012-D	5	16	12	75	53	10.2	178.41	**265**
660.0012-D	6	16	12	75	53	10.2	255.12	**266**
670.0012-D	7	16	12	75	53	10.2	255.12	**267**
680.0012-D	8	16	12	75	53	10.2	255.12	**268**



2A/28
Key I

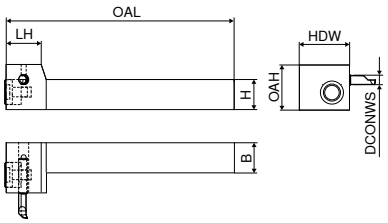


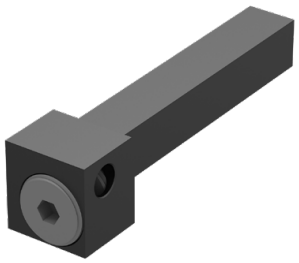
Y5
Clamping screw

Spare parts DCONWS		2A/28 Article no. 70 950 ... £			Y5 Article no. 73 082 ... £	
4	SW2,5	2.23	**175**	M5x0,5x6	4.60	**010**
5	SW2,5	2.23	**175**	M5x0,5x6	4.60	**010**
6	SW2,5	2.23	**175**	M5x0,5x6	4.60	**010**
7	SW2,5	2.23	**175**	M5x0,5x6	4.60	**010**
8	SW2,5	2.23	**175**	M5x0,5x6	4.60	**010**

UltraMini – Toolholder for inserts

Scope of supply:
Tool holder with allen key





Illustrations show right-hand versions

Designation	DCONWS mm	OAL mm	LH mm	B mm	HDW mm	H mm	OAH mm	Left-hand Y5 Article no. 73 083 ... £		Right-hand Y5 Article no. 73 084 ... £	
R/L .UHCM.1212.4	4	90	17	12	20	12	18	324.30	**124**	324.30	**124**
R/L .UHCM.1212.5	5	90	17	12	20	12	18	324.30	**125**	324.30	**125**
R/L .UHCM.1212.6	6	90	17	12	20	12	21	324.30	**126**	324.30	**126**
R/L .UHCM.1212.7	7	90	17	12	20	12	21	324.30	**127**	324.30	**127**

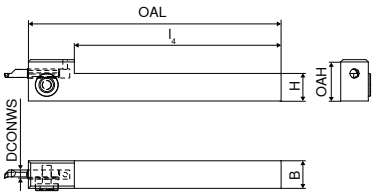

Y7 Clamping key – T

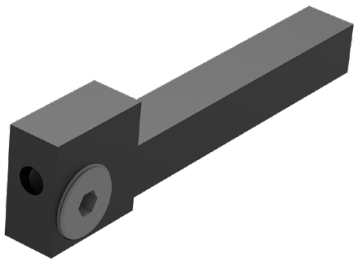

Y5 Clamping screw

Spare parts DCONWS		Article no. 80 397 ... £			Article no. 73 082 ... £	
4	SW5	6.09	**050**	UM 12	38.49	**011**
5	SW5	6.09	**050**	UM 12	38.49	**011**
6	SW5	6.09	**050**	UM 16	38.49	**012**
7	SW5	6.09	**050**	UM 16	38.49	**012**

UltraMini – Toolholder for inserts

Scope of supply:
Tool holder with allen key





Designation	DCONWS mm	OAL mm	l_4 mm	B mm	H mm	OAH mm	Y5 Article no. 73 086 ... £	
UM.1010.4	4	100	75	10	10	20	324.30	**104**
UM.1010.5	5	100	75	10	10	20	324.30	**105**
UM.1212.4	4	100	75	12	12	22	324.30	**124**
UM.1212.5	5	100	75	12	12	22	324.30	**125**
UM.1212.6	6	100	75	12	12	22	324.30	**126**


Y7 Clamping key – T

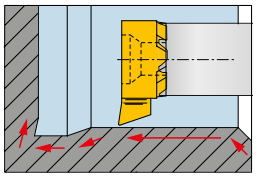

Y5 Clamping screw

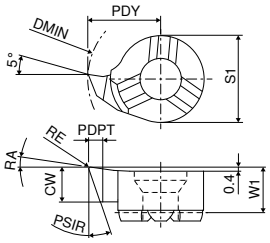
Spare parts DCONWS		Article no. 80 397 ... £			Article no. 73 082 ... £	
4	SW5	6.09	**050**	UM 12	38.49	**011**
5	SW5	6.09	**050**	UM 12	38.49	**011**
6	SW5	6.09	**050**	UM 16	38.49	**012**

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MiniCut – Insert for turning and profiling

CWX500 CWX500







Illustrations show right-hand versions

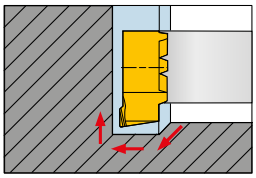
Size	Designation	DMIN mm	CW mm	W1 mm	PDY mm	S1 mm	RE mm	PDPT mm	PSIR °	RA °	Left-hand Y5 Article no. 73 324 ... £		Right-hand Y5 Article no. 73 322 ... £	
08	8,00. R/L .3,30.18°	7.8	3.3	3.5	4.65	6.0	0.20	0.6	18	8	37.06	033	37.06	033
	8,00. R/L .3,50.18°	7.8	3.5	3.5	4.65	6.0	0.05	0.6	18	8	40.25	035	40.25	035
	8,00. R/L .3,50.20°	7.8	3.5	3.5	4.65	6.0	0.20	0.6	20	20	38.92	135	38.92	135
09	9,00. R/L .3,60.18°	9.0	3.6	3.6	5.50	6.2	0.20	0.8	18	8	35.07	136	35.07	136
	9,00. R/L .3,60.20°	9.0	3.6	3.6	5.50	6.2	0.20	0.8	20	20	39.64	236	39.64	236
11	9,80. R/L .3,90.18°	9.8	3.9	4.2	5.50	8.0	0.20	1.0	18	8	37.06	139	37.06	139
	11,00. R/L .3,90.18°	11.0	3.9	4.2	6.70	8.0	0.20	1.0	18	8	36.65	339	36.65	339
	11,00. R/L .4,20.20°	11.0	4.2	4.2	6.70	8.0	0.20	1.0	20	20	39.64	342	39.64	342
14	14,00. R/L .5,00.18°	13.8	5.0	5.1	8.70	9.0	0.20	1.5	18	8	36.65	550	36.65	550
	14,00. R/L .5,30.20°	14.0	5.3	5.3	8.70	9.0	0.20	1.5	20	20	39.64	553	39.64	553
16	15,50. R/L .5,00.18°	15.5	5.0	5.4	9.70	11.0	0.20	1.5	18	8	40.05	750	40.05	750
Steel												●		●
Stainless steel												●		●
Cast iron												●		●
Non ferrous metals												●		●
Heat resistant alloys												●		●
hardened materials														

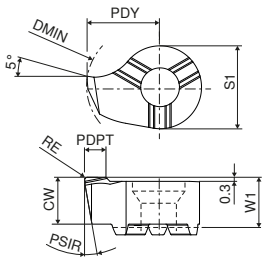
→ v_c Page 60

MiniCut – Insert for copy turning

▲ with chip breaker

CWX500 CWX500







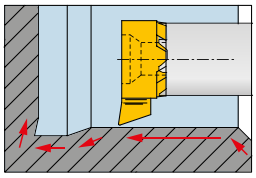
Illustrations show right-hand versions

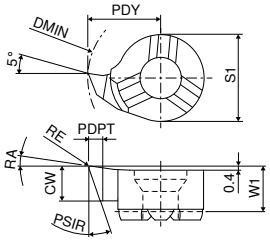
Size	Designation	DMIN mm	CW mm	W1 mm	PDY mm	S1 mm	RE mm	PDPT mm	PSIR °	Left-hand Y5 Article no. 73 388 ... £		Right-hand Y5 Article no. 73 386 ... £	
08	8,00. R/L .3,40.10°	8	3.4	3.5	4.65	6.0	0.2	0.5	10	30.97	13400	30.97	13400
09	9,00. R/L .3,50.10°	9	3.5	3.6	5.50	6.2	0.2	0.5	10	32.27	136	32.27	136
11	11,00. R .4,10.10°	11	4.1	4.2	6.70	8.0	0.2	0.5	10	30.97	14100	30.97	14100
Steel											●		●
Stainless steel											●		●
Cast iron											●		●
Non ferrous metals											●		●
Heat resistant alloys											●		●
hardened materials													

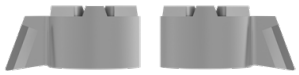
→ v_c Page 60

MiniCut – CBN insert for profiling – hard turning

▲ 56 to 65 HRC







Illustrations show right-hand versions

Size	Designation	DMIN mm	CW mm	W1 mm	PDY mm	S1 mm	RE mm	PDPT mm	PSIR °	RA °	Left-hand CBN Y5 Article no. 73 368 ... £		Right-hand CBN Y5 Article no. 73 366 ... £	
08	8,00. R/L .3,30.18°	7.8	3.3	3.5	4.65	6	0.2	0.39	18	8	167.56	033	167.56	033
11	11,00. R/L .3,90.18°	11.0	3.9	4.2	6.70	8	0.2	0.55	18	8	175.37	139	175.37	139
14	14,00. R/L .5,00.18°	13.8	5.0	5.3	8.70	9	0.2	0.69	18	8	185.81	550	185.81	550
16	16,00. R/L .5,00.18°	15.5	5.0	5.4	9.70	11	0.2	0.77	18	8	193.75	750	193.75	750

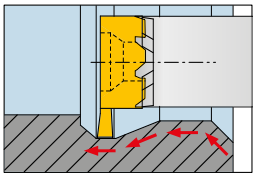
Steel		
Stainless steel		
Cast iron		
Non ferrous metals		
Heat resistant alloys		
hardened materials	●	●

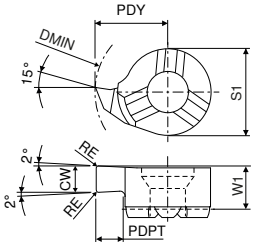
→ v_c Page 60

12

MiniCut – Internal turning insert

CWX500 CWX500







Illustrations show right-hand versions

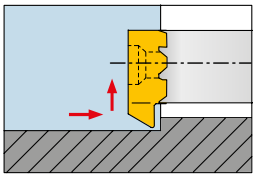
Size	Designation	DMIN mm	CW +0,05 mm	PDPT mm	W1 mm	PDY mm	S1 mm	RE mm	CDX mm	Left-hand Y5 Article no. 73 316 ... £		Right-hand Y5 Article no. 73 314 ... £	
08	8,00. R/L .1,50.1,0	8	1.5	1.0	3.3	4.8	6.0	0.2	0.2	37.49	015	37.49	015
	8,00. R/L .2,00.1,0	8	2.0	1.0	3.3	4.8	6.0	0.2	0.2	35.78	020	35.78	020
09	9,00. R/L .1,50.2,0	9	1.5	2.0	3.6	5.5	6.2	0.2	0.2	38.32	115	38.32	115
	9,00. R/L .1,50.3,0	10	1.5	3.0	3.6	6.5	6.2	0.2	0.2	38.32	121	38.32	121
	9,00. R/L .2,00.2,0	9	2.0	2.0	3.6	5.5	6.2	0.2	0.2	33.98	120	33.98	120
	9,00. R/L .2,00.3,0	10	2.0	3.0	3.6	6.5	6.2	0.2	0.2	33.98	122	33.98	122
11	11,00. R/L .1,50.2,3	11	1.5	2.3	4.2	6.7	8.0	0.2	0.2	39.48	315	39.48	315
	11,00. R/L .2,00.2,3	11	2.0	2.3	4.2	6.7	8.0	0.2	0.2	37.06	320	37.06	320
14	14,00. R/L .1,50.4,0	14	1.5	4.0	5.3	9.0	9.0	0.2	0.2	36.19	515	36.19	515
	14,00. R/L .1,50,5,5	16	1.5	5.5	5.2	10.5	9.0	0.2	0.2	46.05	516	46.05	516
	14,00. R/L .1,50.6,5	17	1.5	6.5	5.2	11.5	9.0	0.2	0.2	46.05	517	46.05	517
	14,00. R/L .2,00.4,0	14	2.0	4.0	5.3	9.0	9.0	0.2	0.2	37.06	520	37.06	520
	14,00. R/L .2,00.5,5	16	2.0	5.5	5.2	10.5	9.0	0.2	0.2	46.05	521	46.05	521
	14,00. R/L .2,00.6,5	17	2.0	6.5	5.2	11.5	9.0	0.2	0.2	46.05	522	46.05	522
	14,00. R/L .2,50.5,5	16	2.5	5.5	5.2	10.5	9.0	0.2	0.2	46.05	525	46.05	525
	14,00. R/L .2,50.6,5	17	2.5	6.5	5.2	11.5	9.0	0.2	0.2	46.05	526	46.05	526
	14,00. R/L .3,00.5,5	16	3.0	5.5	5.2	10.5	9.0	0.2	0.2	46.05	530	46.05	530
	14,00. R/L .3,00.6,5	17	3.0	6.5	5.2	11.5	9.0	0.2	0.2	46.05	531	46.05	531
16	16,00. R/L .2,00.4,3	16	2.0	4.3	5.4	10.2	11.0	0.2	0.2	40.41	720	40.41	720

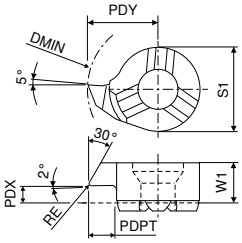
Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

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MiniCut – Back boring insert

CWX500 CWX500







Illustrations show right-hand versions

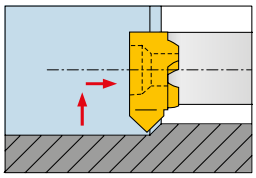
Size	Designation	DMIN mm	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm	RE mm	CDX mm	Left-hand Y5 Article no. 73 332 ... £		Right-hand Y5 Article no. 73 330 ... £	
08	8,00. R/L .30°.1,3	7.8	1.3	3.50	1.0	4.65	6.0	0.2	0.6	42.64	013	42.64	013
09	9,00. R/L .30°.1,7	9.0	1.7	3.55	1.2	5.50	6.2	0.2	0.8	38.92	117	38.92	117
	9,00. R/L .30°.2,3	10.0	2.3	3.55	1.2	6.50	6.2	0.2	0.8	38.92	123	38.92	123
11	11,00. R/L .30°.2,3	11.0	2.3	4.30	1.6	6.70	8.0	0.2	1.0	41.75	323	41.75	323
14	14,00. R/L .30°.3,5	13.8	3.5	5.40	2.4	8.70	9.0	0.2	1.5	42.64	535	42.64	535

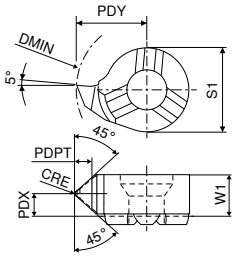
Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

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MiniCut – Internal turning and chamfering insert

CWX500 CWX500







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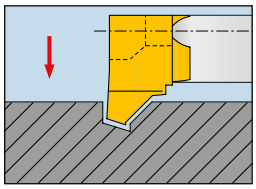
Illustrations show right-hand versions

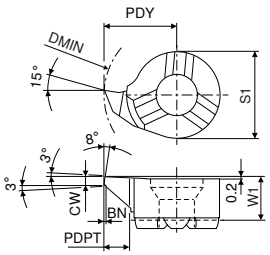
Size	Designation	DMIN mm	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm	CRE mm	CDX mm	Left-hand Y5 Article no. 73 336 ... £		Right-hand Y5 Article no. 73 334 ... £	
08	8,00. R/L .45°.1,4	8	1.4	3.50	1.8	4.8	6.0	0.2	0.6	35.62	010	35.62	010
09	9,00. R/L .45°.1,3	9	1.3	3.55	1.8	5.5	6.2	0.2	0.8	33.38	110	33.38	110
11	11,00. R/L .45°.1,5	11	1.5	4.30	2.2	6.7	8.0	0.2	1.0	35.62	310	35.62	310
14	14,00. R/L .45°.1,5	14	1.5	5.40	2.8	9.0	9.0	0.2	1.2	38.48	510	38.48	510

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

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MiniCut – Insert for pregrooving and chamfering





CWX500 CWX500



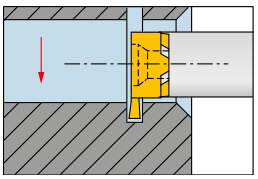
Illustrations show right-hand versions

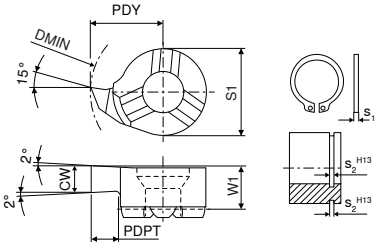
Size	Designation	DMIN mm	CW mm	PDPT mm	W1 mm	PDY mm	S1 mm	BN mm	Left-hand Y5 Article no. 73 340 ... £		Right-hand Y5 Article no. 73 338 ... £	
08	8,00. R/L .1,00.45°	8	1	1.0	3.3	4.8	6.0	0.2	36.20	100	36.20	100
09	9,00. R/L .1,00.45°	9	1	1.5	3.6	5.5	6.2	0.2	34.48	215	34.48	215
11	11,00. R/L .1,00.45°	11	1	1.5	4.2	6.7	8.0	0.2	36.20	315	36.20	315
14	14,00. R/L .1,00.45°	14	1	1.5	5.3	9.0	9.0	0.2	36.20	515	36.20	515
16	16,00. R/L .1,00.45°	16	1	1.5	5.4	10.2	11.0	0.2	36.20	715	36.20	715

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

→ v_c Page 60

MiniCut – Grooving insert





CWX500 CWX500



Illustrations show right-hand versions

Size	Designation	DMIN	CW	PDPT	W1	S1	S2 H13	PDY	S1	Left-hand Y5 Article no. 73 312 ...		Right-hand Y5 Article no. 73 310 ...	
		mm	mm	mm	mm	mm	mm	mm	mm	£		£	
08	8,00. R/L .0,73.1,0	8	0.73	1.0	3.3	0.6	0.7	4.8	6.0	32.02	073	32.02	073
	8,00. R/L .0,83.1,0	8	0.83	1.0	3.3	0.7	0.8	4.8	6.0	32.02	083	32.02	083
	8,00. R/L .0,93.1,0	8	0.93	1.0	3.3	0.8	0.9	4.8	6.0	32.02	093	32.02	093
	8,00. R/L .1,00.1,0	8	1.00	1.0	3.3			4.8	6.0	32.02	110	32.02	110
	8,00. R/L .1,20.1,0	8	1.20	1.0	3.3	1.0	1.1	4.8	6.0	32.02	112	32.02	112
	8,00. R/L .1,40.1,0	8	1.40	1.0	3.3	1.2	1.3	4.8	6.0	32.02	114	32.02	114
	8,00. R/L .1,50.1,0	8	1.50	1.0	3.3			4.8	6.0	32.02	115	32.02	115
	8,00. R/L .1,70.1,0	8	1.70	1.0	3.3	1.5	1.6	4.8	6.0	32.02	117	32.02	117
	8,00. R/L .2,00.1,0	8	2.00	1.0	3.3			4.8	6.0	32.02	120	32.02	120
09	9,00. R/L .0,73.1,2	9	0.73	1.2	3.6	0.6	0.7	5.5	6.2	31.23	173	31.23	173
	9,00. R/L .0,83.1,3	9	0.83	1.3	3.6	0.7	0.8	5.5	6.2	31.23	183	31.23	183
	9,00. R/L .0,93.1,5	9	0.93	1.5	3.6	0.8	0.9	5.5	6.2	31.23	193	31.23	193
	9,00. R/L .1,00.1,8	9	1.00	1.8	3.6			5.5	6.2	31.23	210	31.23	210
	9,00. R/L .1,20.1,8	9	1.20	1.8	3.6	1.0	1.1	5.5	6.2	31.23	212	31.23	212
	9,00. R/L .1,40.1,8	9	1.40	1.8	3.6	1.2	1.3	5.5	6.2	31.23	214	31.23	214
	9,00. R/L .1,50.1,8	9	1.50	1.8	3.6			5.5	6.2	31.23	215	31.23	215
	9,00. R/L .1,70.1,8	9	1.70	1.8	3.6	1.5	1.6	5.5	6.2	31.23	217	31.23	217
	9,00. R/L .2,00.1,8	9	2.00	1.8	3.6			5.5	6.2	31.23	220	31.23	220
	9,00. R/L .2,50.1,8	9	2.50	1.8	3.6			5.5	6.2	31.23	225	31.23	225
	9,00. R/L .3,00.1,8	9	3.00	1.8	3.6			5.5	6.2	31.23	230	31.23	230
11	11,00. R/L .0,73.1,2	11	0.73	1.2	4.2	0.6	0.7	6.7	8.0	32.02	373	32.02	373
	11,00. R/L .0,83.1,3	11	0.83	1.3	4.2	0.7	0.8	6.7	8.0	32.02	383	32.02	383
	11,00. R/L .0,93.1,5	11	0.93	1.5	4.2	0.8	0.9	6.7	8.0	32.02	393	32.02	393
	11,00. R/L .1,00.2,3	11	1.00	2.3	4.2			6.7	8.0	32.02	310	32.02	310
	11,00. R/L .1,20.2,3	11	1.20	2.3	4.2	1.0	1.1	6.7	8.0	32.02	312	32.02	312
	11,00. R/L .1,40.2,3	11	1.40	2.3	4.2	1.2	1.3	6.7	8.0	32.02	314	32.02	314
	11,00. R/L .1,50.2,3	11	1.50	2.3	4.2			6.7	8.0	32.02	315	32.02	315
	11,00. R/L .1,70.2,3	11	1.70	2.3	4.2	1.5	1.6	6.7	8.0	32.02	317	32.02	317
	11,00. R/L .2,00.2,3	11	2.00	2.3	4.2			6.7	8.0	32.02	320	32.02	320
	11,00. R/L .2,50.2,3	11	2.50	2.3	4.2			6.7	8.0	32.02	325	32.02	325
	11,00. R/L .3,00.2,3	11	3.00	2.3	4.2			6.7	8.0	32.02	330	32.02	330
14	14,00. R/L .0,73.1,2	14	0.73	1.2	5.3	0.6	0.7	9.0	9.0	32.02	573	32.02	573
	14,00. R/L .0,83.1,3	14	0.83	1.3	5.3	0.7	0.8	9.0	9.0	32.02	583	32.02	583
	14,00. R/L .0,93.1,5	14	0.93	1.5	5.3	0.8	0.9	9.0	9.0	32.02	593	32.02	593
	14,00. R/L .1,20.4,0	14	1.20	4.0	5.3	1.0	1.1	9.0	9.0	32.02	512	32.02	512
	14,00. R/L .1,40.4,0	14	1.40	4.0	5.3	1.2	1.3	9.0	9.0	32.02	514	32.02	514
	14,00. R/L .1,50.4,0	14	1.50	4.0	5.3			9.0	9.0	32.02	515	32.02	515
	14,00. R/L .1,70.4,0	14	1.70	4.0	5.3	1.5	1.6	9.0	9.0	32.02	517	32.02	517
	14,00. R/L .2,00.4,0	14	2.00	4.0	5.3			9.0	9.0	32.02	520	32.02	520
	14,00. R/L .2,50.4,0	14	2.50	4.0	5.3			9.0	9.0	32.02	525	32.02	525
	14,00. R/L .3,00.4,0	14	3.00	4.0	5.3			9.0	9.0	32.02	530	32.02	530
16	16,00. R/L .0,73.1,2	16	0.73	1.2	5.4	0.6	0.7	10.2	11.0	39.00	773	39.00	773
	16,00. R/L .0,83.1,3	16	0.83	1.3	5.4	0.7	0.8	10.2	11.0	39.00	783	39.00	783
	16,00. R/L .0,93.1,5	16	0.93	1.5	5.4	0.8	0.9	10.2	11.0	39.00	793	39.00	793
	16,00. R/L .1,20.4,3	16	1.20	4.3	5.4	1.0	1.1	10.2	11.0	35.23	712	35.23	712
	16,00. R/L .1,40.4,3	16	1.40	4.3	5.4	1.2	1.3	10.2	11.0	35.23	714	35.23	714
	16,00. R/L .1,50.4,3	16	1.50	4.3	5.4			10.2	11.0	35.23	715	35.23	715
	16,00. R/L .1,70.4,3	16	1.70	4.3	5.4	1.5	1.6	10.2	11.0	35.23	717	35.23	717
	16,00. R/L .2,00.4,3	16	2.00	4.3	5.4			10.2	11.0	35.23	720	35.23	720
	16,00. R/L .2,50.4,3	16	2.50	4.3	5.4			10.2	11.0	35.23	725	35.23	725
	16,00. R/L .3,00.4,3	16	3.00	4.3	5.4			10.2	11.0	35.23	730	35.23	730
	16,00. R/L .3,50.4,3	16	3.50	4.3	5.4			10.2	11.0	35.23	735	35.23	735
	16,00. R/L .4,00.4,3	16	4.00	4.3	5.4			10.2	11.0	35.23	740	35.23	740

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

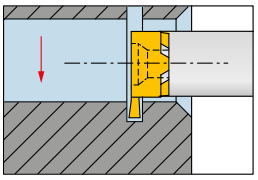
→ v_c Page 60

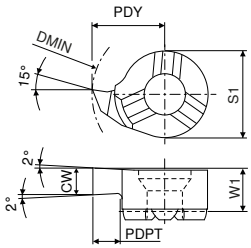
12

MiniCut – Grooving insert

▲ large groove depth ($T_{max.}$ 5.5 mm)

CWX500 CWX500







Illustrations show right-hand versions

Size	Designation	DMIN mm	CW +0,03 mm	PDPT mm	W1 mm	PDY mm	S1 mm	Left-hand Y5 Article no. 73 372 ... £		Right-hand Y5 Article no. 73 370 ... £	
14	14,00. R/L .1,50.5,5	16	1.5	5.5	5.2	10.5	9	37.18	715	37.18	715
	14,00. R/L .2,00.5,5	16	2.0	5.5	5.2	10.5	9	37.18	720	37.18	720
	14,00. R/L .2,50.5,5	16	2.5	5.5	5.2	10.5	9	37.18	725	37.18	725
	14,00. R/L .3,00.5,5	16	3.0	5.5	5.2	10.5	9	37.18	730	37.18	730

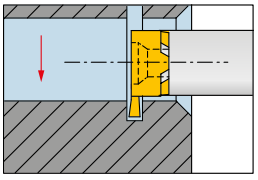
Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

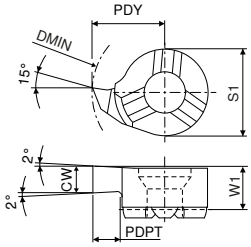
→ v_c Page 60

MiniCut – Grooving insert

▲ large groove depth ($T_{max.}$ 6.5 mm)

CWX500 CWX500







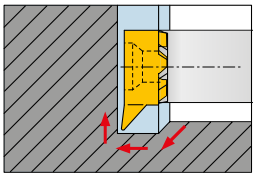
Illustrations show right-hand versions

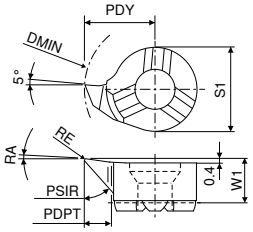
Size	Designation	DMIN mm	CW +0,03 mm	PDPT mm	W1 mm	PDY mm	S1 mm	Left-hand Y5 Article no. 73 384 ... £		Right-hand Y5 Article no. 73 382 ... £	
14	14,00. R/L .1,50.6,5	17	1.5	6.5	5.2	11.5	9	37.18	515	37.18	515
	14,00. R/L .2,00.6,5	17	2.0	6.5	5.2	11.5	9	37.18	520	37.18	520
	14,00. R/L .2,50.6,5	17	2.5	6.5	5.2	11.5	9	37.18	525	37.18	525
	14,00. R/L .3,00.6,5	17	3.0	6.5	5.2	11.5	9	37.18	530	37.18	530

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

→ v_c Page 60

MiniCut – Internal undercut insert





CWX500 CWX500



Illustrations show right-hand versions

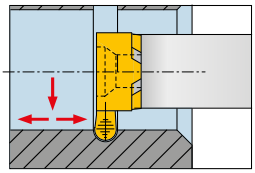
Size	Designation	DMIN mm	PDPT mm	W1 mm	PDY mm	S1 mm	RE mm	CDX mm	PSIR °	RA °	Left-hand Y5 Article no. 73 328 ... £		Right-hand Y5 Article no. 73 326 ... £	
08	8,00. R/L .30°.1,0	7.8	1.0	3.5	4.65	6.0	0.2	0.4	30	3	42.80	010	42.80	010
	8,00. R/L .47°.1,2	7.8	1.2	3.5	4.65	6.0	0.2	0.4	47	3	37.18	012	37.18	012
09	9,00. R/L .47°.1,5	9.0	1.5	3.6	5.50	6.2	0.2	0.5	47	3	34.48	115	34.48	115
11	11,00. R/L .30°.2,3	11.0	2.3	4.2	6.70	8.0	0.2	0.6	30	3	41.80	423	41.80	423
	11,00. R/L .47°.2,3	11.0	2.3	4.2	6.70	8.0	0.2	0.6	47	3	36.20	323	36.20	323
14	13,70. R/L .47°.3,0	13.7	3.0	5.3	8.70	9.0	0.2	0.8	47	3	37.18	530	37.18	530
	13,70. R/L .30°.4,0	13.7	4.0	5.3	8.70	9.0	0.2	0.8	30	3	42.80	540	42.80	540
16	15,80. R/L .30°.4,3	15.8	4.3	5.4	10.20	11.0	0.2	1.0	30	3	41.54	744	41.54	744

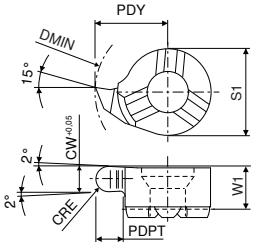
Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

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MiniCut – Full radius grooving and turning insert





CWX500 CWX500



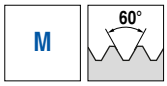
Illustrations show right-hand versions

Size	Designation	DMIN mm	CW mm	PDPT mm	W1 mm	PDY mm	S1 mm	CRE mm	Left-hand Y5 Article no. 73 320 ... £		Right-hand Y5 Article no. 73 318 ... £	
08	8,00. R/L .0,80.1,0	8	0.8	1.0	3.3	4.8	6.0	0.4	39.91	008	39.91	008
	8,00. R/L .1,20.1,0	8	1.2	1.0	3.3	4.8	6.0	0.6	39.91	012	39.91	012
	8,00. R/L .1,80.1,0	8	1.8	1.0	3.3	4.8	6.0	0.9	39.91	018	39.91	018
	8,00. R/L .2,00.1,0	8	2.0	1.0	3.3	4.8	6.0	1.0	36.99	020	36.99	020
09	9,00. R/L .0,80.1,6	9	0.8	1.6	3.6	5.5	6.2	0.4	38.32	108	38.32	108
	9,00. R/L .1,20.1,6	9	1.2	1.6	3.6	5.5	6.2	0.6	38.32	112	38.32	112
	9,00. R/L .1,80.1,6	9	1.8	1.6	3.6	5.5	6.2	0.9	38.32	118	38.32	118
	9,00. R/L .2,00.1,6	9	2.0	1.6	3.6	5.5	6.2	1.0	38.32	120	38.32	120
11	11,00. R/L .0,80.2,3	11	0.8	2.3	4.2	6.7	8.0	0.4	40.41	308	40.41	308
	11,00. R/L .1,20.2,3	11	1.2	2.3	4.2	6.7	8.0	0.6	40.41	312	40.41	312
	11,00. R/L .1,60.2,3	11	1.6	2.3	4.2	6.7	8.0	0.8	38.32	316	38.32	316
	11,00. R/L .1,80.2,3	11	1.8	2.3	4.2	6.7	8.0	0.9	40.41	318	40.41	318
	11,00. R/L .2,00.2,3	11	2.0	2.3	4.2	6.7	8.0	1.0	40.41	320	40.41	320
	11,00. R/L .2,40.2,3	11	2.4	2.3	4.2	6.7	8.0	1.2	38.32	324	38.32	324
	11,00. R/L .3,00.2,3	11	3.0	2.3	4.2	6.7	8.0	1.5	40.41	330	40.41	330
14	14,00. R/L .0,80.4,0	14	0.8	4.0	5.3	9.0	9.0	0.4	39.89	508	39.89	508
	14,00. R/L .1,20.4,0	14	1.2	4.0	5.3	9.0	9.0	0.6	42.77	512	42.77	512
	14,00. R/L .1,80.4,0	14	1.8	4.0	5.3	9.0	9.0	0.9	42.77	518	42.77	518
	14,00. R/L .2,00.4,0	14	2.0	4.0	5.3	9.0	9.0	1.0	42.77	520	42.77	520
	14,00. R/L .2,20.4,0	14	2.2	4.0	5.3	9.0	9.0	1.1	42.77	522	42.77	522
	14,00. R/L .3,00.4,0	14	3.0	4.0	5.3	9.0	9.0	1.5	42.77	530	42.77	530
16	16,00. R/L .1,60.4,3	16	1.6	4.3	5.4	10.2	11.0	0.8	40.96	716	40.96	716
	16,00. R/L .1,80.4,3	16	1.8	4.3	5.4	10.2	11.0	0.9	43.21	718	43.21	718
	16,00. R/L .2,00.4,3	16	2.0	4.3	5.4	10.2	11.0	1.0	40.96	720	40.96	720
	16,00. R/L .2,20.4,3	16	2.2	4.3	5.4	10.2	11.0	1.1	43.21	722	43.21	722
	16,00. R/L .2,40.4,3	16	2.4	4.3	5.4	10.2	11.0	1.2	40.96	724	40.96	724
	16,00. R/L .3,00.4,3	16	3.0	4.3	5.4	10.2	11.0	1.5	43.21	730	43.21	730
	16,00. R/L .3,20.4,3	16	3.2	4.3	5.4	10.2	11.0	1.6	40.96	732	40.96	732
	16,00. R/L .4,00.4,3	16	4.0	4.3	5.4	10.2	11.0	2.0	43.21	740	43.21	740

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

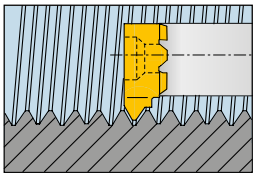
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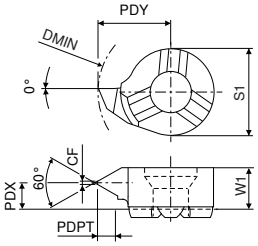
MiniCut – Threading insert (Partial profile)













Illustrations show right-hand versions

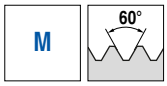
Size	Designation	DMIN mm	TP mm	CF mm	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm	Left-hand Y5 Article no. 73 344 ... £		Right-hand Y5 Article no. 73 342 ... £	
08	8,00. R/L .0,5/0,75.60°	8	0,5 - 0,75	0.06	0.43	3.50	2.7	4.8	6.0	43.21	012	43.21	012
	8,00. R/L .1,0/1,25.60°	8	1,0 - 1,25	0.12	0.70	3.50	2.7	4.8	6.0	43.21	014	43.21	014
	8,00. R/L .1,5/1,75.60°	8	1,5 - 1,75	0.18	0.95	3.50	2.5	4.8	6.0	43.21	010	43.21	010
09	9,00. R/L .0,5/0,75.60°	9	0,5 - 0,75	0.06	0.27	3.55	3.2	5.5	6.2	40.96	112	40.96	112
	9,00. R/L .1,0/1,25.60°	9	1,0 - 1,25	0.12	0.54	3.55	3.0	5.5	6.2	40.96	114	40.96	114
	9,00. R/L .1,5/1,75.60°	9	1,5 - 1,75	0.18	0.81	3.55	2.8	5.5	6.2	40.96	116	40.96	116
	9,00. R/L .1,75/2,0.60°	9	1,75 - 2,0	0.20	0.95	3.55	2.6	5.5	6.2	40.96	118	40.96	118
	9,00. R/L .2,0/2,5.60°	9	2,0 - 2,5	0.25	1.08	3.55	2.5	5.5	6.2	40.96	120	40.96	120
	9,00. R/L .2,5/3,0.60°	9	2,5 - 3,0	0.31	1.35	3.55	2.1	5.5	6.2	40.96	122	40.96	122
	9,00. R/L .3,0/3,5.60°	9	3,0 - 3,5	0.37	1.62	3.55	1.9	5.5	6.2	40.96	124	40.96	124
11	11,00. R/L .0,5/0,75.60°	11	0,5 - 0,75	0.06	0.75	4.30	3.5	6.7	8.0	43.21	312	43.21	312
	11,00. R/L .1,0/1,25.60°	11	1,0 - 1,25	0.12	0.55	4.30	3.5	6.7	8.0	43.21	314	43.21	314
	11,00. R/L .1,5/1,75.60°	11	1,5 - 1,75	0.18	0.81	4.30	3.5	6.7	8.0	43.21	316	43.21	316
	11,00. R/L .2,0/2,5.60°	11	2,0 - 2,5	0.25	1.08	4.30	3.0	6.7	8.0	43.21	310	43.21	310
	11,00. R/L .2,5/3,0.60°	11	2,5 - 3,0	0.31	1.35	4.30	3.0	6.7	8.0	43.21	320	43.21	320
14	14,00. R/L .1,0/1,25.60°	14	1,0 - 1,25	0.12	0.55	5.40	4.7	9.0	9.0	43.21	512	43.21	512
	14,00. R/L .1,5/1,75.60°	14	1,5 - 1,75	0.18	0.81	5.40	4.5	9.0	9.0	43.21	514	43.21	514
	14,00. R/L .2,0/2,5.60°	14	2,0 - 2,5	0.25	1.08	5.40	4.2	9.0	9.0	43.21	510	43.21	510
	14,00. R/L .2,5/3,0.60°	14	2,5 - 3,0	0.31	1.35	5.40	4.7	9.0	9.0	43.21	520	43.21	520
16	16,00. R/L .1,0/1,25.60°	16	1,0 - 1,25	0.12	0.55	5.50	4.7	10.2	11.0	43.21	712	43.21	712
	16,00. R/L .1,5/1,75.60°	16	1,5 - 1,75	0.18	0.81	5.50	4.5	10.2	11.0	43.21	714	43.21	714
	16,00. R/L .2,0/2,5.60°	16	2,0 - 2,5	0.25	1.08	5.50	4.2	10.2	11.0	43.21	716	43.21	716
	16,00. R/L .2,5/3,0.60°	16	2,5 - 3,0	0.31	1.35	5.50	4.2	10.2	11.0	43.21	710	43.21	710

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

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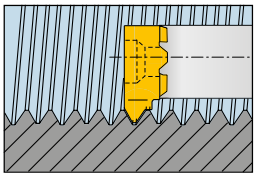
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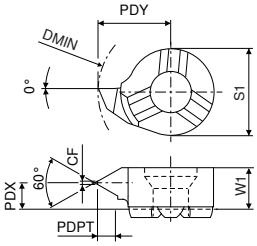
MiniCut – Threading insert (Full profile)













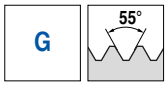
Illustrations show right-hand versions

Size	Designation	DMIN mm	TP mm	CF mm	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm	Left-hand Y5 Article no. 73 348 ... £		Right-hand Y5 Article no. 73 346 ... £	
09	9,00. R/L .0,5.60°	9	0.50	0.06	0.27	3.55	3.25	5.5	6.2	45.65	405	45.65	405
	9,00. R/L .1,0.60°	9	1.00	0.12	0.54	3.55	3.00	5.5	6.2	45.65	410	45.65	410
	9,00. R/L .1,5.60°	9	1.50	0.18	0.81	3.55	2.80	5.5	6.2	45.65	415	45.65	415
	9,00. R/L .1,75.60°	9	1.75	0.20	0.95	3.55	2.70	5.5	6.2	45.65	418	45.65	418
	9,00. R/L .2,0.60°	9	2.00	0.25	1.08	3.55	2.60	5.5	6.2	45.65	420	45.65	420
	9,00. R/L .2,5.60°	9	2.50	0.31	1.35	3.55	2.50	5.5	6.2	45.65	425	45.65	425
	9,00. R/L .3,0.60°	9	3.00	0.37	1.62	3.55	2.20	5.5	6.2	45.65	430	45.65	430
11	11,00. R/L .1,0.60°	11	1.00	0.12	0.54	4.30	3.50	6.7	8.0	49.02	314	49.02	314
	11,00. R/L .1,5.60°	11	1.50	0.18	0.81	4.30	3.50	6.7	8.0	48.24	316	49.02	316
	11,00. R/L .2,0.60°	11	2.00	0.25	1.08	4.30	3.20	6.7	8.0	49.02	310	49.02	310
	11,00. R/L .2,5.60°	11	2.50	0.31	1.35	4.30	3.00	6.7	8.0	49.02	320	49.02	320
	11,00. R/L .3,0.60°	11	3.00	0.37	1.62	4.30	2.90	6.7	8.0	49.02	330	49.02	330
14	14,00. R/L .0,5.60°	14	0.50	0.06	0.27	5.40	3.50	9.0	9.0	49.63	510	49.63	510
	14,00. R/L .1,0.60°	14	1.00	0.12	0.54	5.40	3.50	9.0	9.0	45.18	512	45.18	512
	14,00. R/L .1,5.60°	14	1.50	0.18	0.81	5.40	3.30	9.0	9.0	45.18	514	45.18	514
	14,00. R/L .2,0.60°	14	2.00	0.25	1.08	5.40	4.20	9.0	9.0	45.18	610	45.18	610
	14,00. R/L .2,5.60°	14	2.50	0.31	1.35	5.40	4.70	9.0	9.0	45.18	520	45.18	520
16	16,00. R/L .1,0.60°	16	1.00	0.12	0.54	5.50	4.70	10.2	11.0	54.59	712	54.59	712
	16,00. R/L .1,5.60°	16	1.50	0.18	0.81	5.50	4.50	10.2	11.0	54.59	714	54.59	714
	16,00. R/L .2,0.60°	16	2.00	0.25	1.08	5.50	4.20	10.2	11.0	54.59	716	54.59	716
	16,00. R/L .2,5.60°	16	2.50	0.31	1.35	5.50	4.20	10.2	11.0	54.59	710	54.59	710
	16,00. R/L .3,0.60°	16	3.00	0.37	1.62	5.50	4.00	10.2	11.0	54.59	720	54.59	720
	16,00. R/L .3,5.60°	16	3.50	0.43	1.89	5.50	3.80	10.2	11.0	54.59	730	54.59	730
	16,00. R/L .4,0.60°	16	4.00	0.50	2.16	5.50	3.60	10.2	11.0	54.59	740	54.59	740

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

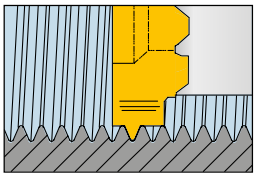
→ v_c Page 60

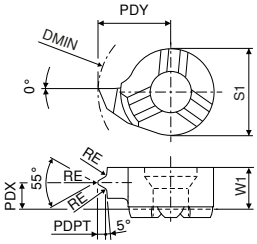
MiniCut – Threading insert (Full profile)













Illustrations show right-hand versions

Size	Designation	DMIN mm	TP mm	TPI 1/"	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm	RE mm	Left-hand Y5 Article no. 73 352 ... £		Right-hand Y5 Article no. 73 350 ... £	
11	11,00. R/L .1,814.55°	11	1.814	14	1.16	4.30	3.0	6.7	8	0.24	63.61	306	63.61	306
	11,00. R/L .1,337.55°	11	1.337	19	0.85	4.30	2.7	6.7	8	0.18	63.61	304	63.61	304
14	14,00. R/L .1,814.55°	14	1.814	14	1.16	5.35	3.6	9.0	9	0.24	62.77	506	62.77	506
	14,00. R/L .1,337.55°	14	1.337	19	0.85	5.35	3.8	9.0	9	0.18	62.77	504	62.77	504
16	16,00. R/L .2,309.55°	16	2.309	11	1.48	5.50	3.5	10.2	11	0.31	69.26	708	69.26	708
	16,00. R/L .1,814.55°	16	1.814	14	1.16	5.50	3.9	10.2	11	0.24	69.26	706	69.26	706

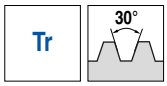
Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

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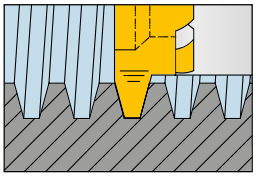
12

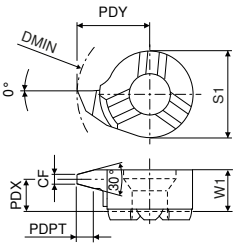
MiniCut – Threading insert (Partial profile)

▲ Trapezoidal thread DIN 103



CWX500 CWX500







Illustrations show right-hand versions

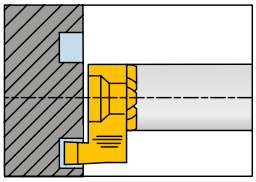
Size	Designation	DMIN mm	TP mm	CF mm	PDPT mm	W1 mm	PDX mm	PDY mm	S1 mm	Left-hand Y5 Article no. 73 356 ... £		Right-hand Y5 Article no. 73 354 ... £	
09	9,00. R/L .1,5.30°	9	1.5	0.47	0.90	3.55	3.00	5.5	6.2	42.16	415	42.16	415
	9,00. R/L .2,0.30°	9	2.0	0.60	1.25	3.55	2.85	5.5	6.2	42.16	420	42.16	420
	9,00. R/L .3,0.30°	9	3.0	0.96	1.75	3.55	2.25	5.5	6.2	42.16	430	42.16	430
	9,00. R/L .4,0.30°	10	4.0	1.33	2.25	3.55	2.25	5.5	6.2	42.16	440	42.16	440
11	11,00. R/L .1,5.30°	11	1.5	0.47	0.90	4.30	3.70	6.7	8.0	44.62	315	44.62	315
	11,00. R/L .2,0.30°	11	2.0	0.60	1.25	4.30	3.50	6.7	8.0	44.62	320	44.62	320
	11,00. R/L .3,0.30°	11	3.0	0.96	1.75	4.30	3.20	6.7	8.0	44.62	330	44.62	330
	11,00. R/L .4,0.30°	11	4.0	1.33	2.25	3.95	2.60	6.7	8.0	42.64	340	42.64	340
14	14,00. R/L .2,0.30°	14	2.0	0.60	1.25	5.30	4.30	9.0	9.0	44.75	520	44.75	520
	14,00. R/L .3,0.30°	14	3.0	0.96	1.75	5.30	4.00	9.0	9.0	44.75	530	44.75	530
	14,00. R/L .4,0.30°	14	4.0	1.33	2.25	5.30	3.60	9.0	9.0	44.75	540	44.75	540
	14,00. R/L .5,0.30°	14	5.0	1.69	2.75	5.30	3.30	9.0	9.0	44.75	550	44.75	550
16	16,00. R/L .2,0.30°	16	2.0	0.60	1.25	5.50	4.50	9.7	11.0	51.73	720	51.73	720
	16,00. R/L .3,0.30°	16	3.0	0.96	1.75	5.50	4.30	9.7	11.0	51.73	730	51.73	730
	16,00. R/L .4,0.30°	16	4.0	1.33	2.25	5.50	4.00	9.7	11.0	51.73	740	51.73	740
	16,00. R/L .5,0.30°	16	5.0	1.69	2.75	5.50	3.55	9.7	11.0	48.36	750	48.36	750
	16,00. R/L .6,0.30°	16	6.0	1.92	3.50	5.50	3.30	10.2	11.0	45.23	760	45.23	760

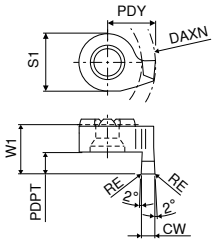
Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

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MiniCut – Axial grooving insert

CWX500 CWX500







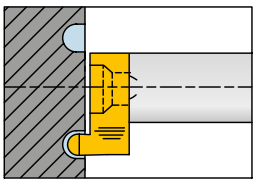
Illustrations show right-hand versions

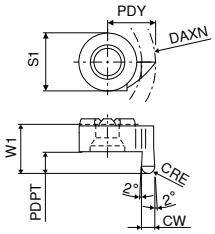
Size	Designation	DAXN mm	CW mm	PDPT mm	W1 mm	PDY mm	RE mm	S1 mm	Left-hand Y5 Article no. 73 364 ... £		Right-hand Y5 Article no. 73 362 ... £	
14	14,00. R/L .1,0.1,5	14	1.0	1.5	8.3	9		9	34.81	510	34.81	510
	14,00. R/L .1,5.2,5	14	1.5	2.5	8.3	9	0.2	9	34.81	515	34.81	515
	14,00. R/L .2,0.3,0	14	2.0	3.0	8.3	9	0.2	9	34.81	520	34.81	520
	14,00. R/L .2,0.5,0	14	2.0	5.0	10.3	9	0.2	9	40.41	620	40.41	620
	14,00. R/L .2,5.3,0	14	2.5	3.0	8.3	9	0.2	9	34.81	525	34.81	525
	14,00. R/L .2,5.5,0	14	2.5	5.0	10.3	9	0.2	9	40.41	625	40.41	625
	14,00. R/L .3,0.3,0	14	3.0	3.0	8.3	9	0.2	9	34.81	530	34.81	530
	14,00. R/L .3,0.5,0	14	3.0	5.0	10.3	9	0.2	9	40.41	630	40.41	630
Steel										●		●
Stainless steel										●		●
Cast iron										●		●
Non ferrous metals										●		●
Heat resistant alloys										●		●
hardened materials												

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MiniCut – Full radius axial grooving insert

CWX500 CWX500







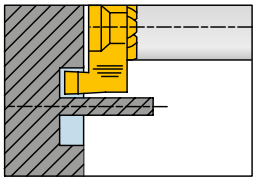
Illustrations show right-hand versions

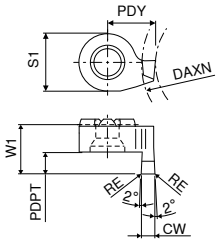
Size	Designation	DAXN mm	CW mm	PDPT mm	W1 mm	PDY mm	CRE mm	S1 mm	Left-hand Y5 Article no. 73 376 ... £		Right-hand Y5 Article no. 73 374 ... £	
14	14,00. R/L . 1,0.1,5	14	1.0	1.5	8.3	9	0.5	9	40.25	510	40.25	510
	14,00. R/L . 1,6.2,5	14	1.6	2.5	8.3	9	0.8	9	40.25	516	40.25	516
	14,00. R/L . 2,0.3,0	14	2.0	3.0	8.3	9	1.0	9	40.25	520	40.25	520
	14,00. R/L . 2,5.3,0	14	2.5	3.0	8.3	9	1.2	9	40.25	525	40.25	525
	14,00. R/L . 3,0.3,0	14	3.0	3.0	8.3	9	1.5	9	40.25	530	40.25	530
Steel										●		●
Stainless steel										●		●
Cast iron										●		●
Non ferrous metals										●		●
Heat resistant alloys										●		●
hardened materials												

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MiniCut – Axial grooving insert over a spigot

CWX500 CWX500







Illustrations show right-hand versions

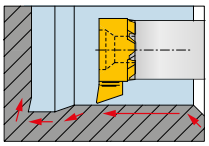
Size	Designation	DAXN mm	CW mm	PDPT mm	W1 mm	PDY mm	RE mm	S1 mm	Left-hand Y5 Article no. 73 360 ... £		Right-hand Y5 Article no. 73 358 ... £	
12	12,00. R/L .1,0.1,5	12	1.0	1.5	8.3	7.0		9	36.20	310	36.20	310
	12,00. R/L .1,5.2,5	12	1.5	2.5	8.3	7.5	0.2	9	37.06	315	37.06	315
	12,00. R/L .2,0.3,0	12	2.0	3.0	8.3	8.0	0.2	9	37.06	320	37.06	320
	12,00. R/L .2,0.5,0	12	2.0	5.0	10.3	8.0	0.2	9	43.20	420	43.20	420
	12,00. R/L .2,5.3,0	12	2.5	3.0	8.3	8.5	0.2	9	37.06	325	37.06	325
	12,00. R/L .2,5.5,0	12	2.5	5.0	10.3	8.5	0.2	9	43.20	425	43.20	425
	12,00. R/L .3,0.3,0	12	3.0	3.0	8.3	9.0	0.2	9	37.06	330	37.06	330
	12,00. R/L .3,0.5,0	12	3.0	5.0	10.3	9.0	0.2	9	43.20	430	43.20	430

Steel	●	●
Stainless steel	●	●
Cast iron	●	●
Non ferrous metals	●	●
Heat resistant alloys	●	●
hardened materials		

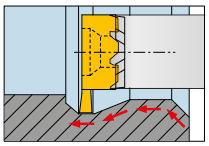
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Set: MiniCut size 9

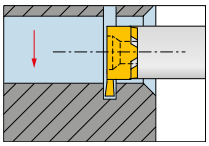
- ▲ Extensive range of size 9 inserts
- ▲ CWX 500



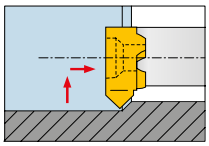
Profile turning (K)



Profile turn (A)



Grooving (E)

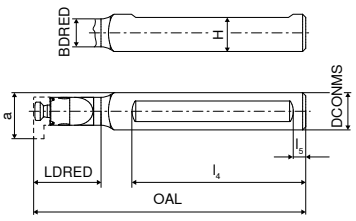


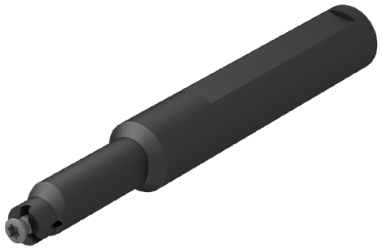
Chamfers (F)



Tool	Designation	Article number	Bore Ø mm	Width mm	Grooving depth mm	Piece	fig.	Y5 Article no. 73 528 ... £	
Grooving insert	**9,00. R .1,00.1,8**	**73 310 210**	9	1,00	1,8	1	E		
NC fine turning insert	**9,00. R .2,00.2,0**	**73 314 120**	9	2,0 +0,05	2,0	1	A		
Profiling insert	**9,00. R .3,60.10°**	**73 386 136**	9	3,6		1	K		
Profiling insert	**9,00. R .3,60.20°**	**73 322 236**	9	3,6		1	K	260.65	125
Chamfering insert	**9,00. R .45°.1,3**	**73 334 110**	9		1,3	1	F		
Tool holder	**9,00/16.N.25.1,0**	**73 522 125**				1			
Tightening Key		**70 950 105**				1			

MiniCut – Steel Tool holder





Size	Designation	a	DCONMS $_{f7}$	OAL	l_4	LDRED	BDRED	H	l_5	Y5 Article no. 73 522 ...	
		mm	mm	mm	mm	mm	mm	mm	mm	£	
08	8,00/16.N.12.1,0	7.8	16	80	60	12	6.0	15.0	5	191.50	012
	8,00/16.N.22.1,0	7.8	16	90	60	22	6.0	15.0	5	219.74	122
09	9,00/16.N.14.1,8	8.6	16	95	60	14	7.4	15.0	5	173.69	014
	9,00/16.N.25.1,8	8.6	16	105	60	25	7.4	15.0	5	199.15	125
11	11,00/16.N.16.2,3	10.7	16	97	60	16	8.0	14.5	5	191.50	016
	11,00/16.N.29.2,3	10.7	16	110	60	29	8.0	14.5	5	219.74	129
14	14,00/16.N.18.4,0	13.8	16	100	60	18	11.0	14.5	5	219.74	018
	14,00/16.N.38.4,0	13.8	16	120	60	38	11.0	14.5	5	219.74	138
16	16,00/16.N.22.4,3	15.7	16	100	60	22	11.0	14.5	5	191.50	022
	16,00/16.N.42.4,3	15.7	16	120	60	42	11.0	14.5	5	219.74	142

Spare parts

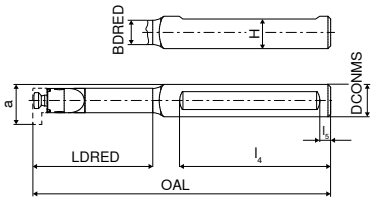

Key D

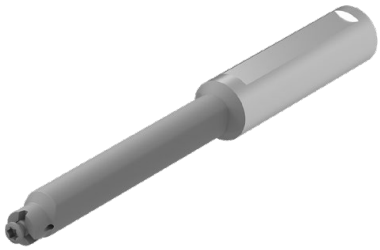

Clamping screw

Size		Y7 Article no. 80 950 ... £			Y5 Article no. 73 082 ... £	
08	T08	10.30	110	M2,6	7.14	002
09	T08	10.30	110	M2,6	7.14	002
11	T10	12.05	112	M3,5	7.14	003
14	T15	12.26	113	M4	7.14	004
16	T20	13.11	114	M5	7.14	005

12

MiniCut – Solid Carbide Tool holder – vibration damped



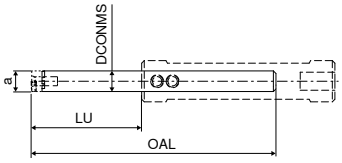


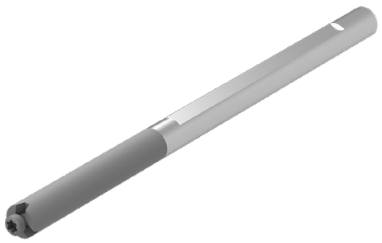
Size	Designation	a	DCONMS $_{f7}$	OAL	l_4	LDRED	BDRED	H	l_5	Y5 Article no. 73 520 ...	
		mm	mm	mm	mm	mm	mm	mm	mm	£	
08	8,00/12.N.21.1,0 HM	7.8	12	80	48	21	6.0	11.0	5	309.81	021
	8,00/12.N.30.1,0 HM	7.8	12	90	48	30	6.0	11.0	5	335.03	030
	8,00/12.N.42.1,0 HM	7.8	12	100	48	42	6.0	11.0	5	394.16	042
	8,00/12.N.50.1,0 HM	7.8	12	115	48	50	6.0	11.0	5	450.29	050
09	9,00/12.N.22.1,0 HM	8.6	12	90	60	22	7.4	11.0	5	311.34	222
	9,00/12.N.30.2,0 HM	8.6	12	98	60	30	7.4	11.0	5	363.22	230
	9,00/12.N.42.3,0 HM	8.6	12	110	60	42	7.4	11.0	5	408.63	242
	9,00/12.N.56.4,0 HM	8.6	12	122	60	56	7.4	11.0	5	462.68	256
11	11,00/12.N.29.2,3 HM	10.7	12	95	60	29	8.0	10.5	5	309.81	129
	11,00/12.N.42.2,3 HM	10.7	12	110	60	42	8.0	10.5	5	335.03	142
	11,00/12.N.56.2,3 HM	10.7	12	120	60	56	8.0	10.5	5	394.16	156
	11,00/12.N.64.2,3 HM	10.7	12	130	60	64	8.0	10.5	5	450.29	164
14	14,00/12.N.34.4,0 HM	13.8	12	100	60	34	11.0	10.5	5	377.05	234
	14,00/12.N.45.4,0 HM	13.8	12	110	60	45	11.0	10.5	5	424.92	245
	14,00/12.N.64.4,0 HM	13.8	12	130	60	64	11.0	10.5	5	501.02	264
	14,00/16.N.34.4,0 HM	13.8	16	100	60	34	11.0	14.5	5	441.90	334
	14,00/16.N.45.4,0 HM	13.8	16	110	60	45	11.0	14.5	5	503.75	345
	14,00/16.N.64.4,0 HM	13.8	16	130	60	64	11.0	14.5	5	579.41	364
	14,00/16.N.75.4,0 HM	13.8	16	145	60	75	11.0	14.5	5	618.99	375
16	16,00/12.N.40.4,3 HM	15.7	12	130	60	40	11.0	10.5	5	399.71	440
	16,00/12.N.56.4,3 HM	15.7	12	130	60	56	11.0	10.5	5	424.92	456
	16,00/12.N.80.4,3 HM	15.7	12	150	60	80	11.0	10.5	5	501.02	480
	16,00/16.N.40.4,3 HM	15.7	16	130	60	40	11.0	14.5	5	486.93	540
	16,00/16.N.56.4,3 HM	15.7	16	130	60	56	11.0	14.5	5	503.75	556
	16,00/16.N.80.4,3 HM	15.7	16	150	60	80	11.0	14.5	5	579.41	580

Spare parts

Size	Y7  Key D Article no. 80 950 ... £		Y5  Clamping screw Article no. 73 082 ... £	
08	T08	10.30 110	M2,6	7.14 002
09	T08	10.30 110	M2,6	7.14 002
11	T10	12.05 112	M3,5	7.14 003
14	T15	12.26 113	M4	7.14 004
16	T20	13.11 114	M5	7.14 005

MiniCut – HM – Flexoholder





Size	Designation	DCONMS mm	OAL mm	LU mm	a mm	Y5 Article no. 73 525 ...	£	
08	8,0/6.N16/2	6	65	18	8		438.90	818
	8,0/6.N40/4	6	103	40	8		499.43	840
11	11,0/8.N20/2	8	79	20	11		555.65	120 1)
	11,0/8.N50/4	8	129	50	11		631.32	150 1)

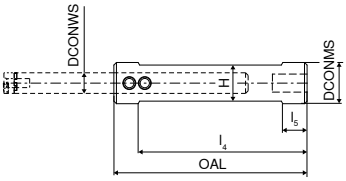
1) with thro' coolant





Spare parts Size		Y7 Article no. 80 950 ... £			Y5 Article no. 73 082 ... £	
08	T08	10.30	110	M2,6	7.14	002
11	T10	12.05	112	M3,5	7.14	003

MiniCut – Base holder for solid carbide Flexoholder





Size	Designation	DCONWS mm	DCONMS mm	H mm	OAL mm	l_4 mm	l_5 mm	Y5 Article no. 73 526 ... £	
08	8/16.75	6	16	14	75	55	10	263.77	816
	8/20.90	6	20	18	90	70	10	263.77	820
11	11/16.75	8	16	14	75	55	10	263.77	116
	11/20.90	8	20	18	90	70	10	263.77	120



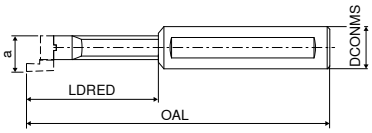


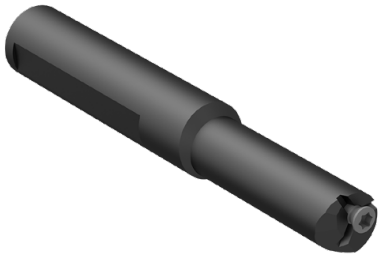
Spare parts for Article no.		2A/28 Article no. 70 950 ... £			Y5 Article no. 73 082 ... £	
73 526 816	SW2,5	2.23	175	M5x0,5x6	4.60	010
73 526 820	SW2,5	2.23	175	M5x0,5x6	4.60	010
73 526 116	SW2,5	2.23	175	M5x0,5x4	4.60	009
73 526 120	SW2,5	2.23	175	M5x0,5x6	4.60	010

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MiniCut – Steel holder

▲ for axial machining





Illustrations show right-hand versions

Size	Designation	a	DCONMS	OAL	LDRED	Left-hand Y5 Article no. 73 523 ... £		Right-hand Y5 Article no. 73 524 ... £	
		mm	mm	mm	mm				
14	14,0/16. R/L .25.1,0	13.5	16	90	25	235.67	025	235.67	025
	14,0/16. R/L .45.1,0	13.5	16	110	45	250.79	145	250.79	145



Key D

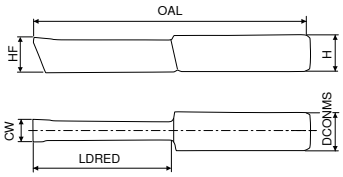


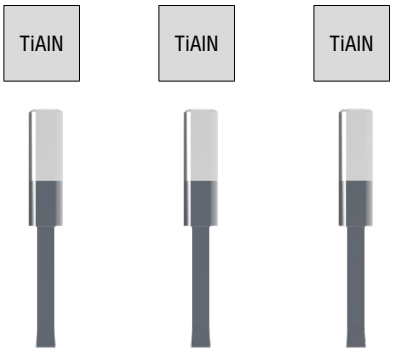
Clamping screw

Spare parts		Y7 Article no. 80 950 ... £			Y5 Article no. 73 082 ... £	
Size						
14	T15	12.26	113	M4	7.14	004

SlotCut – Inserts – DIN 138

▲ b_1 = Groove width





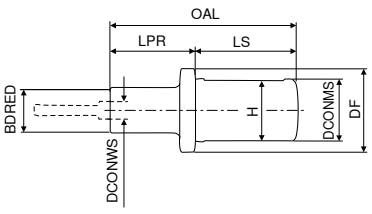
Designation	$b_{1\ P9/JS9/C11}$ mm	CW mm	HF mm	RE mm	OAL mm	LDRED mm	DAXN mm	$DCONMS_{h6}$ mm	H mm	clamping holder	Y5 Article no. 73 600 ... £		Y5 Article no. 73 601 ... £		Y5 Article no. 73 602 ... £	
NPU.0198.01.1	2	1.98	5.5	0.10	38	12.5	6	7	6.3	NHU					81.23	099
NPU.0200.01.1	2	2.01	5.5	0.10	38	12.5	6	7	6.3	NHU			81.23	099		
NPU.0210.03.1	2	2.10	5.5	0.35	38	12.5	6	7	6.3	NHU	81.23	098				
NPU.0298.01.1	3	2.98	6.2	0.10	38	12.5	7	7	6.3	NHU					81.23	100
NPU.0300.01.1	3	3.01	6.2	0.10	38	12.5	7	7	6.3	NHU			81.23	100		
NPU.0310.03.1	3	3.10	6.2	0.35	38	12.5	7	7	6.3	NHU	81.23	099				
NPU.0310.05.1	3	3.10	6.2	0.50	38	12.5	7	7	6.3	NHU	81.23	100				
NPU.0398.01.1	4	3.98	6.2	0.10	40	15.0	7	7	6.3	NHU					71.27	101
NPU.0398.02.2	4	3.98	6.2	0.20	50	25.0	7	7	6.3	NHU					93.50	102
NPU.0400.01.1	4	4.01	6.2	0.10	40	15.0	7	7	6.3	NHU			71.27	101		
NPU.0400.02.1	4	4.01	6.2	0.20	40	15.0	7	7	6.3	NHU			71.27	102		
NPU.0400.02.2	4	4.01	6.2	0.20	50	25.0	7	7	6.3	NHU			93.50	103		
NPU.0410.05.1	4	4.10	6.2	0.50	40	15.0	7	7	6.3	NHU	71.27	101				
NPU.0410.05.2	4	4.10	6.2	0.50	50	25.0	7	7	6.3	NHU	93.50	102				
NPU.0498.02.2	5	4.98	5.8	0.20	50	25.0	7	7	6.3	NHU					93.50	103
NPU.0500.02.2	5	5.01	5.8	0.20	50	25.0	8	7	6.3	NHU			93.50	104		

Tolerance **C 11** for 73 600 ..., Tolerance **JS 9** for 73 601 ..., Tolerance **P 9** for 73 602 ...

SlotCut – Toolholder for broaching inserts

Scope of supply:

Tool holder with clamping screw, without insert





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Designation	DCONWS mm	BDRED mm	$DCONMS_{g6}$ mm	DF mm	OAL mm	LS mm	LPR mm	H mm	Inserts	Y5 Article no. 73 610 ... £	
NHU.25	7	18	25	33	73	40	33	23	NPU	389.33	025
NHU.32	7	20	32	40	73	40	33	30	NPU	407.98	032



2A/28
Key I

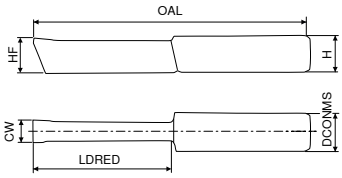


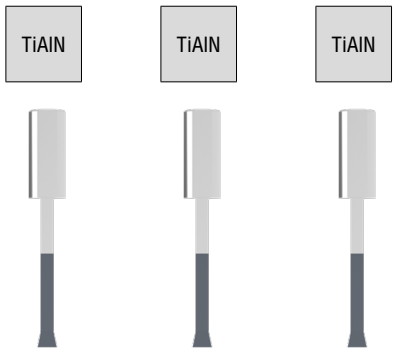
Y5
Clamping screw

Spare parts for Article no.		2A/28 Article no. 70 950 ... £		Y5 Article no. 73 082 ... £	
73 610 025	SW2,5	2.23	175	M5x6	5.74	001
73 610 032	SW2,5	2.23	175	M5x6	5.74	001

SlotCut – Inserts – DIN 138

▲ b_1 = Groove width





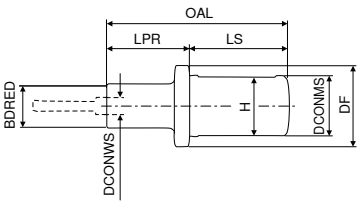
Designation	$b_{1\ JS\,9/P\,9/C\,11}$	CW	HF	RE	OAL	LDRED	DAXN	DCONMS $_{h6}$	H	clamping holder	Y5 Article no. 73 606 ...		Y5 Article no. 73 607 ...		Y5 Article no. 73 608 ...	
	mm	mm	mm	mm	mm	mm	mm	mm	mm		£		£		£	
NP10.398.02.2	4	3.98	9	0.2	50	25	10	10	9.2	NH 10			114.01	**101**		
NP10.398.02.3	4	3.98	9	0.2	66	41	10	10	9.2	NH 10			142.50	**102**		
NP10.400.02.2	4	4.01	9	0.2	50	25	10	10	9.2	NH 10					114.01	**101**
NP10.400.02.3	4	4.01	9	0.2	66	41	10	10	9.2	NH 10					142.50	**102**
NP10.410.05.2	4	4.10	9	0.5	50	25	10	10	9.2	NH 10	114.01	**101**				
NP10.410.05.3	4	4.10	9	0.5	66	41	10	10	9.2	NH 10	142.50	**102**				
NP10.498.02.2	5	4.98	9	0.2	50	25	10	10	9.2	NH 10			114.01	**103**		
NP10.498.02.3	5	4.98	9	0.2	66	41	10	10	9.2	NH 10			142.50	**104**		
NP10.500.02.2	5	5.01	9	0.2	50	25	10	10	9.2	NH 10					114.01	**103**
NP10.500.02.3	5	5.01	9	0.2	66	41	10	10	9.2	NH 10					142.50	**104**
NP10.510.05.2	5	5.10	9	0.5	50	25	10	10	9.2	NH 10	114.01	**103**				
NP10.510.05.3	5	5.10	9	0.5	66	41	10	10	9.2	NH 10	142.50	**104**				

Tolerance **C 11** for 73 606 ..., Tolerance **P 9** for 73 607 ..., Tolerance **JS 9** for 73 608 ...

SlotCut – Toolholder for Cutting Inserts

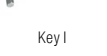
Scope of supply:

Tool holder with clamping screw, without insert





Designation	DCONWS	BDRED	DCONMS $_{g6}$	DF	OAL	LS	LPR	H	Inserts	Y5 Article no. 73 612 ...	
	mm	mm	mm	mm	mm	mm	mm	mm		£	
NH10.0025.1	10	20	25	33	73	40	33	23	NP10	443.18	**025**
NH10.0032.1	10	20	32	40	73	40	33	30	NP10	443.18	**032**

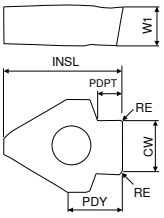


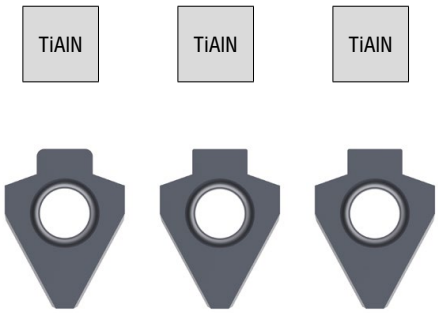


Spare parts for Article no.	2A/28 Article no. 70 950 ...		Y5 Article no. 70 950 ...	
	£		£	
73 612 032	SW03 2.23	**176**	M6x5,5 7.14	**031**
73 612 025	SW03 2.23	**176**	M6x5,5 7.14	**031**

SlotCut – Inserts – DIN 138

▲ b_1 = Groove width





Designation	$b_{1\ P9/JS9/C11}$	CW	RE	PDY	INSL	PDPT	DAXN	W1	clamping holder	Y5 Article no. 73 603 ...		Y5 Article no. 73 604 ...		Y5 Article no. 73 605 ...	
	mm	mm	mm	mm	mm	mm	mm	mm		£		£		£	
NV15.0398.02	4	3.98	0.20	6.5	13.0	2.3	15	3.2	NHV 15					74.84	110
NV15.0401.02	4	4.01	0.20	6.5	13.0	2.3	15	3.2	NHV 15			74.84	110		
NV15.0410.050	4	4.10	0.50	6.5	13.0	2.2	15	3.2	NHV 15	74.84	108				
NV15.0498.02	5	4.98	0.20	6.5	13.0	2.8	15	3.2	NHV 15					74.84	111
NV15.0501.02	5	5.01	0.20	6.5	13.0	2.8	15	3.2	NHV 15			74.84	111		
NV15.0510.050	5	5.10	0.50	6.5	13.0	2.5	15	3.2	NHV 15	74.84	109				
NV15.0598.02	6	5.98	0.20	6.5	13.0	3.3	15	3.2	NHV 15					74.84	112
NV15.0601.02	6	6.01	0.20	6.5	13.0	3.3	15	3.2	NHV 15			74.84	112		
NV15.0612.085	6	6.12	0.85	6.5	13.0	2.6	15	3.2	NHV 15	74.84	110				
NPV.0498.02	5	4.98	0.20	8.0	17.3	2.7	22	5.3	NHV 22					72.69	100
NPV.0501.02	5	5.01	0.20	8.0	17.3	2.7	22	5.3	NHV 22			72.69	100		
NPV.0598.02	6	5.98	0.20	8.0	17.3	3.4	22	5.3	NHV 22					65.83	101
NPV.0601.02	6	6.01	0.20	8.0	17.3	3.4	22	5.3	NHV 22			65.83	101		
NPV.0612.085	6	6.12	0.85	8.0	17.3	2.6	22	5.3	NHV 22	65.83	101				
NPV.0713.085	7	7.13	0.85	8.0	17.3	3.3	22	5.3	NHV 22	65.83	102				
NPV.0798.02	8	7.98	0.20	8.0	17.3	4.1	22	5.3	NHV 22/30					65.83	102
NPV.0801.02	8	8.01	0.20	8.0	17.3	4.1	22	5.3	NHV 22/30			65.83	102		
NPV.0813.105	8	8.13	1.05	8.0	17.3	3.4	22	5.3	NHV 22/30	65.83	103				
NPV.0998.03	10	9.98	0.30	8.0	17.3	4.2	30	5.3	NHV 30					65.83	103
NPV.1001.03	10	10.01	0.30	8.0	17.3	4.2	30	5.3	NHV 30			65.83	103		
NPV.1013.105	10	10.13	1.05	10.9	20.2	4.2	40	5.3	NHV 38	65.83	104				
NPV.1197.03	12	11.97	0.30	10.9	20.2	5.7	40	5.3	NHV 38					72.69	104
NPV.1202.05	20	12.02	0.50	10.9	20.2	8.5	40	5.3	NHV 38			72.69	105		
NPV.1202.03	12	12.02	0.30	10.9	20.2	5.7	40	5.3	NHV 38			72.69	104		
NPV.1215.135	12	12.15	1.35	10.9	20.2	5.1	40	5.3	NHV 38	72.69	105				
NPV.1215.175	16	12.15	1.75	10.9	20.2	6.6	40	5.3	NHV 38	72.69	106				
NPV.1215.225	24	12.15	2.25	10.9	20.2	8.5	40	5.3	NHV 38	72.69	107				
NPV.1397.03	14	13.97	0.30	10.9	20.1	7.5	45	5.3	NHV 45					84.79	106
NPV.1402.03	14	14.02	0.30	10.9	20.1	7.5	45	5.3	NHV 45			84.79	106		
NPV.1597.03	16	15.97	0.30	10.9	20.1	7.5	45	5.3	NHV 45					84.79	107
NPV.1602.03	16	16.02	0.30	10.9	20.1	7.5	45	5.3	NHV 45			84.79	107		
NPV.1797.05	18	17.97	0.50	10.9	20.1	9.5	45	5.3	NHV 45					84.79	108
NPV.1802.05	18	18.02	0.50	10.9	20.1	9.5	45	5.3	NHV 45			84.79	108		
NPV.1997.05	20	19.97	0.50	10.9	20.1	10.0	45	5.3	NHV 45					84.79	109
NPV.2002.05	20	20.02	0.50	10.9	20.1	10.0	45	5.3	NHV 45			84.79	109		

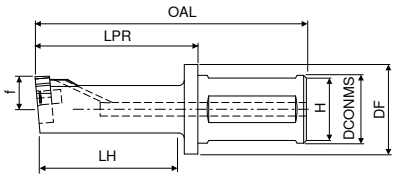
Tolerance **C 11** for 73 603 ..., Tolerance **JS 9** for 73 604 ..., Tolerance **P 9** for 73 605 ...

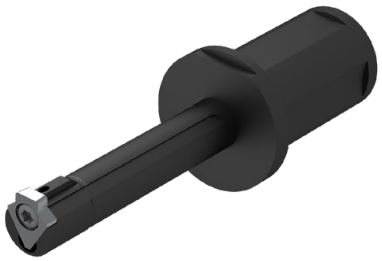
12

SlotCut – Toolholder for inserts

Scope of supply:
Tool holder with clamping screw, without insert



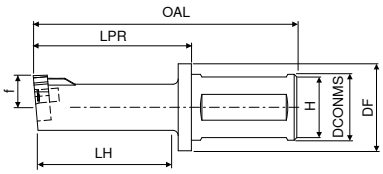


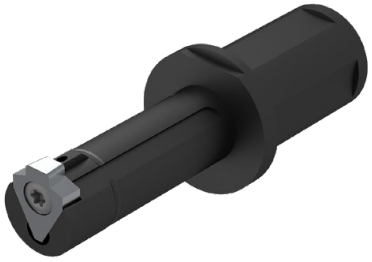


Designation	DCONMS g6	DAXN	DF	OAL	LH	LPR	H	f	Inserts	Y5 Article no. 73 613 ...	
	mm	mm	mm	mm	mm	mm	mm	mm		£	
NHV.15.1	25	15	33	75	25	35	23	8.4	NV15	380.51	**025**
NHV.15.2	25	15	33	90	40	50	23	8.4	NV15	417.27	**125**
NHV.15.3	25	15	33	110	60	70	23	8.4	NV15	475.65	**225**

SlotCut – Toolholder for inserts

Scope of supply:
Tool holder with clamping screw, without insert





Designation	DCONMS g6	DAXN	DF	OAL	LH	LPR	H	f	Inserts	Y5 Article no. 73 611 ...	
	mm	mm	mm	mm	mm	mm	mm	mm		£	
NHV.22	25	22	33	100	50	60	23	12.0	NPV	365.07	**025**
NHV.30	32	30	45	100	50	60	30	16.5	NPV	365.07	**032**
NHV.30	32	30	45	125	75	85	30	16.5	NPV	416.13	**532**
NHV.38	32	38	45	100	50	60	30	22.0	NPV	365.07	**132**
NHV.38	32	38	45	125	75	85	30	22.0	NPV	416.13	**632**
NHV.45	40	45	55	120	50	60	38	24.0	NPV	562.14	**040**
NHV.45	40	45	55	175	105	115	38	24.0	NPV	761.03	**140**
NHV.45	40	45	55	225	155	165	38	24.0	NPV	858.32	**240**

Spare parts DCONMS g6		Y7  Key D Article no. 80 950 ... £			Y5  Clamping screw Article no. 73 082 ... £	
25	T20	13.11	**114**	M5x13	7.50	**007**
32	T20	13.11	**114**	M5x13	7.50	**007**
40	T20	13.11	**114**	M5x13	7.50	**007**

Material examples referring to the cutting data tables

	Index	Material	Strength N/mm² / HB / HRC	Material number	Material designation	Material number	Material designation	Material number	Material designation
P	1.1	General construction steel	< 800 N/mm²	1.0402	EN3B				
	1.2	Free cutting steel	< 800 N/mm²	1.0711	EN1A				
	1.3	Hardened steel, non alloyed	< 800 N/mm²	1.0401	EN32C				
	1.4	Alloyed hardened steel	< 1000 N/mm²	1.7325	25 CD4				
	1.5	Tempering steel, unalloyed	< 850 N/mm²	1.5752	EN36	1.0535	EN9		
	1.6	Tempering steel, unalloyed	< 1000 N/mm²	1.6582	EN24				
	1.7	Tempering steel, alloyed	< 800 N/mm²	1.7225	EN19				
	1.8	Tempering steel, alloyed	< 1300 N/mm²	1.8515	EN40B				
	1.9	Steel castings	< 850 N/mm²	0.9650	G-X 260 Cr 27	1.6750	GS-20 NiCrMo 3.7	1.6582	GS-34 CrNiMo 6
	1.10	Nitriding steel	< 1000 N/mm²	1.8509	EN41B				
	1.11	Nitriding steel	< 1200 N/mm²	1.1186	EN8	1.1160	EN14A		
	1.12	Roller bearing steel	< 1200 N/mm²	1.3505	534A99				
	1.13	Spring steel	< 1200 N/mm²		EN45		EN47		EN43
	1.14	High-speed steel	< 1300 N/mm²	1.3343	M2	1.3249	M34		
	1.15	Cold working tool steel	< 1300 N/mm²	1.2379	D2	1.2311	P20		
	1.16	Hot working tool steel	< 1300 N/mm²	1.2344	H13				
M	2.1	Cast steel and sulphured stainless steel	< 850 N/mm²	1.4581	318				
	2.2	Stainless steel, ferritic	< 750 N/mm²	1.4000	403				
	2.3	Stainless steel, martensitic	< 900 N/mm²	1.4057	EN57				
	2.4	Stainless steel, ferritic / martensitic	<1100 N/mm²	1.4028	EN56B				
	2.5	Stainless steel, austenitic / ferritic	< 850 N/mm²	1.4542	17-4PH				
	2.6	Stainless steel, austenitic	< 750 N/mm²	1.4305	303	1.4401	316	1.4301	304
	2.7	Heat resistant steel	< 1100 N/mm²	1.4876	Incoloy 800				
K	3.1	Grey cast iron with lamellar graphite	100–350 N/mm²	0.6015	Grade 150	0.6020	Grade 220	0.6025	Grade 260
	3.2	Grey cast iron with lamellar graphite	300–500 N/mm²	0.6030	Grade 300	0.6035	Grade 350	0.6040	Grade 400
	3.3	Gray cast iron with spheroidal graphite	300–500 N/mm²	0.7040	SG 400-12	0.7043	SG 370-17	0.7050	SG 500-7
	3.4	Gray cast iron with spheroidal graphite	500–900 N/mm²	0.7060	SG 600-3	0.7070	SG 700-2	0.7080	SG 800-2
	3.5	White malleable cast iron	270–450 N/mm²	0.8035	GTW-35	0.8045	GTW-45		
	3.6	White malleable cast iron	500–650 N/mm²	0.8055	GTW-55	0.8065	GTW-65		
	3.7	Black malleable cast iron	300–450 N/mm²	0.8135	GTS-35	0.8145	GTS-45		
	3.8	Black malleable cast iron	500–800 N/mm²	0.8155	GTS-55	0.8170	GTS-70		
N	4.1	Aluminium (non alloyed, low alloyed)	< 350 N/mm²	3.0255	1050 A	3.0275	1070 A	3.0285	1080 A (A8)
	4.2	Aluminium alloys < 0.5 % Si	< 500 N/mm²	3.1325	2017 A (AU4G)	3.4335	7005 (AZ5G)	3.4365	7075 (AZ5GU)
	4.3	Aluminium alloy 0.5–10 % Si	< 400 N/mm²	3.2315	A- G S1	3.2373	A-S9 G	3.2151	A-S 6 U4
	4.4	Aluminium alloys 10–15 % Si	< 400 N/mm²	3.2581	A-S12	3.2583	A-S12 U		
	4.5	Aluminum alloys > 15 % Si	< 400 N/mm²		A-S18	A-S17 U4			
	4.6	Copper (non alloyed, low alloyed)	< 350 N/mm²	2.0040	Cu-c1	2.0060	Cu-a1	2.0090	Cu-b1
	4.7	Copper wrought alloys	< 700 N/mm²	2.1247	Cub2 (Berylium Copper)	2.0855	CuN2S (Nickel Copper)	2.1310	CU-Fe2P
	4.8	Special copper alloys	< 200 HB	2.0916	Cu-A5	2.1525	Cu-S3 M		Ampco 8 (Cu-A6Fe2)
	4.9	Special copper alloys	< 300 HB	2.0978	Cu-Al11 Fe5 Ni5)		Ampco 18 (Cu- A10 Fe3)		
	4.10	Special copper alloys	> 300 HB	2.1247	Cu Be2		Ampco M4		
	4.11	Short-chipping brass, bronze, red bronze	< 600 N/mm²	2.0331	Cu Zn36 Pb1,5	2.0380	Cu Zn39 Pb2 (Ms 56)	2.0410	Cu Zn44 Pb2
	4.12	Long-chipping brass	< 600 N/mm²	2.0335	Cu Zn 36 (Ms63)	2.1293	Cu Cr1 Zr		
	4.13	Thermoplastics		PE	PVC	PS	Polystyrene		Plexiglas
	4.14	Duroplastics		PF	Bakelite		Pertinax		
	4.15	Fibre-reinforced plastics			Carbon Fibre		Fibreglass		Aramid Fibre (Kevlar)
	4.16	Magnesium and magnesium alloys	< 850 N/mm²	3.5812	Mg A7 Z1	3.5662	Mg A9	3.5105	Mg Tr3 Z2 Zn 1
	4.17	Graphite			R8500X		R8650		Technograph 15
	4.18	Tungsten and tungsten alloys			W-Ni Fe (Densimet)		W- Ni Cu (Inermet)		Denal
	4.19	Molybdenum and molybdenum alloys			TZM		MHQ		Mo W
S	5.1	Pure nickel		2.4066	Ni99 (Nickel 200)	2.4068	Lc Ni99 (Nickel 201)		
	5.2	Nickel alloys		1.3912	Fe-Ni36 (Invar)	1.3917	Fe -Ni42 (N42)	1.3922	Fe-Ni48 (N48)
	5.3	Nickel alloys	< 850 N/mm²	2.4375	Ni Cu30 Al (Monel K500)	2.4360	Ni Cu30Fe (Monel 400)	2.4668	
	5.4	Nickel molybdenum alloys		2.4600	Ni Mo30Cr2 (Hastelloy B4)	2.4617	Ni Mo28 (Hastelloy B2)	2.4819	Ni Mo16Cr16 Hastell. C276
	5.5	Nickel-chromium alloys	< 1300 N/mm²	2.4951	Ni Cr20TiAl (Nimonic 80A)	2.4858	Ni Cr21Mo (Inconel 825)	2.4856	Ni Cr22Mo9Nb Inconel 625
	5.6	Cobalt Chrome Alloys	< 1300 N/mm²	2.4964	Co Cr20 W15 Ni10		Co Cr20 Ni16 Mo7		Co Cr28 Mo 6
	5.7	Heat resistant alloys	< 1300 N/mm²	1.4718	Z45 C S 9-3	1.4747	Z80 CSN 20-02	1.4845	Z12 CN 25-20
	5.8	Nickel-cobalt-chromium alloys	< 1400 N/mm²	2.4851	Ni Cr23Fe (Inconel 601)	2.4668	Ni Cr19NbMo (Inconel 718)	2.4602	Ni Cr21Mo14 Hastelloy C22
	5.9	Pure titanium	< 900 N/mm²	3.7025	T35 (Titanium Grade 1)	3.7034	T40 (Titanium Grade 2)	3.7064	T60 (Titanium Grade 4)
	5.10	Titanium alloys	< 700 N/mm²		T-A6-Nb7 (367)		T-A5-Sn2-Mo4-Cr4 (Ti17)		T-A3-V2,5 (Gr18)
	5.11	Titanium alloys	< 1200 N/mm²	3.7165	T-A6-V4 (Ta6V)		T-A4-3V-Mo2-Fe2 (SP700)		T-A5-Sn1-Zr1-V1-Mo (Gr32)
H	6.1		< 45 HRC						
	6.2		46–55 HRC						
	6.3	Tempered steel	56–60 HRC						
	6.4		61–65 HRC						
	6.5		65–70 HRC						

Cutting data appoximate values

Index	UltraMini K10F	UltraMini K10F-TiN	UltraMini K10-TiAN	UltraMini DPX 57S	MiniCut CWX500	UltraMini TiAlN+	MiniCut CBN
	v_c in m/min						
1.1	30–130	**30–180**	**80–200**	**80–200**	**80–200**		
1.2	30–130	**40–200**	**80–200**	**80–200**	**80–200**		
1.3	30–130	**40–180**	**80–200**	**80–200**	**80–200**		
1.4	15–90	**30–140**	**80–160**	**80–160**	**80–160**		
1.5	15–90	**30–100**		**80–140**			
1.6	15–90	**30–100**	**80–160**	**80–160**	**80–160**		
1.7	30–130	**30–100**	**80–160**	**80–160**	**80–160**		
1.8	15–90	**30–100**	**80–150**	**80–150**	**80–150**		
1.9	30–130	**40–200**	**80–200**	**80–200**	**80–200**		
1.10	15–90	**30–100**	**70–140**	**70–140**	**70–140**		
1.11	15–90	**30–100**	**70–140**	**70–140**	**70–140**		
1.12	15–90	**30–100**	**70–140**	**70–140**	**70–140**		
1.13							
1.14							
1.15	15–45	**30–100**					
1.16	15–45	**30–100**					
2.1		**30–100**	**80–160**	**80–160**	**80–160**		
2.2		**30–100**	**80–160**	**80–160**	**80–160**		
2.3		**30–100**	**80–160**	**80–160**	**80–160**		
2.4		**20–90**	**20–85**	**20–85**	**20–85**		
2.5		**20–65**	**20–75**	**20–75**	**20–75**		
2.6		**20–80**	**20–65**	**20–65**	**20–65**		
2.7		**20–80**	**20–65**	**20–65**	**20–65**		
3.1	30–110	70–150	**30–180**	**30–180**	**30–180**		
3.2	30–90	50–120	**30–150**	**30–150**	**30–150**		
3.3	25–110	30–130	**30–180**	**30–180**	**30–180**		
3.4	25–80	30–110	**30–120**	**30–120**	**30–120**		
3.5	30–110	30–100	**30–90**	**30–90**	**30–90**		
3.6	30–90	30–90	**20–80**	**20–80**	**20–80**		
3.7	30–110	30–100	**30–90**	**30–90**	**30–90**		
3.8	30–90	30–90	**20–80**	**20–80**	**20–80**		
4.1	**110–210**	100–600	**120–600**	**120–600**	**120–600**		
4.2	**90–200**	100–600	**120–600**	**120–600**	**120–600**		
4.3	**90–200**	100–500	**100–450**	**100–450**	**100–450**		
4.4	**50–140**	80–350	**70–300**	**70–300**	**70–300**		
4.5		80–200	**60–150**	**60–150**	**60–150**		
4.6	**50–140**	70–160	**60–150**	**60–150**	**60–150**		
4.7	**60–150**	80–180	**100–180**	**100–180**	**100–180**		
4.8	**50–140**	80–180	**90–180**	**90–180**	**90–180**		
4.9	**50–140**	80–180	**80–180**	**80–180**	**80–180**		
4.10	**50–140**	80–180	**80–180**	**80–180**	**80–180**		
4.11	**80–160**	100–200	**120–220**	**120–220**	**120–220**		
4.12	**50–120**	80–180	**70–150**	**70–150**	**70–150**		
4.13	**40–120**	70–160	**80–180**	**80–180**	**80–180**		
4.14							
4.15							
4.16							
4.17							
4.18	**15–70**						
4.19							
5.1		30–80	**30–80**	30–80	**30–80**		
5.2		18–75	**18–75**	18–75	**18–75**		
5.3		18–75	**18–75**	18–75	**18–75**		
5.4				40–70		**55–75**	
5.5		18–40	**18–40**	40–70	**18–40**	**55–75**	
5.6		18–40	**18–40**	40–70	**18–40**	**55–75**	
5.7		15–30	**15–30**	40–70	**15–30**	**55–75**	
5.8		15–30	**15–30**	40–70	**15–30**	**55–75**	
5.9		15–30	**15–30**	**70–150**	**15–30**		
5.10				**70–150**			
5.11				**70–150**			
6.1							
6.2						**70–100**	
6.3						**70–100**	**50**
6.4						**70–100**	**50**
6.5							

	UltraMini	MiniCut
	f in mm/rev.	
Internal turning and profiling	0,02–0,05	0,03–0,10
Internal turning and profiling – hard turning	0,02–0,06	0,03–0,10
Turning and profile turning – super alloys	0,02–0,08	
Internal turning	0,02–0,05	0,01–0,03
Back boring	0,02–0,04	0,03–0,10
Turning and chamfering	0,01–0,03	0,03–0,10
Pre-parting and chamfering	0,01–0,02	0,01–0,03
Groove turning	0,01–0,02	0,01–0,03
Internal Undercuts	0,01–0,03	0,03–0,08
Groove and profile turning	0,01–0,02	0,01–0,03
Axial grooving	0,02–0,05	0,02–0,05

The cutting data depends largely on the external conditions, e.g. stability of the tools and tool clamping, material and machine type.
The indicated values are possible cutting data which have to be increased or reduced according to the application conditions.

Cutting data standard values – 73 000 ... / 73 001 ...

Index	UltraMini DPX77S	Corner radius in mm			
		0,05	0,1	0,15	0,2
	v_c in m/min	f in mm/rev.			
1.1	80–200	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.2	80–200	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.3	80–200	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.4	80–160	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.5	80–140	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.6	80–160	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.7	80–160	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.8	80–150	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.9	80–200	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.10	70–140	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.11	70–140	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.12	70–140	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
1.13					
1.14					
1.15					
1.16					
2.1	80–160	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
2.2	80–160	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
2.3	80–160	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
2.4	20–85	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
2.5	20–75	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
2.6	20–65	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
2.7	20–65	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
3.1	30–180	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
3.2	30–150	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
3.3	30–180	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
3.4	30–120	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
3.5	30–90	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
3.6	20–80	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
3.7	30–90	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
3.8	20–80	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.1	120–600	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.2	120–600	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.3	100–450	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.4	70–300	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.5	60–150	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.6	60–150	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.7	100–180	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.8	90–180	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.9	80–180	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.10	80–180	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.11	120–220	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.12	70–150	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.13	80–180	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
4.14					
4.15					
4.16					
4.17					
4.18					
4.19					
5.1	30–80	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
5.2	18–75	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
5.3	18–75	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
5.4	40–70	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
5.5	40–70	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
5.6	40–70	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
5.7	40–70	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
5.8	40–70	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
5.9	40–70	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
5.10	40–70	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
5.11	40–70	0,015–0,03	0,02–0,06	0,02–0,08	0,02–0,12
6.1					
6.2					
6.3					
6.4					
6.5					

The cutting data depends largely on the external conditions, e.g. stability of the tools and tool clamping, material and machine type.
The indicated values are possible cutting data which have to be increased or reduced according to the application conditions.

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Broaching – Recommendations for Correct Use

SlotCut

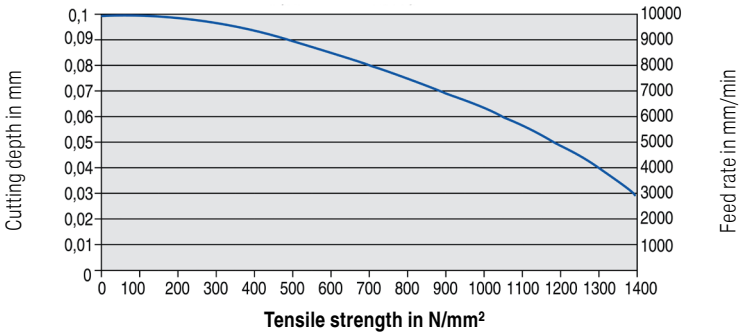
More and more often small and medium sized batch sizes are manufactured with precision grooves.

To directly machine such grooves in one set-up on one machine, it requires a special application of "Broaching" tools.

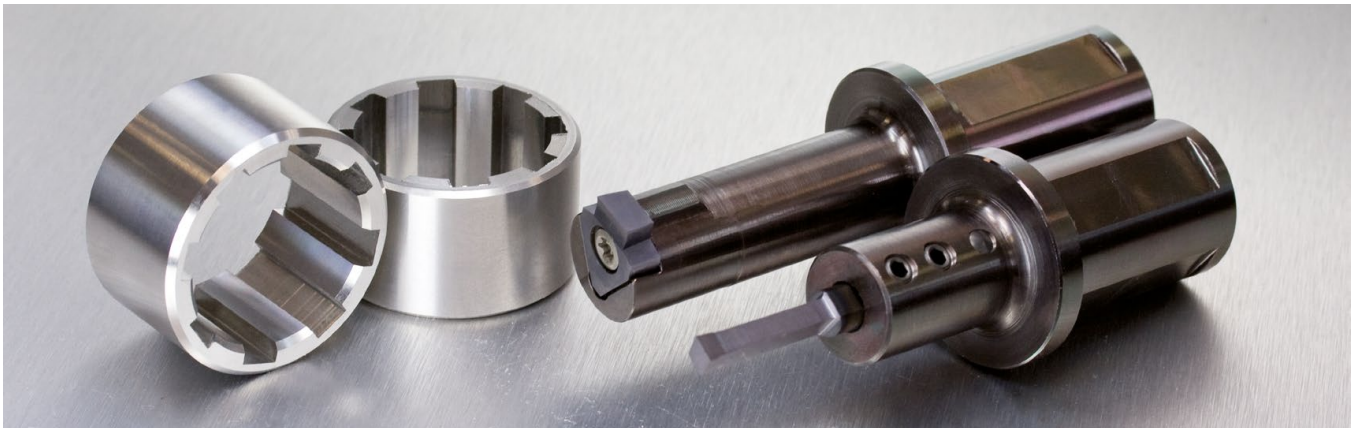
The SlotCut system can produce grooves with the most common groove tolerances.
To this end, there are four options. Two concepts are based on a solid carbide solution, which gives great success with small diameters.
For larger diameters, the concept with screw-on inserts is more suitable.

Broaching, on both lathes and machining centers is now economical, and provides highly accurate results in the shortest possible time.

Appoximate values when broaching



The data depends strongly on the conditions and represent only an appoximate value, factors such as machine stability, application and material may require adjustment of the data upward or downward.



Tips for the User

- Avoid interrupted cuts.
- Where possible, orientate the part so the groove is at the top, so the chips fall away!
- Ensure there is a relief at the end of the groove.
- Lift the tool out of the groove when retracting.
- Use coolant.
  This will increase tool life and surface quality.
- Adjustment of the tool is essential, therefore the tool diameter must be considered.



Symbol explanation

UltraMini

 Internal turning and profiling

 Back boring

 Internal Undercuts

 High-feed turning

 Turning and chamfering

 Groove and profile turning

 Turning and profile turning – super alloys

 Pre-parting and chamfering

 Internal thread turning

 Internal turning

 Groove turning

 Axial grooving

MiniCut

 Internal turning and profiling

 Pre-parting and chamfering

 Internal thread turning

 Internal turning

 Groove turning

 Axial grooving

 Back boring

 Internal Undercuts

 Turning and chamfering

 Groove and profile turning

Coatings

TiAlN+
- ▲ TiAlN multilayer coating
- ▲ Maximum application temperature: 1000 °C

TiN
- ▲ TiN coating
- ▲ Maximum application temperature: 450 °C

TiAlN
- ▲ TiAlN multilayer coating
- ▲ Maximum application temperature: 900 °C

CWX500
- ▲ Carbide, TiAlN-coated
- ▲ ISO | **K30**
- ▲ The universal carbide grade for almost all materials

DXP77S
- ▲ TiAlN+X-coating
- ▲ Maximum application temperature: 900 °C

DPX57S
- ▲ TiCrN coating
- ▲ Maximum application temperature: 900 °C

Thread types

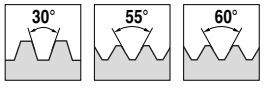
M Metric ISO standard thread

MF Metric ISO fine thread

G Whitworth thread

Tr Metric ISO trapezoidal fine thread

Thread flank angle



Coolant

 with thro‘ coolant