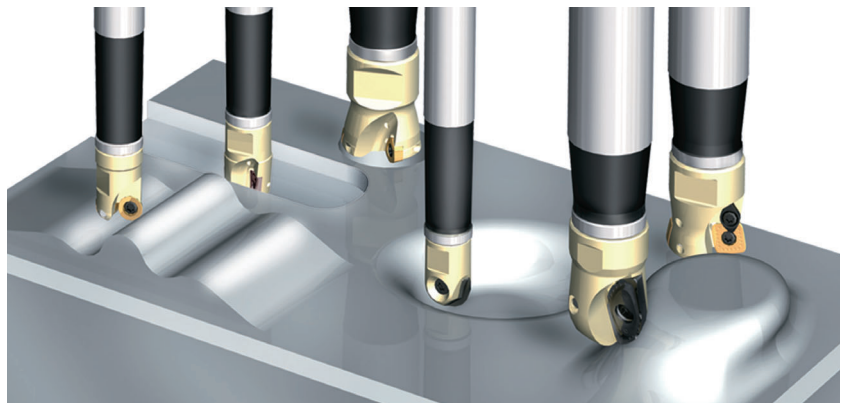


QCH series

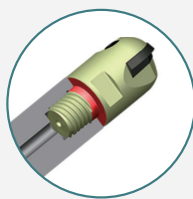
Indexable heads

- Quick tool change reduces the set-up time and therefore the machine breakdown.
- Stable force-locking connection.
- Increased flexibility in production.
- All indexable heads are designed for the application with inner cooling (except QCH-ZOHX).

Machining operations



Force-locking connection

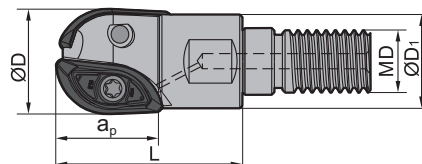
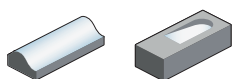


- Extensions available in steel and solid carbide.



Profile milling

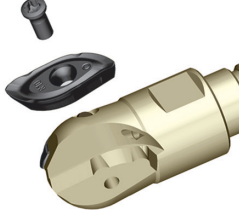
QCH - XPHT



Article	*	Stock	Dimensions [mm]					Teeth	kg	Inserts
			ØD	ØD ₁	a _p	L	MD			
QCH-16-XPHT16-M10	●		16	17	16	28	10	2	0.036	XPHT16
QCH-20-XPHT20-M12	○		20	19	20	30	12	2	0.051	XPHT20
QCH-25-XPHT25-M12	●		25	24	25	35	12	2	0.071	XPHT25
QCH-30-XPHT30-M16	●		30	29	30	45	16	2	0.14	XPHT30
QCH-32-XPHT32-M16	●		32	30	32	45	16	2	0.162	XPHT32

● Ex stock ○ On demand

* With internal cooling

Spare parts							
	Insert	XPHT16	XPHT20	XPHT25	XPHT30	XPHT32	
	ØD	16	20	25	30	32	
	Screw (insert)	I60M2.5*6.5 (1.0 Nm)		I60M4*10 (3.4 Nm)	I60M5*13.2 (6.7 Nm)	I60M5*13.2 (6.7 Nm)	
	Screw (insert)		I60M3.5*08TT (2.7 Nm)				
	Wrench (insert)		WT10IP				
	Wrench (insert)				WT20IT	WT20IT	
	Wrench (insert)	WT07P					
	Wrench (insert)			WT15S			

System code > B26

Grade selection > B24

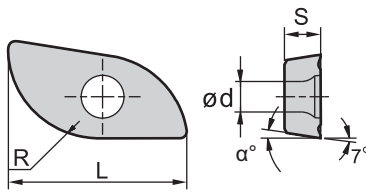
Technical info > B463

Cutting data > B224

Milling inserts

-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

XPHT	L	S	d
16	16	3.18	3.1
20	20	3.97	4
25	25	4.76	4.7
30	30	6.35	5.8
32	32	6.35	5.8

XP** milling insert			HC ¹ (CVD)								HC ¹ (PVD)						HT	HC ²	HW				
	P																						
	M																						
	K																						
	N																						
	S																						
	H																						
ISO	R	α	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	XPHT16R0803-GM	8	9														●						
	XPHT20R10T3-GM	10	9														●						
	XPHT25R1204-GM	12.5	9														●						
	XPHT30R1506-GM	15	11														●						
	XPHT32R1606-GM	16	9														●						

● Ex stock ○ On demand

HC¹ Coated carbide
 HT Uncoated cermet
 HC² Coated cermet
 HW Uncoated carbide

A

Turning

B

Milling

C

Drilling

D

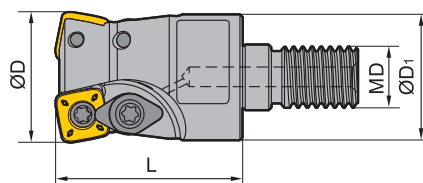
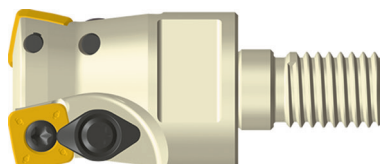
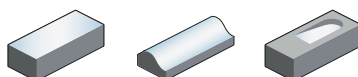
Technical
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High-feed mills

QCH - SDMT Kr: 15°



Article	*	Stock	Dimensions [mm]				Teeth	kg	Inserts
			ØD	ØD ₁	L	MD			
QCH-20-SDMT06-M10-03	●		20	19	30	10	3	0.058	SDMT06T2
QCH-25-SDMT06-M12-04	●		25	24	35	12	4	0.097	
QCH-32-SDMT06-M16-05	○		32	30	45	16	5	0.183	
QCH-25-SDMT09-M12-02	○		25	24	35	12	2	0.088	SDMT09T3
QCH-30-SDMT09-M16-03	●		30	29	45	16	3	0.176	
QCH-35-SDMT09-M16-03	○		35	30	45	16	3	0.216	
QCH-32-SDMT12-M16-02	●		32	30	45	16	2	0.175	SDMT1204
QCH-35-SDMT12-M16-02	○		35	30	45	16	2	0.2	
QCH-40-SDMT12-M16-03	○		40	30	45	16	3	0.3	

● Ex stock ○ On demand

* With internal cooling

Spare parts					
	Insert	SDMT06T2	SDMT09T3	SDMT1204	
	ØD	20-35	25-35	32-40	
	Clamp		WD-204	WD-204	
	Screw (clamp)			I60M4*8.4 (3.4 Nm)	
	Screw (clamp)		I60M3.5*08TT (2.7 Nm)		
	Screw (insert)	I60M2.2*5.5 (0.8 Nm)	I60M4*8.4 (3.4 Nm)	I60M4*8.4 (3.4 Nm)	
	Wrench (clamp)		WT10IP	WT15IP	
	Wrench (insert)	WT07IP	WT15IP	WT15IP	

System code > B26

Grade selection > B24

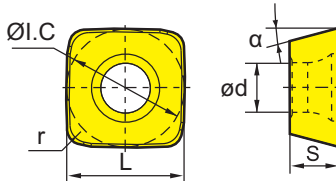
Technical info > B463

Cutting data > B224

Milling inserts

-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

SDMT	L	I.C	S	d
06 T2	6.35	6.35	2.58	2.5
09 T3	9.525	9.525	3.97	4
12 04	12.7	12.7	4.76	4.4

SD** milling insert				HC ¹ (CVD)								HC ¹ (PVD)				HT	HC ²	HW						
		P																						
		M																						
		K																						
		N																						
		S																						
		H																						
ISO		r	α	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	SDMT06T208-DM	0.8	15						○							○								
	SDMT09T312-DM	1.2	15	●					●	○						●	●							
	SDMT120412-DM	1.2	15	●					●	○						●	○							
	SDMT06T208-PM	0.8	15	●		●									●									
	SDMT09T312-PM	1.2	15				●								●	●								
	SDMT120412-PM	1.2	15				●								●	●								

● Ex stock ○ On demand

HC¹ Coated carbide
 HT Uncoated cermet
 HC² Coated cermet
 HW Uncoated carbide

A

Turning

B

Milling

C

Drilling

D

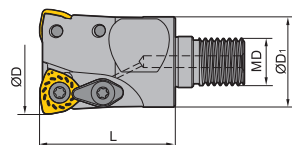
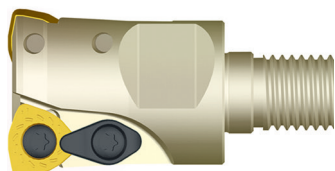
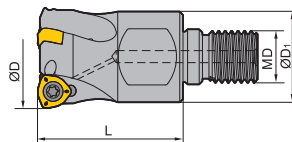
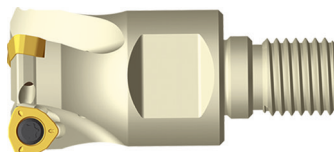
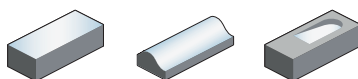
Technical
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High-feed mills

QCH - WPGT Kr: 11°-22°



Article	*	Stock	Dimensions [mm]				Teeth	kg	Inserts
			ØD	ØD ₁	L	MD			
QCH-20-WPGT05-M10-02	○		20	18	30	10	2	0.056	WPGT0503
QCH-25-WPGT06-M12-02	○		25	21	35	12	2	0.097	
QCH-32-WPGT06-M16-03	●		32	29	43	16	3	0.185	
QCH-35-WPGT06-M16-03	●		35	30	45	16	3	0.201	WPGT0604
QCH-42-WPGT06-M16-04	○		42	29	43	16	4		
QCH-35-WPGT08-M16-02	●		35	30	45	16	2	0.196	WPGT0806

● Ex stock ○ On demand

* With internal cooling

variabler Einstellwinkel (Einstellwinkel ist hier plattengrößenabhängig)- lead angle:

WPGT05 insert: 16°; WPGT06 insert: 22°; WPGT08 insert: 11°; WPGT09 insert: 21°

Spare parts					
Insert	WPGT0503	WPGT0604	WPGT0806		
ØD	20	25-42	35		
Clamp			WD-208		
Screw (clamp)			I60M5*13 (6.7 Nm)		
Screw (insert)		I60M4*8.4 (3.4 Nm)	I60M5*13 (6.7 Nm)		
Screw (insert)	I60M3.5*08TT (2.7 Nm)				
Wrench (clamp)			WT20IT		
Wrench (insert)			WT20IT		
Wrench (insert)	WT10P	WT15P			

System code > B26

Grade selection > B24

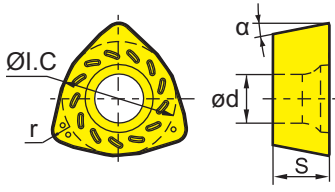
Technical info > B463

Cutting data > B224

Milling inserts

-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

WPGT	I.C	S	d
05 03	7.94	3.5	4
06 04	9.525	4.2	4.4
08 06	12.85	6.35	5.5

WP** positive insert		HC ¹ (CVD)						HC ¹ (PVD)				HT	HC ²	HW									
		P																					
		M																					
		K																					
		N																					
		S																					
		H																					
ISO		r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	WPGT050315ZSR-PM	1.5												●									
	WPGT060415ZSR-PM	1.5	●											●									
	WPGT080615ZSR-PM	1.5	●											●									
	WPGT050315ZSR	1.5	●					●								●							
	WPGT060415ZSR	1.5	●					●						●		●							
	WPGT080615ZSR	1.5	●					●						●		●							

● Ex stock ○ On demand

HC¹ Coated carbide
 HT Uncoated cermet
 HC² Coated cermet
 HW Uncoated carbide

A

Turning

B

Milling

C

Drilling

D

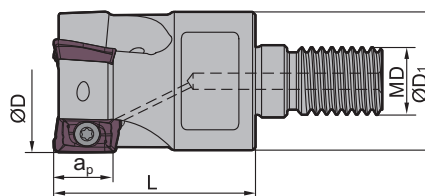
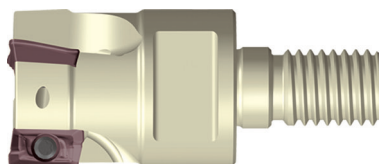
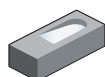
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Indexable heads – QCH series

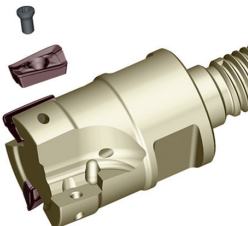
QCH - APKT Kr: 90°



Article	*	Stock	Dimensions [mm]					Teeth	kg	Inserts
			ØD	ØD ₁	a _p	L	MD			
QCH-16-APKT11-M8-02	•	•	16	12.5	10.5	25	8	2	0.028	APKT11T3
QCH-20-APKT11-M10-03	•	•	20	18	10.5	30	10	3	0.059	
QCH-25-APKT11-M12-04	•	•	25	21	10.5	35	12	4	0.104	
QCH-32-APKT11-M16-05	•	•	32	29	10.5	43	16	5		
QCH-40-APKT11-M16-06	•	•	40	29	10.5	43	16	6		
QCH-25-APKT16-M12-02	○	○	25	21	10.5	38	12	2	0.09	APKT1604
QCH-32-APKT16-M16-03	•	•	32	29	10.5	46	16	3		
QCH-40-APKT16-M16-04	○	○	40	29	10.5	46	16	4		

• Ex stock ○ On demand

* With internal cooling

Spare parts				
	Insert	APKT11T3	APKT1604	
	ØD	16-40	25-40	
	Screw (insert)		I60M4*8.4 (3.4Nm)	
	Screw (insert)	I60M2.5*6.5T (1.0Nm)		
	Wrench (insert)	WT08IP	WT15IP	

System code > B26

Grade selection > B24

Technical info > B463

Cutting data > B224

Milling inserts

-  Ideal machining conditions
-  Normal machining conditions
-  Unfavourable machining conditions

APKT	L	S	d
11 T3	12.24	3.6	2.8
16 04	17.877	5.76	4.4

AP** milling insert					HC ¹ (CVD)							HC ¹ (PVD)				HT	HC ²	HW								
			P																							
			M																							
			K																							
			N																							
			S																							
			H																							
ISO			r	I.W	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201	
	APKT11T304-ALH	0.4	6.5											●											●	●
	APKT11T308-ALH	0.8	6.5											●											●	●
	APKT160408-ALH	0.8	9.33											●											●	●
	APKT11T304-APF	0.4	6.5												●											
	APKT11T308-APF	0.8	6.5												●											
	APKT160408-APF	0.8	9.33												●		○		○							
	APKT11T304-APM	0.4	6.5				●			●				●												
	APKT11T308-APM	0.8	6.5				●			●				●												
	APKT11T312-APM	1.2	6.5				●			●				●												
	APKT11T316-APM	1.6	6.5				●			●				●												
	APKT11T320-APM	2	6.5				●			●				●												
	APKT160408-APM	0.8	9.33				●			●	●			●												
	APKT160416-APM	1.6	9.33				●			●				●												
	APKT160420-APM	2	9.33				●			●				●												
	APKT160424-APM	2.4	9.33				●			●				●												
	APKT160430-APM	3	9.33				●			●				●												
	APKT11T304-LH	0.4	6.5																						●	●
	APKT11T308-LH	0.8	6.5																						●	●
	APKT160408-LH	0.8	9.33																						●	●
	APKT11T304-PF	0.4	6.5		○			●						●		●		●								
	APKT11T308-PF	0.8	6.5						○					○		●										
	APKT11T312-PF	1.2	6.5														○									
	APKT11T316-PF	1.6	6.5														○									
	APKT160408-PF	0.8	9.33		●				○	●							●		●							
	APKT160430-PF	3	9.33	○																						
	APKT11T304-PM	0.4	6.5	●	●	○		●	●					○		●		●								
	APKT11T308-PM	0.8	6.5	●	●		●	●	●	●	●	●		●		●	●	●								
	APKT11T312-PM	1.2	6.5						○					○		●		○								
	APKT11T316-PM	1.6	6.5						●					○		●		○								
	APKT160408-PM	0.8	9.33	●	●	●	●	●	●	●	●	●		●		●	●	●		●						
	APKT160416-PM	1.6	9.33	○													●									
	APKT11T304-PR	0.4	6.5							○						○		○								
	APKT11T316-PR	1.6	6.5															○								

● Ex stock ○ On demand

HC ¹	Coated carbide
HT	Uncoated cermet
HC ²	Coated cermet
HW	Uncoated carbide

System code > B26

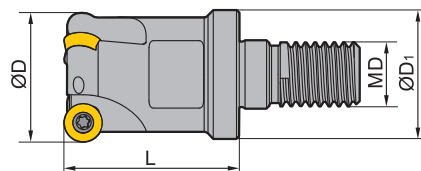
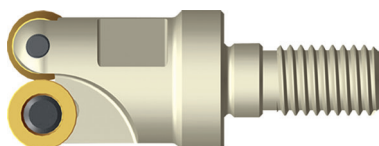
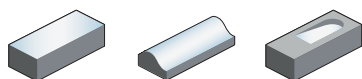
Grade selection > B24

Technical info > B463

Cutting data > B224

Indexable heads – QCH series

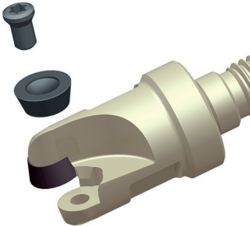
QCH - RD



Article	*	Stock	Dimensions [mm]				Teeth		Inserts 
			ØD	ØD ₁	L	MD			
QCH-16-RD07-M8-02	●		16	15	25	8	2	0.027	RDkW0702
QCH-20-RD07-M10-03	○		20	18	30	10	3	0.058	
QCH-25-RD07-M12-03	○		25	21	35	12	3	0.093	
QCH-20-RD10-M10-02	○		20	19	30	10	2	0.054	RDkW10T3
QCH-25-RD10-M12-02	○		25	24	35	12	2	0.097	
QCH-32-RD10-M16-03	○		32	30	45	16	3	0.183	
QCH-32-RD16-M16-02	○		32	30	45	16	2	0.156	RDkW1605

● Ex stock ○ On demand

* With internal cooling

Spare parts					
	Insert	RDKW0702	RDKW10T3	RDKW1605	
	ØD	16-25	20-32	32	
	Screw (insert)	I60M2.5*5.0 (1.0 Nm)	I60M4*8 (3.4 Nm)	I60M5*13 (6.7 Nm)	
	Wrench (insert)	WT08IP	WT15IP		
	Wrench (insert)			WT20IT	

System code > B26

Grade selection > B24

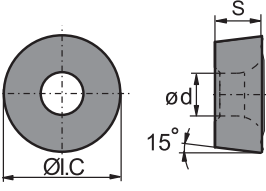
Technical info > B463

Cutting data > B224

Milling inserts

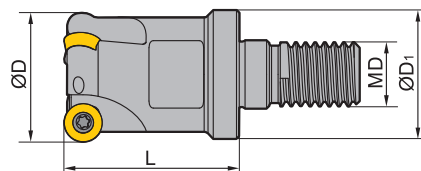
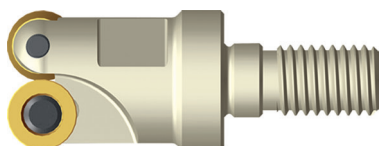
-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

RDkW	I.C	S	d
07 02	7	2.38	2.7
10 T3	10	3.97	4.4
16 05	16	5.56	5.5

RD** milling insert		HC ¹ (CVD)						HC ¹ (PVD)						HT	HC ²	HW																																																										
		P	      	     	     	     	     	     	     	     	     																																																															
																																																																										
   	     	     	     	     	     	     	     	     	    																																																																	
																																																																										
     	     	     	     	     	     	     	     	     	  																																																																	
																																																																										
 	     	     	     	     	     	     	     	     	     																																																																	
																																																																										
   	     	     	     	     	     	     	     	     	    																																																																	
																																																																										
     	     	     	     	     	     	     	     																																																																			

Indexable heads – QCH series

QCH - RD



Article	*	Stock	Dimensions [mm]				Teeth	kg	Inserts
			ØD	ØD ₁	L	MD			
QCH-15-RDKW0702-M8-02		●	8	12.5	23	8	2		RDKW0702
QCH-15-RDKW0702-M8-03		●	8	12.5	23	8	3		
QCH-20-RDKW0702-M10-04		●	13	18	30	10	4		
QCH-25-RDKW0702-M12-05		●	18	21	35	12	5		
QCH-20-RDKW1003-M10-02		●	10	18	30	10	2		RDKW1003
QCH-25-RDKW1003-M12-02		●	15	21	35	12	2		
QCH-25-RDKW1003-M12-03		●	15	21	35	12	3		
QCH-30-RDKW1003-M16-04		●	20	29	43	16	4		
QCH-35-RDKW1003-M16-04		●	25	29	43	16	4		RDKW12T3
QCH-42-RDKW1003-M16-05		●	32	29	43	16	5		
QCH-24-RDKW12T3-M12-02		●	12	21	35	12	2		
QCH-35-RDKW12T3-M16-03		●	23	29	43	16	3		
QCH-42-RDKW12T3-M16-04		●	30	29	43	16	4		RDKW1604
QCH-32-RDKW1604-M16-02		●	16	29	43	16	2		

● Ex stock ○ On demand

* With internal cooling

Spare parts					
	Insert	RDKW0702	RDKW1003	RDKW12T3	RDKW1604
	ØD	15-25	20-42	24-42	32
	Clamp				WX16N
	Screw (clamp)				I60M4.5*10 (5.0 Nm)
	Screw (clamp)			LOM3.5*7.1	
	Screw (insert)	I60M2.5*5.0 (1.0 Nm)	I60M3.5*7.7 (2.7 Nm)	I60M3.5*7.7 (2.7 Nm)	I60M4.5*10 (5.0 Nm)
	Wrench (insert)	WT07P	WT15P	WT15P	
	Wrench (insert)				WT20T

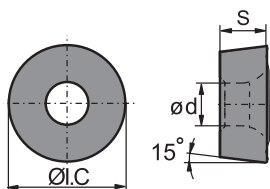
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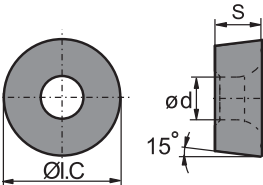
Grade selection > B24

Technical info > B463

Cutting data > B224

Milling inserts



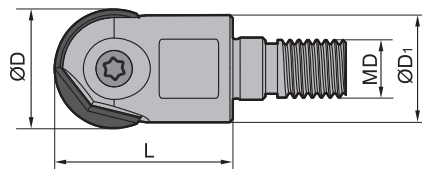
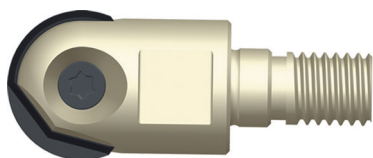
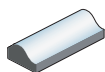
RD** milling insert		HC ¹ (CVD)							HC ¹ (PVD)					HT		HC ²	HW					
		P																				
		M																				
		K																				
		N																				
		S																				
		H																				
ISO		YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	RDKW0702MO-1						●					●			●							
	RDKW0702MO-2										●											
	RDKW1003MO-1					●	●					●	●	●								
	RDKW1003MO-2										●											
	RDKW1003MO-3					●							●									
	RDKW12T3MO-1					●	●					●	●	●								
	RDKW12T3MO-2										●		○									
	RDKW12T3MO-3					●							●									
	RDKW1604MO-1						●					●	●	●		●						
	RDKW1604MO-2										○											
	RDKW1604MO-3	○	○		●			●		○		●			●							

● Ex stock ○ On demand

HC ¹	Coated carbide
HT	Uncoated cermet
HC ²	Coated cermet
HW	Uncoated carbide

Indexable heads – QCH series

QCH - ZOHX

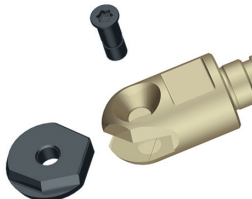


Article	*	Stock	Dimensions [mm]				kg	Inserts
			ØD	ØD ₁	L	MD		
QCH-16-ZOHX16-M8	•		16	15	28	8	0.029	ZOHX16
QCH-20-ZOHX20-M10	•		20	19	30	10	0.048	ZOHX20
QCH-25-ZOHX25-M12	•		25	24	35	12	0.087	ZOHX25
QCH-30-ZOHX30-M16	•		30	29	45	16	0.17	ZOHX30
QCH-32-ZOHX32-M16	•		32	30	45	16	0.18	ZOHX32

• Ex stock ○ On demand

* With internal cooling

Spare parts						
	Insert	ZOHX16	ZOHX20	ZOHX25	ZOHX30	ZOHX32
	ØD	16	20	25	30	32
	Screw (insert)	I70M5*12TT (6.7 Nm)	I70M5*16TT (6.7 Nm)	I70M6*20TT (9.1 Nm)	I70M8*25TT (16.2 Nm)	I70M8*25TT (16.2 Nm)
	Wrench (insert)	WT20IP	WT20IP	WT20IP		
	Wrench (insert)				WT30IT	WT30IT



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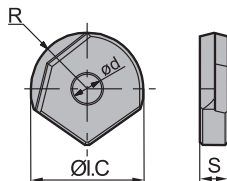
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Milling inserts

-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

ZOHX	I.C	S	d
16	16	4	5
20	20	5	5
25	25	6	6
30	30	7	8
32	32	7	8

ZO** milling insert			HC ¹ (CVD)						HC ¹ (PVD)						HT	HC ²	HW							
			P																					
			M																					
			K																					
			N																					
			S																					
			H																					
ISO			R	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	ZOHX1604-GF	8																		●				
	ZOHX2005-GF	10																		●				
	ZOHX2506-GF	12.5																		○				
	ZOHX3007-GF	15																		●				
	ZOHX3207-GF	16																		●				
	ZOHX1604-GM	8																		●				
	ZOHX2005-GM	10																		●				
	ZOHX2506-GM	12.5																		○				
	ZOHX3007-GM	15																		●				
	ZOHX3207-GM	16																		●				

● Ex stock ○ On demand

HC¹ Coated carbide
 HT Uncoated cermet
 HC² Coated cermet
 HW Uncoated carbide

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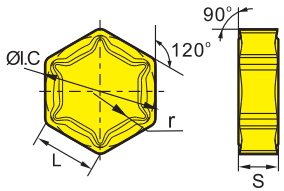
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Turning

Milling inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

HNGX	L	I.C	S
09 05	9.16	15.875	5.56

HN** milling insert				HC ¹ (CVD)								HC ¹ (PVD)				HT	HC ²	HW								
			P																							
			M																							
			K																							
			N																							
			S																							
			H																							
ISO			r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YBG320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201		
	HDR	HNGX090530-HDR	3							○	○															
	MR	HNGX090516-MR	1.6							●																
		HNGX090520-MR	2							●																

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

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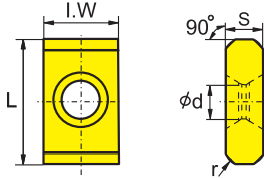
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Milling inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

LNE3	L	I.W	S
2.53	15.875	4.76	9.525

LN** milling insert			HC ¹ (CVD)						HC ¹ (PVD)						HT	HC ²	HW						
	P																						
	M																						
	K																						
	N																						
	S																						
	H																						
ISO		r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	LNE32.534	1.6						○	○	○													

● Ex stock

○ On demand

HC¹ Coated carbide
 HT Uncoated cermet
 HC² Coated cermet
 HW Uncoated carbide

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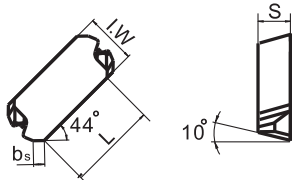
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- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

LNCX	I.W	L	S
18 06	10	24	6.4

Milling inserts

LN** milling insert			HC ¹ (CVD)								HC ¹ (PVD)					HT	HC ²	HW						
	P	     	        	 																				
	M	    	        	 																				
	K	 		 																				
	N																 							
	S	 	  																					
	H																							
ISO			bs	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	LNCX1806AZR	2.0	●																					
	LNCX1806AZT11L	2.0								○														
	LNCX1806AZT11R	2.0								○														

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code > B26

Grade selection > B24

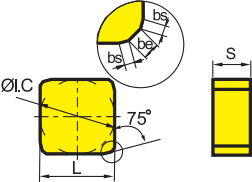
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Milling inserts

- Ideal machining conditions
- ⊗ Normal machining conditions
- ⊗ Unfavourable machining conditions

SNKN	L	I.C	S
12 04	12.7	12.7	4.76
15 04	15.875	15.875	4.76

SN** milling insert				HC ¹ (CVD)								HC ¹ (PVD)				HT	HC ²	HW								
				P																						
				M																						
				K																						
				N																						
				S																						
				H																						
ISO				bs	be	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	SNKN1204ENN			1.5	0.9		●				○	●														
	SNKN1504ENN			1.5	0.9		●				○															○

● Ex stock

○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

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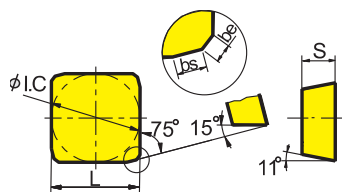
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Milling inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

SPCN	L	I.C	S
12 03	12.7	12.7	1.4
15 04	15.875	15.875	1.4

SP** milling insert			HC ¹ (CVD)								HC ¹ (PVD)				HT	HC ²	HW								
	P																								
	M																								
	K																								
	N																								
	S																								
	H																								
ISO			bs	be	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YBG320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	SPCN1203EDSKR	3.2	1.0	●																					
	SPCN1504EDSKR	4.8	1.0	●																					

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

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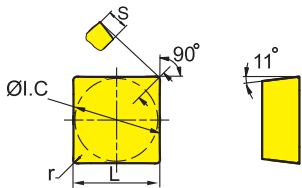
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Milling inserts

- Ideal machining conditions
- ⊗ Normal machining conditions
- ⊗ Unfavourable machining conditions

SPMR	L	I.C	S
09 03	9.525	9.525	3.18
12 03	12.7	12.7	3.18

SP** milling insert			HC ¹ (CVD)						HC ¹ (PVD)						HT	HC ²	HW						
		P																					
		M																					
		K																					
		N																					
		S																					
		H																					
ISO		r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	SPMR090304	0.4					○																
	SPMR090308	0.8					○																
	SPMR120304	0.4					●																
	SPMR120308	0.8					●	○															
	SPMR120312	1.2						○															

● Ex stock

○ On demand

HC¹ Coated carbide
 HT Uncoated cermet
 HC² Coated cermet
 HW Uncoated carbide

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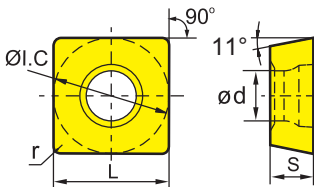
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Milling inserts

- Ideal machining conditions
- Normal machining conditions
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SPMT	L	I.C	S	d
06 03	6.35	6.35	3.18	2.8
09 T3	9.525	9.525	3.97	4.4
12 04	12.7	12.7	4.76	5.5

SP** milling insert			HC ¹ (CVD)								HC ¹ (PVD)					HT	HC ²	HW						
			P																					
			M																					
			K																					
			N																					
			S																					
			H																					
ISO			r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
HT-1 	SPMT120408-HT-1	0.8															○							
HT 	SPMT09T308-HT	0.8				●				●							●							
KT 	SPMT060304-KT	0.4	○																					

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code > B26

Grade selection > B24

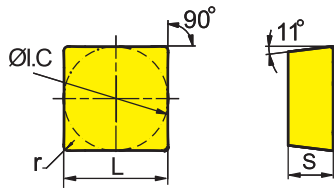
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Milling inserts

-  Ideal machining conditions
 Normal machining conditions
 Unfavourable machining conditions

SP**	L	I.C	S
12 03	12.7	12.7	3.18
15 04	15.875	15.875	4.76

SP** milling insert			HC ¹ (CVD)								HC ¹ (PVD)					HT	HC ²	HW					
	P																						
	M																						
	K																						
	N																						
	S																						
	H																						
ISO		r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	SPGN120304	0.4													●								
	SPGN120308	0.8													●								
	SPUN120308	0.8				●	○																○
	SPUN120312	1.2				●																	
	SPUN150408	0.8																					○
	SPUN150412	1.2																					○

● Ex stock ○ On demand

HC¹ Coated carbide
 HT Uncoated cermet
 HC² Coated cermet
 HW Uncoated carbide

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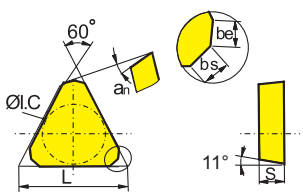
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- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

TPCN	L	I.C	S
22 04	22	12.7	4.76

Milling inserts

TP** milling insert				HC ¹ (CVD)						HC ¹ (PVD)						HT	HC ²	HW									
				P																							
				M																							
				K																							
				N																							
				S																							
				H																							
ISO				bs	be	an	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	TPCN2204PDFR			1.4	1.4	15																				o	

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code > B26

Grade selection > B24

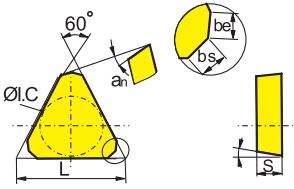
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Milling inserts

- Ideal machining conditions
- ⊗ Normal machining conditions
- ⊗ Unfavourable machining conditions

TPKN	L	I.C	S
16 03	16.5	9.525	3.18

TP** milling insert				HC ¹ (CVD)								HC ¹ (PVD)				HT	HC ²	HW									
				P																							
				M																							
				K																							
				N																							
				S																							
				H																							
ISO				bs	be	an	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	TPKN1603PDTKR			1.0	1.2	11																				○	
	TPKN1603PPER			1.0	1.2	11	●																			○	
	TPKN1603PPFR			1.0	1.2	11																				○	

● Ex stock

○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

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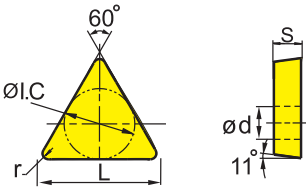
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TP**	L	I.C	S
09 02	9.63	5.56	2.38
11 03	11	6.35	3.18
16 03	16.5	9.525	3.18
22 04	22	12.7	4.76

Milling inserts

- Ideal machining conditions
- Normal machining conditions
- Unfavourable machining conditions

TP** milling insert				HC ¹ (CVD)						HC ¹ (PVD)						HT	HC ²	HW						
	P																							
	M																							
	K																							
	N																							
	S																							
	H																							
ISO			r	YBC302	YBC301	YBC401	YBM253	YBM251	YBM351	YBD152	YBD252	YBG101	YBG102	YB9320	YBG205	YBG202	YBG212	YBG302	YBG152	YBG252	YNG151	YNG151C	YD101	YD201
	TPMR090204	0.4					●																	
	TPMR110304	0.4					●																	
	TPMR110308	0.8					●																	
	TPMR160304	0.4					●																	
	TPMR160308	0.8					●	●	○															
	TPMR160312	1.2						○	○															
	TPMR220412	1.2					●																	
	TPUN110304	0.4					●																	
	TPUN110308	0.8					●																	
	TPUN160304	0.4					●																○	
	TPUN160308	0.8					●	○															○	
	TPUN160312	1.2					●																	
	TPUN220408	0.8					●																	
	TPUN220412	1.2							○															
	TPUN220416	1.6																					○	

● Ex stock ○ On demand

HC¹ Coated carbide
HT Uncoated cermet
HC² Coated cermet
HW Uncoated carbide

System code > B26

Grade selection > B24

Technical info > B463

Cutting data > B224

[illegible]

Turning

Milling

Drilling

Technical Information

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