DIAMETAL®

TURNDEC

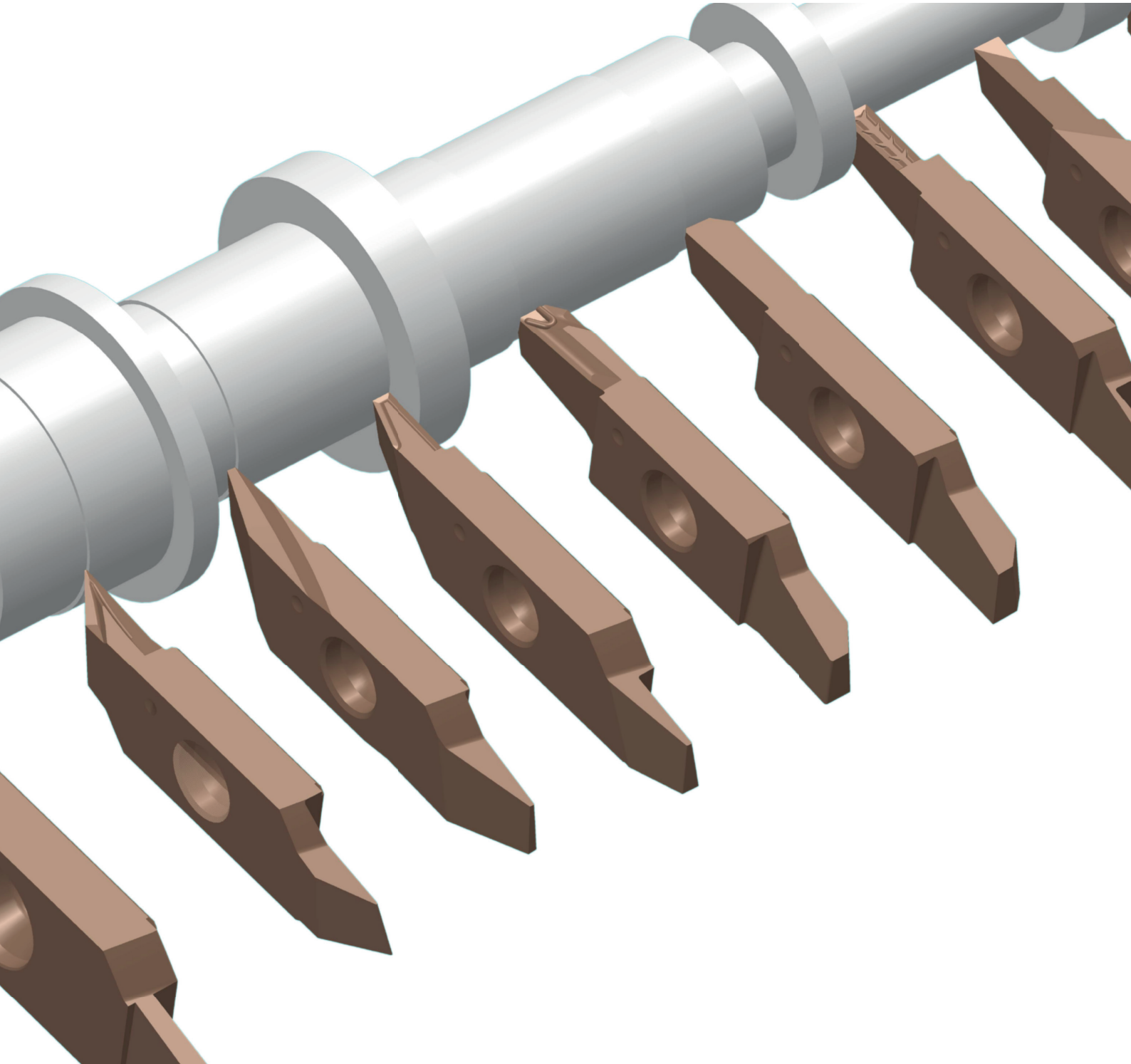
DE·EN

DIAMETAL
SWISS CUTTING TOOLS

TURNDEC

Komplettes Drehsystem für Abstechen, Einstechen, Drehen und Gewindedrehen

Complete turning system for parting off, grooving, turning and threating



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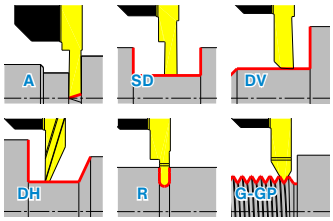
TURNDEC

Kodierung von Wendeschneidplatten
Codification of inserts

01	02	03	04	05	06	07	**Art. N°**
DH	8	F	R	RP	0.70 x 0.12 x 8.00 r0.03	DWS	**442843**

01 Anwendung
Application



02 Grösse
Size

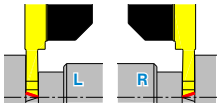


	6	8/8P	10
H0	5.60	8.00	10.00

03 Option
Option

C
Gegenspindel
Counter spindle
F
Wiper
Wiper

04 Richtung
Direction



05 Schneidengeometrie
Cutting geometry

06 Dimensionen
Dimension

07 Beschichtung
Coating

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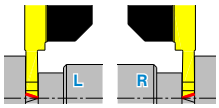
TURNDEC

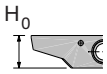
Kodierung von Werkzeughaltern
Codification of tool holders

01	02	03	04	Art. N°
L	8	12 x 12 x 120	C	**448008**

01 Richtung
Direction

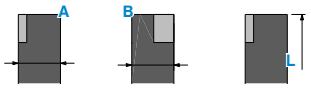


02 Grösse
Size

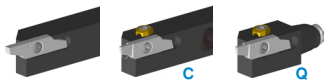


	6	8	10
H0	5.60	8.00	10.00

03 Dimensionen
Dimension



04 Ausführung
Execution



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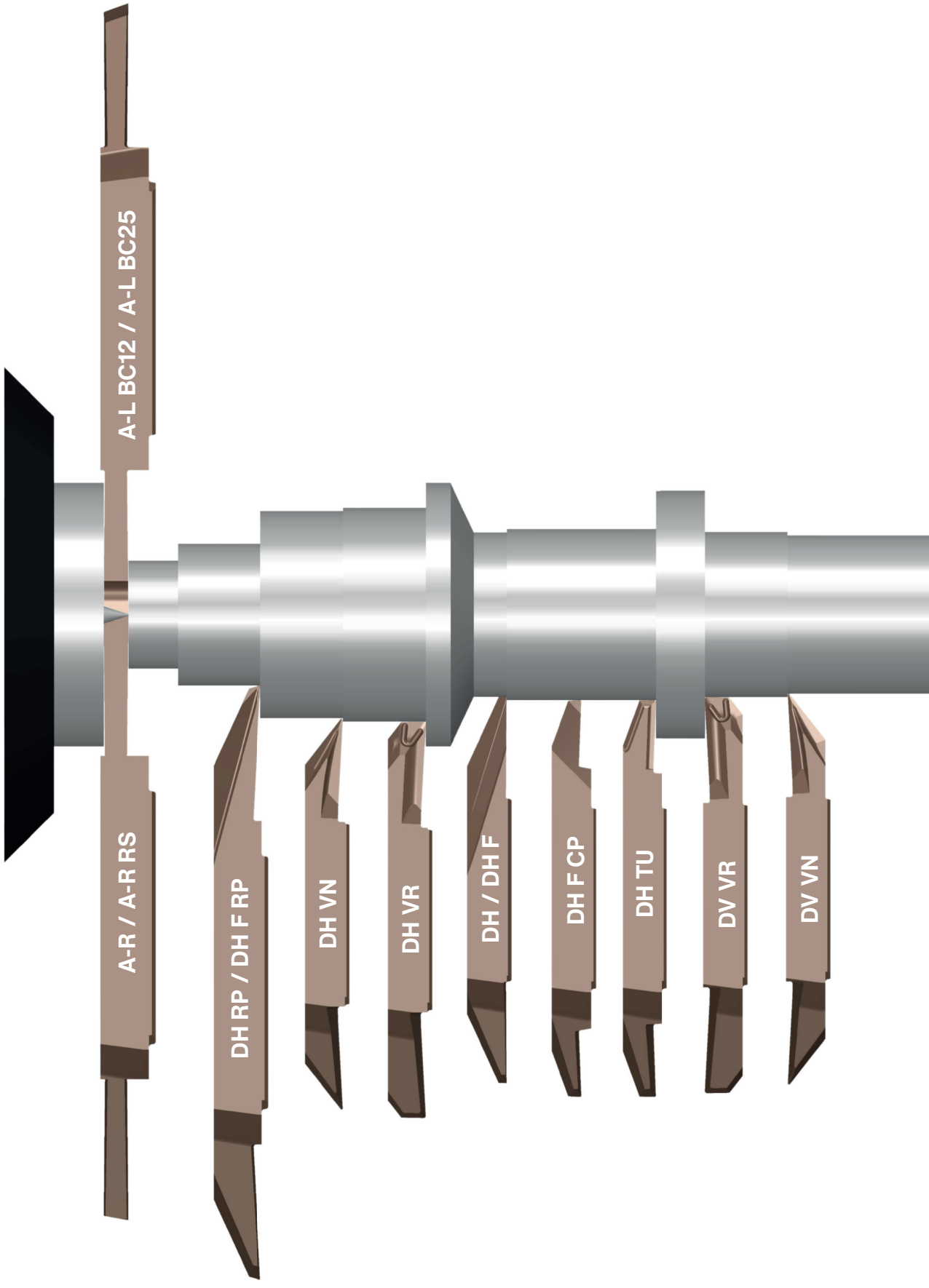

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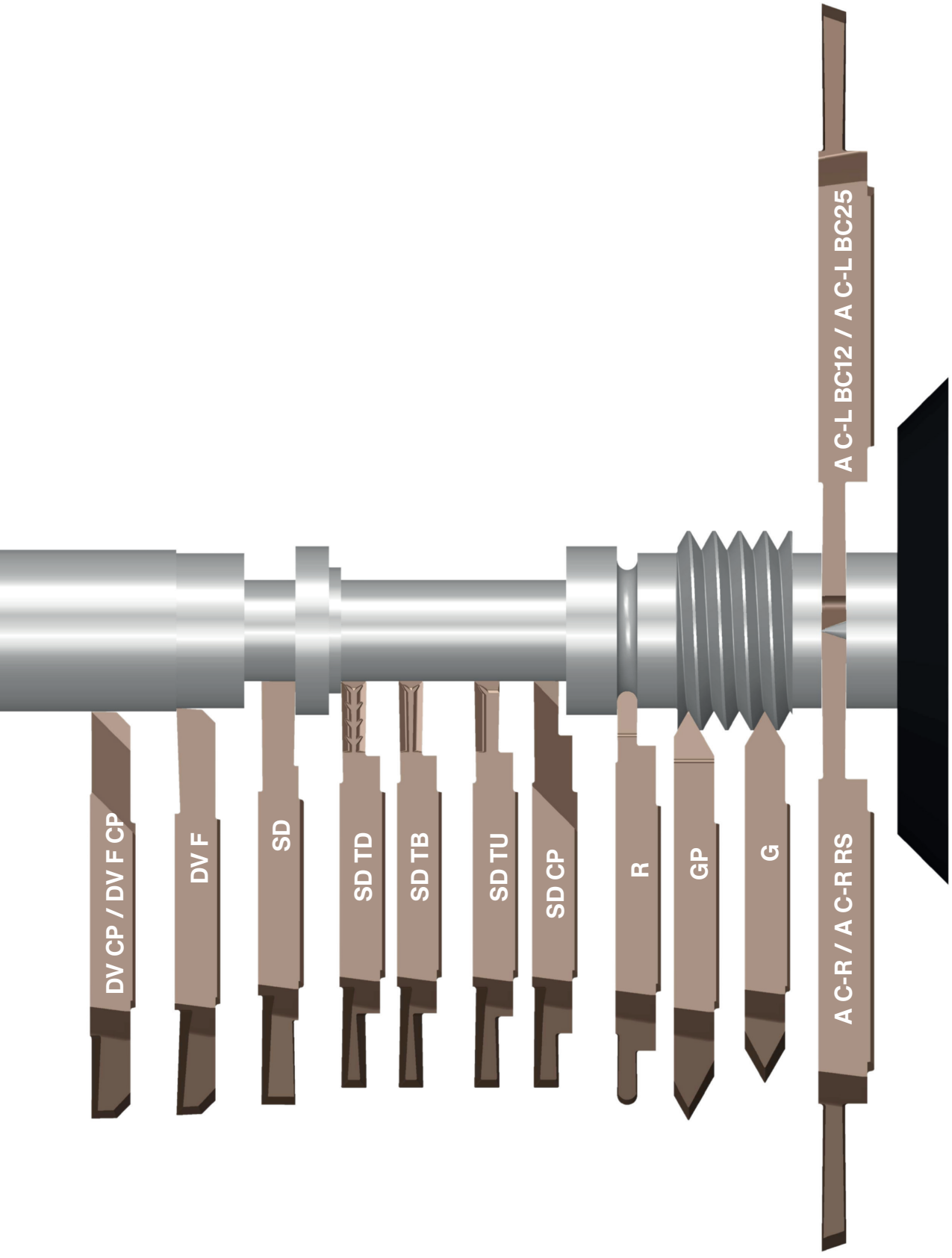

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TURNDEC

Anwendungen
Applications

ISO	Werkstoffe *Materials*	Abstechen / Abstechen Gegenspindel *Parting off / Parting off counter spindle*				Einstechen und Drehen *Grooving and Turning*					
	Funktion *Function*										
	Bezeichnung *Designation*	A A C	A RS A C RS	A BC12 A C BC12	A BC25 A C BC25	SD	SD CP	SD TU	SD TB	SD TD	DV
											
	Schruppen *Roughing*	▸▸▸	▸▸▸	▸▸▸	▸▸▸	▸	▸▸	▸▸▸	▸▸▸	▸▸▸	▸
	Schlichten *Finishing*	▸▸▸	▸▸▸	▸▸▸	▸▸▸	▸▸▸	▸▸▸	▸▸	▸▸	▸▸	▸▸
	Seite A *Page A*										
	Seite AC *Page AC*										
P1	Automatenstahl *Free-cutting steel*	▸▸▸	▸▸▸	▸▸	▸	▸▸▸	▸▸▸	▸▸▸	▸▸▸	▸▸▸	▸▸
P2	Automatenstahl bleifrei *Lead-free free-cutting steel*	▸▸▸	▸▸▸	▸▸		▸▸▸	▸▸▸	▸▸▸	▸▸▸	▸▸▸	▸▸
P3	Unlegierter Stahl (Rm < 800 N/mm²) *Unalloyed steel (Rm < 800 N/mm²)*	▸▸▸	▸▸▸	▸▸		▸▸▸	▸▸	▸▸▸	▸▸▸	▸▸▸	▸▸
P4	Niedriglegierter Stahl (Rm < 900 N/mm²) *Low alloy steel (Rm < 900 N/mm²)*	▸▸	▸▸	▸		▸▸	▸	▸▸	▸▸	▸▸▸	▸
P5	Hochlegierter Stahl (Rm < 1200 N/mm²) *High alloy steel (Rm < 1200 N/mm²)*	▸▸	▸▸	▸		▸▸	▸	▸▸	▸▸	▸▸▸	▸
M1	Ferritischer rostfreier Stahl *Ferritic stainless steel*	▸▸	▸▸	▸▸		▸▸	▸▸▸	▸▸▸	▸▸▸	▸▸▸	▸
M2	Martensitischer rostfreier Stahl *Martensitic stainless steel*	▸	▸	▸▸		▸	▸▸	▸▸▸	▸▸▸	▸▸▸	▸
M3	Austenitischer rostfreier Stahl *Austenitic stainless steel*	▸▸	▸▸	▸▸▸	▸	▸▸	▸▸▸	▸▸▸	▸▸▸	▸▸▸	▸
K1	Gusseisen *Cast iron*	▸▸▸	▸▸▸	▸▸		▸▸▸	▸▸	▸▸	▸▸	▸▸	▸▸
N1	Aluminiumguss *Cast aluminum*	▸	▸	▸▸	▸▸▸	▸	▸▸▸	▸▸	▸▸	▸	▸
N2	Aluminium Legierungen *Aluminum alloys*	▸	▸	▸▸	▸▸▸	▸	▸▸▸	▸▸	▸▸	▸	▸
N3	Messing, Bronze *Brass, Bronze*	▸▸▸	▸▸▸	▸▸		▸▸▸	▸▸	▸▸	▸▸	▸▸	▸▸
N4	Messing bleifrei *Lead-free brass*	▸▸▸	▸▸▸	▸▸		▸▸▸	▸▸	▸▸	▸▸	▸▸	▸▸
N5	Kupfer *Copper*	▸	▸	▸▸▸	▸▸	▸	▸▸▸	▸▸	▸▸		▸
N6	Edelmetalle *Precious metals*	▸	▸	▸▸▸	▸▸	▸	▸▸▸	▸▸	▸▸		▸
N7	Platin, Palladium *Platinum, Palladium*	▸▸	▸▸	▸	▸	▸▸	▸	▸	▸	▸▸	▸
N8	Kunststoffe *Plastics*			▸	▸▸▸		▸▸▸	▸▸	▸▸	▸	
S1	Titan rein *Pure Titanium*	▸	▸	▸▸▸	▸▸	▸	▸▸▸	▸▸	▸▸	▸▸	▸
S2	Titan Legierungen *Titanium alloys*	▸▸▸	▸▸▸	▸▸	▸	▸▸▸	▸▸	▸	▸	▸▸▸	▸▸
S3	Super Legierungen (Cr, Co, Ni) *Superalloys (Cr, Co, Ni)*	▸▸	▸▸	▸		▸▸	▸	▸▸	▸▸	▸▸▸	▸
H1	Gehärteter Stahl (< 55 HRC) *Hardened steel (< 55 HRC)*	▸▸	▸▸			▸▸	▸	▸	▸	▸▸	▸
H2	Gehärteter Stahl (> 55 HRC) *Hardened steel (> 55 HRC)*	▸▸	▸▸			▸▸				▸	▸

▸▸▸ Optimal / *Optimal* ▸▸ Gut / *Good* ▸ Funktionell / *Functional*

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Vorwärts Drehen *Front turning*				Rückwärts Drehen *Back turning*						Radius Einstich *Radius grooving*	Gewindedrehen *Threading*	
F	DV CP DV F CP	DV VR	DV VN	DH DH F	DH F CP	DH TU	DH VR	DH VN	DH RP DH F RP	R	G	GP
	▸▸	▸▸▸	▸▸	▸▸▸	▸▸	▸▸	▸▸▸	▸▸	▸▸▸	▸▸▸	▸▸▸	▸▸▸
▸	▸▸▸	▸▸▸	▸▸▸	▸▸▸	▸▸▸	▸▸▸	▸▸▸	▸▸▸	▸▸▸	▸▸▸	▸▸▸	▸▸▸
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Richtwerte
Indicative values

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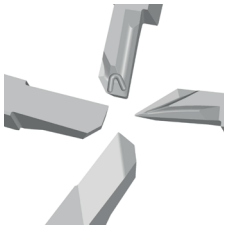
TURNDEC

Stärken
Strengths

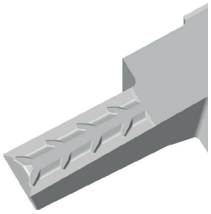


DV:
Die neue Wendeschneidplattenfamilie zum Vorwärts Drehen

Die Wendeschneidplattenfamilie DV für vorwärts Drehen, ergänzt das TURNDEC Programm perfekt. Dadurch ermöglicht es ihnen die komplette Bearbeitung der Werkstücke.

DV:
The new range of front turning inserts

The new range of DV front turning inserts perfectly completes the TURNDEC program to allow the complete machining of your parts.

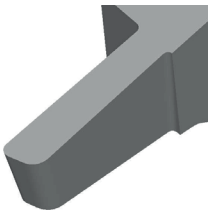


SD TD:
Die ideale Wendeschneidplatte zum Einstechen und Drehen von schwierigen Matrialen

Der Spanbrecher TD wurde speziell entwickelt, um die Fragmentierung und die Kontrolle der Späne zu fördern. Der Vorschub und die Schnitttiefe werden dadurch gesteigert.

SD TD:
The ideal grooving and turning insert for materials difficult to machine

The TD chipbreaker has been specially developed to facilitate the fragmentation and the control of the chips. It allows to increase the feed and the depth of cut.

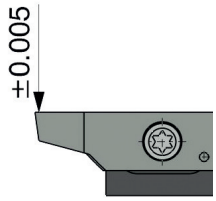


A:
Verstärkte Abstechplatte

Neue Abstechplatten mit Radien ergänzen das TURNDEC-Programm, um höhere Standzeiten bei der Bearbeitung von schwierigen Materialien zu erreichen.

A:
Process reliability

As the TURNDEC toolholders and inserts are ground, the continuity and stability of your processes are guaranteed without interruption by removing the insert.

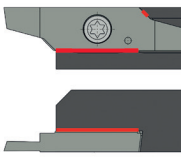


Zuverlässigkeit der Prozesse

Da TURNDEC Werkzeughalter und Wendeschneidplatten geschliffen werden, sind die Kontinuität und Stabilität Ihrer Prozesse ohne Unterbruch beim Wechsel der Wendeschneidplatte garantiert.

Process reliability

As the TURNDEC toolholders and inserts are ground, the continuity and stability of your processes are guaranteed without interruption by removing the insert.



1 Schraube, 3 Stützpunkte: einfach und stabil

Das einzigartige TURNDEC 1-Schrauben-Spannsystem ermöglicht einen schnellen Wechsel der Wendeschneidplatten.

1 screw, 3 support points: simple and rigid

The unique TURNDEC 1 screw clamping system allows a quick change of the worn or damaged insert.

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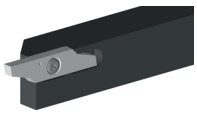
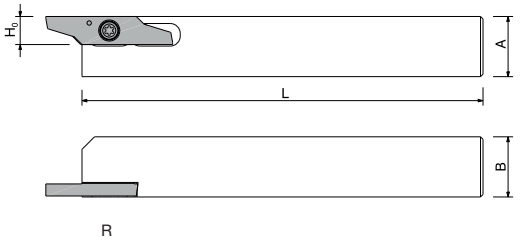
TURNDEC

Präzisions-Werkzeughalter
Precision toolholders









A x B x L	A x B (Zoll) *(inch)*	H0	Dir. L Art. N°	Dir. R Art. N°
L6 & R6				
7 × 7 × 110		5.60	**381932**	**381933**
8 × 8 × 110		5.60	**378819**	**378820**
10 × 10 × 120		5.60	**378813**	**378816**
12 × 12 × 120		5.60	**378814**	**378817**
16 × 16 × 120		5.60	**448000**	**404104**
12.7 × 12.7 × 120	1/2 × 1/2	5.60	**461476**	**461480**
15.875 × 15.875 × 120	5/8 × 5/8	5.60	**461477**	**461481**
19.05 × 19.05 × 120	3/4 × 3/4	5.60	**461478**	**461482**
25.4 × 25.4 × 120	1 × 1	5.60	**461479**	**461483**
L8 & R8				
10 × 10 × 120		8.00	**374662**	**374665**
12 × 12 × 120		8.00	**374663**	**374666**
16 × 16 × 120		8.00	**374664**	**374667**
20 × 20 × 120		8.00	**383910**	**383790**
12.7 × 12.7 × 120	1/2 × 1/2	8.00	**457034**	**457035**
15.875 × 15.875 × 120	5/8 × 5/8	8.00	**461484**	**461487**
19.05 × 19.05 × 120	3/4 × 3/4	8.00	**461485**	**461488**
25.4 × 25.4 × 120	1 × 1	8.00	**461486**	**461489**
R10				
12 × 12 × 120		10.00		**432151**
16 × 16 × 120		10.00		**432152**
20 × 20 × 120		10.00		**432153**
12.7 × 12.7 × 120	1/2 × 1/2	10.00		**461490**
15.875 × 15.875 × 120	5/8 × 5/8	10.00		**461491**
19.05 × 19.05 × 120	3/4 × 3/4	10.00		**461492**
25.4 × 25.4 × 120	1 × 1	10.00		**461493**

Werkzeughalter mit Schraube & Schraubenzieher geliefert
Toolholder provided with screw & screwdriver

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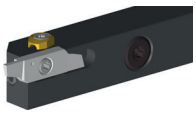
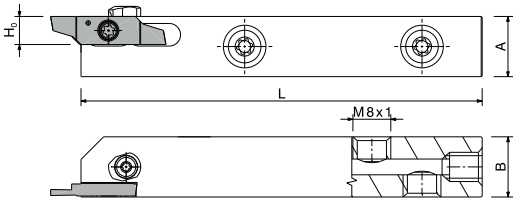
TURNDEC

Präzisions-Werkzeughalter mit Innenkühlung
Precision toolholders with integrated coolant









R

A x B x L	H0	Dir. L Art. N°	Dir. R Art. N°
L6-C & R6-C			
10 x 10 x 120	5.60	**448001**	**448004**
12 x 12 x 120	5.60	**448002**	**448005**
16 x 16 x 120	5.60	**448003**	**448006**
L8-C & R8-C			
10 x 10 x 120	8.00	**448007**	**448010**
12 x 12 x 120	8.00	**448008**	**448011**
16 x 16 x 120	8.00	**448009**	**448012**

Werkzeughalter mit Schraube & Schraubenzieher geliefert
Toolholder provided with screw & screwdriver

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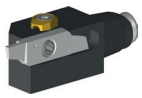
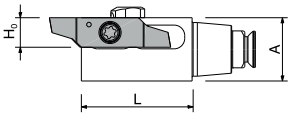
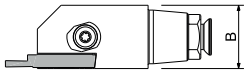
TURNDEC

Präzisions-Schnellwechselschneidköpfe mit Innenkühlung
Precision quick interchangeable heads with integrated coolant









R

A x B x L	H0	Dir. L Art. N°	Dir. R Art. N°
L6-Q & R6-Q			
10 x 10 x 21	5.60	**448016**	**448019**
12 x 12 x 21	5.60	**448017**	**448020**
16 x 16 x 21	5.60	**448018**	**448021**
L8-Q & R8-Q			
10 x 10 x 30	8.00	**448022**	**448025**
12 x 12 x 30	8.00	**448023**	**448026**
16 x 16 x 30	8.00	**448024**	**448027**

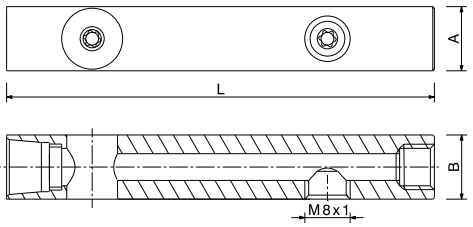
Q

Grundhalter für Schnellwechselköpfe
Tool holder for quick interchangeable heads









A x B x L	Art. N°
Q	
10 x 10 x 80	**448013**
12 x 12 x 80	**448014**
16 x 16 x 80	**448015**

Werkzeughalter mit Schraube & Schraubenzieher geliefert
Toolholder provided with screw & screwdriver

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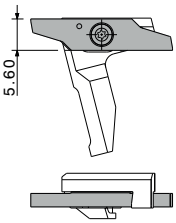
TURNDEC ESCOMATIC

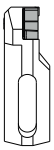
Präzisions-Werkzeughalter für ESCOMATIC Maschinen
Precision toolholder for ESCOMATIC machine











R

A x B x L	Dir. L Art. N°	Dir. R Art. N°
TE-R/L6		
25.2 × 8.1	**458637**	**458638**

Werkzeughalter mit Schraube & Schraubenzieher geliefert
Toolholder provided with screw & screwdriver

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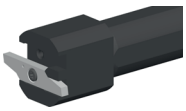
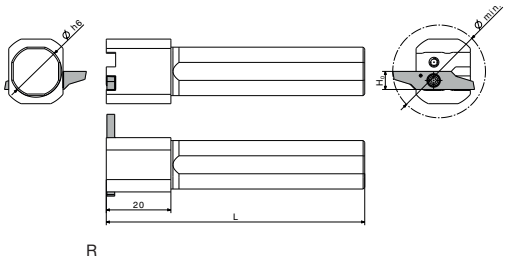
TURNDEC FRONT

Turndec Frontaler Drehhalter
Turndec frontal toolholder









R

Ø x L	H_0	Ø min.	Dir. L Art. N°	Dir. R Art. N°
TF-R/L6				
Ø 16 x 80	5.60	30.00	**460953**	**460953**
Ø 16 x 160	5.60	30.00	**460955**	**460955**
Ø 19.05 x 80	5.60	30.00	**460956**	**460956**
Ø 19.05 x 160	5.60	30.00	**460957**	**460957**
Ø 20 x 80	5.60	30.00	**460959**	**460959**
Ø 20 x 160	5.60	30.00	**460960**	**460960**
Ø 22 x 80	5.60	30.00	**460961**	**460961**
Ø 22 x 160	5.60	30.00	**460962**	**460962**
Ø 25 x 80	5.60	30.00	**460963**	**460963**
Ø 25 x 160	5.60	30.00	**460964**	**460964**
Ø 25.4 x 80	5.60	30.00	**460965**	**460965**
Ø 25.4 x 160	5.60	30.00	**460966**	**460966**

Werkzeughalter mit Schraube & Schraubenzieher geliefert
Toolholder provided with screw & screwdriver

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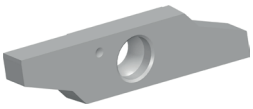
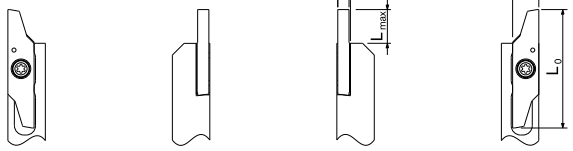
E

Ebauche
Blank

P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	H2







E-L E-R

Dir.	H0	E0	Ed	Lmax	L0	**Unbeschichtet *Uncoated* Art. N°**
E6-L						
L	5.60	2.70	2.40	7.00	25.00	**444997**
E6-R						
R	5.60	2.70	2.40	7.00	25.00	**444998**
E8-L						
L	8.00	3.35	2.95	11.00	37.50	**445000**
E8-R						
R	8.00	3.35	2.95	11.00	37.50	**445001**
E8P-L						
L	8.00	3.35	3.20	11.00	37.50	**448028**
E8P-R						
R	8.00	3.35	3.20	11.00	37.50	**448029**
E10-R						
R	10.00	4.45	3.95	17.00	59.00	**445002**

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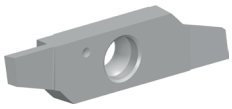
A

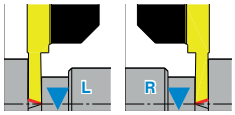
Abstechen
Parting off



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7		S1	S2	S3	H1	H2

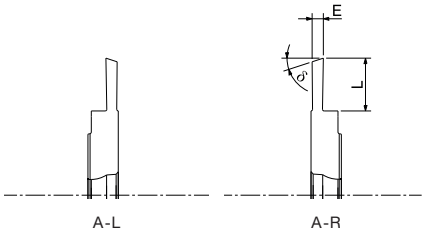


Schruppen
Roughing





Schlichten
Finishing



Dir.	E	L	δ	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
A6-L							
L	0.50	1.50	18.0°	**448030**	**448031**	**448032**	**448033**
L	0.60	2.00	18.0°	**448034**	**448035**	**448036**	**448037**
L	0.75	2.50	18.0°	**437373**	**442455**	**448038**	**381649**
L	0.80	2.50	18.0°	**448039**	**448040**	**448041**	**448042**
L	1.00	3.50	18.0°	**437378**	**442457**	**427038**	**381650**
L	1.20	4.50	18.0°	**448043**	**448044**	**448045**	**448046**
L	1.25	4.50	18.0°	**437380**	**442459**	**428649**	**381651**
L	1.50	5.50	18.0°	**437383**	**442461**	**426704**	**404930**
L	1.80	6.00	18.0°	**448047**	**448048**	**448049**	**448050**
L	2.00	6.50	18.0°	**437386**	**442463**	**448072**	**381652**
A6-R							
R	0.50	1.50	18.0°	**448051**	**448052**	**448053**	**448054**
R	0.60	2.00	18.0°	**448055**	**448056**	**448057**	**448058**
R	0.75	2.50	18.0°	**435886**	**442456**	**448059**	**381654**
R	0.80	2.50	18.0°	**448060**	**448061**	**448062**	**448063**
R	1.00	3.50	18.0°	**435273**	**442458**	**427039**	**381655**
R	1.20	4.50	18.0°	**448064**	**448065**	**448066**	**448067**
R	1.25	4.50	18.0°	**437396**	**442460**	**436031**	**381656**
R	1.50	5.50	18.0°	**437398**	**442462**	**427040**	**404931**
R	1.80	6.00	18.0°	**448068**	**448069**	**448070**	**448071**
R	2.00	6.50	18.0°	**435274**	**442464**	**448073**	**381657**

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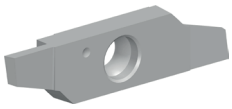
A

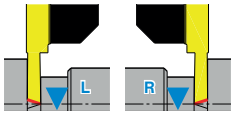
Abstechen
Parting off



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7		S1	S2	S3	H1	H2

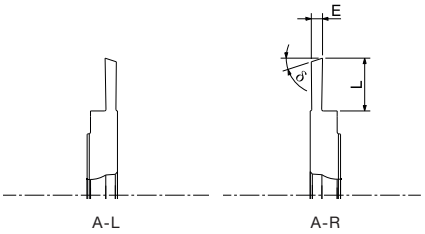


Schruppen
Roughing





Schlichten
Finishing



Dir.	E	L	δ	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
A8-L							
L	1.00	5.00	18.0°	**441554**	**442466**	**448074**	**448075**
L	1.20	6.50	18.0°	**448076**	**448077**	**448078**	**448079**
L	1.25	6.50	18.0°	**441556**	**442468**	**448080**	**448081**
L	1.50	8.50	18.0°	**374676**	**438871**	**427071**	**374679**
L	1.80	9.00	18.0°	**448082**	**448083**	**448084**	**448085**
L	2.00	9.50	18.0°	**374675**	**442476**	**427073**	**374678**
L	2.20	10.00	18.0°	**448086**	**448087**	**448088**	**448089**
L	2.50	10.50	18.0°	**374674**	**442479**	**427075**	**374677**
A8-R							
R	1.00	5.00	18.0°	**441555**	**442467**	**448090**	**448091**
R	1.20	6.50	18.0°	**448092**	**448093**	**448094**	**448095**
R	1.25	6.50	18.0°	**441557**	**442469**	**448096**	**448097**
R	1.50	8.50	18.0°	**374697**	**442472**	**427072**	**374700**
R	1.80	9.00	18.0°	**448098**	**448099**	**448100**	**448101**
R	2.00	9.50	18.0°	**374696**	**437882**	**427074**	**374699**
R	2.20	10.00	18.0°	**448102**	**448103**	**448104**	**448105**
R	2.50	10.50	18.0°	**374695**	**442480**	**427076**	**374698**
A10-R							
R	1.50	16.00	15.0°	**435050**	**436600**	**432171**	**432172**
R	2.00	16.00	15.0°	**435051**	**436601**	**432174**	**432175**
R	2.50	16.00	15.0°	**435052**	**436602**	**432177**	**432178**
R	3.00	16.00	15.0°	**435053**	**436603**	**432180**	**432181**
R	3.50	16.00	15.0°	**435054**	**436604**	**432183**	**432184**

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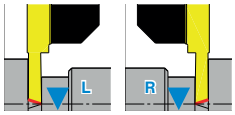
A RS

Abstechen mit verstärkten Radien
Parting off with reinforced radius



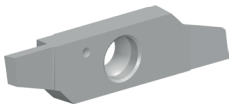
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7		S1	S2	S3	H1	H2

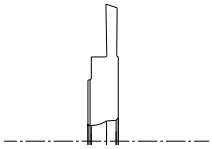
Schruppen
Roughing



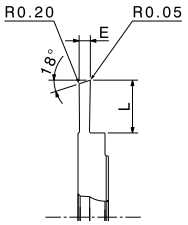
Schlichten
Finishing







A RS-L



A RS-R

Dir.	E	L	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
A8-L RS						
L	1.50	8.50	**448106**	**448119**	**448132**	**448222**
L	1.80	9.00	**448107**	**448120**	**448133**	**448223**
L	2.00	9.50	**448108**	**448121**	**448134**	**448224**
L	2.20	10.00	**448109**	**448122**	**448135**	**448225**
L	2.50	10.50	**448110**	**448123**	**448136**	**448226**
A8-R RS						
R	1.50	8.50	**448111**	**448124**	**448137**	**448227**
R	1.80	9.00	**448112**	**448125**	**448138**	**448228**
R	2.00	9.50	**448113**	**448126**	**448139**	**448229**
R	2.20	10.00	**448114**	**448127**	**448140**	**448230**
R	2.50	10.50	**448115**	**448128**	**448141**	**448231**

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A BC12

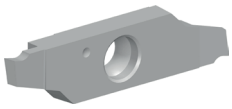
Abstechen mit Spanwinkel von 12°
Parting off with rake angle of 12°

P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3		

Schruppen
Roughing

Schlichten
Finishing







A-L BC12 A-R BC12



Dir.	E	L	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
A6-L BC12							
L	0.50	1.50	-	**448116**	**448129**	**448142**	**448232**
L	0.50	1.50	0.03	**448117**	**448130**	**448143**	**448233**
L	0.60	2.00	-	**448118**	**448131**	**448144**	**448234**
L	0.75	2.50	-	**437454**	**442617**	**448145**	**417603**
L	0.80	2.50	-	**448235**	**448236**	**448146**	**448237**
L	1.00	3.50	-	**437457**	**442619**	**448147**	**417604**
L	1.00	3.50	0.03	**448238**	**448239**	**448148**	**448240**
L	1.20	4.50	0.03	**448241**	**448242**	**448149**	**448243**
L	1.25	4.50	-	**437459**	**442621**	**448150**	**417605**
L	1.50	5.50	-	**437460**	**444692**	**448151**	**417606**
L	1.50	5.50	0.03	**448244**	**448245**	**448152**	**448246**
L	1.80	6.00	0.03	**448247**	**448248**	**448153**	**448249**
L	2.00	6.50	-	**437461**	**442625**	**448154**	**417607**
L	2.00	6.50	0.03	**448250**	**448254**	**448155**	**448258**
A6-R BC12							
R	0.50	1.50	-	**448251**	**448255**	**448156**	**448259**
R	0.50	1.50	0.03	**448252**	**448256**	**448157**	**448260**
R	0.60	2.00	-	**448253**	**448257**	**448158**	**448261**
R	0.75	2.50	-	**437463**	**442618**	**448159**	**417608**
R	0.80	2.50	-	**448262**	**448263**	**448160**	**448264**
R	1.00	3.50	-	**437464**	**442620**	**448161**	**417609**
R	1.00	3.50	0.03	**448265**	**448266**	**448162**	**448267**
R	1.20	4.50	0.03	**448268**	**448269**	**448163**	**448270**
R	1.25	4.50	-	**437465**	**442622**	**448164**	**417610**
R	1.50	5.50	-	**437467**	**442624**	**448165**	**417611**
R	1.50	5.50	0.03	**448271**	**448272**	**448166**	**448273**
R	1.80	6.00	0.03	**448274**	**448275**	**448167**	**448276**
R	2.00	6.50	-	**437468**	**442626**	**448168**	**417612**
R	2.00	6.50	0.03	**448277**	**448291**	**448169**	**448305**

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A BC12

Abstechen mit Spanwinkel von 12°
Parting off with rake angle of 12°

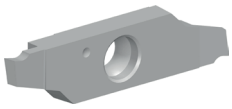


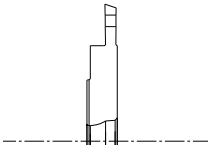
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3		

Schruppen
Roughing

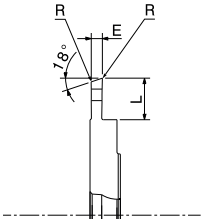


Schlichten
Finishing





A-L BC12



A-R BC12



Dir.	E	L	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
A8-L BC12							
L	1.50	8.50	0.03	**448278**	**448292**	**448170**	**448306**
L	1.80	9.00	0.03	**448279**	**448293**	**448171**	**448307**
L	2.00	9.50	0.03	**448280**	**448294**	**448172**	**448308**
L	2.20	10.00	0.03	**448281**	**448295**	**448173**	**448309**
L	2.50	10.50	0.03	**448282**	**448296**	**448174**	**448310**
A8-R BC12							
R	1.50	8.50	0.03	**448283**	**448297**	**448175**	**448311**
R	1.80	9.00	0.03	**448284**	**448298**	**448176**	**448312**
R	2.00	9.50	0.03	**448285**	**448299**	**448177**	**448313**
R	2.20	10.00	0.03	**448286**	**448300**	**448178**	**448314**
R	2.50	10.50	0.03	**448287**	**448301**	**448179**	**448315**

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A BC25

Abstechen mit Spanwinkel von 25°
Parting off with rake angle of 25°

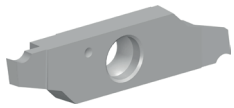


P1 | M3 | N1 | N2 | N5 | N6 | N7 | N8 | S1 | S2

Schruppen
Roughing



Schlichten
Finishing





A-L BC25

A-R BC25



Dir.	E	L	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
A6-L BC25							
L	0.50	1.50	-	**448288**	**448302**	**448180**	**448316**
L	0.50	1.50	0.03	**448289**	**448303**	**448181**	**448317**
L	0.60	2.00	-	**448290**	**448304**	**448182**	**448318**
L	0.75	2.50	-	**437469**	**442627**	**448183**	**417613**
L	0.80	2.50	-	**448319**	**448320**	**448184**	**448321**
L	1.00	3.50	-	**437470**	**442629**	**448185**	**417614**
L	1.00	3.50	0.03	**448322**	**448323**	**448186**	**448324**
L	1.20	4.50	0.03	**448327**	**448326**	**448187**	**448325**
L	1.25	4.50	-	**437472**	**442631**	**448188**	**417615**
L	1.50	5.50	-	**437473**	**442633**	**448189**	**417616**
L	1.50	5.50	0.03	**448328**	**448329**	**448190**	**448330**
L	1.80	6.00	0.03	**448331**	**448332**	**448191**	**448333**
L	2.00	6.50	-	**437474**	**442635**	**448192**	**417617**
L	2.00	6.50	0.03	**448334**	**448338**	**448193**	**448342**
A6-R BC25							
R	0.50	1.50	-	**448335**	**448339**	**448194**	**448343**
R	0.50	1.50	0.03	**448336**	**448340**	**448195**	**448344**
R	0.60	2.00	-	**448337**	**448341**	**448196**	**448345**
R	0.75	2.50	-	**437475**	**442628**	**448197**	**417618**
R	0.80	2.50	-	**448346**	**448347**	**448198**	**448348**
R	1.00	3.50	-	**437477**	**442630**	**448199**	**417619**
R	1.00	3.50	0.03	**448349**	**448350**	**448200**	**448351**
R	1.20	4.50	0.03	**448352**	**448353**	**448201**	**448354**
R	1.25	4.50	-	**437478**	**442632**	**448202**	**417620**
R	1.50	5.50	-	**437480**	**442634**	**448203**	**417621**
R	1.50	5.50	0.03	**448355**	**448356**	**448204**	**448357**
R	1.80	6.00	0.03	**448358**	**448359**	**448205**	**448360**
R	2.00	6.50	-	**437481**	**442636**	**448206**	**417623**
R	2.00	6.50	0.03	**448361**	**448374**	**448207**	**448387**

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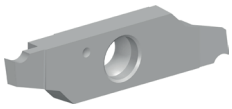
A BC25

Abstechen mit Spanwinkel von 25°
Parting off with rake angle of 25°



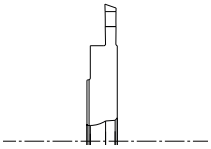
P1 | M3 | N1 | N2
N5 | N6 | N7 | N8 | S1 | S2



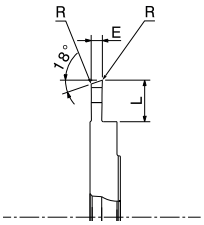
Schruppen
Roughing



Schlichten
Finishing



A-L BC25



A-R BC25



Dir.	E	L	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
A8-L BC25							
L	1.50	8.50	0.03	**448362**	**448375**	**448208**	**448388**
L	1.80	9.00	0.03	**448363**	**448376**	**448209**	**448389**
L	2.00	9.50	0.03	**448364**	**448377**	**448210**	**448390**
L	2.20	10.00	0.03	**448365**	**448378**	**448211**	**448391**
L	2.50	10.50	0.03	**448366**	**448379**	**448212**	**448392**
A8-R BC25							
R	1.50	8.50	0.03	**448367**	**448380**	**448213**	**448393**
R	1.80	9.00	0.03	**448368**	**448381**	**448214**	**448394**
R	2.00	9.50	0.03	**448369**	**448382**	**448215**	**448395**
R	2.20	10.00	0.03	**448370**	**448383**	**448216**	**448396**
R	2.50	10.50	0.03	**448371**	**448384**	**448217**	**448397**

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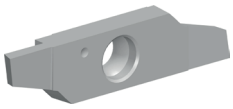
A C

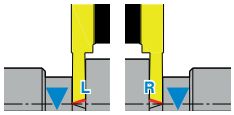
Abstechen Gegenspindel
Parting off counter spindle



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7		S1	S2	S3	H1	H2

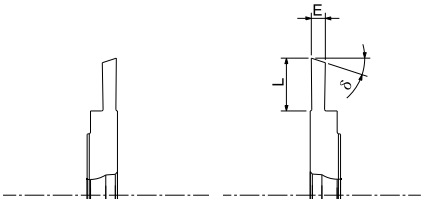


Schruppen
Roughing





Schlichten
Finishing



A C-L A C-R

Dir.	E	L	δ	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
A6C-L							
L	0.50	1.50	18.0°	**448372**	**448385**	**448218**	**448398**
L	0.60	2.00	18.0°	**448373**	**448386**	**448219**	**448399**
L	0.75	2.50	18.0°	**437415**	**442481**	**448220**	**381659**
L	0.80	2.50	18.0°	**448400**	**448401**	**448221**	**448402**
L	1.00	3.50	18.0°	**437419**	**442484**	**427045**	**381660**
L	1.20	4.50	18.0°	**448403**	**448404**	**448405**	**448406**
L	1.25	4.50	18.0°	**437421**	**442486**	**428524**	**381661**
L	1.50	5.50	18.0°	**384871**	**442488**	**427047**	**404933**
L	1.80	6.00	18.0°	**448407**	**448408**	**448409**	**448410**
L	2.00	6.50	18.0°	**437425**	**442491**	**448411**	**381662**
A6C-R							
R	0.50	1.50	18.0°	**450215**	**448412**	**448413**	**448414**
R	0.60	2.00	18.0°	**448415**	**448416**	**448417**	**448418**
R	0.75	2.50	18.0°	**437429**	**442483**	**448419**	**381664**
R	0.80	2.50	18.0°	**448421**	**448422**	**448420**	**448423**
R	1.00	3.50	18.0°	**437433**	**442485**	**427046**	**381665**
R	1.20	4.50	18.0°	**448424**	**448425**	**448426**	**448427**
R	1.25	4.50	18.0°	**437435**	**442487**	**448428**	**381666**
R	1.50	5.50	18.0°	**437438**	**442489**	**427048**	**404934**
R	1.80	6.00	18.0°	**448429**	**448430**	**448431**	**448432**
R	2.00	6.50	18.0°	**437440**	**442492**	**448433**	**381667**

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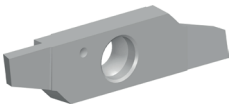
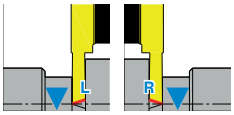
A C

Abstechen Gegenspindel
Parting off counter spindle

P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7		S1	S2	S3	H1	H2

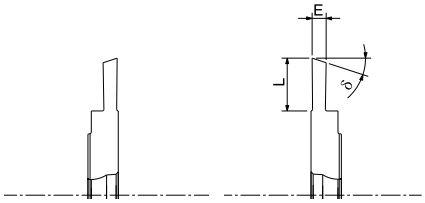


Schruppen
Roughing





Schlichten
Finishing



A C-L A C-R

Dir.	E	L	δ	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
A8C-L							
L	1.00	5.00	18.0°	**441558**	**442493**	**448434**	**448435**
L	1.20	6.50	18.0°	**448436**	**448437**	**448438**	**448439**
L	1.25	6.50	18.0°	**441560**	**442495**	**448441**	**448440**
L	1.50	8.50	18.0°	**437443**	**442498**	**427083**	**377859**
L	1.80	9.00	18.0°	**448442**	**448443**	**448444**	**448445**
L	2.00	9.50	18.0°	**437444**	**442612**	**427085**	**377858**
L	2.20	10.00	18.0°	**448446**	**448447**	**448448**	**448449**
L	2.50	10.50	18.0°	**437446**	**442615**	**427087**	**377857**
A8C-R							
R	1.00	5.00	18.0°	**441559**	**442494**	**448450**	**448453**
R	1.20	6.50	18.0°	**448457**	**448456**	**448451**	**448454**
R	1.25	6.50	18.0°	**441561**	**442497**	**448452**	**448455**
R	1.50	8.50	18.0°	**437448**	**436054**	**427084**	**377856**
R	1.80	9.00	18.0°	**448458**	**448459**	**448460**	**448461**
R	2.00	9.50	18.0°	**437450**	**442613**	**427086**	**377855**
R	2.20	10.00	18.0°	**448462**	**448463**	**448464**	**448465**
R	2.50	10.50	18.0°	**437452**	**442616**	**427088**	**377854**

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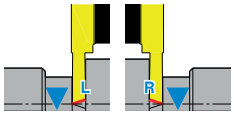
A C RS

Abstechen Gegenspindel mit verstärkten Radien
Parting off counter-spindle with reinforced radius



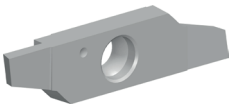
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7		S1	S2	S3	H1	H2

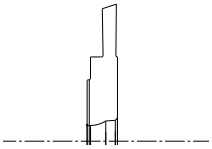
Schruppen
Roughing



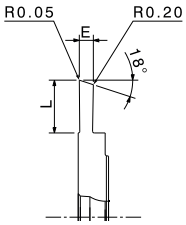


Schlichten
Finishing





A C RS-L



A C RS-R

Dir.	E	L	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
A8C-L RS						
L	1.50	8.50	**448466**	**448479**	**448492**	**448581**
L	1.80	9.00	**448467**	**448480**	**448493**	**448582**
L	2.00	9.50	**448468**	**448481**	**448494**	**448583**
L	2.20	10.00	**448469**	**448482**	**448495**	**448584**
L	2.50	10.50	**448470**	**448483**	**448496**	**448585**
A8C-R RS						
R	1.50	8.50	**448471**	**448484**	**448497**	**448586**
R	1.80	9.00	**448472**	**448485**	**448498**	**448587**
R	2.00	9.50	**448473**	**448486**	**448499**	**448588**
R	2.20	10.00	**448474**	**448487**	**448500**	**448589**
R	2.50	10.50	**448475**	**448488**	**448501**	**448590**

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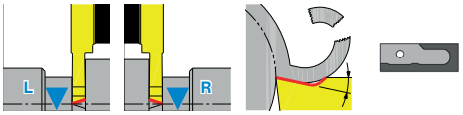
A C BC12

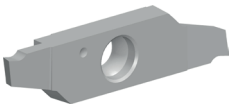
Abstechen Gegenspindel mit Spanwinkel von 12°
Parting off counter spindle with rake angle of 12°

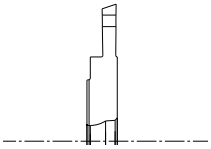
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3		

Schruppen
Roughing

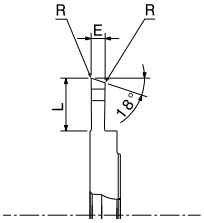
Schlichten
Finishing







A C-L BC12



A C-R BC12



Dir.	E	L	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
A6C-L BC12							
L	0.50	1.50	-	448476	448489	448502	448591
L	0.50	1.50	0.03	448477	448490	448503	448592
L	0.60	2.00	-	448478	448491	448504	448593
L	0.75	2.50	-	437483	442637	448505	417624
L	0.80	2.50	-	448594	448595	448506	448596
L	1.00	3.50	-	437484	442639	448507	417625
L	1.00	3.50	0.03	448597	448598	448508	448599
L	1.20	4.50	0.03	448600	448601	448509	448602
L	1.25	4.50	-	437485	442641	448510	417626
L	1.50	5.50	-	437486	442643	448511	417627
L	1.50	5.50	0.03	448603	448604	448512	448605
L	1.80	6.00	0.03	448606	448607	448513	448608
L	2.00	6.50	-	437487	442645	448514	417628
L	2.00	6.50	0.03	448609	448613	448515	448617
A6C-R BC12							
R	0.50	1.50	-	448610	448614	448516	448618
R	0.50	1.50	0.03	448611	448615	448517	448619
R	0.60	2.00	-	448612	448616	448518	448620
R	0.75	2.50	-	437488	442638	448519	417629
R	0.80	2.50	-	448621	448622	448520	448623
R	1.00	3.50	-	437489	442640	448521	417630
R	1.00	3.50	0.03	448624	448625	448522	448626
R	1.20	4.50	0.03	448627	448628	448523	448629
R	1.25	4.50	-	437490	442642	448524	417631
R	1.50	5.50	-	437491	442644	448525	417632
R	1.50	5.50	0.03	448630	448631	448526	448632
R	1.80	6.00	0.03	448633	448634	448527	448635
R	2.00	6.50	-	437492	442646	448528	417633
R	2.00	6.50	0.03	448636	448650	448529	448664

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A C BC12

Abstechen Gegenspindel mit Spanwinkel von 12°
Parting off counter spindle with rake angle of 12°

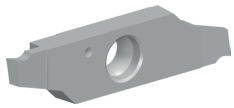


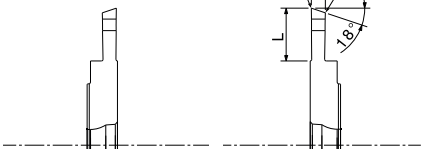
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3		

Schruppen
Roughing



Schlichten
Finishing





A C-L BC12 A C-R BC12



Dir.	E	L	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
A8C-L BC12							
L	1.50	8.50	0.03	**448637**	**448651**	**448530**	**448665**
L	1.80	9.00	0.03	**448638**	**448652**	**448531**	**448666**
L	2.00	9.50	0.03	**448639**	**448653**	**448532**	**448667**
L	2.20	10.00	0.03	**448640**	**448654**	**448533**	**448668**
L	2.50	10.50	0.03	**448641**	**448655**	**448534**	**448669**
A8C-R BC12							
R	1.50	8.50	0.03	**448642**	**448656**	**448535**	**448670**
R	1.80	9.00	0.03	**448643**	**448657**	**448536**	**448671**
R	2.00	9.50	0.03	**448644**	**448658**	**448537**	**448672**
R	2.20	10.00	0.03	**448645**	**448659**	**448538**	**448673**
R	2.50	10.50	0.03	**448646**	**448660**	**448539**	**448674**

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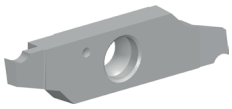
A C BC25

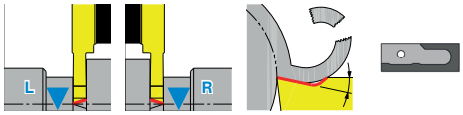
Abstechen Gegenspindel mit Spanwinkel von 25°
Parting off counter spindle with rake angle of 25°



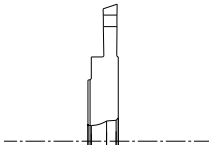


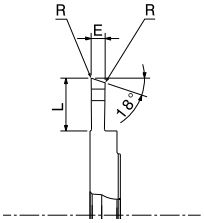
P1 | M3 | N1 | N2 | N5 | N6 | N7 | N8 | S1 | S2

Schruppen
Roughing



Schlichten
Finishing


A C-L BC25



A C-R BC25



Dir.	E	L	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
A6C-L BC25							
L	0.50	1.50	-	448647	448661	448540	448675
L	0.50	1.50	0.03	448648	448662	448541	448676
L	0.60	2.00	-	448649	448663	448542	448677
L	0.75	2.50	-	437493	442647	448543	417634
L	0.80	2.50	-	448678	448679	448544	448680
L	1.00	3.50	-	437494	442649	448545	417635
L	1.00	3.50	0.03	448681	448683	448546	448685
L	1.20	4.50	0.03	448682	448684	448547	448686
L	1.25	4.50	-	437495	442651	448548	417636
L	1.50	5.50	-	437496	442653	448549	417637
L	1.50	5.50	0.03	448687	448689	448550	448691
L	1.80	6.00	0.03	448688	448690	448551	448692
L	2.00	6.50	-	437497	442655	448552	417638
L	2.00	6.50	0.03	448693	448697	448553	448701
A6C-R BC25							
R	0.50	1.50	-	448694	448698	448554	448702
R	0.50	1.50	0.03	448695	448699	448555	448703
R	0.60	2.00	-	448696	448700	448556	448704
R	0.75	2.50	-	437498	442648	448557	417639
R	0.80	2.50	-	448705	448706	448558	448707
R	1.00	3.50	-	437499	442650	448559	417640
R	1.00	3.50	0.03	448708	448710	448560	448712
R	1.20	4.50	0.03	448709	448711	448561	448713
R	1.25	4.50	-	437500	442652	448562	417641
R	1.50	5.50	-	437501	442654	448563	417642
R	1.50	5.50	0.03	448714	448716	448564	448718
R	1.80	6.00	0.03	448715	448717	448565	448719
R	2.00	6.50	-	437502	442656	448566	417643
R	2.00	6.50	0.03	448720	448731	448567	448742

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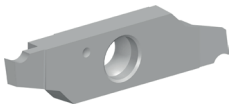
A C BC25

Abstechen Gegenspindel mit Spanwinkel von 25°
Parting off counter spindle with rake angle of 25°

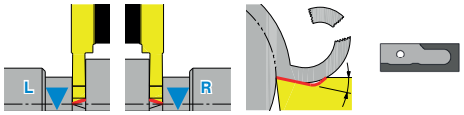


P1 | M3 | N1 | N2

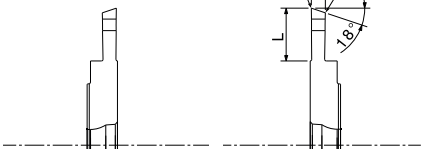
N5 | N6 | N7 | N8 | S1 | S2



Schruppen
Roughing



Schlichten
Finishing



A C-L BC25

A C-R BC25



Dir.	E	L	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
A8C-L BC25							
L	1.50	8.50	0.03	**448721**	**448732**	**448568**	**448743**
L	1.80	9.00	0.03	**448722**	**448733**	**448569**	**448744**
L	2.00	9.50	0.03	**448723**	**448734**	**448570**	**448745**
L	2.20	10.00	0.03	**448724**	**448735**	**448571**	**448746**
L	2.50	10.50	0.03	**448725**	**448736**	**448572**	**448747**
A8C-R BC25							
R	1.50	8.50	0.03	**448726**	**448737**	**448573**	**448748**
R	1.80	9.00	0.03	**448727**	**448738**	**448574**	**448749**
R	2.00	9.50	0.03	**448728**	**448739**	**448575**	**448750**
R	2.20	10.00	0.03	**448729**	**448740**	**448576**	**448751**
R	2.50	10.50	0.03	**448730**	**448741**	**448577**	**448752**

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Einstechen und Drehen
Grooving and Turning

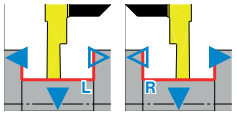
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7		S1	S2	S3	H1	H2

Schruppen
Roughing

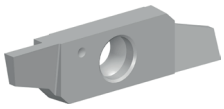
▸

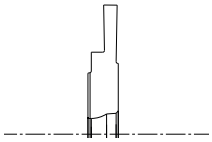
Schlichten
Finishing

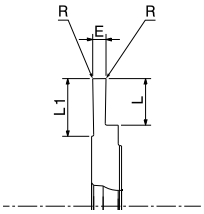
▸ ▸ ▸











Dir.	E	L	L1	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
SD6-L								
L	0.50	2.00	6.00	-	**437338**	**440240**	**448578**	**381636**
L	0.60	2.00	6.00	-	**448753**	**448755**	**448579**	**448757**
L	0.75	2.50	6.00	-	**448754**	**448756**	**448580**	**448758**
L	0.80	2.50	6.00	-	**437341**	**440241**	**427029**	**381637**
L	0.80	2.50	6.00	0.08	**448759**	**448761**	**453870**	**448767**
L	0.90	3.00	6.00	-	**448760**	**448762**	**448763**	**448768**
L	1.00	3.00	6.00	-	**437343**	**440794**	**448764**	**381638**
L	1.00	3.00	6.00	0.08	**448769**	**448770**	**448765**	**448771**
L	1.20	4.00	6.00	-	**437346**	**441599**	**448766**	**381639**
L	1.50	4.00	6.00	-	**437349**	**440227**	**426706**	**381640**
L	1.50	4.00	6.00	0.08	**448772**	**448776**	**453871**	**453872**
L	1.50	4.00	6.00	0.15	**448773**	**448777**	**453873**	**453874**
L	1.50	4.00	6.00	0.20	**448774**	**448778**	**453875**	**453876**
L	1.80	4.50	6.00	-	**448775**	**448779**	**453877**	**453878**
L	2.00	5.00	6.00	-	**437351**	**440226**	**427032**	**381641**
L	2.00	5.00	6.00	0.08	**453879**	**453880**	**453881**	**448780**
L	2.00	5.00	6.00	0.15	**453882**	**453883**	**453884**	**448781**
L	2.00	5.00	6.00	0.20	**453885**	**453886**	**453887**	**448782**

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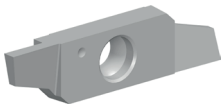
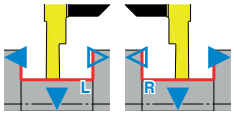
Einstechen und Drehen
Grooving and Turning



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7		S1	S2	S3	H1	H2

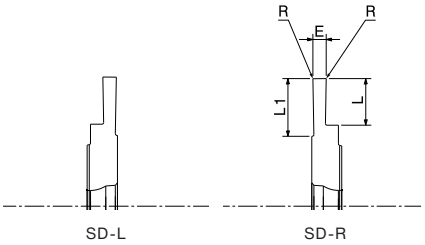


Schruppen
Roughing





Schlichten
Finishing



Dir.	E	L	L1	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
SD6-R								
R	0.50	2.00	6.00	-	**437353**	**434794**	**453888**	**381642**
R	0.60	2.00	6.00	-	**448783**	**448785**	**453889**	**448787**
R	0.75	2.50	6.00	-	**448784**	**448786**	**453890**	**448788**
R	0.80	2.50	6.00	-	**437356**	**442156**	**427030**	**381643**
R	0.80	2.50	6.00	0.08	**448789**	**448791**	**448793**	**448798**
R	0.90	3.00	6.00	-	**448790**	**448792**	**448794**	**448799**
R	1.00	3.00	6.00	-	**437358**	**442157**	**448795**	**381644**
R	1.00	3.00	6.00	0.08	**448800**	**448801**	**448796**	**448802**
R	1.20	4.00	6.00	-	**437361**	**442158**	**448797**	**381645**
R	1.50	4.00	6.00	-	**437364**	**434570**	**427031**	**381646**
R	1.50	4.00	6.00	0.08	**448803**	**448807**	**448811**	**448815**
R	1.50	4.00	6.00	0.15	**448804**	**448808**	**448812**	**448816**
R	1.50	4.00	6.00	0.20	**448805**	**448809**	**448813**	**448817**
R	1.80	4.50	6.00	-	**448806**	**448810**	**448814**	**448818**
R	2.00	5.00	6.00	-	**428537**	**434571**	**427033**	**381647**
R	2.00	5.00	6.00	0.08	**448819**	**448825**	**448831**	**448840**
R	2.00	5.00	6.00	0.15	**448820**	**448826**	**448832**	**448841**
R	2.00	5.00	6.00	0.20	**448821**	**448827**	**448833**	**448842**

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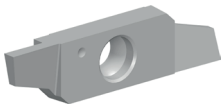
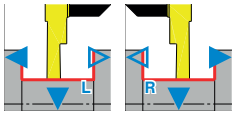
Einstechen und Drehen
Grooving and Turning



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7		S1	S2	S3	H1	H2

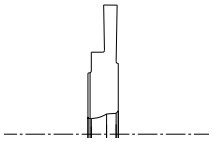


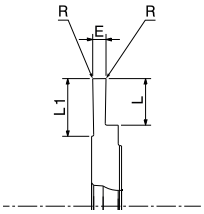
Schruppen
Roughing





Schlichten
Finishing





Dir.	E	L	L1	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
SD8-L								
L	0.50	4.00	6.00	-	**448822**	**448828**	**448834**	**448843**
L	0.75	4.50	6.50	-	**448823**	**448829**	**448835**	**448844**
L	0.80	4.50	6.50	-	**448824**	**448830**	**448836**	**448845**
L	1.00	5.00	8.00	-	**442160**	**442165**	**448837**	**448846**
L	1.00	5.00	8.00	0.08	**448850**	**448849**	**448838**	**448847**
L	1.20	5.00	8.00	-	**442162**	**442166**	**448839**	**448848**
L	1.50	5.00	8.00	-	**374670**	**442167**	**427059**	**374673**
L	1.50	5.00	8.00	0.08	**448851**	**448855**	**448859**	**448863**
L	1.50	5.00	8.00	0.15	**448852**	**448856**	**448860**	**448864**
L	1.50	5.00	8.00	0.20	**448853**	**448857**	**448861**	**448865**
L	1.80	5.00	8.00	-	**448854**	**448858**	**448862**	**448866**
L	2.00	5.00	8.00	-	**374669**	**442168**	**427061**	**374672**
L	2.00	5.00	8.00	0.08	**448867**	**448870**	**448873**	**448876**
L	2.00	5.00	8.00	0.15	**448868**	**448871**	**448874**	**448877**
L	2.00	5.00	8.00	0.20	**448869**	**448872**	**448875**	**448878**
L	2.50	6.00	8.00	-	**374668**	**442169**	**427063**	**374671**
L	2.50	6.00	8.00	0.15	**448879**	**448884**	**448889**	**448897**
L	2.50	6.00	8.00	0.20	**448880**	**448885**	**448890**	**448898**
SD8P-L								
L	3.00	6.00	8.00	-	**448937**	**448949**	**448961**	**448985**
L	3.00	6.00	8.00	0.08	**448938**	**448950**	**448962**	**448986**
L	3.00	6.00	8.00	0.15	**448939**	**448951**	**448963**	**448987**
L	3.00	6.00	8.00	0.20	**448940**	**448952**	**448964**	**448988**
L	3.00	6.00	8.00	0.40	**448941**	**448953**	**448965**	**448989**

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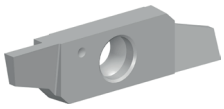
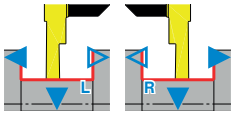
Einstechen und Drehen
Grooving and Turning



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7		S1	S2	S3	H1	H2

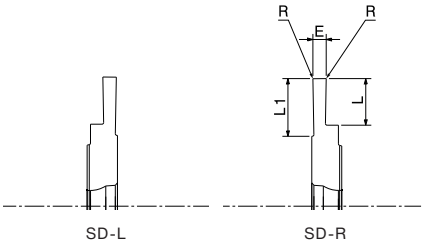


Schruppen
Roughing





Schlichten
Finishing



Dir.	E	L	L1	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
SD8-R								
R	0.50	4.00	6.00	-	**448881**	**448886**	**448891**	**448899**
R	0.75	4.50	6.50	-	**448882**	**448887**	**448892**	**448900**
R	0.80	4.50	6.50	-	**448883**	**448888**	**448893**	**448901**
R	1.00	5.00	8.00	-	**442163**	**442170**	**448894**	**448902**
R	1.00	5.00	8.00	0.08	**448905**	**448906**	**448895**	**448903**
R	1.20	5.00	8.00	-	**442164**	**442171**	**448896**	**448904**
R	1.50	5.00	8.00	-	**374691**	**438081**	**427060**	**374694**
R	1.50	5.00	8.00	0.08	**448907**	**448911**	**448915**	**448919**
R	1.50	5.00	8.00	0.15	**448908**	**448912**	**448916**	**448920**
R	1.50	5.00	8.00	0.20	**448909**	**448913**	**448917**	**448921**
R	1.80	5.00	8.00	-	**448910**	**448914**	**448918**	**448922**
R	2.00	5.00	8.00	-	**374690**	**437881**	**427062**	**374693**
R	2.00	5.00	8.00	0.08	**448923**	**448926**	**448929**	**448932**
R	2.00	5.00	8.00	0.15	**448924**	**448927**	**448930**	**448933**
R	2.00	5.00	8.00	0.20	**448925**	**448928**	**448931**	**448934**
R	2.50	6.00	8.00	-	**374689**	**442172**	**427064**	**374692**
R	2.50	6.00	8.00	0.15	**448935**	**448947**	**448959**	**448983**
R	2.50	6.00	8.00	0.20	**448936**	**448948**	**448960**	**448984**
SD8P-R								
R	3.00	6.00	8.00	-	**448942**	**448954**	**448966**	**448990**
R	3.00	6.00	8.00	0.08	**448943**	**448955**	**448967**	**448991**
R	3.00	6.00	8.00	0.15	**448944**	**448956**	**448968**	**448992**
R	3.00	6.00	8.00	0.20	**448945**	**448957**	**448969**	**448993**
R	3.00	6.00	8.00	0.40	**448946**	**448958**	**448970**	**448994**

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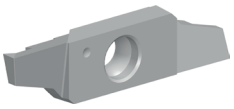
SD CP

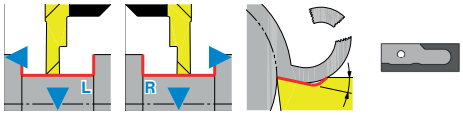
Einstechen und Drehen mit Spanbrecher
Grooving and Turning with chipbreaker



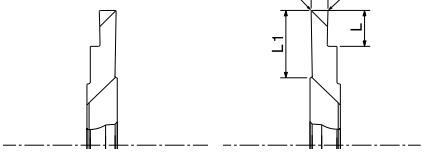
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	



Schruppen
Roughing



Schlichten
Finishing



SD-L CP SD-R CP

Dir.	E	L	L1	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
SD6-L CP								
L	0.80	2.00	6.00	-	**442173**	**442182**	**448971**	**448995**
L	1.00	2.50	6.00	0.08	**442174**	**442183**	**448972**	**448996**
L	1.20	3.00	6.00	-	**442175**	**442184**	**448973**	**448997**
L	1.50	3.00	6.00	-	**442176**	**442185**	**448974**	**448998**
L	1.50	3.00	6.00	0.08	**442177**	**442186**	**448975**	**448999**
L	1.50	3.00	6.00	0.15	**449007**	**449010**	**448976**	**449000**
L	1.50	3.00	6.00	0.20	**449008**	**449011**	**448977**	**449001**
L	1.80	3.50	6.00	-	**449009**	**449012**	**448978**	**449002**
L	2.00	4.00	6.00	-	**442178**	**442187**	**448979**	**449003**
L	2.00	4.00	6.00	0.08	**442179**	**442188**	**448980**	**449004**
L	2.00	4.00	6.00	0.15	**449013**	**449015**	**448981**	**449005**
L	2.00	4.00	6.00	0.20	**449014**	**449016**	**448982**	**449006**
SD6-R CP								
R	0.80	2.00	6.00	-	**436533**	**436551**	**431766**	**431767**
R	1.00	2.50	6.00	0.08	**436534**	**436552**	**431769**	**431770**
R	1.20	3.00	6.00	-	**441539**	**442180**	**449017**	**449018**
R	1.50	3.00	6.00	-	**436535**	**436553**	**431772**	**431773**
R	1.50	3.00	6.00	0.08	**436536**	**436554**	**431775**	**431776**
R	1.50	3.00	6.00	0.15	**449019**	**449022**	**449025**	**449028**
R	1.50	3.00	6.00	0.20	**449020**	**449023**	**449026**	**449029**
R	1.80	3.50	6.00	-	**449021**	**449024**	**449027**	**449030**
R	2.00	4.00	6.00	-	**436537**	**436555**	**431778**	**431779**
R	2.00	4.00	6.00	0.08	**441540**	**442181**	**449031**	**449032**
R	2.00	4.00	6.00	0.15	**449033**	**449036**	**449039**	**449066**
R	2.00	4.00	6.00	0.20	**449034**	**449037**	**449040**	**449067**

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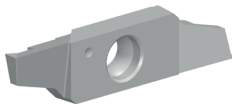
SD CP

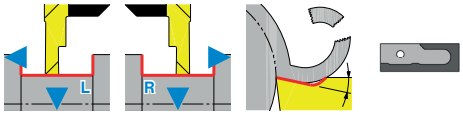
Einstechen und Drehen mit Spanbrecher
Grooving and Turning with chipbreaker



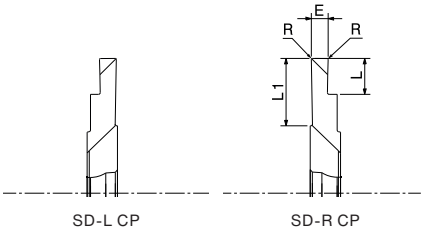
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	



Schruppen
Roughing



Schlichten
Finishing



SD-L CP SD-R CP

Dir.	E	L	L1	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
SD8-L CP								
L	1.00	4.00	6.00	-	**449035**	**449038**	**449041**	**449068**
L	1.00	4.00	6.00	0.08	**442189**	**442197**	**449042**	**449069**
L	1.00	4.00	6.00	0.20	**449093**	**449094**	**449043**	**449070**
L	1.20	4.00	6.00	-	**449095**	**449096**	**449044**	**449071**
L	1.20	4.00	6.00	0.08	**442190**	**442198**	**449045**	**449072**
L	1.50	4.00	6.00	-	**449097**	**449098**	**449046**	**449073**
L	1.50	4.00	6.00	0.08	**442191**	**442199**	**449047**	**449074**
L	1.50	4.00	6.00	0.15	**449099**	**449102**	**449048**	**449075**
L	1.50	4.00	6.00	0.20	**449100**	**449103**	**449049**	**449076**
L	1.80	4.50	6.00	-	**449101**	**449104**	**449050**	**449077**
L	2.00	5.00	6.00	-	**442192**	**442200**	**449051**	**449078**
L	2.00	5.00	6.00	0.08	**449105**	**449107**	**449052**	**449079**
L	2.00	5.00	6.00	0.15	**449106**	**449108**	**449053**	**449080**
L	2.00	5.00	6.00	0.20	**442193**	**442201**	**449054**	**449081**
L	2.50	6.00	6.00	-	**442194**	**442202**	**449055**	**449082**
L	2.50	6.00	6.00	0.08	**449109**	**449114**	**449056**	**449083**
L	2.50	6.00	6.00	0.15	**449110**	**449115**	**449057**	**449084**
L	2.50	6.00	6.00	0.20	**449111**	**449116**	**449058**	**449085**
L	2.50	6.00	6.00	0.35	**449112**	**449117**	**449059**	**449086**
SD8P-L CP								
L	3.00	6.00	6.00	-	**449149**	**449163**	**449177**	**449201**
L	3.00	6.00	6.00	0.08	**449150**	**449164**	**449178**	**449202**
L	3.00	6.00	6.00	0.15	**449151**	**449165**	**449179**	**449203**
L	3.00	6.00	6.00	0.20	**449152**	**449166**	**449180**	**449204**
L	3.00	6.00	6.00	0.40	**449153**	**449167**	**449181**	**449205**

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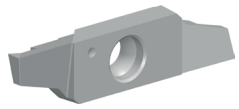
SD CP

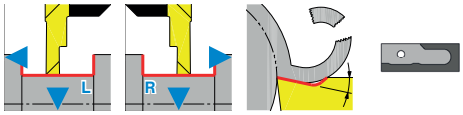
Einstechen und Drehen mit Spanbrecher
Grooving and Turning with chipbreaker



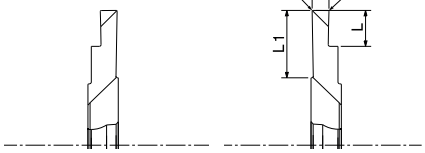
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	



Schruppen
Roughing



Schlichten
Finishing



SD-L CP SD-R CP

Dir.	E	L	L1	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
SD8-R CP								
R	1.00	4.00	6.00	-	**449113**	**449118**	**449060**	**449087**
R	1.00	4.00	6.00	0.08	**441541**	**442195**	**449061**	**449088**
R	1.00	4.00	6.00	0.20	**449119**	**449121**	**449062**	**449089**
R	1.20	4.00	6.00	-	**449120**	**449122**	**449063**	**449090**
R	1.20	4.00	6.00	0.08	**441542**	**442196**	**449064**	**449091**
R	1.50	4.00	6.00	-	**449123**	**449124**	**449065**	**449092**
R	1.50	4.00	6.00	0.08	**436538**	**436556**	**431781**	**431782**
R	1.50	4.00	6.00	0.15	**449125**	**449128**	**449131**	**449134**
R	1.50	4.00	6.00	0.20	**449126**	**449129**	**449132**	**449135**
R	1.80	4.50	6.00	-	**449127**	**449130**	**449133**	**449136**
R	2.00	5.00	6.00	-	**436539**	**436557**	**431784**	**431785**
R	2.00	5.00	6.00	0.08	**449137**	**449139**	**449141**	**449143**
R	2.00	5.00	6.00	0.15	**449138**	**449140**	**449142**	**449144**
R	2.00	5.00	6.00	0.20	**436540**	**436558**	**431787**	**431788**
R	2.50	6.00	6.00	-	**436541**	**436559**	**431790**	**431791**
R	2.50	6.00	6.00	0.08	**449145**	**449159**	**449173**	**449197**
R	2.50	6.00	6.00	0.15	**449146**	**449160**	**449174**	**449198**
R	2.50	6.00	6.00	0.20	**449147**	**449161**	**449175**	**449199**
R	2.50	6.00	6.00	0.35	**449148**	**449162**	**449176**	**449200**
SD8P-R CP								
R	3.00	6.00	6.00	-	**449154**	**449168**	**449182**	**449206**
R	3.00	6.00	6.00	0.08	**449155**	**449169**	**449183**	**449207**
R	3.00	6.00	6.00	0.15	**449156**	**449170**	**449184**	**449208**
R	3.00	6.00	6.00	0.20	**449157**	**449171**	**449185**	**449209**
R	3.00	6.00	6.00	0.40	**449158**	**449172**	**449186**	**449210**

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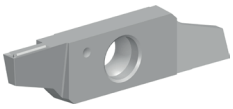
SD TU

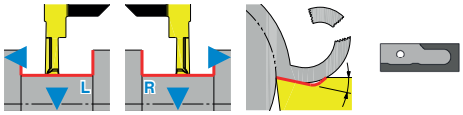
Einstechen und Drehen mit Spanbrecher
Grooving and Turning with chipbreaker



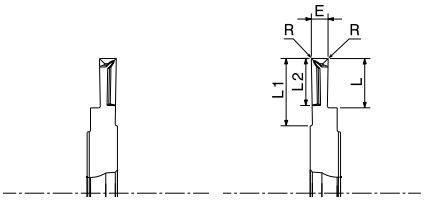
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	



Schruppen
Roughing



Schlichten
Finishing



SD-L TU SD-R TU

Dir.	E	L	L1	L2	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
SD6-L TU									
L	0.50	2.00	6.00	2.00	0.01	**442206**	**442217**	**449187**	**449211**
L	0.80	2.50	6.00	2.50	0.01	**442207**	**442218**	**449188**	**449212**
L	1.00	3.00	6.00	3.00	0.01	**442208**	**442219**	**449189**	**449213**
L	1.20	4.00	6.00	4.00	0.01	**442209**	**442220**	**449190**	**449214**
L	1.50	4.00	6.00	4.00	0.01	**442210**	**442221**	**449191**	**449215**
L	1.50	4.00	6.00	4.00	0.08	**442211**	**442222**	**449192**	**449216**
L	2.00	5.00	6.00	5.00	0.01	**442212**	**442223**	**449193**	**449217**
L	2.00	5.00	6.00	5.00	0.08	**442213**	**442224**	**449194**	**449218**
SD6-R TU									
R	0.50	2.00	6.00	2.00	0.01	**441543**	**442214**	**449195**	**449219**
R	0.80	2.50	6.00	2.50	0.01	**441544**	**442215**	**449196**	**449220**
R	1.00	3.00	6.00	3.00	0.01	**436501**	**436565**	**432613**	**432614**
R	1.20	4.00	6.00	4.00	0.01	**441545**	**442216**	**449221**	**449222**
R	1.50	4.00	6.00	4.00	0.01	**436502**	**436566**	**432616**	**432617**
R	1.50	4.00	6.00	4.00	0.08	**436503**	**436567**	**432619**	**432620**
R	2.00	5.00	6.00	5.00	0.01	**436504**	**436568**	**432622**	**432623**
R	2.00	5.00	6.00	5.00	0.08	**436505**	**436569**	**432625**	**432626**

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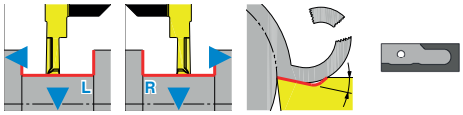
SD TU

Einstechen und Drehen mit Spanbrecher
Grooving and Turning with chipbreaker

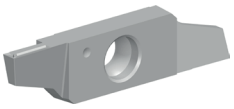


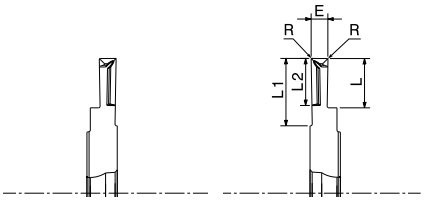
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	

Schruppen
Roughing



Schlichten
Finishing





SD-L TU SD-R TU

Dir.	E	L	L1	L2	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
SD8-L TU									
L	1.00	5.00	8.00	5.00	0.03	**442226**	**442236**	**449223**	**449234**
L	1.20	5.00	8.00	5.00	0.03	**442227**	**442237**	**449224**	**449235**
L	1.50	5.00	8.00	5.00	0.03	**442228**	**442238**	**449225**	**449236**
L	1.50	5.00	8.00	5.00	0.08	**449245**	**449246**	**449226**	**449237**
L	2.00	5.00	8.00	5.00	0.08	**442229**	**442239**	**449227**	**449238**
L	2.00	5.00	8.00	5.00	0.20	**442230**	**442240**	**449228**	**449239**
L	2.50	6.00	8.00	6.00	0.03	**442231**	**442241**	**449229**	**449240**
L	2.50	6.00	8.00	6.00	0.08	**442232**	**442242**	**449230**	**449241**
L	2.50	6.00	8.00	6.00	0.20	**442233**	**442243**	**449231**	**449242**
SD8-R TU									
R	1.00	5.00	8.00	5.00	0.03	**441546**	**442234**	**449232**	**449243**
R	1.20	5.00	8.00	5.00	0.03	**441547**	**442235**	**449233**	**449244**
R	1.50	5.00	8.00	5.00	0.03	**436506**	**436570**	**432628**	**432629**
R	1.50	5.00	8.00	5.00	0.08	**449247**	**449248**	**449249**	**449250**
R	2.00	5.00	8.00	5.00	0.08	**436507**	**436571**	**432631**	**432632**
R	2.00	5.00	8.00	5.00	0.20	**436508**	**436572**	**432634**	**432635**
R	2.50	6.00	8.00	6.00	0.03	**436509**	**436573**	**432637**	**432638**
R	2.50	6.00	8.00	6.00	0.08	**436510**	**436574**	**432640**	**432641**
R	2.50	6.00	8.00	6.00	0.20	**436511**	**436575**	**432643**	**432644**

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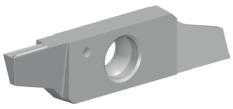
SD TB

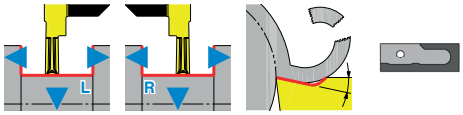
Einstechen und Drehen mit Spanbrecher
Grooving and Turning with chipbreaker



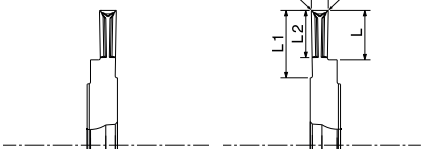
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	



Schruppen
Roughing



Schlichten
Finishing



Dir.	E	L	L1	L2	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
SD6-L TB									
L	1.50	4.00	6.00	4.00	0.03	**442244**	**442248**	**453891**	**453892**
L	1.50	4.00	6.00	4.00	0.08	**442245**	**442249**	**449251**	**449254**
L	2.00	5.00	6.00	5.00	0.03	**442246**	**442250**	**449252**	**449255**
L	2.00	5.00	6.00	5.00	0.08	**442247**	**442251**	**449253**	**449256**
SD6-R TB									
R	1.50	4.00	6.00	4.00	0.03	**436512**	**436576**	**432646**	**432647**
R	1.50	4.00	6.00	4.00	0.08	**436513**	**436577**	**432649**	**432650**
R	2.00	5.00	6.00	5.00	0.03	**436514**	**436578**	**432652**	**432653**
R	2.00	5.00	6.00	5.00	0.08	**436515**	**436579**	**432655**	**432656**

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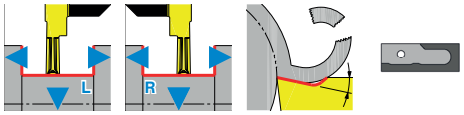
SD TB

Einstechen und Drehen mit Spanbrecher
Grooving and Turning with chipbreaker

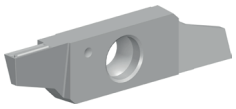


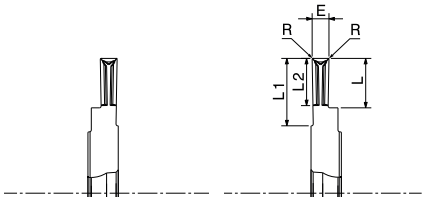
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	

Schruppen
Roughing



Schlichten
Finishing





SD-L TB SD-R TB

Dir.	E	L	L1	L2	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
SD8-L TB									
L	1.50	4.00	8.00	4.00	0.08	**442252**	**442257**	**449257**	**454797**
L	2.00	5.00	8.00	5.00	0.08	**442253**	**442258**	**449258**	**449264**
L	2.00	5.00	8.00	5.00	0.15	**442254**	**442259**	**449259**	**449265**
L	2.00	5.00	8.00	5.00	0.35	**449270**	**449271**	**449260**	**449266**
L	2.50	6.00	8.00	6.00	0.08	**442255**	**442260**	**449261**	**449267**
L	2.50	6.00	8.00	6.00	0.15	**442256**	**442261**	**449262**	**449268**
L	2.50	6.00	8.00	6.00	0.35	**449272**	**449273**	**449263**	**449269**
SD8P-L TB									
L	3.00	6.00	8.00	6.00	0.08	**449279**	**449286**	**449293**	**449310**
L	3.00	6.00	8.00	6.00	0.15	**449280**	**449287**	**449294**	**449311**
L	3.00	6.00	8.00	6.00	0.35	**449281**	**449288**	**449295**	**449312**

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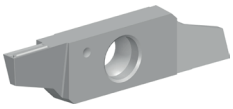
SD TB

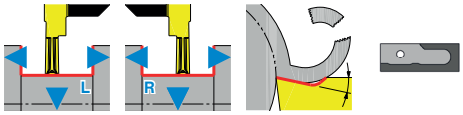
Einstechen und Drehen mit Spanbrecher
Grooving and Turning with chipbreaker



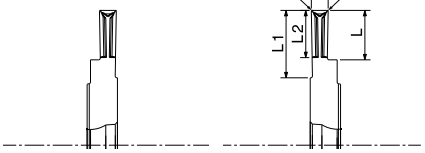
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	



Schruppen
Roughing



Schlichten
Finishing



SD-L TB SD-R TB

Dir.	E	L	L1	L2	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
SD8-R TB									
R	1.50	4.00	8.00	4.00	0.08	**436516**	**436580**	**432658**	**432659**
R	2.00	5.00	8.00	5.00	0.08	**436517**	**436581**	**432661**	**432662**
R	2.00	5.00	8.00	5.00	0.15	**436518**	**436582**	**432664**	**432665**
R	2.00	5.00	8.00	5.00	0.35	**449274**	**449275**	**449276**	**449277**
R	2.50	6.00	8.00	6.00	0.08	**436519**	**436583**	**432667**	**432668**
R	2.50	6.00	8.00	6.00	0.15	**436520**	**436584**	**432670**	**432671**
R	2.50	6.00	8.00	6.00	0.35	**449278**	**449285**	**449292**	**449309**
SD8P-R TB									
R	3.00	6.00	8.00	6.00	0.08	**449282**	**449289**	**449296**	**449313**
R	3.00	6.00	8.00	6.00	0.15	**449283**	**449290**	**449297**	**449314**
R	3.00	6.00	8.00	6.00	0.35	**449284**	**449291**	**449298**	**449315**

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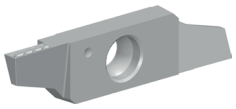
SD TD

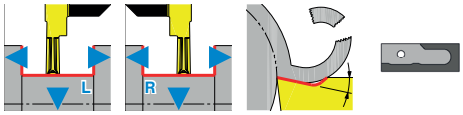
Einstechen und Drehen mit Spanbrecher
Grooving and Turning with chipbreaker



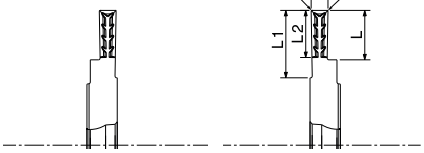
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4			N7	N8	S1	S2	S3	H1	H2



Schruppen
Roughing



Schlichten
Finishing



SD-L TD SD-R TD

Dir.	E	L	L1	L2	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
SD6-L TD									
L	0.50	2.00	6.00	2.00	0.01	**442262**	**442273**	**449299**	**449316**
L	0.80	2.50	6.00	2.50	0.01	**442263**	**442274**	**449300**	**449317**
L	1.00	3.00	6.00	3.00	0.01	**442264**	**442275**	**449301**	**449318**
L	1.20	4.00	6.00	4.00	0.01	**442265**	**442276**	**449302**	**449319**
L	1.50	4.00	6.00	4.00	0.01	**442266**	**442277**	**449303**	**449320**
L	1.50	4.00	6.00	4.00	0.08	**442267**	**442278**	**449304**	**449321**
L	2.00	5.00	6.00	5.00	0.01	**442268**	**442279**	**449305**	**449322**
L	2.00	5.00	6.00	5.00	0.08	**442269**	**442280**	**449306**	**449323**
SD6-R TD									
R	0.50	2.00	6.00	2.00	0.01	**441548**	**442270**	**449307**	**449324**
R	0.80	2.50	6.00	2.50	0.01	**441549**	**442271**	**449308**	**449325**
R	1.00	3.00	6.00	3.00	0.01	**436521**	**436585**	**432673**	**432674**
R	1.20	4.00	6.00	4.00	0.01	**441550**	**442272**	**449326**	**449327**
R	1.50	4.00	6.00	4.00	0.01	**436522**	**436586**	**432676**	**432677**
R	1.50	4.00	6.00	4.00	0.08	**436523**	**436587**	**432679**	**432680**
R	2.00	5.00	6.00	5.00	0.01	**436524**	**436588**	**432682**	**432683**
R	2.00	5.00	6.00	5.00	0.08	**436525**	**436589**	**432685**	**432686**

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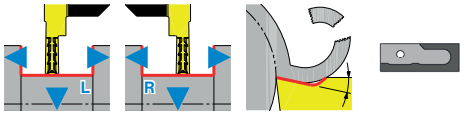
SD TD

Einstechen und Drehen mit Spanbrecher
Grooving and Turning with chipbreaker

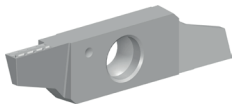


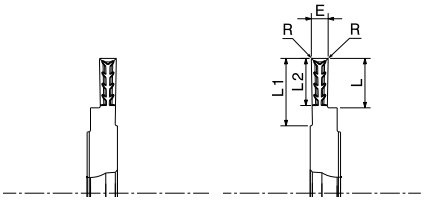
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4			N7	N8	S1	S2	S3	H1	H2

Schruppen
Roughing



Schlichten
Finishing





SD-L TD SD-R TD

Dir.	E	L	L1	L2	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
SD8-L TD									
L	1.00	3.00	8.00	3.00	0.03	**442281**	**442294**	**449328**	**449341**
L	1.20	3.50	8.00	3.50	0.03	**442282**	**442295**	**449329**	**449342**
L	1.50	4.00	8.00	4.00	0.03	**442283**	**442296**	**449330**	**449343**
L	1.50	4.00	8.00	4.00	0.08	**442284**	**442297**	**449331**	**449344**
L	1.50	4.00	8.00	4.00	0.20	**450462**	**450463**	**449332**	**449345**
L	2.00	5.00	8.00	5.00	0.08	**442285**	**442298**	**449333**	**449346**
L	2.00	5.00	8.00	5.00	0.20	**442286**	**442299**	**449334**	**449347**
L	2.50	6.00	8.00	6.00	0.03	**442287**	**442300**	**449335**	**449348**
L	2.50	6.00	8.00	6.00	0.08	**442288**	**442301**	**449336**	**449349**
L	2.50	6.00	8.00	6.00	0.20	**442289**	**442302**	**449337**	**449350**
L	2.50	6.00	8.00	6.00	0.40	**442290**	**442303**	**449338**	**449351**
SD8P-L TD									
L	3.00	6.00	8.00	6.00	0.08	**449532**	**449526**	**449442**	**449360**
L	3.00	6.00	8.00	6.00	0.20	**449533**	**449527**	**449443**	**449361**
L	3.00	6.00	8.00	6.00	0.40	**449534**	**449528**	**449444**	**449362**

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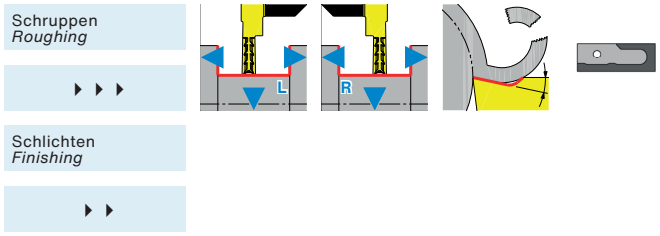
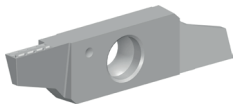
SD TD

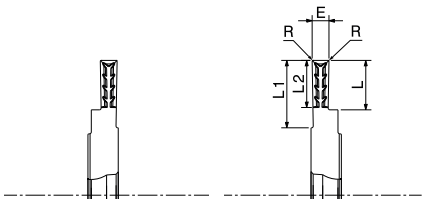
Einstechen und Drehen mit Spanbrecher
Grooving and Turning with chipbreaker



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4			N7	N8	S1	S2	S3	H1	H2







Dir.	E	L	L1	L2	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
SD8-R TD									
R	1.00	3.00	8.00	3.00	0.03	**441551**	**442292**	**449339**	**449352**
R	1.20	3.50	8.00	3.50	0.03	**441552**	**442293**	**449340**	**449353**
R	1.50	4.00	8.00	4.00	0.03	**436526**	**436590**	**432688**	**432689**
R	1.50	4.00	8.00	4.00	0.08	**436527**	**436591**	**432691**	**432692**
R	1.50	4.00	8.00	4.00	0.20	**449354**	**449355**	**449356**	**449357**
R	2.00	5.00	8.00	5.00	0.08	**436528**	**436592**	**432694**	**432695**
R	2.00	5.00	8.00	5.00	0.20	**436529**	**436593**	**432697**	**432698**
R	2.50	6.00	8.00	6.00	0.03	**436530**	**436594**	**432700**	**432701**
R	2.50	6.00	8.00	6.00	0.08	**436531**	**436595**	**432703**	**432704**
R	2.50	6.00	8.00	6.00	0.20	**436532**	**436596**	**432706**	**432707**
R	2.50	6.00	8.00	6.00	0.40	**441553**	**442291**	**449358**	**449359**
SD8P-R TD									
R	3.00	6.00	8.00	6.00	0.08	**449535**	**449529**	**449445**	**449363**
R	3.00	6.00	8.00	6.00	0.20	**449536**	**449530**	**449446**	**449364**
R	3.00	6.00	8.00	6.00	0.40	**449537**	**449531**	**449447**	**449365**

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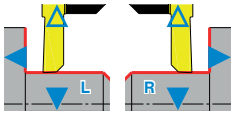
DV F

Vorwärts Drehen mit Wiper
Front turning with wiper



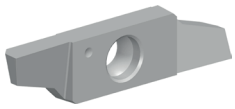
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7		S1	S2	S3	H1	H2

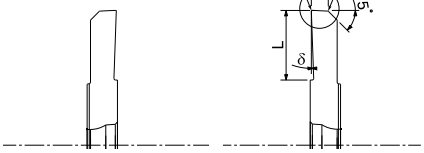
Schruppen
Roughing

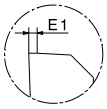




Schlichten
Finishing







Dir.	E	E1	L	R	δ	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
DV6F-L									
L	1.50	0.30	6.00	-	-	**442559**	**442568**	**449448**	**449366**
L	1.50	0.30	6.00	0.03	-	**442561**	**442569**	**449449**	**449367**
L	1.50	0.30	6.00	0.08	-	**442563**	**442570**	**449450**	**449368**
L	1.50	0.30	6.00	-	2.0°	**443025**	**443033**	**449451**	**449369**
L	1.50	0.30	6.00	0.03	2.0°	**443026**	**443965**	**449452**	**449370**
L	1.50	0.30	6.00	0.08	2.0°	**443027**	**443034**	**449453**	**449371**
DV6F-R									
R	1.50	0.30	6.00	-	-	**442565**	**442571**	**449454**	**449372**
R	1.50	0.30	6.00	0.03	-	**442566**	**442572**	**449455**	**449373**
R	1.50	0.30	6.00	0.08	-	**442567**	**442573**	**449456**	**449374**
R	1.50	0.30	6.00	-	2.0°	**443029**	**443035**	**449457**	**449375**
R	1.50	0.30	6.00	0.03	2.0°	**443030**	**443036**	**449458**	**449376**
R	1.50	0.30	6.00	0.08	2.0°	**443031**	**443037**	**449459**	**449377**

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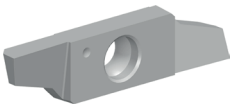
DV F

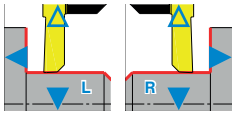
Vorwärts Drehen mit Wiper
Front turning with wiper



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7		S1	S2	S3	H1	H2

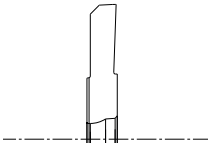


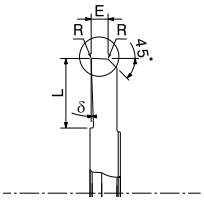
Schruppen
Roughing

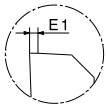




Schlichten
Finishing







Dir.	E	E1	L	R	δ	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
DV8F-L									
L	2.00	0.50	8.00	-	-	**442530**	**442549**	**449460**	**449378**
L	2.00	0.50	8.00	0.03	-	**442532**	**442551**	**449461**	**449379**
L	2.00	0.50	8.00	0.08	-	**442533**	**442552**	**449462**	**449380**
L	2.00	0.50	8.00	0.20	-	**443966**	**442535**	**449463**	**449381**
L	2.00	0.50	8.00	-	3.0°	**442536**	**443038**	**449464**	**449382**
L	2.00	0.50	8.00	0.03	3.0°	**442537**	**443039**	**449465**	**449383**
L	2.00	0.50	8.00	0.08	3.0°	**442538**	**443040**	**449466**	**449384**
L	2.00	0.50	8.00	0.20	3.0°	**442539**	**443041**	**449467**	**449385**
DV8F-R									
R	2.00	0.50	8.00	-	-	**442531**	**442554**	**449468**	**449386**
R	2.00	0.50	8.00	0.03	-	**443980**	**442540**	**449469**	**449387**
R	2.00	0.50	8.00	0.08	-	**442541**	**442555**	**449470**	**449388**
R	2.00	0.50	8.00	0.20	-	**453893**	**442542**	**449471**	**449389**
R	2.00	0.50	8.00	-	3.0°	**442543**	**443043**	**449472**	**449390**
R	2.00	0.50	8.00	0.03	3.0°	**442544**	**443044**	**449473**	**449391**
R	2.00	0.50	8.00	0.08	3.0°	**442545**	**443045**	**449474**	**449392**
R	2.00	0.50	8.00	0.20	3.0°	**442546**	**443046**	**449475**	**449393**

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DV CP

Vorwärts Drehen mit Spanbrecher
Front turning with chipbreaker

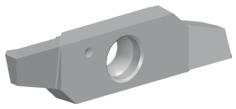


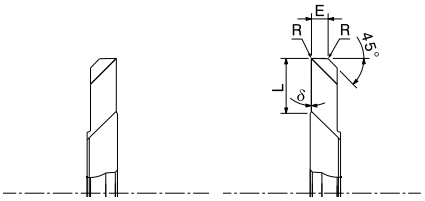
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	H2

Schruppen
Roughing



Schlichten
Finishing





DV-L CP DV-R CP

Dir.	E	L	R	δ	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
DV6-L CP								
L	1.50	4.50	-	-	**442574**	**443051**	**449476**	**449394**
L	1.50	4.50	0.03	-	**443047**	**443053**	**449477**	**449395**
L	1.50	4.50	0.08	-	**443048**	**443054**	**449478**	**449396**
DV6-R CP								
R	1.50	4.50	-	-	**443052**	**443055**	**449479**	**449397**
R	1.50	4.50	0.03	-	**443049**	**443056**	**449480**	**449398**
R	1.50	4.50	0.08	-	**443050**	**443057**	**449481**	**449399**
DV8-L CP								
L	2.00	7.00	-	-	**443058**	**443064**	**449482**	**449400**
L	2.00	7.00	0.03	-	**443059**	**443065**	**449483**	**449401**
L	2.00	7.00	0.08	-	**443060**	**443066**	**449484**	**449402**
DV8-R CP								
R	2.00	7.00	-	-	**443061**	**443067**	**449485**	**449403**
R	2.00	7.00	0.03	-	**443062**	**443068**	**449486**	**449404**
R	2.00	7.00	0.08	-	**443063**	**443069**	**449487**	**449405**

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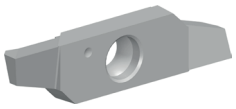
DV F CP

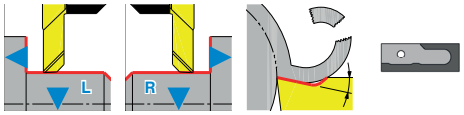
Vorwärts Drehen mit Spanbrecher und Wiper
Front turning with chipbreaker and wiper



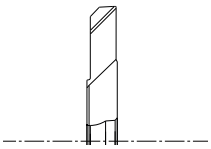
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	H2

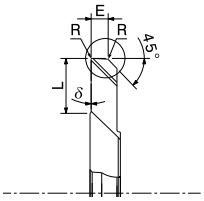


Schruppen
Roughing

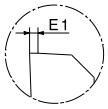


Schlichten
Finishing


DV F-L CP



DV F-R CP



Dir.	E	E1	L	R	δ	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
DV6F-L CP									
L	1.50	0.30	4.50	-	-	**443070**	**443077**	**449488**	**449406**
L	1.50	0.30	4.50	0.03	-	**443071**	**443078**	**449489**	**449407**
L	1.50	0.30	4.50	0.08	-	**443072**	**443079**	**449490**	**449408**
DV6F-R CP									
R	1.50	0.30	4.50	-	-	**443074**	**443080**	**449491**	**452877**
R	1.50	0.30	4.50	0.03	-	**443075**	**443081**	**449492**	**449410**
R	1.50	0.30	4.50	0.08	-	**443076**	**443130**	**449493**	**449411**
DV8F-L CP									
L	2.00	0.50	7.00	-	-	**443082**	**443090**	**449494**	**449412**
L	2.00	0.50	7.00	0.03	-	**443083**	**443091**	**449495**	**449413**
L	2.00	0.50	7.00	0.08	-	**443084**	**443092**	**449496**	**449414**
L	2.00	0.50	7.00	0.20	-	**443085**	**443093**	**449497**	**449415**
DV8F-R CP									
R	2.00	0.50	7.00	-	-	**443086**	**443094**	**449498**	**449416**
R	2.00	0.50	7.00	0.03	-	**443087**	**443095**	**449499**	**449417**
R	2.00	0.50	7.00	0.08	-	**443088**	**443096**	**449500**	**449418**
R	2.00	0.50	7.00	0.20	-	**443089**	**443097**	**449501**	**449419**

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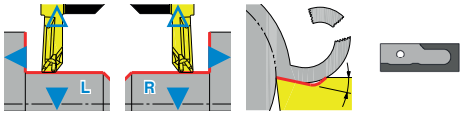
DV VR

Vorwärts Drehen mit Spanbrecher
Front turning with chipbreaker

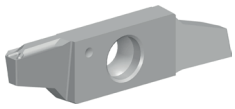


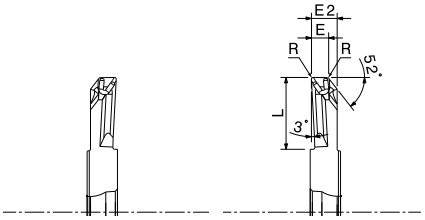
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	H2

Schruppen
Roughing



Schlichten
Finishing





DV-L VR DV-R VR

Dir.	E	E2	L	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
DV6-L VR								
L	1.50	2.30	6.00	-	**443098**	**443104**	**449502**	**449420**
L	1.50	2.30	6.00	0.08	**443099**	**443105**	**449503**	**449421**
L	1.50	2.30	6.00	0.20	**443100**	**443106**	**449504**	**449422**
DV6-R VR								
R	1.50	2.30	6.00	-	**443101**	**443107**	**449505**	**449423**
R	1.50	2.30	6.00	0.08	**443102**	**443108**	**449506**	**449424**
R	1.50	2.30	6.00	0.20	**443103**	**443109**	**449507**	**449425**
DV8-L VR								
L	1.50	2.85	8.00	0.08	**443110**	**443114**	**449508**	**449426**
L	1.50	2.85	8.00	0.20	**443111**	**443115**	**449509**	**449427**
DV8-R VR								
R	1.50	2.85	8.00	0.08	**443112**	**443116**	**449510**	**449428**
R	1.50	2.85	8.00	0.20	**443113**	**443117**	**449511**	**449429**

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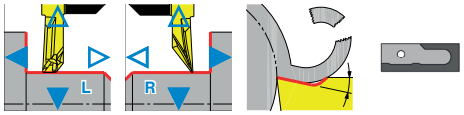
DV VN

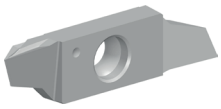
Vorwärts Drehen mit Spanbrecher
Front turning with chipbreaker

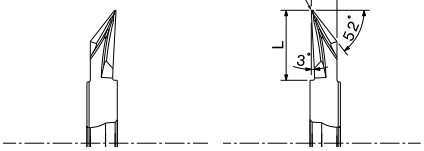
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	

Schruppen
Roughing

Schlichten
Finishing







DV-L VN DV-R VN

Dir.	R	L	E2	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
DV6-L VN							
L	0.05	6.00	2.30	**443118**	**443124**	**449512**	**449430**
L	0.08	6.00	2.30	**443119**	**443125**	**449513**	**449431**
L	0.20	6.00	2.30	**443120**	**443126**	**449514**	**449432**
DV6-R VN							
R	0.05	6.00	2.30	**443121**	**443127**	**449515**	**449433**
R	0.08	6.00	2.30	**443122**	**443128**	**449516**	**449434**
R	0.20	6.00	2.30	**443282**	**443129**	**449517**	**449435**
DV8-L VN							
L	0.05	8.00	2.85	**443131**	**443137**	**449518**	**449436**
L	0.08	8.00	2.85	**443132**	**443138**	**449519**	**449437**
L	0.20	8.00	2.85	**443133**	**443139**	**449520**	**449438**
DV8-R VN							
R	0.05	8.00	2.85	**443134**	**443140**	**449521**	**449439**
R	0.08	8.00	2.85	**443135**	**443141**	**449522**	**449440**
R	0.20	8.00	2.85	**443136**	**443142**	**449523**	**449441**

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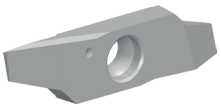
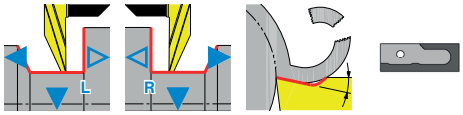
DH

Rückwärts Drehen
Back turning

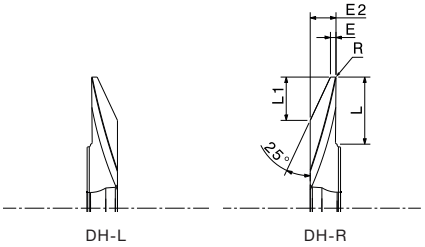
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	H2



Schruppen
Roughing



Schlichten
Finishing



DH-L DH-R

Dir.	E	E2	L	L1	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
DH6-L									
L	0.50	2.30	6.00	4.00	-	**437503**	**444808**	**449524**	**381668**
L	0.50	2.30	6.00	4.00	0.05	**437504**	**444809**	**449525**	**389959**
DH6-R									
R	0.50	2.30	6.00	4.00	-	**425771**	**437964**	**436118**	**381669**
R	0.50	2.30	6.00	4.00	0.05	**437505**	**437959**	**449538**	**389958**
R	0.50	2.30	6.00	4.00	0.10	**453919**	**453920**	**453921**	**391865**
DH8-L									
L	0.50	2.75	7.00	5.00	-	**374680**	**436055**	**449539**	**374681**
L	0.50	2.75	7.00	5.00	0.10	**408423**	**444810**	**449540**	**389961**
DH8-R									
R	0.50	2.75	7.00	5.00	-	**437506**	**436064**	**449541**	**374702**
R	0.50	2.75	7.00	5.00	0.10	**437507**	**444811**	**449542**	**389960**

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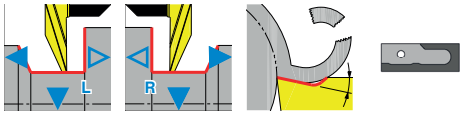
DH F

Rückwärts Drehen mit Wiper
Back turning with wiper



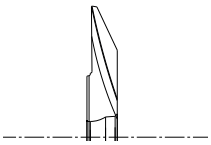
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	H2

Schruppen
Roughing

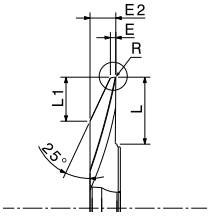


Schlichten
Finishing

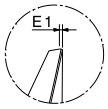




DH F-L



DH F-R



Dir.	E	E1	E2	L	L1	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
DH6F-L										
L	0.50	0.10	2.30	6.00	4.00	-	**437508**	**439318**	**427051**	**381670**
L	0.50	0.10	2.30	6.00	4.00	0.05	**437509**	**444812**	**449543**	**390276**
DH6F-R										
R	0.50	0.10	2.30	6.00	4.00	-	**435887**	**434795**	**427052**	**381671**
R	0.50	0.10	2.30	6.00	4.00	0.05	**437510**	**444813**	**449544**	**390277**
DH8F-L										
L	0.50	0.10	2.75	7.00	5.00	-	**437511**	**444814**	**427091**	**379666**
L	0.50	0.10	2.75	7.00	5.00	0.05	**408424**	**444815**	**449545**	**390278**
DH8F-R										
R	0.50	0.10	2.75	7.00	5.00	-	**396261**	**439151**	**427092**	**377851**
R	0.50	0.10	2.75	7.00	5.00	0.05	**437512**	**441670**	**449546**	**390279**

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DH F CP

Rückwärts Drehen mit Spanbrecher und Wiper
Back turning with chipbreaker and wiper

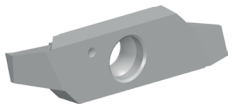


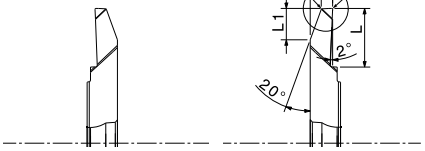
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	H2

Schruppen
Roughing

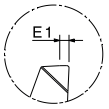


Schlichten
Finishing





DH F-L CP DH F-R CP



Dir.	E	E1	E2	L	L1	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
DH6F-L CP										
L	0.50	0.16	1.50	3.00	2.70	-	**442351**	**442356**	**449547**	**449552**
L	0.50	0.16	1.50	3.00	2.70	0.08	**442358**	**442361**	**449548**	**449553**
L	0.80	0.26	1.80	4.00	2.70	-	**442390**	**442392**	**449549**	**449554**
L	1.00	0.33	2.00	4.00	2.70	-	**442393**	**442394**	**449550**	**449555**
L	1.20	0.40	2.20	5.00	2.70	-	**442395**	**442396**	**449551**	**449556**
DH6F-R CP										
R	0.50	0.16	1.50	3.00	2.70	-	**436542**	**436560**	**431793**	**431794**
R	0.50	0.16	1.50	3.00	2.70	0.08	**436543**	**436561**	**431796**	**431797**
R	0.80	0.26	1.80	4.00	2.70	-	**436544**	**436562**	**431799**	**431800**
R	1.00	0.33	2.00	4.00	2.70	-	**436545**	**436563**	**431802**	**431803**
R	1.20	0.40	2.20	5.00	2.70	-	**436546**	**436564**	**431805**	**431806**
DH8F-L CP										
L	0.85	0.40	2.35	5.00	4.10	-	**442397**	**442399**	**449557**	**449568**
L	0.85	0.40	2.35	5.00	4.10	0.08	**442401**	**442403**	**449558**	**449569**
L	1.35	0.50	2.85	6.00	4.10	-	**442405**	**442407**	**449559**	**449570**
L	1.35	0.50	2.85	6.00	4.10	0.20	**442409**	**442411**	**449560**	**449571**
DH8F-R CP										
R	0.85	0.40	2.35	5.00	4.10	-	**442398**	**442400**	**449561**	**449572**
R	0.85	0.40	2.35	5.00	4.10	0.08	**442402**	**442404**	**449562**	**449573**
R	1.35	0.50	2.85	6.00	4.10	-	**442406**	**442408**	**449563**	**449574**
R	1.35	0.50	2.85	6.00	4.10	0.20	**442410**	**442412**	**449564**	**449575**

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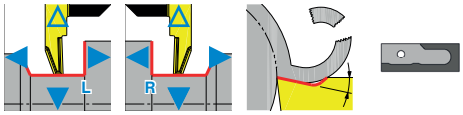
DH TU

Rückwärts Drehen mit Spanbrecher
Back turning with chipbreaker

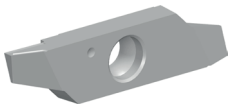


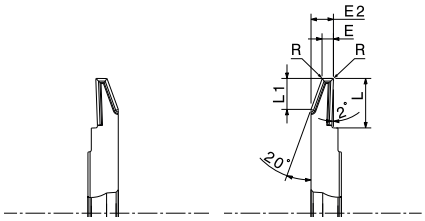
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	

Schruppen
Roughing



Schlichten
Finishing





DH-L TU DH-R TU

Dir.	E	E2	L	L1	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
DH6-L TU									
L	1.00	2.00	4.00	2.70	-	**442413**	**442414**	**449565**	**449576**
L	1.00	2.00	4.00	2.70	0.01	**449579**	**449580**	**449566**	**449577**
L	1.00	2.00	4.00	2.70	0.08	**442415**	**442416**	**449567**	**449578**
DH6-R TU									
R	1.00	2.00	4.00	2.70	-	**436613**	**436608**	**436605**	**436606**
R	1.00	2.00	4.00	2.70	0.01	**449581**	**449582**	**449583**	**449584**
R	1.00	2.00	4.00	2.70	0.08	**436614**	**436612**	**436609**	**436610**
DH8-L TU									
L	1.00	2.50	5.50	4.10	0.01	**442417**	**442425**	**449585**	**449691**
L	1.00	2.50	5.50	4.10	0.08	**449733**	**449734**	**449586**	**449692**
L	1.00	2.50	5.50	4.10	0.20	**442427**	**442429**	**449587**	**449693**
DH8-R TU									
R	1.00	2.50	5.50	4.10	0.01	**442424**	**442426**	**449588**	**449694**
R	1.00	2.50	5.50	4.10	0.08	**449735**	**449736**	**449589**	**449695**
R	1.00	2.50	5.50	4.10	0.20	**442428**	**442430**	**449590**	**449696**

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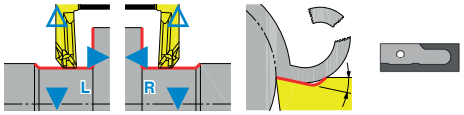
DH VR

Rückwärts Drehen mit Spanbrecher
Back turning with chipbreaker

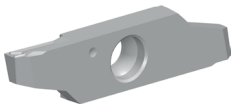


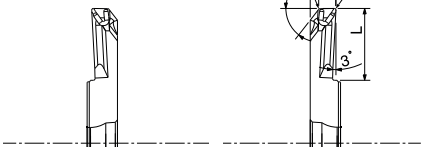
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	H2

Schruppen
Roughing



Schlichten
Finishing





DH-L VR

DH-R VR

Dir.	E	E2	L	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
DH6-L VR								
L	1.50	2.30	6.00	-	**442435**	**442437**	**449591**	**449697**
L	1.50	2.30	6.00	0.08	**442439**	**442441**	**449592**	**449698**
L	1.50	2.30	6.00	0.20	**442443**	**442508**	**449593**	**449699**
DH6-R VR								
R	1.50	2.30	6.00	-	**442436**	**442438**	**449594**	**449700**
R	1.50	2.30	6.00	0.08	**442440**	**442442**	**449595**	**449701**
R	1.50	2.30	6.00	0.20	**442507**	**442509**	**449596**	**449702**
DH8-L VR								
L	1.50	2.85	8.00	-	**442445**	**442447**	**449597**	**449703**
L	1.50	2.85	8.00	0.08	**442449**	**442451**	**449598**	**449704**
L	1.50	2.85	8.00	0.20	**442510**	**442512**	**449599**	**449705**
DH8-R VR								
R	1.50	2.85	8.00	-	**442446**	**442448**	**449600**	**449706**
R	1.50	2.85	8.00	0.08	**442450**	**442452**	**449601**	**449707**
R	1.50	2.85	8.00	0.20	**442511**	**442513**	**449602**	**449708**

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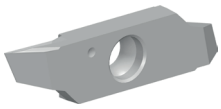
DH VN

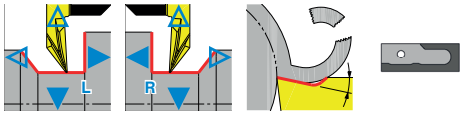
Rückwärts Drehen mit Spanbrecher
Back turning with chipbreaker



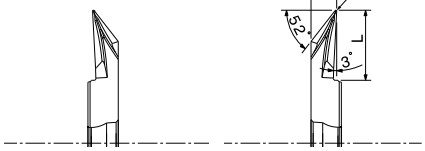
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	



Schruppen
Roughing



Schlichten
Finishing



DH-L VN DH-R VN

Dir.	R	L	E2	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
DH6-L VN							
L	0.05	6.00	2.30	**442731**	**442801**	**449603**	**449709**
L	0.08	6.00	2.30	**442803**	**442805**	**449604**	**449710**
L	0.20	6.00	2.30	**442807**	**442809**	**449605**	**449711**
DH6-R VN							
R	0.05	6.00	2.30	**442800**	**442802**	**449606**	**449712**
R	0.08	6.00	2.30	**442804**	**442806**	**449607**	**449713**
R	0.20	6.00	2.30	**442808**	**442810**	**449608**	**449714**
DH8-L VN							
L	0.05	8.00	2.85	**442811**	**442813**	**449609**	**449715**
L	0.08	8.00	2.85	**442815**	**442817**	**449610**	**449716**
L	0.20	8.00	2.85	**442819**	**442821**	**449611**	**449717**
DH8-R VN							
R	0.05	8.00	2.85	**442812**	**442814**	**449612**	**449718**
R	0.08	8.00	2.85	**442816**	**442818**	**449613**	**449719**
R	0.20	8.00	2.85	**442820**	**442822**	**449614**	**449720**

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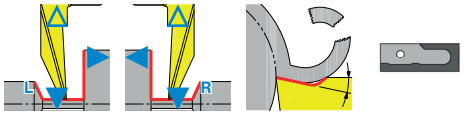
DH RP

Rückwärts Drehen mit Spanbrecher
Back turning with chipbreaker

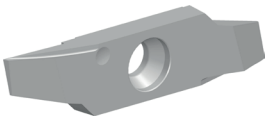


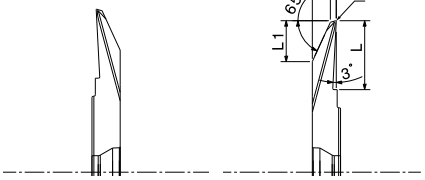
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	H2

Schruppen
Roughing



Schlichten
Finishing





DH-L RP

DH-R RP

Dir.	E	E2	L	L1	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
DH8-L RP									
L	0.70	2.85	8.00	4.80	0.03	**442514**	**442577**	**449615**	**449721**
L	0.70	2.85	8.00	4.80	0.08	**442579**	**442581**	**449616**	**449722**
L	0.70	2.85	8.00	4.80	0.20	**442583**	**442585**	**449617**	**449723**
DH8-R RP									
R	0.70	2.85	8.00	4.80	0.03	**442576**	**442578**	**449618**	**449724**
R	0.70	2.85	8.00	4.80	0.08	**442580**	**442582**	**449619**	**449725**
R	0.70	2.85	8.00	4.80	0.20	**442584**	**442586**	**449620**	**449726**

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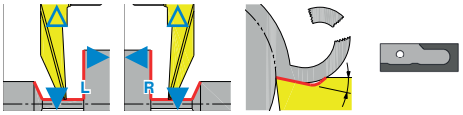
DH F RP

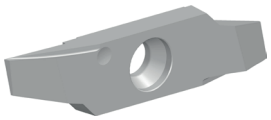
Rückwärts Drehen mit Spanbrecher und Wiper
Back turning with chipbreaker and wiper

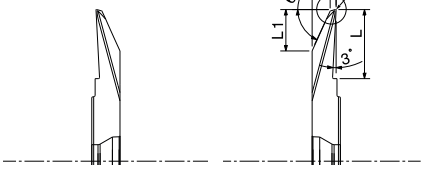
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	H2

Schruppen
Roughing

Schlichten
Finishing







DH F-L RP DH F-R RP



Dir.	E	E1	E2	L	L1	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
DH8F-L RP										
L	0.70	0.12	2.85	8.00	4.80	0.03	**442823**	**442842**	**449621**	**449727**
L	0.70	0.20	2.85	8.00	4.80	0.08	**442844**	**442846**	**449622**	**449728**
L	0.70	0.30	2.85	8.00	4.80	0.20	**442848**	**442850**	**449623**	**449729**
DH8F-R RP										
R	0.70	0.12	2.85	8.00	4.80	0.03	**442841**	**442843**	**449624**	**449730**
R	0.70	0.20	2.85	8.00	4.80	0.08	**442845**	**442847**	**449625**	**449731**
R	0.70	0.30	2.85	8.00	4.80	0.20	**442849**	**442851**	**449626**	**449732**

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R

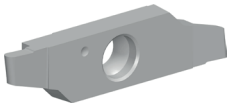
Radius Einstich
Radius groove

P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	H2

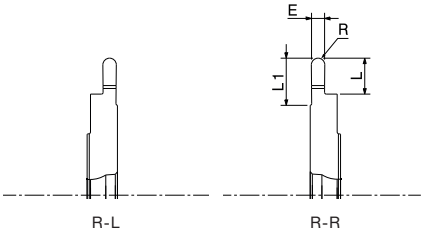
Schruppen
Roughing

Schlichten
Finishing









Dir.	R	E	L	L1	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
R6-L								
L	0.25	0.50	2.00	3.00	**437513**	**443143**	**449627**	**395910**
L	0.40	0.80	2.00	3.00	**441562**	**443145**	**449628**	**449737**
L	0.45	0.90	3.00	4.00	**442525**	**443147**	**449629**	**449738**
L	0.50	1.00	3.00	4.00	**437514**	**443981**	**449630**	**395911**
L	0.60	1.20	3.00	4.00	**437515**	**443149**	**449631**	**395912**
L	0.75	1.50	4.00	5.00	**437516**	**443150**	**449632**	**395913**
L	0.80	1.60	4.00	5.00	**437517**	**443151**	**449633**	**395914**
L	1.00	2.00	5.00	6.00	**437518**	**443152**	**449634**	**395915**
R6-R								
R	0.25	0.50	2.00	3.00	**437519**	**443144**	**449635**	**395900**
R	0.40	0.80	2.00	3.00	**441563**	**443146**	**449636**	**449739**
R	0.45	0.90	3.00	4.00	**442526**	**443153**	**449637**	**409222**
R	0.50	1.00	3.00	4.00	**437520**	**443148**	**449638**	**395901**
R	0.60	1.20	3.00	4.00	**437521**	**443154**	**449639**	**395902**
R	0.75	1.50	4.00	5.00	**437522**	**443155**	**449640**	**395903**
R	0.80	1.60	4.00	5.00	**437523**	**443156**	**449641**	**395904**
R	1.00	2.00	5.00	6.00	**437524**	**443157**	**449642**	**395905**
R8-L								
L	0.50	1.00	5.00	8.00	**449740**	**449748**	**449643**	**449756**
L	0.75	1.50	5.00	8.00	**449741**	**449749**	**449644**	**449757**
L	1.00	2.00	5.00	8.00	**449742**	**449750**	**449645**	**449758**
L	1.25	2.50	5.00	8.00	**449743**	**449751**	**449646**	**449759**
R8-R								
R	0.50	1.00	5.00	8.00	**449744**	**449752**	**449647**	**449760**
R	0.75	1.50	5.00	8.00	**449745**	**449753**	**449648**	**449761**
R	1.00	2.00	5.00	8.00	**449746**	**449754**	**449649**	**449762**
R	1.25	2.50	5.00	8.00	**449747**	**449755**	**449650**	**449763**

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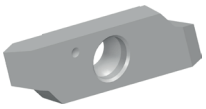
G

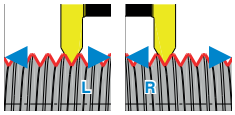
Gewindedrehen
Threading



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	H2

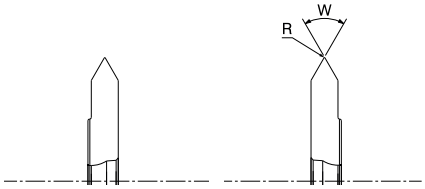


Schruppen
Roughing





Schlichten
Finishing



Dir.	W	R	Unbeschichtet *Uncoated* Art. N°	DWS Art. N°	D30 Art. N°	D60 Art. N°
G6-L						
L	55.0°	0.05	**437525**	**442910**	**449651**	**381672**
L	60.0°	0.05	**437526**	**441024**	**449652**	**381673**
G6-R						
R	55.0°	0.05	**437527**	**442911**	**449653**	**381674**
R	60.0°	0.05	**437528**	**442913**	**449654**	**381675**
G8-L						
L	55.0°	0.10	**437529**	**442914**	**449655**	**374688**
L	60.0°	0.10	**437530**	**442916**	**449656**	**374687**
G8-R						
R	55.0°	0.10	**437531**	**442915**	**449657**	**374706**
R	60.0°	0.10	**437532**	**442917**	**449658**	**374705**

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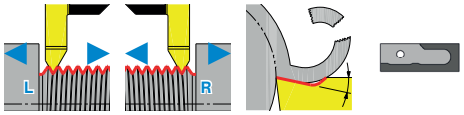
GP 60°

Gewindedrehen mit versetztem Teilprofil
Threading with shifted partial profile

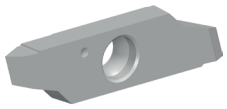


P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	H2

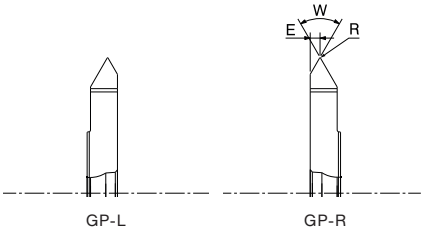
Schruppen
Roughing



Schlichten
Finishing







Dir.	W	Steigung *Pitch* P	R	E	**Unbeschichtet *Uncoated* Art. N°**	**DWS Art. N°**	**D30 Art. N°**	**D60 Art. N°**
GP6-L 60°								
L	60.0°	0.080	-	0.050	**441564**	**441581**	**449659**	**449764**
L	60.0°	0.125	-	0.075	**441566**	**441583**	**449660**	**449765**
L	60.0°	0.175	0.02	0.125	**441568**	**441585**	**449661**	**449766**
L	60.0°	0.300	0.02	0.225	**441571**	**441587**	**449662**	**449767**
L	60.0°	0.500	0.06	0.400	**441573**	**441589**	**449663**	**449768**
L	60.0°	1.000	0.10	0.875	**441575**	**441591**	**449664**	**449769**
GP6-R 60°								
R	60.0°	0.080	-	0.050	**441565**	**441582**	**449665**	**449770**
R	60.0°	0.125	-	0.075	**441567**	**441584**	**449666**	**449771**
R	60.0°	0.175	0.02	0.125	**441570**	**441586**	**449667**	**449772**
R	60.0°	0.300	0.02	0.225	**441572**	**441588**	**449668**	**449773**
R	60.0°	0.500	0.06	0.400	**441574**	**441590**	**449669**	**449774**
R	60.0°	1.000	0.10	0.875	**441576**	**441592**	**449670**	**449775**
GP8-L 60°								
L	60.0°	1.000	0.10	0.875	**441577**	**441593**	**449683**	**449788**
L	60.0°	2.000	0.20	1.500	**441579**	**441595**	**449684**	**449789**
GP8-R 60°								
R	60.0°	1.000	0.10	0.875	**441578**	**441594**	**449685**	**449790**
R	60.0°	2.000	0.20	1.500	**441580**	**441596**	**449686**	**449791**

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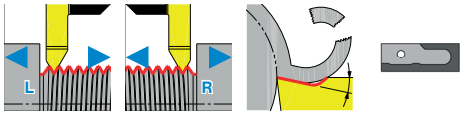
GP 55°

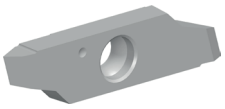
Gewindedrehen mit versetztem Teilprofil
Threading with shifted partial profile

P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	H2

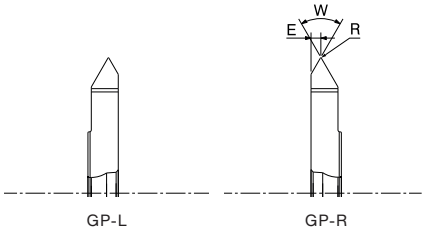
Schruppen
Roughing

Schlichten
Finishing









Dir.	W	Steigung *Pitch* P	R	E	**Unbeschichtet *Uncoated* Art. N°**	**DWS Art. N°**	**D30 Art. N°**	**D60 Art. N°**
GP6-L 55°								
L	55.0°	0.080	-	0.050	**449796**	**449808**	**449671**	**449776**
L	55.0°	0.125	-	0.075	**449797**	**449809**	**449672**	**449777**
L	55.0°	0.175	0.02	0.125	**449798**	**449810**	**449673**	**449778**
L	55.0°	0.300	0.02	0.225	**449799**	**449811**	**449674**	**449779**
L	55.0°	0.500	0.06	0.400	**449800**	**449812**	**449675**	**449780**
L	55.0°	1.000	0.10	0.875	**449801**	**449813**	**449676**	**449781**
GP6-R 55°								
R	55.0°	0.080	-	0.050	**449802**	**449814**	**449677**	**449782**
R	55.0°	0.125	-	0.075	**449803**	**449815**	**449678**	**449783**
R	55.0°	0.175	0.02	0.125	**449804**	**449816**	**449679**	**449784**
R	55.0°	0.300	0.02	0.225	**449805**	**449817**	**449680**	**449785**
R	55.0°	0.500	0.06	0.400	**449806**	**449818**	**449681**	**449786**
R	55.0°	1.000	0.10	0.875	**449807**	**449819**	**449682**	**449787**
GP8-L 55°								
L	55.0°	1.000	0.10	0.875	**449820**	**449825**	**449687**	**449792**
L	55.0°	2.000	0.20	1.500	**449821**	**449826**	**449688**	**449793**
GP8-R 55°								
R	55.0°	1.000	0.10	0.875	**449822**	**449827**	**449689**	**449794**
R	55.0°	2.000	0.20	1.500	**449823**	**449828**	**449690**	**449795**

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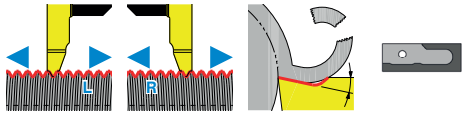
GF 60°

Gewindeschneiden mit vollem Profil
Threading with full profile

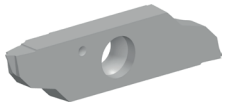


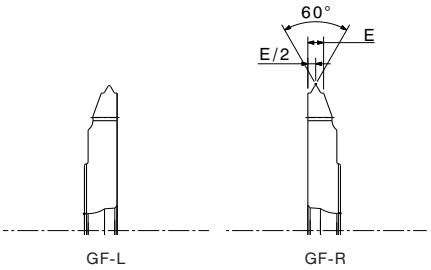
P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	H2

Schruppen
Roughing



Schlichten
Finishing







Dir.	W	Steigung *Pitch* P	**Unbeschichtet *Uncoated* Art. N°**	**DWS Art. N°**	**D60 Art. N°**
GF6-L 60°					
L	60.0°	0.25	**459108**	**459121**	**459134**
L	60.0°	0.30	**459109**	**459122**	**459135**
L	60.0°	0.35	**459110**	**459123**	**459136**
L	60.0°	0.40	**459111**	**459124**	**459137**
L	60.0°	0.45	**459112**	**459125**	**459138**
L	60.0°	0.50	**459113**	**459126**	**459139**
GF6-R 60°					
R	60.0°	0.25	**459069**	**459082**	**459095**
R	60.0°	0.30	**459070**	**459083**	**459096**
R	60.0°	0.35	**459071**	**459084**	**459097**
R	60.0°	0.40	**459072**	**459085**	**459098**
R	60.0°	0.45	**459073**	**459086**	**459099**
R	60.0°	0.50	**459074**	**459087**	**459100**
GF8-L 60°					
L	60.0°	0.60	**459159**	**459168**	**459177**
L	60.0°	0.70	**459160**	**459169**	**459178**
GF8-R 60°					
R	60.0°	0.60	**459147**	**459151**	**459155**
R	60.0°	0.70	**459148**	**459152**	**459156**

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TURNDEC

Ersatzteile und Zubehör
Spare parts and accessories

Bezeichnung *Designation*				

Schraube und Schraubenzieher für Wendeschneidplatten
Screw and screwdriver for inserts

L6 & R6	TP7 M2.5 x 6.5	**381683**	**TP7**	**436799**
L8 & R8	TP15 M3.5 x 9.0	**374757**	**TP15**	**436801**
R10	TP15 M4.0 x 10.0	**431980**	**TP15**	**436801**

Bezeichnung *Designation*			

Ersatzteile für Werkzeughalter mit Innenkühlung
Parts for toolholders with integrated coolant

L* & R*-C 10x10x120-C	**455311 / 456568**	T6	**305184**	**450451**
L* & R*-C 12x12x120-C	**455331 / 456569**	T6	**305184**	**450451**
L* & R*-C 16x16x120-C	**455331 / 455037**	T6	**305184**	**450451**

Bezeichnung *Designation*			

Ersatzteile für Schnellwechselköpfe mit Innenkühlung
Parts for toolholders with quick-change heads function and integrated coolant

L* & R* 10x10x*-Q	**455311 / 456568**	T6	**305184**	**450442**
L* & R* 12x12x*-Q	**455331 / 456569**	T6	**305184**	**450443**
L* & R* 16x16x*-Q	**455331 / 455037**	T6	**305184**	**450444**

Bezeichnung *Designation*				

Ersatzteile für Grundhalter der Schnellwechselköpfe
Parts for quick-change toolholder heads

Q10	**450453**	**450456**	**450459**	**450451**
Q12	**450454**	**450457**	**450459**	**450451**
Q16	**450455**	**450458**	**450460**	**450451**

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