

WhizCut®

Smart Solutions on the Cutting Edge



The World of WhizCut

Smart Solutions on the Cutting Edge

Demand on production for small parts around the world is continuously increasing. Higher expectations are put on the producers of these parts, and this is where WhizCut comes in.

At WhizCut we understand the day to day challenges the users of automatic lathes are up against. To assist these users WhizCut has developed a wide range of useful products for all automatic lathes around the globe.

We try, to put it simple, to find new solutions for existing problems within the world of small part machining. Our company is based on these new products that will make your production faster, more precise and more effective. No matter if your work is in external cutting or internal cutting, we have the solutions to boost your production.

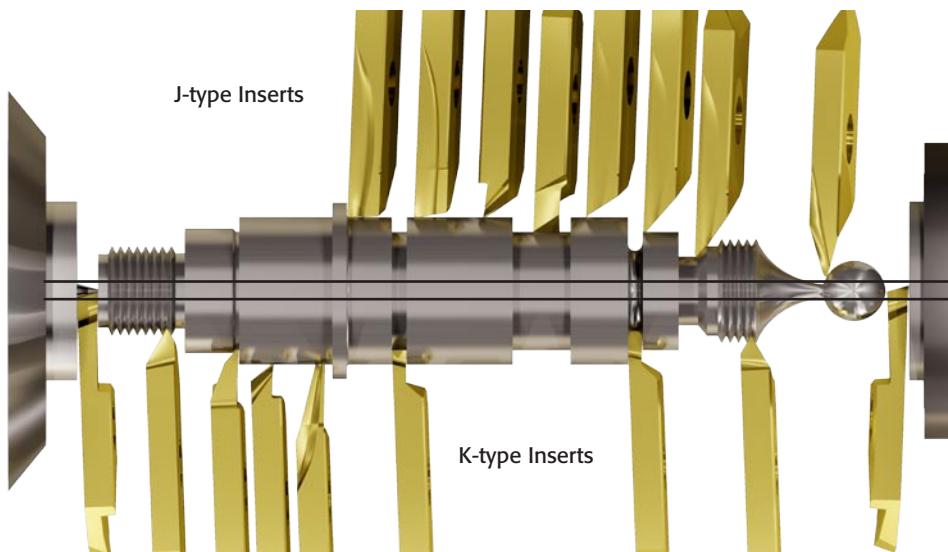
WhizCut is determined to continue being one of the leading manufacturers for small part machining in the world.

Table of Contents

WhizCut external inserts and toolholders are specially designed for small parts machining. The range includes the WhizFix toolholder system for easy change of inserts in Swiss type automatic lathes.



J-type Tooling for Front Turning



K-type Tooling for Radial Turning

Page 7
Introduction WhizCut External Tooling

Page 8
Technical Information Toolholders

Page 9
Technical Information Inserts

Page 10
Technical Information J-type Inserts

Page 11
J-type Toolholders

Page 12-13
J-type Inserts, Front Turning

Page 14
Technical Information K-type Inserts

Page 15
K-type Toolholders

Page 16-19
K-type Inserts, Radial Turning

Page 21
Introduction WhizIn

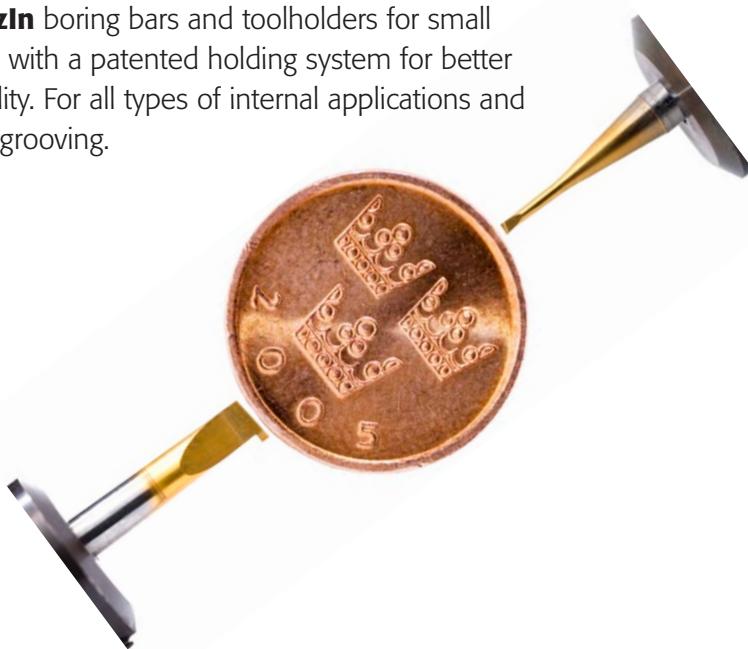
Page 22
Technical Information
WhizIn

Page 23
Toolholders

Page 24
Boring bars
Internal Turning

Page 25
Boring bars
Internal Grooving, and
Face Grooving

WhizIn boring bars and toolholders for small parts with a patented holding system for better stability. For all types of internal applications and face grooving.



Page 27
Introduction WhizThrill

Page 28
Technical Information
WhizThrill

Page 29
Metrical

Page 30
Metrical with coolant
and external

Page 31
Micro and Metric with
Chamfer

Page 32-33
Unified, Pipe Threads
NPT/NPTF

WhizThrill is a wide range of solid carbide thread mills with a patent pending deburring function.



Page 35
WhizForm,
Special Tools

WhizForm are highest quality special form tools for any kind of application.





WhizCut

External Toolholders and Inserts

WhizCut offers the market's widest range of tooling for external turning in Swiss type automatic lathes.

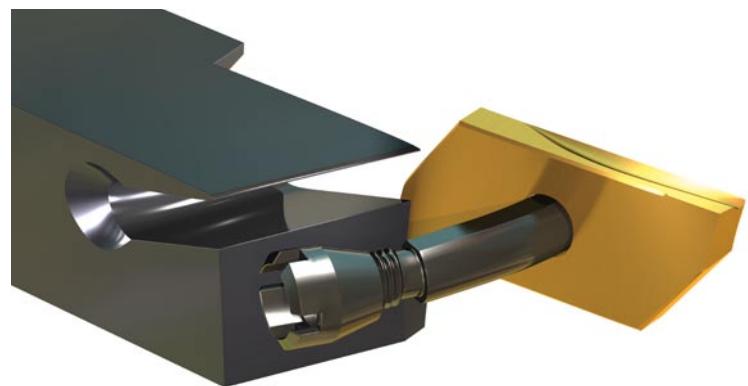
The inserts with fully ground cutting edges have been designed with special geometries resulting in the ultimate tooling performance. WhizCut has designed several types of inserts that are not available from any other manufacturer of carbide inserts. The WhizCut back turning inserts are one example of inserts where WhizCut has used unique geometries to enhance the users productivity and overall economy many times.

Only two types of toolholders are needed to make use of the entire range of inserts. For maximum usage of insert tooling WhizCut has developed the WhizFix toolholder system. WhizFix makes it possible to change an insert in a Swiss type automatic lathe without taking out the toolholder.

WhizFix Clamping

WhizCut has the best solution to all indexing problems in Swiss type automatics.

1. Indexing or changing an insert can be done in 15 seconds without removing the tool holder from the machine.
2. Indexing or changing an insert will not change the setting resulting in a much faster return to full production.
3. There is no risk of damaging the new cutting edge.



Many types of Toolholders

Today WhizCut offers a variety of toolholders. The two most popular being the patented pin type and the traditional screw type toolholders.

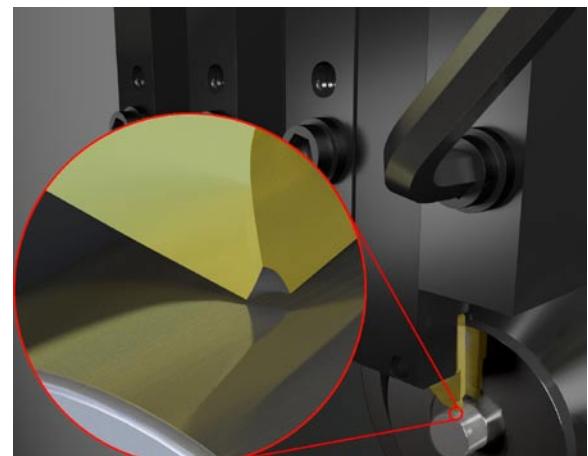
We also offer a range of different toolholders for axial mounting, specially designed for flat bed lathes. In this range there is also a toolholder with two insert pockets, which makes it possible to utilize two inserts. This doubles the amount of applications that can be used in one single setup, in machines that normally have limited tooling spaces.



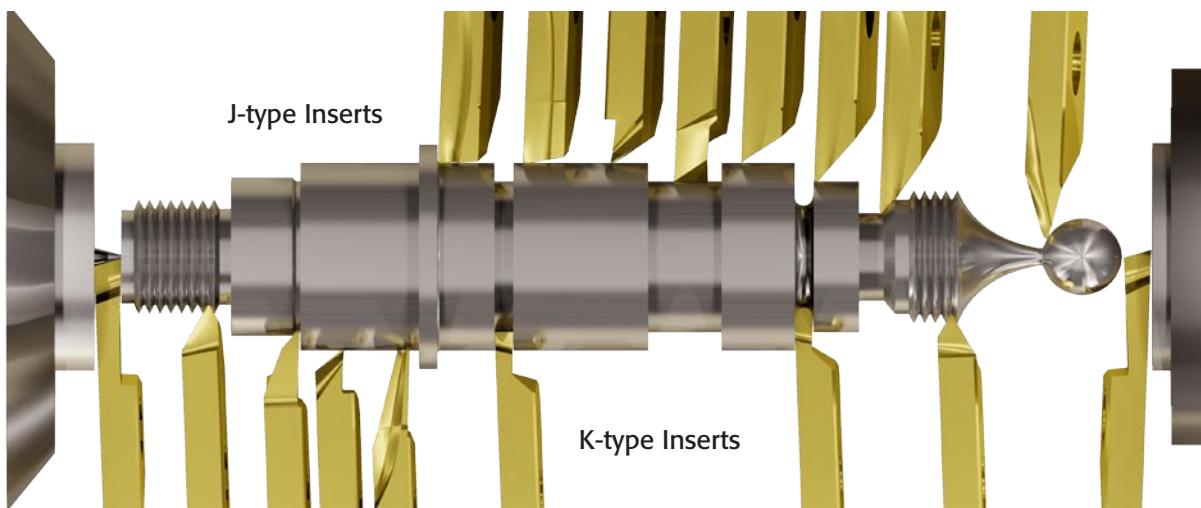
To Take into Consideration when Choosing Toolholder

When changing or indexing an insert in a conventional Swiss type automatic lathe the toolholder is taken out when the insert is indexed. When then the toolholder is clamped back in the machine the toolholders X-variable is normally set by taking the insert down to the work piece until they very slightly touch. This will sometimes chip the insert, making the performance go down drastically.

For this reason we recommend our WhizFix pin type toolholder for Swiss type automatic lathes. It is easy to see the profit in using a WhizFix toolholder even if it is slightly more expensive when purchased. Only one small chip of a cutting edge of a single insert is costlier than the extra expense of the WhizFix toolholder, considering the shorter tool life and disruption of production.



Chipping when contact between insert and the workingpiece when calibrating with a conventional toolholder



For All Types of Applications

WhizCut offers the markets widest range of external carbide inserts for Swiss type automatics. Our goal is that our customers can solve all applications in the lathes with our tools.

We divide up our inserts into 2 different application

styles; radial turning and front turning. This way we have been able to develop the two best toolholder systems for the two styles. All in all the user of WhizCut inserts only need two types of toolholders to be able to perform almost any operation.

Geometry

All WhizCut standard Inserts have sharp, fully ground cutting edges. The standard inserts are available in a 2, 6, 8, 12, 16 or 20° positive cutting edge to ensure the best performance for every operation. The combination of a high positive cutting rake and a ground cutting edge makes the WhizCut inserts useful for most types of material and applications. All inserts are developed for maximum stability and performance together with a very high level of chip control.

The carbide allows the insert to have a very sharp, but still strong edge. This also makes the inserts suitable for materials which are difficult to machine, such as Titanium and Super Alloys.

The combination of the best grades of carbide, the most suitable geometries and sharp cutting edges will ensure you getting the best tooling possible for your Swiss type automatic lathe.



Grades of Carbide

WhizCut Inserts are available in both PVD-coated and uncoated fine grain carbide with hardness over 1750 Hv. WhizCut has recently replaced the carbide grades of the inserts. The new carbide in the 8M, C8 and F8 grades is harder but still has the same strength as the old ones. It is therefore considerably more wear-resistant and has given an average of 30% better tool life.

Stock Standard Grades

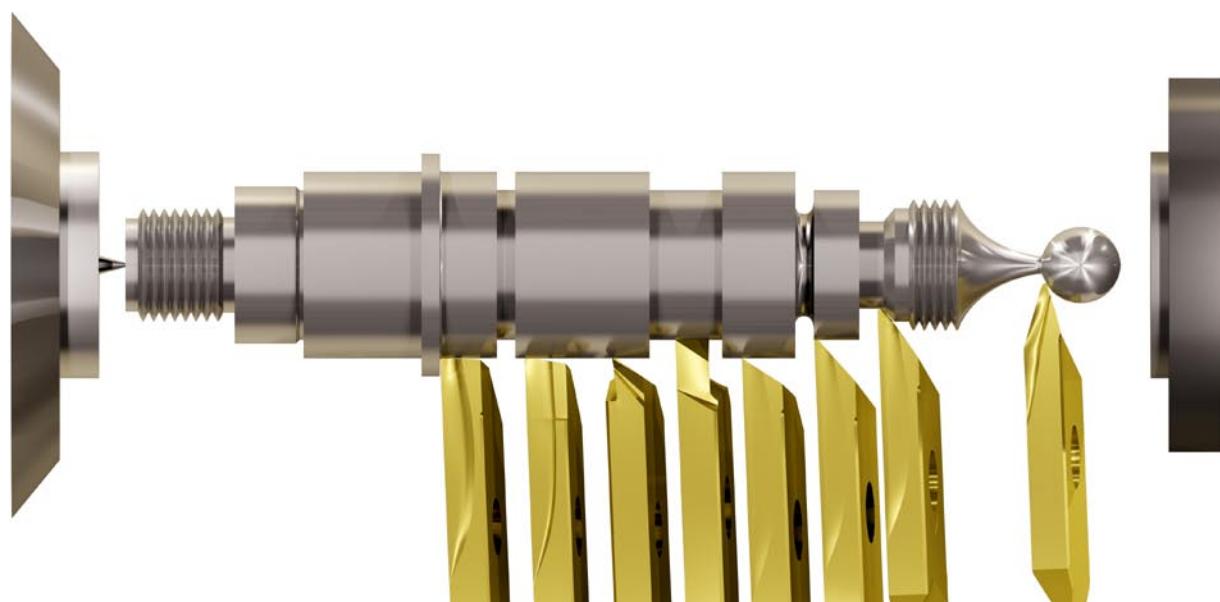
- 8M** is an uncoated grade covering ISO groups K10-K20 and M10-M20.
- C8** is a TiN coated grade covering ISO groups K05-K20, M05-M20 and P05-P10.
- F8** is a TiAlN, multicoated grade suitable when extreme heat is developed during machining.
- B8** Is a AlCrN coating for materials such as titanium etc. where extreme heat is developed during machining.

Special Geometries

As we have the widest range of inserts for Swiss type automatic lathes we can do almost all applications. However, no one can have all possible geometries in stock. We are a very flexible company and our production is set up for us to make special inserts easily. Contact your local distributor for a quote.

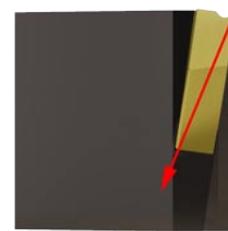
J-type Inserts & Toolholders for Front Turning

(straight turning, copy turning, groove turning, profile turning)



The **J-type inserts** are available in many variations in order to be able to choose the best alternatives in regards to cutting rakes, shapes, corner executions, chip control and grades of carbide.

The J-type insert are tilted in the toolholder to give best clearance and maximum stability in the tooling. See resulting cutting force.

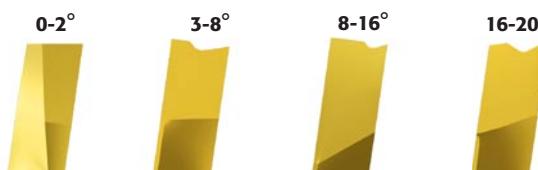


— = Resulting cutting force

To Take into Consideration when Choosing Insert

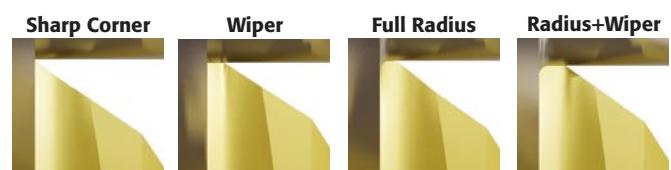
1. Axial Relief vs Component Possibilities

- 3° gives the strongest tool and smoother finish
- 10° gives a strong tool and good finish
- 33° medium strong tool, wiper needed for smooth finish
- 48-53° less strong tool, wiper needed for smooth finish



2. Chip Control

- Style H = Long chips and/or high feed rate
- Style J = Long chips and/or highest feed rate
- Style D, N & V = Short chips and/or low to moderate feedrate
- Style M = short chips and/or low to moderate feedrate
- Style F = thin chips and/or moderate feedrate



3. Cutting Rake vs Material

- 0-2° for short-chipping materials
- 3-8° for harder long-chipping materials
- 8-16° for long-chipping materials
- 16-20° for sticky long-chipping materials

4. Corner Alternatives

- Sharp corner = Minimum cutting force, good when component is weak.
- Wiper = For higher feed-rates resulting in better surface finish
- Radius = Stronger tool also used upon request of component.
- Wiper and radius = For higher feed-rate with better surface.

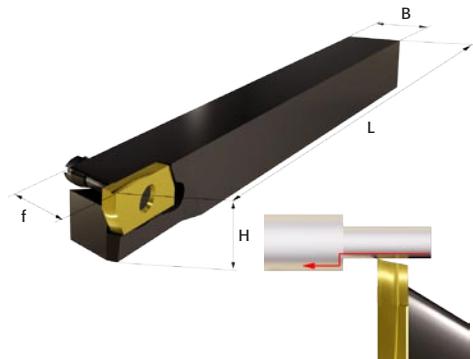
WPJ | Toolholder with WhizFix Clamping

Toolholder	B	H	L	f	Insert	Pin + Nut	Screw driver	Bit	Stock	Price group
WPJ11ER/L 88K-8T	8	8	125	8	J11ER/L	Pin 8	WSD2*	K3	a	A62
WPJ11ER/L 1010K-8T	10	10	125	10	J11ER/L	Pin 8	WSD2*	K3	a	A62
WPJ15ER/L 1010K-8T	10	10	125	10	J15ER/L	Pin 12	WSD2*	K3	a	A62
WPJ15ER 1212F-8T	12	12	85	12	J15ER	Pin 12	WSD2*	K3	r	A61
WPJ15ER/L 1212K-8T	12	12	125	12	J15ER/L	Pin 12	WSD2*	K3	a	A62
WPJ15ER/L 1205K-8T	12	1/2"	125	12	J15ER/L	Pin 12	WSD2*	K3	r	A62
WPJ15ER/L 1616K-8T	16	16	125	16	J15ER/L	Pin 12	WSD2*	K3	a	A63
WPJ20ER 1212K-8T	12	12	125	12	J20ER	Pin 16	WSD2*	K3	r	A62
WPJ20ER 1205K-8T	12	1/2"	125	12	J20ER	Pin 16	WSD2*	K3	r	A62
WPJ20ER 1616K-8T	16	16	125	16	J20ER	Pin 16	WSD2*	K3	r	A63
WPJ20ER 2020K-8T	20	20	125	20	J20ER	Pin 16	WSD2*	K3	r	A64

Right hand toolholder shown.

* Ordered separately

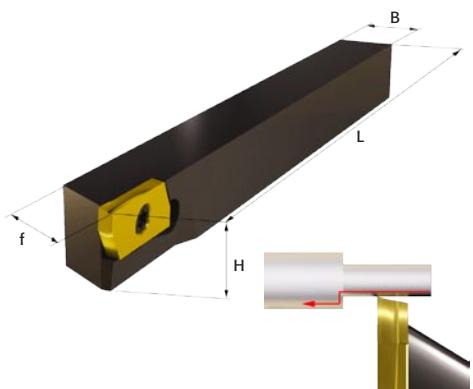
e.g. Toolholder WPJ15ER 1010K-8T can be used with J15ER J8-2 C8



WSJ | Toolholder with Centerlock Screw

Toolholder	B	H	L	f	Insert	Screw	Key	Stock	Price group
WSJ11ER/L 88K-8T	8	8	125	8	J11ER/L	M2,5x6	J2	a	A52
WSJ15ER/L 1010K-8T	10	10	125	10	J15ER/L	M3x7	J3	a	A52
WSJ15ER/L 1212K-8T	12	12	125	12	J15ER/L	M3x7	J3	a	A52
WSJ15ER/L 1205K-8T	12	1/2"	125	12	J15ER/L	M3x7	J3	r	A52
WSJ15ER/L 1616K-8T	16	16	125	16	J15ER/L	M3x7	J3	a	A53
WSJ20ER 1212K-8T	12	12	125	12	J20ER	M4x9	J4	r	A52
WSJ20ER 1205K-8T	12	1/2"	125	12	J20ER	M4x9	J4	r	A52
WSJ20ER 1616K-8T	16	16	125	16	J20ER	M4x9	J4	r	A53
WSJ20ER 2020K-8T	20	20	125	20	J20ER	M4x9	J4	r	A54
WSJ20ER 2525K-8T	25	25	150	25	J20ER	M4x9	J4	r	A55
WSJ20ER 1000K-8T	1"	1"	150	1"	J20ER	M4x9	J4	r	A55

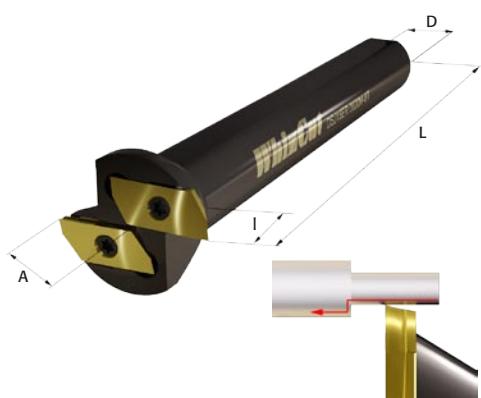
Right hand toolholder shown.



Toolholders for Flat Bed Lathes

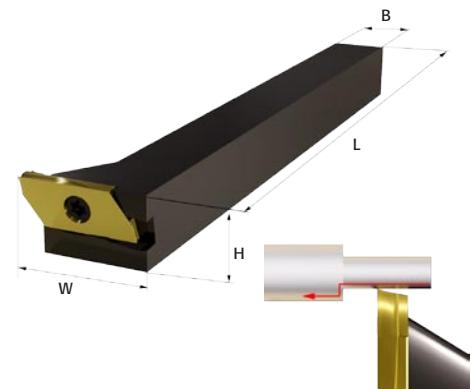
DSJ | Round Shanks - Double Inserts

Toolholder	D	A	L	I	Insert	Screw	Key	Stock	Price group
DSJ15ER 0016M-8T	16	14	150	8	J15ER	M3x7	J3	r	A76
DSJ15ER 0020M-8T	20	14	150	5	J15ER	M3x7	J3	r	A77

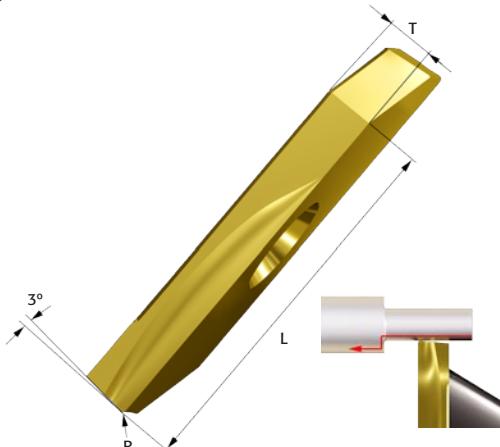


ZSJ | Square Shanks

Toolholder	B	H	L	W	Insert	Screw	Key	Stock	Price group
ZSJ15ER 1212K-8T	12	12	125	20	J15ER	M3x7	J3	r	A72
ZSJ15ER 1616K-8T	16	16	125	24	J15ER	M3x7	J3	r	A73



J-type Inserts

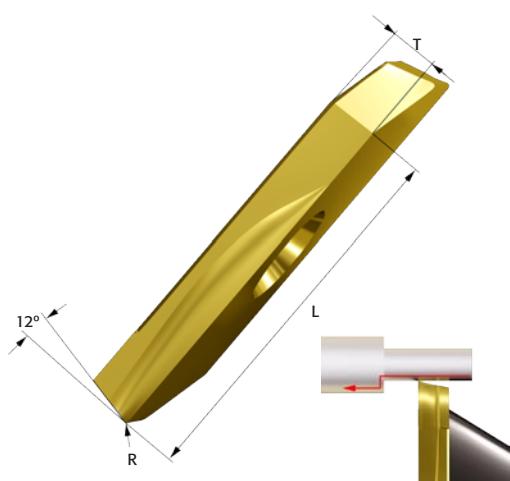


Style H | Inserts for Turning

Inserts	L	B	R	Cutting rake °	Stock	Price
	8M	C8	F8	B8	group	
J15ER H6-0	15	2,1	0	6	b	b
J15ER H6-2	15	2,1	0,2	6	b	b
J15ER H16-0	15	2,1	0	16	b	b
J15ER H16-1	15	2,1	0,1	16	b	k
						A3
						A4

Stock status:

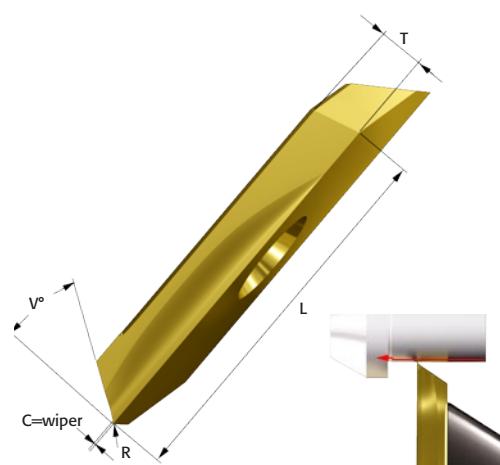
- a ER Stock standard, EL Stock standard L T
- b ER Stock standard, EL against inquiry 11 2,5
- c EL Stock standard, ER against inquiry 15 2,1
- r ER Stock standard only 20 3,5
- l EL Stock standard only
- k ER against inquiry, EL against inquiry



Style J | Inserts for Turning

Inserts	L	B	R	Cutting rake °	Stock	Price
	8M	C8	F8	B8	group	
J11ER/L J8-0	11	2,5	0	8	a	b
J11ER/L J8-2	11	2,5	0,2	8	a	b
J11ER/L J20-0	11	2,5	0	20	a	b
J11ER/L J20-2	11	2,5	0,2	20	a	b
J15ER/L J8-0	15	2,1	0	8	a	b
J15ER/L J8-1	15	2,1	0,1	8	a	b
J15ER/L J8-2	15	2,1	0,2	8	a	b
J15ER/L J20-0	15	2,1	0	20	a	b
J15ER/L J20-1	15	2,1	0,1	20	a	b
J15ER/L J20-2	15	2,1	0,2	20	a	b
J20ER J8-2	20	3,5	0,2	8	r	r
J20ER J8-4	20	3,5	0,4	8	r	r
J20ER J20-2	20	3,5	0,2	20	r	r
J20ER J20-4	20	3,5	0,4	20	r	r
						A21
						A21
						A23
						A23

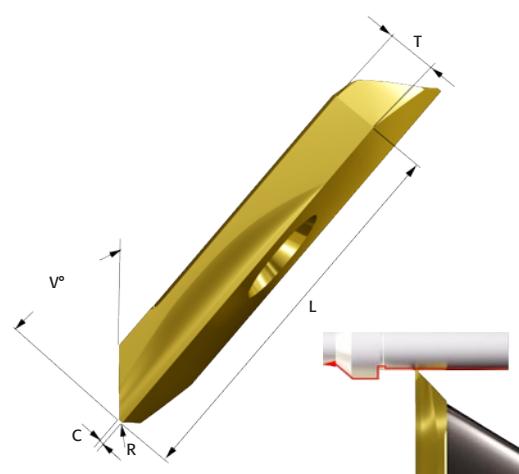
Right hand insert shown.



Style D | Inserts for Finish Turning

Inserts	L	V°	R	C	Cutting rake °	Stock	Price
	8M	C8	F8	B8	group		
J11ER/L D2-0	11	33	0,02	0	2	a	b
J11ER/L D2-0-1	11	33	0	0,12	2	a	b
J11ER/L D12-0	11	33	0,02	0	12	a	b
J11ER/L D12-0-1	11	33	0	0,12	12	a	b
J15ER/L D2-0	15	33	0,02	0	2	a	b
J15ER/L D2-0-2	15	33	0	0,2	2	a	b
J15ER/L D12-0	15	33	0,02	0	12	a	b
J15ER/L D12-0-2	15	33	0	0,2	12	a	b
J15ER/L D12-1-3	15	33	0,15	0,3	12	a	b
J20ER D2-2-5	20	33	0,2	0,5	2	r	r
J20ER D12-2-5	20	33	0,2	0,5	12	r	r
							A23
							A24

Right hand insert shown.



Style N | Inserts for Finish Turning

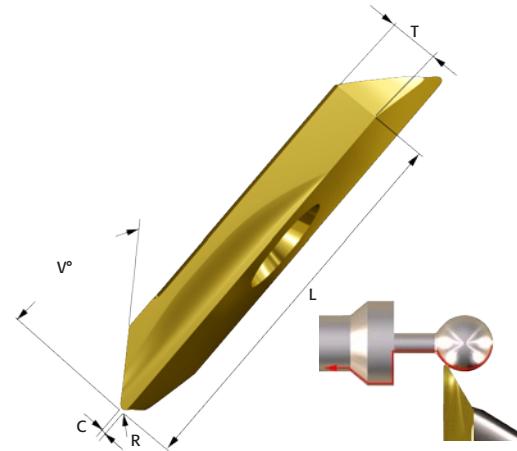
Inserts	L	V°	R	C	Cutting rake °	Stock	Price
	8M	C8	F8	B8	group		
J15ER/L N2-0-2	15	48	0	0,2	2	a	b
J15ER/L N2-1-3	15	48	0,1	0,3	2	a	b
J15ER/L N12-0-2	15	48	0	0,2	12	a	b
J15ER/L N12-1-3	15	48	0,1	0,3	12	a	b
J20ER N2-2-5	20	48	0,2	0,5	2	r	r
J20ER N12-2-5	20	48	0,2	0,5	12	r	r
							A24
							A25

Right hand insert shown.

Style V | Inserts for Finish and Copy Turning

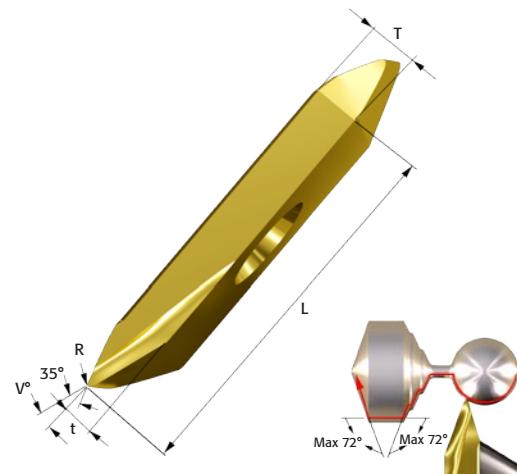
Inserts	L	V°	R	C	Cutting		Stock		Price	
					rake °	8M	C8	F8	B8	group
J11ER/L V2-1	11	53	0,1	0	2	a	a	b	k	A6
J11ER/L V12-2	11	53	0,2	0	12	a	a	b	k	A7
J15ER/L V2-1	15	53	0,1	0	2	a	a	b	k	A6
J15ER/L V2-0-2	15	53	0	0,2	2	b	b	b	k	A6
J15ER/L V12-2	15	53	0,2	0	12	a	a	b	k	A7

Right hand insert shown.



Style M | Inserts for Profile and Copy Turning

Inserts	L	t	V°	R	Cutting		Stock		Price	
					rake °	8M	C8	F8	B8	group
J15ER M12-08	15	1,3	17,5	0,08	12	r	r	r	k	A7
J15ER M12-2	15	1,3	17,5	0,2	12	r	r	r	k	A7



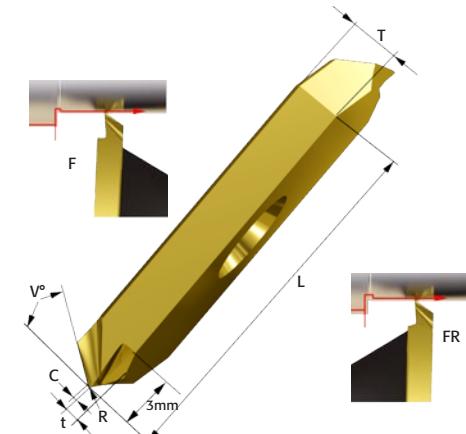
Style F | Inserts for an Extra Finishing Cut; Turning

Inserts	L	C	t	R	V	Cutting		Stock		Price	
						rake °	8M	C8	F8	B8	group
J15ER F16-0-05	15	0,15	0,6	0,05	30	16	r	r	r	k	A7

Style FR | Inserts for an Extra Finishing Cut; Turning Out from Guide Bushing

Inserts	L	C	t	R	V	Cutting		Stock		Price	
						rake °	8M	C8	F8	B8	group
J15EL FR16-0-05	15	0,15	0,1	0,05	30	16	-	-	-	k	A7

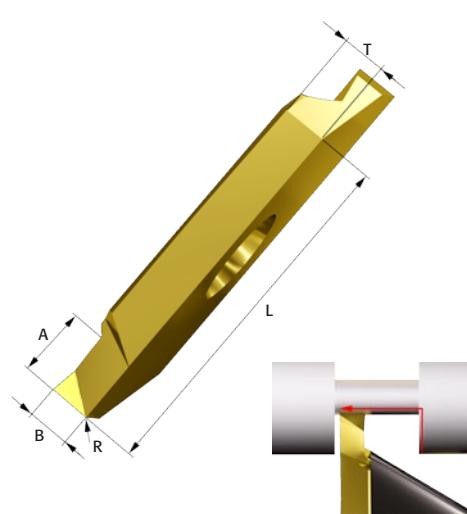
Please note: Left hand insert for right hand turning shown. Right hand not available.



Style A | Inserts for Groove Turning

Inserts	L	B	A	R	Cutting		Stock		Price	
					rake °	8M	C8	F8	B8	group
J11ER/L A0-0	11	1,3	2,0	0	0	a	a	b	k	A5
J11ER/L A12-0	11	1,3	2,0	0	12	a	a	b	k	A6
J15ER/L A0-08-0	15	0,5	0,8	0	0	b	b	b	k	A5
J15ER/L A0-12-0	15	0,75	1,2	0	0	b	b	b	k	A5
J15ER/L A0-16-0	15	1,0	1,6	0	0	b	b	b	k	A5
J15ER/L A0-0	15	1,5	2,3	0	0	a	a	b	k	A5
J15ER/L A12-16-0	15	1,0	1,6	0	12	b	b	b	k	A6
J15ER/L A12-0	15	1,5	2,3	0	12	a	a	b	k	A6
J20ER A0-3-0	20	2,0	3,0	0	0	r	r	r	k	A22
J20ER A0-5-0	20	3,0	5,0	0	0	r	r	r	k	A22
J20ER A12-3-0	20	2,0	3,0	0	12	r	r	r	k	A24
J20ER A12-5-0	20	3,0	5,0	0	12	r	r	r	k	A24

Right hand insert shown.



All angles are shown when mounted in toolholder

K-type Inserts & Toolholders for Radial Turning

(back turning, grooving, threading and parting off)



Back turning

WhizCut's leading product group with a very wide range of special designs for all back turning applications (see below)

Grooving

Grooving inserts from 0,1 mm up to 3,0 mm with positive cutting rake.

Threading

Threading inserts for both partial and full profile threading.

Parting off

Parting off inserts range from 0,7-3mm in width with a maximum diameter of cut of 20mm. Different geometries are available with different cutting rakes and front angles.

Advantages with the WhizCut Back Turning Inserts

- Gives better roundness on the component
- Controls chips by moving the chips away from the workpiece

- A narrow parting off insert can be used when clearing up unwanted end material
- Available in a wide range of geometries

Choosing the Correct Back Turning Insert

Style B

Style B is for general use in back turning applications in stainless steel and other hard and long-chipping materials where good chip control is needed.

Style BC

Style BC is used when a higher feed rate is wanted with cutting depths up to 1,5 mm. Typical applications are shafts with long parts turned down to smaller diameters.

Style BP

Style BP is used for sticky materials when there is a chance of an edge build up that can spoil the surface finish or reduce tool-life.

Style BT

Style BT inserts have a corner treatment on the leading corner that improves the tool-life in harder materials. Try it when the wear on the style B insert comes fast on this corner.

Style C

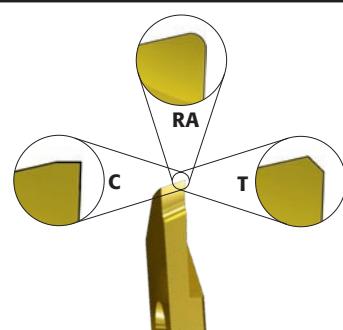
Style C is used when there is an undercut required.

Style E

Style E is used for fine turning, using high rev and low feedrate. This insert will give the best possible surface finish.

Special Corner Alternatives for Parting Off Inserts

Parting off applications sometimes demand a different kind of corner execution on the parting off insert. WhizCut can arrange any type of corner execution to suit your need. Contact your local distributor to assist you finding the type that suits your needs.



WPK | Toolholder with WhizFix Clamping

Toolholder	B	H	L	f	Insert	Pin + Nut	Screw driver	Bit	Stock	Price group
WPK11ER/L 88K-2P	8	8	125	8	K11ER/L	Pin 8	WSD2*	K3	a	A62
WPK11ER/L 1010K-2P	10	10	125	10	K11ER/L	Pin 8	WSD2*	K3	a	A62
WPK15ER/L 1010K-2P	10	10	125	10	K15ER/L	Pin 12	WSD2*	K3	a	A62
WPK15ER 1212F-2P	12	12	85	12	K15ER	Pin 12	WSD2*	K3	r	A61
WPK15ER/L 1212K-2P	12	12	125	12	K15ER/L	Pin 12	WSD2*	K3	a	A62
WPK15ER/L 1205K-2P	12	1 1/2"	125	12	K15ER/L	Pin 12	WSD2*	K3	r	A62
WPK15ER/L 1616K-2P	16	16	125	16	K15ER/L	Pin 12	WSD2*	K3	a	A63
WPK20ER 1212K-2P	12	12	125	12	K20ER	Pin 16	WSD2*	K3	r	A62
WPK20ER 1205K-2P	12	1 1/2"	125	12	K20ER	Pin 16	WSD2*	K3	r	A62
WPK20ER 1616K-2P	16	16	125	16	K20ER	Pin 16	WSD2*	K3	r	A63
WPK20ER 2020K-2P	20	20	125	20	K20ER	Pin 16	WSD2*	K3	r	A64

Right hand toolholder shown.

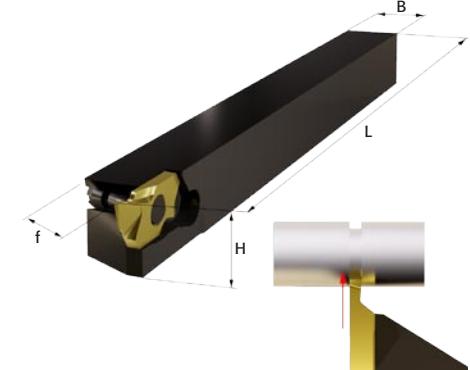
* Ordered separately

e.g. Toolholder WPK15ER 1010K-2P can be used with K15ER G1,0 C8

WSK | Toolholder with Centerlock Screw

Toolholder	B	H	L	f	Insert	Screw	Key	Stock	Price group
WSK11ER/L 88K-2P	8	8	125	8	K11ER/L	M2,5x6	J2	a	A52
WSK15ER/L 1010K-2P	10	10	125	10	K15ER/L	M3x7	J3	a	A52
WSK15ER/L 1212K-2P	12	12	125	12	K15ER/L	M3x7	J3	a	A52
WSK15ER/L 1205K-2P	12	1 1/2"	125	12	K15ER/L	M3x7	J3	a	A52
WSK15ER/L 1616K-2P	16	16	125	16	K15ER/L	M3x7	J3	a	A53
WSK20ER 1212K-2P	12	12	125	12	K20ER	M4x9	J4	r	A52
WSK20ER 1205K-2P	12	1 1/2"	125	12	K20ER	M4x9	J4	r	A52
WSK20ER 1616K-2P	16	16	125	16	K20ER	M4x9	J4	r	A53
WSK20ER 2020K-2P	20	20	125	20	K20ER	M4x9	J4	r	A54
WSK20ER 2525K-2P	25	25	150	25	K20ER	M4x9	J4	r	A55
WSK20ER 1000K-2P	1"	1"	150	1"	K20ER	M4x9	J4	r	A55

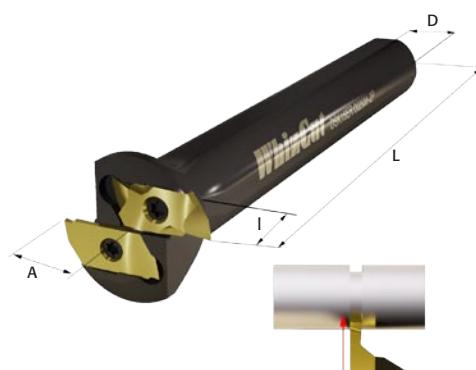
Right hand toolholder shown.



Toolholders for Flat Bed Lathes

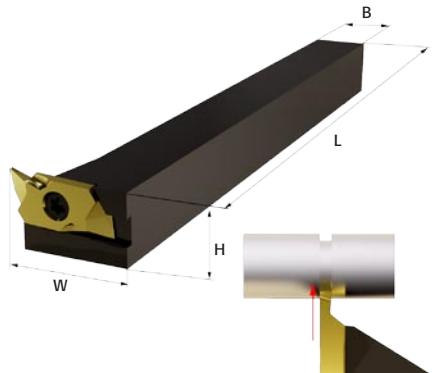
DSK | Round Shanks - Double Inserts

Toolholder	D	A	L	I	Insert	Screw	Key	Stock	Price group
DSK15ER 0016M-2P	16	14	150	8	K15ER	M3x7	J3	r	A76
DSK15ER 0020M-2P	20	14	150	5	K15ER	M3x7	J3	r	A77

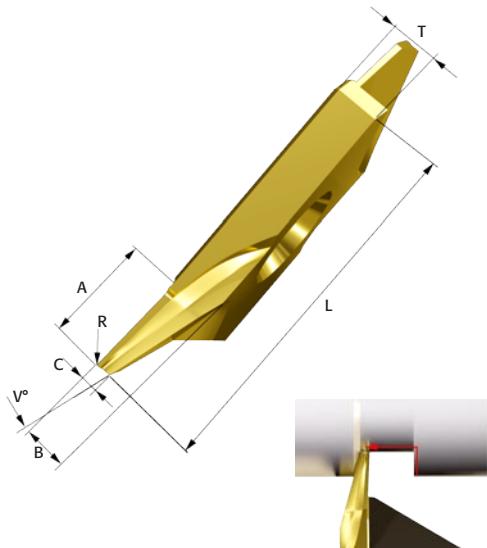


ZSK | Square Shanks

Toolholder	B	H	L	W	Insert	Screw	Key	Stock	Price group
ZSK15ER 1212K-2P	12	12	125	20	K15ER	M3x7	J3	r	A72
ZSK15ER 1616K-2P	16	16	125	24	K15ER	M3x7	J3	r	A73



K-type Inserts



Style B | Inserts for Back Turning in Steel and Other Hard and Long-Chipping Materials

Inserts	Max A	B	C	R	V	Cutting rake°	Stock 8M	Stock C8	Stock F8	Stock B8	Price group
K11ER/L B12-2-0	2	1,0	0,4	0	15	12	a	a	b	k	A8
K11ER/L B12-3-0	3,5	1,5	0,6	0	15	12	a	a	b	k	A8
K15ER/L B12-2-0	2,5	1,3	0,5	0	15	12	a	a	b	k	A8
K15ER/L B12-4-0	4	1,9	0,7	0	15	12	a	a	b	k	A8
K15ER/L B12-4-05	4	1,9	0,7	0,05	15	12	a	a	b	k	A9
K15ER/L B12-4-1	4	1,9	0,7	0,1	15	12	a	a	b	k	A9
K15ER/L B12-4-2	4	1,9	0,7	0,2	15	12	a	a	b	k	A9
K20ER B12-7-0	7	3,2	1,3	0	15	12	r	r	r	k	A28
K20ER B12-7-2	7	3,2	1,3	0,2	15	12	r	r	r	k	A29
K20ER BT12-7-2	7	3,2	1,3	0,2	15	12	r	r	r	k	A29

Right hand insert shown.



Style BP | Inserts for Back Turning in Sticky Materials

Inserts	Max A	B	C	R	V	Cutting rake°	Stock 8M	Stock C8	Stock F8	Stock B8	Price group
K15ER/L BP12-4-1	4	1,9	0,7	0,1	15	12	b	b	b	k	A9

Please note: K15ER BP12-4-1 has a small chamfer on the left corner



All other variables are same as style B



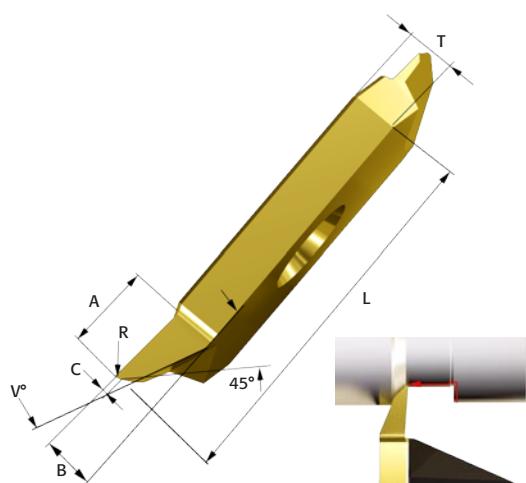
All variables are same as style B

Style BT | Inserts for Back Turning for Longer Tool Life in Tough Materials

Inserts	Max A	B	C	R	V	Cutting rake°	Stock 8M	Stock C8	Stock F8	Stock B8	Price group
K15ER BT12-4-2	4	1,9	0,7	0,2	15	12	b	b	b	k	A9

Style BC | Inserts for Back Turning with High Feed Rates

Inserts	Max A	B	C	R	V	Cutting rake°	Stock 8M	Stock C8	Stock F8	Stock B8	Price group
K15ER/L BC12-1-0	1,5	1,9	0,5	0	45	12	r	r	r	k	A8



Style C | Inserts for Back Turning when there is an Undercut Required

Inserts	Max A	B	C	R	V	Cutting rake°	Stock 8M	Stock C8	Stock F8	Stock B8	Price group
K11ER CO-1-0	1,3	1	0,2	0	30 only	0	b	b	b	k	A6
K15ER/L CO-3-0	3	1,9	0,2	0	20	0	a	a	b	k	A7

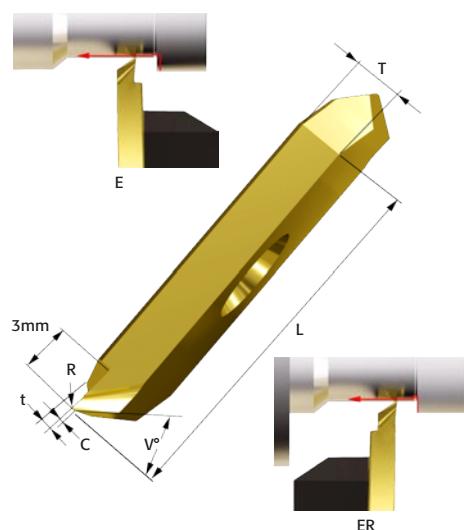
Right hand insert shown.

All angles are shown when mounted in toolholder

Style E | Inserts for an Extra Finishing Cut; Backturning

Inserts	Max cut	C	t	R	V	Cutting rake °	Stock 8M	Stock C8	Stock F8	Stock B8	Price group
K15ER E16-0-05	0,08	0,15	0,6	0,05	30	16	r	r	r	k	A7

Please note: Fine turning insert. Maximum depth of cut in one pass is 0,08mm



Style ER | Inserts for an extra finishing cut; back turning out from guide bushing

Inserts	Max cut	C	t	R	V	Cutting rake °	Stock 8M	Stock C8	Stock F8	Stock B8	Price group
K15EL ER16-0-05	0,08	0,15	0,1	0,05	30	16	I	I	I	k	A7

Please note: Fine turning insert. Maximum depth of cut in one pass is 0,08mm.

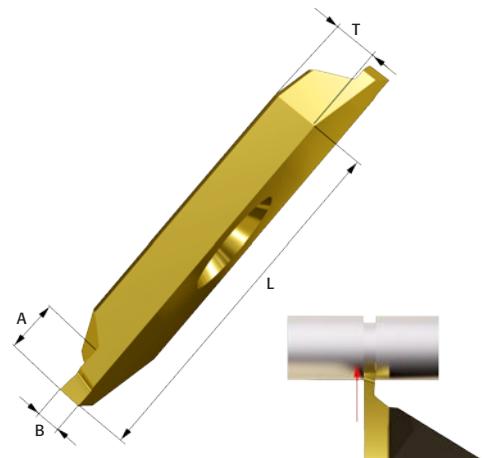
Left hand insert for right hand turning shown. Right hand not available.

Stock status:

- | | | | |
|---|--|----|-----|
| a | ER Stock standard, EL Stock standard | L | T |
| b | ER Stock standard, EL against inquiry | 11 | 2,5 |
| c | EL Stock standard, ER against inquiry | 15 | 2,1 |
| r | ER Stock standard only | 20 | 3,5 |
| l | EL Stock standard only | | |
| k | ER against inquiry, EL against inquiry | | |

Style G | Inserts for Grooving

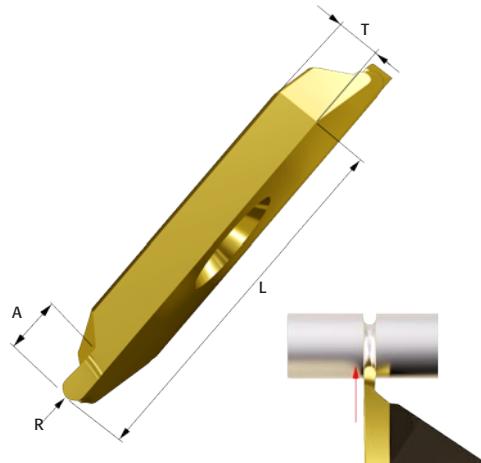
Insert	B	Max A	Circclip size °	Stock 8M	Stock C8	Stock F8	Stock B8	Price group
K11ER/L G0,5	0,5	1,0	0,4	b	b	b	k	A4
K11ER/L G0,8	0,8	1,6	0,7	b	b	b	k	A4
K11ER/L G1,0	1,0	2,0	0,9	a	a	b	k	A4
K11ER/L G1,15	1,15	2,3	1,0	b	b	b	k	A4
K11ER/L G1,5	1,5	3,0	a	a	b	k	A4	
K15ER G0,1	0,1	0,2	r	r	r	r	k	A6
K15ER G0,2	0,2	0,4	r	r	r	r	k	A5
K15ER G0,25	0,25	0,5	r	r	r	r	k	A5
K15ER G0,3	0,3	0,6	r	r	r	r	k	A4
K15ER/L G0,5	0,5	1,0	0,4	a	a	b	k	A4
K15ER/L G0,6	0,6	1,2	0,5	b	b	b	k	A4
K15ER/L G0,7	0,7	1,4	0,6	b	b	b	k	A4
K15ER/L G0,8	0,8	1,6	0,7	a	a	b	k	A4
K15ER/L G1,0	1,0	2,0	0,9	a	a	b	k	A4
K15ER/L G1,15	1,15	2,3	1,0	b	b	b	k	A4
K15ER/L G1,35	1,35	2,7	1,2	b	b	b	k	A4
K15ER/L G1,5	1,5	3,0	a	a	b	k	A4	
K15ER/L G1,65	1,65	3,3	1,5	b	b	b	k	A4
K15ER/L G1,90	1,90	3,8	1,75	b	b	b	k	A4
K15ER/L G2,05	2,05	4,1	a	a	b	k	A4	
K20ER G2,0	2,0	4,0	r	r	r	r	k	A24
K20ER G2,5	2,5	5,0	r	r	r	r	k	A24
K20ER G3,0	3,0	6,0	r	r	r	r	k	A24



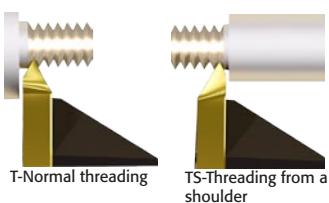
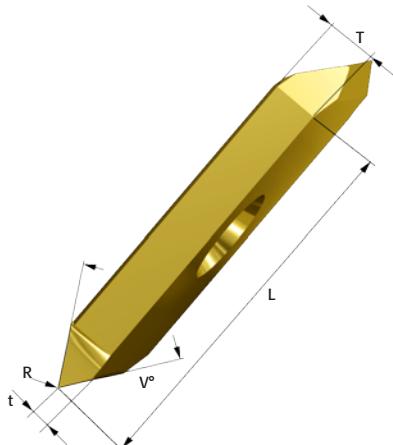
Style GR | Inserts for Radius Grooving

Inserts	R	A	L	T	Stock 8M	Stock C8	Stock F8	Stock B8	Price group
K15ER GR 0,25	0,25	0,4	15	2,1	b	b	b	k	A7
K15ER GR 0,5	0,5	0,8	15	2,1	b	b	b	k	A7
K15ER GR 0,75	0,75	1,2	15	2,1	b	b	b	k	A7
K15ER GR 1,0	1,0	1,5	15	2,1	b	b	b	k	A7
K20ER GR 1,25	1,25	2,0	20	3,5	b	b	b	k	A27
K20ER GR 1,5	1,5	2,4	20	3,5	b	b	b	k	A27
K20ER GR 1,75	1,75	3	20	3,5	b	b	b	k	A27

Right hand insert shown.



K-type Inserts



Style T | Inserts for Partial Profile Threading

Inserts	L	V	t	R	Stock				Price group
					8M	C8	F8	B8	
K11ER/L T55-5	11	55	0,5	0,03	b	b	b	k	A5
K11ER/L T60-5	11	60	0,5	0,03	a	a	b	k	A4
K15ER/L T55-5	15	55	0,5	0,03	b	b	b	k	A5
K15ER T60-025	15	60	0,25	0,02	b	b	b	k	A4
K15ER/L T60-5	15	60	0,5	0,02	a	a	b	k	A4
K15ER T60-5-06	15	60	0,5	0,06	b	b	b	k	A4
K15ER/L T60-8	15	60	0,8	0,05	a	a	b	k	A4
K15ER T60-10-1	15	60	1,0	0,12	b	b	b	k	A4
K15ER TS60-16	15	60	1,6	0,03	b	b	b	k	A5
K20ER T60-10	20	60	1	0,1	r	r	r	k	A25
K20ER T60-15	20	60	1,5	0,2	r	r	r	k	A25
K20ER TS60-25	20	60	2,5	0,1	r	r	r	k	A25

Right hand insert shown.

Stock status:

L	T
11	2,5
15	2,1
20	3,5

- a ER Stock standard, EL Stock standard
- b ER Stock standard, EL against inquiry
- c EL Stock standard, ER against inquiry
- r ER Stock standard only
- l EL Stock standard only
- k ER against inquiry, EL against inquiry

Style T | Inserts for Full Profile Threading ISO

Pitch mm	Inserts	L	t	P	Thread Standard		Stock			Price group
					8M	C8	F8	B8		
0,3	K15ER T0,3ISO	15	0,2	0,3	ISO		k	k	k	A7
0,35	K15ER T0,35ISO	15	0,25	0,35	ISO		k	k	k	A7
0,4	K15ER T0,4ISO	15	0,25	0,4	ISO		r	r	r	A7
0,5	K15ER T0,5ISO	15	0,3	0,5	ISO		r	r	r	A7
0,7	K15ER T0,7ISO	15	0,4	0,7	ISO		r	r	r	A6
0,75	K15ER T0,75ISO	15	0,4	0,75	ISO		r	r	r	A6
0,8	K15ER T0,8ISO	15	0,45	0,8	ISO		r	r	r	A6
1	K15ER T1,0ISO	15	0,55	1	ISO		r	r	r	A6
1,25	K15ER T1,25ISO	15	0,7	1,25	ISO		r	r	r	A6
1,5	K15ER T1,5ISO	15	0,8	1,5	ISO		r	r	r	A6

Right hand insert shown.

Style T | Inserts for Full Profile Threading Unified

TPI	Inserts	L	t	P	Thread Standard		Stock			Price group
					8M	C8	F8	B8		
40	K15ER T40UN	15	0,35	40	UN		r	r	r	A6
32	K15ER T32UN	15	0,45	32	UN		r	r	r	A6
24	K15ER T24UN	15	0,6	24	UN		r	r	r	A6
20	K15ER T20UN	15	0,7	20	UN		r	r	r	A6
18	K15ER T18UN	15	0,8	18	UN		r	r	r	A6
16	K15ER T16UN	15	0,9	16	UN		r	r	r	A6

Right hand insert shown.

Style T | Inserts for Full Profile Threading NPT

TPI	Inserts	L	t	P	Thread Standard		Stock			Price group
					8M	C8	F8	B8		
27	K15ER T27NPT	15	0,55	27	NPT		r	r	r	A6
18	K15ER T18NPT	15	0,8	18	NPT		r	r	r	A6
14	K15ER T14NPT	15	1	14	NPT		r	r	r	A6

Right hand insert shown.

Style T | Inserts for Full Profile Threading NPTF

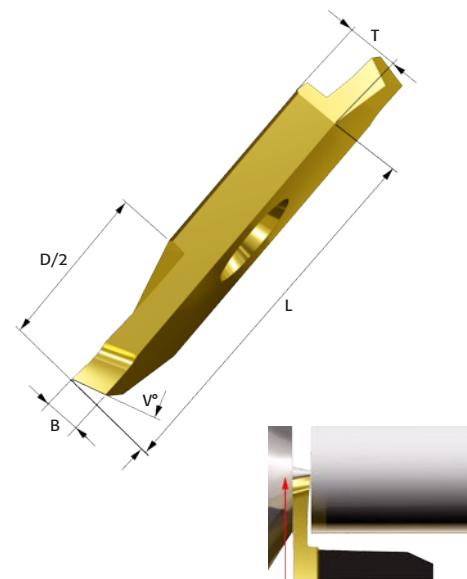
TPI	Inserts	L	t	P	Thread Standard		Stock			Price group
					8M	C8	F8	B8		
27	K15ER T27NPTF	15	0,55	27	NPTF		r	r	r	A6
18	K15ER T18NPTF	15	0,8	18	NPTF		r	r	r	A6
14	K15ER T14NPTF	15	1	14	NPTF		r	r	r	A6

Right hand insert shown.

Style P, Y, Z, S, U | Inserts for Parting off

Inserts	B	D	V	Max rake °	Cutting rake °	Stock 8M	Stock C8	Stock F8	Stock B8	Price group
K11ER/L P0,8-12	0,8	7	0°	12	b	b	b	k	A5	
K11ER/L P1,0-12	1,0	9	0°	12	b	b	b	k	A5	
K11ER/L P1,5-12	1,5	11	0°	12	b	b	b	k	A4	
K15ER/L P0,7-12	0,7	5	0°	12	b	b	b	k	A5	
K15ER/L P1,0-12	1,0	10	0°	12	a	a	b	k	A5	
K15ER/L P1,0-20	1,0	10	0°	20	r	r	r	k	A5	
K15ER/L P1,2-12	1,2	12	0°	12	a	a	b	k	A5	
K15ER/L P1,5-12	1,5	12	0°	12	a	a	b	k	A4	
K15ER/L P1,5-20	1,5	12	0°	20	r	r	r	k	A4	
K15ER/L P2,0-12	2,0	12	0°	12	a	a	b	k	A4	
K20ER P1,5-12	1,5	16	0°	12	r	r	r	k	A25	
K20ER P2,0-12	2,0	20	0°	12	r	r	r	k	A25	
K20ER P2,5-12	2,5	20	0°	12	r	r	r	k	A25	
K20ER P3,0-12	3,0	20	0°	12	r	r	r	k	A25	
K11ER/L Y1,0-12	1,0	9	6°	12	b	b	b	k	A6	
K11ER/L Y1,5-12	1,5	11	6°	12	b	b	b	k	A5	
K15ER/L Y1,0-12	1,0	10	6°	12	a	a	b	k	A6	
K15ER/L Y1,2-12	1,2	12	6°	12	b	b	b	k	A5	
K15ER/L Y1,5-12	1,5	12	6°	12	a	a	b	k	A5	
K15ER/L Y2,0-12	2,0	12	6°	12	a	a	b	k	A5	
K20ER Y2,0-12	2,0	20	6°	12	r	r	r	k	A26	
K20ER Y2,5-12	2,5	20	6°	12	r	r	r	k	A26	
K11ER/L Z1,0-0	1,0	9	15°	0	a	a	b	k	A6	
K11ER/L Z1,0-12	1,0	9	15°	12	a	a	b	k	A6	
K11ER/L Z1,5-0	1,5	11	15°	0	a	a	b	k	A5	
K11ER/L Z1,5-12	1,5	11	15°	12	a	a	b	k	A5	
K15ER/L Z0,7-0	0,7	5	15°	0	b	b	b	k	A6	
K15ER/L Z0,7-12	0,7	5	15°	12	b	b	b	k	A6	
K15ER/L Z1,0-0	1,0	10	15°	0	a	a	b	k	A6	
K15ER/L Z1,0-12	1,0	10	15°	12	a	a	b	k	A6	
K15ER/L Z1,5-0	1,5	12	15°	0	a	a	b	k	A5	
K15ER/L Z1,5-12	1,5	12	15°	12	a	a	b	k	A5	
K15ER/L Z2,0-0	2,0	12	15°	0	a	a	b	k	A5	
K15ER/L Z2,0-12	2,0	12	15°	12	a	a	b	k	A5	
K20ER Z2,0-0	2,0	20	15°	0	r	r	r	k	A26	
K20ER Z2,0-12	2,0	20	15°	12	r	r	r	k	A26	
K20ER Z2,5-0	2,5	20	15°	0	r	r	r	k	A26	
K20ER Z2,5-12	2,5	20	15°	12	r	r	r	k	A26	
K15ER S1,0-0	1,0	6	20°	0	b	b	b	k	A5	
K15ER S1,0-12	1,0	6	20°	12	b	b	b	k	A6	
K15ER S1,5-0	1,5	9	20°	0	b	b	b	k	A5	
K15ER S1,5-12	1,5	9	20°	12	b	b	b	k	A6	
K11ER/L U1,0-0	1,0	8	30°	0	a	a	b	k	A6	
K15ER/L U1,0-0	1,0	9	30°	0	a	a	b	k	A6	
K15ER/L U1,5-0	1,5	12	30°	0	a	a	b	k	A6	
K20ER U2,0-0	2,0	16	30°	0	r	r	r	k	A26	
K20ER U2,5-0	2,5	20	30°	0	r	r	r	k	A26	

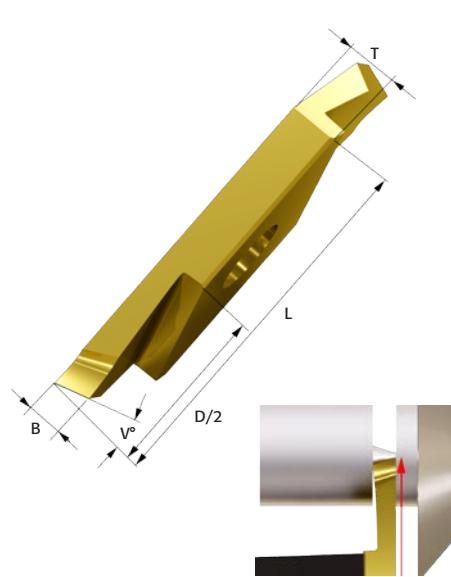
Right hand insert shown.

Style P
V = 0°Style Y
V = 6°Style Z
V = 15°Style S Short
V = 20°Style U
V = 30°

Style YR, ZR, SR | Inserts for Parting Off Against Sub Spindle etc.

Inserts	B	D	V	Max rake °	Cutting rake °	Stock 8M	Stock C8	Stock F8	Stock B8	Price group
K15EL YR1,5-12	1,5	12	6°	12					k	A6
K15EL YR2,0-12	2,0	12	6°	12					k	A6
K11EL ZR1,0-0	1,0	9	15°	0					k	A6
K11EL ZR1,0-12	1,0	9	15°	12					k	A6
K11EL ZR1,5-0	1,5	11	15°	0					k	A6
K11EL ZR1,5-12	1,5	11	15°	12					k	A6
K15EL ZR1,0-0	1,0	10	15°	0					k	A6
K15EL ZR1,0-12	1,0	10	15°	12					k	A6
K15EL ZR1,5-0	1,5	12	15°	0					k	A6
K15EL ZR1,5-12	1,5	12	15°	12					k	A6
K15EL ZR2,0-0	2,0	12	15°	0					k	A6
K15EL ZR2,0-12	2,0	12	15°	12					k	A6
K15EL SR1,0-0	1,0	5,5	20°	0					k	A6
K15EL SR1,0-12	1,0	5,5	20°	12					k	A6
K15EL SR1,5-0	1,5	8	20°	0					k	A6
K15EL SR1,5-12	1,5	8	20°	12					k	A6

Left hand insert for right hand turning shown. Right hand not available.

Style YR,
V = 6°Style ZR
V = 15°Style SR
Short
V = 20°



WhizIn

Internal Boring Bars

WhizIn, another revolutionary product developed by WhizCut is designed to improve productivity of internal applications. It has been specially developed for small diameters in internal turning applications and is unlike anything else on the market.

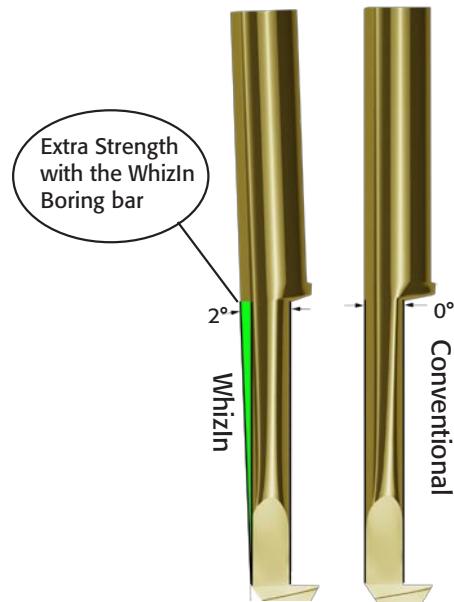
The WhizIn toolholder has the carbide bar mounted at an angle to achieve the maximum stability for a set diameter. By grinding away less from the base of the insert, the insert becomes more stable. Other benefits are less grinding time and grinding stress and that the coolant may go through the toolholder and spray directly on to the cutting zone.

The WhizIn program includes a wide range of toolholders and inserts for internal turning, grooving, threading etc. The inserts are fully ground and made of micro grain carbide.

We Clamp it Crooked, You get a Stronger Tool and You Pay Less!

The WhizIn Boring Bar Set at an Angle

- Better stability, up to 50% more material at the critical point
- Less grinding needed
- Less grinding stress
- Better boring bar cheaper



The WhizIn Toolholder

- Through coolant
- Double screws for security and stability
- Special toolholder designs for Swiss Type Automatic Lathes



Turning with the Right Grade of Carbide

10M an uncoated micrograin grade at ISO K20-K30 for non ferrous materials.

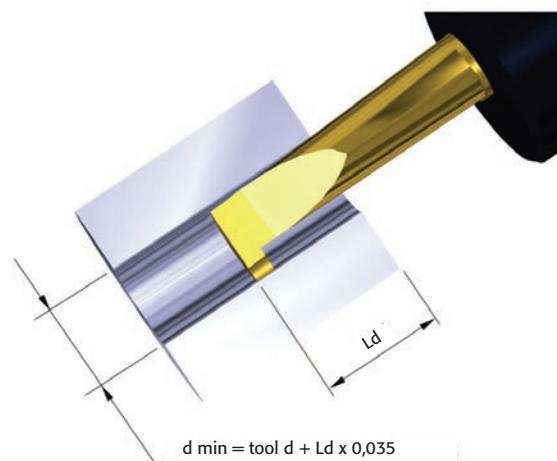
C10 a TiN, PVD coated micrograin grade (ISO P10-P30, K10-K30) for longer tool life and also for Steel, Stainless etc. using higher cutting speed.

F10 A TiAlN multicoated grade suitable when extreme heat (900°C) is developed during machining.

B10 A AlCrN coating suitable when extreme heat (1100°C) is developed during machining.

Minimum Bore Size

Due to the angular mounting of the WhizIn insert, the minimum bore size depends on the depth the tool is going into the smaller hole. This can easily be calculated as shown in the picture to the right.



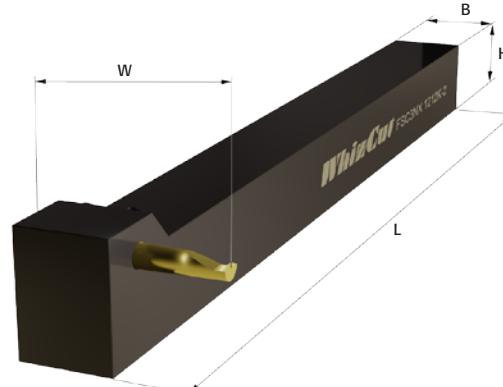
WRC | With Cylindrical Shanks

Catalog number	D	Insert size	I	L with standard inserts	Inserts	Stock	Price group
WRC3N 0012E-2	12	3	70	82	C3N---	r	B20
WRC4N 0012E-2	12	4	70	86,5	C4N---	r	B20
WRC3N 0016F-2	16	3	80	92	C3N---	r	B21
WRC4N 0016F-2	16	4	80	96,5	C4N---	r	B21
WRC5N 0016F-2	16	5	80	101	C5N---	r	B21
WRC6N 0016F-2	16	6	80	106	C6N---	r	B21
WRC3N 0750H-2	3/4"	3	100	112	C3N---	r	B22
WRC4N 0750H-2	3/4"	4	100	116,5	C4N---	r	B22
WRC5N 0750H-2	3/4"	5	100	121	C5N---	r	B22
WRC6N 0750H-2	3/4"	6	100	126	C6N---	r	B22
WRC8N 0750H-2	3/4"	8	100	145	C8N---	r	B22
WRC3N 0020H-2	20	3	100	112	C3N---	r	B22
WRC4N 0020H-2	20	4	100	116,5	C4N---	r	B22
WRC5N 0020H-2	20	5	100	121	C5N---	r	B22
WRC6N 0020H-2	20	6	100	126	C6N---	r	B22
WRC8N 0020H-2	20	8	100	145	C8N---	r	B22
WRC3N 0022J-2	22	3	110	122	C3N---	r	B23
WRC4N 0022J-2	22	4	110	126,5	C4N---	r	B23
WRC5N 0022J-2	22	5	110	131	C5N---	r	B23
WRC6N 0022J-2	22	6	110	136	C6N---	r	B23
WRC8N 0022J-2	22	8	110	155	C8N---	r	B23
WRC3N 0025J-2	25	3	110	122	C3N---	r	B24
WRC4N 0025J-2	25	4	110	126,5	C4N---	r	B24
WRC5N 0025J-2	25	5	110	131	C5N---	r	B24
WRC6N 0025J-2	25	6	110	136	C6N---	r	B24
WRC8N 0025J-2	25	8	110	155	C8N---	r	B24
WRC3N 1000J-2	1"	3	110	122	C3N---	r	B24
WRC4N 1000J-2	1"	4	110	126,5	C4N---	r	B24
WRC5N 1000J-2	1"	5	110	131	C5N---	r	B24
WRC6N 1000J-2	1"	6	110	136	C6N---	r	B24
WRC8N 1000J-2	1"	8	110	155	C8N---	r	B24



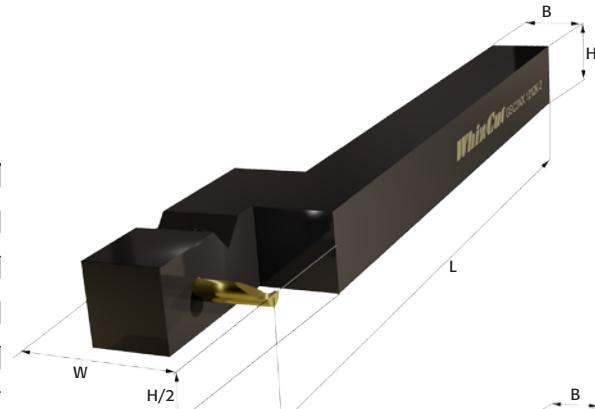
FSC | Square Shanks with Centerline at Top

Catalog number	B	H	L	W	Inserts	Stock	Price group
FSC3NX 1208K-2	12	8	125	24	C3N---	r	B20
FSC3NX 1210K-2	12	10	125	24	C3N---	r	B21
FSC3NX 1212K-2	12	12	125	24	C3N---	r	B22
FSC3NX 1616K-2	16	16	125	24	C3N---	r	B23
FSC4NX 1908K-2	19	8	125	38	C4N---	r	B20
FSC4NX 1910K-2	19	10	125	38	C4N---	r	B21
FSC4NX 1912K-2	19	12	125	38	C4N---	r	B22
FSC4NX 1916K-2	19	16	125	38	C4N---	r	B23
FSC5NX 2412K-2	24	12	125	50	C5N---	r	B22
FSC5NX 2416K-2	24	16	125	50	C5N---	r	B22
FSC5NX 2420K-2	24	20	125	50	C5N---	r	B23



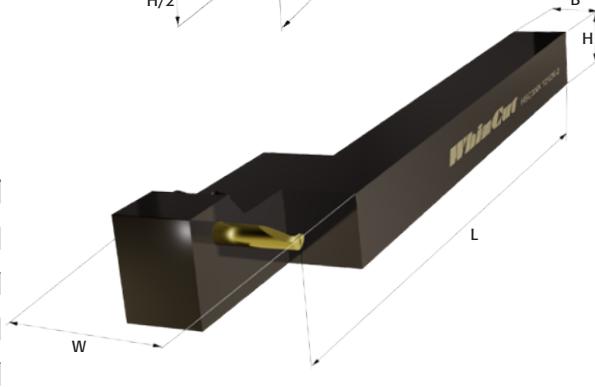
GSC | Square Shanks with Centerline at Center

Catalog number	B	H	L	W	Inserts	Stock	Price group
GSC3NX 1208K-2	12	8	125	24	C3N---	k	B25
GSC3NX 1210K-2	12	10	125	24	C3N---	k	B26
GSC3NX 1212K-2	12	12	125	24	C3N---	r	B27
GSC3NX 1616K-2	16	16	125	24	C3N---	k	B28
GSC4NX 1908K-2	19	8	125	38	C4N---	k	B25
GSC4NX 1910K-2	19	10	125	38	C4N---	k	B26
GSC4NX 1912K-2	19	12	125	38	C4N---	k	B27
GSC4NX 1916K-2	19	16	125	38	C4N---	k	B28
GSC5NX 2412K-2	24	12	125	50	C5N---	k	B27
GSC5NX 2416K-2	24	16	125	50	C5N---	k	B28

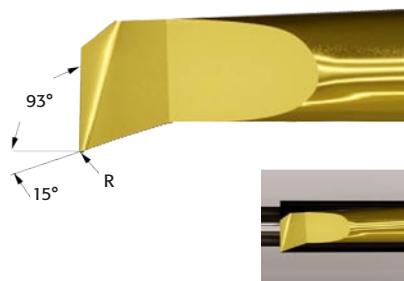


HSC | Square Shanks with Centerline at Top

Catalog number	B	H	L	W	Inserts	Stock	Price group
HSC3NX 1208K-2	12	8	125	24	C3N---	k	B27
HSC3NX 1210K-2	12	10	125	24	C3N---	k	B28
HSC3NX 1212K-2	12	12	125	24	C3N---	r	B29
HSC3NX 1616K-2	16	16	125	24	C3N---	k	B30
HSC4NX 1908K-2	19	8	125	38	C4N---	k	B28
HSC4NX 1910K-2	19	10	125	38	C4N---	k	B29
HSC4NX 1912K-2	19	12	125	38	C4N---	k	B30
HSC4NX 1916K-2	19	16	125	38	C4N---	k	B31
HSC5NX 2412K-2	24	12	125	50	C5N---	k	B31
HSC5NX 2416K-2	24	16	125	50	C5N---	k	B32

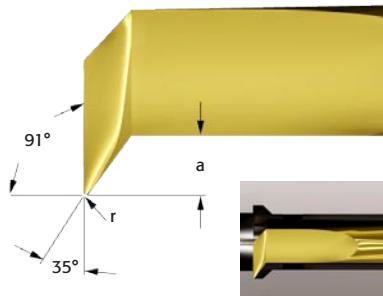


C-type Boring Bars



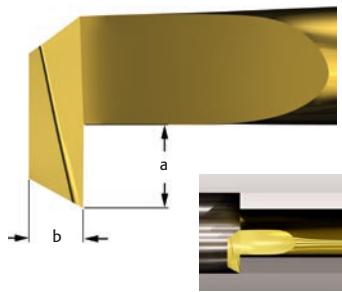
Style J | Inserts for Turning 93°

Catalog Number	D mm	d mm	Cutting rake	R mm	f mm	L mm	I mm	Stock 10M	C10	F10	B10	Price group
C31NR J8-0	3	0,8	8	0,0	0,4	24	4	b	b	b	k	B4
C32NR J8-0	3	1,6	8	0,0	0,75	24	7	b	b	b	k	B3
C33NR J8-0	3	2,2	8	0,0	1,1	24	10	b	b	b	k	B3
C34NR J8-0	3	3,0	8	0,0	1,5	24	12	b	b	b	k	B2
C34NR J8-1	3	3,0	8	0,1	1,5	24	12	b	b	b	k	B3
C4NR J8-0	4	4,0	8	0,0	2,0	32	16,5	b	b	b	k	B3
C4NR J8-1	4	4,0	8	0,1	2,0	32	16,5	b	b	b	k	B4
C5NR J8-0	5	5,0	8	0,0	2,5	40	21	b	b	b	k	B4
C5NR J8-1	5	5,0	8	0,1	2,5	40	21	b	b	b	k	B5
C6NR J8-0	6	6,0	8	0,0	3,0	48	26	b	b	b	k	B6
C6NR J8-1	6	6,0	8	0,1	3,0	48	26	b	b	b	k	B7
C8NR J8-0	8	8,0	8	0,0	4,0	72	45	b	b	b	k	B10
C8NR J8-1	8	8,0	8	0,1	4,0	72	45	b	b	b	k	B11



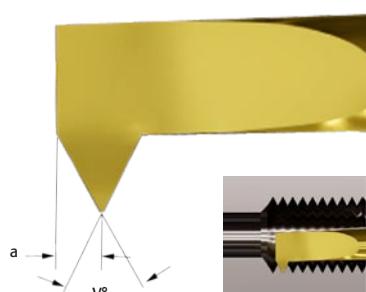
Style V | Inserts for Copy turning 35°

Catalog Number	D mm	d mm	Cutting rake	a mm	r mm	f mm	L mm	I mm	Stock 10M	C10	F10	B10	Price group
C3NR V8	3	3,0	8	1,0	0,10	1,5	24	12	b	b	b	k	B3
C4NR V8	4	4,0	8	1,4	0,15	2,0	32	16,5	b	b	b	k	B4
C5NR V8	5	5,0	8	1,7	0,20	2,5	40	21	b	b	b	k	B5
C6NR V8	6	6,0	8	2,0	0,25	3,0	48	26	b	b	b	k	B7
C8NR V8	8	8,0	8	2,7	0,30	4,0	72	45	b	b	b	k	B11



Style B | Inserts for Back Turning

Catalog Number	D mm	d mm	a mm	b mm	f mm	L mm	I mm	Stock 10M	C10	F10	B10	Price group
C3NR B12-1-0	3	3,0	1,0	0,75	1,5	24	11	b	b	b	k	B4
C4NR B12-1,4-0	4	4,0	1,4	1,0	2,0	32	16,5	b	b	b	k	B5
C5NR B12-1,7-0	5	5,0	1,7	1,25	2,5	40	21	b	b	b	k	B6
C6NR B12-2-0	6	6,0	2,0	1,5	3,0	48	27	b	b	b	k	B8
C8NR B12-2,7-0	8	8,0	2,7	1,8	4,0	72	45	b	b	b	k	B12

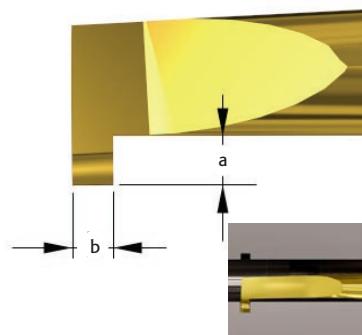


Style T | Inserts for Threading

Catalog Number	D mm	d mm	Pitch mm	V°	a mm	f mm	L mm	I mm	Stock 10M	C10	F10	B10	Price group
C31NR T60	3	0,8	0,2-0,4	60	0,2	0,5	24	4	b	b	b	k	B4
C32NR T60	3	1,6	0,2-0,6	60	0,3	0,75	24	7	b	b	b	k	B3
C33NR T60	3	2,2	0,2-0,8	60	0,4	1,25	24	10	b	b	b	k	B3
C34NR T60	3	3,0	0,2-1,0	60	0,5	1,5	24	12	b	b	b	k	B2
C4NR T60	4	4,0	0,25-1,25	60	0,6	2	32	16,5	b	b	b	k	B3
C4NR T55	4	4,0	0,25-1,25	55	0,6	2	32	16,5	b	b	b	k	B3
C5NR T60	5	5,0	0,25-1,5	60	0,7	2,5	40	21	b	b	b	k	B4
C6NR T60	6	6,0	0,25-1,75	60	0,8	3	48	27	b	b	b	k	B5
C6NR T55	6	6,0	0,25-1,75	55	0,8	3	48	27	b	b	b	k	B5
C8NR T60	8	8,0	0,35-2,5	60	1,2	4	72	45	b	b	b	k	B10

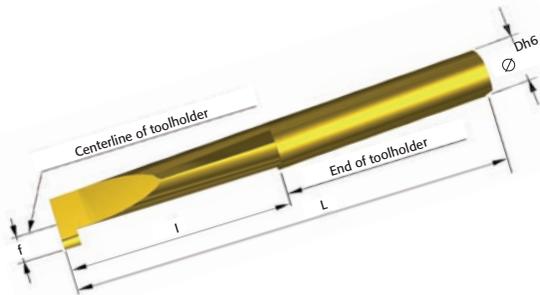
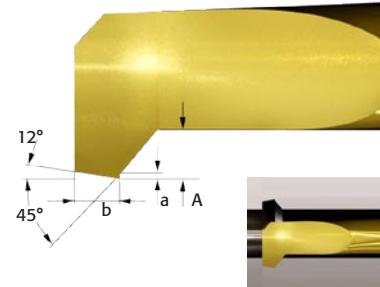
Style G | Inserts for Straight Grooves

Catalog Number	D mm	d mm	b mm	a mm	f mm	L mm	I mm	Stock 10M	Price C10	F10	B10 group
C31NR G0,2	3	0,8	0,2	0,3	0,4	24	4	b	b	b	k B4
C32NR G0,3	3	1,6	0,3	0,5	0,75	24	7	b	b	b	k B4
C33NR G0,5	3	2,2	0,5	0,7	1,1	24	10	b	b	b	k B4
C34NR G0,2	3	3,0	0,2	0,3	1,5	24	12	b	b	b	k B3
C34NR G0,5	3	3,0	0,5	0,8	1,5	24	12	b	b	b	k B3
C34NR G0,8	3	3,0	0,8	1,0	1,5	24	12	b	b	b	k B3
C34NR G1,0	3	3,0	1,0	1,0	1,5	24	12	b	b	b	k B3
C4NR G0,5	4	4,0	0,5	0,8	2,0	32	16,5	b	b	b	k B4
C4NR G1,0	4	4,0	1,0	1,3	2,0	32	16,5	b	b	b	k B4
C5NR G0,5	5	5,0	0,5	0,8	2,5	40	21	b	b	b	k B5
C5NR G1,0	5	5,0	1,0	1,5	2,5	40	21	b	b	b	k B5
C5NR G1,5	5	5,0	1,5	1,5	2,5	40	21	b	b	b	k B5
C6NR G0,7	6	6,0	0,7	1,3	3,0	48	26	b	b	b	k B7
C6NR G1,0	6	6,0	1,0	1,3	3,0	48	26	b	b	b	k B7
C6NR G1,5	6	6,0	1,5	2,0	3,0	48	26	b	b	b	k B7
C6NR G2,0	6	6,0	2,0	2,0	3,0	48	26	b	b	b	k B7
C8NR G1,0	8	8,0	1,0	1,7	4,0	72	45	b	b	b	k B11
C8NR G1,5	8	8,0	1,5	2,2	4,0	72	45	b	b	b	k B11
C8NR G2,0	8	8,0	2,0	2,7	4,0	72	45	b	b	b	k B11
C8NR G2,5	8	8,0	2,5	2,7	4,0	72	45	b	b	b	k B11



Style P | Inserts for Grooving and Chamfering before Parting Off

Catalog Number	D mm	d mm	b mm	A mm	a mm	f mm	L mm	I mm	Stock 10M	Price C10	F10	B10 group
C3NR P0,8	3	3,0	0,8	0,8	0,1	1,5	24	12	b	b	b	k B4
C4NR P1,0	4	4,0	1,0	1,0	0,1	2,0	32	16,5	b	b	b	k B5
C5NR P1,0	5	5,0	1,0	1,3	0,2	2,5	40	21	b	b	b	k B6
C6NR P1,0	6	6,0	1,0	1,5	0,2	3,0	48	26	b	b	b	k B8
C8NR P1,5	8	8,0	1,5	2,0	0,3	4,0	72	45	b	b	b	k B12



Stock status:

- a ER Stock standard, EL Stock standard
- b ER Stock standard, EL against inquiry
- c EL Stock standard, ER against inquiry
- r ER Stock standard only
- l EL Stock standard only
- k ER against inquiry, EL against inquiry

Style A | Inserts for Face Grooving

Catalog number	D mm	b mm	a mm	L mm	I mm	Stock 10M	Price C10	F10	B10 group
C3NR A8-3-07	3	0,7	0,8	18	6	b	b	b	k B2
C4NR A8-4-10	4	1,0	1,25	23,5	8	b	b	b	k B3
C5NR A8-5-12	5	1,2	1,5	29	10	b	b	b	k B4
C6NR A8-6-15	6	1,5	2	34	12	b	b	b	k B6
C8NR A8-8-20	8	2,0	2,5	43	16	b	b	b	k B10

Special widths and depths can be produced. Contact your local distributor for a quote

