



# Vibration Damped Machining Tools

## Welcome to the MAQ-World!

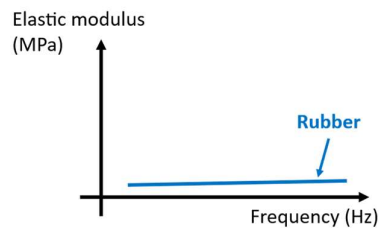
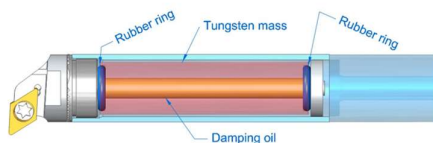
At MAQ, our vision is simple yet revolutionary: “Simplify Machining.” With our groundbreaking plug-and-play technology, we eliminate vibrations from manufacturing processes, reducing production time and costs while enhancing product quality.

### *The Challenge: Vibration in Machining*

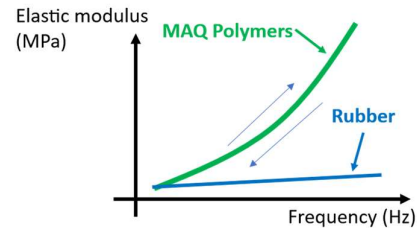
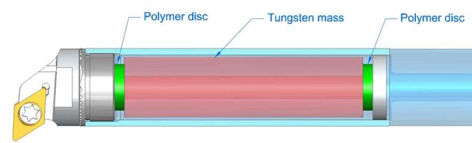
Vibration during machining can result in damaged surfaces, broken cutting inserts, and skyrocketing production costs. This issue is particularly severe in operations requiring tools with a high length-to-diameter ratio (L/D), though even shorter overhang tools are not immune.

At the heart of the problem lies the variability of vibration frequencies. Cutting conditions like tool wear, joint deterioration, workpiece material variations, or setup changes can cause these frequencies to shift. Traditional vibration-damped tools rely on fixed tuning, which can worsen vibrations when the frequency moves outside their optimized range.

*4<sup>th</sup> Generation –*  
Rubber rings with damping oil



*5<sup>th</sup> Generation – from MAQ*  
Polymers with frequency dependent stiffness



### *The MAQ Solution: A Self-Tuning Revolution*

MAQ tools are designed to adapt dynamically to these challenges. Our patented STMD™ (Self-Tuning Mass Dampener) technology uses innovative polymer spring elements that adjust their stiffness in real-time to match changing vibration frequencies. This unique self-tuning property ensures consistent performance, even under fluctuating machining conditions. The above picture illustrates our STMD technology versus the prior-art solution on the market.

The result? Superior surface finishes, tighter tolerances, enhanced process reliability, and significantly boosted productivity.

### *Why Choose MAQ Tools?*

- **Simplicity Meets Ingenuity:** Our tools are easy to implement and outperform leading competitors.
- **Cost Savings:** Reduce tooling and overall machining costs while cutting down setup time and eliminating secondary operations.
- **High Efficiency:** No need for manual tuning—our tools do the work for you.

With MAQ, machining becomes effortless, efficient, and cost-effective. Join the movement to simplify machining and experience the MAQ difference today!

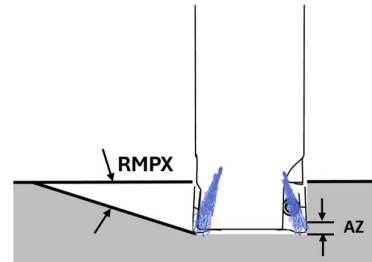
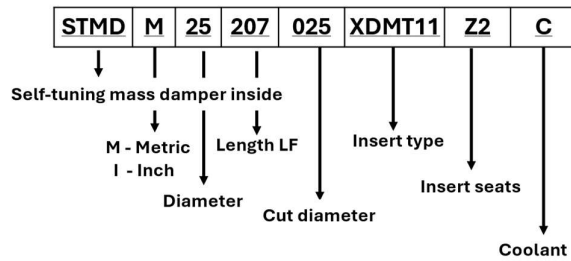
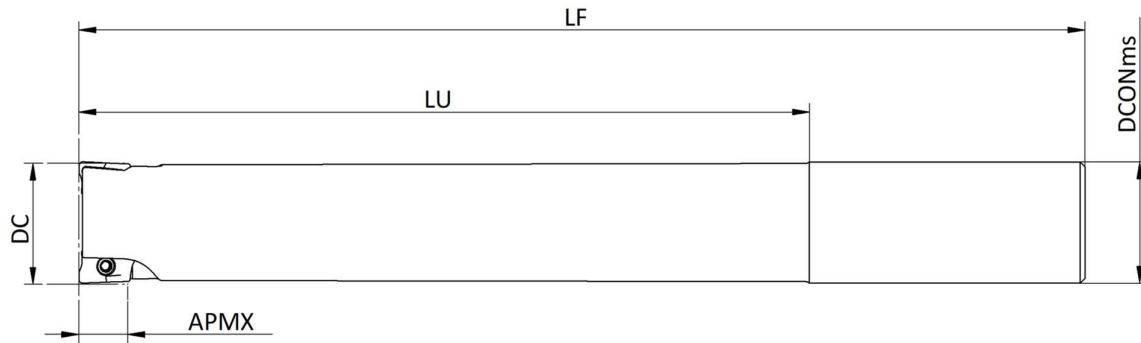
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## Milling

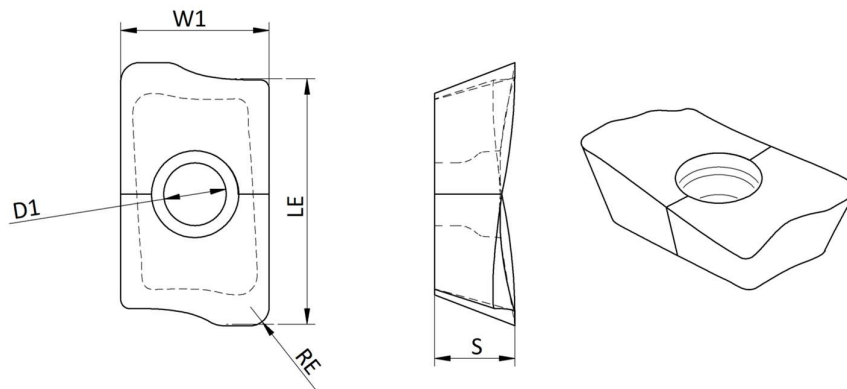
### Monoblock milling tools



| Damped square shoulder milling tool - Monoblock |                              |                         |         |         |         |          |         |             |   |         |                        |              |     |
|-------------------------------------------------|------------------------------|-------------------------|---------|---------|---------|----------|---------|-------------|---|---------|------------------------|--------------|-----|
| Part number                                     | Type                         | DCON <sub>ms</sub> (mm) | DC (mm) | LU (mm) | LF (mm) | RMPX (°) | AZ (mm) | Insert seat | Z | Max RPM | Balancing <sup>a</sup> | Thread screw |     |
| 310001                                          | STMD M20-171 020 XDMT11 Z2 C | 20 h6                   | 20      | 120     | 171     | 5.5      | 1       | XDMT 11     | 2 | 32500   | NO                     | M2.5x6       | 0.6 |
| 310002                                          | STMD M25-207 025 XDMT11 Z2 C | 25 h6                   | 25      | 150     | 207     | 5        | 1       | XDMT 11     | 2 | 24000   | NO                     | M2.5x6       | 0.9 |
| 310003                                          | STMD M32-254 032 XDMT11 Z2 C | 32 h6                   | 32      | 192     | 254     | 3.6      | 1       | XDMT 11     | 2 | 15000   | NO                     | M2.5x6       | 1.5 |

|                                                     |
|-----------------------------------------------------|
| a - with a floating mass and naturally not balanced |
|-----------------------------------------------------|

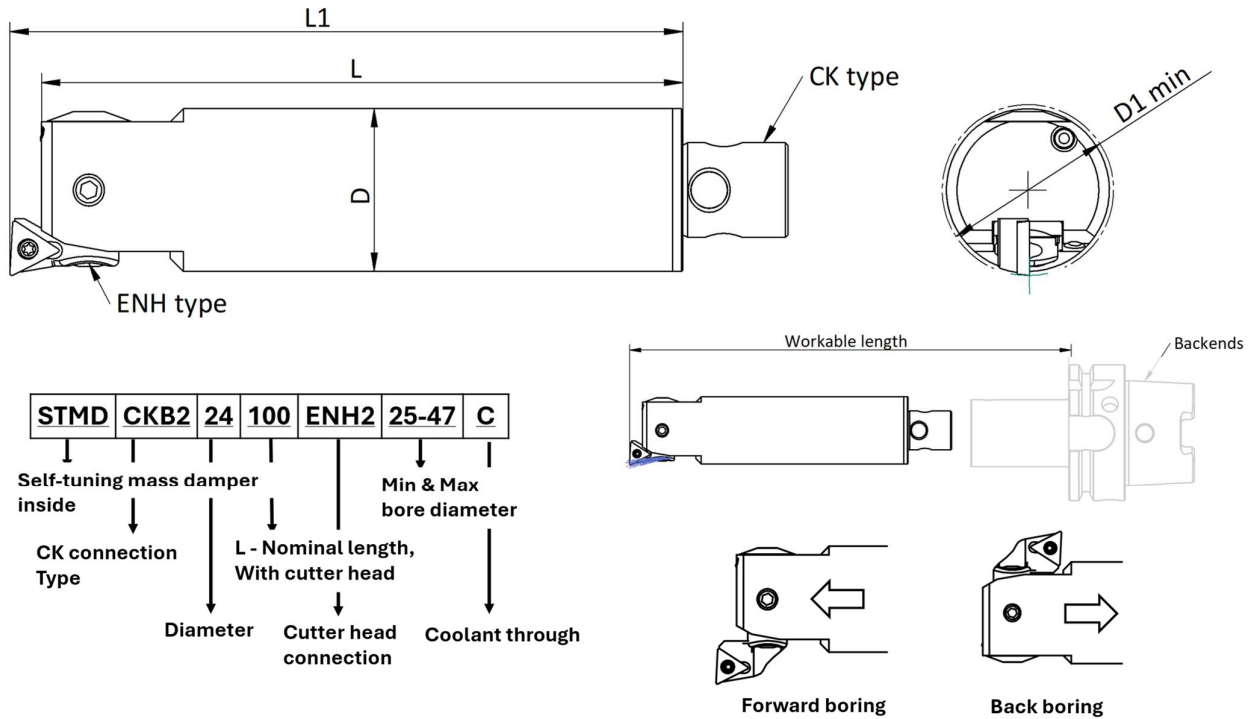
### Milling tool inserts



| Part Number | Insert code                              | W1 (mm) | LE (mm) | RE (mm) | D1 (mm) | S (mm) | P | M | K | H | S | N |
|-------------|------------------------------------------|---------|---------|---------|---------|--------|---|---|---|---|---|---|
| 310004      | XDMT 11T308 PM P15P (10 pcs/pack)        | 6.8     | 11      | 0.8     | 2.8     | 3.59   | ● | ● | ○ | ○ | ○ | ○ |
| 310005      | XDMT 11T308 PM P25P (10 pcs/pack)        | 6.8     | 11      | 0.8     | 2.8     | 3.59   | ● | ● | ○ | ○ | ○ | ○ |
| 310006      | XDMT 11T308 PL P10U Cermet (10 pcs/pack) | 6.8     | 11      | 0.8     | 2.8     | 3.59   | ● | ● | ● | ○ | ○ | ○ |
| 310009      | XDMT 11T308 AL N05U (10 pcs/pack)        | 6.8     | 11      | 0.8     | 2.8     | 3.59   | ○ | ○ | ○ | ○ | ○ | ● |

## Rotational boring

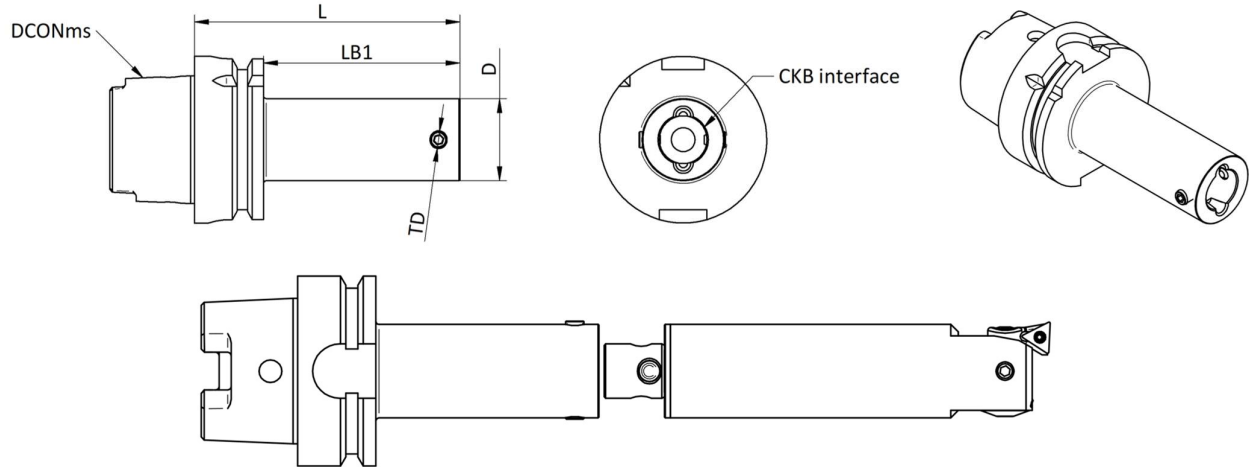
### Fine boring tools



| Fine boring tools with CK backends (1 scale = 0.01 mm or 0.0004 inch) |                                  |                      |        |             |        |     |             | Forward       |                  | Back Boring |                  |         |        |
|-----------------------------------------------------------------------|----------------------------------|----------------------|--------|-------------|--------|-----|-------------|---------------|------------------|-------------|------------------|---------|--------|
| Part number                                                           | Type                             | Workable length (mm) | D (mm) | D1 min (mm) | L (mm) | KG  | Part number | Insert holder | Diameter D1 (mm) | L1 (mm)     | Diameter D1 (mm) | L1 (mm) | Insert |
| 301274                                                                | STMD CKB1 19-080 ENH1 (20-36) C  | 80-140               | 19     | 20          | 80     | 0.2 | 301359      | ENH 1-1       | 20-26            | 83          | -                | -       | TP0802 |
|                                                                       |                                  |                      |        |             |        |     | 301360      | ENH 1-2       | 25-31            | 83          | -                | -       | TP0802 |
|                                                                       |                                  |                      |        |             |        |     | 301361      | ENH 1-3       | 30-36            | 83          | 30-36            | 61      | TP0802 |
| 301349                                                                | STMD CKB2 24-100 ENH2 (25-47) C  | 100-175              | 24     | 25          | 99     | 0.4 | 301362      | ENH 2-1       | 25-33            | 100.5       | -                | -       | TP0802 |
|                                                                       |                                  |                      |        |             |        |     | 301363      | ENH 2-2       | 32-40            | 100.5       | -                | -       | TP0802 |
|                                                                       |                                  |                      |        |             |        |     | 301364      | ENH 2-3       | 39-47            | 100.5       | 39-47            | 76.5    | TP0802 |
| 301350                                                                | STMD CKB3 31-128 ENH3 (32-60) C  | 128-224              | 31     | 32          | 128    | 0.9 | 301365      | ENH 3-1       | 32-47            | 122         | -                | -       | TP0802 |
|                                                                       |                                  |                      |        |             |        |     | 301366      | ENH 3-2       | 41-51            | 122         | -                | -       | TP0802 |
|                                                                       |                                  |                      |        |             |        |     | 301367      | ENH 3-3       | 50-60            | 122         | 50-60            | 98      | TP0802 |
| 301351                                                                | STMD CKB4 39-160 ENH4 (41-74) C  | 160-280              | 39     | 41          | 155    | 1.3 | 301368      | ENH 4-1       | 41-54            | 160         | -                | -       | TC1102 |
|                                                                       |                                  |                      |        |             |        |     | 301369      | ENH 4-2       | 50-63            | 160         | 53-63            | 127     | TC1102 |
|                                                                       |                                  |                      |        |             |        |     | 301370      | ENH 4-3       | 61-74            | 160         | 61-74            | 127     | TC1102 |
| 301352                                                                | STMD CKB5 50-200 ENH5 (53-95) C  | 200-350              | 50     | 53          | 196    | 3.5 | 301371      | ENH 5-1       | 53-70            | 200         | 62-70            | 162     | TC1102 |
|                                                                       |                                  |                      |        |             |        |     | 301372      | ENH 5-2       | 65-82            | 200         | 65-82            | 162     | TC1102 |
|                                                                       |                                  |                      |        |             |        |     | 301373      | ENH 5-3       | 78-95            | 200         | 78-95            | 162     | TC1102 |
| 301353                                                                | STMD CKB6 64-240 ENH6 (68-150) C | 240-448              | 64     | 68          | 235    | 6.1 | 301374      | ENH 6-1       | 68-100           | 240         | 80-100           | 191     | TC1102 |
|                                                                       |                                  |                      |        |             |        |     | 301375      | ENH 6-2       | 94-126           | 240         | 94-126           | 191     | TC1102 |
|                                                                       |                                  |                      |        |             |        |     | 301376      | ENH 6-3       | 118-150          | 240         | 118-150          | 191     | TC1102 |

Insert holders, type 1, type 2 and type 3 are included by default when delivering boring tools.

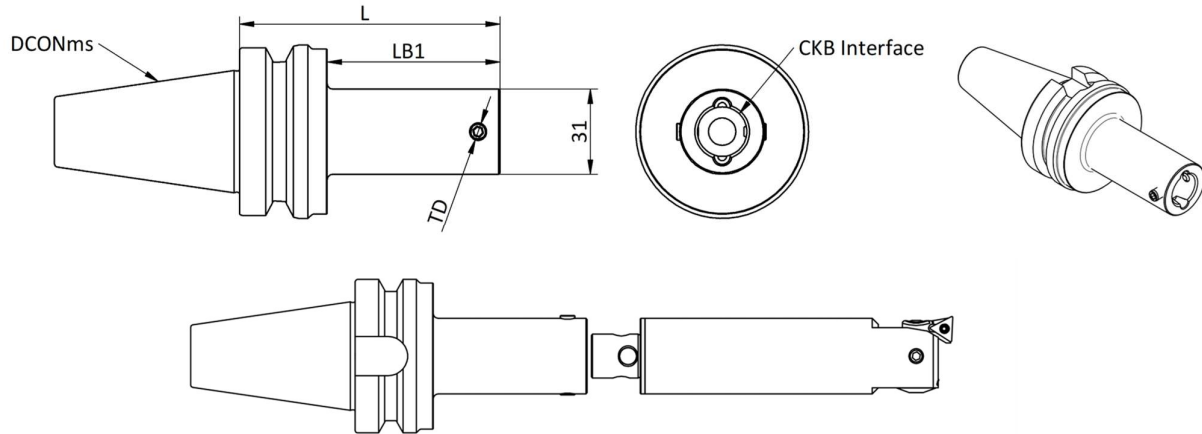
## Boring master shank - HSK



| Part number | Type               | DCON <sub>MS</sub> | CK   | D (mm) | L (mm) | LB1 | TD      | KG  | Stock |
|-------------|--------------------|--------------------|------|--------|--------|-----|---------|-----|-------|
| 301437      | HSK63A CKB1 - 075L | HSK63A             | CKB1 | 19     | 75     | 46  | M4x0.5  | 0.9 | ●     |
| 301438      | HSK63A CKB2 - 090L | HSK63A             | CKB2 | 24     | 90     | 61  | M5x0.5  | 1.0 | ●     |
| 301439      | HSK63A CKB3 - 100L | HSK63A             | CKB3 | 31     | 100    | 71  | M6x0.75 | 1.1 | ●     |
| 301440      | HSK63A CKB4 - 090L | HSK63A             | CKB4 | 39     | 90     | 61  | M8x0.75 | 1.2 | ●     |
| 301441      | HSK63A CKB4 - 130L | HSK63A             | CKB4 | 39     | 130    | 101 | M8x0.75 | 1.5 | ○     |
| 301442      | HSK63A CKB5 - 080L | HSK63A             | CKB5 | 50     | 80     | 51  | M10x1.0 | 1.3 | ●     |
| 301443      | HSK63A CKB5 - 135L | HSK63A             | CKB5 | 50     | 135    | 106 | M10x1.0 | 1.8 | ○     |
| 301444      | HSK63A CKB6 - 080L | HSK63A             | CKB6 | 63     | 80     | 51  | M12x1.0 | 1.5 | ●     |
| 301445      | HSK63A CKB6 - 115L | HSK63A             | CKB6 | 63     | 115    | 86  | M12x1.0 | 2.3 | ○     |
| 301446      | HSK63A CKB6 - 150L | HSK63A             | CKB6 | 63     | 150    | 121 | M12x1.0 | 3.1 | ○     |
| 301447      | HSK63A CKB6 - 180L | HSK63A             | CKB6 | 63     | 180    | 151 | M12x1.0 | 3.9 | ○     |

|   |                                                       |
|---|-------------------------------------------------------|
| ● | Stock item, on shelf for immediate shipping           |
| ○ | Non-stock item, on demand, and 3 weeks' delivery time |

## Boring master shank -BT / SK / CAT

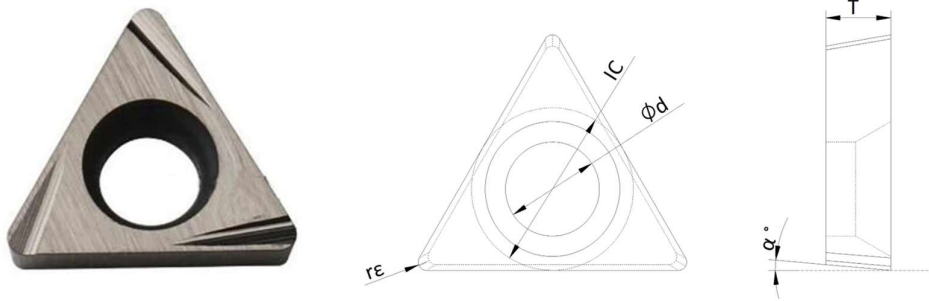


| Part number | Type              | DCON <sub>MS</sub> | CK   | D (mm) | L (mm) | LB1   | TD      | KG  | Stock |
|-------------|-------------------|--------------------|------|--------|--------|-------|---------|-----|-------|
| 301448      | BT40 CKB1 - 070L  | BT40               | CKB1 | 19     | 70     | 43    | M4x0.5  | 1.1 | ●     |
| 301449      | BT40 CKB2 - 075L  | BT40               | CKB2 | 24     | 75     | 48    | M5x0.5  | 1.2 | ●     |
| 301450      | BT40 CKB3 - 080L  | BT40               | CKB3 | 31     | 80     | 53    | M6x0.75 | 1.3 | ●     |
| 301451      | BT40 CKB4 - 070L  | BT40               | CKB4 | 39     | 70     | 43    | M8x0.75 | 1.5 | ●     |
| 301452      | BT40 CKB4 - 100L  | BT40               | CKB4 | 39     | 100    | 73    | M8x0.75 | 1.9 | ○     |
| 301453      | BT40 CKB5 - 060L  | BT40               | CKB5 | 50     | 60     | 33    | M10x1.0 | 1.6 | ●     |
| 301454      | BT40 CKB5 - 100L  | BT40               | CKB5 | 50     | 100    | 73    | M10x1.0 | 2.3 | ○     |
| 301455      | BT40 CKB6 - 060L  | BT40               | CKB6 | 63     | 60     | 33    | M12x1.0 | 1.6 | ●     |
| 301456      | BT40 CKB6 - 100L  | BT40               | CKB6 | 63     | 115    | 88    | M12x1.0 | 2.6 | ○     |
| 301457      | BT40 CKB6 - 150L  | BT40               | CKB6 | 63     | 165    | 138   | M12x1.0 | 3.6 | ○     |
| 301458      | BT40 CKB6 - 180L  | BT40               | CKB6 | 63     | 205    | 178   | M12x1.0 | 4.6 | ○     |
|             |                   |                    |      |        |        |       |         |     |       |
| 301459      | SK40 CKB1 - 075L  | SK40               | CKB1 | 19     | 75     | 55,9  | M4x0.5  | 1.1 | ●     |
| 301460      | SK40 CKB2 - 085L  | SK40               | CKB2 | 24     | 85     | 65,9  | M5x0.5  | 1.2 | ●     |
| 301461      | SK40 CKB3 - 095L  | SK40               | CKB3 | 31     | 95     | 75,9  | M6x0.75 | 1.3 | ●     |
| 301462      | SK40 CKB4 - 085L  | SK40               | CKB4 | 39     | 85     | 65,9  | M8x0.75 | 1.5 | ●     |
| 301463      | SK40 CKB4 - 130L  | SK40               | CKB4 | 39     | 130    | 110,9 | M8x0.75 | 1.9 | ○     |
| 301464      | SK40 CKB5 - 075L  | SK40               | CKB5 | 50     | 75     | 55,9  | M10x1.0 | 1.6 | ●     |
| 301465      | SK40 CKB5 - 125L  | SK40               | CKB5 | 50     | 125    | 105,9 | M10x1.0 | 2.3 | ○     |
| 301466      | SK40 CKB6 - 065L  | SK40               | CKB6 | 63     | 65     | 45,9  | M12x1.0 | 1.6 | ●     |
| 301467      | SK40 CKB6 - 115L  | SK40               | CKB6 | 63     | 115    | 95,9  | M12x1.0 | 2.6 | ○     |
| 301468      | SK40 CKB6 - 165L  | SK40               | CKB6 | 63     | 165    | 145,9 | M12x1.0 | 3.6 | ○     |
| 301469      | SK40 CKB6 - 205L  | SK40               | CKB6 | 63     | 205    | 185,9 | M12x1.0 | 4.6 | ○     |
|             |                   |                    |      |        |        |       |         |     |       |
| 301470      | CAT40 CKB1 - 075L | CAT40              | CKB1 | 19     | 75     | 59,1  | M4x0.5  | 1.1 | ●     |
| 301471      | CAT40 CKB2 - 085L | CAT40              | CKB2 | 24     | 85     | 69,1  | M5x0.5  | 1.2 | ●     |
| 301472      | CAT40 CKB3 - 095L | CAT40              | CKB3 | 31     | 95     | 79,1  | M6x0.75 | 1.3 | ●     |
| 301473      | CAT40 CKB4 - 085L | CAT40              | CKB4 | 39     | 85     | 69,1  | M8x0.75 | 1.5 | ●     |
| 301474      | CAT40 CKB4 - 130L | CAT40              | CKB4 | 39     | 130    | 114,1 | M8x0.75 | 1.9 | ○     |
| 301475      | CAT40 CKB5 - 075L | CAT40              | CKB5 | 50     | 75     | 59,1  | M10x1.0 | 1.6 | ●     |
| 301476      | CAT40 CKB5 - 125L | CAT40              | CKB5 | 50     | 125    | 109,1 | M10x1.0 | 2.3 | ○     |
| 301477      | CAT40 CKB6 - 065L | CAT40              | CKB6 | 63     | 65     | 49,1  | M12x1.0 | 1.6 | ●     |
| 301478      | CAT40 CKB6 - 115L | CAT40              | CKB6 | 63     | 115    | 99,1  | M12x1.0 | 2.6 | ○     |
| 301479      | CAT40 CKB6 - 165L | CAT40              | CKB6 | 63     | 165    | 149,1 | M12x1.0 | 3.6 | ○     |
| 301480      | CAT40 CKB6 - 205L | CAT40              | CKB6 | 63     | 205    | 189,1 | M12x1.0 | 4.6 | ○     |

|   |                                                         |
|---|---------------------------------------------------------|
| ● | Stock item, on shelf for immediate shipping             |
| ○ | Non-stock item, on demand, and 3 weeks' s delivery time |



## Fine boring inserts:

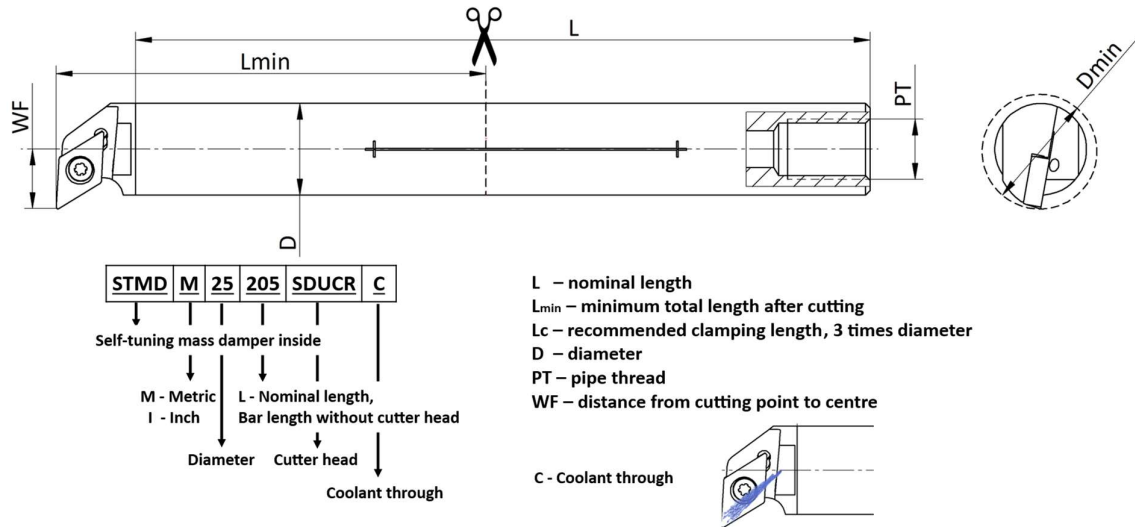


| Part Number | Insert Type                             | IC   | d   | T    | rE  | $\alpha$ | P | M | K | N | Stock |
|-------------|-----------------------------------------|------|-----|------|-----|----------|---|---|---|---|-------|
| 301489      | TPGH 080202 L - FF P05U Cermet, 10 pcs  | 4.76 | 2.3 | 2.38 | 0.2 | 11       | ● | ● | ● | - | ●     |
| 301490      | TPGH 080204 L - FF P05U Cermet, 10 pcs  | 4.76 | 2.3 | 2.38 | 0.4 | 11       | ● | ● | ● | - | ●     |
| 301491      | TPGH 080202 L - FF P10C Carbide, 10 pcs | 4.76 | 2.3 | 2.38 | 0.2 | 11       | ● | ○ | ● | - | ●     |
| 301492      | TPGH 080204 L - FF P10C Carbide, 10 pcs | 4.76 | 2.3 | 2.38 | 0.4 | 11       | ● | ○ | ● | - | ●     |
| 301493      | TPGH 080202 L - FF N10U Carbide, 10 pcs | 4.76 | 2.3 | 2.38 | 0.2 | 11       | - | - | - | ● | ●     |
| 301494      | TPGH 080204 L - FF N10U Carbide, 10 pcs | 4.76 | 2.3 | 2.38 | 0.4 | 11       | - | - | - | ● | ●     |
| 301495      | TPGH 080202 N01 PCD, 1 pcs              | 4.76 | 2.3 | 2.38 | 0.2 | 11       | - | - | - | ● | ●     |
| 301496      | TPGH 080204 N01 PCD, 1 pcs              | 4.76 | 2.3 | 2.38 | 0.4 | 11       | - | - | - | ● | ●     |
| 301497      | TPGH 110204 L - FF P05U Cermet, 10 pcs  | 6.35 | 3.4 | 2.38 | 0.4 | 11       | ● | ● | ● | - | ●     |
| 301498      | TPGH 110204 L - FF P10C Carbide, 10 pcs | 6.35 | 3.4 | 2.38 | 0.4 | 11       | ● | ○ | ● | - | ●     |
| 301499      | TPGH 110204 L - FF N10U Carbide, 10 pcs | 6.35 | 3.4 | 2.38 | 0.4 | 11       | - | - | - | ● | ●     |
| 301500      | TCGT 110204 N01 PCD, 1 pcs              | 6.35 | 3.4 | 2.38 | 0.4 | 11       | - | - | - | ● | ●     |

|   |                                                         |
|---|---------------------------------------------------------|
| ● | Stock item, on shelf for immediate shipping             |
| ○ | Non-stock item, on demand, and 3 weeks' s delivery time |

## Turning 3-6xD

### Straight holder (3-6xD) with fixed cutter heads (Metric)



| Standard: Metric (with fixed head SDUCR for DCMT insert) |                           |                       |                                   |                       |                     |         |          |          |               |              |     |     |  |
|----------------------------------------------------------|---------------------------|-----------------------|-----------------------------------|-----------------------|---------------------|---------|----------|----------|---------------|--------------|-----|-----|--|
| Part number                                              | Type                      | D <sub>min</sub> (mm) | Workable length <sup>b</sup> (mm) | L <sub>min</sub> (mm) | L <sub>c</sub> (mm) | WF (mm) | LAMS (°) | GAMO (°) | Master insert | Insert screw | PT  | Kg  |  |
| 300205                                                   | STMD M12-108 SDUCR C      | 16                    | 36-72                             | 72                    | 36                  | 9       | -6       | 0        | DCMT 070204   | IS M2.5x6.0  | G ½ | 0.1 |  |
| 300176                                                   | STMD M16-138 SDUCR C 0702 | 20                    | 48-96                             | 96                    | 48                  | 11      | -8       | 0        | DCMT 070204   | IS M2.5x6.0  | G ½ | 0.2 |  |
| 301431                                                   | STMD M16-138 SDUCR C 11T3 | 25                    | 48-96                             | 96                    | 48                  | 14      | -8       | 0        | DCMT 11T304   | IS M3.5x10.0 | G ¾ | 0.2 |  |
| 300177                                                   | STMD M20-160 SDUCR C      | 25                    | 60-120                            | 120                   | 60                  | 13      | -10      | 0        | DCMT 11T304   | IS M3.5x10.0 | G ¾ | 0.4 |  |
| 300110                                                   | STMD M25-205 SDUCR C      | 32                    | 75-150                            | 155                   | 75                  | 17      | -10      | 0        | DCMT 11T304   | IS M3.5x10.0 | G ¾ | 0.6 |  |
| 300178                                                   | STMD M32-256 SDUCR C      | 40                    | 96-192                            | 192                   | 96                  | 22      | -10      | 0        | DCMT 11T304   | IS M3.5x10.0 | G ¾ | 1.2 |  |
| 300179                                                   | STMD M40-320 SDUCR C      | 50                    | 120-240                           | 240                   | 120                 | 27      | -10      | 0        | DCMT 11T304   | IS M3.5x10.0 | G ¾ | 2.4 |  |

| Standard: Metric (with fixed head SCLCR for CCMT insert) |                      |                       |                                   |                       |                     |         |          |          |               |              |     |     |  |
|----------------------------------------------------------|----------------------|-----------------------|-----------------------------------|-----------------------|---------------------|---------|----------|----------|---------------|--------------|-----|-----|--|
| Part number                                              | Type                 | D <sub>min</sub> (mm) | Workable length <sup>b</sup> (mm) | L <sub>min</sub> (mm) | L <sub>c</sub> (mm) | WF (mm) | LAMS (°) | GAMO (°) | Master insert | Insert screw | PT  | Kg  |  |
| 300206                                                   | STMD M12-108 SCLCR C | 16                    | 36-72                             | 72                    | 36                  | 8,5     | -6       | 0        | CCMT 060204   | IS M2.5x6.0  | G ½ | 0.1 |  |
| 300186                                                   | STMD M16-138 SCLCR C | 20                    | 48-96                             | 96                    | 48                  | 11      | -6       | 0        | CCMT 060204   | IS M2.5x6.0  | G ½ | 0.2 |  |
| 300188                                                   | STMD M20-160 SCLCR C | 25                    | 60-120                            | 120                   | 60                  | 13      | -10      | 0        | CCMT 09T304   | IS M3.5x10.0 | G ¾ | 0.4 |  |
| 300184                                                   | STMD M25-205 SCLCR C | 32                    | 75-150                            | 155                   | 75                  | 17      | -10      | 0        | CCMT 09T304   | IS M3.5x10.0 | G ¾ | 0.6 |  |
| 300183                                                   | STMD M32-256 SCLCR C | 40                    | 96-192                            | 192                   | 96                  | 22      | -8       | 0        | CCMT 09T304   | IS M3.5x10.0 | G ¾ | 1.2 |  |
| 300181                                                   | STMD M40-320 SCLCR C | 50                    | 120-240                           | 240                   | 120                 | 27      | -10      | 0        | CCMT 09T304   | IS M3.5x10.0 | G ¾ | 2.4 |  |

| Standard: Metric (with fixed head STFCR for TCMT insert) |                           |                       |                                   |                       |                     |         |          |          |               |              |     |     |  |
|----------------------------------------------------------|---------------------------|-----------------------|-----------------------------------|-----------------------|---------------------|---------|----------|----------|---------------|--------------|-----|-----|--|
| Part number                                              | Type                      | D <sub>min</sub> (mm) | Workable length <sup>b</sup> (mm) | L <sub>min</sub> (mm) | L <sub>c</sub> (mm) | WF (mm) | LAMS (°) | GAMO (°) | Master insert | Insert screw | PT  | Kg  |  |
| 300207                                                   | STMD M12-108 STFCR C 0902 | 16                    | 36-72                             | 72                    | 36                  | 9       | -6       | 0        | TCMT 090204   | IS M2.2x5.0  | G ½ | 0.1 |  |
| 300587                                                   | STMD M12-108 STFCR C 1102 | 16                    | 36-72                             | 72                    | 36                  | 9       | -6       | 0        | TCMT 110204   | IS M2.5x6.0  | G ½ | 0.1 |  |
| 300187                                                   | STMD M16-138 STFCR C 0902 | 20                    | 48-96                             | 96                    | 48                  | 11      | -6       | 0        | TCMT 090204   | IS M2.2x5.0  | G ½ | 0.2 |  |
| 300588                                                   | STMD M16-138 STFCR C 1102 | 20                    | 48-96                             | 96                    | 48                  | 11      | -6       | 0        | TCMT 110204   | IS M2.5x6.0  | G ½ | 0.2 |  |
| 300589                                                   | STMD M20-160 STFCR C 1102 | 25                    | 60-120                            | 120                   | 60                  | 13      | -6       | 0        | TCMT 110204   | IS M2.5x8.0  | G ¾ | 0.4 |  |
| 300189                                                   | STMD M20-160 STFCR C 1103 | 25                    | 60-120                            | 120                   | 60                  | 13      | -4       | 0        | TCMT 110304   | IS M2.5x8.0  | G ¾ | 0.4 |  |
| 300590                                                   | STMD M25-205 STFCR C 1102 | 32                    | 75-150                            | 155                   | 75                  | 17      | -4       | 0        | TCMT 110204   | IS M2.5x8.0  | G ¾ | 0.6 |  |
| 300185                                                   | STMD M25-205 STFCR C 1103 | 32                    | 75-150                            | 155                   | 75                  | 17      | -4       | 0        | TCMT 110304   | IS M2.5x8.0  | G ¾ | 0.6 |  |
| 300180                                                   | STMD M32-256 STFCR C 16T3 | 40                    | 96-192                            | 192                   | 96                  | 22      | -6       | 0        | TCMT 16T304   | IS M3.5x10.0 | G ¾ | 1.2 |  |
| 300182                                                   | STMD M40-320 STFCR C 16T3 | 50                    | 120-240                           | 240                   | 120                 | 27      | -6       | 0        | TCMT 16T304   | IS M3.5x10.0 | G ¾ | 2.4 |  |

|                                                    |
|----------------------------------------------------|
| b – measured from the cutting edge to the clamping |
|----------------------------------------------------|

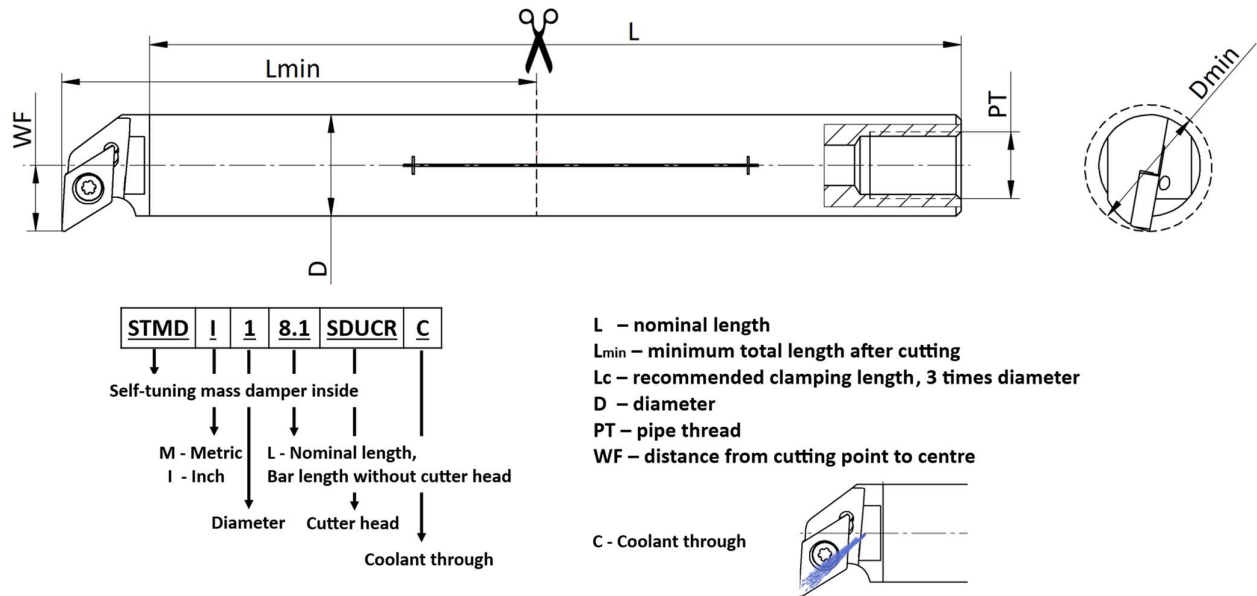
| Standard: Metric (with fixed head SDUCL for DCMT insert) |                           |           |                                   |           |         |         |          |          |               |              |     |                                                                                     |
|----------------------------------------------------------|---------------------------|-----------|-----------------------------------|-----------|---------|---------|----------|----------|---------------|--------------|-----|-------------------------------------------------------------------------------------|
| Part number                                              | Type                      | Dmin (mm) | Workable length <sup>b</sup> (mm) | Lmin (mm) | Lc (mm) | WF (mm) | LAMS (°) | GAMO (°) | Master insert | Insert screw | PT  |  |
| 300405                                                   | STMD M12-108 SDUCL C      | 16        | 36-72                             | 72        | 36      | 9       | -6       | 0        | DCMT 070204   | IS M2.5x6.0  | G ½ | 0.1                                                                                 |
| 300406                                                   | STMD M16-138 SDUCL C 0702 | 20        | 48-96                             | 96        | 48      | 11      | -8       | 0        | DCMT 070204   | IS M2.5x6.0  | G ¾ | 0.2                                                                                 |
| 300407                                                   | STMD M20-160 SDUCL C      | 25        | 60-120                            | 120       | 60      | 13      | -10      | 0        | DCMT 11T304   | IS M3.5x10.0 | G ¾ | 0.4                                                                                 |
| 300408                                                   | STMD M25-205 SDUCL C      | 32        | 75-150                            | 155       | 75      | 17      | -10      | 0        | DCMT 11T304   | IS M3.5x10.0 | G ¾ | 0.6                                                                                 |
| 300409                                                   | STMD M32-256 SDUCL C      | 40        | 96-192                            | 192       | 96      | 22      | -10      | 0        | DCMT 11T304   | IS M3.5x10.0 | G ¾ | 1.2                                                                                 |
| 300410                                                   | STMD M40-320 SDUCL C      | 50        | 120-240                           | 240       | 120     | 27      | -10      | 0        | DCMT 11T304   | IS M3.5x10.0 | G ¾ | 2.4                                                                                 |

| Standard: Metric (with fixed head SCLCL for CCMT insert) |                      |    |         |     |     |     |     |   |             |              |     |     |
|----------------------------------------------------------|----------------------|----|---------|-----|-----|-----|-----|---|-------------|--------------|-----|-----|
| 300411                                                   | STMD M12-108 SCLCL C | 16 | 36-72   | 72  | 36  | 8,5 | -6  | 0 | CCMT 060204 | IS M2.5x6.0  | G ½ | 0.1 |
| 300412                                                   | STMD M16-138 SCLCL C | 20 | 48-96   | 96  | 48  | 11  | -8  | 0 | CCMT 060204 | IS M2.5x6.0  | G ¾ | 0.2 |
| 300413                                                   | STMD M20-160 SCLCL C | 25 | 60-120  | 120 | 60  | 13  | -10 | 0 | CCMT 09T304 | IS M3.5x10.0 | G ¾ | 0.4 |
| 300414                                                   | STMD M25-205 SCLCL C | 32 | 75-150  | 155 | 75  | 17  | -10 | 0 | CCMT 09T304 | IS M3.5x10.0 | G ¾ | 0.6 |
| 300415                                                   | STMD M32-256 SCLCL C | 40 | 96-192  | 192 | 96  | 22  | -10 | 0 | CCMT 09T304 | IS M3.5x10.0 | G ¾ | 1.2 |
| 300416                                                   | STMD M40-320 SCLCL C | 50 | 120-240 | 240 | 120 | 27  | -10 | 0 | CCMT 09T304 | IS M3.5x10.0 | G ¾ | 2.4 |

| Standard: Metric (with fixed head STFCL for TCMT insert) |                           |    |         |     |     |    |    |   |             |              |     |     |
|----------------------------------------------------------|---------------------------|----|---------|-----|-----|----|----|---|-------------|--------------|-----|-----|
| 300591                                                   | STMD M12-108 STFCL C 1102 | 16 | 36-72   | 72  | 36  | 9  | -6 | 0 | TCMT 110204 | IS M2.5x6.0  | G ½ | 0.1 |
| 300592                                                   | STMD M16-138 STFCL C 1102 | 20 | 48-96   | 96  | 48  | 11 | -6 | 0 | TCMT 110204 | IS M2.5x6.0  | G ¾ | 0.2 |
| 300593                                                   | STMD M20-160 STFCL C 1102 | 25 | 60-120  | 120 | 60  | 13 | -4 | 0 | TCMT 110204 | IS M2.5x8.0  | G ¾ | 0.4 |
| 300594                                                   | STMD M25-205 STFCL C 1102 | 32 | 75-150  | 155 | 75  | 17 | -4 | 0 | TCMT 110204 | IS M2.5x8.0  | G ¾ | 0.6 |
| 300595                                                   | STMD M32-256 STFCL C 16T3 | 40 | 96-192  | 192 | 96  | 22 | -6 | 0 | TCMT 16T304 | IS M3.5x10.0 | G ¾ | 1.2 |
| 300596                                                   | STMD M40-320 STFCL C 16T3 | 50 | 120-240 | 240 | 120 | 27 | -6 | 0 | TCMT 16T304 | IS M3.5x10.0 | G ¾ | 2.4 |

|  |                                                    |  |  |  |  |  |  |  |  |  |  |  |
|--|----------------------------------------------------|--|--|--|--|--|--|--|--|--|--|--|
|  | b – measured from the cutting edge to the clamping |  |  |  |  |  |  |  |  |  |  |  |
|--|----------------------------------------------------|--|--|--|--|--|--|--|--|--|--|--|

## Straight holder (3-6xD) with fixed cutter heads (Inch)



| Standard: Inch (with fixed head SDUCR for DCMT insert) |                               |             |                                     |             |           |           |          |          |               |              |     |     |  |
|--------------------------------------------------------|-------------------------------|-------------|-------------------------------------|-------------|-----------|-----------|----------|----------|---------------|--------------|-----|-----|--|
| Part number                                            | Art. Nr                       | Dmin (inch) | Workable length <sup>b</sup> (inch) | Lmin (inch) | Lc (inch) | WF (inch) | LAMS (°) | GAMO (°) | Master insert | Insert screw | PT  | KO  |  |
| 300211                                                 | STMD I ½ -4.3 SDUCR C         | 0.63        | 1.500-3.000                         | 2.8         | 1.4       | 0.35      | -6       | 0        | DCMT 070204   | IS M2.5x6.0  | G ½ | 0.1 |  |
| 300212                                                 | STMD I 5/8 – 5.4 SDUCR C 0702 | 0.78        | 1.875-3.750                         | 3.8         | 1.9       | 0.43      | -8       | 0        | DCMT 070204   | IS M2.5x6.0  | G ¼ | 0.2 |  |
| 301432                                                 | STMD I 5/8 – 5.4 SDUCR C 11T3 | 0.78        | 1.875-3.750                         | 3.8         | 1.9       | 0.43      | -8       | 0        | DCMT 11T304   | IS M3.5x10.0 | G ¼ | 0.2 |  |
| 300213                                                 | STMD I ¾ - 6.3 SDUCR C        | 0.98        | 2.250-4.500                         | 4.7         | 2.4       | 0.51      | -10      | 0        | DCMT 11T304   | IS M3.5x10.0 | G ¼ | 0.4 |  |
| 300214                                                 | STMD I 1-8.1 SDUCR C          | 1.26        | 3.000-6.000                         | 6.1         | 2.9       | 0.67      | -10      | 0        | DCMT 11T304   | IS M3.5x10.0 | G ¼ | 0.6 |  |
| 300215                                                 | STMD I 1 ¼ -10.1 SDUCR C      | 1.57        | 3.750-7.500                         | 7.6         | 3.8       | 0.86      | -10      | 0        | DCMT 11T304   | IS M3.5x10.0 | G ½ | 1.2 |  |
| 300216                                                 | STMD I 1 ½-12.6 SDUCR C       | 1.96        | 4.500-9.000                         | 9.4         | 4.7       | 1.06      | -10      | 0        | DCMT 11T304   | IS M3.5x10.0 | G ½ | 2.4 |  |

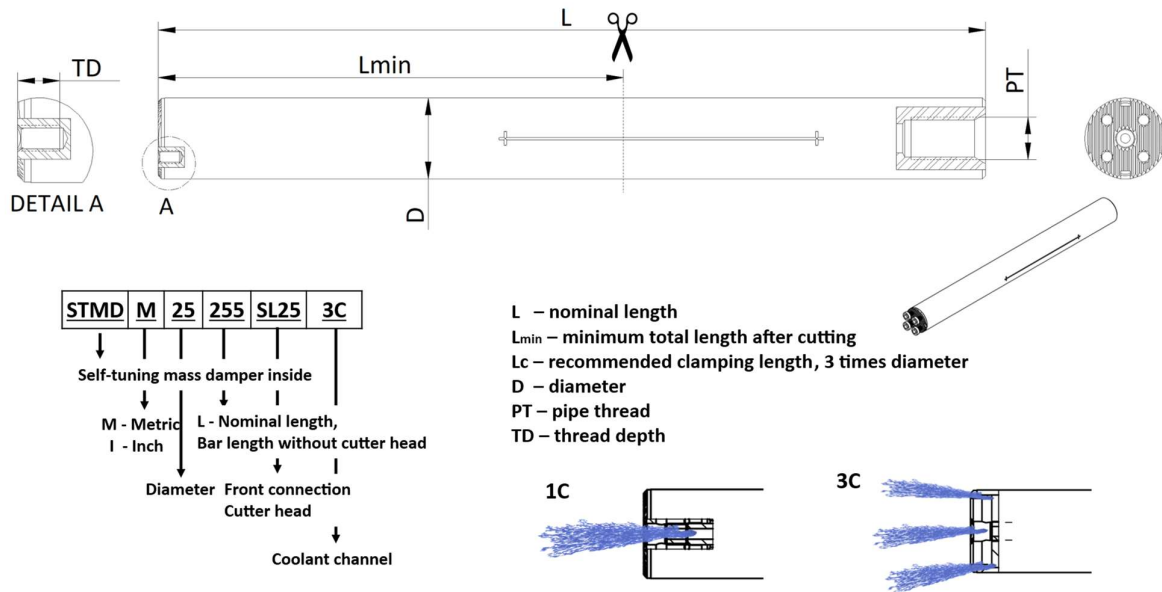
| Standard: Inch (with fixed head SCLCR for CCMT insert) |                          |             |                                     |             |           |           |          |          |               |              |     |     |  |
|--------------------------------------------------------|--------------------------|-------------|-------------------------------------|-------------|-----------|-----------|----------|----------|---------------|--------------|-----|-----|--|
| Part number                                            | Art. Nr                  | Dmin (inch) | Workable length <sup>b</sup> (inch) | Lmin (inch) | Lc (inch) | WF (inch) | LAMS (°) | GAMO (°) | Master insert | Insert screw | PT  | KO  |  |
| 300217                                                 | STMD I ½ -4.3 SCLCR C    | 0.63        | 1.500-3.000                         | 2.8         | 1.4       | 0.33      | -6       | 0        | CCMT 060204   | IS M2.5x6.0  | G ½ | 0.1 |  |
| 300218                                                 | STMD I 5/8 – 5.4 SCLCR C | 0.78        | 1.875-3.750                         | 3.8         | 1.9       | 0.43      | -6       | 0        | CCMT 060204   | IS M2.5x6.0  | G ¼ | 0.2 |  |
| 300219                                                 | STMD I ¾ - 6.3 SCLCR C   | 0.98        | 2.250-4.500                         | 4.7         | 2.4       | 0.51      | -10      | 0        | CCMT 09T304   | IS M3.5x10.0 | G ¼ | 0.4 |  |
| 300220                                                 | STMD I 1-8.1 SCLCR C     | 1.26        | 3.000-6.000                         | 6.1         | 2.9       | 0.67      | -10      | 0        | CCMT 09T304   | IS M3.5x10.0 | G ¼ | 0.6 |  |
| 300221                                                 | STMD I 1 ¼ -10.1 SCLCR C | 1.57        | 3.750-7.500                         | 7.6         | 3.8       | 0.86      | -8       | 0        | CCMT 09T304   | IS M3.5x10.0 | G ½ | 1.2 |  |
| 300222                                                 | STMD I 1 ½-12.6 SCLCR C  | 1.96        | 4.500-9.000                         | 9.4         | 4.7       | 1.06      | -10      | 0        | CCMT 09T304   | IS M3.5x10.0 | G ½ | 2.4 |  |

| Standard: Inch (with fixed head STFCR for TCMT insert) |                          |             |                                     |             |           |           |          |          |               |              |     |     |  |
|--------------------------------------------------------|--------------------------|-------------|-------------------------------------|-------------|-----------|-----------|----------|----------|---------------|--------------|-----|-----|--|
| Part number                                            | Art. Nr                  | Dmin (inch) | Workable length <sup>b</sup> (inch) | Lmin (inch) | Lc (inch) | WF (inch) | LAMS (°) | GAMO (°) | Master insert | Insert screw | PT  | KO  |  |
| 300223                                                 | STMD I ½ -4.3 STFCR C    | 0.63        | 1.500-3.000                         | 2.8         | 1.4       | 0.35      | -6       | 0        | TCMT 090204   | IS M2.2x5.0  | G ½ | 0.1 |  |
| 300224                                                 | STMD I 5/8 – 5.4 STFCR C | 0.78        | 1.875-3.750                         | 3.8         | 1.9       | 0.43      | -6       | 0        | TCMT 090204   | IS M2.2x5.0  | G ¼ | 0.2 |  |
| 300225                                                 | STMD I ¾ - 6.3 STFCR C   | 0.98        | 2.250-4.500                         | 4.7         | 2.4       | 0.51      | -4       | 0        | TCMT 110304   | IS M2.5x8.0  | G ¼ | 0.4 |  |
| 300226                                                 | STMD I 1-8.1 STFCR C     | 1.26        | 3.000-6.000                         | 6.1         | 2.9       | 0.67      | -4       | 0        | TCMT 110304   | IS M2.5x8.0  | G ¼ | 0.6 |  |
| 300227                                                 | STMD I 1 ¼ -10.1 STFCR C | 1.57        | 3.750-7.500                         | 7.6         | 3.8       | 0.86      | -6       | 0        | TCMT 16T304   | IS M3.5x10.0 | G ½ | 1.2 |  |
| 300228                                                 | STMD I 1 ½-12.6 STFCR C  | 1.96        | 4.500-9.000                         | 9.4         | 4.7       | 1.06      | -6       | 0        | TCMT 16T304   | IS M3.5x10.0 | G ½ | 2.4 |  |

|                                                    |  |  |  |  |  |  |  |  |  |  |  |  |  |
|----------------------------------------------------|--|--|--|--|--|--|--|--|--|--|--|--|--|
| b – measured from the cutting edge to the clamping |  |  |  |  |  |  |  |  |  |  |  |  |  |
|----------------------------------------------------|--|--|--|--|--|--|--|--|--|--|--|--|--|

## Turning 6-9xD

Straight holder (6-9xD) with SL (Serration Lock) interface (Metric)



| Standard: Metric (with SL interface and exchangeable heads) |                                      |                                   |                         |           |         |            |         |       |                  |      |
|-------------------------------------------------------------|--------------------------------------|-----------------------------------|-------------------------|-----------|---------|------------|---------|-------|------------------|------|
| Part number                                                 | Type                                 | Workable length <sup>b</sup> (mm) | D min (mm) <sup>g</sup> | Lmin (mm) | Lc (mm) | Screws     | TD (mm) | PT    | Material         | KG   |
| 300001                                                      | STMD M12-144 SL12 3C                 | 72-96                             | 16                      | 144       | 36      | M2X8 or 14 | 5.5     | G ½   | S+C <sup>d</sup> | 0.18 |
| 300004                                                      | STMD M16-170 SL16 3C                 | 96-128                            | 20                      | 117       | 48      | M3X8       | 5.5     | G ¾   | Steel            | 0.25 |
| 300005                                                      | STMD M20-200 SL20 3C                 | 120-160                           | 25                      | 137       | 60      | M3X8       | 5.5     | G ¾   | Steel            | 0.50 |
| 300006                                                      | STMD M25-255 SL25 3C                 | 150-200                           | 32                      | 180       | 75      | M4X9       | 6.5     | G ¾   | Steel            | 1.10 |
| 300008                                                      | STMD M32-320 SL32 3C                 | 192-256                           | 40                      | 213       | 96      | M5X12      | 10      | G ½   | Steel            | 2.10 |
| 300010                                                      | STMD M40-408 SL40 1C <sup>e</sup>    | 240-320                           | 50                      | 260       | 120     | M6X14      | 10      | G ½   | Steel            | 3.9  |
| 300240                                                      | STMD M40-408 SL40 3C                 | 240-320                           | 50                      | 260       | 120     | M6X14      | 10      | G ½   | Steel            | 3.9  |
| 300012                                                      | STMD M50-518 SL40 1C                 | 300-400                           | 60                      | 324       | 150     | M6X14      | 10      | G ¾   | Steel            | 8.0  |
| 300013                                                      | STMD M50-518 SL50 1C <sup>e</sup>    | 300-400                           | NA                      | 322       | 150     | M8X14      | 12      | G ¾   | Steel            | 8.0  |
| 300015                                                      | STMD M60-628 SL40 1C                 | 360-480                           | 70                      | 424       | 180     | M6X14      | 10      | G ¾   | Steel            | 13.6 |
| 300016                                                      | STMD M60-628 SL60 1C <sup>e</sup>    | 360-480                           | NA                      | 422       | 180     | M8X14      | 12      | G ¾   | Steel            | 13.6 |
| 300585                                                      | STMD M80-880 SL40 1C <sup>e</sup>    | 480-640                           | 90                      | 546       | 240     | M6X14      | 10      | G 1 ¼ | Steel            | 33.0 |
| 300174                                                      | STMD M100-1100 SL80 C <sup>e</sup> L | 600-800                           | 120                     | 600       | 300     | M10X20     | 14      | G 1   | Steel            | 63.0 |
| 301547                                                      | STMD M100-1100 SL80 C <sup>e</sup> R | 600-800                           | 120                     | 600       | 300     | M10X20     | 14      | G 1   | Steel            | 63.0 |

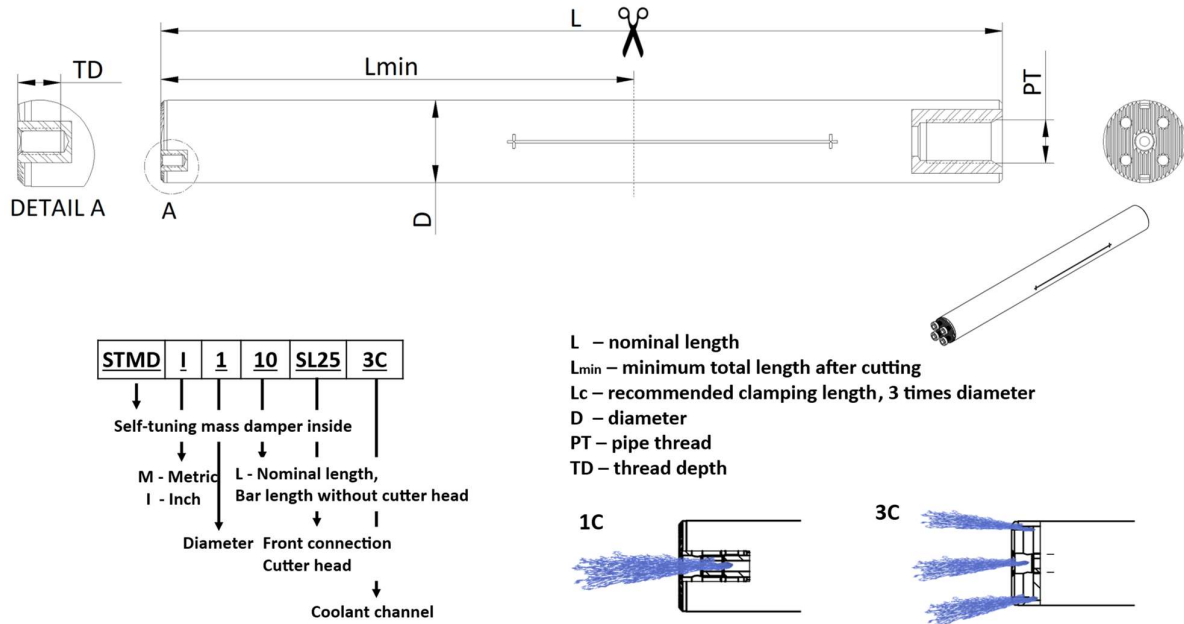
<sup>b</sup> – measured from the cutting edge to the clamping.

<sup>d</sup> – Carbide back end joined with steel

<sup>e</sup> – only on order and with a longer lead-time,

<sup>g</sup> - estimated with using standard SDUCR cutter heads from MAQ.

## Straight holder (6-9xD) with SL (Serration Lock) interface (Inch)

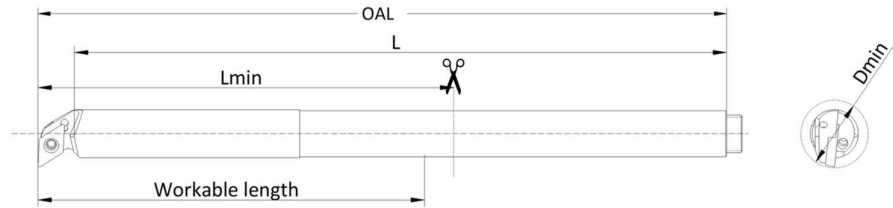


| Standard: Inch (with SL interface and exchangeable heads) |                                        |                                     |                           |             |           |            |         |       |                  |       |
|-----------------------------------------------------------|----------------------------------------|-------------------------------------|---------------------------|-------------|-----------|------------|---------|-------|------------------|-------|
| Part number                                               | Type                                   | Workable length <sup>b</sup> (inch) | D min (inch) <sup>g</sup> | Lmin (inch) | Lc (inch) | Screws     | TD (mm) | PT    | Material         | KG    |
| 300040                                                    | STMD I 1/2-5.7 SL12 3C                 | 3.000–4.000                         | 0.630                     | 5.7         | 1.41      | M2X8 or 14 | 5.5     | G ⅝   | S+C <sup>d</sup> | 0.18  |
| 300041                                                    | STMD I 5/8-6.7 SL16 3C                 | 3.750–5.000                         | 0.787                     | 4.6         | 1.88      | M3X8       | 5.5     | G ¾   | Steel            | 0.25  |
| 300042                                                    | STMD I 3/4-7.9 SL20 3C                 | 4.500–6.000                         | 0.984                     | 5.4         | 2.25      | M3X8       | 5.5     | G ¾   | Steel            | 0.50  |
| 300043                                                    | STMD I 1-10 SL25 3C                    | 6.000–8.000                         | 1.260                     | 7.1         | 3.00      | M4X9       | 6.5     | G ¾   | Steel            | 1.10  |
| 300044                                                    | STMD I 1 1/4-12.6 SL32 3C              | 7.500–10.000                        | 1.575                     | 8.4         | 3.75      | M5X12      | 10      | G ½   | Steel            | 2.10  |
| 300255                                                    | STMD I 1 1/2-16.0 SL40 1C <sup>e</sup> | 9.000–12.000                        | 1.969                     | 10.2        | 4.72      | M6X14      | 10      | G ½   | Steel            | 3.90  |
| 300045                                                    | STMD I 1 1/2-16.0 SL40 3C              | 9.000–12.000                        | 1.969                     | 10.2        | 4.72      | M6X14      | 10      | G ½   | Steel            | 3.90  |
| 300046                                                    | STMD I 2-20.4 SL40 1C                  | 12.000–16.000                       | 2.362                     | 12.7        | 5.90      | M6X14      | 10      | G ¾   | Steel            | 8.00  |
| 300047                                                    | STMD I 2-20.4 SL50 1C <sup>e</sup>     | 12.000–16.000                       | NA                        | 12.7        | 5.90      | M8X14      | 10      | G ¾   | Steel            | 8.00  |
| 300048                                                    | STMD I 2 1/2-24.7 SL40 1C              | 15.000–20.000                       | 2.756                     | 16.7        | 7.10      | M6X14      | 12      | G ¾   | Steel            | 13.60 |
| 300049                                                    | STMD I 2 1/2-24.7 SL60 1C <sup>e</sup> | 15.000–20.000                       | NA                        | 16.7        | 7.10      | M8X14      | 10      | G ¾   | Steel            | 13.60 |
| 300586                                                    | STMD I 3-34.6 SL40 1C <sup>e</sup>     | 18.900–25.200                       | 3.543                     | 21.5        | 9.40      | M6X14      | 12      | G 1 ¼ | Steel            | 30.0  |

b – measured from the cutting edge to the clamping.  
 d – Carbide back end joined with steel  
 e – only on order and with a longer lead-time,  
 g – estimated with using standard SDUCR cutter heads from MAQ.

## Turning 8-12xD

### Straight holder (8-12xD) with fixed cutter heads (Metric)



**STMD M 12 180 SDUCR C**

Self-tuning mass damper inside

M - Metric  
I - Inch

Diameter

L - Nominal length,  
Bar length without cutter head

Front connection  
Cutter head

Coolant through

L - nominal length

Lmin - minimum total length after cutting

Lc - recommended clamping length, 3 times diameter

D - diameter

WF - distance from cutting point to centre

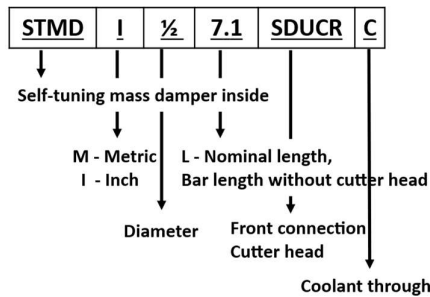
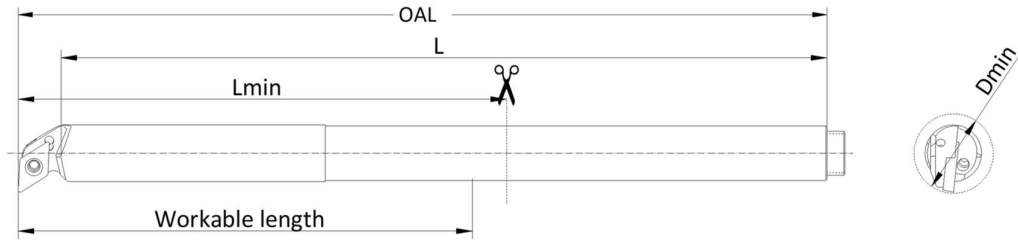
OAL - overall length

C - Coolant through



| Standard: Metric (with fixed head)                            |                      |                                   |           |                        |         |                      |          |          |           |        |               |              |                  |      |
|---------------------------------------------------------------|----------------------|-----------------------------------|-----------|------------------------|---------|----------------------|----------|----------|-----------|--------|---------------|--------------|------------------|------|
| Part number                                                   | Type                 | Workable length <sup>b</sup> (mm) | Dmin (mm) | Lmin <sup>a</sup> (mm) | Lc (mm) | WF <sup>c</sup> (mm) | OAL (mm) | LAMS (°) | GAM O (°) | PT     | Master insert | Insert screw | Material         | WG   |
| 300680                                                        | STMD M06-90 SCLCR    | 42-66                             | 8         | 96                     | 18      | 3.5                  | 96       | -13      | 0         | NA     | CCMT 040102   | IS M2.0x4.0  | S+C <sup>d</sup> | 0.04 |
| 301485                                                        | STMD M06-90 SCLCL    | 42-66                             | 8         | 96                     | 18      | 3.5                  | 96       | -13      | 0         | NA     | CCMT 040102   | IS M2.0x4.0  | S+C <sup>d</sup> | 0.04 |
| 300310                                                        | STMD M08-120 SCLCR C | 56-88                             | 10        | 128                    | 24      | 5                    | 128      | -11      | 0         | M7x0.5 | CCMT 060204   | IS M2.5x4.5  | S+C <sup>d</sup> | 0.15 |
| 300568                                                        | STMD M08-120 SCLCL C | 56-88                             | 10        | 128                    | 24      | 5                    | 128      | -11      | 0         | M7x0.5 | CCMT 060204   | IS M2.5x4.5  | S+C <sup>d</sup> | 0.15 |
| 300390                                                        | STMD M10-150 SCLCR C | 70-110                            | 12        | 161                    | 30      | 6.1                  | 161      | -9       | 0         | M9x0.5 | CCMT 060204   | IS M2.5x6.0  | S+C <sup>d</sup> | 0.20 |
| 300571                                                        | STMD M10-150 SCLCL C | 70-110                            | 12        | 161                    | 30      | 6.1                  | 161      | -9       | 0         | M9x0.5 | CCMT 060204   | IS M2.5x6.0  | S+C <sup>d</sup> | 0.20 |
| 300099                                                        | STMD M12-180 SCLCR C | 84-132                            | 16        | 179                    | 36      | 8.5                  | 179      | -6       | 0         | G ½    | CCMT 060204   | IS M2.5x6.0  | S+C <sup>d</sup> | 0.30 |
| 300574                                                        | STMD M12-180 SCLCL C | 84-132                            | 16        | 179                    | 36      | 8.5                  | 179      | -6       | 0         | G ½    | CCMT 060204   | IS M2.5x6.0  | S+C <sup>d</sup> | 0.30 |
| 301433                                                        | STMD M08-120 SDUCR C | 56-88                             | 13        | 130                    | 24      | 8                    | 128      | -9       | 0         | M7x0.5 | DCMT 070204   | IS M2.5x4.5  | S+C <sup>d</sup> | 0.15 |
| 301434                                                        | STMD M08-120 SDUCL C | 56-88                             | 13        | 130                    | 24      | 8                    | 128      | -9       | 0         | M7x0.5 | DCMT 070204   | IS M2.5x4.5  | S+C <sup>d</sup> | 0.15 |
| 300389                                                        | STMD M10-150 SDUCR C | 70-110                            | 15        | 160                    | 30      | 9                    | 160      | -7       | 0         | M9x0.5 | DCMT 070204   | IS M2.5x6.0  | S+C <sup>d</sup> | 0.20 |
| 300570                                                        | STMD M10-150 SDUCL C | 70-110                            | 15        | 160                    | 30      | 9                    | 160      | -7       | 0         | M9x0.5 | DCMT 070204   | IS M2.5x6.0  | S+C <sup>d</sup> | 0.20 |
| 300098                                                        | STMD M12-180 SDUCR C | 84-132                            | 16        | 179                    | 36      | 8.9                  | 179      | -6       | 0         | G ½    | DCMT 070204   | IS M2.5x6.0  | S+C <sup>d</sup> | 0.30 |
| 300573                                                        | STMD M12-180 SDUCL C | 84-132                            | 16        | 179                    | 36      | 8.9                  | 179      | -6       | 0         | G ½    | DCMT 070204   | IS M2.5x6.0  | S+C <sup>d</sup> | 0.30 |
| 300567                                                        | STMD M08-120 SDQCL C | 56-88                             | 11        | 130                    | 24      | 6                    | 130      | -11      | 0         | M7x0.5 | DCMT 070204   | IS M2.5x4.5  | S+C <sup>d</sup> | 0.15 |
| 300565                                                        | STMD M08-120 SDQCR C | 56-88                             | 11        | 130                    | 24      | 6                    | 130      | -11      | 0         | M7x0.5 | DCMT 070204   | IS M2.5x4.5  | S+C <sup>d</sup> | 0.15 |
| 301414                                                        | STMD M12-180 SDXCR C | 84-132                            | 16        | 179                    | 36      | 9                    | 179      | -6       | 0         | G ½    | DCMT 070204   | IS M2.5x6.0  | S+C <sup>d</sup> | 0.30 |
| 301377                                                        | STMD M06-90 STUBR    | 42-66                             | 8         | 96                     | 18      | 3.5                  | 96       | -13      | 0         | NA     | TBGT 060102   | IS M2.0x4.0  | S+C <sup>d</sup> | 0.04 |
| 301487                                                        | STMD M06-90 STUBL    | 42-66                             | 8         | 96                     | 18      | 3.5                  | 96       | -13      | 0         | NA     | TBGT 060102   | IS M2.0x4.0  | S+C <sup>d</sup> | 0.04 |
| 300386                                                        | STMD M08-120 STUBR C | 56-88                             | 10        | 127                    | 24      | 5                    | 127      | -11      | 0         | M7x0.5 | TBGT 060104   | IS M2.0x4.0  | S+C <sup>d</sup> | 0.15 |
| 300569                                                        | STMD M08-120 STUBL C | 56-88                             | 10        | 127                    | 24      | 5                    | 127      | -11      | 0         | M7x0.5 | TBGT 060104   | IS M2.0x4.0  | S+C <sup>d</sup> | 0.15 |
| 300391                                                        | STMD M10-150 STFCR C | 70-110                            | 13        | 161                    | 30      | 6.8                  | 161      | -8       | 0         | M9x0.5 | TCMT 090204   | IS M2.2x5.0  | S+C <sup>d</sup> | 0.20 |
| 300572                                                        | STMD M10-150 STFCL C | 70-110                            | 13        | 161                    | 30      | 6.8                  | 161      | -8       | 0         | M9x0.5 | TCMT 090204   | IS M2.2x5.0  | S+C <sup>d</sup> | 0.20 |
| 300100                                                        | STMD M12-180 STFCR C | 84-132                            | 16        | 179                    | 36      | 9                    | 179      | -6       | 0         | G ½    | TCMT 090204   | IS M2.2x5.0  | S+C <sup>d</sup> | 0.30 |
| 300575                                                        | STMD M12-180 STFCL C | 84-132                            | 16        | 179                    | 36      | 9                    | 179      | -6       | 0         | G ½    | TCMT 090204   | IS M2.2x5.0  | S+C <sup>d</sup> | 0.30 |
| 301215                                                        | STMD M12-180 SVJCR C | 84-132                            | 14        | 179                    | 36      | 7                    | 185      | -5       | 0         | G ½    | VCMT 080204   | IS M2.0x4.0  | S+C <sup>d</sup> | 0.30 |
| 301531                                                        | STMD M12-180 SVJCL C | 84-132                            | 14        | 179                    | 36      | 7                    | 185      | -5       | 0         | G ½    | VCMT 080204   | IS M2.0x4.0  | S+C <sup>d</sup> | 0.30 |
| a - total length to the cutting point                         |                      |                                   |           |                        |         |                      |          |          |           |        |               |              |                  |      |
| b - measured from the cutting edge to the clamping.           |                      |                                   |           |                        |         |                      |          |          |           |        |               |              |                  |      |
| c - distance from cutting point to centre with master insert. |                      |                                   |           |                        |         |                      |          |          |           |        |               |              |                  |      |
| d - Carbide back end joined with steel                        |                      |                                   |           |                        |         |                      |          |          |           |        |               |              |                  |      |

## Straight holder (8-12xD) with fixed cutter heads (Inch)



L – nominal length  
L<sub>min</sub> – minimum total length after cutting  
L<sub>c</sub> – recommended clamping length, 3 times diameter  
D – diameter  
WF – distance from cutting point to centre  
OAL – overall length

C - Coolant through



| Standard: Inch (with fixed head) |                         |                                     |             |                          |                       |                        |            |          |           |        |               |              |                  |      |
|----------------------------------|-------------------------|-------------------------------------|-------------|--------------------------|-----------------------|------------------------|------------|----------|-----------|--------|---------------|--------------|------------------|------|
| Part number                      | Type                    | Workable length <sup>b</sup> (inch) | Dmin (inch) | Lmin <sup>a</sup> (inch) | L <sub>c</sub> (inch) | WF <sup>c</sup> (inch) | OAL (inch) | LAMS (°) | GAM O (°) | PT     | Master insert | Insert screw | Material         | KG   |
| 300681                           | STMD I 1/4-3.5 SCLCR    | 1.653-2.598                         | 0.315       | 3.78                     | 0.708                 | 0.138                  | 3.78       | -13      | 0         | NA     | CCMT 040102   | IS M2.0x4.0  | S+C <sup>d</sup> | 0.04 |
| 301486                           | STMD I 1/4-3.5 SCLCL    | 1.653-2.598                         | 0.315       | 3.78                     | 0.708                 | 0.138                  | 3.78       | -13      | 0         | NA     | CCMT 040102   | IS M2.0x4.0  | S+C <sup>d</sup> | 0.04 |
| 300387                           | STMD I 5/16-4.7 SCLCR C | 2.204-3.464                         | 0.39        | 5.04                     | 0.94                  | 0.20                   | 5.04       | -11      | 0         | M7x0.5 | CCMT 060204   | IS M2.5x4.5  | S+C <sup>d</sup> | 0.15 |
| 300577                           | STMD I 5/16-4.7 SCLCL C | 2.204-3.464                         | 0.39        | 5.04                     | 0.94                  | 0.20                   | 5.04       | -11      | 0         | M7x0.5 | CCMT 060204   | IS M2.5x4.5  | S+C <sup>d</sup> | 0.15 |
| 300393                           | STMD I 3/8-5.9 SCLCR C  | 2.625-4.125                         | 0.47        | 6.34                     | 1.18                  | 0.24                   | 6.34       | -9       | 0         | M9x0.5 | CCMT 060204   | IS M2.5x6.0  | S+C <sup>d</sup> | 0.20 |
| 300580                           | STMD I 3/8-5.9 SCLCL C  | 2.625-4.125                         | 0.47        | 6.34                     | 1.18                  | 0.24                   | 6.34       | -9       | 0         | M9x0.5 | CCMT 060204   | IS M2.5x6.0  | S+C <sup>d</sup> | 0.20 |
| 300154                           | STMD I 1/2-7.1 SCLCR C  | 3.500-5.500                         | 0.63        | 7.05                     | 1.42                  | 0.33                   | 7.05       | -6       | 0         | G 1/2  | CCMT 060204   | IS M2.5x6.0  | S+C <sup>d</sup> | 0.30 |
| 300583                           | STMD I 1/2-7.1 SCLCL C  | 3.500-5.500                         | 0.63        | 7.05                     | 1.42                  | 0.33                   | 7.05       | -6       | 0         | G 1/2  | CCMT 060204   | IS M2.5x6.0  | S+C <sup>d</sup> | 0.30 |

|        |                        |             |      |      |      |      |      |    |   |        |             |             |                  |      |
|--------|------------------------|-------------|------|------|------|------|------|----|---|--------|-------------|-------------|------------------|------|
| 300392 | STMD I 3/8-5.9 SDUCR C | 2.625-4.125 | 0.59 | 6.30 | 1.18 | 0.35 | 6.30 | -7 | 0 | M9x0.5 | DCMT 070204 | IS M2.5x6.0 | S+C <sup>d</sup> | 0.20 |
| 300579 | STMD I 3/8-5.9 SDUCR C | 2.625-4.125 | 0.59 | 6.30 | 1.18 | 0.35 | 6.30 | -7 | 0 | M9x0.5 | DCMT 070204 | IS M2.5x6.0 | S+C <sup>d</sup> | 0.20 |
| 300153 | STMD I 1/2-7.1 SDUCR C | 3.500-5.500 | 0.63 | 7.05 | 1.42 | 0.35 | 7.05 | -6 | 0 | G 1/2  | DCMT 070204 | IS M2.5x6.0 | S+C <sup>d</sup> | 0.30 |
| 300582 | STMD I 1/2-7.1 SDUCR C | 3.500-5.500 | 0.63 | 7.05 | 1.42 | 0.35 | 7.05 | -6 | 0 | G 1/2  | DCMT 070204 | IS M2.5x6.0 | S+C <sup>d</sup> | 0.30 |

|        |                         |             |      |      |      |      |      |     |   |        |             |             |                  |      |
|--------|-------------------------|-------------|------|------|------|------|------|-----|---|--------|-------------|-------------|------------------|------|
| 300566 | STMD I 5/16-4.7 SDQCR C | 2.204-3.464 | 0.43 | 5.12 | 0.94 | 0.24 | 5.12 | -11 | 0 | M7x0.5 | DCMT 070204 | IS M2.5x4.5 | S+C <sup>d</sup> | 0.15 |
| 300576 | STMD I 5/16-4.7 SDQCL C | 2.204-3.464 | 0.43 | 5.12 | 0.94 | 0.24 | 5.12 | -11 | 0 | M7x0.5 | DCMT 070204 | IS M2.5x4.5 | S+C <sup>d</sup> | 0.15 |

|        |                        |             |      |      |      |      |      |    |   |       |             |             |                  |      |
|--------|------------------------|-------------|------|------|------|------|------|----|---|-------|-------------|-------------|------------------|------|
| 301415 | STMD I 1/2-7.1 SDXCR C | 3.500-5.500 | 0.63 | 7.05 | 1.42 | 0.35 | 7.05 | -6 | 0 | G 1/2 | DCMT 070204 | IS M2.5x6.0 | S+C <sup>d</sup> | 0.30 |
|--------|------------------------|-------------|------|------|------|------|------|----|---|-------|-------------|-------------|------------------|------|

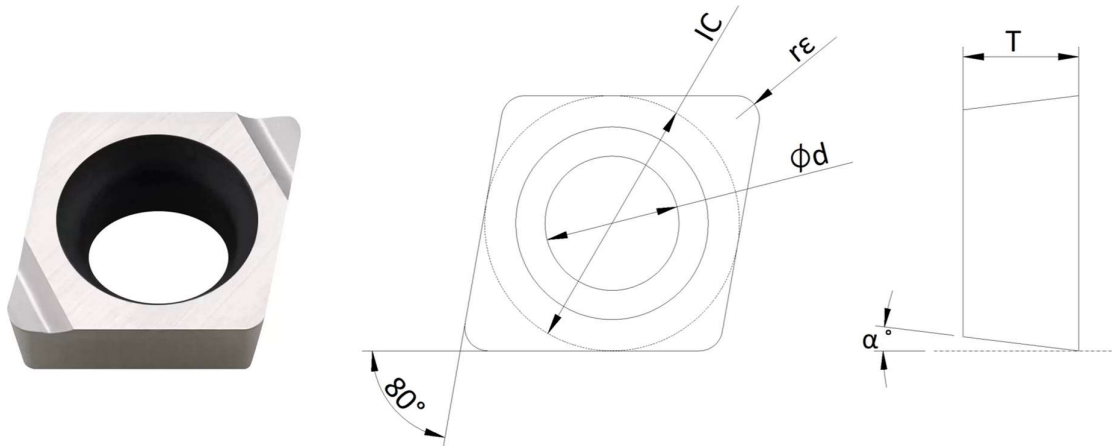
|        |                         |             |       |      |       |       |      |     |   |        |             |             |                  |      |
|--------|-------------------------|-------------|-------|------|-------|-------|------|-----|---|--------|-------------|-------------|------------------|------|
| 301378 | STMD I 1/4-3.5 STUBR    | 1.653-2.598 | 0.315 | 3.78 | 0.708 | 0.138 | 3.78 | -13 | 0 | NA     | TBGT 060102 | IS M2.0x4.0 | S+C <sup>d</sup> | 0.04 |
| 301488 | STMD I 1/4-3.5 STUBL    | 1.653-2.598 | 0.315 | 3.78 | 0.708 | 0.138 | 3.78 | -13 | 0 | NA     | TBGT 060102 | IS M2.0x4.0 | S+C <sup>d</sup> | 0.04 |
| 300388 | STMD I 5/16-4.7 STUBR C | 2.204-3.464 | 0.39  | 5.00 | 0.94  | 0.20  | 5.00 | -11 | 0 | M7x0.5 | TBGT 060104 | IS M2.0x4.0 | S+C <sup>d</sup> | 0.15 |
| 300578 | STMD I 5/16-4.7 STUBL C | 2.204-3.464 | 0.39  | 5.00 | 0.94  | 0.20  | 5.00 | -11 | 0 | M7x0.5 | TBGT 060104 | IS M2.0x4.0 | S+C <sup>d</sup> | 0.15 |
| 300155 | STMD I 1/2-7.1 STFCR C  | 3.500-5.500 | 0.63  | 7.05 | 1.42  | 0.35  | 7.05 | -6  | 0 | G 1/2  | TCMT 090204 | IS M2.2x5.0 | S+C <sup>d</sup> | 0.30 |
| 300584 | STMD I 1/2-7.1 STFCL C  | 3.500-5.500 | 0.63  | 7.05 | 1.42  | 0.35  | 7.05 | -6  | 0 | G 1/2  | TCMT 090204 | IS M2.2x5.0 | S+C <sup>d</sup> | 0.30 |
| 300394 | STMD I 3/8-5.9 STFCR C  | 2.625-4.125 | 0.51  | 6.34 | 1.18  | 0.27  | 6.34 | -8  | 0 | M9x0.5 | TCMT 090204 | IS M2.2x5.0 | S+C <sup>d</sup> | 0.20 |
| 300581 | STMD I 3/8-5.9 STFCL C  | 2.625-4.125 | 0.51  | 6.34 | 1.18  | 0.27  | 6.34 | -8  | 0 | M9x0.5 | TCMT 090204 | IS M2.2x5.0 | S+C <sup>d</sup> | 0.20 |

|        |                        |             |      |      |      |      |      |    |   |       |             |             |                  |      |
|--------|------------------------|-------------|------|------|------|------|------|----|---|-------|-------------|-------------|------------------|------|
| 301216 | STMD I 1/2-7.1 SVJCR C | 3.500-5.500 | 0.55 | 7.05 | 1.42 | 0.28 | 7.28 | -5 | 0 | G 1/2 | VCMT 080204 | IS M2.0x4.0 | S+C <sup>d</sup> | 0.30 |
|--------|------------------------|-------------|------|------|------|------|------|----|---|-------|-------------|-------------|------------------|------|

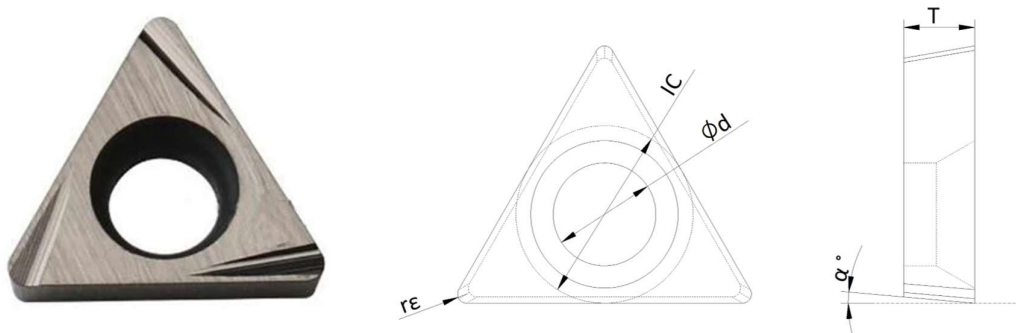
a – total length to the cutting point  
b – measured from the cutting edge to the clamping.  
c – distance from cutting point to centre with master insert.  
d – Carbide back end joined with steel



## Small tool inserts

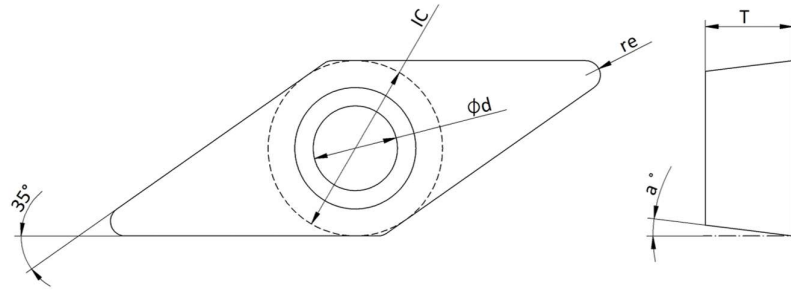
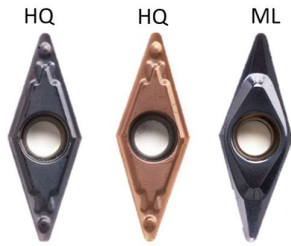


| Part Number                                                                            | Insert Type                                | IC  | d   | T   | rε  | α  | P | M | K | N | S | H |
|----------------------------------------------------------------------------------------|--------------------------------------------|-----|-----|-----|-----|----|---|---|---|---|---|---|
| 301221                                                                                 | CCGT 040101 L <sup>a</sup> -F P10U Cermet  | 4.3 | 2.3 | 1.8 | 0.1 | 7° | ● | ○ | ○ | - | - | - |
| 301222                                                                                 | CCGT 040102 L <sup>a</sup> -F P10U Cermet  | 4.3 | 2.3 | 1.8 | 0.2 | 7° | ● | ○ | ○ | - | - | - |
| 301223                                                                                 | CCGT 040104 L <sup>a</sup> -F P10U Cermet  | 4.3 | 2.3 | 1.8 | 0.4 | 7° | ● | ○ | ○ | - | - | - |
| 301224                                                                                 | CCGT 040101 L <sup>a</sup> -F P15C Carbide | 4.3 | 2.3 | 1.8 | 0.1 | 7° | ○ | ● | ○ | - | - | - |
| 301225                                                                                 | CCGT 040102 L <sup>a</sup> -F P15C Carbide | 4.3 | 2.3 | 1.8 | 0.2 | 7° | ○ | ● | ○ | - | - | - |
| 301226                                                                                 | CCGT 040104 L <sup>a</sup> -F P15C Carbide | 4.3 | 2.3 | 1.8 | 0.4 | 7° | ○ | ● | ○ | - | - | - |
| 301516                                                                                 | CCGT 040102 PCD (1 pcs package)            | 4.3 | 2.3 | 1.8 | 0.4 | 7° | - | - | - | ● | - | - |
| 301517                                                                                 | CCGT 040104 PCD (1 pcs package)            | 4.3 | 2.3 | 1.8 | 0.4 | 7° | - | - | - | ● | - | - |
| 301524                                                                                 | CCGT 040102 CBN (1 pcs package)            | 4.3 | 2.3 | 1.8 | 0.4 | 7° | ○ | - | ○ | - | ○ | ● |
| 301525                                                                                 | CCGT 040104 CBN (1 pcs package)            | 4.3 | 2.3 | 1.8 | 0.4 | 7° | ○ | - | ○ | - | ○ | ● |
| <sup>a</sup> In internal turning, L - left hand used for Right hand cutter heads/tools |                                            |     |     |     |     |    |   |   |   |   |   |   |
| <sup>b</sup> Order oriented product, 10 pcs/package, 2 weeks delivery time             |                                            |     |     |     |     |    |   |   |   |   |   |   |



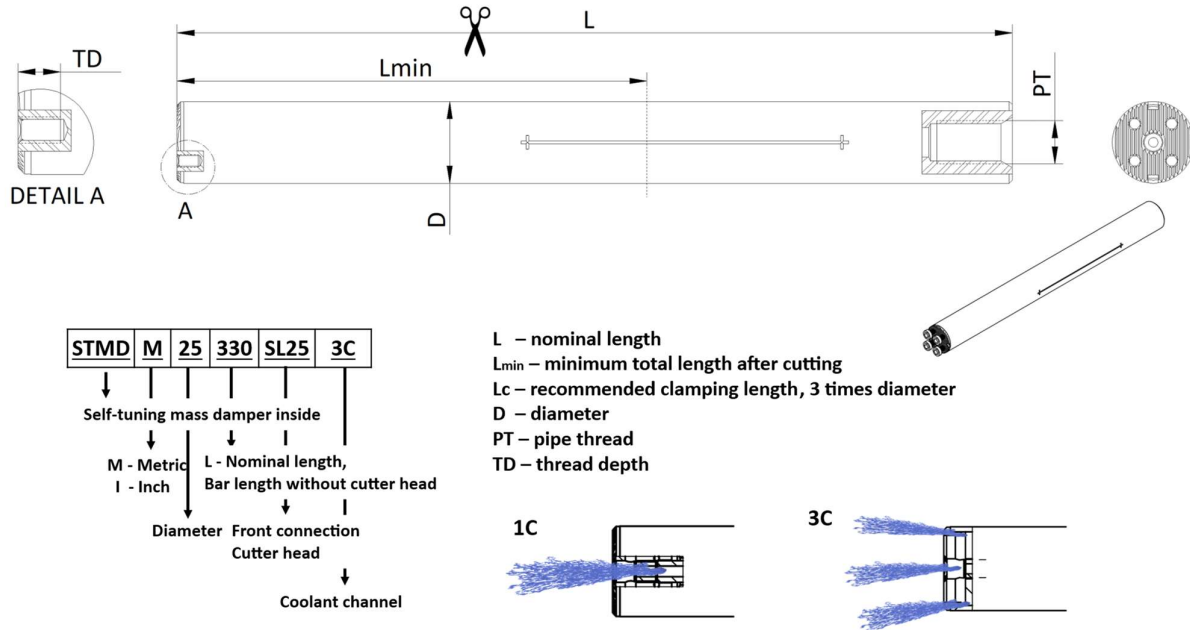
| Part Number                                                                            | Insert Type                                          | IC   | d   | T    | rε  | α  | P | M | K | N | S | H |
|----------------------------------------------------------------------------------------|------------------------------------------------------|------|-----|------|-----|----|---|---|---|---|---|---|
| 301227                                                                                 | TBGT 060102 L <sup>a</sup> P10U Cermet <sup>b</sup>  | 3.97 | 2.3 | 1.59 | 0.2 | 5° | ● | ○ | ○ | - | - | - |
| 301228                                                                                 | TBGT 060104 L <sup>a</sup> P10U Cermet <sup>b</sup>  | 3.97 | 2.3 | 1.59 | 0.4 | 5° | ● | ○ | ○ | - | - | - |
| 301229                                                                                 | TBGT 060102 L <sup>a</sup> P15C Carbide <sup>b</sup> | 3.97 | 2.3 | 1.59 | 0.2 | 5° | ○ | ● | ○ | - | - | - |
| 301230                                                                                 | TBGT 060104 L <sup>a</sup> P15C Carbide <sup>b</sup> | 3.97 | 2.3 | 1.59 | 0.4 | 5° | ○ | ● | ○ | - | - | - |
| 301231                                                                                 | TBGT 060102 N01 PCD                                  | 3.97 | 2.3 | 1.59 | 0.2 | 5° | - | - | - | ● | - | - |
| <sup>a</sup> In internal turning, L - left hand used for Right hand cutter heads/tools |                                                      |      |     |      |     |    |   |   |   |   |   |   |
| <sup>b</sup> Order oriented product, 10 pcs/package, 2 weeks delivery time             |                                                      |      |     |      |     |    |   |   |   |   |   |   |

Chip breaker:



| Part Number                                                                | Insert Type                              | IC   | d   | T    | re  | $\alpha$ | P | M | K | N | S | H |
|----------------------------------------------------------------------------|------------------------------------------|------|-----|------|-----|----------|---|---|---|---|---|---|
| 301232                                                                     | VCMT 080202 HQ P10U Cermet <sup>a</sup>  | 4.76 | 2.3 | 2.38 | 0.2 | 7        | ● | ○ | ○ | - | - | - |
| 301233                                                                     | VCMT 080204 HQ P10U Cermet <sup>a</sup>  | 4.76 | 2.3 | 2.38 | 0.4 | 7        | ● | ○ | ○ | - | - | - |
| 301234                                                                     | VCMT 080202 HQ P05C Carbide <sup>a</sup> | 4.76 | 2.3 | 2.38 | 0.2 | 7        | ○ | ● | ○ | - | - | - |
| 301235                                                                     | VCMT 080204 HQ P05C Carbide <sup>a</sup> | 4.76 | 2.3 | 2.38 | 0.4 | 7        | ○ | ● | ○ | - | - | - |
| 301236                                                                     | VCMT 080202 N01 PCD <sup>a</sup>         | 4.76 | 2.3 | 2.38 | 0.2 | 7        | - | - | - | ● | - | - |
| 301237                                                                     | VCMT 080204 N01 PCD <sup>a</sup>         | 4.76 | 2.3 | 2.38 | 0.4 | 7        | - | - | - | ● | - | - |
| <sup>a</sup> Order oriented product, 10 pcs/package, 2 weeks delivery time |                                          |      |     |      |     |          |   |   |   |   |   |   |

## Straight holder (8-12xD) with SL (Serration Lock) interface (Metric)



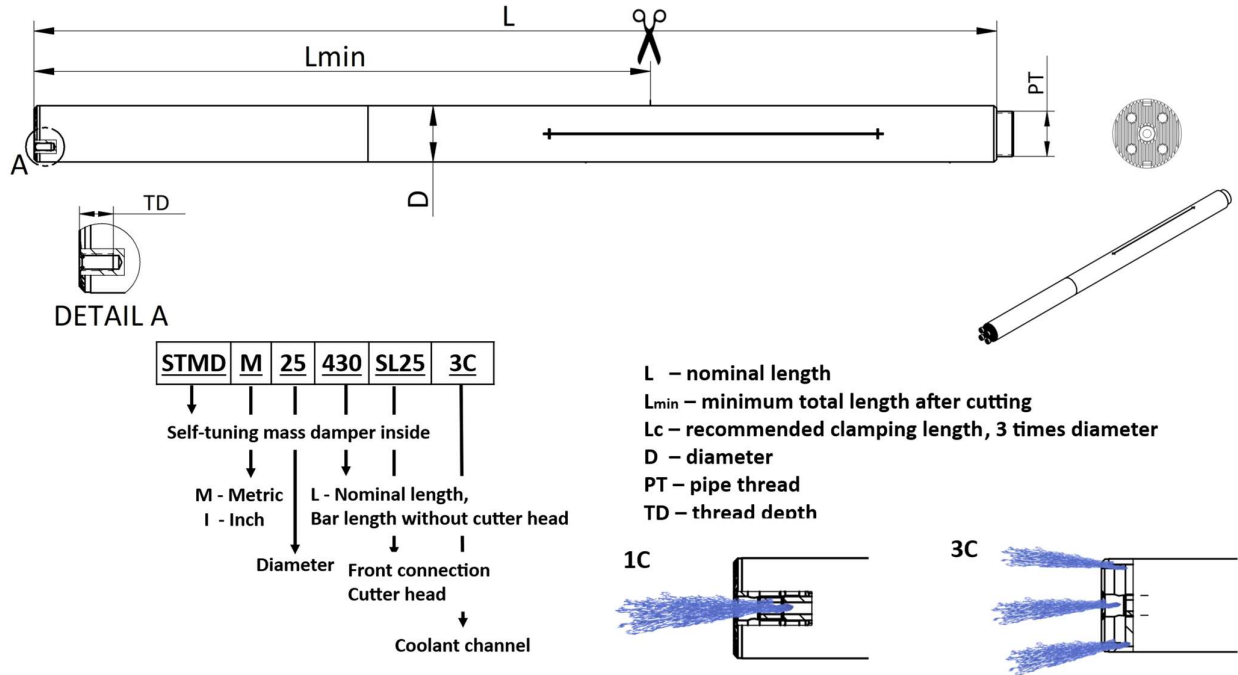
| Standard: Metric (with SL interface and exchangeable heads) |                                      |                                   |                         |           |         |        |         |       |                  |      |  |
|-------------------------------------------------------------|--------------------------------------|-----------------------------------|-------------------------|-----------|---------|--------|---------|-------|------------------|------|--|
| Part number                                                 | Type                                 | Workable length <sup>b</sup> (mm) | D min (mm) <sup>g</sup> | Lmin (mm) | Lc (mm) | Screws | TD (mm) | PT    | Material         | KG   |  |
| 300017                                                      | STMD M16-204 SL16 3C                 | 128-176                           | 20                      | 204       | 48      | M3X8   | 5.5     | G ¼   | S+C <sup>d</sup> | 0.50 |  |
| 300018                                                      | STMD M20-260 SL20 3C                 | 160-220                           | 25                      | 260       | 60      | M3X8   | 5.5     | G ¼   | S+C <sup>d</sup> | 1.00 |  |
| 300019                                                      | STMD M25-330 SL25 3C                 | 200-275                           | 32                      | 255       | 75      | M4X9   | 6.5     | G ¼   | Steel            | 1.70 |  |
| 300020                                                      | STMD M32-416 SL32 3C                 | 256-352                           | 40                      | 309       | 96      | M5X12  | 10      | G ½   | Steel            | 3.50 |  |
| 300241                                                      | STMD M40-528 SL40 1C <sup>e</sup>    | 320-440                           | 50                      | 312       | 120     | M6X14  | 10      | G ½   | Steel            | 5.00 |  |
| 300021                                                      | STMD M40-528 SL40 3C                 | 320-440                           | 50                      | 312       | 120     | M6X14  | 10      | G ½   | Steel            | 5.00 |  |
| 300022                                                      | STMD M50-660 SL40 1C                 | 400-550                           | 60                      | 384       | 150     | M6X14  | 10      | G ¾   | Steel            | 9.40 |  |
| 300023                                                      | STMD M50-660 SL50 1C <sup>e</sup>    | 400-550                           | NA                      | 382       | 150     | M8X14  | 12      | G ¾   | Steel            | 9.40 |  |
| 300024                                                      | STMD M60-808 SL40 1C                 | 480-660                           | 70                      | 484       | 180     | M6X14  | 10      | G ¾   | Steel            | 16.4 |  |
| 300025                                                      | STMD M60-808 SL60 1C <sup>e</sup>    | 480-660                           | NA                      | 482       | 180     | M8X14  | 12      | G ¾   | Steel            | 16.4 |  |
| 300242                                                      | STMD M80-1200 SL40 1C <sup>e</sup>   | 640-880                           | 90                      | 645       | 240     | M6X14  | 10      | G 1 ¼ | Steel            | 42.0 |  |
| 301540                                                      | STMD M100-1500 SL80 C <sup>e</sup> L | 800-1100                          | 120                     | 1000      | 300     | M10X20 | 14      | G 1   | Steel            | 88.0 |  |
| 301483                                                      | STMD M100-1500 SL80 C <sup>e</sup> R | 800-1100                          | 120                     | 1000      | 300     | M10X20 | 14      | G 1   | Steel            | 88.0 |  |

b – measured from the cutting edge to the clamping.  
d – Carbide back end joined with steel  
e – only on order and with a longer lead time  
g- estimated with using standard SDUCR cutter heads from MAQ.



## Turning 11-15xD

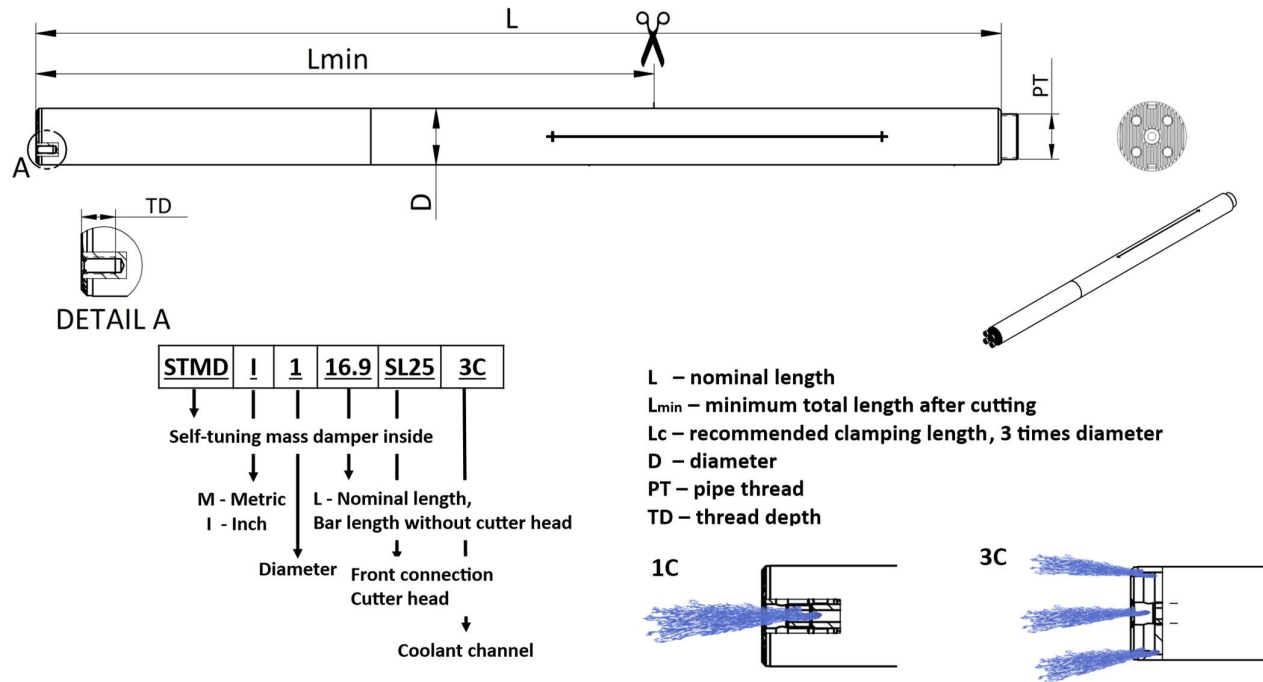
Straight holder (11-15xD) with SL (Serration Lock) interface (Metric)



| Standard: Metric (with SL interface and exchangeable heads) |                                    |                                   |                         |                       |                     |        |         |       |                  |      |
|-------------------------------------------------------------|------------------------------------|-----------------------------------|-------------------------|-----------------------|---------------------|--------|---------|-------|------------------|------|
| Part number                                                 | Type                               | Workable length <sup>b</sup> (mm) | D min (mm) <sup>g</sup> | L <sub>min</sub> (mm) | L <sub>c</sub> (mm) | Screws | TD (mm) | PT    | Material         | KG   |
| 300089                                                      | STMD M16-268 SL16 3C               | 176-240                           | 20                      | 268                   | 48                  | M3X8   | 5.5     | G ½   | S+C <sup>d</sup> | 0.75 |
| 300090                                                      | STMD M20-340 SL20 3C               | 220-300                           | 25                      | 340                   | 60                  | M3X8   | 5.5     | G ½   | S+C <sup>d</sup> | 1.50 |
| 300091                                                      | STMD M25-430 SL25 3C               | 275-375                           | 32                      | 430                   | 75                  | M4X9   | 6.5     | G ¾   | S+C <sup>d</sup> | 3.20 |
| 300085                                                      | STMD M32-544 SL32 3C               | 352-480                           | 40                      | 544                   | 96                  | M5X12  | 10      | G ¾   | S+C <sup>d</sup> | 6.40 |
| 300309                                                      | STMD M40-688 SL40 1C               | 440-600                           | 50                      | 688                   | 120                 | M6x14  | 10      | M36x1 | S+C <sup>d</sup> | 9.40 |
| 300093                                                      | STMD M40-688 SL40 3C               | 440-600                           | 50                      | 688                   | 120                 | M6x14  | 10      | M36x1 | S+C <sup>d</sup> | 9.40 |
| 300094                                                      | STMD M50-861 SL40 1C               | 550-750                           | 60                      | 861                   | 150                 | M6X14  | 10      | G 1/4 | S+C <sup>d</sup> | 18.6 |
| 300095                                                      | STMD M50-861 SL50 1C               | 550-750                           | NA                      | 861                   | 150                 | M6X14  | 10      | G 1/4 | S+C <sup>d</sup> | 18.6 |
| 300096                                                      | STMD M60-1040 SL40 1C <sup>e</sup> | 660-900                           | 70                      | 1040                  | 180                 | M6x14  | 10      | G 3/8 | S+C <sup>d</sup> | 34.4 |
| 300097                                                      | STMD M60-1040 SL60 1C <sup>e</sup> | 660-900                           | NA                      | 1040                  | 180                 | M6x14  | 10      | G 3/8 | S+C <sup>d</sup> | 34.4 |
| 301214                                                      | STMD M80-1400 SL40 1C <sup>e</sup> | 880-1200                          | 90                      | 1400                  | 240                 | M6x14  | 10      | G 3/4 | S+C <sup>d</sup> | 80   |
| 301552                                                      | STMD M80-1400 SL80 C <sup>e</sup>  | 880-1200                          | 90                      | 1400                  | 240                 | M10x18 | 10      | G 3/4 | S+C <sup>d</sup> | 80   |

|                                                                |
|----------------------------------------------------------------|
| b – measured from the cutting edge to the clamping.            |
| d – Carbide back end joined with steel                         |
| e – only on order and with a longer lead-time,                 |
| g - estimated with using standard SDUCR cutter heads from MAQ. |

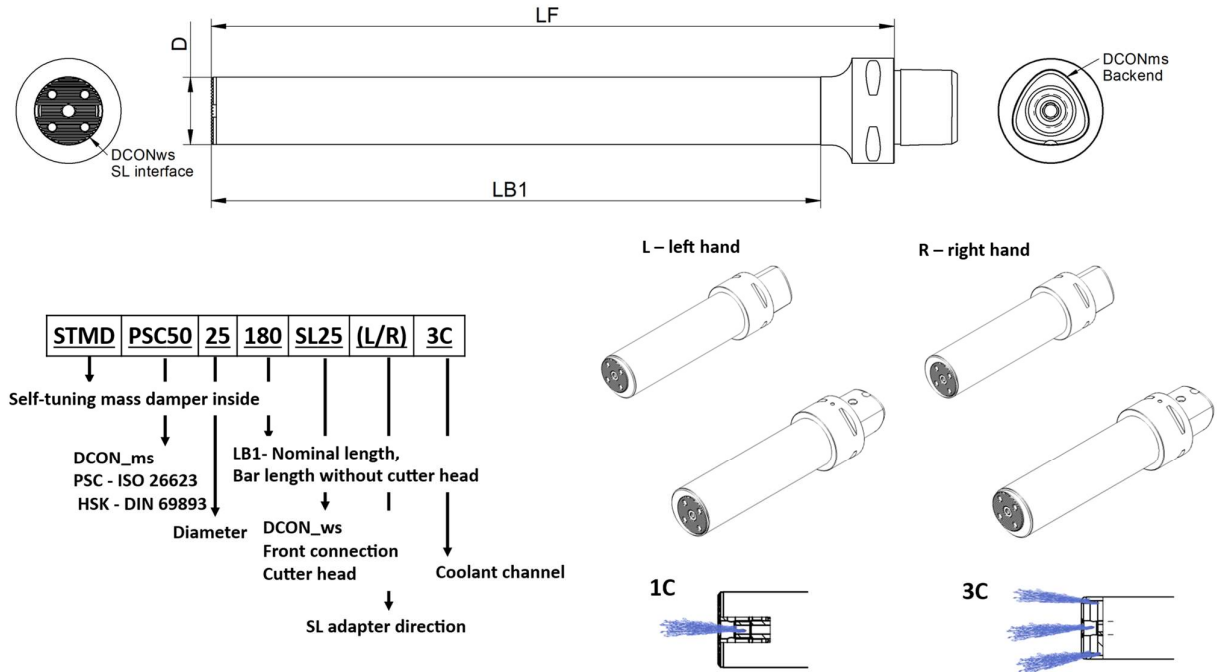
## Straight holder (11-15xD) with SL (Serration Lock) interface (Inch)



| Standard: Inch (with SL interface and exchangeable heads) |                                        |                                     |                          |             |           |        |                  |         |                  |      |
|-----------------------------------------------------------|----------------------------------------|-------------------------------------|--------------------------|-------------|-----------|--------|------------------|---------|------------------|------|
| Part number                                               | Type                                   | Workable length <sup>b</sup> (inch) | Dmin (inch) <sup>g</sup> | Lmin (inch) | Lc (inch) | Screws | PT               | TD (mm) | Material         | KG   |
| 300159                                                    | STMD I 5/8-10.6 SL16 3C                | 6.875-9.375                         | 0.787                    | 10.6        | 1.88      | M3X8   | G ½              | 5.5     | S+C <sup>d</sup> | 0.75 |
| 300160                                                    | STMD I 3/4-13.4 SL20 3C                | 8.250-11.250                        | 0.984                    | 13.4        | 2.25      | M3X8   | G ½ <sup>2</sup> | 5.5     | S+C <sup>d</sup> | 1.50 |
| 300161                                                    | STMD I 1-16.9 SL25 3C                  | 11.000-15.000                       | 1.260                    | 16.9        | 3.00      | M4X9   | G ¾ <sup>3</sup> | 6.5     | S+C <sup>d</sup> | 3.20 |
| 300162                                                    | STMD I 1 1/4-21.4 SL32 3C              | 13.750-18.750                       | 1.575                    | 21.4        | 3.75      | M5X14  | G ¾ <sup>4</sup> | 10      | S+C <sup>d</sup> | 6.40 |
| 300397                                                    | STMD I 1 1/2-27.1 SL40 1C <sup>e</sup> | 16.500-22.500                       | 1.969                    | 27.1        | 4.50      | M6x14  | M36x1            | 10      | S+C <sup>d</sup> | 9.40 |
| 300396                                                    | STMD I 1 1/2-27.1 SL40 3C <sup>e</sup> | 16.500-22.500                       | 1.969                    | 27.1        | 4.50      | M6x14  | M36x1            | 10      | S+C <sup>d</sup> | 9.40 |
| 300398                                                    | STMD I 2-33.9 SL40 1C <sup>e</sup>     | 22.000-30.000                       | 2.362                    | 33.9        | 6.00      | M6X14  | G 1/4            | 10      | S+C <sup>d</sup> | 18.6 |
| 300400                                                    | STMD I 2-33.9 SL50 1C <sup>e</sup>     | 22.000-30.000                       | NA                       | 33.9        | 6.00      | M8X14  | G 1/4            | 10      | S+C <sup>d</sup> | 18.6 |
| 300399                                                    | STMD I 2 1/2-40.9 SL40 1C <sup>e</sup> | 27.500- 37.500                      | 2.756                    | 40.9        | 7.50      | M6x14  | G 3/8            | 10      | S+C <sup>d</sup> | 34.4 |
| 300401                                                    | STMD I 2 1/2-40.9 SL60 1C <sup>e</sup> | 27.500- 37.500                      | NA                       | 40.9        | 7.50      | M8x14  | G 3/8            | 10      | S+C <sup>d</sup> | 34.4 |

b – measured from the cutting edge to the clamping.  
d – Carbide back end joined with steel  
e – only on order and with a longer lead-time,  
g - estimated with using standard SDUCR cutter heads from MAQ.

## Turning – Multitask with modular backends.



### Standard: PSC32 (with SL interface and exchangeable heads)

| Standard: PSC32 (with SL interface and exchangeable heads) |                           |         |        |                        |         |          |        |          |                                                                                      |  |
|------------------------------------------------------------|---------------------------|---------|--------|------------------------|---------|----------|--------|----------|--------------------------------------------------------------------------------------|--|
| Part number                                                | Type                      | Backend | D (mm) | Dmin (mm) <sup>d</sup> | LF (mm) | LB1 (mm) | Screws | Material |  |  |
| 300476                                                     | STMD PSC32 16-064 SL16 3C | PSC32   | 16     | 20                     | 99      | 64       | M3X8   | Steel    | 0.3                                                                                  |  |
| 300477                                                     | STMD PSC32 16-096 SL16 3C | PSC32   | 16     | 20                     | 131     | 96       | M3X8   | Steel    | 0.3                                                                                  |  |
| 300478                                                     | STMD PSC32 20-090 SL20 3C | PSC32   | 20     | 25                     | 125     | 90       | M3X8   | Steel    | 0.3                                                                                  |  |
| 300479                                                     | STMD PSC32 20-130 SL20 3C | PSC32   | 20     | 25                     | 165     | 130      | M3X8   | Steel    | 0.4                                                                                  |  |
| 300480                                                     | STMD PSC32 25-130 SL25 3C | PSC32   | 25     | 32                     | 165     | 130      | M4X9   | Steel    | 0.6                                                                                  |  |
| 300481                                                     | STMD PSC32 25-180 SL25 3C | PSC32   | 25     | 32                     | 215     | 180      | M4X9   | Steel    | 0.8                                                                                  |  |
| 300482                                                     | STMD PSC32 25-230 SL25 3C | PSC32   | 25     | 32                     | 265     | 230      | M4X9   | Steel    | 1.0                                                                                  |  |
| 300483                                                     | STMD PSC32 32-170 SL32 3C | PSC32   | 32     | 40                     | 205     | 170      | M5X12  | Steel    | 1.8                                                                                  |  |
| 300484                                                     | STMD PSC32 32-230 SL32 3C | PSC32   | 32     | 40                     | 265     | 230      | M5X12  | Steel    | 2.4                                                                                  |  |

<sup>d</sup> - estimated with using standard SDUCR cutter heads from MAQ.

## Standard: PSC40 (with SL interface and exchangeable heads)

| Standard: PSC40 (with SL interface and exchangeable heads) |                           |         |        |                        |         |          |        |          |     |
|------------------------------------------------------------|---------------------------|---------|--------|------------------------|---------|----------|--------|----------|-----|
| Part number                                                | Type                      | Backend | D (mm) | Dmin (mm) <sup>d</sup> | LF (mm) | LB1 (mm) | Screws | Material | KG  |
| 300485                                                     | STMD PSC40 16-064 SL16 3C | PSC40   | 16     | 20                     | 100     | 64       | M3X8   | Steel    | 0.4 |
| 300486                                                     | STMD PSC40 16-096 SL16 3C | PSC40   | 16     | 20                     | 132     | 96       | M3X8   | Steel    | 0.5 |
| 300487                                                     | STMD PSC40 20-090 SL20 3C | PSC40   | 20     | 25                     | 126     | 90       | M3X8   | Steel    | 0.5 |
| 300488                                                     | STMD PSC40 20-130 SL20 3C | PSC40   | 20     | 25                     | 166     | 130      | M3X8   | Steel    | 0.7 |
| 300489                                                     | STMD PSC40 25-130 SL25 3C | PSC40   | 25     | 32                     | 167     | 130      | M4X9   | Steel    | 0.8 |
| 300490                                                     | STMD PSC40 25-180 SL25 3C | PSC40   | 25     | 32                     | 216     | 180      | M4X9   | Steel    | 0.9 |
| 300491                                                     | STMD PSC40 25-230 SL25 3C | PSC40   | 25     | 32                     | 266     | 230      | M4X9   | Steel    | 1.2 |
| 300492                                                     | STMD PSC40 32-170 SL32 3C | PSC40   | 32     | 40                     | 206     | 170      | M5X12  | Steel    | 1.5 |
| 300493                                                     | STMD PSC40 32-230 SL32 3C | PSC40   | 32     | 40                     | 266     | 230      | M5X12  | Steel    | 2.0 |
| 300494                                                     | STMD PSC40 32-294 SL32 3C | PSC40   | 32     | 40                     | 330     | 294      | M5X12  | Steel    | 2.6 |
| 300495                                                     | STMD PSC40 40-210 SL40 3C | PSC40   | 40     | 50                     | 246     | 210      | M6X14  | Steel    | 1.7 |
| 300496                                                     | STMD PSC40 40-290 SL40 3C | PSC40   | 40     | 50                     | 326     | 290      | M6x14  | Steel    | 3.4 |

<sup>d</sup> - estimated with using standard SDUCR cutter heads from MAQ.

## Standard: PSC50 (with SL interface and exchangeable heads)

| Standard: PSC50 (with SL interface and exchangeable heads) |                             |         |        |                        |         |          |        |          |     |
|------------------------------------------------------------|-----------------------------|---------|--------|------------------------|---------|----------|--------|----------|-----|
| Part number                                                | Type                        | Backend | D (mm) | Dmin (mm) <sup>d</sup> | LF (mm) | LB1 (mm) | Screws | Material | KG  |
| 300497                                                     | STMD PSC50 16-064 SL16 3C   | PSC50   | 16     | 20                     | 99      | 64       | M3X8   | Steel    | 0.5 |
| 300498                                                     | STMD PSC50 16-096 SL16 3C   | PSC50   | 16     | 20                     | 131     | 96       | M3X8   | Steel    | 0.7 |
| 300499                                                     | STMD PSC50 20-090 SL20 3C   | PSC50   | 20     | 25                     | 131     | 96       | M3X8   | Steel    | 0.7 |
| 300500                                                     | STMD PSC50 20-130 SL20 3C   | PSC50   | 20     | 25                     | 165     | 130      | M3X8   | Steel    | 0.9 |
| 300501                                                     | STMD PSC50 25-130 SL25 3C   | PSC50   | 25     | 32                     | 165     | 130      | M4X9   | Steel    | 1.0 |
| 300462                                                     | STMD PSC50 25-180 SL25 3C   | PSC50   | 25     | 32                     | 215     | 180      | M4X9   | Steel    | 1.2 |
| 300463                                                     | STMD PSC50 25-230 SL25 3C   | PSC50   | 25     | 32                     | 265     | 230      | M4X9   | Steel    | 1.4 |
| 300502                                                     | STMD PSC50 32-170 SL32 3C   | PSC50   | 32     | 40                     | 205     | 170      | M5X12  | Steel    | 1.4 |
| 300464                                                     | STMD PSC50 32-230 SL32 3C   | PSC50   | 32     | 40                     | 265     | 230      | M5X12  | Steel    | 1.8 |
| 300465                                                     | STMD PSC50 32-294 SL32 3C   | PSC50   | 32     | 40                     | 329     | 294      | M5X12  | Steel    | 2.4 |
| 300503                                                     | STMD PSC50 40-210 SL40 3C   | PSC50   | 40     | 50                     | 245     | 210      | M6X14  | Steel    | 2.2 |
| 300504                                                     | STMD PSC50 40-290 SL40 3C   | PSC50   | 40     | 50                     | 325     | 290      | M6x14  | Steel    | 3.6 |
| 300505                                                     | STMD PSC50 40-370 SL40 3C   | PSC50   | 40     | 50                     | 405     | 370      | M6x14  | Steel    | 4.2 |
| 301184                                                     | STMD PSC50 50-270 SL40 L 1C | PSC50   | 50     | 60                     | 305     | 270      | M6x14  | Steel    | 5.2 |
| 301185                                                     | STMD PSC50 50-370 SL40 L 1C | PSC50   | 50     | 60                     | 405     | 370      | M6x14  | Steel    | 7.1 |
| 301200                                                     | STMD PSC50 50-270 SL40 R 1C | PSC50   | 50     | 60                     | 305     | 270      | M6x14  | Steel    | 5.2 |
| 301201                                                     | STMD PSC50 50-370 SL40 R 1C | PSC50   | 50     | 60                     | 405     | 370      | M6x14  | Steel    | 7.1 |

<sup>d</sup> - estimated with using standard SDUCR cutter heads from MAQ.



Standard: PSC63 (with SL interface and exchangeable heads)

| Standard: PSC63 (with SL interface and exchangeable heads) |                                        |         |        |                        |         |          |        |          |                                                                                     |
|------------------------------------------------------------|----------------------------------------|---------|--------|------------------------|---------|----------|--------|----------|-------------------------------------------------------------------------------------|
| Part number                                                | Type                                   | Backend | D (mm) | Dmin (mm) <sup>d</sup> | LF (mm) | LB1 (mm) | Screws | Material |  |
| 300506                                                     | STMD PSC63 16-064 SL16 3C              | PSC63   | 16     | 20                     | 102     | 64       | M3X8   | Steel    | 1.0                                                                                 |
| 300507                                                     | STMD PSC63 16-096 SL16 3C              | PSC63   | 16     | 20                     | 134     | 96       | M3X8   | Steel    | 1.2                                                                                 |
| 300508                                                     | STMD PSC63 20-090 SL20 3C              | PSC63   | 20     | 20                     | 128     | 90       | M3X8   | Steel    | 1.0                                                                                 |
| 300509                                                     | STMD PSC63 20-130 SL20 3C              | PSC63   | 20     | 25                     | 168     | 130      | M3X8   | Steel    | 1.2                                                                                 |
| 300510                                                     | STMD PSC63 25-130 SL25 3C              | PSC63   | 25     | 32                     | 168     | 130      | M4X9   | Steel    | 1.5                                                                                 |
| 300511                                                     | STMD PSC63 25-180 SL25 3C              | PSC63   | 25     | 32                     | 218     | 180      | M4X9   | Steel    | 1.6                                                                                 |
| 300512                                                     | STMD PSC63 25-230 SL25 3C              | PSC63   | 25     | 32                     | 268     | 230      | M4X9   | Steel    | 1.7                                                                                 |
| 300513                                                     | STMD PSC63 32-170 SL32 3C              | PSC63   | 32     | 40                     | 208     | 170      | M5X12  | Steel    | 1.8                                                                                 |
| 300514                                                     | STMD PSC63 32-230 SL32 3C              | PSC63   | 32     | 40                     | 268     | 230      | M5X12  | Steel    | 2.2                                                                                 |
| 300515                                                     | STMD PSC63 32-294 SL32 3C              | PSC63   | 32     | 40                     | 332     | 294      | M5X12  | Steel    | 2.7                                                                                 |
| 300516                                                     | STMD PSC63 40-210 SL40 3C              | PSC63   | 40     | 50                     | 248     | 210      | M6X14  | Steel    | 2.6                                                                                 |
| 300517                                                     | STMD PSC63 40-290 SL40 3C              | PSC63   | 40     | 50                     | 328     | 290      | M6x14  | Steel    | 3.9                                                                                 |
| 300518                                                     | STMD PSC63 40-370 SL40 3C <sup>a</sup> | PSC63   | 40     | 50                     | 408     | 370      | M6x14  | Steel    | 4.2                                                                                 |
| 301186                                                     | STMD PSC63 50-270 SL40 L 1C            | PSC63   | 50     | 60                     | 308     | 270      | M6x14  | Steel    | 5.7                                                                                 |
| 301187                                                     | STMD PSC63 50-370 SL40 L 1C            | PSC63   | 50     | 60                     | 408     | 370      | M6x14  | Steel    | 7.6                                                                                 |
| 301188                                                     | STMD PSC63 50-470 SL40 L 1C            | PSC63   | 50     | 60                     | 508     | 470      | M6x14  | Steel    | 9.3                                                                                 |
| 301192                                                     | STMD PSC63 60-330 SL40 L 1C            | PSC63   | 60     | 70                     | 368     | 330      | M6x14  | Steel    | 8.0                                                                                 |
| 301193                                                     | STMD PSC63 60-450 SL40 L 1C            | PSC63   | 60     | 70                     | 488     | 450      | M6x14  | Steel    | 10.6                                                                                |
| 301202                                                     | STMD PSC63 50-270 SL40 R 1C            | PSC63   | 50     | 60                     | 308     | 270      | M6x14  | Steel    | 5.7                                                                                 |
| 301203                                                     | STMD PSC63 50-370 SL40 R 1C            | PSC63   | 50     | 60                     | 408     | 370      | M6x14  | Steel    | 7.6                                                                                 |
| 301204                                                     | STMD PSC63 50-470 SL40 R 1C            | PSC63   | 50     | 60                     | 508     | 470      | M6x14  | Steel    | 9.3                                                                                 |
| 301205                                                     | STMD PSC63 60-330 SL40 R 1C            | PSC63   | 60     | 70                     | 368     | 330      | M6x14  | Steel    | 8.0                                                                                 |
| 301206                                                     | STMD PSC63 60-450 SL40 R 1C            | PSC63   | 60     | 70                     | 488     | 450      | M6x14  | Steel    | 10.6                                                                                |

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| d - estimated with using standard SDUCR cutter heads from MAQ. |
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# Standard: PSC80 (with SL interface and exchangeable heads)

| Standard: PSC80 (with SL interface and exchangeable heads) |                                        |         |        |                        |         |          |        |          |                                                                                        |
|------------------------------------------------------------|----------------------------------------|---------|--------|------------------------|---------|----------|--------|----------|----------------------------------------------------------------------------------------|
| Part number                                                | Type                                   | Backend | D (mm) | Dmin (mm) <sup>d</sup> | LF (mm) | LB1 (mm) | Screws | Material |  KG |
| 300519                                                     | STMD PSC80 16-064 SL16 3C              | PSC80   | 16     | 20                     | 94      | 64       | M3X8   | Steel    | 1.1                                                                                    |
| 300520                                                     | STMD PSC80 16-096 SL16 3C              | PSC80   | 16     | 20                     | 126     | 96       | M3X8   | Steel    | 1.3                                                                                    |
| 300521                                                     | STMD PSC80 20-090 SL20 3C              | PSC80   | 20     | 25                     | 120     | 90       | M3X8   | Steel    | 1.4                                                                                    |
| 300522                                                     | STMD PSC80 20-130 SL20 3C              | PSC80   | 20     | 25                     | 160     | 130      | M3X8   | Steel    | 1.6                                                                                    |
| 300523                                                     | STMD PSC80 25-130 SL25 3C              | PSC80   | 25     | 32                     | 160     | 130      | M4X9   | Steel    | 2.0                                                                                    |
| 300524                                                     | STMD PSC80 25-180 SL25 3C              | PSC80   | 25     | 32                     | 210     | 180      | M4X9   | Steel    | 2.5                                                                                    |
| 300525                                                     | STMD PSC80 25-230 SL25 3C              | PSC80   | 25     | 32                     | 260     | 230      | M4X9   | Steel    | 3.0                                                                                    |
| 300526                                                     | STMD PSC80 32-170 SL32 3C              | PSC80   | 32     | 40                     | 200     | 170      | M5X12  | Steel    | 2.8                                                                                    |
| 300527                                                     | STMD PSC80 32-230 SL32 3C              | PSC80   | 32     | 40                     | 260     | 230      | M5X12  | Steel    | 3.6                                                                                    |
| 300528                                                     | STMD PSC80 32-294 SL32 3C              | PSC80   | 32     | 40                     | 324     | 294      | M5X12  | Steel    | 4.5                                                                                    |
| 300529                                                     | STMD PSC80 40-210 SL40 3C              | PSC80   | 40     | 50                     | 240     | 210      | M6X14  | Steel    | 3.7                                                                                    |
| 300530                                                     | STMD PSC80 40-290 SL40 3C              | PSC80   | 40     | 50                     | 320     | 290      | M6x14  | Steel    | 5.2                                                                                    |
| 300531                                                     | STMD PSC80 40-370 SL40 3C <sup>a</sup> | PSC80   | 40     | 50                     | 400     | 370      | M6x14  | Steel    | 5.4                                                                                    |
| 301189                                                     | STMD PSC80 50-270 SL40 L 1C            | PSC80   | 50     | 60                     | 302     | 270      | M6x14  | Steel    | 6.4                                                                                    |
| 301190                                                     | STMD PSC80 50-370 SL40 L 1C            | PSC80   | 50     | 60                     | 402     | 370      | M6x14  | Steel    | 8.3                                                                                    |
| 301191                                                     | STMD PSC80 50-470 SL40 L 1C            | PSC80   | 50     | 60                     | 502     | 470      | M6x14  | Steel    | 10.0                                                                                   |
| 301194                                                     | STMD PSC80 60-330 SL40 L 1C            | PSC80   | 60     | 70                     | 362     | 330      | M6x14  | Steel    | 8.7                                                                                    |
| 301195                                                     | STMD PSC80 60-450 SL40 L 1C            | PSC80   | 60     | 70                     | 482     | 450      | M6x14  | Steel    | 11.3                                                                                   |
| 301196                                                     | STMD PSC80 60-570 SL40 L 1C            | PSC80   | 60     | 70                     | 602     | 570      | M6x14  | Steel    | 13.2                                                                                   |
| 301207                                                     | STMD PSC80 50-270 SL40 R 1C            | PSC80   | 50     | 60                     | 302     | 270      | M6x14  | Steel    | 6.4                                                                                    |
| 301208                                                     | STMD PSC80 50-370 SL40 R 1C            | PSC80   | 50     | 60                     | 402     | 370      | M6x14  | Steel    | 8.3                                                                                    |
| 301209                                                     | STMD PSC80 50-470 SL40 R 1C            | PSC80   | 50     | 60                     | 502     | 470      | M6x14  | Steel    | 10.0                                                                                   |
| 301210                                                     | STMD PSC80 60-330 SL40 R 1C            | PSC80   | 60     | 70                     | 362     | 330      | M6x14  | Steel    | 8.7                                                                                    |
| 301211                                                     | STMD PSC80 60-450 SL40 R 1C            | PSC80   | 60     | 70                     | 482     | 450      | M6x14  | Steel    | 11.3                                                                                   |
| 301212                                                     | STMD PSC80 60-570 SL40 R 1C            | PSC80   | 60     | 70                     | 602     | 570      | M6x14  | Steel    | 13.2                                                                                   |
| 301197                                                     | STMD PSC80 80-450 SL40 LR 1C           | PSC80   | 80     | 90                     | 482     | 450      | M6x14  | Steel    | 12.1                                                                                   |
| 301198                                                     | STMD PSC80 80-610 SL40 LR 1C           | PSC80   | 80     | 90                     | 642     | 610      | M6x14  | Steel    | 18.2                                                                                   |
| 301199                                                     | STMD PSC80 80-740 SL40 LR 1C           | PSC80   | 80     | 90                     | 772     | 740      | M6x14  | Steel    | 20.6                                                                                   |

<sup>d</sup> - estimated with using standard SDUCR cutter heads from MAQ.

## Standard: HSK63T (with SL interface and exchangeable heads)

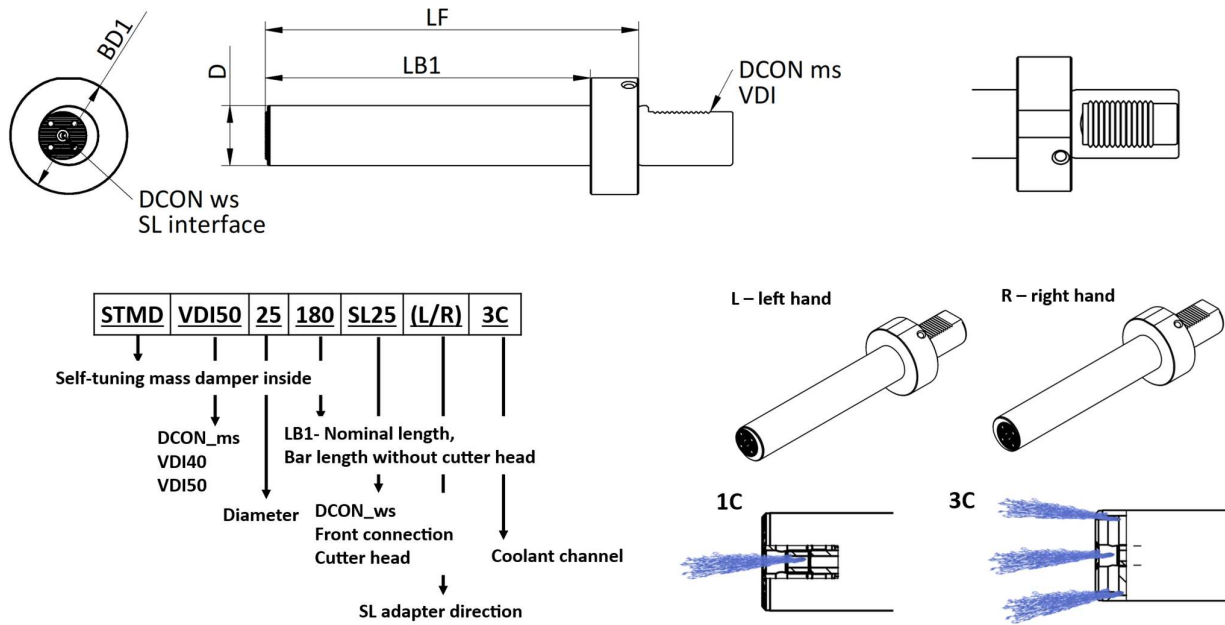
| Standard: HSK63T (with SL interface and exchangeable heads) |                                         |         |        |                        |         |          |        |          |     |
|-------------------------------------------------------------|-----------------------------------------|---------|--------|------------------------|---------|----------|--------|----------|-----|
| Part number                                                 | Type                                    | Backend | D (mm) | Dmin (mm) <sup>d</sup> | LF (mm) | LB1 (mm) | Screws | Material | KG  |
| 300532                                                      | STMD HSK63T 16-064 SL16 3C              | HSK63   | 16     | 20                     | 120     | 64       | M3X8   | Steel    | 1.0 |
| 300533                                                      | STMD HSK63T 16-096 SL16 3C              | HSK63   | 16     | 20                     | 152     | 96       | M3X8   | Steel    | 1.2 |
| 300534                                                      | STMD HSK63T 20-090 SL20 3C              | HSK63   | 20     | 25                     | 146     | 90       | M3X8   | Steel    | 1.0 |
| 300535                                                      | STMD HSK63T 20-130 SL20 3C              | HSK63   | 20     | 25                     | 186     | 130      | M3X8   | Steel    | 1.2 |
| 300536                                                      | STMD HSK63T 25-130 SL25 3C              | HSK63   | 25     | 32                     | 186     | 130      | M4X9   | Steel    | 1.5 |
| 300537                                                      | STMD HSK63T 25-180 SL25 3C              | HSK63   | 25     | 32                     | 236     | 180      | M4X9   | Steel    | 1.6 |
| 300538                                                      | STMD HSK63T 25-230 SL25 3C              | HSK63   | 25     | 32                     | 286     | 230      | M4X9   | Steel    | 1.7 |
| 300539                                                      | STMD HSK63T 32-170 SL32 3C              | HSK63   | 32     | 40                     | 226     | 170      | M5X12  | Steel    | 1.8 |
| 300540                                                      | STMD HSK63T 32-230 SL32 3C              | HSK63   | 32     | 40                     | 286     | 230      | M5X12  | Steel    | 2.2 |
| 300541                                                      | STMD HSK63T 32-294 SL32 3C              | HSK63   | 32     | 40                     | 350     | 294      | M5X12  | Steel    | 2.7 |
| 300542                                                      | STMD HSK63T 40-210 SL40 3C              | HSK63   | 40     | 50                     | 266     | 210      | M6X14  | Steel    | 2.6 |
| 300543                                                      | STMD HSK63T 40-290 SL40 3C              | HSK63   | 40     | 50                     | 346     | 290      | M6x14  | Steel    | 3.9 |
| 300544                                                      | STMD HSK63T 40-370 SL40 3C <sup>a</sup> | HSK63   | 40     | 50                     | 426     | 370      | M6x14  | Steel    | 4.2 |

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| d - estimated with using standard SDUCR cutter heads from MAQ. |
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## Standard: KM63 XMZ (with SL interface and exchangeable heads)

| Standard: KM63 XMZ (with SL interface and exchangeable heads) |                                |          |        |                        |         |          |        |          |      |
|---------------------------------------------------------------|--------------------------------|----------|--------|------------------------|---------|----------|--------|----------|------|
| Part number                                                   | Type                           | Backend  | D (mm) | Dmin (mm) <sup>d</sup> | LF (mm) | LB1 (mm) | Screws | Material | KG   |
| 301380                                                        | STMD KM63 XMZ 16-064 SL16 3C   | KM63 XMZ | 16     | 20                     | 109     | 64       | M3X8   | Steel    | 1.0  |
| 301381                                                        | STMD KM63 XMZ 16-096 SL16 3C   | KM63 XMZ | 16     | 20                     | 141     | 96       | M3X8   | Steel    | 1.2  |
| 301382                                                        | STMD KM63 XMZ 20-090 SL20 3C   | KM63 XMZ | 20     | 25                     | 135     | 90       | M3X8   | Steel    | 1.0  |
| 301383                                                        | STMD KM63 XMZ 20-130 SL20 3C   | KM63 XMZ | 20     | 25                     | 175     | 130      | M3X8   | Steel    | 1.2  |
| 301384                                                        | STMD KM63 XMZ 25-130 SL25 3C   | KM63 XMZ | 25     | 32                     | 175     | 130      | M4X9   | Steel    | 1.5  |
| 301385                                                        | STMD KM63 XMZ 25-180 SL25 3C   | KM63 XMZ | 25     | 32                     | 225     | 180      | M4X9   | Steel    | 1.6  |
| 301386                                                        | STMD KM63 XMZ 25-230 SL25 3C   | KM63 XMZ | 25     | 32                     | 275     | 230      | M4X9   | Steel    | 1.7  |
| 301387                                                        | STMD KM63 XMZ 32-170 SL32 3C   | KM63 XMZ | 32     | 40                     | 215     | 170      | M5X12  | Steel    | 1.8  |
| 301388                                                        | STMD KM63 XMZ 32-230 SL32 3C   | KM63 XMZ | 32     | 40                     | 275     | 230      | M5X12  | Steel    | 2.2  |
| 301389                                                        | STMD KM63 XMZ 32-294 SL32 3C   | KM63 XMZ | 32     | 40                     | 339     | 294      | M5X12  | Steel    | 2.7  |
| 301390                                                        | STMD KM63 XMZ 40-210 SL40 3C   | KM63 XMZ | 40     | 50                     | 255     | 210      | M6X14  | Steel    | 2.6  |
| 301391                                                        | STMD KM63 XMZ 40-290 SL40 3C   | KM63 XMZ | 40     | 50                     | 335     | 290      | M6x14  | Steel    | 3.9  |
| 301392                                                        | STMD KM63 XMZ 40-370 SL40 3Ca  | KM63 XMZ | 40     | 50                     | 415     | 370      | M6x14  | Steel    | 4.2  |
| 301393                                                        | STMD KM63 XMZ 50-270 SL40 L 1C | KM63 XMZ | 50     | 60                     | 315     | 270      | M6x14  | Steel    | 5.7  |
| 301394                                                        | STMD KM63 XMZ 50-370 SL40 L 1C | KM63 XMZ | 50     | 60                     | 415     | 370      | M6x14  | Steel    | 7.6  |
| 301395                                                        | STMD KM63 XMZ 50-470 SL40 L 1C | KM63 XMZ | 50     | 60                     | 515     | 470      | M6x14  | Steel    | 9.3  |
| 301396                                                        | STMD KM63 XMZ 60-330 SL40 L 1C | KM63 XMZ | 60     | 70                     | 375     | 330      | M6x14  | Steel    | 8.0  |
| 301397                                                        | STMD KM63 XMZ 60-450 SL40 L 1C | KM63 XMZ | 60     | 70                     | 495     | 450      | M6x14  | Steel    | 10.6 |
| 301398                                                        | STMD KM63 XMZ 50-270 SL40 R 1C | KM63 XMZ | 50     | 60                     | 315     | 270      | M6x14  | Steel    | 5.7  |
| 301399                                                        | STMD KM63 XMZ 50-370 SL40 R 1C | KM63 XMZ | 50     | 60                     | 415     | 370      | M6x14  | Steel    | 7.6  |
| 301400                                                        | STMD KM63 XMZ 50-470 SL40 R 1C | KM63 XMZ | 50     | 60                     | 515     | 470      | M6x14  | Steel    | 9.3  |
| 301401                                                        | STMD KM63 XMZ 60-330 SL40 R 1C | KM63 XMZ | 60     | 70                     | 375     | 330      | M6x14  | Steel    | 8.0  |
| 301402                                                        | STMD KM63 XMZ 60-450 SL40 R 1C | KM63 XMZ | 60     | 70                     | 495     | 450      | M6x14  | Steel    | 10.6 |

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| d - estimated with using standard SDUCR cutter heads from MAQ. |
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Standard: VDI30 (with SL interface and exchangeable heads)

| Standard: VDI30 (with SL interface and exchangeable heads) |                           |         |        |                        |         |          |        |          |     |  |
|------------------------------------------------------------|---------------------------|---------|--------|------------------------|---------|----------|--------|----------|-----|--|
| Part number                                                | Type                      | Backend | D (mm) | Dmin (mm) <sup>d</sup> | LF (mm) | LB1 (mm) | Screws | Material | KG  |  |
| 301405                                                     | STMD VDI30 25-130 SL25 3C | VDI30   | 25     | 32                     | 168     | 130      | M4X9   | Steel    | 2.0 |  |
| 301406                                                     | STMD VDI30 25-180 SL25 3C | VDI30   | 25     | 32                     | 218     | 180      | M4X9   | Steel    | 2.5 |  |
| 301407                                                     | STMD VDI30 25-230 SL25 3C | VDI30   | 25     | 32                     | 268     | 230      | M4X9   | Steel    | 3.0 |  |
| 301408                                                     | STMD VDI30 32-170 SL32 3C | VDI30   | 32     | 40                     | 208     | 170      | M5X12  | Steel    | 2.8 |  |
| 301409                                                     | STMD VDI30 32-230 SL32 3C | VDI30   | 32     | 40                     | 268     | 230      | M5X12  | Steel    | 3.6 |  |
| 301410                                                     | STMD VDI30 32-294 SL32 3C | VDI30   | 32     | 40                     | 332     | 294      | M5X12  | Steel    | 4.5 |  |
| 301411                                                     | STMD VDI30 40-210 SL40 3C | VDI30   | 40     | 50                     | 248     | 210      | M6X14  | Steel    | 3.7 |  |
| 301412                                                     | STMD VDI30 40-290 SL40 3C | VDI30   | 40     | 50                     | 328     | 290      | M6x14  | Steel    | 5.2 |  |

Standard: VDI40 (with SL interface and exchangeable heads)

| Standard: VDI40 (with SL interface and exchangeable heads) |                              |         |        |                        |         |          |        |          |                                                                                     |
|------------------------------------------------------------|------------------------------|---------|--------|------------------------|---------|----------|--------|----------|-------------------------------------------------------------------------------------|
| Part number                                                | Type                         | Backend | D (mm) | Dmin (mm) <sup>d</sup> | LF (mm) | LB1 (mm) | Screws | Material |  |
| 301297                                                     | STMD VDI40 25-130 SL25 3C    | VDI40   | 25     | 32                     | 170     | 130      | M4X9   | Steel    | 2.0                                                                                 |
| 301298                                                     | STMD VDI40 25-180 SL25 3C    | VDI40   | 25     | 32                     | 220     | 180      | M4X9   | Steel    | 2.5                                                                                 |
| 301299                                                     | STMD VDI40 25-230 SL25 3C    | VDI40   | 25     | 32                     | 270     | 230      | M4X9   | Steel    | 3.0                                                                                 |
| 301300                                                     | STMD VDI40 32-170 SL32 3C    | VDI40   | 32     | 40                     | 210     | 170      | M5X12  | Steel    | 2.8                                                                                 |
| 301301                                                     | STMD VDI40 32-230 SL32 3C    | VDI40   | 32     | 40                     | 270     | 230      | M5X12  | Steel    | 3.6                                                                                 |
| 301302                                                     | STMD VDI40 32-294 SL32 3C    | VDI40   | 32     | 40                     | 334     | 294      | M5X12  | Steel    | 4.5                                                                                 |
| 301303                                                     | STMD VDI40 40-210 SL40 3C    | VDI40   | 40     | 50                     | 250     | 210      | M6X14  | Steel    | 3.7                                                                                 |
| 301304                                                     | STMD VDI40 40-290 SL40 3C    | VDI40   | 40     | 50                     | 330     | 290      | M6x14  | Steel    | 5.2                                                                                 |
| 301305                                                     | STMD VDI40 40-370 SL40 3C    | VDI40   | 40     | 50                     | 410     | 370      | M6x14  | Steel    | 5.4                                                                                 |
| 301306                                                     | STMD VDI40 50-270 SL40 L 1C  | VDI40   | 50     | 60                     | 310     | 270      | M6x14  | Steel    | 6.4                                                                                 |
| 301307                                                     | STMD VDI40 50-370 SL40 L 1C  | VDI40   | 50     | 60                     | 410     | 370      | M6x14  | Steel    | 8.3                                                                                 |
| 301308                                                     | STMD VDI40 50-470 SL40 L 1C  | VDI40   | 50     | 60                     | 510     | 470      | M6x14  | Steel    | 10.0                                                                                |
| 301309                                                     | STMD VDI40 60-330 SL40 L 1C  | VDI40   | 60     | 70                     | 370     | 330      | M6x14  | Steel    | 8.7                                                                                 |
| 301310                                                     | STMD VDI40 60-450 SL40 L 1C  | VDI40   | 60     | 70                     | 490     | 450      | M6x14  | Steel    | 11.3                                                                                |
| 301311                                                     | STMD VDI40 60-570 SL40 L 1C  | VDI40   | 60     | 70                     | 610     | 570      | M6x14  | Steel    | 13.2                                                                                |
| 301312                                                     | STMD VDI40 50-270 SL40 R 1C  | VDI40   | 50     | 60                     | 310     | 270      | M6x14  | Steel    | 6.4                                                                                 |
| 301313                                                     | STMD VDI40 50-370 SL40 R 1C  | VDI40   | 50     | 60                     | 410     | 370      | M6x14  | Steel    | 8.3                                                                                 |
| 301314                                                     | STMD VDI40 50-470 SL40 R 1C  | VDI40   | 50     | 60                     | 510     | 470      | M6x14  | Steel    | 10.0                                                                                |
| 301315                                                     | STMD VDI40 60-330 SL40 R 1C  | VDI40   | 60     | 70                     | 370     | 330      | M6x14  | Steel    | 8.7                                                                                 |
| 301316                                                     | STMD VDI40 60-450 SL40 R 1C  | VDI40   | 60     | 70                     | 490     | 450      | M6x14  | Steel    | 11.3                                                                                |
| 301317                                                     | STMD VDI40 60-570 SL40 R 1C  | VDI40   | 60     | 70                     | 610     | 570      | M6x14  | Steel    | 13.2                                                                                |
| 301318                                                     | STMD VDI40 80-450 SL40 LR 1C | VDI40   | 80     | 90                     | 490     | 450      | M6x14  | Steel    | 12.1                                                                                |
| 301319                                                     | STMD VDI40 80-610 SL40 LR 1C | VDI40   | 80     | 90                     | 650     | 610      | M6x14  | Steel    | 18.2                                                                                |
| 301320                                                     | STMD VDI40 80-740 SL40 LR 1C | VDI40   | 80     | 90                     | 780     | 740      | M6x14  | Steel    | 20.6                                                                                |

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| d - estimated with using standard SDUCR cutter heads from MAQ. |
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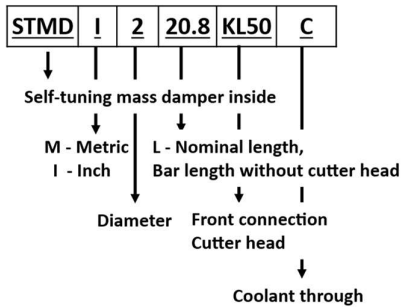
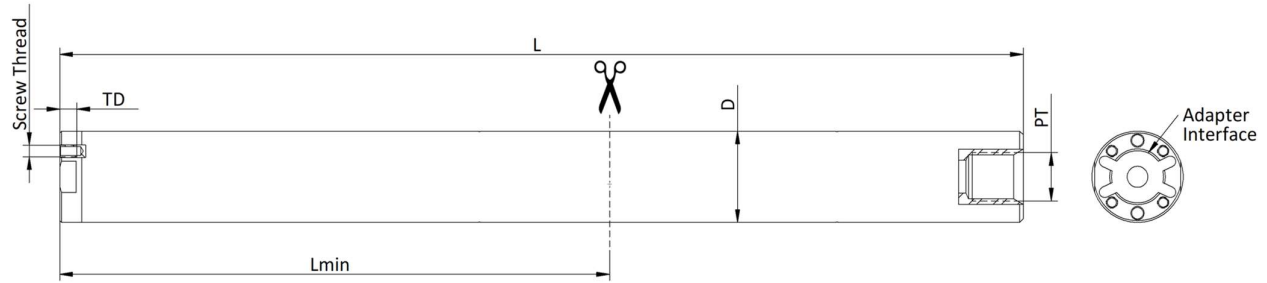
# Standard: VDI50 (with SL interface and exchangeable heads)

| Standard: VDI50 (with SL interface and exchangeable heads) |                              |         |        |                        |         |          |        |          |                                                                                     |
|------------------------------------------------------------|------------------------------|---------|--------|------------------------|---------|----------|--------|----------|-------------------------------------------------------------------------------------|
| Part number                                                | Type                         | Backend | D (mm) | Dmin (mm) <sup>d</sup> | LF (mm) | LB1 (mm) | Screws | Material |  |
| 301321                                                     | STMD VDI50 25-130 SL25 3C    | VDI50   | 25     | 32                     | 170     | 130      | M4X9   | Steel    | 2.0                                                                                 |
| 301322                                                     | STMD VDI50 25-180 SL25 3C    | VDI50   | 25     | 32                     | 220     | 180      | M4X9   | Steel    | 2.5                                                                                 |
| 301323                                                     | STMD VDI50 25-230 SL25 3C    | VDI50   | 25     | 32                     | 270     | 230      | M4X9   | Steel    | 3.0                                                                                 |
| 301324                                                     | STMD VDI50 32-170 SL32 3C    | VDI50   | 32     | 40                     | 210     | 170      | M5X12  | Steel    | 2.8                                                                                 |
| 301325                                                     | STMD VDI50 32-230 SL32 3C    | VDI50   | 32     | 40                     | 270     | 230      | M5X12  | Steel    | 3.6                                                                                 |
| 301326                                                     | STMD VDI50 32-294 SL32 3C    | VDI50   | 32     | 40                     | 334     | 294      | M5X12  | Steel    | 4.5                                                                                 |
| 301327                                                     | STMD VDI50 40-210 SL40 3C    | VDI50   | 40     | 50                     | 250     | 210      | M6X14  | Steel    | 3.7                                                                                 |
| 301328                                                     | STMD VDI50 40-290 SL40 3C    | VDI50   | 40     | 50                     | 330     | 290      | M6X14  | Steel    | 5.2                                                                                 |
| 301329                                                     | STMD VDI50 40-370 SL40 3C    | VDI50   | 40     | 50                     | 410     | 370      | M6X14  | Steel    | 5.4                                                                                 |
| 301330                                                     | STMD VDI50 50-270 SL40 L 1C  | VDI50   | 50     | 60                     | 310     | 270      | M6X14  | Steel    | 6.4                                                                                 |
| 301331                                                     | STMD VDI50 50-370 SL40 L 1C  | VDI50   | 50     | 60                     | 410     | 370      | M6X14  | Steel    | 8.3                                                                                 |
| 301332                                                     | STMD VDI50 50-470 SL40 L 1C  | VDI50   | 50     | 60                     | 510     | 470      | M6X14  | Steel    | 10.0                                                                                |
| 301333                                                     | STMD VDI50 60-330 SL40 L 1C  | VDI50   | 60     | 70                     | 370     | 330      | M6X14  | Steel    | 8.7                                                                                 |
| 301334                                                     | STMD VDI50 60-450 SL40 L 1C  | VDI50   | 60     | 70                     | 490     | 450      | M6X14  | Steel    | 11.3                                                                                |
| 301335                                                     | STMD VDI50 60-570 SL40 L 1C  | VDI50   | 60     | 70                     | 610     | 570      | M6X14  | Steel    | 13.2                                                                                |
| 301336                                                     | STMD VDI50 50-270 SL40 R 1C  | VDI50   | 50     | 60                     | 310     | 270      | M6X14  | Steel    | 6.4                                                                                 |
| 301337                                                     | STMD VDI50 50-370 SL40 R 1C  | VDI50   | 50     | 60                     | 410     | 370      | M6X14  | Steel    | 8.3                                                                                 |
| 301338                                                     | STMD VDI50 50-470 SL40 R 1C  | VDI50   | 50     | 60                     | 510     | 470      | M6X14  | Steel    | 10.0                                                                                |
| 301339                                                     | STMD VDI50 60-330 SL40 R 1C  | VDI50   | 60     | 70                     | 370     | 330      | M6X14  | Steel    | 8.7                                                                                 |
| 301340                                                     | STMD VDI50 60-450 SL40 R 1C  | VDI50   | 60     | 70                     | 490     | 450      | M6X14  | Steel    | 11.3                                                                                |
| 301341                                                     | STMD VDI50 60-570 SL40 R 1C  | VDI50   | 60     | 70                     | 610     | 570      | M6X14  | Steel    | 13.2                                                                                |
| 301342                                                     | STMD VDI50 80-450 SL40 LR 1C | VDI50   | 80     | 90                     | 490     | 450      | M6X14  | Steel    | 12.1                                                                                |
| 301343                                                     | STMD VDI50 80-610 SL40 LR 1C | VDI50   | 80     | 90                     | 650     | 610      | M6X14  | Steel    | 18.2                                                                                |
| 301344                                                     | STMD VDI50 80-740 SL40 LR 1C | VDI50   | 80     | 90                     | 780     | 740      | M6X14  | Steel    | 20.6                                                                                |

|                                                                |
|----------------------------------------------------------------|
| d - estimated with using standard SDUCR cutter heads from MAQ. |
|----------------------------------------------------------------|

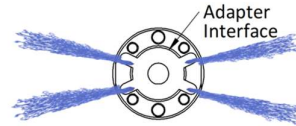
V

## Tools with KL interface



L – nominal length  
Lmin – minimum total length after cutting  
Lc – recommended clamping length, 3 times diameter  
D – diameter  
PT – pipe thread  
TD – thread depth

C – Coolant through



| Standard: Metric (with KL interface and exchangeable heads) |                                    |                                   |                         |           |         |                |         |       |          |      |
|-------------------------------------------------------------|------------------------------------|-----------------------------------|-------------------------|-----------|---------|----------------|---------|-------|----------|------|
| Part number                                                 | Type                               | Workable length <sup>c</sup> (mm) | D min (mm) <sup>g</sup> | Lmin (mm) | Lc (mm) | Screws         | TD (mm) | PT    | Material | KG   |
| 300648                                                      | STMD M50-528-KL50 C <sup>a,b</sup> | 300-400                           | 60                      | 322       | 150     | 1/4"-20 x 1/2  | 9       | G 3/4 | Steel    | 8.0  |
| 300649                                                      | STMD M60-642-KL60 C <sup>a,b</sup> | 360-480                           | 70                      | 422       | 180     | 5/16"-18 x 1/2 | 12      | G 3/4 | Steel    | 13.6 |

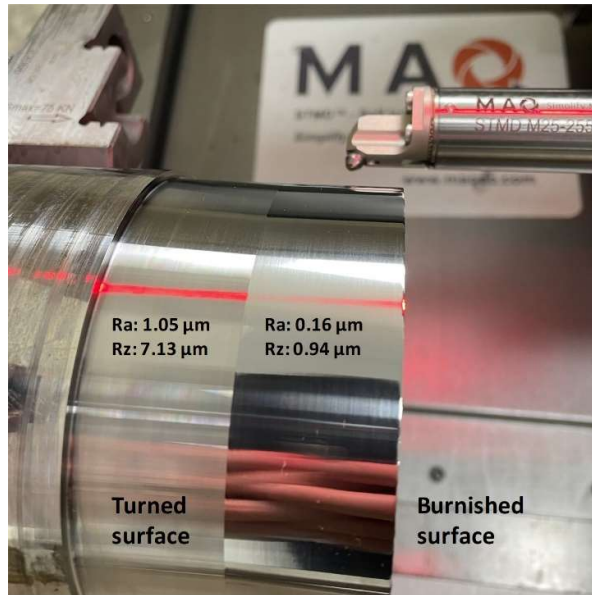
| Standard: Inch (with KL interface and exchangeable heads) |                                         |                                     |                           |             |           |                |         |       |          |      |
|-----------------------------------------------------------|-----------------------------------------|-------------------------------------|---------------------------|-------------|-----------|----------------|---------|-------|----------|------|
| Part number                                               | Type                                    | Workable length <sup>c</sup> (inch) | D min (inch) <sup>g</sup> | Lmin (inch) | Lc (inch) | Screws         | TD (mm) | PT    | Material | KG   |
| 300650                                                    | STMD I 2-20.8-KL50 C <sup>a,b</sup>     | 12.000-16.000                       | 2.362                     | 12.7        | 5.90      | 1/4"-20 x 1/2  | 9       | G 3/4 | Steel    | 8.0  |
| 300651                                                    | STMD I 2 1/2-25.3-KL60 C <sup>a,b</sup> | 15.000-20.000                       | 2.756                     | 16.7        | 7.10      | 5/16"-18 x 1/2 | 12      | G 3/4 | Steel    | 13.6 |

| Standard: Metric (with KL interface and exchangeable heads) |                                    |                                   |                         |           |         |                |         |       |          |      |
|-------------------------------------------------------------|------------------------------------|-----------------------------------|-------------------------|-----------|---------|----------------|---------|-------|----------|------|
| Part number                                                 | Type                               | Workable length <sup>c</sup> (mm) | D min (mm) <sup>g</sup> | Lmin (mm) | Lc (mm) | Screws         | TD (mm) | PT    | Material | KG   |
| 300646                                                      | STMD M50-670-KL50 C <sup>a,b</sup> | 400-550                           | 60                      | 384       | 150     | 1/4"-20 x 1/2  | 9       | G 3/4 | Steel    | 9.4  |
| 300647                                                      | STMD M60-822-KL60 C <sup>a,b</sup> | 480-660                           | 70                      | 484       | 180     | 5/16"-18 x 1/2 | 12      | G 3/4 | Steel    | 16.4 |

| Standard: Inch (with KL interface and exchangeable heads) |                                         |                                     |                           |             |           |                |         |       |          |      |
|-----------------------------------------------------------|-----------------------------------------|-------------------------------------|---------------------------|-------------|-----------|----------------|---------|-------|----------|------|
| Part number                                               | Type                                    | Workable length <sup>c</sup> (inch) | D min (inch) <sup>g</sup> | Lmin (inch) | Lc (inch) | Screws         | TD (mm) | PT    | Material | KG   |
| 300637                                                    | STMD I 2-26.4-KL50 C <sup>a,b</sup>     | 16.000-22.000                       | 2.362                     | 15.0        | 5.90      | 1/4"-20 x 1/2  | 9       | G 3/4 | Steel    | 9.4  |
| 300638                                                    | STMD I 2 1/2-32.4-KL60 C <sup>a,b</sup> | 20.000-27.500                       | 2.756                     | 19.1        | 7.10      | 5/16"-18 x 1/2 | 12      | G 3/4 | Steel    | 16.4 |

|                                                                                                                                                                                                       |  |  |  |  |  |  |  |  |  |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|--|--|--|--|--|--|--|
| <p>a – delivery time 3 weeks</p> <p>b – exchangeable to KM Lock interface</p> <p>c – measured from the cutting edge to the clamping.</p> <p>g – estimated with standard KM Lock SDUCR cutter head</p> |  |  |  |  |  |  |  |  |  |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|--|--|--|--|--|--|--|

## Burnishing



### **Mirror surface finish in one pass, up to 15xD!**

The MAQ diamond burnishing tool works on carbon steel, tool steel, cast iron, ferrous and non-ferrous (P, M, K, N, S) materials.

Suggested starting machining parameter to all materials:

- Interference with workpiece material 0.05-0.2 mm (0.002-0.003 inch)
- Cutting speed 60-230 m/min (200-750 SFM)
- Feed rate 0.08-0.15 mm/rev (0.003-0.006 IPR)

We recommend a feed rate at 70% of the feed rate in previous turning operation.

We recommend start with interference of 0.1 mm (0.004  $\mu\text{inch}$ ) and increase the interference if the surface finish is not reached.

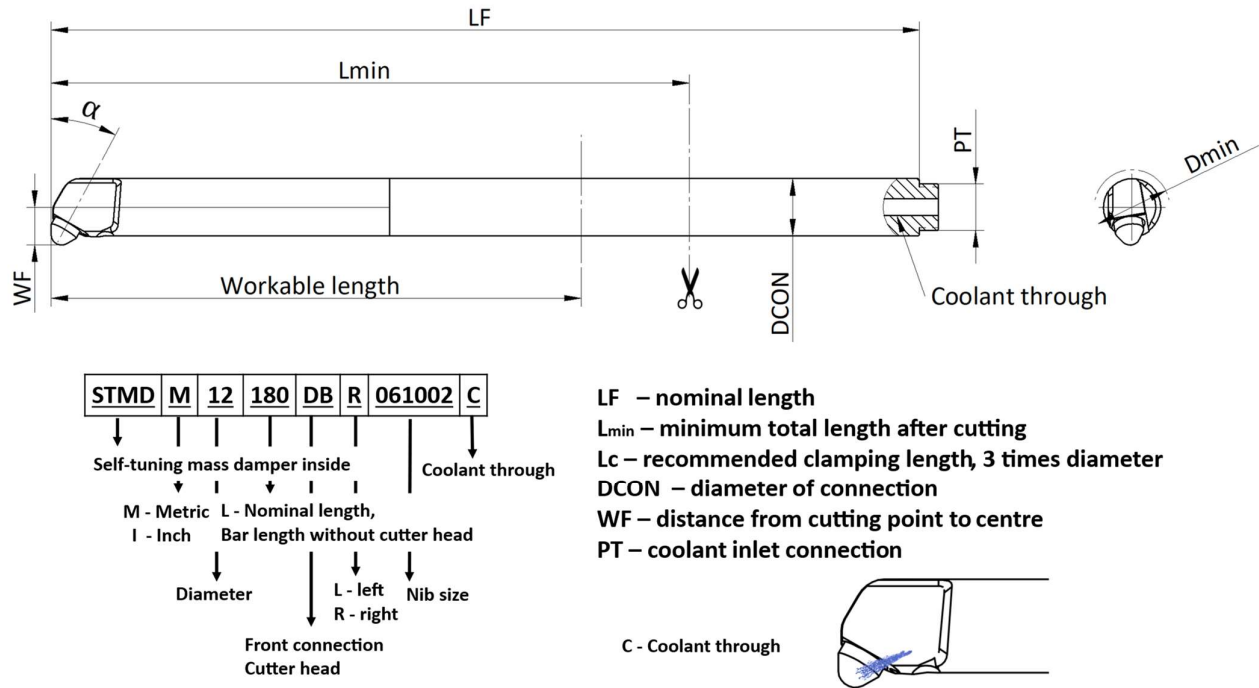
Recommended surface finish prior burnishing operation is  $Ra < 1.6 \mu\text{m}$  (64  $\mu\text{inch}$ ). After burnishing, the surface finish can normally reach  $Ra < 0.3 \mu\text{m}$ .

Diamond burnishing works well on STMD tools and can reach mirror surface finish up to 15xD setup.

Note: diamond burnishing normally has negligible impact on the size of the bore. A typical bore size change in burnishing of high alloy steel 4340 is within 10-15  $\mu\text{m}$  (0.0004-0.0006 inch).



## Diamond burnishing tools – Monoblock

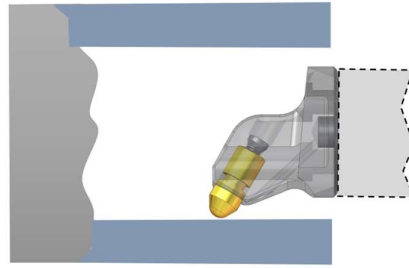
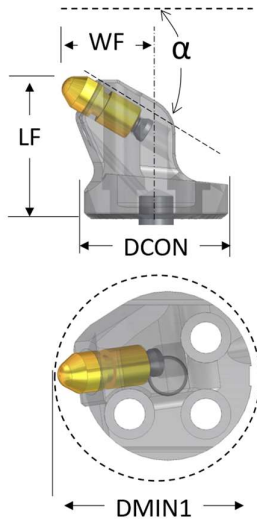


| Standard: Metric (with fixed head) |                          |                                   |           |                        |         |                      |       |          |       |            |              |                  |      |
|------------------------------------|--------------------------|-----------------------------------|-----------|------------------------|---------|----------------------|-------|----------|-------|------------|--------------|------------------|------|
| Part number                        | Type                     | Workable length <sup>b</sup> (mm) | Dmin (mm) | Lmin <sup>a</sup> (mm) | Lc (mm) | WF <sup>c</sup> (mm) | α (°) | LAMS (°) | PT    | Master nib | Insert screw | Material         | KG   |
| 301355                             | STMD M12-180 DB R 061002 | 72-132                            | 16        | 180                    | 36      | 8                    | 30    | 10       | G1/8  | DB 061002  | IS M3x6      | S+C <sup>d</sup> | 0.30 |
| 301356                             | STMD M16-224 DB R 061002 | 96-176                            | 20        | 224                    | 48      | 10                   | 30    | 9        | M12x1 | DB 061002  | IS M3x6      | S+C <sup>d</sup> | 0.55 |

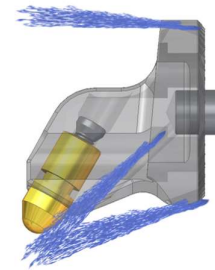
| Standard: Inch (with fixed head) |                            |                                     |             |                          |           |                        |       |          |       |            |              |                  |      |
|----------------------------------|----------------------------|-------------------------------------|-------------|--------------------------|-----------|------------------------|-------|----------|-------|------------|--------------|------------------|------|
| Part number                      | Type                       | Workable length <sup>b</sup> (inch) | Dmin (inch) | Lmin <sup>a</sup> (inch) | Lc (inch) | WF <sup>c</sup> (inch) | α (°) | LAMS (°) | PT    | Master nib | Insert screw | Material         | KG   |
| 301357                           | STMD i 1/2-7.1 DB R 061002 | 3-5.5                               | 0.63        | 7.1                      | 1.5       | 0.31                   | 30    | 10       | G1/8  | DB 061002  | IS M3x6      | S+C <sup>d</sup> | 0.30 |
| 301358                           | STMD i 5/8-8.8 DB R 061002 | 3.75-6.88                           | 0.79        | 8.8                      | 1.88      | 0.39                   | 30    | 9        | M12x1 | DB 061002  | IS M3x6      | S+C <sup>d</sup> | 0.55 |

|                                                                                                |
|------------------------------------------------------------------------------------------------|
| a – total length to the cutting point                                                          |
| b – measured from the cutting edge to the clamping                                             |
| c – distance from cutting point to centre                                                      |
| d – Carbide back end joined with steel                                                         |
| All burnishing tools are delivered with the burnishing nib (artificial diamond) and nib screw. |

## Diamond burnishing heads



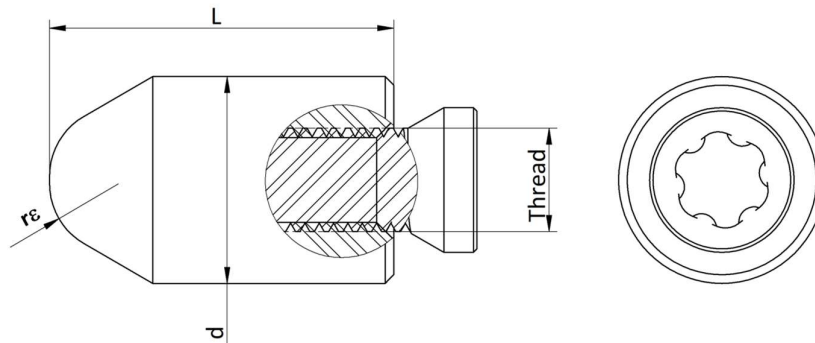
CP – Central and Peripheral coolant



| Part Number | Type         | DCON (mm) | DMIN1 (mm) | LF (mm) | WF (mm) | $\alpha$ (°) | LAMS (°) | Burnishing Nib | Nib screw | KG   |
|-------------|--------------|-----------|------------|---------|---------|--------------|----------|----------------|-----------|------|
| 300631      | SL20 DB R CP | SL 20     | 24         | 21      | 12      | 30           | 11       | DB 061402      | IS M3x6   | 0.02 |
| 300632      | SL25 DB R CP | SL 25     | 30         | 25      | 16      | 30           | 8        | DB 061402      | IS M3x6   | 0.04 |
| 300633      | SL32 DB R CP | SL 32     | 38         | 33      | 20      | 30           | 7        | DB 061402      | IS M3x6   | 0.07 |
| 300634      | SL40 DB R CP | SL 40     | 46         | 34      | 24      | 30           | 10       | DB 061402      | IS M3x6   | 0.14 |

All burnishing heads are delivered with the burnishing nib (artificial diamond) and nib screw.

## Diamond burnishing nibs

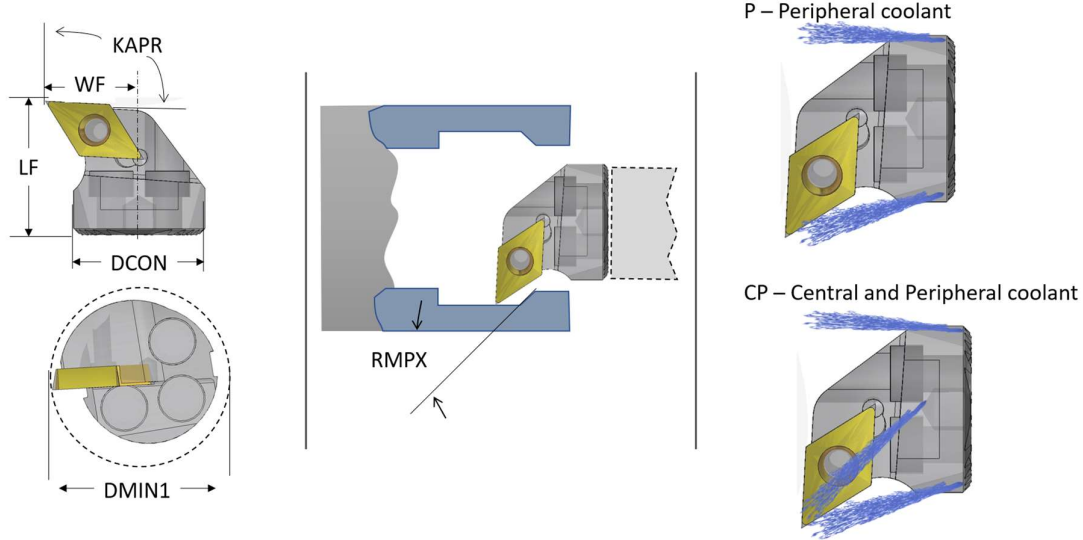


| Part Number | Nib Type               | d | L  | rε | Thread | P | M | K | H | S | N |
|-------------|------------------------|---|----|----|--------|---|---|---|---|---|---|
| 301379      | DB 061002 - Artificial | 6 | 10 | 2  | M3     | ● | ● | ● | ● | ● | ● |
| 300630      | DB 061402 - Artificial | 6 | 14 | 2  | M3     | ● | ● | ● | ● | ● | ● |
| 301541      | DB 061002 - Natural    | 6 | 10 | 2  | M3     | ● | ● | ● | ● | ● | ● |
| 301542      | DB 061402 - Natural    | 6 | 14 | 2  | M3     | ● | ● | ● | ● | ● | ● |

Natural diamond has longer life time and is more wear resistance comparing to artificial diamond.

## End-effecters

### SDUCR, SDUCL for DCMT Inserts



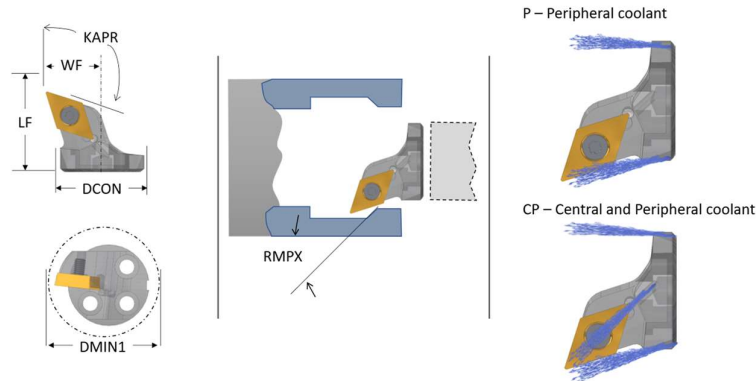
| Part Number | Type                            | DMIN1 (mm) | LF (mm) | WF (mm) | KAPR (°) | RMPX (°) | LAMS (°) | GAMO (°) | Master insert | Insert screw | KG   |
|-------------|---------------------------------|------------|---------|---------|----------|----------|----------|----------|---------------|--------------|------|
| 300118      | SL12 SDUCL P <sup>a</sup>       | 16         | 14      | 9       | 93       | 30       | -8       | 0        | DCMT 070204   | IS M2.5x6.0  | 0.01 |
| 300059      | SL12 SDUCR P <sup>a</sup>       | 16         | 14      | 9       | 93       | 30       | -8       | 0        | DCMT 070204   | IS M2.5x6.0  | 0.01 |
| 300119      | SL16 SDUCL P <sup>a</sup>       | 20         | 17      | 11      | 93       | 30       | -6       | 0        | DCMT 070204   | IS M2.5x6.0  | 0.01 |
| 300060      | SL16 SDUCR P <sup>a</sup>       | 20         | 17      | 11      | 93       | 30       | -6       | 0        | DCMT 070204   | IS M2.5x6.0  | 0.01 |
| 300120      | SL20 SDUCL P <sup>a</sup>       | 25         | 20      | 13      | 93       | 30       | -8       | 0        | DCMT 11T304   | IS M3.5x10.0 | 0.02 |
| 300061      | SL20 SDUCR P <sup>a</sup>       | 25         | 20      | 13      | 93       | 30       | -8       | 0        | DCMT 11T304   | IS M3.5x10.0 | 0.02 |
| 300121      | SL25 SDUCL P <sup>a</sup>       | 32         | 22      | 17      | 93       | 30       | -6       | 0        | DCMT 11T304   | IS M3.5x10.0 | 0.04 |
| 300062      | SL25 SDUCR P <sup>a</sup>       | 32         | 22      | 17      | 93       | 30       | -6       | 0        | DCMT 11T304   | IS M3.5x10.0 | 0.04 |
| 300122      | SL32 SDUCL P <sup>a</sup>       | 40         | 27      | 22      | 93       | 30       | -10      | 0        | DCMT 11T304   | IS M3.5x10.0 | 0.07 |
| 300063      | SL32 SDUCR P <sup>a</sup>       | 40         | 27      | 22      | 93       | 30       | -10      | 0        | DCMT 11T304   | IS M3.5x10.0 | 0.07 |
| 300064      | SL40 SDUCR P <sup>a</sup> WF27  | 50         | 32      | 27      | 93       | 30       | -10      | 0        | DCMT 11T304   | IS M3.5x10.0 | 0.14 |
| 300209      | SL40 SDUCL CP <sup>b</sup> WF27 | 50         | 32      | 27      | 93       | 30       | -8       | 0        | DCMT 11T304   | IS M3.5x10.0 | 0.14 |
| 300195      | SL40 SDUCR CP <sup>b</sup> WF27 | 50         | 32      | 27      | 93       | 30       | -8       | 0        | DCMT 11T304   | IS M3.5x10.0 | 0.14 |
| 301553      | SL40 SDUCR CP <sup>b</sup> WF22 | 45         | 32      | 22      | 93       | 30       | -8       | 0        | DCMT 11T304   | IS M3.5x10.0 | 0.14 |
| 301421      | SL80 SDUCL 11T3                 | 90         | 40      | 47      | 93       | 30       | -4       | 0        | DCMT 11T304   | IS M3.5x10.0 | 0.40 |
| 301418      | SL80 SDUCR 11T3                 | 90         | 40      | 47      | 93       | 30       | -4       | 0        | DCMT 11T304   | IS M3.5x10.0 | 0.40 |

All cutter heads are delivered with the insert clamp screw and torx key

a - P - Peripheral coolant works for SL connection with 3C

b - CP - Central and Peripheral coolant works with SL connection with both 1C and 3C

## SDQCR for DCMT Inserts



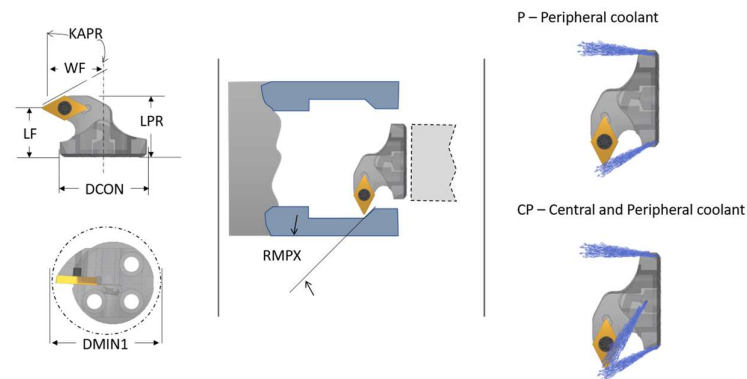
| Part Number | Type                       | DMIN1 (mm) | LF (mm) | WF (mm) | KAPR (°) | RMPX (°) | LAMS (°) | GAMO (°) | Master insert | Insert screw | KG   |
|-------------|----------------------------|------------|---------|---------|----------|----------|----------|----------|---------------|--------------|------|
| 300545      | SL16 SDQCR P <sup>a</sup>  | 20         | 18      | 11      | 107.5    | 17       | -6       | 0        | DCMT 070204   | IS M2.5x6.0  | 0.01 |
| 300546      | SL20 SDQCR CP <sup>b</sup> | 25         | 24      | 13      | 107.5    | 17       | -8       | 0        | DCMT 11T304   | IS M3.5x10.0 | 0.02 |
| 300547      | SL25 SDQCR CP <sup>b</sup> | 32         | 24      | 17      | 107.5    | 17       | -6       | 0        | DCMT 11T304   | IS M3.5x10.0 | 0.04 |
| 300548      | SL32 SDQCR CP <sup>b</sup> | 40         | 26      | 22      | 107.5    | 17       | -5       | 0        | DCMT 11T304   | IS M3.5x10.0 | 0.07 |
| 300549      | SL40 SDQCR CP <sup>b</sup> | 50         | 26      | 27      | 107.5    | 17       | -5       | 0        | DCMT 11T304   | IS M3.5x10.0 | 0.14 |

All cutter heads are delivered with the insert clamp screw and torx key

a - P - Peripheral coolant works for SL connection with 3C

b - CP - Central and Peripheral coolant works with SL connection with both 1C and 3C

## SDXCR for DCMT Inserts



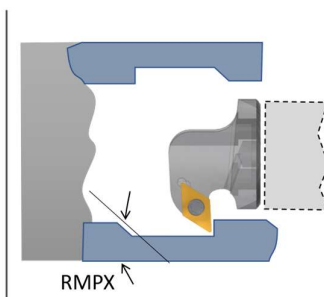
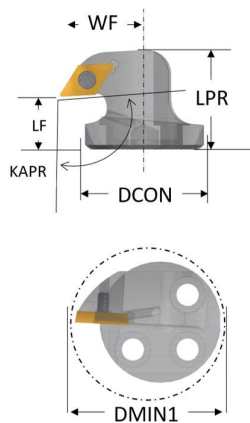
| Part Number | Type                       | DMIN1 (mm) | LF (mm) | LPR (mm) | WF (mm) | KAPR (°) | RMPX (°) | LAMS (°) | GAMO (°) | Master insert | Insert screw | KG   |
|-------------|----------------------------|------------|---------|----------|---------|----------|----------|----------|----------|---------------|--------------|------|
| 300550      | SL16 SDXCR CP <sup>a</sup> | 22         | 12.5    | 16       | 13      | 62.5     | 60       | -6       | 0        | DCMT 070204   | IS M2.5x6.0  | 0.01 |
| 300551      | SL20 SDXCR CP <sup>b</sup> | 27         | 13      | 17       | 15      | 62.5     | 60       | -3       | 0        | DCMT 070204   | IS M2.5x8.0  | 0.02 |
| 300552      | SL25 SDXCR CP <sup>b</sup> | 33         | 14      | 17.6     | 18      | 62.5     | 60       | -3       | 0        | DCMT 070204   | IS M2.5x8.0  | 0.04 |
| 300553      | SL32 SDXCR CP <sup>b</sup> | 40         | 17      | 22.5     | 22      | 62.5     | 60       | -8       | 0        | DCMT 11T304   | IS M3.5x10.0 | 0.07 |
| 300554      | SL40 SDXCR CP <sup>b</sup> | 50         | 17      | 22       | 27      | 62.5     | 60       | -8       | 0        | DCMT 11T304   | IS M3.5x10.0 | 0.14 |

All cutter heads are delivered with the insert clamp screw and torx key

a - P - Peripheral coolant works for SL connection with 3C

b - CP - Central and Peripheral coolant works with SL connection with both 1C and 3C

## Back boring – B-SDUCR for DCMT Inserts



P – Peripheral coolant



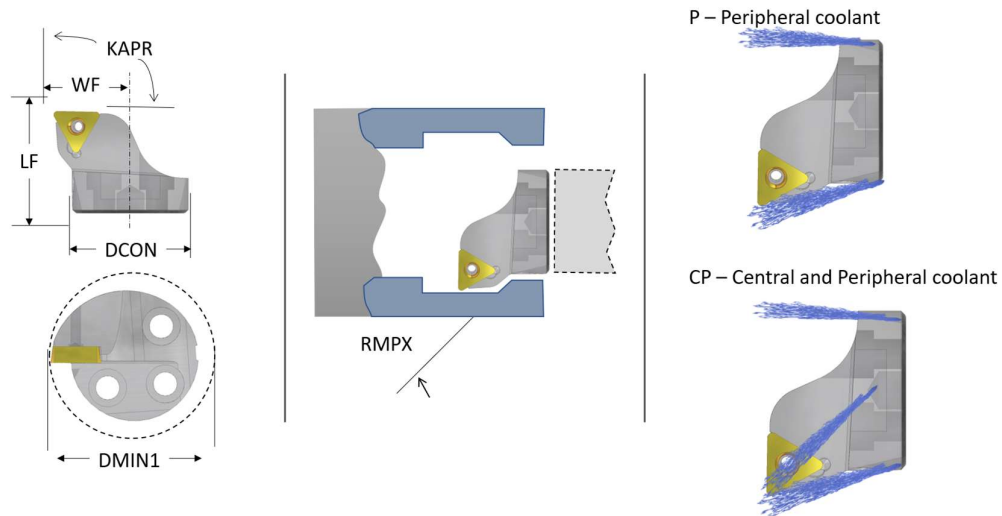
CP – Central and Peripheral coolant



| Part Number | Type                         | DMIN1 (mm) | LF (mm) | LPR (mm) | WF (mm) | KAPR (°) | RMPX (°) | LAMS (°) | GAMO (°) | Master insert | Insert screw | KG   |
|-------------|------------------------------|------------|---------|----------|---------|----------|----------|----------|----------|---------------|--------------|------|
| 300555      | SL16 B-SDUCR CP <sup>a</sup> | 20         | 11      | 20       | 13      | 93       | 30       | -6       | 0        | DCMT 070204   | IS M2.5x6.0  | 0.01 |
| 300556      | SL20 B-SDUCR CP <sup>a</sup> | 25         | 11      | 20       | 15      | 93       | 30       | -3       | 0        | DCMT 070204   | IS M2.5x6.0  | 0.02 |
| 300557      | SL25 B-SDUCR CP <sup>a</sup> | 32         | 11      | 21       | 18      | 93       | 30       | -3       | 0        | DCMT 070204   | IS M2.5x8.0  | 0.04 |
| 300558      | SL32 B-SDUCR CP <sup>a</sup> | 40         | 13      | 27       | 22      | 93       | 30       | -10      | 0        | DCMT 11T304   | IS M3.5x10.0 | 0.07 |
| 300559      | SL40 B-SDUCR CP <sup>a</sup> | 50         | 15      | 29       | 27      | 93       | 30       | -8       | 0        | DCMT 11T304   | IS M3.5x10.0 | 0.14 |

All cutter heads are delivered with the insert clamp screw and torx key  
a - CP -Central and Peripheral coolant exits

## STFCR, STFCL for TCMT Inserts



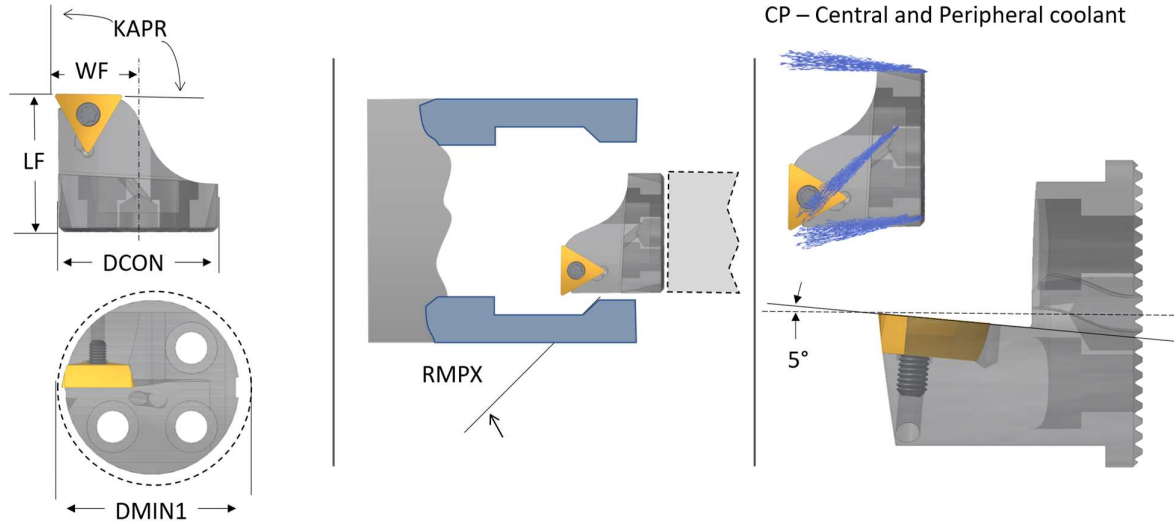
| Part Number | Type                       | DMIN1 (mm) | LF (mm) | WF (mm) | KAPR (°) | RMPX (°) | LAMS (°) | GAMO (°) | Master insert | Insert screw | KG   |
|-------------|----------------------------|------------|---------|---------|----------|----------|----------|----------|---------------|--------------|------|
| 300124      | SL12 STFCL P <sup>a</sup>  | 16         | 14      | 9       | 91       | NA       | -6       | 0        | TCMT 090204   | IS M2.2x5.0  | 0.01 |
| 300065      | SL12 STFCR P <sup>a</sup>  | 16         | 14      | 9       | 91       | NA       | -6       | 0        | TCMT 090204   | IS M2.2x5.0  | 0.01 |
| 300125      | SL16 STFCL P <sup>a</sup>  | 20         | 16      | 11      | 91       | NA       | -6       | 0        | TCMT 090204   | IS M2.2x5.0  | 0.01 |
| 300066      | SL16 STFCR P <sup>a</sup>  | 20         | 16      | 11      | 91       | NA       | -6       | 0        | TCMT 090204   | IS M2.2x5.0  | 0.01 |
| 300126      | SL20 STFCL P <sup>a</sup>  | 25         | 20      | 13      | 91       | NA       | -4       | 0        | TCMT 110304   | IS M2.5x8.0  | 0.02 |
| 300067      | SL20 STFCR P <sup>a</sup>  | 25         | 20      | 13      | 91       | NA       | -4       | 0        | TCMT 110304   | IS M2.5x8.0  | 0.02 |
| 300127      | SL25 STFCL P <sup>a</sup>  | 32         | 22      | 17      | 91       | NA       | -4       | 0        | TCMT 110304   | IS M2.5x8.0  | 0.04 |
| 300068      | SL25 STFCR P <sup>a</sup>  | 32         | 22      | 17      | 91       | NA       | -4       | 0        | TCMT 110304   | IS M2.5x8.0  | 0.04 |
| 300128      | SL32 STFCL P <sup>a</sup>  | 40         | 27      | 22      | 91       | NA       | -10      | 0        | TCMT 16T304   | IS M3.5x10.0 | 0.07 |
| 300069      | SL32 STFCR P <sup>a</sup>  | 40         | 27      | 22      | 91       | NA       | -10      | 0        | TCMT 16T304   | IS M3.5x10.0 | 0.07 |
| 300070      | SL40 STFCR P <sup>a</sup>  | 50         | 32      | 27      | 91       | NA       | -10      | 0        | TCMT 16T304   | IS M3.5x10.0 | 0.14 |
| 300210      | SL40 STFCL CP <sup>b</sup> | 50         | 32      | 27      | 91       | NA       | -10      | 0        | TCMT 16T304   | IS M3.5x10.0 | 0.14 |
| 300197      | SL40 STFCR CP <sup>b</sup> | 50         | 32      | 27      | 91       | NA       | -10      | 0        | TCMT 16T304   | IS M3.5x10.0 | 0.14 |

All cutter heads are delivered with the insert clamp screw and torx key

a - P - Peripheral coolant works for SL connection with 3C

b - CP - Central and Peripheral coolant works with SL connection with both 1C and 3C

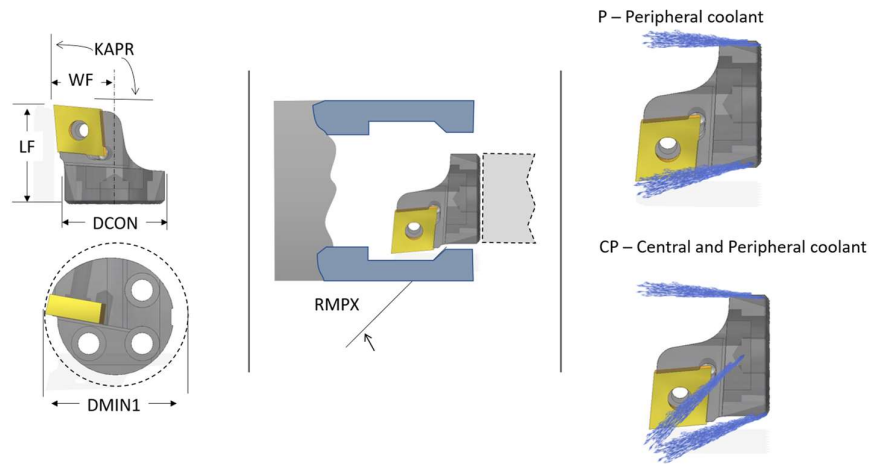
## STFPR for TPMT Inserts



| Part Number | Type                       | DMIN1 (mm) | LF (mm) | WF (mm) | KAPR (°) | RMPX (°) | LAMS (°) | GAMO (°) | Master insert | Insert screw | KG   |
|-------------|----------------------------|------------|---------|---------|----------|----------|----------|----------|---------------|--------------|------|
| 300466      | SL16 STFPR CP <sup>a</sup> | 18         | 17      | 8.8     | 91       | NA       | -3.5     | 5        | TPMT 090204   | IS M2.2x5.0  | 0.01 |
| 300467      | SL20 STFPR CP <sup>a</sup> | 22         | 19      | 10.8    | 91       | NA       | -2       | 5        | TPMT 110304   | IS M2.5x8.0  | 0.02 |
| 300468      | SL25 STFPR CP <sup>a</sup> | 27         | 22      | 13.3    | 91       | NA       | 0        | 5        | TPMT 110304   | IS M2.5x8.0  | 0.04 |

|                                                                                     |  |  |  |  |  |  |  |  |  |  |  |
|-------------------------------------------------------------------------------------|--|--|--|--|--|--|--|--|--|--|--|
| All cutter heads are delivered with the insert clamp screw and torx key             |  |  |  |  |  |  |  |  |  |  |  |
| a - CP -Central and Peripheral coolant works with SL connection with both 1C and 3C |  |  |  |  |  |  |  |  |  |  |  |

## SCLCR, SCLCL for CCMT Inserts

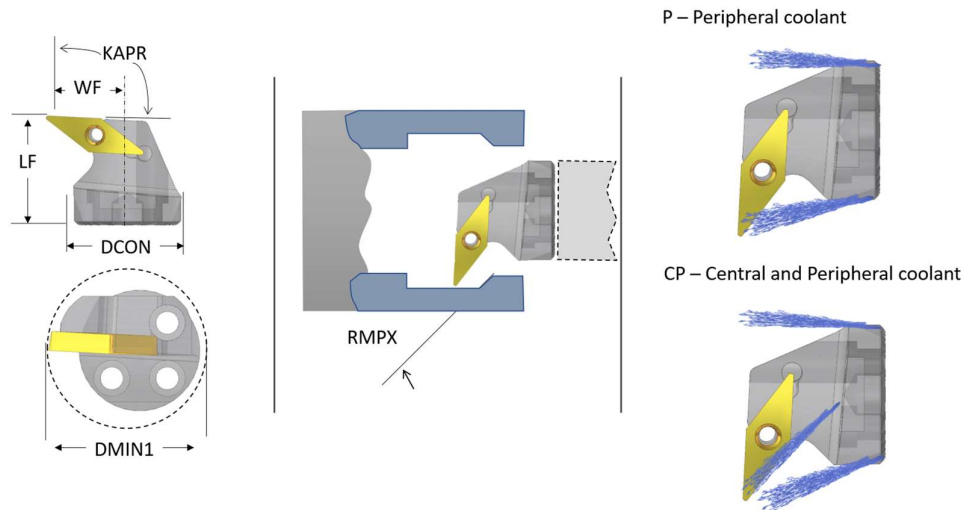


| Part Number | Type                       | DMIN1 (mm) | LF (mm) | WF (mm) | KAPR (°) | RMPX (°) | LAMS (°) | GAMO (°) | Master Insert | Insert screw | KG   |
|-------------|----------------------------|------------|---------|---------|----------|----------|----------|----------|---------------|--------------|------|
| 300112      | SL12 SCLCL P <sup>a</sup>  | 17         | 15      | 10      | 95       | NA       | -6       | 0        | CCMT 060204   | IS M2.5x6.0  | 0.01 |
| 300071      | SL12 SCLCR P <sup>a</sup>  | 17         | 15      | 10      | 95       | NA       | -6       | 0        | CCMT 060204   | IS M2.5x6.0  | 0.01 |
| 300113      | SL16 SCLCL P <sup>a</sup>  | 20         | 17      | 11      | 95       | NA       | -6       | 0        | CCMT 060204   | IS M2.5x6.0  | 0.01 |
| 300072      | SL16 SCLCR P <sup>a</sup>  | 20         | 17      | 11      | 95       | NA       | -6       | 0        | CCMT 060204   | IS M2.5x6.0  | 0.01 |
| 300114      | SL20 SCLCL P <sup>a</sup>  | 25         | 20      | 13      | 95       | NA       | -8       | 0        | CCMT 09T304   | IS M3.5x10.0 | 0.02 |
| 300073      | SL20 SCLCR P <sup>a</sup>  | 25         | 20      | 13      | 95       | NA       | -8       | 0        | CCMT 09T304   | IS M3.5x10.0 | 0.02 |
| 300115      | SL25 SCLCL P <sup>a</sup>  | 32         | 22      | 17      | 95       | NA       | -6       | 0        | CCMT 09T304   | IS M3.5x10.0 | 0.04 |
| 300074      | SL25 SCLCR CP <sup>a</sup> | 32         | 22      | 17      | 95       | NA       | -6       | 0        | CCMT 09T304   | IS M3.5x10.0 | 0.04 |
| 300116      | SL32 SCLCL P <sup>a</sup>  | 40         | 24      | 22      | 95       | NA       | -10      | 0        | CCMT 09T304   | IS M3.5x10.0 | 0.07 |
| 300075      | SL32 SCLCR P <sup>a</sup>  | 40         | 24      | 22      | 95       | NA       | -10      | 0        | CCMT 09T304   | IS M3.5x10.0 | 0.07 |
| 300076      | SL40 SCLCR P <sup>a</sup>  | 50         | 25      | 27      | 95       | NA       | -10      | 0        | CCMT 09T304   | IS M3.5x10.0 | 0.14 |
| 300208      | SL40 SCLCL CP <sup>b</sup> | 50         | 26      | 27      | 95       | NA       | -7       | 0        | CCMT 120404   | IS M4.0x15.0 | 0.14 |
| 300196      | SL40 SCLCR CP <sup>b</sup> | 50         | 26      | 27      | 95       | NA       | -7       | 0        | CCMT 120404   | IS M4.0x15.0 | 0.14 |

|                                                                                                                                                                                                                               |  |  |  |  |  |  |  |  |  |  |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|--|--|--|--|--|--|--|--|
| All cutter heads are delivered with the insert clamp screw and torx key<br>a - P - Peripheral coolant works for SL connection with 3C<br>b - CP - Central and Peripheral coolant works with SL connection with both 1C and 3C |  |  |  |  |  |  |  |  |  |  |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|--|--|--|--|--|--|--|--|



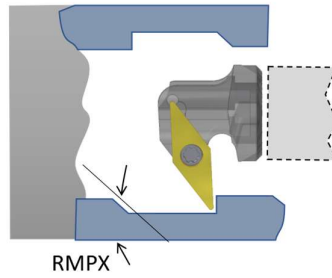
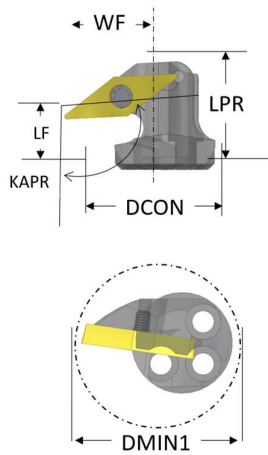
## SVUCR, SVUCL for VCMT Inserts



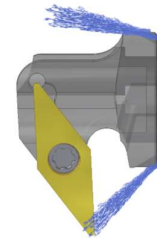
| Part Number | Type                           | DMIN (mm) | LF (mm) | WF (mm) | KAPR (°) | RMPX (°) | LAMS (°) | GAMO (°) | Master Insert | Insert screw | KG   |
|-------------|--------------------------------|-----------|---------|---------|----------|----------|----------|----------|---------------|--------------|------|
| 301534      | SL16 SVUCL P <sup>a</sup> WF16 | 25        | 17      | 16      | 93       | 45       | -8       | 0        | VCMT 110304   | IS M2.5x6.0  | 0.02 |
| 300666      | SL16 SVUCR P <sup>a</sup> WF16 | 25        | 17      | 16      | 93       | 45       | -8       | 0        | VCMT 110304   | IS M2.5x6.0  | 0.02 |
| 300199      | SL20 SVUCL P <sup>a</sup>      | 27        | 20.5    | 15      | 93       | 45       | -4       | 0        | VCMT 110304   | IS M2.5x8.0  | 0.02 |
| 300198      | SL20 SVUCR P <sup>a</sup>      | 27        | 20.5    | 15      | 93       | 45       | -4       | 0        | VCMT 110304   | IS M2.5x8.0  | 0.02 |
| 300201      | SL25 SVUCL P <sup>a</sup>      | 33        | 20.5    | 18      | 93       | 45       | -2       | 0        | VCMT 110304   | IS M2.5x8.0  | 0.04 |
| 300200      | SL25 SVUCR P <sup>a</sup>      | 33        | 20.5    | 18      | 93       | 45       | -2       | 0        | VCMT 110304   | IS M2.5x8.0  | 0.04 |
| 300598      | SL32 SVUCL CP <sup>b</sup>     | 40        | 25      | 22      | 93       | 45       | -10      | 0        | VCMT 160404   | IS M3.5x10.0 | 0.08 |
| 300597      | SL32 SVUCR CP <sup>b</sup>     | 40        | 25      | 22      | 93       | 45       | -10      | 0        | VCMT 160404   | IS M3.5x10.0 | 0.08 |
| 300560      | SL40 SVUCL CP <sup>b</sup>     | 50        | 28      | 27      | 93       | 45       | -6       | 0        | VCMT 160404   | IS M3.5x10.0 | 0.12 |
| 300561      | SL40 SVUCR CP <sup>b</sup>     | 50        | 28      | 27      | 93       | 45       | -6       | 0        | VCMT 160404   | IS M3.5x10.0 | 0.12 |

|                                                                                                                                                                                                                               |  |  |  |  |  |  |  |  |  |  |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|--|--|--|--|--|--|--|--|
| All cutter heads are delivered with the insert clamp screw and torx key<br>a - P - Peripheral coolant works for SL connection with 3C<br>b - CP - Central and Peripheral coolant works with SL connection with both 1C and 3C |  |  |  |  |  |  |  |  |  |  |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|--|--|--|--|--|--|--|--|--|

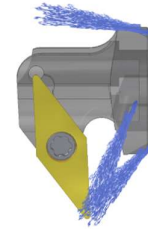
## Back boring – B-SVUCR for VCMT Inserts



P – Peripheral coolant



CP – Central and Peripheral coolant



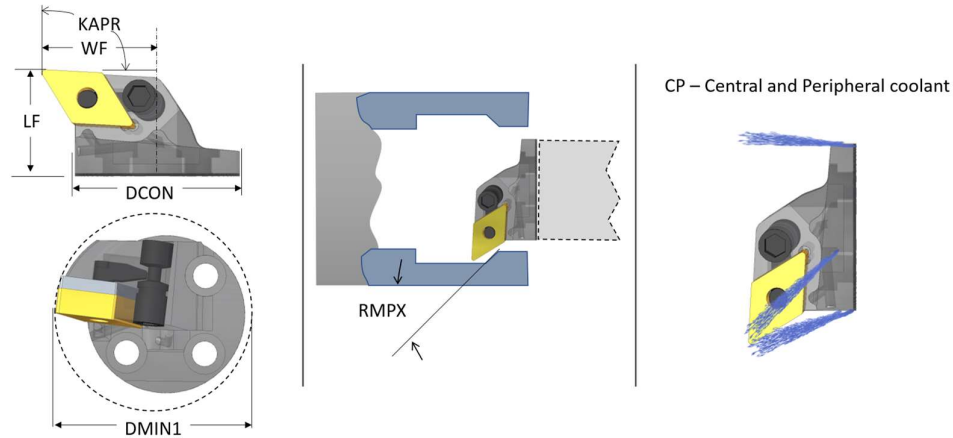
| Part Number | Type                         | DMIN1 (mm) | LF (mm) | LPR (mm) | WF (mm) | KAPR (°) | RMPX (°) | LAMS (°) | GAMO (°) | Master insert | Insert screw | KG   |
|-------------|------------------------------|------------|---------|----------|---------|----------|----------|----------|----------|---------------|--------------|------|
| 300667      | SL16 B SVUCR CP <sup>b</sup> | 25         | 8       | 17       | 16      | 93       | 45       | -8       | 0        | VCMT 110304   | IS M2.5x6.0  | 0.02 |

All cutter heads are delivered with the insert clamp screw and torx key

a - P - Peripheral coolant works for SL connection with 3C

b - CP - Central and Peripheral coolant works with SL connection with both 1C and 3C

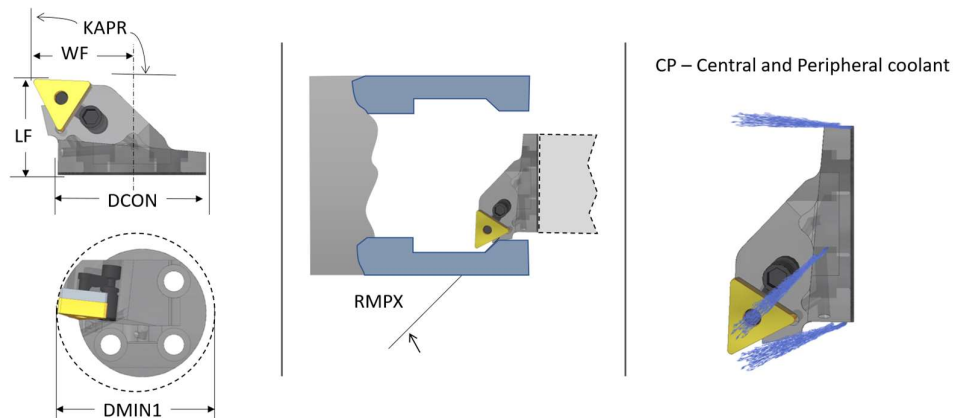
## PDUNR, PDUNL for DNMG Inserts



| Part Number | Type                            | DMIN1 (mm) | LF (mm) | WF (mm) | KAPR (°) | RMPX (°) | LAMS (°) | GAMO (°) | Insert      | Slot screw | Level     | Shim         | KG   |
|-------------|---------------------------------|------------|---------|---------|----------|----------|----------|----------|-------------|------------|-----------|--------------|------|
| 300661      | SL25 PDUNL CP <sup>a</sup>      | 34         | 23      | 19      | 93       | 27       | -10      | -6       | DNMG 1104XX | M5x0.8x15  | LV3 G0310 | NA           | 0.05 |
| 300660      | SL25 PDUNR CP <sup>a</sup>      | 34         | 23      | 19      | 93       | 27       | -10      | -6       | DNMG 1104XX | M5x0.8x15  | LV3 G0310 | NA           | 0.05 |
| 300562      | SL32 PDUNL CP <sup>a</sup>      | 40         | 26      | 22      | 93       | 27       | -10      | -7       | DNMG 1104XX | M6x1x17    | LV3 G0312 | PS DNMG 1104 | 0.09 |
| 300427      | SL32 PDUNR CP <sup>a</sup>      | 40         | 26      | 22      | 93       | 27       | -10      | -7       | DNMG 1104XX | M6x1x17    | LV3 G0312 | PS DNMG 1104 | 0.09 |
| 300402      | SL40 PDUNL CP <sup>a</sup> 1506 | 50         | 26      | 30      | 93       | 27       | -10      | -6       | DNMG 1506XX | M8x1x21    | LV4 G0516 | PS DNMG 1506 | 0.14 |
| 300086      | SL40 PDUNR CP <sup>a</sup> 1506 | 50         | 26      | 30      | 93       | 27       | -10      | -6       | DNMG 1506XX | M8x1x21    | LV4 G0516 | PS DNMG 1506 | 0.14 |
| 300107      | SL40 PDUNL CP <sup>a</sup> 1504 | 50         | 26      | 30      | 93       | 27       | -10      | -6       | DNMG 1504XX | M8x1x21    | LV4 G0516 | PS DNMG 1504 | 0.14 |
| 300106      | SL40 PDUNR CP <sup>a</sup> 1504 | 50         | 26      | 30      | 93       | 27       | -10      | -6       | DNMG 1504XX | M8x1x21    | LV4 G0516 | PS DNMG 1504 | 0.14 |

All cutter heads are delivered with the insert clamp screw and torx key  
a - CP -Central and Peripheral coolant works with SL connection with both 1C and 3C

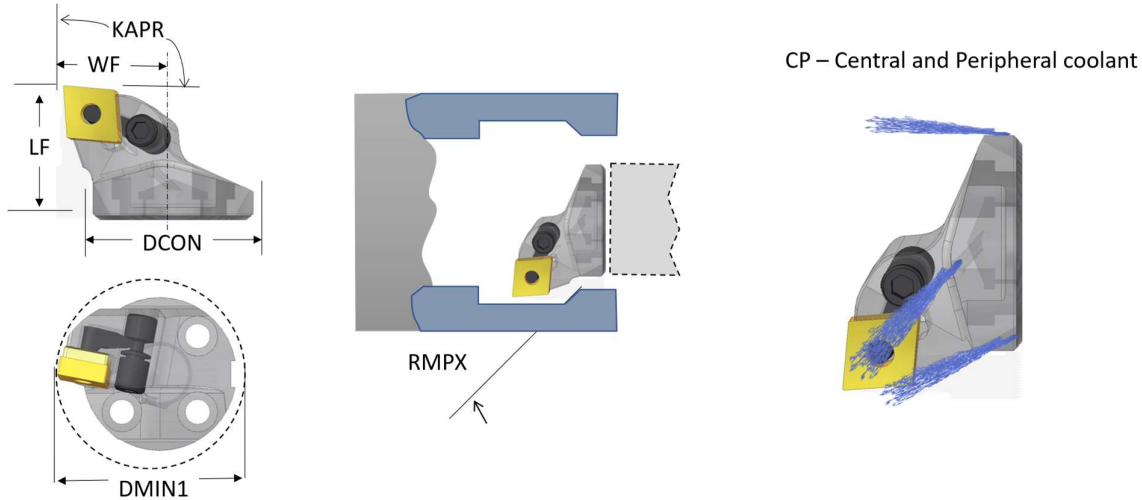
## PTFNR, PTFNL for TNMG Inserts



| Part Number | Type                       | DMIN1 (mm) | LF (mm) | WF (mm) | KAPR (°) | RMPX (°) | LAMS (°) | GAMO (°) | Insert      | Slot screw | Level     | Shim         | KG   |
|-------------|----------------------------|------------|---------|---------|----------|----------|----------|----------|-------------|------------|-----------|--------------|------|
| 300429      | SL32 PTFNR CP <sup>a</sup> | 40         | 27      | 22      | 91       | NA       | -9       | -6       | TNMG 1604XX | M6x1x17    | LV3 G0310 | PS TNMG 1604 | 0.09 |
| 300563      | SL32 PTFNL CP <sup>a</sup> | 40         | 27      | 22      | 91       | NA       | -9       | -6       | TNMG 1604XX | M6x1x17    | LV3 G0310 | PS TNMG 1604 | 0.09 |
| 300088      | SL40 PTFNR CP <sup>a</sup> | 50         | 26      | 27      | 91       | NA       | -10      | -6       | TNMG 1604XX | M6x1x17    | LV3 G0310 | PS TNMG 1604 | 0.14 |
| 300403      | SL40 PTFNL CP <sup>a</sup> | 50         | 26      | 27      | 91       | NA       | -10      | -6       | TNMG 1604XX | M6x1x17    | LV3 G0310 | PS TNMG 1604 | 0.14 |

All cutter heads are delivered with the insert clamp screw and torx key  
a - CP -Central and Peripheral coolant works with SL connection with both 1C and 3C

## PCLNR, PCLNL for CNMG Inserts

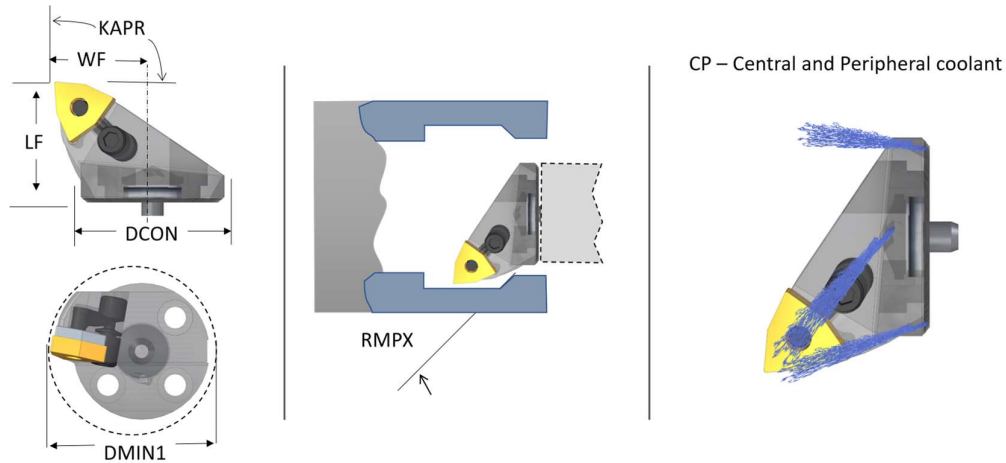


| Part Number | Type                       | DMIN1 (mm) | LF (mm) | WF (mm) | KAPR (°) | RMPX (°) | LAMS (°) | GAMO (°) | Insert      | Slot screw | Level     | Shim         | KG   |
|-------------|----------------------------|------------|---------|---------|----------|----------|----------|----------|-------------|------------|-----------|--------------|------|
| 300428      | SL32 PCLNR CP <sup>a</sup> | 40         | 26      | 27      | 95       | NA       | -11      | -6       | CNMG 1204XX | M6x1x17    | LV4 G0513 | PS CNMG 1204 | 0.09 |
| 300564      | SL32 PCLNL CP <sup>a</sup> | 40         | 26      | 27      | 95       | NA       | -11      | -6       | CNMG 1204XX | M6x1x17    | LV4 G0513 | PS CNMG 1204 | 0.09 |
| 300087      | SL40 PCLNR CP <sup>a</sup> | 50         | 26      | 33      | 95       | NA       | -11      | -6       | CNMG 1204XX | M8x1x21    | LV4 G0513 | PS CNMG 1204 | 0.14 |
| 300404      | SL40 PCLNL CP <sup>a</sup> | 50         | 26      | 33      | 95       | NA       | -11      | -6       | CNMG 1204XX | M8x1x21    | LV4 G0513 | PS CNMG 1204 | 0.14 |

All cutter heads are delivered with the insert clamp screw and torx key

a - CP -Central and Peripheral coolant works with SL connection with both 1C and 3C

## PWLNR, PWLNL for WNMG Inserts

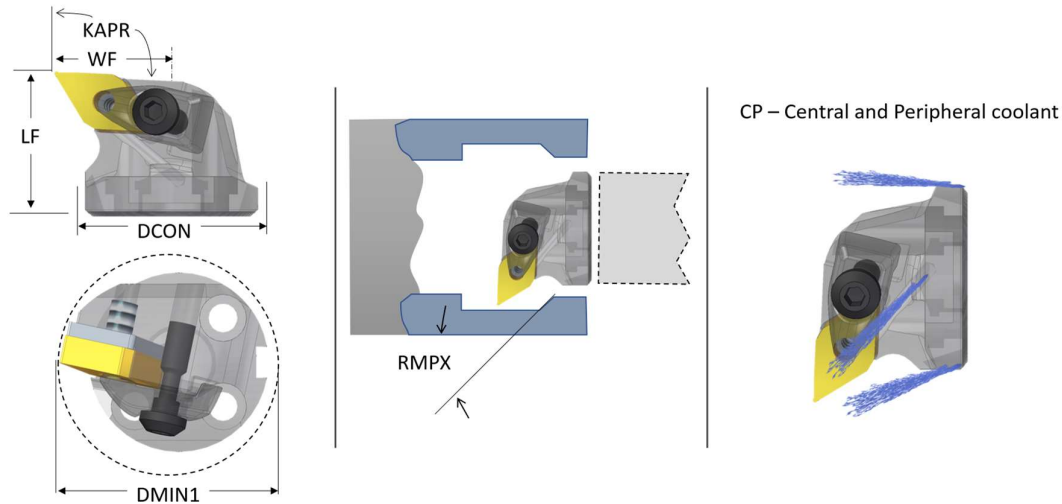


| Part Number | Type                       | DCON (mm) | DMIN1 (mm) | LF (mm) | WF (mm) | KAP R (°) | RMPX (°) | LAMS (°) | GAMO (°) | Insert      | Slot screw | Level     | Shim         | KG  |
|-------------|----------------------------|-----------|------------|---------|---------|-----------|----------|----------|----------|-------------|------------|-----------|--------------|-----|
| 300474      | SL40 PWLNR CP <sup>a</sup> | SL 40     | 50         | 26      | 27      | 95        | NA       | -10      | -6       | WNMG 0804XX | M8x1x21    | LV4 G0513 | PS WNMG 0804 | 0.2 |
| 300475      | SL40 PWLNL CP <sup>a</sup> | SL 40     | 50         | 26      | 27      | 95        | NA       | -10      | -6       | WNMG 0804XX | M8x1x21    | LV4 G0513 | PS WNMG 0804 | 0.2 |

All cutter heads are delivered with the insert clamp screw and torx key

a - CP -Central and Peripheral coolant works with SL connection with both 1C and 3C

## DDUNR, DDUNL for DNMG Inserts

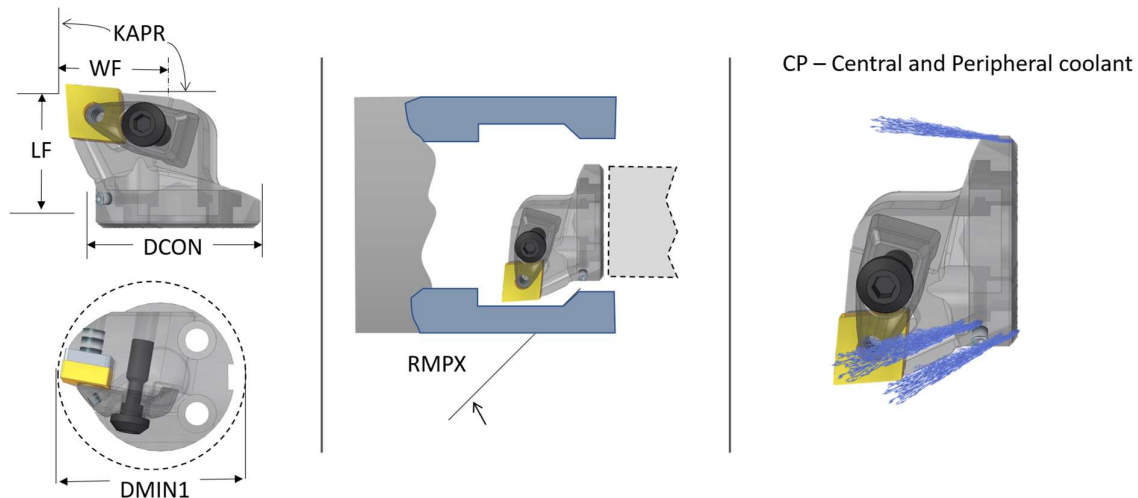


| Part Number | Type                            | DMIN1 (mm) | LF (mm) | WF (mm) | KAPR (°) | RMPX (°) | LAMS (°) | GAMO (°) | Insert      | Clamp | Clamp screw | Shim  | Shim screw     | KG   |
|-------------|---------------------------------|------------|---------|---------|----------|----------|----------|----------|-------------|-------|-------------|-------|----------------|------|
| 301238      | SL40 DDUNR CP <sup>a</sup> 1506 | 50         | 33      | 27      | 93       | 27       | -12      | -6       | DNMG 1506XX | C2RA  | CM6X25C     | D1503 | Sleeve M6x0.75 | 0.21 |
| 301239      | SL40 DDUNL CP <sup>a</sup> 1506 | 50         | 33      | 27      | 93       | 27       | -12      | -6       | DNMG 1506XX | C2RA  | CM6X25C     | D1503 | Sleeve M6x0.75 | 0.21 |
| 301240      | SL40 DDUNR CP <sup>a</sup> 1504 | 50         | 33      | 27      | 93       | 27       | -12      | -6       | DNMG 1506XX | C2RA  | CM6X25C     | D15BM | Sleeve M6x0.75 | 0.21 |
| 301241      | SL40 DDUNL CP <sup>a</sup> 1504 | 50         | 33      | 27      | 93       | 27       | -12      | -6       | DNMG 1504XX | C2RA  | CM6X25C     | D15BM | Sleeve M6x0.75 | 0.21 |
| 301420      | SL80 DDUNL 1506                 | 90         | 39      | 47      | 93       | 27       | -8       | -6       | DNMG 1506XX | C2RA  | CM6X25C     | D15BM | Sleeve M6x0.75 | 0.21 |
| 301417      | SL80 DDUNR 1506                 | 90         | 39      | 47      | 93       | 27       | -8       | -6       | DNMG 1506XX | C2RA  | CM6X25C     | D15BM | Sleeve M6x0.75 | 0.21 |

All cutter heads are delivered with the insert clamp screw and torx key

a - CP - Central and Peripheral coolant works with SL connection with both 1C and 3C

## DCLNR, DCLNL for CNMG Inserts

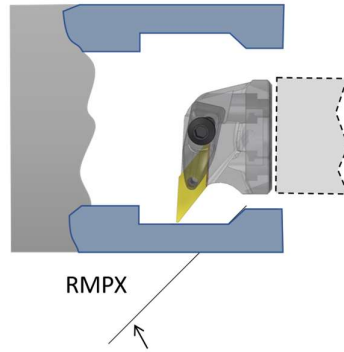
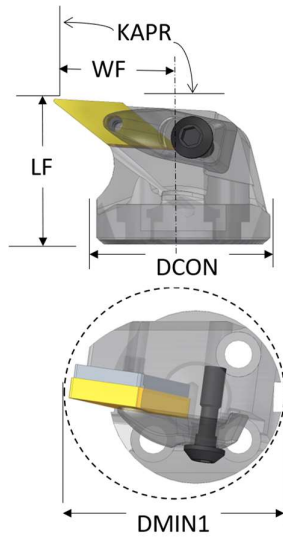


| Part Number | Type                            | DMIN1 (mm) | LF (mm) | WF (mm) | KAPR (°) | RMPX (°) | LAMS (°) | GAMO (°) | Insert      | Clamp | Clamp screw | Shim  | Shim screw     | KG   |
|-------------|---------------------------------|------------|---------|---------|----------|----------|----------|----------|-------------|-------|-------------|-------|----------------|------|
| 301242      | SL40 DCLNR CP <sup>a</sup> 1204 | 50         | 33      | 27      | 95       | NA       | -10      | -6       | CNMG 1204XX | C2RA  | CM6X25C     | C12BM | Sleeve M6x0.75 | 0.21 |
| 301243      | SL40 DCLNL CP <sup>a</sup> 1204 | 50         | 33      | 27      | 95       | NA       | -10      | -6       | CNMG 1204XX | C2RA  | CM6X25C     | C12BM | Sleeve M6x0.75 | 0.21 |
| 301416      | SL80 DCLNR 1204                 | 90         | 40      | 47      | 95       | NA       | -8       | -6       | CNMG 1204XX | C2RA  | CM6X25C     | C12BM | Sleeve M6x0.75 | 0.40 |
| 301419      | SL80 DCLNL 1204                 | 90         | 40      | 47      | 95       | NA       | -8       | -6       | CNMG 1204XX | C2RA  | CM6X25C     | C12BM | Sleeve M6x0.75 | 0.40 |

All cutter heads are delivered with the insert clamp screw and accessories.

a - CP - Central and Peripheral coolant works with SL connection with both 1C and 3C

## DVUNR, DVUNL for VNMG Inserts



CP – Central and Peripheral coolant

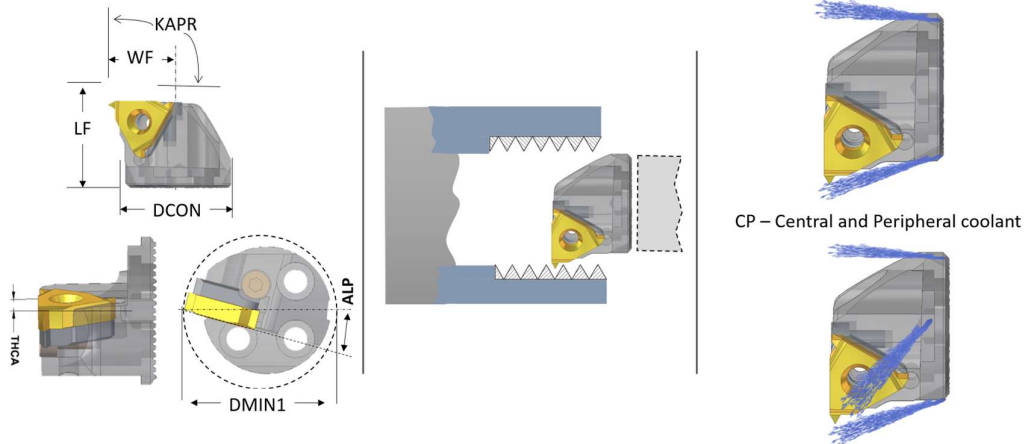


| Part Number | Type                            | DMIN1 (mm) | LF (mm) | WF (mm) | KAPR (°) | RMPX (°) | LAMS (°) | GAM O (°) | Insert      | Clamp | Clamp screw | Shim  | Shim screw    | kg   |
|-------------|---------------------------------|------------|---------|---------|----------|----------|----------|-----------|-------------|-------|-------------|-------|---------------|------|
| 301426      | SL40 DVUNR CP <sup>a</sup> 1604 | 52         | 33      | 30      | 93       | 45       | -8       | -6        | VNMG 1604XX | C6RA  | CM5X22C     | V16BM | Sleeve M5x0.5 | 0.21 |
| 301427      | SL40 DVUNL CP <sup>a</sup> 1604 | 52         | 33      | 30      | 93       | 45       | -8       | -6        | VNMG 1604XX | C6RA  | CM5X22C     | V16BM | Sleeve M5x0.5 | 0.21 |

All cutter heads are delivered with the insert clamp screw and torx key

a - CP -Central and Peripheral coolant works with SL connection with both 1C and 3C

## End effectors - Threading



### Left hand

| Part Number | Type                                       | DMIN1 (mm) | LF (mm) | WF (mm) | Master insert | Insert screw | Shim | Shim screw | ALP (°) | THCA (°) | KG   |
|-------------|--------------------------------------------|------------|---------|---------|---------------|--------------|------|------------|---------|----------|------|
| 300268      | SL12 SXFNL P <sup>a</sup> 11               | 16         | 16      | 8.9     | 11 IL A60     | IS M2.5x6.0  | NA   | NA         | -15     | -2       | 0.01 |
| 300269      | SL16 SXFNL P <sup>a</sup> 11               | 20         | 20      | 10.4    | 11 IL A60     | IS M2.5x6.0  | NA   | NA         | -15     | -1       | 0.01 |
| 300270      | SL16 SXFNL P <sup>a</sup> 16               | 20         | 20      | 10.4    | 16 IL AG60    | IS M3.5x10.0 | NA   | NA         | -15     | -2       | 0.01 |
| 300271      | SL20 SXFNL P <sup>a</sup> 11               | 25         | 20      | 12.7    | 11 IL A60     | IS M2.5x6.0  | NA   | NA         | -15     | -1       | 0.02 |
| 300272      | SL20 SXFNL P <sup>a</sup> 16               | 25         | 23      | 13.7    | 16 IL AG60    | IS M3.5x11.0 | NA   | NA         | -15     | -2       | 0.02 |
| 300273      | SL25 SXFNL P <sup>a</sup> 16               | 30         | 24      | 16.3    | 16 IL AG60    | IS M3.5x11.0 | EA16 | HS M3x6    | -15     | -1       | 0.04 |
| 300274      | SL25 SXFNL P <sup>a</sup> 22               | 32         | 30      | 18.3    | 22 IL N60     | IS M4.5x12.0 | EA22 | HS M3x6    | -15     | -2       | 0.04 |
| 300275      | SL32 SXFNL P <sup>a</sup> 16               | 37         | 28      | 19.7    | 16 IL AG60    | IS M3.5x10.0 | EA16 | HS M3x6    | -15     | -1       | 0.07 |
| 300276      | SL32 SXFNL CP <sup>b</sup> 22              | 39         | 32      | 21.7    | 22 IL N60     | IS M4.5x12.0 | EA22 | HS M3x6    | -15     | -2       | 0.07 |
| 300277      | SL40 SXFNL CP <sup>b</sup> 16              | 45         | 28      | 23.7    | 16 IL AG60    | IS M3.5x10.0 | EA16 | HS M3x6    | -15     | -1       | 0.14 |
| 300278      | SL40 SXFNL CP <sup>b</sup> 22              | 47         | 30      | 25.7    | 22 IL N60     | IS M4.5x12.0 | EA22 | HS M3x6    | -15     | -2       | 0.14 |
| 300279      | SL40 SXFNL CP <sup>b</sup> 27 <sup>c</sup> | 48         | 35      | 26.8    | 27 IL Q60     | IS M5.0x18.0 | EA27 | HS M4x9    | -15     | -2.5     | 0.14 |

### Right hand

| Part Number | Type                          | DMIN1 (mm) | LF (mm) | WF (mm) | Master insert | Insert screw | Shim | Shim screw | ALP (°) | THCA (°) | KG   |
|-------------|-------------------------------|------------|---------|---------|---------------|--------------|------|------------|---------|----------|------|
| 300280      | SL12 SXFNR P <sup>a</sup> 11  | 16         | 16      | 8.9     | 11 IR A60     | IS M2.5x6.0  | NA   | NA         | -15     | -2       | 0.01 |
| 300281      | SL16 SXFNR P <sup>a</sup> 11  | 20         | 20      | 10.4    | 11 IR A60     | IS M2.5x6.0  | NA   | NA         | -15     | -1       | 0.01 |
| 300282      | SL16 SXFNR P <sup>a</sup> 16  | 20         | 20      | 10.4    | 16 IR AG60    | IS M3.5x10.0 | NA   | NA         | -15     | -2       | 0.01 |
| 300283      | SL20 SXFNR P <sup>a</sup> 11  | 25         | 20      | 12.7    | 11 IR A60     | IS M2.5x6.0  | NA   | NA         | -15     | -1       | 0.02 |
| 300284      | SL20 SXFNR P <sup>a</sup> 16  | 25         | 23      | 13.7    | 16 IR AG60    | IS M3.5x11.0 | NA   | NA         | -15     | -2       | 0.02 |
| 300285      | SL25 SXFNR P <sup>a</sup> 16  | 30         | 24      | 16.3    | 16 IR AG60    | IS M3.5x11.0 | IA16 | HS M3x6    | -15     | -1       | 0.04 |
| 300286      | SL25 SXFNR P <sup>a</sup> 22  | 32         | 30      | 18.3    | 22 IR N60     | IS M4.5x12.0 | IA22 | HS M3x6    | -15     | -2       | 0.04 |
| 300287      | SL32 SXFNR P <sup>a</sup> 16  | 37         | 28      | 19.7    | 16 IR AG60    | IS M3.5x10.0 | IA16 | HS M3x6    | -15     | -1       | 0.07 |
| 300288      | SL32 SXFNR CP <sup>b</sup> 22 | 39         | 32      | 21.7    | 22 IR N60     | IS M4.5x12.0 | IA22 | HS M3x6    | -15     | -2       | 0.07 |
| 300289      | SL40 SXFNR CP <sup>b</sup> 16 | 45         | 28      | 23.7    | 16 IR AG60    | IS M3.5x10.0 | IA16 | HS M3x6    | -15     | -1       | 0.14 |
| 300290      | SL40 SXFNR CP <sup>b</sup> 22 | 47         | 30      | 25.7    | 22 IR N60     | IS M4.5x12.0 | IA22 | HS M3x6    | -15     | -2       | 0.14 |
| 300291      | SL40 SXFNR CP <sup>b</sup> 27 | 48         | 35      | 26.8    | 27 IR Q60     | IS M5.0x18.0 | IA27 | HS M4x9    | -15     | -2.5     | 0.14 |

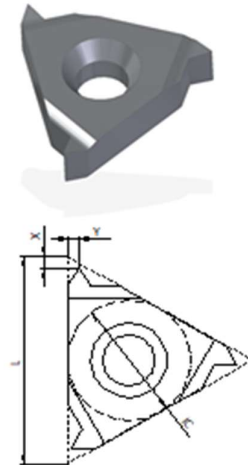
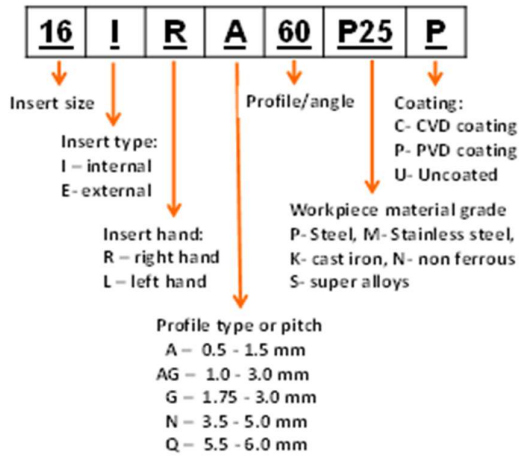
a - P - Peripheral coolant works for SL connection with 3C

b - CP - Central and Peripheral coolant works with SL connection with both 1C and 3C

c - Product on request.

All cutter heads are delivered with the insert clamp screw and torx key

Inserts are sold in packages of 10 pcs.



## Left

| Part Number | Type            | Pitch mm (TPI)  | IC     | L  | X   | Y   |
|-------------|-----------------|-----------------|--------|----|-----|-----|
| 300297      | 11 IL A60 P25P  | 0.5-1.5 (48-16) | 6.350  | 11 | 0.8 | 0.9 |
| 300298      | 16 IL A60 P25P  | 0.5-1.5 (48-16) | 9.525  | 16 | 0.8 | 0.9 |
| 300299      | 16 IL G60 P25P  | 1.75-3.0 (14-8) | 9.525  | 16 | 1.2 | 1.7 |
| 300300      | 16 IL AG60 P25P | 1.0-3.0 (26-8)  | 9.525  | 16 | 1.2 | 1.7 |
| 300301      | 22 IL N60 P25P  | 3.5-5.0 (7-5)   | 12.7   | 22 | 1.7 | 2.5 |
| 300302      | 27 IL Q60 P25P  | 5.5-6.0 (4.5-4) | 15.875 | 27 | 2.1 | 3.1 |

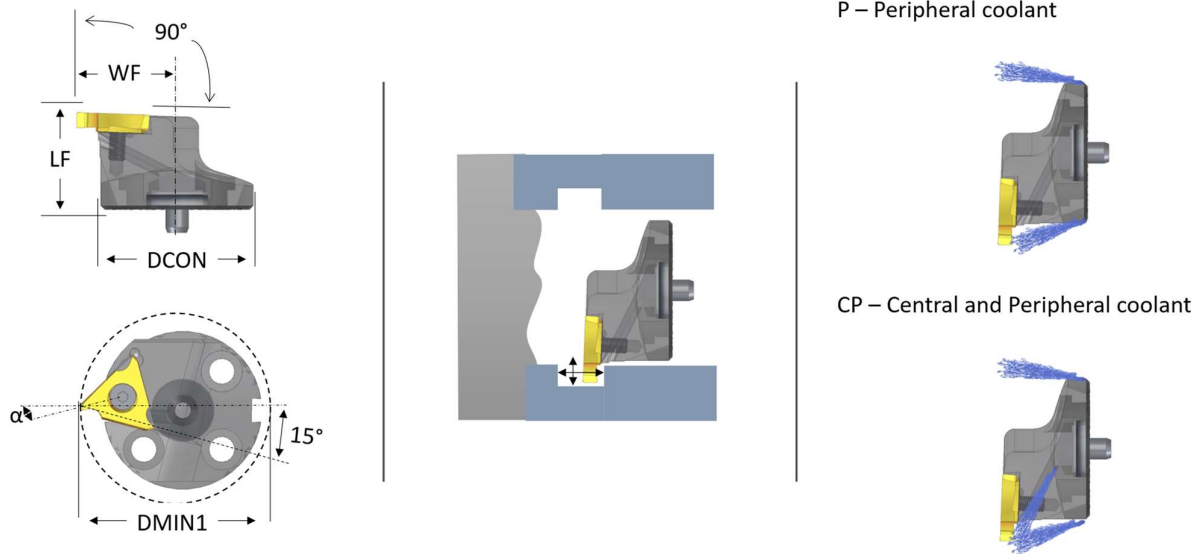
## Right

|                                                                                  |                 |                 |        |    |     |     |
|----------------------------------------------------------------------------------|-----------------|-----------------|--------|----|-----|-----|
| 300303                                                                           | 11 IR A60 P25P  | 0.5-1.5 (48-16) | 6.350  | 11 | 0.8 | 0.9 |
| 300304                                                                           | 16 IR A60 P25P  | 0.5-1.5 (48-16) | 9.525  | 16 | 0.8 | 0.9 |
| 300305                                                                           | 16 IR G60 P25P  | 1.75-3.0 (14-8) | 9.525  | 16 | 1.2 | 1.7 |
| 300306                                                                           | 16 IR AG60 P25P | 1.0-3.0 (26-8)  | 9.525  | 16 | 1.2 | 1.7 |
| 300307                                                                           | 22 IR N60 P25P  | 3.5-5.0 (7-5)   | 12.7   | 22 | 1.7 | 2.5 |
| 300308                                                                           | 27 IR Q60 P25P  | 5.5-6.0 (4.5-4) | 15.875 | 27 | 2.1 | 3.1 |
| Other full profile inserts, with different standards are available upon request. |                 |                 |        |    |     |     |

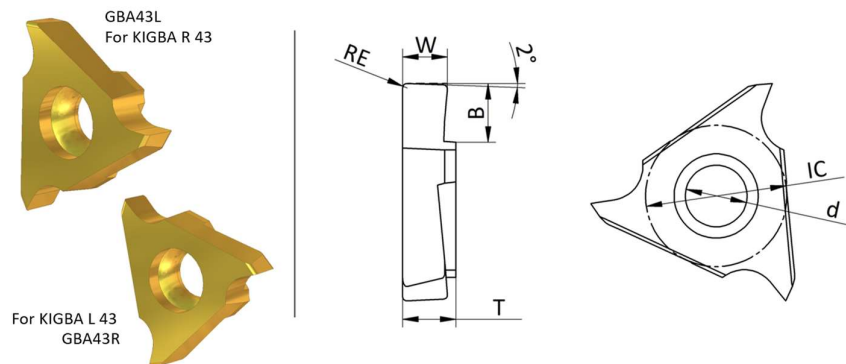


## End effectors – Grooving

### KIGBA for GBA43 insert



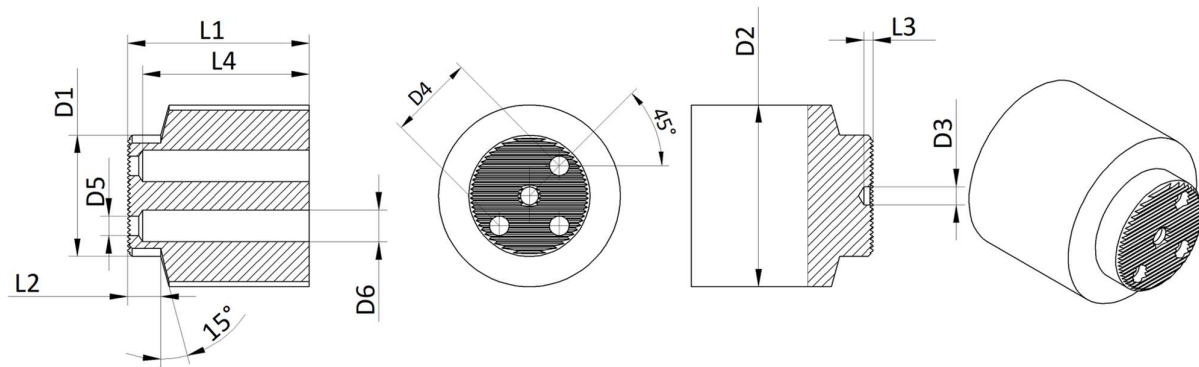
| Part Number                                                                                                                                                                                                             | Type                                            | DMIN1 (mm) | LF (mm) | WF (mm) | Master insert | Insert screw | KG   |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------|------------|---------|---------|---------------|--------------|------|
| 300699                                                                                                                                                                                                                  | SL40 KIGBA R CP <sup>a</sup> GBA43              | 50         | 25      | 27      | GBA43 L       | IS M4.5x12   | 0.12 |
| 301169                                                                                                                                                                                                                  | SL40 KIGBA L CP <sup>a</sup> GBA43 <sup>b</sup> | 50         | 25      | 27      | GBA43 R       | IS M4.5x12   | 0.12 |
| <p>a - Product available after 2024-April</p> <p>b - CP -Central and Peripheral coolant works with SL connection with both 1C and 3C</p> <p>All cutter heads are delivered with the insert clamp screw and torx key</p> |                                                 |            |         |         |               |              |      |



| Part Number                                                                | Insert Type                       | IC   | d   | T    | W    | B   | RE   |
|----------------------------------------------------------------------------|-----------------------------------|------|-----|------|------|-----|------|
| 301170                                                                     | GBA43 R 100-010 P25C <sup>a</sup> | 12.7 | 5.5 | 4.76 | 1.00 | 2.6 | 0.10 |
| 301171                                                                     | GBA43 R 200-010 P25C <sup>a</sup> | 12.7 | 5.5 | 4.76 | 2.00 | 4.1 | 0.10 |
| 301172                                                                     | GBA43 R 300-010 P25C <sup>a</sup> | 12.7 | 5.5 | 4.76 | 3.00 | 4.1 | 0.10 |
| 301173                                                                     | GBA43 R 400-010 P25C <sup>a</sup> | 12.7 | 5.5 | 4.76 | 4.00 | 5.2 | 0.10 |
| 301174                                                                     | GBA43 L 100-010 P25C <sup>a</sup> | 12.7 | 5.5 | 4.76 | 1.00 | 2.6 | 0.10 |
| 301175                                                                     | GBA43 L 200-010 P25C <sup>a</sup> | 12.7 | 5.5 | 4.76 | 2.00 | 4.1 | 0.10 |
| 301176                                                                     | GBA43 L 300-010 P25C <sup>a</sup> | 12.7 | 5.5 | 4.76 | 3.00 | 4.1 | 0.10 |
| 301177                                                                     | GBA43 L 400-010 P25C <sup>a</sup> | 12.7 | 5.5 | 4.76 | 4.00 | 5.2 | 0.10 |
| <sup>a</sup> Order oriented product, 10 pcs/package, 2 weeks delivery time |                                   |      |     |      |      |     |      |

## End effectors – SL blanks

### SL blanks Left hand

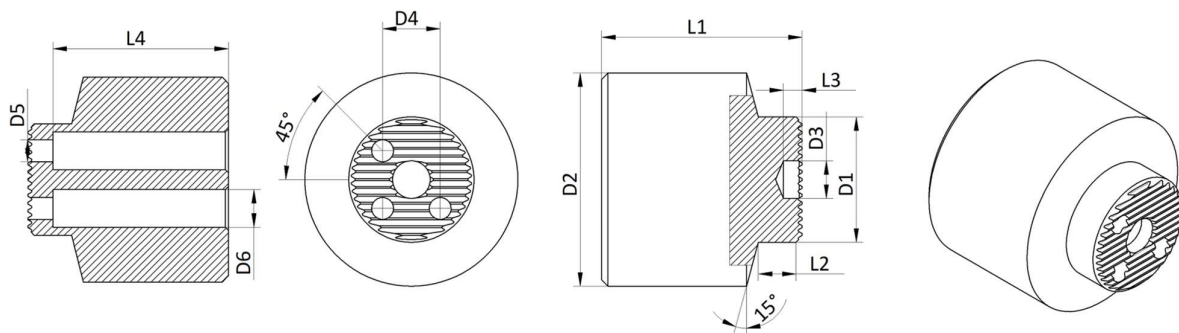


#### Left

| Part Number | Type         | D1 (mm) | D2 (mm) | D3 (mm) | D4 (mm) | D5 (mm) | D6 (mm) | L1 (mm) | L2 (mm) | L3 (mm) | L4 (mm) |
|-------------|--------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|
| 300140      | SL12-20-20 L | 12      | 20      | 4       | 7.4     | 2.5     | 4       | 20      | 7       | 3       | 17      |
| 300142      | SL16-26-25 L | 16      | 26      | 4       | 9.5     | 3.5     | 6       | 25      | 7       | 3       | 22      |
| 300144      | SL20-34-32 L | 20      | 34      | 6       | 13      | 3.5     | 6       | 32      | 7       | 3       | 29      |
| 300146      | SL25-40-40 L | 25      | 40      | 6       | 16      | 4.5     | 7.5     | 40      | 7       | 3       | 37      |
| 300148      | SL32-50-50 L | 32      | 50      | 6       | 22      | 5.5     | 9       | 50      | 11      | 3       | 47      |
| 300150      | SL40-60-60 L | 40      | 60      | 6       | 28      | 6.5     | 10.5    | 60      | 11      | 3       | 57      |
| 300152      | SL50-70-70 L | 50      | 70      | 8       | 35      | 8.5     | 13.5    | 70      | 11      | 4       | 67      |

all SL blank parts will be supplied with a centering pin equivalent to the dimension

### SL blanks Right hand



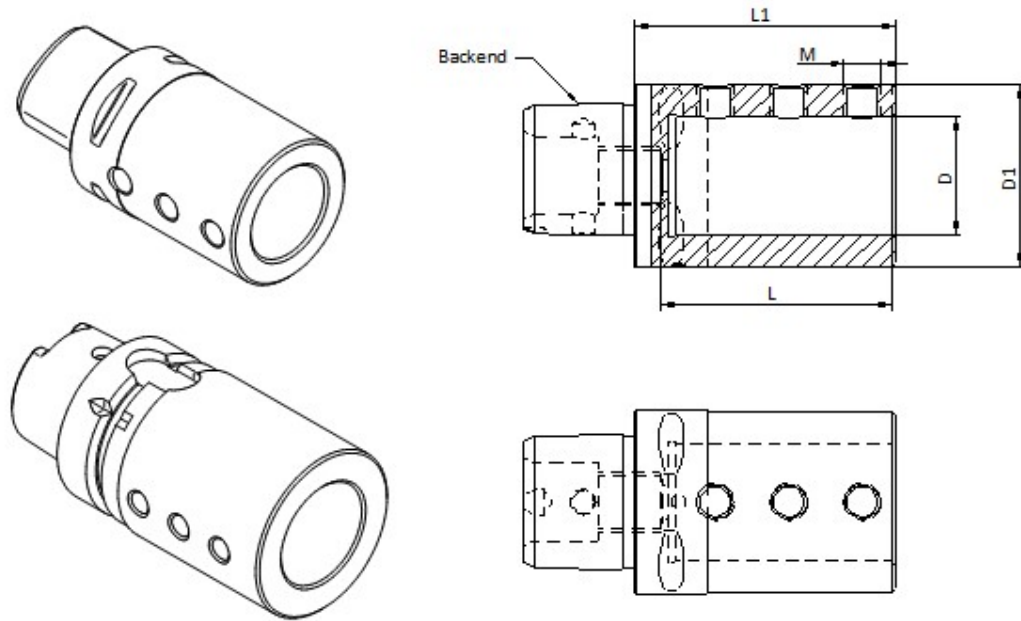
#### Right

| Part Number | Type         | D1 (mm) | D2 (mm) | D3 (mm) | D4 (mm) | D5 (mm) | D6 (mm) | L1 (mm) | L2 (mm) | L3 (mm) | L4 (mm) |
|-------------|--------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|
| 300139      | SL12-20-20 R | 12      | 20      | 4       | 7.4     | 2.5     | 4       | 20      | 7       | 3       | 17      |
| 300141      | SL16-26-25 R | 16      | 26      | 4       | 9.5     | 3.5     | 6       | 25      | 7       | 3       | 22      |
| 300143      | SL20-34-32 R | 20      | 34      | 6       | 13      | 3.5     | 6       | 32      | 7       | 3       | 29      |
| 300145      | SL25-40-40 R | 25      | 40      | 6       | 16      | 4.5     | 7.5     | 40      | 7       | 3       | 37      |
| 300147      | SL32-50-50 R | 32      | 50      | 6       | 22      | 5.5     | 9       | 50      | 11      | 3       | 47      |
| 300149      | SL40-60-60 R | 40      | 60      | 6       | 28      | 6.5     | 10.5    | 60      | 11      | 3       | 57      |
| 300151      | SL50-70-70 R | 50      | 70      | 8       | 35      | 8.5     | 13.5    | 70      | 11      | 4       | 67      |

all SL blank parts will be supplied with a centering pin equivalent to the dimension

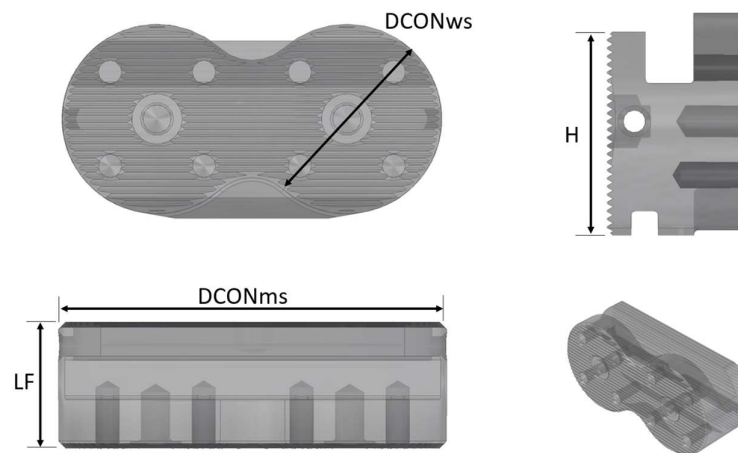
## Accessories

### Modular fixtures



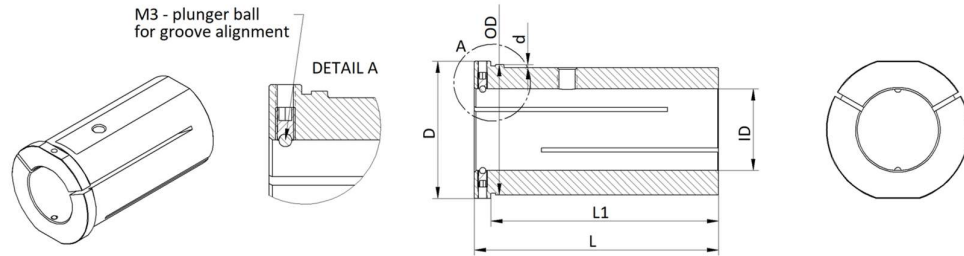
| Part Number | Type               | Backend | D (mm) | L (mm) | D1 (mm) | L1 (mm) | M thread |
|-------------|--------------------|---------|--------|--------|---------|---------|----------|
| 300292      | PSC63-SLT40x72-86  | PSC63   | 40     | 72     | 62.5    | 86      | M12x1.75 |
| 300293      | HSK63T-SLT32x62-90 | HSK63T  | 32     | 62     | 50      | 80      | M10x1.5  |

### SL adapters



| Part Number | Type                        | DCONms | DCONws | Hand    | LF (mm) | H (mm) | Coolant | KG   |
|-------------|-----------------------------|--------|--------|---------|---------|--------|---------|------|
| 300292      | SL80 - SL40 LR Adapter WF40 | SL80   | SL40   | L and R | 26      | 34     | NA      | 0.36 |

## Reduction sleeves



### Metric

| Part Number | Type     | OD h6 (mm) | ID H7 (mm) | L (mm) | D (mm) | L1 (mm) | d (mm) |
|-------------|----------|------------|------------|--------|--------|---------|--------|
| 301180      | RS 16-06 | 16         | 6          | 48     | 20     | 43      | 0.75   |

|        |          |    |    |    |    |    |   |
|--------|----------|----|----|----|----|----|---|
| 300606 | RS 20-16 | 20 | 16 | 55 | 37 | 50 | 1 |
| 300607 | RS 20-12 | 20 | 12 | 55 | 37 | 50 | 1 |
| 300608 | RS 20-10 | 20 | 10 | 55 | 37 | 50 | 1 |
| 300609 | RS 20-08 | 20 | 8  | 55 | 37 | 50 | 1 |
| 301179 | RS 20-06 | 20 | 6  | 55 | 37 | 50 | 1 |

|        |          |    |    |    |    |    |   |
|--------|----------|----|----|----|----|----|---|
| 300601 | RS 25-20 | 25 | 20 | 61 | 30 | 56 | 1 |
| 300602 | RS 25-16 | 25 | 16 | 61 | 30 | 56 | 1 |
| 300603 | RS 25-12 | 25 | 12 | 61 | 30 | 56 | 1 |
| 300604 | RS 25-10 | 25 | 10 | 61 | 30 | 56 | 1 |
| 300605 | RS 25-08 | 25 | 8  | 61 | 30 | 56 | 1 |
| 301178 | RS 25-06 | 25 | 6  | 61 | 30 | 56 | 1 |

|        |          |    |    |    |    |    |   |
|--------|----------|----|----|----|----|----|---|
| 300190 | RS 32-25 | 32 | 25 | 65 | 37 | 60 | 1 |
| 300191 | RS 32-20 | 32 | 20 | 65 | 37 | 60 | 1 |
| 300192 | RS 32-16 | 32 | 16 | 65 | 37 | 60 | 1 |
| 300193 | RS 32-12 | 32 | 12 | 65 | 37 | 60 | 1 |
| 300194 | RS 32-10 | 32 | 10 | 65 | 37 | 60 | 1 |
| 300600 | RS 32-08 | 32 | 8  | 65 | 37 | 60 | 1 |
| 300683 | RS 32-06 | 32 | 6  | 65 | 37 | 60 | 1 |

|        |          |    |    |    |    |    |     |
|--------|----------|----|----|----|----|----|-----|
| 300163 | RS 40-32 | 40 | 32 | 75 | 44 | 70 | 1.5 |
| 300164 | RS 40-25 | 40 | 25 | 75 | 44 | 70 | 1.5 |
| 300165 | RS 40-20 | 40 | 20 | 75 | 44 | 70 | 1.5 |
| 300166 | RS 40-16 | 40 | 16 | 75 | 44 | 70 | 1.5 |
| 300167 | RS 40-12 | 40 | 12 | 75 | 44 | 70 | 1.5 |
| 300168 | RS 40-10 | 40 | 10 | 75 | 44 | 70 | 1.5 |
| 300599 | RS 40-08 | 40 | 8  | 75 | 44 | 70 | 1.5 |
| 300682 | RS 40-06 | 40 | 6  | 75 | 44 | 70 | 1.5 |

|        |          |    |    |    |    |    |   |
|--------|----------|----|----|----|----|----|---|
| 300455 | RS 50-40 | 50 | 40 | 95 | 58 | 90 | 1 |
| 300456 | RS 50-32 | 50 | 32 | 95 | 58 | 90 | 1 |
| 300457 | RS 50-25 | 50 | 25 | 95 | 58 | 90 | 1 |

|        |          |    |    |     |    |     |   |
|--------|----------|----|----|-----|----|-----|---|
| 300458 | RS 60-50 | 60 | 50 | 110 | 68 | 105 | 1 |
| 300459 | Rs 60-40 | 60 | 40 | 110 | 68 | 105 | 1 |

|        |          |    |    |     |    |     |   |
|--------|----------|----|----|-----|----|-----|---|
| 300460 | RS 80-60 | 80 | 60 | 128 | 88 | 123 | 1 |
| 300461 | RS 80-50 | 80 | 50 | 128 | 88 | 123 | 1 |

## Inch

| Part Number | Type                       | OD h6 (inch) | ID H7 (inch) | L (inch) | D (inch) | L1 (inch) | d (inch) |
|-------------|----------------------------|--------------|--------------|----------|----------|-----------|----------|
| 300235      | RS i 1 ¼ - 1               | 1.25         | 1.00         | 2.56     | 1.46     | 2.36      | 0.04     |
| 300236      | RS i 1 ¼ - ¾               | 1.25         | 0.75         | 2.56     | 1.46     | 2.36      | 0.04     |
| 300237      | RS i 1 ¼ - ⅝               | 1.25         | 0.625        | 2.56     | 1.46     | 2.36      | 0.04     |
| 300238      | RS i 1 ¼ - ½               | 1.25         | 0.50         | 2.56     | 1.46     | 2.36      | 0.04     |
| 300239      | RS i 1 ¼ - ⅜               | 1.25         | 0.375        | 2.56     | 1.46     | 2.36      | 0.04     |
| 300636      | RS i 1 ¼ - ⅝ <sub>16</sub> | 1.25         | 0.3125       | 2.56     | 1.46     | 2.36      | 0.04     |
| 301218      | RS i 1 ¼ - ¼               | 1.25         | 0.25         | 2.56     | 1.46     | 2.36      | 0.04     |

|        |                            |      |        |      |      |      |      |
|--------|----------------------------|------|--------|------|------|------|------|
| 300229 | RS i 1 ½ - 1 ¼             | 1.50 | 1.25   | 2.95 | 1.69 | 2.76 | 0.06 |
| 300230 | RS i 1 ½ - 1               | 1.50 | 1.00   | 2.95 | 1.65 | 2.76 | 0.06 |
| 300231 | RS i 1 ½ - ¾               | 1.50 | 0.75   | 2.95 | 1.65 | 2.76 | 0.06 |
| 300232 | RS i 1 ½ - ⅝               | 1.50 | 0.625  | 2.95 | 1.65 | 2.76 | 0.06 |
| 300233 | RS i 1 ½ - ½               | 1.50 | 0.50   | 2.95 | 1.65 | 2.76 | 0.06 |
| 300234 | RS i 1 ½ - ⅜               | 1.50 | 0.375  | 2.95 | 1.65 | 2.76 | 0.06 |
| 300635 | RS i 1 ½ - ⅝ <sub>16</sub> | 1.50 | 0.3125 | 2.95 | 1.65 | 2.76 | 0.06 |
| 301217 | RS i 1 ½ - ¼               | 1.50 | 0.25   | 2.95 | 1.65 | 2.76 | 0.06 |

|        |             |      |      |      |      |      |      |
|--------|-------------|------|------|------|------|------|------|
| 300639 | RS i 2- 1 ½ | 2.00 | 1.25 | 3.74 | 2.28 | 3.54 | 0.04 |
| 300640 | RS i 2- 1 ¼ | 2.00 | 1.50 | 3.74 | 2.28 | 3.54 | 0.04 |
| 300641 | RS i 2- 1   | 2.00 | 1.00 | 3.74 | 2.28 | 3.54 | 0.04 |

|        |                |      |      |      |      |      |      |
|--------|----------------|------|------|------|------|------|------|
| 300642 | RS i 2 ½- 2    | 2.50 | 2.00 | 4.33 | 2.67 | 4.13 | 0.04 |
| 300643 | RS i 2 ½ - 1 ½ | 2.50 | 1.50 | 4.33 | 2.67 | 4.13 | 0.04 |

|        |              |      |      |      |      |      |      |
|--------|--------------|------|------|------|------|------|------|
| 300644 | RS i 3 - 2 ½ | 3.00 | 2.50 | 5.04 | 3.46 | 4.84 | 0.04 |
| 300645 | RS i 3 - 2   | 3.00 | 2.00 | 5.04 | 3.46 | 4.84 | 0.04 |

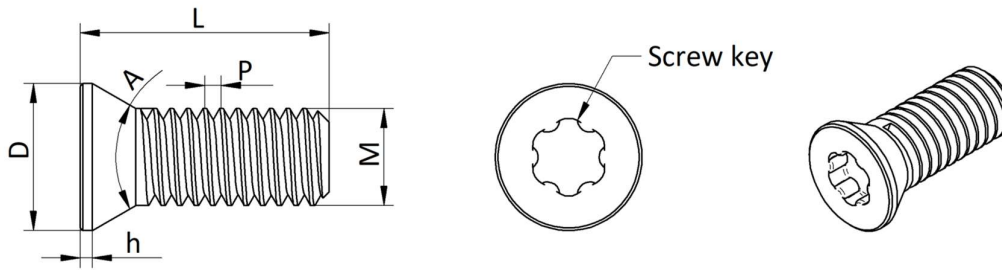
## Level Indicator



| Part Number | Product                              | Width (mm) | Length (mm) | Height (mm) | Weight (g) | Battery   | Lightning |
|-------------|--------------------------------------|------------|-------------|-------------|------------|-----------|-----------|
| 300175      | Digital protractor - Level Indicator | 26         | 57          | 55          | 85         | AA. 2 pcs | Yes       |

|  |                                                                                       |
|--|---------------------------------------------------------------------------------------|
|  | Delivered with a magnet with power of 4.8 kg for easier alignment of machining tools. |
|--|---------------------------------------------------------------------------------------|

## Insert screws

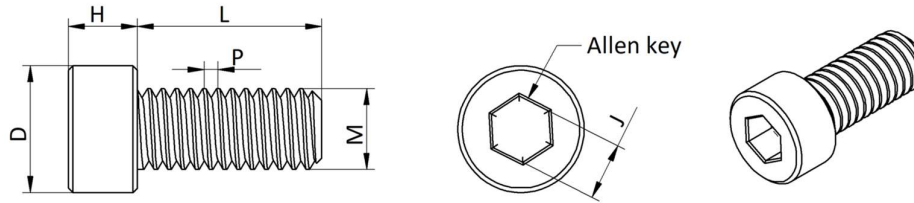


## Insert screws

| Part Number | Type - Torx     | Quantity   | Designation          | Thread M | D (mm) | L (mm) | A (°) | P (mm) | h (mm) | Torx Key |
|-------------|-----------------|------------|----------------------|----------|--------|--------|-------|--------|--------|----------|
| 300659      | IS M2.0x4.0     | 10 pcs/bag | M2.0x4xD2.8xP0.4     | M2.0     | 2.8    | 4      | 60    | 0.40   | 0.3    | T6       |
| 300257      | IS M2.2x5.0     | 10 pcs/bag | M2.2x5.0xD3.0xP0.45  | M2.2     | 3.0    | 5.0    | 60    | 0.45   | 0.8    | T7       |
| 300701      | IS M2.5x4.5     | 10 pcs/bag | M2.5x4.5xD3.6xP0.45  | M2.5     | 3.6    | 4.5    | 55    | 0.45   | 0.6    | T8       |
| 300258      | IS M2.5x6.0     | 10 pcs/bag | M2.5x6.0xD3.6xP0.45  | M2.5     | 3.6    | 6.0    | 55    | 0.45   | 0.6    | T8       |
| 300620      | IS M2.5x8.0     | 10 pcs/bag | M2.5x8.0xD3.6xP0.45  | M2.5     | 3.6    | 8.0    | 55    | 0.45   | 0.6    | T8       |
| 301574      | IS M3.0x6.0     | 10 pcs/bag | M3x6.0xD4.0XP0.50    | M3.0     | 4.0    | 6.0    | 55    | 0.50   | 0.5    | T8       |
| 300617      | IS M3.5x11.0    | 10 pcs/bag | M3.5x11.0xD5.3XP0.60 | M3.5     | 5.3    | 10.0   | 60    | 0.60   | 1.2    | T15      |
| 300618      | IS M4.0x15.0xD7 | 10 pcs/bag | M4.0x15.0xD7.0xP0.70 | M4.0     | 7.0    | 15.0   | 60    | 0.70   | NA     | T15      |
| 300619      | IS M4.5x12.0    | 10 pcs/bag | M4.5x12.0xD6.8xP0.75 | M4.5     | 6,8    | 12     | 60    | 0.75   | NA     | T20      |
| 300425      | IS M5.0x18.0    | 10 pcs/bag | M5.0x18.0xD8.2xP0.8  | M5.0     | 8,2    | 18     | 60    | 0.80   | NA     | T20      |

## Cutter head screws

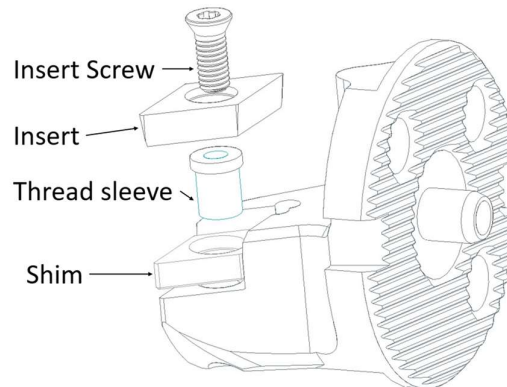
Standard: DIN 912



### Cutter head screws

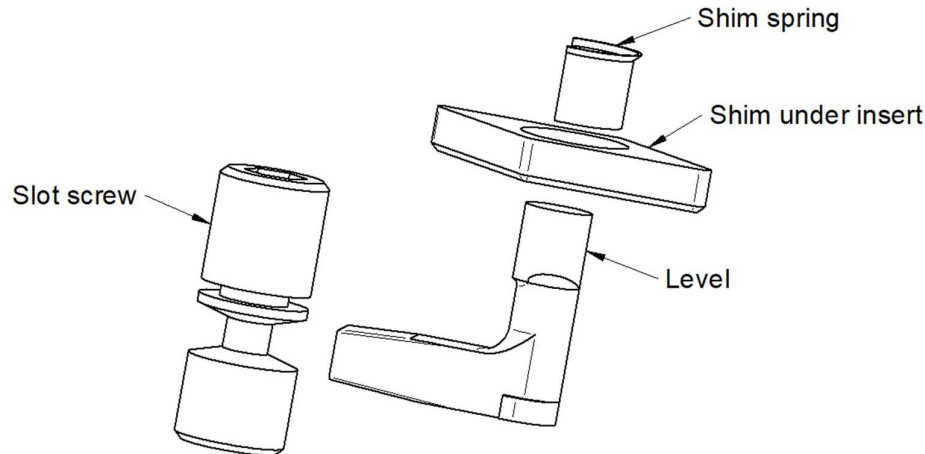
| Part Number | Type (DIN912) | Quantity   | Thread M | D (mm) | L (mm) | H (mm) | P (mm) | Key (mm)          | Suitable for           |
|-------------|---------------|------------|----------|--------|--------|--------|--------|-------------------|------------------------|
| 300260      | HS M2x8       | 10 pcs/bag | M2       | 3.8    | 8      | 2      | 0.4    | Allen key A/F 1.5 | SL12                   |
| 300261      | HS M2x14      | 10 pcs/bag | M2       | 3.8    | 14     | 2      | 0.4    | Allen key A/F 1.5 | SL12                   |
| 300673      | HS M3x6       | 10 pcs/bag | M3       | 5.5    | 6      | 3      | 0.5    | Allen key A/F 2.5 | EA16, IA16, EA22, IA22 |
| 300169      | HS M3x8       | 10 pcs/bag | M3       | 5.5    | 8      | 3      | 0.5    | Allen key A/F 2.5 | SL16, SL20             |
| 300170      | HS M4x9       | 10 pcs/bag | M4       | 7      | 9      | 4      | 0.7    | Allen key A/F 3   | SL25                   |
| 300171      | HS M5x12      | 10 pcs/bag | M5       | 8.5    | 12     | 5      | 0.8    | Allen key A/F 4   | SL32                   |
| 300262      | HS M6x14      | 10 pcs/bag | M6       | 10     | 14     | 6      | 1      | Allen key A/F 5   | SL40                   |
| 300263      | HS M8x14      | 10 pcs/bag | M8       | 13     | 14     | 8      | 1.25   | Allen key A/F 6   | SL50, SL60             |

## Shims



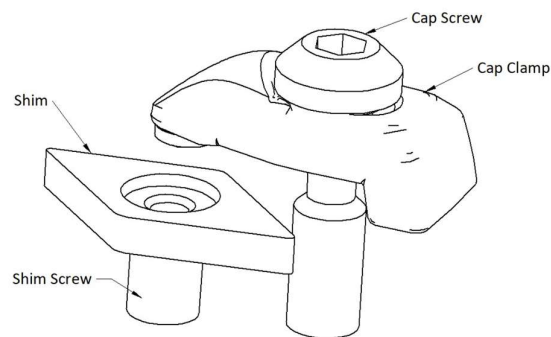
| Part Number | Type                                          | Fits                                                                         |
|-------------|-----------------------------------------------|------------------------------------------------------------------------------|
| 300433      | Shim CCMT 09T3 with thread sleeve M5x0.5-M3.5 | STMD M32-256 SCLCL/R C, STMD M40-320 SCLCL/R C                               |
| 300430      | Shim CCMT 1204 with thread sleeve M6x0.75-M4  | SL40 SCLCL/R CP                                                              |
| 300431      | Shim DCMT 11T3 with thread sleeve M5x0.5-M3.5 | SL40 SDUCL/R CP, SL32 SDUCL/R CP, STMD M32-256 SDUCR/L, STMD M40-320 SDUCR/L |
| 300432      | Shim TCMT 16T3 with thread sleeve M5x0.5-M3.5 | SL40 STFCL/R CP                                                              |
| 300669      | Shim VCMT 1604 with thread sleeve M5x0.5-M3.5 | SL40 SVUCL/R CP, SL32 SVUCL/R CP                                             |
| 300435      | Shim EA16 - IL16                              | SL25 SXFNL P 16, SL32 SXFNL P 16, SL40 SXFNL CP 16                           |
| 300436      | Shim IA16 - IR16                              | SL25 SXFNR P 16, SL32 SXFNR P 16, SL40 SXFNR CP 16                           |
| 300437      | Shim EA22 - IL22                              | SL25 SXFNL P 22, SL32 SXFNL CP 22, SL40 SXFNL CP 22                          |
| 300438      | Shim IA22 - IR22                              | SL25 SXFNR P 22, SL32 SXFNR CP 22, SL40 SXFNR CP 22                          |
| 300439      | Shim EA27 - IL27                              | SL40 SXFNL CP 27                                                             |
| 300440      | Shim IA27 - IR27                              | SL40 SXFNR CP 27                                                             |

## Service kit for P clamp heads (includes level, shim, slot screw, spring)



| Part number | Service kit for                      | Cutter head                                                      | Level, 1 pcs | Shim, 1 pcs    | Slot screw, 1 pcs | Spring, 1 pcs |
|-------------|--------------------------------------|------------------------------------------------------------------|--------------|----------------|-------------------|---------------|
| 300434      | 300086<br>300402                     | SL40 PDUNR CP<br>SL40 PDUNL CP                                   | LV4 G0516    | Shim DNMG 1506 | M8x1x21           | T2-6          |
| 300426      | 300427<br>300562                     | SL32 PDUNR CP<br>SL32 PDUNL CP                                   | LV3 G0312    | Shim DNMG 1104 | M6x1x17           | T1-5          |
| 301165      | 300661<br>300660                     | SL25 PDUNR CP<br>SL25 PDUNL CP                                   | LV3 G0310    | Shim DNMG 1104 | M5x0.8x15         | T1-5          |
| 300471      | 300088<br>300403<br>300429<br>300563 | SL40 PTFNR CP<br>SL40 PTFNL CP<br>SL32 PTFNR CP<br>SL32 PTFNL CP | LV3 G0310    | Shim TNMG 1604 | M6x1x17           | T1-5          |
| 300472      | 300087<br>300404                     | SL40 PCLNR CP<br>SL40 PCLNL CP                                   | LV4 G0513    | Shim CNMG 1204 | M8x1x21           | T2-6          |
| 300473      | 300428<br>300564                     | SL32 PCLNR CP<br>SL32 PCLNL CP                                   | LV4 G0513    | Shim CNMG 1204 | M6x1x17           | T2-6          |
| 300668      | 300474<br>300475                     | SL40 PWLNR CP<br>SL40 PWLNL CP                                   | LV4 G0513    | Shim WNMG 0804 | M8x1x21           | T2-6          |

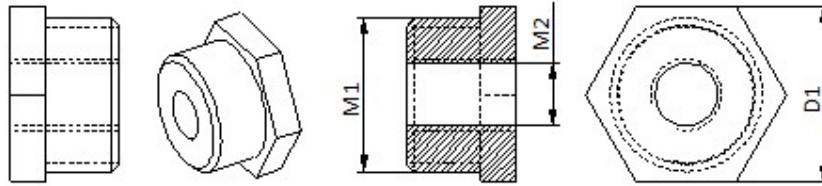
## Service kit for D clamp heads (includes Cap, Cap screw, shim, shim screw and spring)



| Part number | Service kit for | Cutter head                              | Cap Clamp 1 pcs | Cap screw 1 pcs | Spring 1 pcs | Shim 1 pcs | Shim screw 1 pcs |
|-------------|-----------------|------------------------------------------|-----------------|-----------------|--------------|------------|------------------|
| 301423      | 301238 301239   | SL40 DDUNR CP 1506<br>SL40 DDUNL CP 1506 | C2RA            | CM6X25C         | SPR4 7x11    | D1503      | Sleeve M6x0.75   |
| 301425      | 301240 301241   | SL40 DDUNR CP 1504<br>SL40 DDUNL CP 1504 | C2RA            | CM6X25C         | SPR4 7x11    | D15BM      | Sleeve M6x0.75   |
| 301424      | 301242 301243   | SL40 DCLNR CP 1204<br>SL40 DCLNL CP 1204 | C2RA            | CM6X25C         | SPR4 7x11    | C12BM      | Sleeve M6x0.75   |
| 301535      | 301 426 301 427 | SL40 DVUNR CP 1604<br>SL40 DVUNL CP 1604 | C6RA            | CM5X25C         | SPR6 7x10    | V16BM      | Sleeve M5x0.5    |



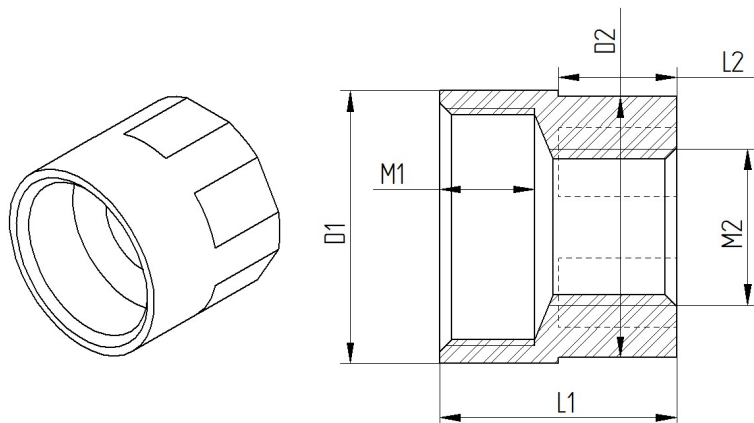
## Coolant adapters for steel bars



### Steel bars

| Part Number | Type         | M1  | M2  | D1 |
|-------------|--------------|-----|-----|----|
| 300610      | CA G ¼ - G ⅝ | G ¼ | G ⅝ | 17 |
| 300611      | CA G ½ - G ⅝ | G ½ | G ⅝ | 24 |
| 300612      | CA G ¾ - G ⅝ | G ¾ | G ⅝ | 30 |

## Coolant adapters for carbide bars

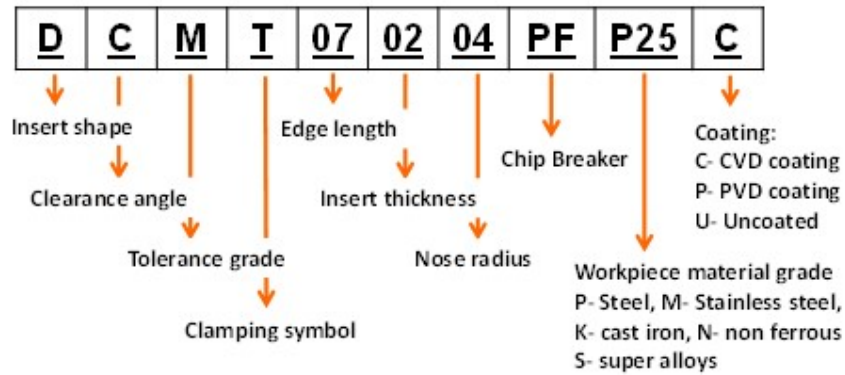


### Carbide bars

| Part Number | Type         | M1    | M2  | L1 | L2 | D1 | D2 | Works for                                                                          |
|-------------|--------------|-------|-----|----|----|----|----|------------------------------------------------------------------------------------|
| 300613      | CA M12x1 G ⅝ | M12x1 | G ⅝ | 16 | 8  | 14 | 13 | STMD M16-204 SL16, STMD M16-268 SL16<br>STMD I 5/8-8.0 SL16, STMD I 5/8-10.6 SL16  |
| 300614      | CA M16x1 G ⅝ | M16x1 | G ⅝ | 20 | 10 | 18 | 16 | STMD M20-260 SL20, STMD M20-340 SL20<br>STMD I 3/4-10.3 SL20, STMD I 3/4-13.4 SL20 |
| 300615      | CA M20x1 G ⅝ | M20x1 | G ⅝ | 20 | 10 | 23 | 22 | STMD M25-340 SL25, STMD I 1-16.9 SL25                                              |
| 300616      | CA M24x1 G ⅝ | M24x1 | G ⅝ | 30 | 15 | 30 | 28 | STMD M32-544 SL32, STMD I 1 1/4 -21.4 SL32                                         |

## MAQ Master Inserts

Inserts are sold in packages of 10 pcs.



### Positive insert

| Part Number | Article             | DCMT                                                                               |
|-------------|---------------------|------------------------------------------------------------------------------------|
| 300244      | DCMT 070204-FP P25C |  |
| 300245      | DCMT 11T304-FP P25C |                                                                                    |

| Part Number | Article             | TCMT                                                                                 |
|-------------|---------------------|--------------------------------------------------------------------------------------|
| 300246      | TCMT 090204-FP P25C |  |
| 300247      | TCMT 110304-FP P25C |                                                                                      |
| 300248      | TCMT 16T304-FP P25C |                                                                                      |

| Part Number | Article             | CCMT                                                                                 |
|-------------|---------------------|--------------------------------------------------------------------------------------|
| 300249      | CCMT 060204-FP P25C |  |
| 300250      | CCMT 09T304-FP P25C |                                                                                      |
| 300251      | CCMT 120404-FP P25C |                                                                                      |

### Negative insert

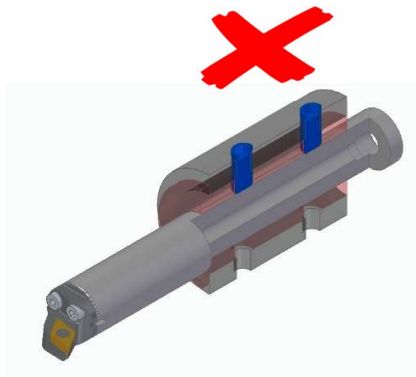
| Part Number | Article             | DNMG                                                                                 |
|-------------|---------------------|--------------------------------------------------------------------------------------|
| 300294      | DNMG 150604-LC P25C |  |

| Part Number | Article             | TNMG                                                                                 |
|-------------|---------------------|--------------------------------------------------------------------------------------|
| 300295      | TNMG 160404-LC P25C |  |

| Part Number | Article             | CNMG                                                                                 |
|-------------|---------------------|--------------------------------------------------------------------------------------|
| 300296      | CNMG 120404 LC P25C |  |

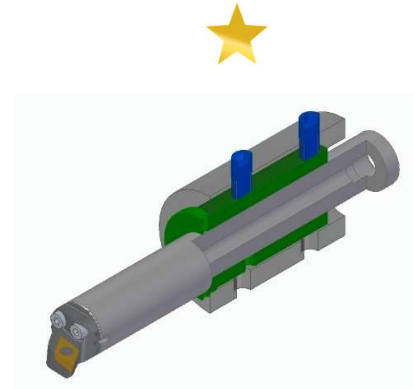
## Clamping of Turning tools

The clamping of the tool is very important in all operations but even more so when the overhang is long, i.e. high L/D -ratios. Please be aware that a weak clamping with low bending stiffness will have negative impact on the performance.



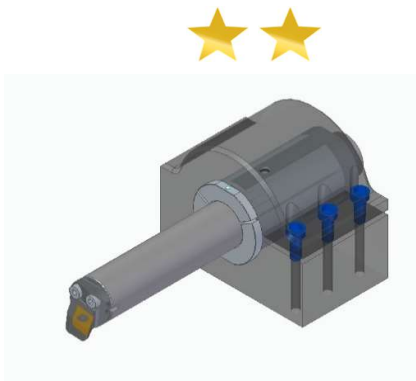
### Direct Screw Mount:

- Unacceptable Bending Stiffness
- Clamping Length = N/A



### Reduction Sleeve:

- Acceptable Bending Stiffness for low L/D
- Recommended Clamping Length =  $>3xD$



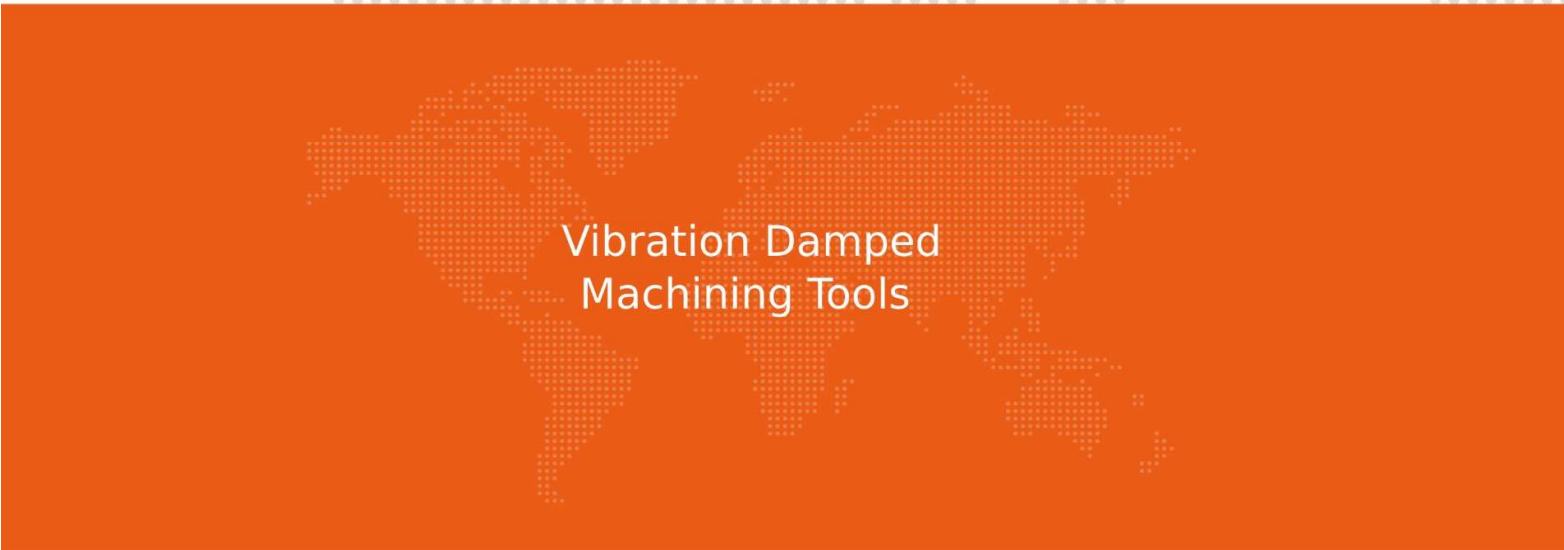
### All Around Clamp:

- Better Bending Stiffness
- Recommended Clamping Length =  $>3xD$



### Hydraulic Fixtures:

- Best Bending Stiffness (Recommended for high L/D)
- Recommended Clamping Length =  $>2xD$



## Vibration Damped Machining Tools

**MAQ AB**

Stenhuggarvagen 1  
SE-132 38 Saltsjö-boo  
Sweden

[www.maqab.com](http://www.maqab.com)