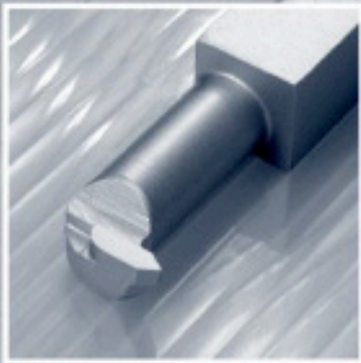
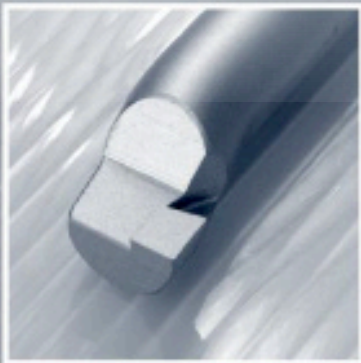


GELÖTETE HM-DREHHALTER

Katalog



Brazed tools

Technical information	K.02
Inserts	K.03
Applications	K.05
Toolholders	K.06
Boring bars	K.11

Inserts

General turning

Aluminium
wheel turning

Automatic lathes

Ceramic tools

Parting and
grooving

Threading

Drills

Cartridges

Brazed tools

Uncoated inserts

KM15

A finishing grade in the K10 range. This carbide grade is for use on cast iron, aluminium and heat-resistant alloys. This grade works well on cobalt based alloys and synthetic materials and is suitable for finishing on heat-resistant alloys.

PM25

A general purpose uncoated grade in the P30 range. This tough, economical grade is for machining of carbon steels, alloy steels, tool steels and stainless steels.

PM25 provides toughness and resistance to deformation in roughing and semi-finishing operations.

Grinding

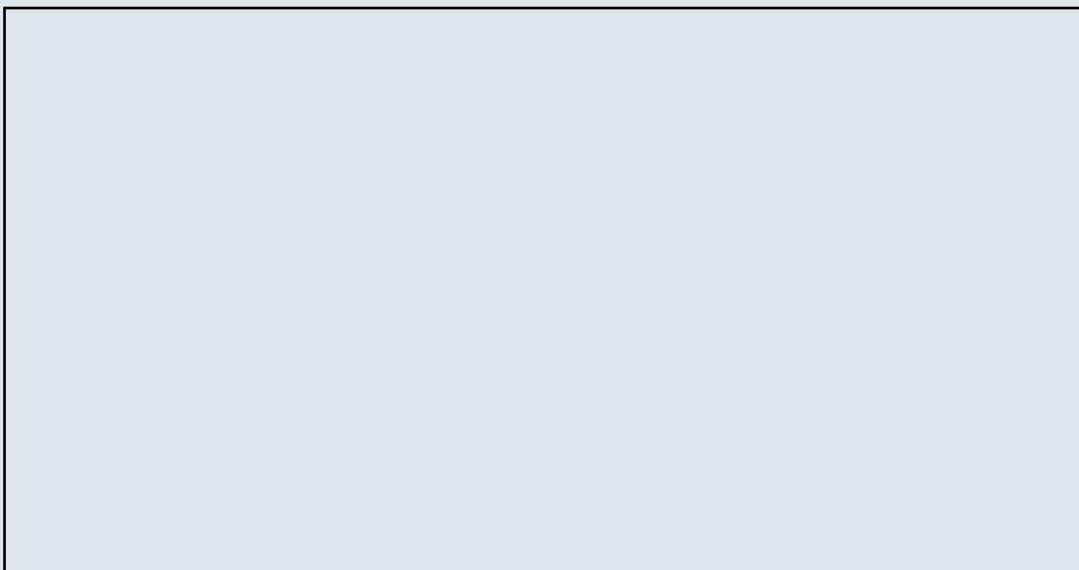
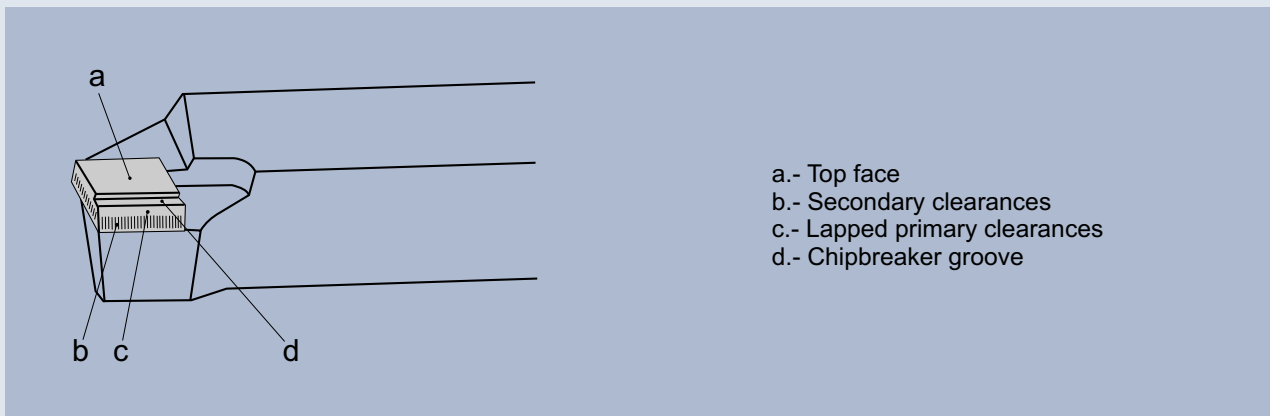
In order to obtain a satisfactory result, it is necessary to have a steady grinding table or holder which can be set to the required angle by means of a graduated scale and by non-vibrating small spindles.

Rough grinding is normally carried out using a silicon carbide grinding wheel. The finish grind or lapping must always be made using a diamond wheel.

Longer life of the cutting edge and less breakage justify the increased cost of correct grinding.

The grinding wheel must be kept clean to ensure that cutting capacity is maintained.

Whenever possible, always grind perpendicular to the cutting edge.



	AB	Normally available for immediate delivery ● Only available in a limited quantity ○													
			l	s	b	r	β°	KM15	PM25	PM40	TIN16	TIN17	TIN22	TIN25	TIN32
	AB 6	6,00	2,50	4,00	2,00	-	●								
	AB 8	8,00	3,00	5,00	3,00	-	●								

	ABC	Normally available for immediate delivery ● Only available in a limited quantity ○													
			l	s	b	r	β°	KM15	PM25	PM40	TIN16	TIN17	TIN22	TIN25	TIN32
	ABC 10	11,00	4,00	6,00	-	16°	●	●							
	ABC 12	13,00	5,00	8,00	-	18°	●	●							
	ABC 16	17,00	6,00	10,00	-	18°	●	●							
	ABC 20	21,00	7,00	12,00	-	16°	●	●							
	ABC 25	26,00	8,00	14,00	-	16°	●	●							


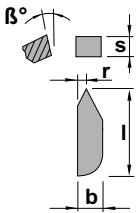

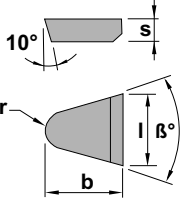

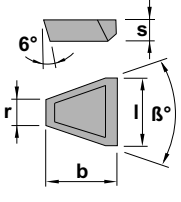
Only for:
 -ABC 10
 -ABC 20
 -ABC 25

Only for:
 -ABC 12
 -ABC 16

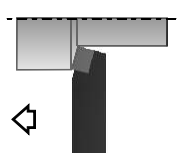
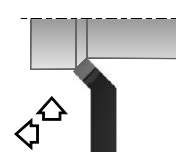
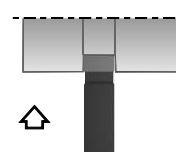
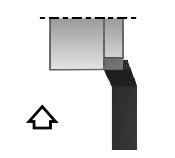
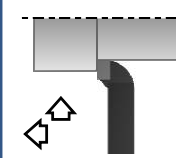
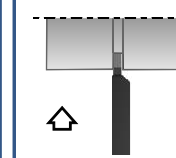
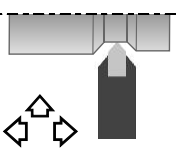
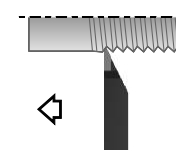
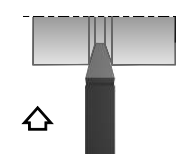
	C	Normally available for immediate delivery ● Only available in a limited quantity ○													
			l	s	b	r	β°	KM15	PM25	PM40	TIN16	TIN17	TIN22	TIN25	TIN32
	C 7	7,00	2,50	5,00	-	0°	●	●							
	C 8	8,00	3,25	5,00	-	0°	●	●							
	C 10	10,00	4,00	6,00	-	18°	●	●							
	C 12	12,00	5,00	8,00	-	18°	●	●							
	C 16	16,00	6,00	10,00	-	18°	●	●							
	C 20	20,00	7,00	12,00	-	18°	●	●							
	C 25	25,00	8,00	14,00	-	18°	●	●							

	D	Normally available for immediate delivery ● Only available in a limited quantity ○													
			l	s	b	r	β°	KM15	PM25	PM40	TIN16	TIN17	TIN22	TIN25	TIN32
	D 3	3,00	3,00	8,00	-	0°	●	●							
	D 4	4,00	4,00	10,00	-	14°	●	●							
	D 5	5,00	5,00	12,00	-	14°	●	●							
	D 6	6,00	6,00	14,00	-	14°	●	●							
	D 8	8,00	8,00	16,00	-	14°	●	●							
	D 10	10,00	10,00	18,00	-	14°	●	●							

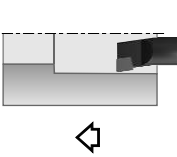
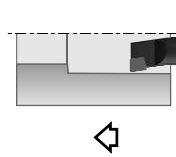
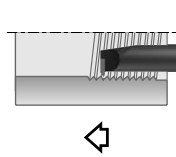
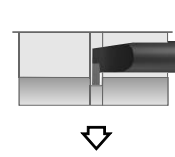
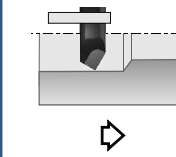
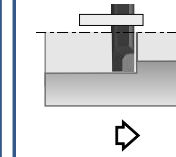
	E	Normally available for immediate delivery ● Only available in a limited quantity ○													
			l	s	b	r	β°	KM15	PM25	PM40	TIN16	TIN17	TIN22	TIN25	TIN32
	E 8	8,00	4,00	16,00	-	9°	●	●							
	E 10	10,00	5,00	18,00	-	9°	●	●							
	E 12	12,00	6,00	20,00	-	9°	●	●							

Inserts		Normally available for immediate delivery ● Only available in a limited quantity ○														
General turning		FIL	l	s	b	r	β°	KM15	PM25	PM40	TIN16	TIN17	TIN22	TIN25	TIN32	ZR10
		FIL 3,5	12,00	3,50	3,50	1,00	5°	●	●							
		FIL 4	14,00	4,00	4,00	1,20	5°	●	●							
		FIL 5	16,00	5,00	5,00	1,50	5°	●	●							
		FIL 6	18,00	6,00	6,00	1,80	5°	●	●							
Aluminium wheel turning		Normally available for immediate delivery ● Only available in a limited quantity ○														
Automatic lathes		PR	l	s	b	r	β°	KM15	PM25	PM40	TIN16	TIN17	TIN22	TIN25	TIN32	ZR10
		PR 8	8,00	4,00	12,00	1,00	30°	●								
		PR 10	10,00	4,00	14,00	1,50	30°	●								
		PR 12	12,00	5,00	17,00	2,50	30°	●								
Ceramic tools		Normally available for immediate delivery ● Only available in a limited quantity ○														
Parting and grooving		TR	l	s	b	r	β°	KM15	PM25	PM40	TIN16	TIN17	TIN22	TIN25	TIN32	ZR10
		TR 16-32	16,00	6,00	21,00	5,00	32°	●								
		TR 16-36	16,00	6,00	21,00	4,00	36°	●								
		TR 20-32	20,00	6,00	25,00	7,50	32°	●								
		TR 20-36	20,00	6,00	25,00	5,80	36°	●								
Threading																
Drills																
Cartridges																
Brazed tools																

Toolholders

<p>ISO 1 75°</p>  <p>Page K.06</p>	<p>ISO 2 45°</p>  <p>Page K.06</p>	<p>ISO 4 90°</p>  <p>Page K.07</p>	<p>ISO 5 90°</p>  <p>Page K.07</p>	<p>ISO 6 90°</p>  <p>Page K.08</p>	<p>ISO 7 90°</p>  <p>Page K.08</p>
<p>ISO 351 80°</p>  <p>Page K.09</p>	<p>UI 30 55° - 60°</p>  <p>Page K.09</p>	<p>UI 80</p>  <p>Page K.10</p>			

Boring bars

<p>ISO 8 75°</p>  <p>Page K.11</p>	<p>ISO 9 90°</p>  <p>Page K.11</p>	<p>UI 40 55° - 60°</p>  <p>Page K.12</p>	<p>UI 50 90°</p>  <p>Page K.12</p>	<p>C6 60°</p>  <p>Page K.13</p>	<p>D6 90°</p>  <p>Page K.13</p>
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Inserts

General turning

Aluminium wheel turning

Automatic lathes

Ceramic tools

Parting and grooving

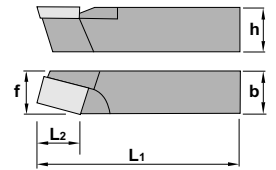
Threading

Drills

Cartridges

Brazed tools

Characteristics:
Brazed toolholder DIN 4971



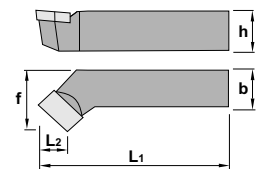
ISO 1 75°

Normally available for immediate delivery ●

Only available in a limited quantity ○

Ref.		h	b	L	L2	f	Insert size	Kg	KM15	PM25
ISO1 1616 R	ISO1 1616 R	16	16	110	11	10	ABC 12	0,200	●	●
	ISO1 1616 L	16	16	110	11	10	ABC 12	0,200	●	●
ISO1 2020 R	ISO1 2020 R	20	20	125	15	12	ABC 16	0,350	●	●
	ISO1 2020 L	20	20	125	15	12	ABC 16	0,350	●	●
ISO1 2525 R	ISO1 2525 R	25	25	140	18	15	ABC 20	0,650	●	●
	ISO1 2525 L	25	25	140	18	15	ABC 20	0,650	●	●

Characteristics:
Brazed toolholder DIN 4972



ISO 2 45°

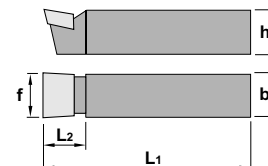
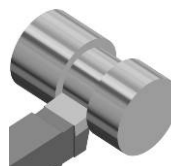
Normally available for immediate delivery ●

Only available in a limited quantity ○

Ref.		h	b	L	L2	f	Insert size	Kg	KM15	PM25
ISO2 1010 R	ISO2 1010 R	10	10	90	8	14	C8	0,070	○	○
	ISO2 1010 L	10	10	90	8	14	C8	0,070	○	○
ISO2 1212 R	ISO2 1212 R	12	12	100	10	17	ABC10	0,100	○	●
	ISO2 1212 L	12	12	100	10	17	ABC10	0,100	○	●
ISO2 1616 R	ISO2 1616 R	16	16	110	12	22	ABC12	0,200	●	●
	ISO2 1616 L	16	16	110	12	22	ABC12	0,200	●	●
ISO2 2020 R	ISO2 2020 R	20	20	125	16	28	ABC16	0,400	●	●
	ISO2 2020 L	20	20	125	16	28	ABC16	0,400	●	●
ISO2 2525 R	ISO2 2525 R	25	25	140	20	35	ABC20	0,650	●	●
	ISO2 2525 L	25	25	140	20	35	ABC20	0,650	●	●
ISO2 3232 R	ISO2 3232 R	32	32	170	25	44	ABC25	1,300	●	●
	ISO2 3232 L	32	32	170	25	44	ABC25	1,300	●	●



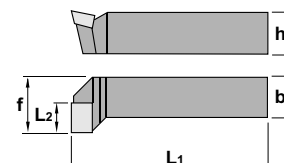
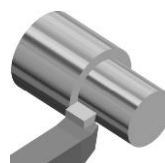
Characteristics:
Brazed toolholder DIN 4976



ISO 4 90°		Normally available for immediate delivery ● Only available in a limited quantity ○								
		h	b	L	L2	f	Insert size	kg	KM15	PM25
Ref.	ISO4 1010 N	10	10	90	10	10	ABC10	0,070	○	○
	ISO4 1212 N	12	12	100	12	12	ABC12	0,100	○	○
	ISO4 1616 N	16	16	110	16	16	ABC16	0,250	○	○
	ISO4 2020 N	20	20	125	20	20	ABC20	0,400	○	○
	ISO4 2525 N	25	25	140	25	25	ABC25	0,650	○	○



Characteristics:
Brazed toolholder DIN 4977



ISO 5 90°		Normally available for immediate delivery ● Only available in a limited quantity ○								
		h	b	L	L2	f	Insert size	kg	KM15	PM25
Ref.	ISO5 1616 R	16	16	110	12	24	ABC12	0,200	○	○
	ISO5 1616 L	16	16	110	12	24	ABC12	0,200	○	○
	ISO5 2020 R	20	20	125	16	30	ABC16	0,400	○	○
	ISO5 2020 L	20	20	125	16	30	ABC16	0,400	○	○

Inserts

General turning

Aluminium wheel turning

Automatic lathes

Ceramic tools

Parting and grooving

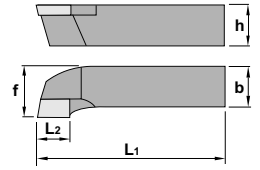
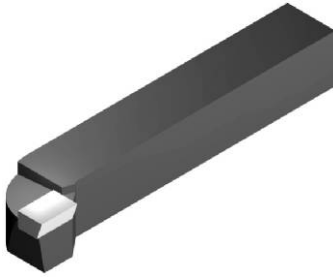
Threading

Drills

Cartridges

Brazed tools

Characteristics:
Brazed toolholder DIN 4980



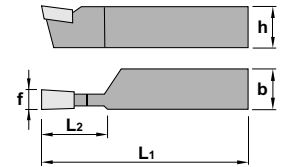
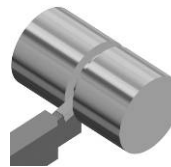
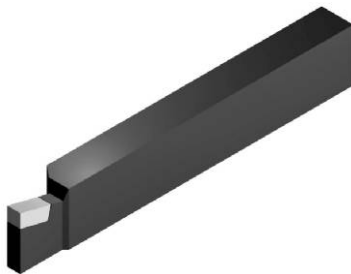
ISO 6 90°

Normally available for immediate delivery ●

Only available in a limited quantity ○

Ref.		h	b	L	L2	f	Insert size	Kg	KM15	PM25
ISO6 1010 R	ISO6 1010 R	10	10	90	8	14	C8	0,070	○	○
	ISO6 1010 L	10	10	90	8	14	C8	0,070	○	○
ISO6 1212 R	ISO6 1212 R	12	12	100	10	17	ABC10	0,100	○	●
	ISO6 1212 L	12	12	100	10	17	ABC10	0,100	○	●
ISO6 1616 R	ISO6 1616 R	16	16	110	12	22	ABC12	0,200	●	●
	ISO6 1616 L	16	16	110	12	22	ABC12	0,200	●	●
ISO6 2020 R	ISO6 2020 R	20	20	125	16	28	ABC16	0,400	●	●
	ISO6 2020 L	20	20	125	16	28	ABC16	0,400	●	●
ISO6 2525 R	ISO6 2525 R	25	25	140	20	35	ABC20	0,650	●	●
	ISO6 2525 L	25	25	140	20	35	ABC20	0,650	●	●
ISO6 3232 R	ISO6 3232 R	32	32	170	25	44	ABC25	1,250	●	●
	ISO6 3232 L	32	32	170	25	44	ABC25	1,250	●	●

Characteristics:
Brazed toolholder DIN 4981

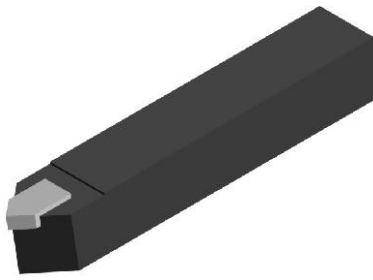


ISO 7 90°

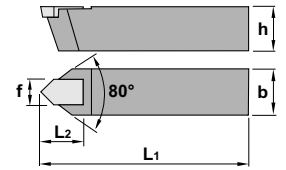
Normally available for immediate delivery ●

Only available in a limited quantity ○

Ref.		h	b	L	L2	f	Insert size	Kg	KM15	PM25
ISO7 1208 R	ISO7 1208 R	12	08	100	12	3	D3	0,070	○	●
	ISO7 1208 L	12	08	100	12	3	D3	0,070	○	●
ISO7 1610 R	ISO7 1610 R	16	10	110	14	4	D4	0,150	●	●
	ISO7 1610 L	16	10	110	14	4	D4	0,150	●	●
ISO7 2012 R	ISO7 2012 R	20	12	125	16	5	D5	0,200	●	●
	ISO7 2012 L	20	12	125	16	5	D5	0,200	●	●
ISO7 2516 R	ISO7 2516 R	25	16	140	20	6	D6	0,400	●	●
	ISO7 2516 L	25	16	140	20	6	D6	0,400	●	●
ISO7 3220 R	ISO7 3220 R	32	20	170	25	8	D8	0,750	●	●
	ISO7 3220 L	32	20	170	25	8	D8	0,750	●	●
ISO7 4025 R	ISO7 4025 R	40	25	200	32	10	D10	1,350	●	●
	ISO7 4025 L	40	25	200	32	10	D10	1,350	●	●



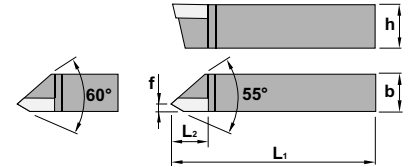
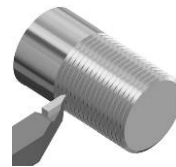
Characteristics:
Brazed toolholder DIN 4975



ISO 351 80°		Normally available for immediate delivery ● Only available in a limited quantity ○								
		h	b	L	L2	f	Insert size	Kg	KM15	PM25
Ref.	ISO351 1212 N	12	12	100	10	5	E5	0,100	○	○
	ISO351 1616 N	16	16	110	12	6	E6	0,200	○	○
								0,200	○	○
	ISO351 2012 N	20	12	125	12	6	E6	0,400	○	○
	ISO351 2020 N	20	20	125	16	8	E8	0,400	○	○
								0,400	○	○
	ISO351 2516 N	25	16	140	16	8	E8			
	ISO351 2525 N	25	25	140	18	10	E10	0,650	○	○



Characteristics:
Brazed toolholder ISO 352.



UI 30 ^{55°/60°}		Normally available for immediate delivery ● Only available in a limited quantity ○									
		h	b	L	L2	f	Insert size	Kg	KM15	PM25	
Ref.	UI 30 55° 1212 R	12	12	100	12	1,8	FIL 3,5	0,100	○	○	
	UI 30 55° 1616 R	16	16	110	14	2,0	FIL 4	0,200	○	●	
	UI 30 55° 2020 R	20	20	125	16	2,5	FIL 5	0,350	○	●	
	UI 30 55° 2525 R	25	25	140	18	3,0	FIL 6	0,600	○	●	
	UI 30 60° 1212 R	12	12	100	12	1,8	FIL 3,5	0,100	●	●	
	UI 30 60° 1616 R	16	16	110	14	2,0	FIL 4	0,200	●	●	
	UI 30 60° 2020 R	20	20	125	16	2,5	FIL 5	0,350	●	●	
	UI 30 60° 2525 R	25	25	140	18	3,0	FIL 6	0,600	●	●	

Inserts

General turning

Aluminium wheel turning

Automatic lathes

Ceramic tools

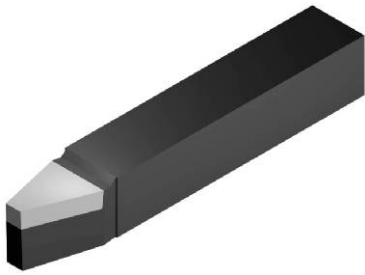
Parting and grooving

Threading

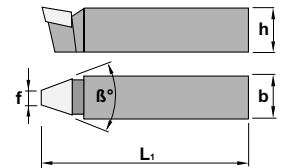
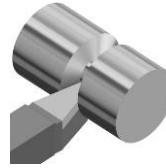
Drills

Cartridges

Brazed tools



Characteristics:
Brazed toolholder DIN 2217



UI 80

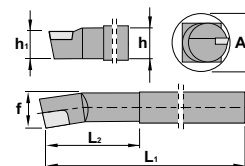
Normally available for immediate delivery ●

Only available in a limited quantity ○

Ref.		h	b	L	L2	β°	Insert size	kg	KM15	PM25
	UI 80 34° 2516	25	16	170	34°	4,2	TR16-3..	0,500		●
	UI 80 36° 2516	25	16	170	36°	3,7	TR16-3..	0,500		●
	UI 80 38° 2516	25	16	170	38°	3,1	TR16-3..	0,500	○	○
	UI 80 34° 3220	32	20	200	34°	6,2	TR20-3..	0,950	○	○
	UI 80 36° 3220	32	20	200	36°	5,5	TR20-3..	0,950	○	○
	UI 80 38° 3220	32	20	200	38°	4,9	TR20-3..	0,950	○	○



Characteristics:
Brazed boring bar UNI 4110



ISO 8 75°

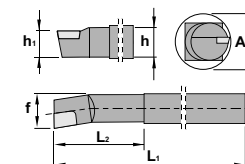
Normally available for immediate delivery ●

Only available in a limited quantity ○

Ref.		h=b	h1	L	b2	L2	f	A	Insert size	Kg	KM15	PM25
ISO8 1010 R		10	8,0	150	3,8	50	14	18	C7	0,100	○	○
ISO8 1212 R		12	9,6	180	4,8	63	17	21	C8	0,200	○	○
ISO8 1616 R		16	12,8	210	5,7	80	22	27	ABC 10	0,400	○	○
ISO8 2020 R		20	16,0	250	7,6	100	28	34	ABC 12	0,700	○	○
ISO8 2525 R		25	20,0	300	9,5	125	35	43	ABC 16	1,300	○	○



Characteristics:
Brazed boring bar UNI 4111



ISO 9 90°

Normally available for immediate delivery ●

Only available in a limited quantity ○

Ref.		h=b	h1	L	b2	L2	f	A	Insert size	Kg	KM15	PM25
ISO9 0808 R		8	6,4	125	3,1	40	11	14	C7	0,060	●	●
ISO9 1010 R		10	8,0	150	4,0	50	14	18	C7	0,100	●	●
ISO9 1212 R		12	9,6	180	5,1	63	17	21	C8	0,250	●	●
ISO9 1616 R		16	12,8	210	6,2	80	22	27	ABC 10	0,400	●	●
ISO9 2020 R		20	16,0	250	8,3	100	28	34	ABC 12	0,700	●	●
ISO9 2525 R		25	20,0	300	10,0	125	35	43	ABC 16	1,300	●	●
ISO9 3232 R		32	25,6	355	12,0	160	44	52	ABC 20	2,500	●	●

Inserts

General turning

Aluminium wheel turning

Automatic lathes

Ceramic tools

Parting and grooving

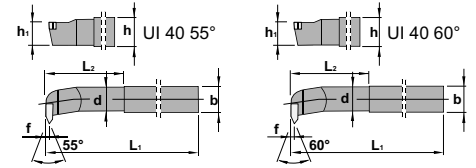
Threading

Drills

Cartridges

Brazed tools

Characteristics:
Brazed boring bar ISO 353

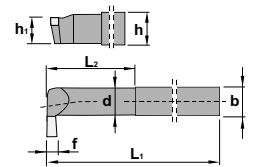
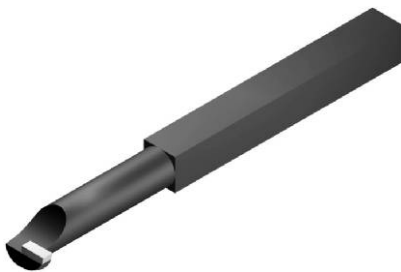


Normally available for immediate delivery ●
Only available in a limited quantity ○

UI 40 ^{55°}/_{60°}

Ref.	d	h=b	L	L2	f	Insert size	kg	KM15	PM25
UI 40 55° 1010 R	10	10	140	52	1,8	FIL 3,5	0,070	○	○
UI 40 55° 1212 R	12	12	160	56	1,8	FIL 3,5	0,200	○	○
UI 40 55° 1616 R	16	16	180	63	2,0	FIL 4	0,250	○	○
UI 40 55° 2020 R	20	20	210	80	2,0	FIL 4	0,450	○	○
UI 40 60° 1010 R	10	10	140	52	1,8	FIL 3,5	0,070	●	●
UI 40 60° 1212 R	12	12	160	56	1,8	FIL 3,5	0,200	●	●
UI 40 60° 1616 R	16	16	180	63	2,0	FIL 4	0,250	●	●
UI 40 60° 2020 R	20	20	210	80	2,0	FIL 4	0,450	●	●
UI 40 60° 2525 R	25	25	250	100	2,5	FIL 5	0,750	●	●

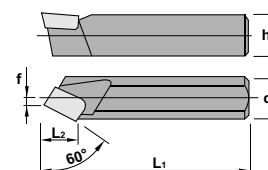
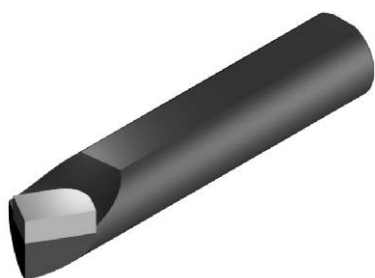
Characteristics:
Brazed boring bar ISO 354



Normally available for immediate delivery ●
Only available in a limited quantity ○

UI 50 90°

Ref.	d	h=b	L	L2	f	Insert size	kg	KM15	PM25
UI 50 90° 1010 R	10	10	140	52	3	D3	0,100	●	●
UI 50 90° 1212 R	12	12	160	56	4	D4	0,200	●	●
UI 50 90° 1616 R	16	16	180	63	5	D5	0,350	●	●
UI 50 90° 2020 R	20	20	210	80	6	D6	0,700	●	●
UI 50 90° 2525 R	25	25	250	100	8	D8	1,250	●	●

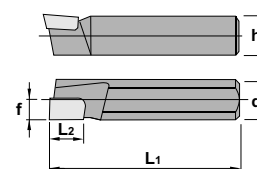
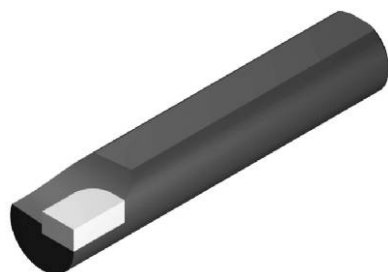


C6 60°

Normally available for immediate delivery ●

Only available in a limited quantity ○

Ref.		d	h=b	L	L2	f	Insert size	Kg	KM15	PM25
C6-08		8	7,5	30	6,5	0	C7	0,010		●
C6-10		10	9,0	50	6,5	0	C8	0,025		●



D6 90°

Normally available for immediate delivery ●

Only available in a limited quantity ○

Ref.		d	h	L	L2	f	Insert size	Kg	KM15	PM25
D6-08		8	7,0	30	7,0	1,9	C7	0,010		●
D6-10		10	8,5	50	8,0	4,6	C8	0,025		●
D6-12		12	10,5	60	10,0	5,6	ABC10	0,045		●
D6-16		16	14,0	90	12,0	7,6	ABC12	0,150		●