ISCAR New Products

Inch Version 2022

NEOLOGIQ

MACHINING INTELLIGENTLY

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NEOTA

NEO ISCAR TOOL ADVISOR

Find The NEOLOGIQAL Tool For Your Application!

- The virtual tool advisor features advanced AI and 'Big Data' analytics
- Supports with complicated machining tasks and challenges
- Offers a wide range of functions and recommendations to operate machining centers
- Features online service 24/7 in more than 30 languages
- Functions according to ISO 13399 standard

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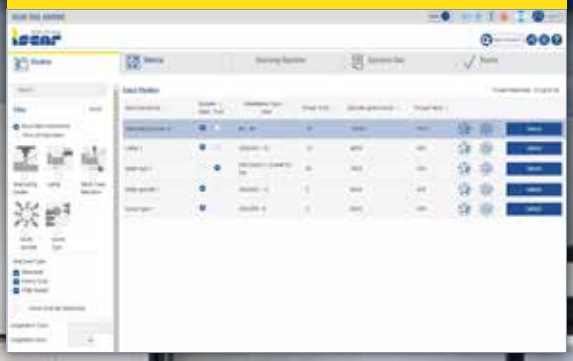
Available now on ISCAR.COM

NEO ITA System Workflow

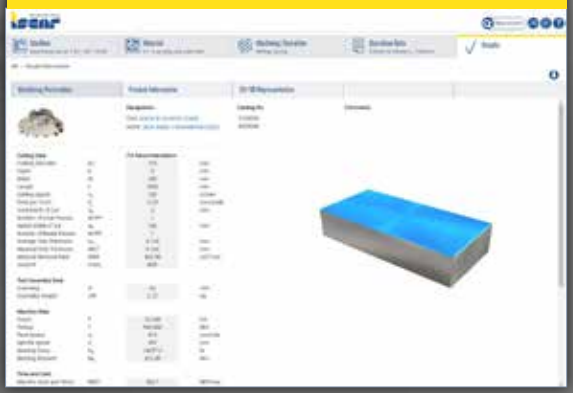
Select a Machine



Define and customize machine specifications

Search material by groups or by random choice

Choose a Tool Recommendation



and the ISCAR World App

TURNING PRODUCTS

HOLE MAKING PRODUCTS

MILLING PRODUCTS

ADAPTATION PRODUCTS

CUTTING MATERIALS

NEOLOGIQTURN

MACHINING INTELLIGENTLY

TANG-GRIP
Y AXIS PARTING LINE

ISOY AXIS TURN

LOGIQFGRIP
HIGH FEED GRIP HOLDER

PICCOINDEX
INDEXABLE INSERTS

SWISSGRIP
NARROW WIDTHS

Member IMC Group

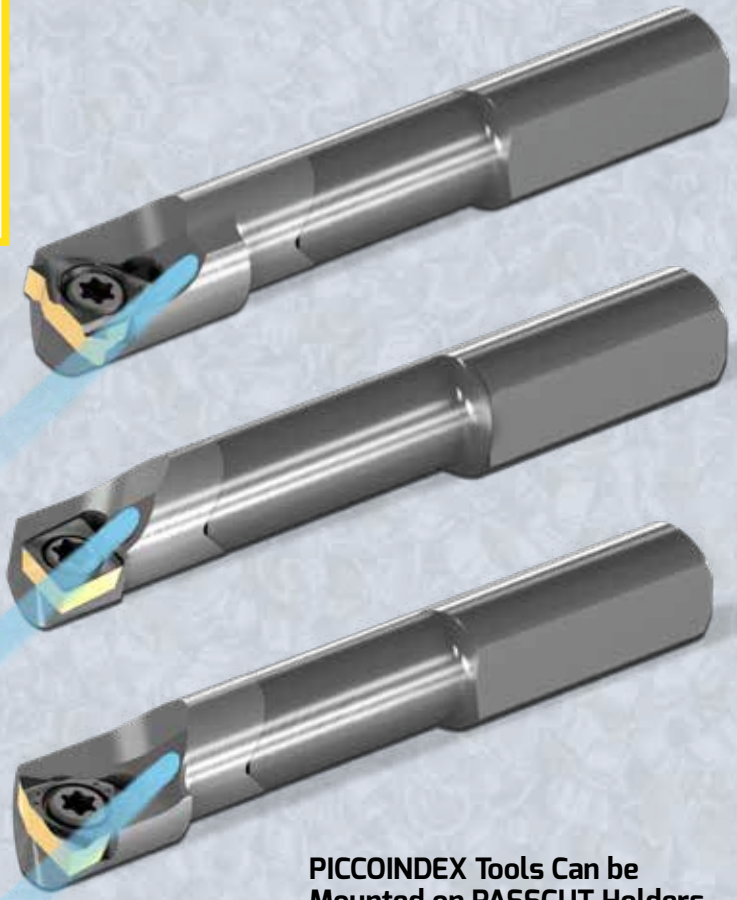
ISCAR

New Solid Carbide Tools

PICCOINDEX
INDEXABLE INSERTS

New PICCOINDEX Solid Carbide Tools with Indexable Inserts for **Machining Miniature Parts** and Increased Tool Life

200% Increased Tool Life



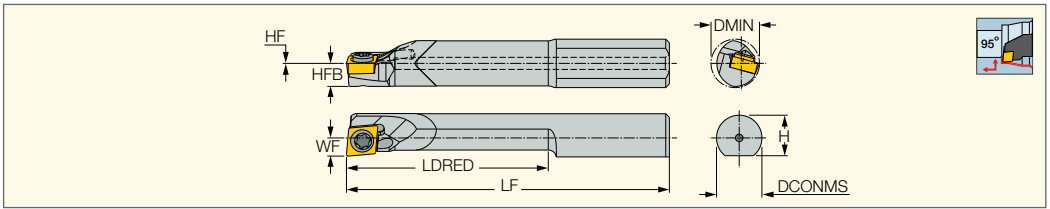
PICCOINDEX Tools Can be Mounted on PASSCUT Holders and the NEOPASS Holder

VIDEO

PICCOINDEX
INDEXABLE INSERTS

PICIN-SCLCR/L

Solid Carbide PICCO Tools
Carrying 80° Rhombic Inserts



Designation	DCONMS	LF	LDRED	H	HFB	WF	DMIN	HF	CSP(1)	MIID(2)
PICIN E05-T20-SCLCR/L-03	.197	1.378	.79	.177	.083	.073	.177	.000	1	CCGT 03X101-F1P
PICIN E06-T25-SCLCR/L-03	.236	1.575	.98	.213	.114	.089	.236	.000	1	CCGT 03X101-F1P

(1) 0 - Without coolant supply, 1 - With coolant supply
(2) Master insert identification

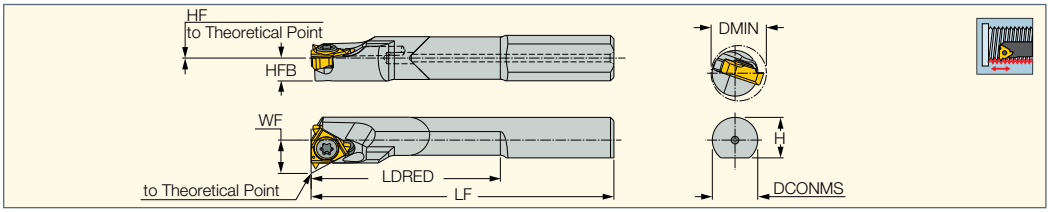
Spare Parts

Designation		
PICIN-SCLCR/L	CSTA-1.6	T-6/5

PICCOINDEX
INDEXABLE INSERTS

PICIN-MGSIR/L

Solid Carbide PICCO Tools
Carrying Internal Laydown
Threading Inserts



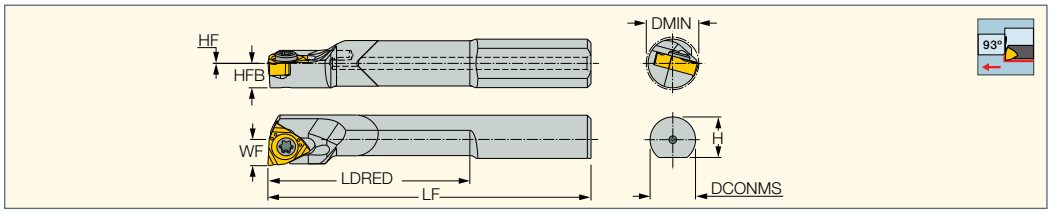
Designation	DCONMS	LF	LDRED	H	HFB	WF	DMIN	HF	CSP(1)	MIID(2)		
PICIN E06-T25-MGSIL-06	.236	1.575	.98	.213	.118	.174	.287	.000	1	06IL A 55	SR 14-552	T-6/5
PICIN E06-T25-MGSIR-06	.236	1.575	.98	.213	.118	.174	.287	.000	1	06IR A 55	SR 14-552	T-6/5

(1) 0 - Without coolant supply, 1 - With coolant supply
(2) Master insert identification

PICCOINDEX
INDEXABLE INSERTS

PICIN-SWUBR/L

Solid Carbide PICCO Tools
Carrying Small WBMT/WBGT
Trigon Inserts



Designation	DCONMS	LF	LDRED	H	HFB	WF	DMIN	HF	CSP(1)	MIID(2)		
PICIN E06-T25-SWUBL-06	.236	1.575	.98	.213	.118	.128	.256	.000	1	WBMT 060101R	SR 14-552	T-6/5
PICIN E06-T25-SWUBR-06	.236	1.575	.98	.213	.118	.128	.256	.000	1	WBMT 060101L	SR 14-552	T-6/5

(1) 0 - Without coolant supply, 1 - With coolant supply
(2) Master insert identification

Smart Holder for Small Part Boring

NEOPASS
PICCO LINES HOLDER

Smart Holder Can Mount All Types of Picco Heads. Features **Unique Coolant Outlets** for Increased Tool Life.

200% Increased Tool Life

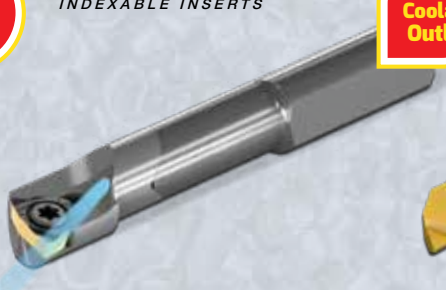
A Wide Variety of Tools and Inserts Options for Machining Miniature Parts

PICCOJET
COOLANT THROUGH

Internal Coolant Outlet

PICCOINDEX
INDEXABLE INSERTS

Internal Coolant Outlet



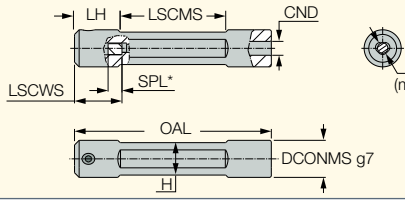
PICCOCUT
MINI BORING

VIDEO

NEOPASS
PICCO LINES HOLDER

PICMU

Holders with Improved Cooling Supply Suitable for Mounting PICCO-CUT, PICCO-JET Inserts and PICCO-INDEX Heads

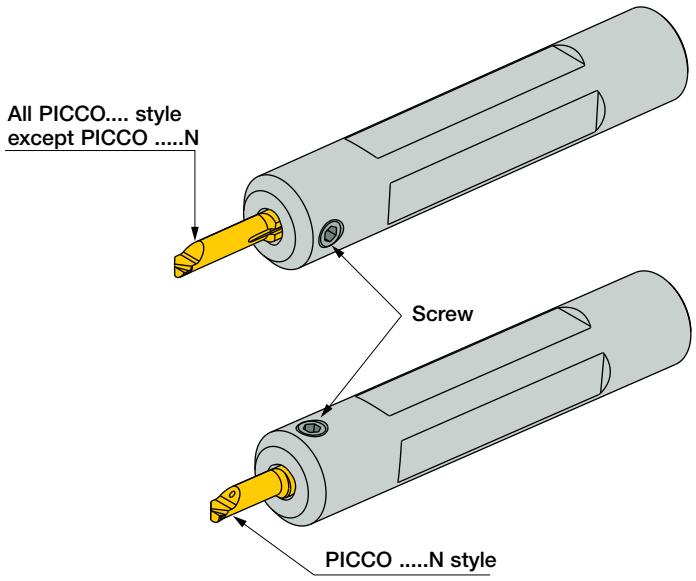


* To be used only when mounting PICCO-CUT insert types

Designation	DCONMS	DCONNWS(1)	DCONXWS(2)	OAL	LH	LSCMS	H	LSCWS	CND	SPL(3)
PICMU 12.7-4	.500	.158	.160	3.346	.776	1.795	.433	.7480	.197	.2363
PICMU 12.7-5	.500	.197	.199	3.346	.776	1.795	.433	.8070	.236	.2363
PICMU 15.9-4	.625	.158	.160	3.346	.776	1.795	.551	.7480	.197	.2363
PICMU 15.9-5	.625	.197	.199	3.346	.776	1.795	.551	.8070	.236	.2363
PICMU 15.9-6	.625	.236	.238	3.346	.776	1.795	.551	.8070	.236	.2363
PICMU 15.9-7	.625	.276	.278	3.346	.776	1.795	.551	.8190	.315	.2756
PICMU 19-4	.750	.158	.160	3.346	.776	1.795	.709	.7480	.197	.2363
PICMU 19-5	.750	.197	.199	3.346	.776	1.795	.709	.8070	.236	.2363
PICMU 19-6	.750	.236	.238	3.346	.776	1.795	.709	.8070	.236	.2363
PICMU 19-7	.750	.276	.278	3.346	.776	1.795	.709	.8190	.315	.2756
PICMU 25.4-4	1.000	.158	.160	3.346	.776	1.795	.787	.7480	.197	.2363
PICMU 25.4-5	1.000	.197	.199	3.346	.776	1.795	.787	.8070	.236	.2363
PICMU 25.4-6	1.000	.236	.238	3.346	.776	1.795	.787	.8070	.236	.2363
PICMU 25.4-7	1.000	.276	.278	3.346	.776	1.795	.787	.8190	.315	.2756

- Holders are suitable for left- and right-hand inserts, and boring bars

(1) Minimum diameter
(2) Maximum diameter
(3) Spacer length



Spare Parts

Designation				
PICMU 12.7-4	SPACER D3.7X6		HW 2.5	PL 16 M6-D5
PICMU 12.7-5	SPACER D4.7X6		HW 2.5	PL 16 M6-D5
PICMU 15.9-4	SPACER D3.7X6		HW 2.5	PL 16 M6-D5
PICMU 15.9-5	SPACER D4.7X6		HW 2.5	PL 16 M6-D5
PICMU 15.9-6	SPACER D5.7X6	SR M6X0.5X6 PF	HW 3.0	PL 16 M6-D5
PICMU 15.9-7	SPACER D6.7X7	SR M6X0.5X6 PF	HW 3.0	PL 16 M6-D5
PICMU 19-4	SPACER D3.7X6		HW 2.5	PL 16 M6-D5
PICMU 19-5	SPACER D4.7X6		HW 2.5	PL 16 M6-D5
PICMU 19-6	SPACER D5.7X6	SR M6X0.5X6 PF	HW 3.0	PL 16 M6-D5
PICMU 19-7	SPACER D6.7X7	SR M6X0.5X6 PF	HW 3.0	PL 16 M6-D5
PICMU 25.4-4	SPACER D3.7X6		HW 2.5	PL 16 M6-D5
PICMU 25.4-5	SPACER D4.7X6		HW 2.5	PL 16 M6-D5
PICMU 25.4-6	SPACER D5.7X6	SR M6X0.5X6 PF	HW 3.0	PL 16 M6-D5*
PICMU 25.4-7	SPACER D6.7X7	SR M6X0.5X6 PF	HW 3.0	PL 16 M6-D5

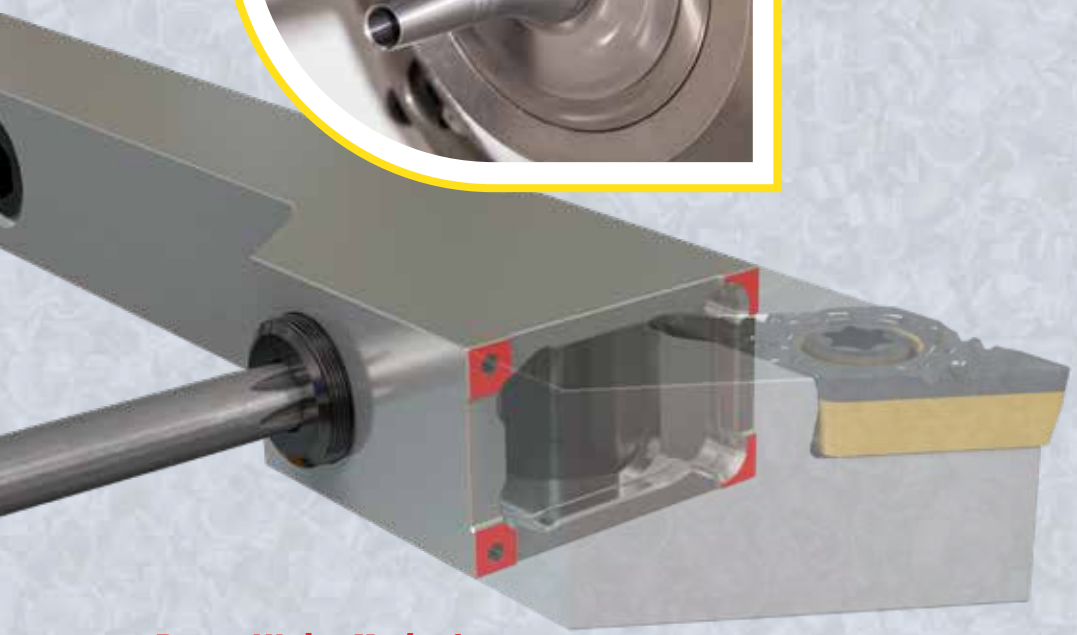
Modular Swiss-Type Turning Holder

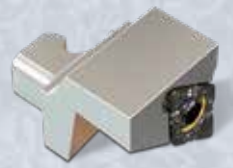
NEOSWISS
INDEXABLE HEADS

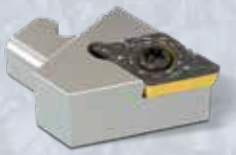
New System for Swiss-Type Turning Machines with **Quick-Change Heads.** Features Minimum Setup Time.

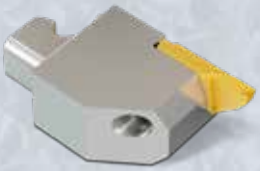
Fast Setup Minimizes Machine Downtime

A Variety of Right and Left Heads Can Be Mounted on the Same Shank









Rotary Wedge Mechanism
Designed to Amplify the Clamping Force for a Rigid Connection

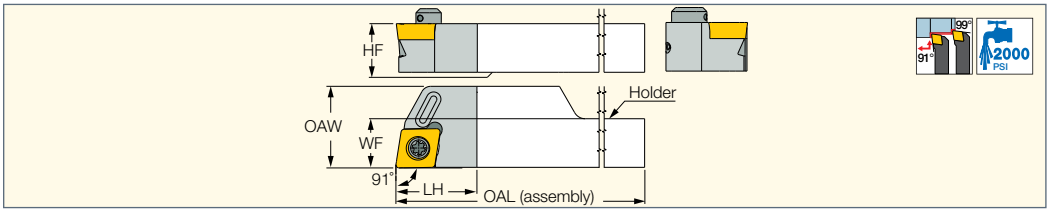
VIDEO

NEOSWISS INDEXABLE HEADS

ISOTURN

NQCH-SCACR/L-JHP

Screw Lock Modular Heads with High-Pressure Coolant - 7° Clearance 80° Rhombic Inserts for SwissType Machines



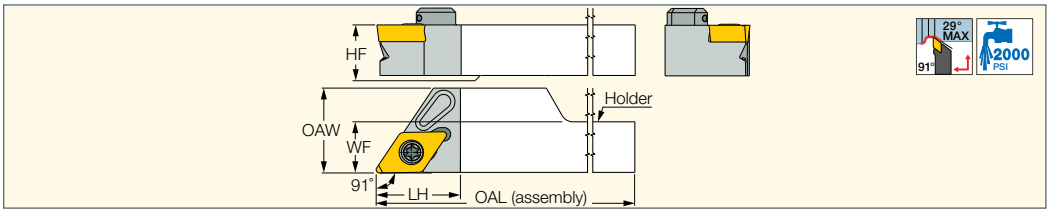
Designation	WF	HF	LH	OAL	OAW	Insert		
NQCH12-SCACR/L-09S-JHP	.478	.472	.787	4.724	.793	CC#09T3#(3-#)	SR 16-236	T-15/5
NQCH16-SCACR/L-09S-JHP	.636	.630	.787	4.724	.793	CC#09T3#(3-#)	SR 16-236	T-15/5

NEOSWISS INDEXABLE HEADS

ISOTURN

NQCH-SDACR/L-S-JHP

Screw Lock Modular Heads with High-Pressure Coolant - 7° Clearance 55° Rhombic Inserts for SwissType Machines



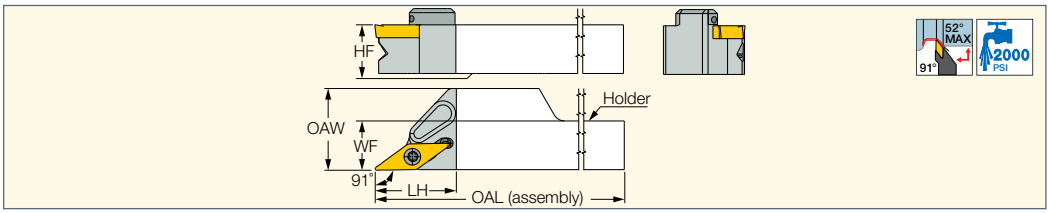
Designation	WF	HF	LH	OAL	OAW	Insert		
NQCH12-SDACR/L-11S-JHP	.478	.472	.787	4.724	.793	DC#11T3(3-#)	SR 16-236 P	T-15/5
NQCH16-SDACR/L-11S-JHP	.636	.630	.787	4.724	.793	DC#11T3(3-#)	SR 16-236 P	T-15/5

NEOSWISS INDEXABLE HEADS

ISOTURN

NQCH-SVACR/L-S-JHP

Screw Lock Modular Heads with High-Pressure Coolant Carrying 7° Clearance 35° Rhombic Inserts for SwissType Machines

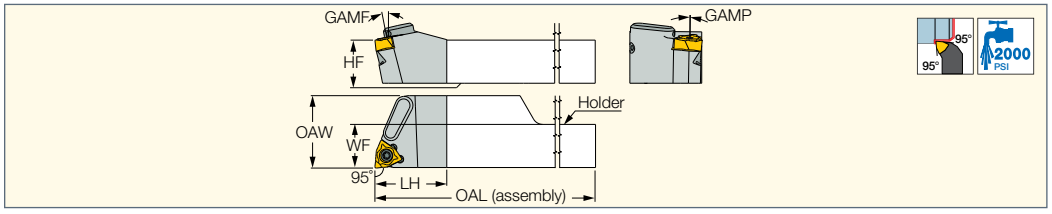


Designation	WF	HF	LH	OAL	OAW	Insert		
NQCH12-SVACR/L-11S-JHP	.478	.472	.787	4.724	.793	VC#1103#(22#)	SR 14-560	T-8/5
NQCH16-SVACR/L-11S-JHP	.636	.630	.787	4.724	.793	VC#1103#(22#)	SR 14-560	T-8/5

NEOSWISS INDEXABLE HEADS
MINIPTURN POSITIVE DOUBLE SIDED

NQCH-SWLNR/L-S-JHP

Screw Lock Modular Heads with High-Pressure Coolant - Positive Double-Sided Trigon Inserts for SwissType Machines



Designation	WF	HF	LH	OAL	OAW	GAMP	GAMF	Insert
NQCH12-SWLNR/L-04S-JHP	.478	.472	.787	4.724	.793	11.0	1.0	WNGP 0403#(22#)
NQCH16-SWLNR/L-04S-JHP	.636	.630	.787	4.724	.793	11.0	1.0	WNGP 0403#(22#)

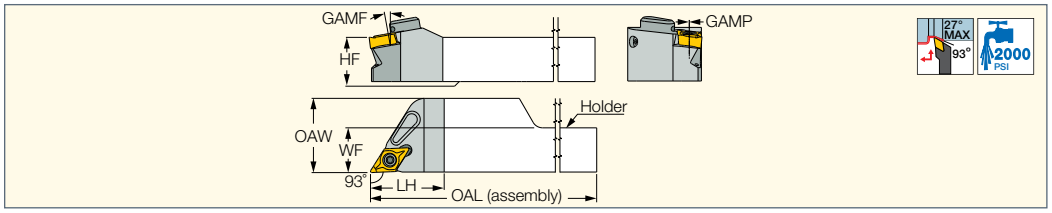
Spare Parts

Designation		
NQCH-SWLNR/L-S-JHP	SR 34-514	T-7/5

NEOSWISS INDEXABLE HEADS
MINIPTURN POSITIVE DOUBLE SIDED

NQCH-SDJNR/L-S-JHP

Screw Lock Modular Heads with High-Pressure Coolant, Positive Double-Sided 55° Rhombic Inserts for Swiss-Type Machines

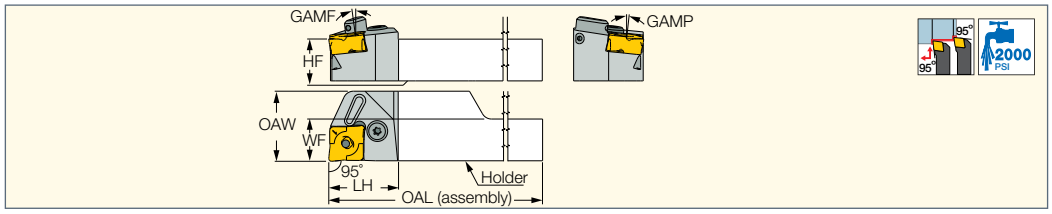


Designation	WF	HF	LH	OAL	OAW	GAMP	GAMF	Insert		
NQCH12-SDJNR/L-07S-JHP	.478	.472	.787	4.724	.793	10.0	.0	DNGP 0703#(22#)	SR 34-514	T-7/5
NQCH16-SDJNR/L-07S-JHP	.636	.630	.787	4.724	.793	10.0	.0	DNGP 0703#(22#)	SR 34-514	T-7/5

NEOSWISS INDEXABLE HEADS
LOGIQ4TURN POSITIVE DOUBLE SIDED

NQCH-PCLXR/L-S-JHP

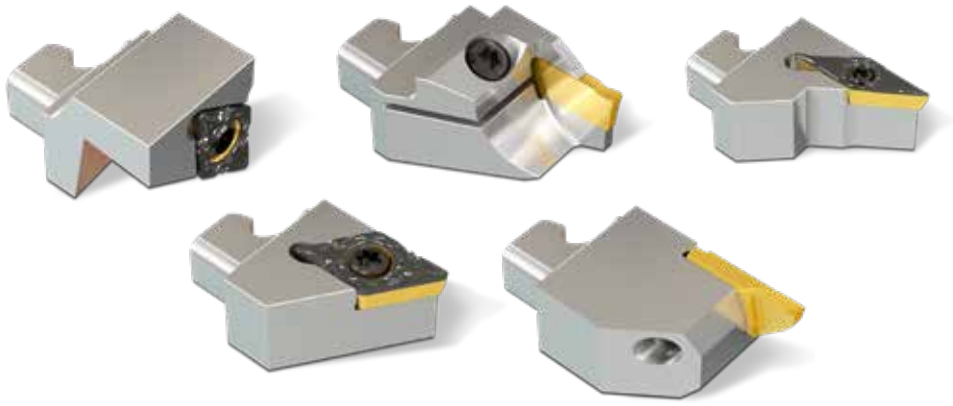
Lever Lock Modular Heads with High-Pressure Coolant, Positive Double-Sided 80° Rhombic Inserts for SwissType Machines



Designation	WF	HF	LH	OAL	OAW	GAMP	GAMF	Insert
NQCH12-PCLXR/L-09X-JHP	.478	.472	.787	4.724	.793	6.0	6.0	CXMG 0904#
NQCH16-PCLXR/L-09X-JHP	.636	.630	.787	4.724	.793	6.0	6.0	CXMG 0904#

Spare Parts

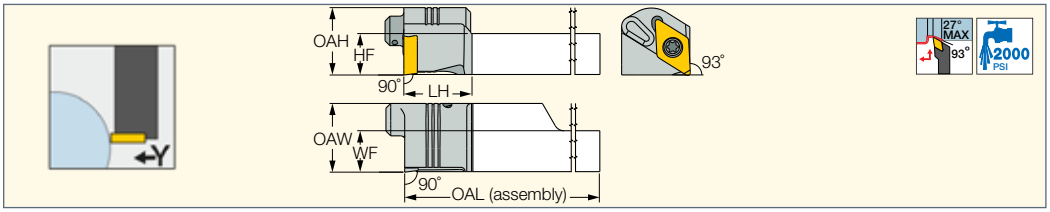
Designation			
NQCH-PCLXR/L-S-JHP	LR 3X SET	SR M6XL11.5V	T-8/5



NEOSWISS INDEXABLE HEADS
ISOTURN

NQCH-Y-SDJCR-S-JHP

Y-Axis Screw Lock Modular Heads with High-Pressure Coolant - 7° Clearance 55° Rhombic Inserts for SwissType Machines

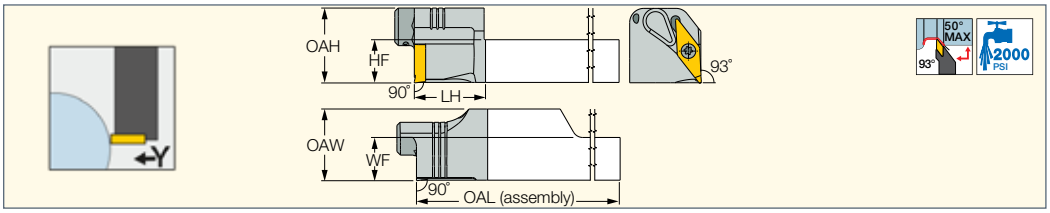


Designation	WF	HF	LH	OAL	OAW	Insert		
NQCH12-Y-SDJCR-11S-JHP	.478	.480	.787	4.724	.787	DC#11T3(3-#)	SR 16-236 P	T-15/5
NQCH16-Y-SDJCR-11S-JHP	.636	.638	.787	4.724	.787	DC#11T3(3-#)	SR 16-236 P	T-15/5

NEOSWISS INDEXABLE HEADS
ISOTURN

NQCH-Y-SVJCR-S-JHP

Y-Axis Screw Lock Modular Heads with High-Pressure Coolant - 7° Clearance 35° Rhombic Inserts for SwissType Machines

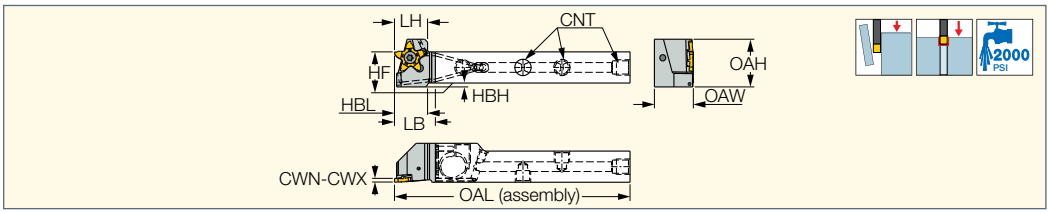


Designation	WF	HF	LH	OAL	OAW	Insert		
NQCH12-Y-SVJCR-11S-JHP	.478	.480	.787	4.724	.793	VC#1103#(22#)	SR 14-560	T-8/5
NQCH16-Y-SVJCR-11S-JHP	.636	.638	.787	4.724	.793	VC#1103#(22#)	SR 14-560	T-8/5

NEOSWISS INDEXABLE HEADS
PENTACUT PARTING & GROOVING LINE

NQCH-PCHR/L-S-JHP

Screw Lock JETCUT Modular Heads for Swiss Type Machines - Grooving, Parting, Recessing 5 Cutting Edged Inserts



Designation	HF	OAW	LB	OAH	HBH	LH	OAL	HBL	CWN(1)	CWX(2)	Insert
NQCH12-PCHR/LS-17-JHP	.472	.787	.827	.961	.236	.669	4.764	.669	.010	.125	PENTA 17
NQCH16-PCHR/LS-17-JHP	.630	.787	.827	.965	.079	.669	4.764	.669	.010	.125	PENTA 17

(1) Minimum cutting width
(2) Maximum cutting width

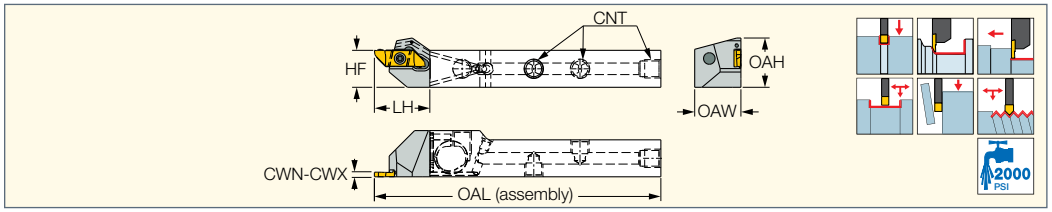
Spare Parts

Designation		
NQCH12-PCHLS-17-JHP	SR M4-39432	T-1508/5
NQCH12-PCHRS-17-JHP	SR M4-39432L	T-1508/5
NQCH16-PCHLS-17-JHP	SR M4-39432	T-1508/5
NQCH16-PCHRS-17-JHP	SR M4-39432L	T-1508/5

NEOSWISS INDEXABLE HEADS
SWISSCUT

NQCH-SCHR/L-BF-JHP

Screw Lock JETCUT Modular Heads for Swiss Type Machines - Grooving and Turning, Back or Front Clamped Inserts



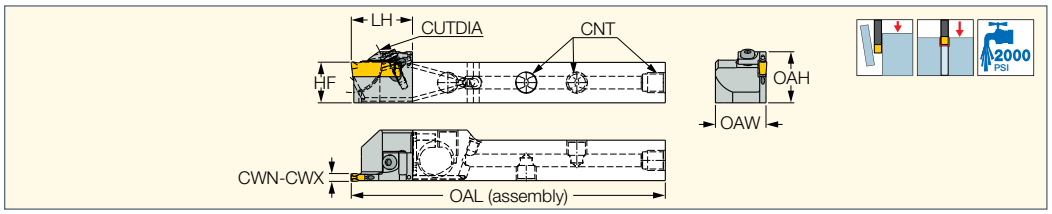
Designation	HF	OAW	LH	OAH	OAL	CWN(1)	CWX(2)	Insert		
NQCH12-SCHR/L-22BF-JHP	.472	.787	.945	.681	4.882	.020	.098	SCIR/L-22	SR M4X0.7-19425	T-8/5
NQCH16-SCHR/L-22BF-JHP	.630	.787	.945	.831	4.882	.020	.098	SCIR/L-22	SR M4X0.7-19425	T-8/5

(1) Minimum cutting width
(2) Maximum cutting width

NEOSWISS INDEXABLE HEADS DO-GRIP TWISTED 2-SIDED

NQCH-DGTR/L-D-SH-JHP

Screw Lock JETCUT Modular Heads for Swiss Type Machines - Double-Sided Parting Inserts



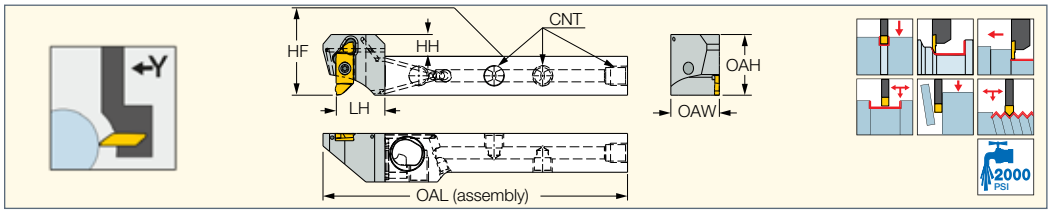
Designation	CWN(1)	CWX(2)	HF	OAW	OAH	LH	OAL	CUTDIA	Insert		
NQCH12-DGTL-2D24SH-JHP	.075	.098	.476	.787	.638	.945	4.882	.945	DGN	SR M3X10DIN912	HW 2.5
NQCH12-DGTR-2D24SH-JHP	.075	.098	.476	.787	.638	.953	4.890	.945	DGN	SR M3X10DIN912	HW 2.5
NQCH16-DGTL-2D24SH-JHP	.075	.098	.634	.787	.795	.945	4.882	.945	DGN	SR M3X10DIN912	HW 2.5
NQCH16-DGTR-2D24SH-JHP	.075	.098	.634	.787	.795	.953	4.890	.945	DGN	SR M3X10DIN912	HW 2.5
NQCH12-DGTL-3D24SH-JHP	.118	.125	.476	.787	.638	.945	4.882	.945	DGN	SR M3X10DIN912	HW 2.5
NQCH12-DGTR-3D24SH-JHP	.118	.125	.476	.787	.638	.953	4.890	.945	DGN	SR M3X10DIN912	HW 2.5
NQCH16-DGTL-3D24SH-JHP	.118	.125	.634	.787	.795	.945	4.882	.945	DGN	SR M3X10DIN912	HW 2.5
NQCH16-DGTR-3D24SH-JHP	.118	.125	.634	.787	.795	.953	4.890	.945	DGN	SR M3X10DIN912	HW 2.5

(1) Minimum cutting width
(2) Maximum cutting width

NEOSWISS INDEXABLE HEADS
SWISSCUT

NQCH-Y-SCHR-BF-JHP

Y-Axis Screw Lock JETCUT Modular Heads for Swiss Type Machines - Grooving and Turning, Back or Front Clamped Inserts



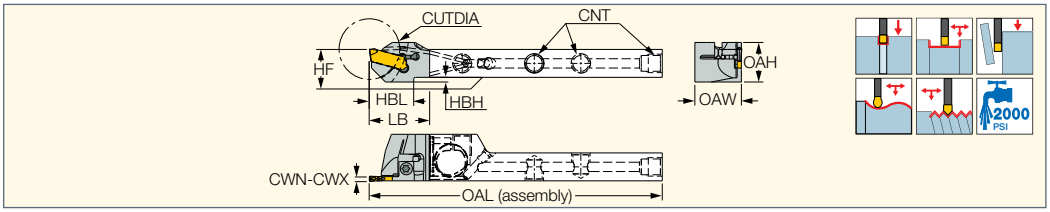
Designation	HF	OAH	LH	OAW	HH	OAL	CWN(1)	CWX(2)	Insert		
NQCH12-Y-SCHR-22BF-JHP	.472	.984	.787	.787	.512	4.941	.020	.098	SCIR/L-22-N/R/L	SR M4X0.7-19425	T-8/5
NQCH16-Y-SCHR-22BF-JHP	.630	.984	.787	.787	.354	4.941	.020	.098	SCIR/L-22-N/R/L	SR M4X0.7-19425	T-8/5

(1) Minimum cutting width
(2) Maximum cutting width

NEOSWISS INDEXABLE HEADS
CUTGRIP

NQCH-GHSR/L-JHP

Screw Lock JETCUT Modular Heads for Swiss Type Machines - Grooving and Turning Inserts



Designation	HF	OAW	LB	OAH	HBH	OAL	HBL	CWN(1)	CWX(2)	CUTDIA	Insert
NQCH12-GHSR/L-2-JHP	.472	.787	1.024	.669	.079	4.961	.079	.087	.118	.984	GIP
NQCH16-GHSR/L-2-JHP	.630	.787	1.024	.748	-	4.961	-	.087	.118	.984	GIP

(1) Minimum cutting width
(2) Maximum cutting width

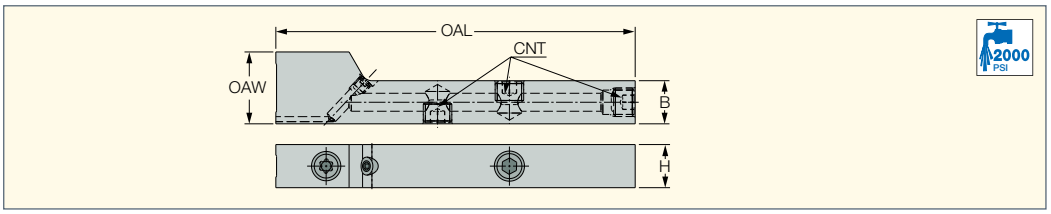
Spare Parts

Designation		
NQCH-GHSR/L-JHP	SR 16-236 P	T-15/3

NEOSWISS INDEXABLE HEADS JETCUT

NQCH-JHP

Square Shank with High-Pressure Coolant for NEOSWISS Modular Heads - Swiss Type Machine



Designation	B	H	OAL	OAW	CNT	
NQCH-1212-JHP	.472	.472	3.937	.787	UNF 5/16-24	SR 5/16UNF TL360
NQCHL-12.7-JHP	.500	.500	3.937	.787	UNF 5/16-24	SR 5/16UNF TL360
NQCHR-12.7-JHP	.500	.500	3.937	.787	UNF 5/16-24	SR 5/16UNF TL360
NQCH-1616-JHP	.630	.630	3.937	.787	UNF 5/16-24	SR 5/16UNF TL360

Clamping Operation Steps

Attention: The clamping screw is not removable. To avoid undesired damage, do not apply excessive force when opening or clamping.

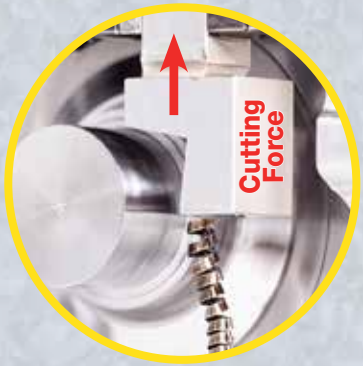
Supplied Accessories	**Item No: 7003805** SW6-T-SH	
	Item No: 7002553 BLD IP20/S7	
Recommended (Optional) Accessories	**Item No: 7007221** TSA 6 44.1-123.5 lbf*in (TSA 6 5-14Nm)	
	Item No: 7007027 BLD 6 T20IP	

Y-Axis Swiss Type Machining

NEO Y AXIS SWISS

New **Y-Axis Turning and Grooving Holders** for Machining Miniature Parts on Swiss Type Machines. Suitable for Difficult-To-Cut Materials.

Bottom and Top High Pressure Coolant



Excellent Chip Evacuation and Stable Machining

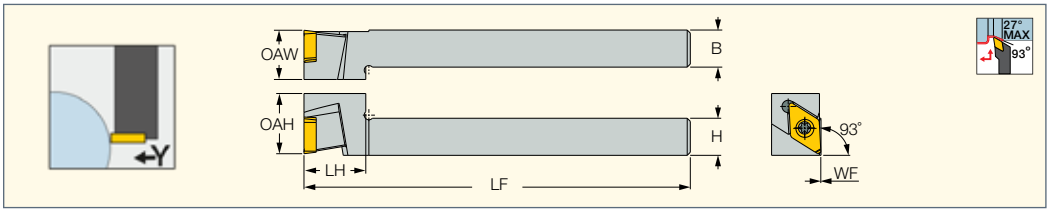
VIDEO

PENTACUT SWISSCUT ISOTURN

NEOYSWISS 4 AXIS

Y-SDJCR

Y-Axis Screw Lock Swiss Type Tools that Mount 55° Rhombic Inserts with a 7° Clearance Angle

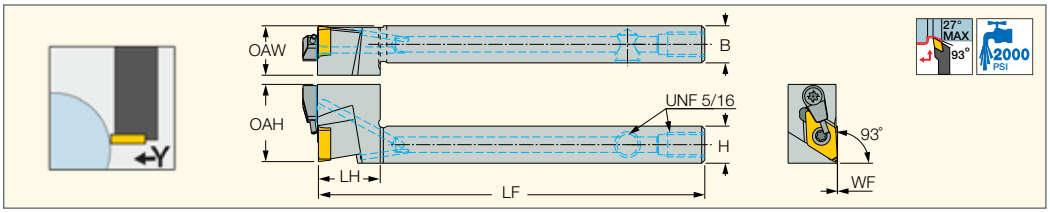


Designation	H	B	LF	LH	OAH	OAW	WF	Insert		
Y-SDJCR 08-3S	.500	.500	5.000	.827	.787	.630	.000	DC.. 3	SR 35080I	T-15/5

NEOYSWISS 4 AXIS

Y-SDJCR-JHP

Y-Axis Screw Lock Swiss Tools with a JETCUT Coolant System that Mount 55° Rhombic Inserts with a 7° Clearance Angle

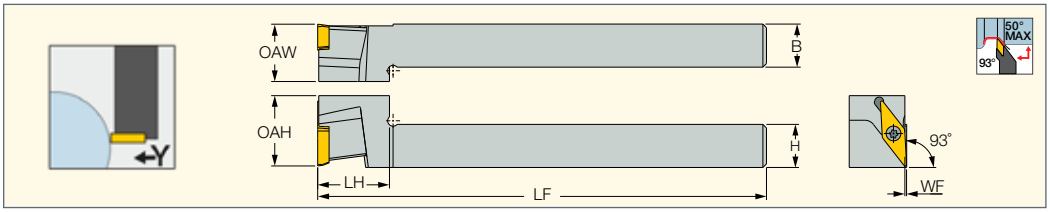


Designation	H	B	LF	LH	OAH	OAW	WF	Insert				
Y-SDJCR 08-3S-JHP	.500	.500	5.000	.827	1.004	.630	.000	DC.. 3	SR 35080I	T-15/5	HW 5/32"	SR 5/16UNF TL360

NEOYSWISS 4 AXIS

Y-SVJCR

Y-Axis Screw Lock Swiss Type Tools that Mount 35° Rhombic Inserts with a 7° Clearance Angle

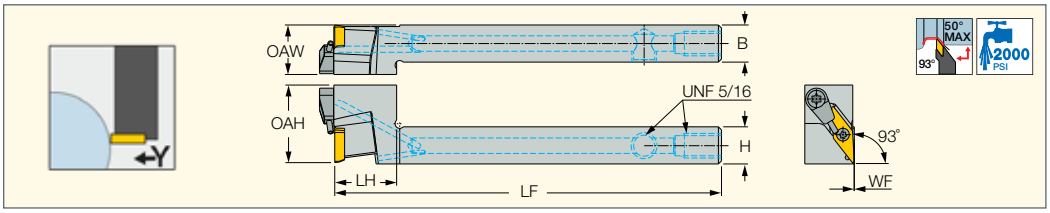


Designation	H	B	LF	LH	OAH	OAW	WF	Insert	
Y-SVJCR 08-2S	.500	.500	5.000	.827	.787	.630	.000	VC.. 2	T-7/5

NEOYSWISS 4 AXIS

Y-SVJCR-JHP

Y-Axis Screw Lock Swiss Tools with a JETCUT Coolant System that Mount 35° Rhombic Inserts with a 7° Clearance Angle

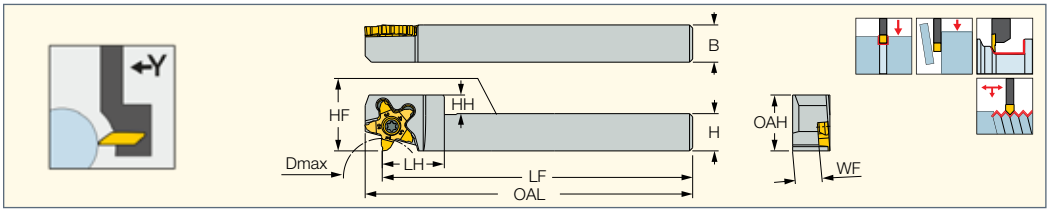


Designation	H	B	LF	LH	OAH	OAW	WF	Insert			
Y-SVJCR 08-2S-JHP	.500	.500	5.000	.827	1.004	.630	.000	VC.. 2	T-7/5	HW 5/32"	SR 5/16UNF TL360

NEOSWISS AXIS

Y-PCHRS-17

Y-Axis Swiss-Type Tools - 5 Cutting Edged Inserts for Grooving, Parting and Recessing Next to High Shoulders



Designation	H	B	HH	LH	HF	WF	OAH	LF	OAL	D max
Y-PCHRS 12.7-17	.500	.500	.209	.787	.500	.366	.709	3.937	4.154	.984

- Use right-hand inserts on right-hand tools and vice versa

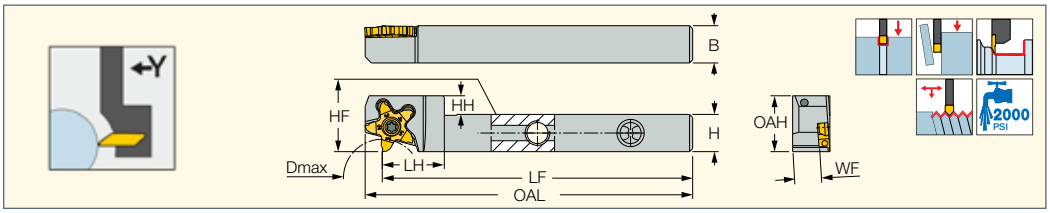
Spare Parts

Designation		
Y-PCHRS-17	SR M4-39432L	T-1508/5

NEOSWISS AXIS

Y-PCHRS-17-JHP

Y-Axis Swiss Type JETCUT Tools - 5 Cutting Edged Inserts for Grooving, Parting and Recessing Next to Shoulders



Designation	H	B	HH	LH	HF	WF	OAH	LF	OAL	D max
Y-PCHRS 12.7-17-JHP	.500	.500	.209	.787	.500	.366	.709	3.937	4.154	.984 (1)

- Use right-hand inserts on right-hand tools and vice versa

(1) for grooving

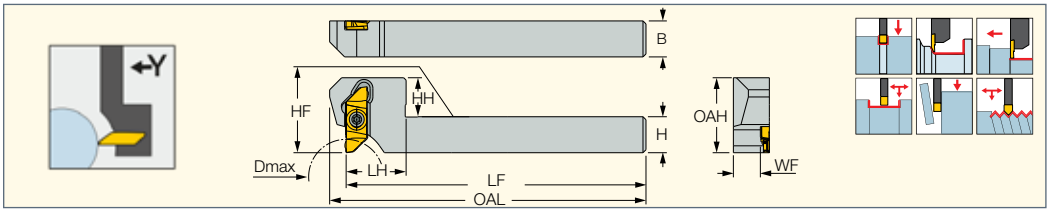
Spare Parts

Designation				
Y-PCHRS 12.7-17-JHP	SR M4-39432L	T-1508/5	HW 5/32"	SR 5/16UNF TL360

NEOYSWISS AXIS

Y-SCHR-22BF

Y-Axis Tools for Swiss-Type Machines - Back or Front Clamped Inserts for Grooving and Turning Operations



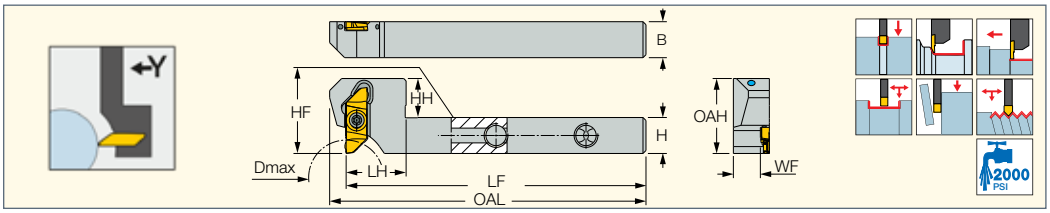
Designation	H	B	HH	LH	HF	WF	OAH	LF	OAL	D max		
Y-SCHR 12.7-22BF	.500	.500	.484	.787	.500	.382	.984	3.937	4.154	.984 (1)	SR M4X0.7-19425	T-8/5

(1) for grooving

NEOYSWISS AXIS

Y-SCHR-22BF-JHP

Y-Axis JETCUT Tools for Swiss-Type Machines - Back or Front Clamped Inserts for Grooving and Turning Operations



Designation	H	B	HH	LH	HF	WF	OAH	LF	OAL	D max
Y-SCHR 12.7-22BF-JHP	.500	.500	.484	.787	.500	.382	.984	3.937	4.154	.984 (1)

(1) for grooving

Spare Parts

Designation				
Y-SCHR 12.7-22BF-JHP	HW 5/32"	SR M4X0.7-19425	T-8/5	SR 5/16UNF TL360

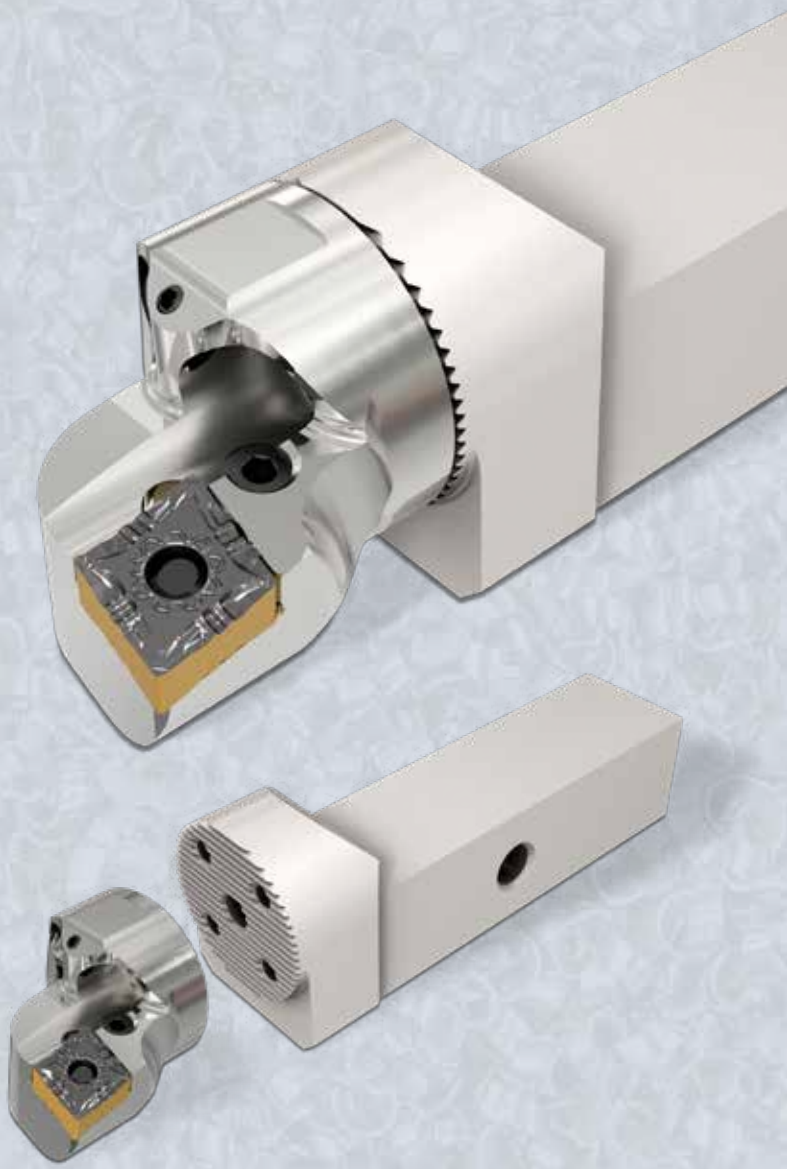
Interchangeable Turning Heads

NEOMODU
INDEXABLE TURNING HEADS

A New Line for External Turning with **Interchangeable Heads** For General Turning Applications.

External Square Shanks
.75, 1.00, 1.25 & 1.50"

Steel Eco Shank and Dedicated
External Interchangeable Heads

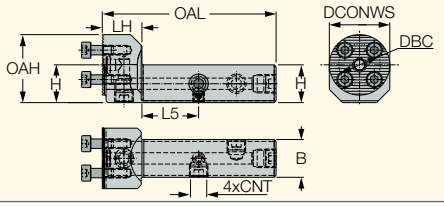


VIDEO

NEOMODU
INDEXABLE TURNING HEADS

SH-S#-N-AVC

Square Shank Holders with Serrated Connection

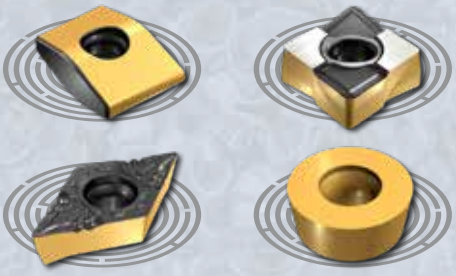


Designation	DCONWS	LH	OAH	OAL	H	B	DBC	L5	CNT
SH-S12-N-AVC-D20-JHP-MC	.7870	.827	1.146	3.622	.750	.750	.512	1.181	G 1/8
SH-S12-N-AVC-D25-JHP-MC	.9840	.827	1.244	3.622	.750	.750	.630	1.181	G 1/8
SH-S12-N-AVC-D32-JHP-MC	1.2600	.827	1.382	3.622	.750	.750	.866	1.181	G 1/8
SH-S16-N-AVC-D25-JHP-MC	.9840	.827	1.492	4.213	1.000	1.000	.630	1.417	G 1/8
SH-S16-N-AVC-D32-JHP-MC	1.2600	.827	1.630	4.213	1.000	1.000	.866	1.417	G 1/8
SH-S16-N-AVC-D40-JHP-MC	1.5750	.827	1.787	4.213	1.000	1.000	1.102	1.417	G 1/8
SH-S20-N-AVC-D32-JHP-MC	1.2600	.827	1.882	5.984	1.250	1.250	.866	-	G 1/8
SH-S20-N-AVC-D40-JHP-MC	1.5750	1.024	2.039	5.984	1.250	1.250	1.102	-	G 1/8
SH-S24-N-AVC-D40-JHP-MC	1.5750	1.024	2.287	7.874	1.500	1.500	1.102	-	G 1/8

Y-Axis For Multi-Tasking Machines

Y AXIS
ISOYTURN

New **Y Axis Tool Holder** for Multi-Tasking Machines, Replaces Several Kinds of Turning Tools.



120°

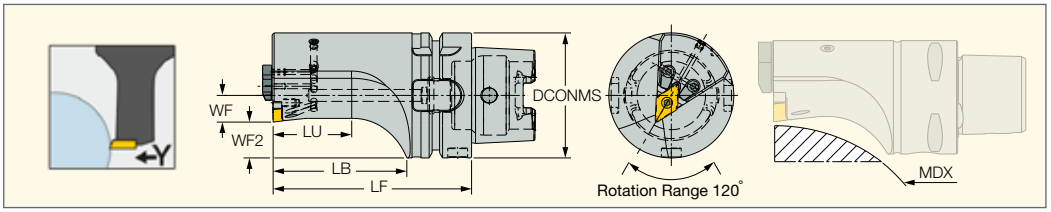
Lead Angle Can be Changed Which Enables **Insert Versatility Options**

VIDEO

HSK ISOTURN Y AXIS

HSK A63WH-SDJCN-13-Y

Y-Axis Turning Tools Carrying
55° Diamond Inserts with
7° Clearance Angle



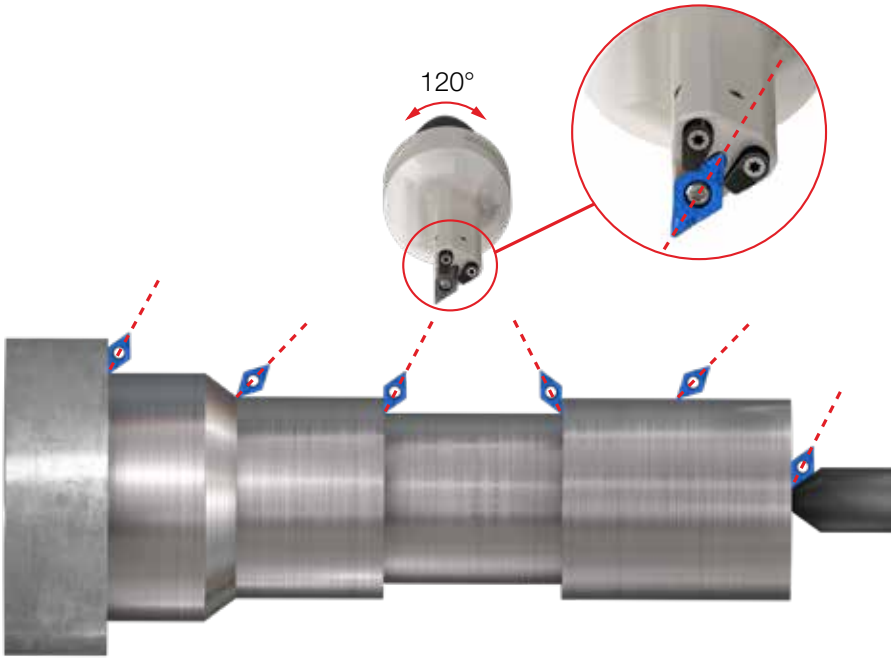
Designation	DCONMS	LU	LB	LF	WF	WF2	MDX(1)	MIID(2)	CDI(3)
HSK A63WH-SDJCN-13SL-100Y	2.480	1.5591	2.654	3.937	.529	.71	8.465	DCMT 13T504-F3P-SL	0
HSK A63WH-SDJCN-13SL-125Y	2.480	2.5433	3.638	4.921	.529	.71	15.354	DCMT 13T504-F3P-SL	0

- A cooling tube must be used with all coolant through HSK spindles (should be ordered separately).

(1) Machinable diameter maximum

(2) Master insert identification

(3) 1 - Hole for data chip, 0 - Without hole for data chip



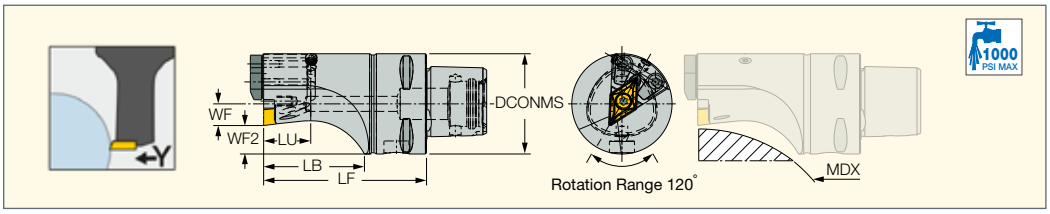
Spare Parts

Designation					
HSK A63WH-SDJCN-13-Y	CH-1.9D-JHP-A SET	BLD IP15/S7	SW6-T-SH	SR M4X4 DIN913 TL360	SR M4X0.7-L9.6 IP15

CAMFIX ISOTURN Y AXIS

C#-SDJCN-13-Y

Y-Axis Turning Tools Carrying
55° Diamond Inserts with
7° Clearance Angle



Designation	DCONMS	LU	LB	LF	WF	WF2	MDX(1)	MIID(2)	CDI(3)
C4-SDJCN-13-SL-H65-Y	1.575	.7401	1.583	2.559	.340	.45	4.724	DCMT 13T504-F3P-SL	0
C4-SDJCN-13-SL-H80-Y	1.575	1.1929	2.142	3.150	.340	.45	8.268	DCMT 13T504-F3P-SL	0
C5-SDJCN-13-SL-H80-Y	1.968	1.1102	2.114	3.150	.424	.56	7.087	DCMT 13T504-F3P-SL	0
C5-SDJCN-13-SL-H100-Y	1.968	1.8976	2.902	3.937	.424	.56	12.598	DCMT 13T504-F3P-SL	0
C6-SDJCN-13-SL-H100-Y	2.480	1.8425	2.906	3.937	.529	.71	10.236	DCMT 13T504-F3P-SL	0
C6-SDJCN-13-SL-H125-Y	2.480	2.8071	3.870	4.921	.529	.71	16.535	DCMT 13T504-F3P-SL	0

(1) Machinable diameter maximum

(2) Master insert identification

(3) 1 - Hole for data chip, 0 - Without hole for data chip

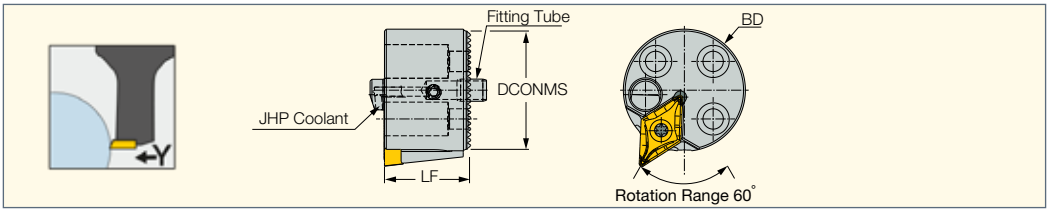
Spare Parts

Designation					
C#-SDJCN-13-Y	CH-1.9D-JHP-A SET	BLD IP15/S7	SW6-T-SH	SR M4X4 DIN913 TL360	SR M4X0.7-L9.6 IP15

ISO Y-AXIS TURN

AVC-SDJCN-Y

Y-Axis Interchangeable Heads
Carrying 55° Rhombic Inserts



Designation	DCONMS	BD	LF	MIID[1]	CSP[2]
AVC-D25-SDJCN-13-SL-Y	.984	1.0236	.787	DCMT 13T504-F3P-SL	1
AVC-D32-SDJCN-13-SL-Y	1.260	1.2992	.906	DCMT 13T504-F3P-SL	1
AVC-D40-SDJCN-13-SL-Y	1.575	1.6142	.984	DCMT 13T504-F3P-SL	1

[1] Master insert identification
[2] 0 - Without coolant supply, 1 - With coolant supply

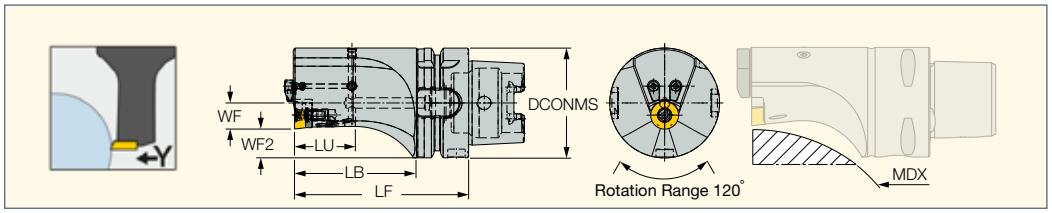
Spare Parts

Designation						
AVC-SDJCN-Y	CH-1.9D-JHP-A SET	SR M5X5 DIN913 TL360	BLD IP15/S7	SW6-T-SH	SR M4X0.7-L9.6 IP15	PIN FT39 D6-5X11

HSK ISO Y-AXIS TURN

HSK A63WH-RCMT-Y

Y-Axis Turning Tools
Carrying Round Inserts
with 7° Clearance Angle



Designation	DCONMS	LU	LB	LF	WF	WF2	MDX[1]	Insert	CDI[2]
HSK A63WH-SRDCN-16-100Y	2.480	1.3740	2.748	3.937	.591	.65	9.449	RCMT 1606MO-14	0
HSK A63WH-SRDCN-16-125Y	2.480	2.3622	3.677	4.921	.591	.65	14.961	RCMT 1606MO-14	0

- A cooling tube must be used with all coolant through HSK spindles (should be ordered separately).

[1] Machinable diameter maximum
[2] 1 - Hole for data chip, 0 - Without hole for data chip

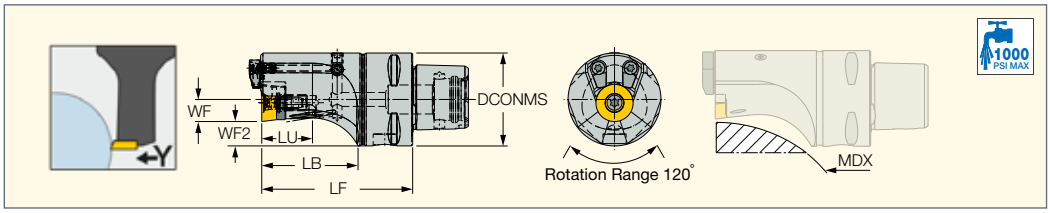
Spare Parts

Designation							
HSK A63WH-RCMT-Y	TRC 5-0	SR TC-4	CH-1.9D-JHP-A SET	SR 16-212	HW 3.0	BLD T20/S7	SW6-T-SH

CAMFIX ISO Y-AXIS TURN

C#-RCMT-16-Y

Y-Axis Turning Tools
Carrying Round Inserts
with 7° Clearance Angle



Designation	DCONMS	LU	LB	LF	WF	WF2	MDX[1]	Insert	CDI[2]
C4-SRDCN-16-H65-Y	1.575	.8622	1.634	2.559	.374	.41	5.118	RCMT 1606M0-14	0
C4-SRDCN-16-H80-Y	1.575	1.4488	2.232	3.150	.374	.41	8.268	RCMT 1606M0-14	0
C5-SRDCN-16-H80-Y	1.968	1.0630	2.213	3.150	.472	.51	7.087	RCMT 1606M0-14	0
C5-SRDCN-16-H100-Y	1.968	1.7480	3.000	3.937	.472	.51	13.780	RCMT 1606M0-14	0
C6-SRDCN-16-H100-Y	2.480	1.5945	2.913	3.937	.591	.65	10.236	RCMT 1606M0-14	0
C6-SRDCN-16-H125-Y	2.480	2.5787	3.894	4.921	.591	.65	17.717	RCMT 1606M0-14	0

[1] Machinable diameter maximum
[2] 1 - Hole for data chip, 0 - Without hole for data chip

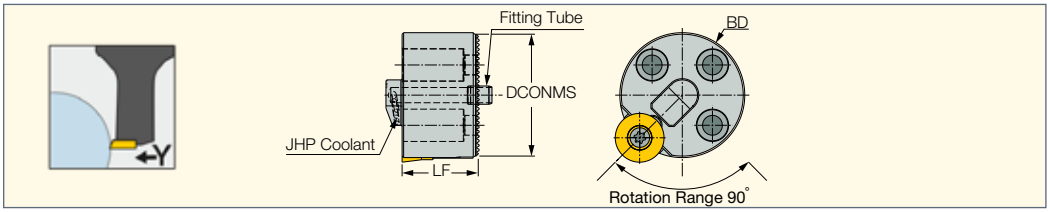
Spare Parts

Designation							
C#-RCMT-16-Y	TRC 5-0	SR TC-4	CH-1.9D-JHP-A SET	SR 16-212	HW 3.0	BLD T20/S7	SW6-T-SH

ISOYTURN AXIS

AVC-SRDCN-Y

Y-Axis Interchangeable Heads
Carrying Round Inserts



Designation	DCONMS	BD	LF	MIID[1]	CSP[2]
AVC-D16-SRDCN-08-Y	.630	.6693	.472	RCMT 0803M0-14	1
AVC-D20-SRDCN-10-Y	.787	.8268	.787	RCMT 10T3M0-14	1
AVC-D25-SRDCN-12-Y	.984	1.0236	.787	RCMT 1204M0-14	1
AVC-D32-SRDCN-16-Y	1.260	1.2992	.906	RCMT 1606M0-14	1
AVC-D40-SRDCN-16-Y	1.575	1.6142	.984	RCMT 1606M0-14	1

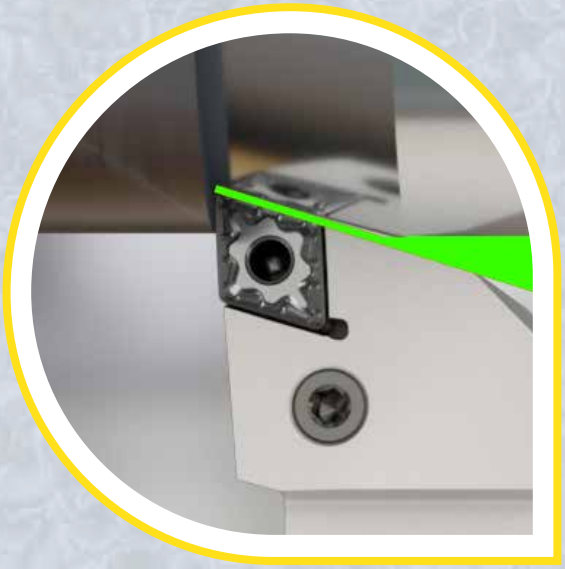
(1) Master insert identification

(2) 0 - Without coolant supply, 1 - With coolant supply

70° Corner Angle Turning

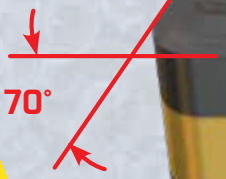
NEOTURN
ISOTURNING

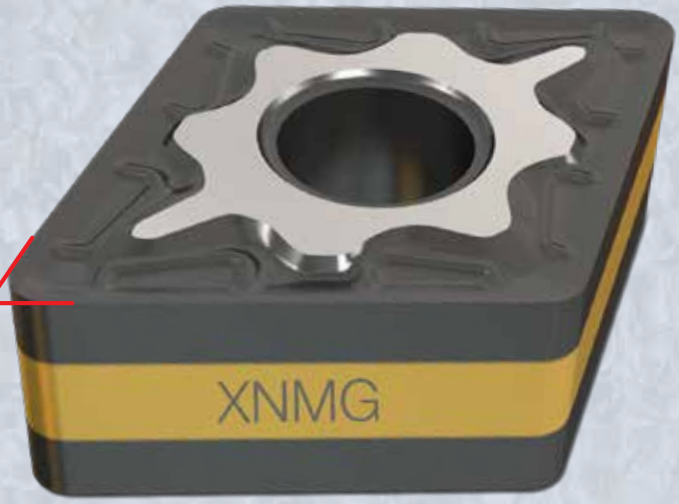
New XNMG **70° Corner Insert** for Turning Combines 55° and 80° Inserts. One Insert for **All Turning Applications.**



Deeper Rampdown and Increased Flexibility

Guaranteed Excellent
Chip Evacuation



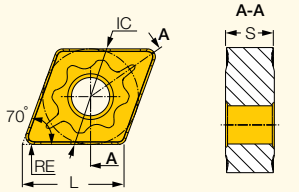


VIDEO

ISOTURN

XNMG-F3P

Double-Sided 70° Rhombic Inserts for Semi-Finishing and Finishing Applications

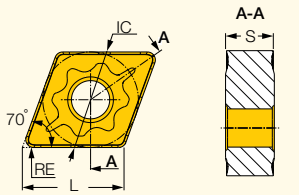


Designation	Dimensions L	IC	S	RE	Tough ↔ Hard IC830	IC8250	IC8150	IC807	Recommended Machining Data a_p (inch)	f (IPR)
XNMG 331-F3P	.399	.375	.187	.0157	●	●	●	●	.020-.138	.0027-.0098
XNMG 332-F3P	.399	.375	.187	.0315	●	●	●	●	.035-.138	.0031-.0098
XNMG 431-F3P	.532	.500	.187	.0157	●	●	●	●	.020-.138	.0027-.0098
XNMG 432-F3P	.532	.500	.187	.0315	●	●	●	●	.035-.138	.0031-.0098

ISOTURN

XNMG-M3P

Double-Sided 70° Rhombic Inserts for Medium Machining Conditions on Steel

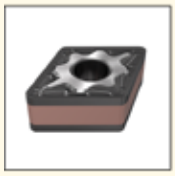


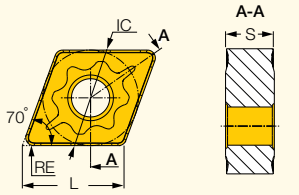
Designation	Dimensions L	IC	S	RE	Tough ↔ Hard IC830	IC8250	IC8150	IC807	Recommended Machining Data a_p (inch)	f (IPR)
XNMG 331-M3P	.399	.375	.187	.0157	●	●	●	●	.020-.138	.0027-.0098
XNMG 332-M3P	.399	.375	.187	.0315	●	●	●	●	.035-.138	.0031-.0098
XNMG 431-M3P	.532	.500	.187	.0157	●	●	●	●	.020-.138	.0027-.0098
XNMG 432-M3P	.532	.500	.187	.0315	●		●	●	.035-.138	.0031-.0098

ISOTURN

XNMG-F3M

Double-sided 70° Rhombic Inserts for Stainless Steel Finishing Applications



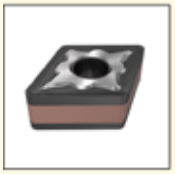


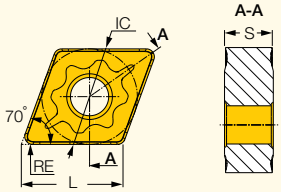
Designation	Dimensions L	IC	S	RE	Tough ↔ Hard IC830	IC6025	IC6015	IC806	IC807	Recommended Machining Data a_p (inch)	f (IPR)
XNMG 331-F3M	.399	.375	.187	.0157	●	●	●	●	●	.004-.059	.0020-.0118
XNMG 332-F3M	.399	.375	.187	.0315	●	●	●	●	●	.004-.059	.0039-.0157
XNMG 431-F3M	.532	.500	.187	.0157	●	●	●	●	●	.004-.059	.0020-.0118
XNMG 432-F3M	.532	.500	.187	.0315	●	●	●	●	●	.004-.059	.0039-.0157

ISOTURN

XNMG-M3M

Double-Sided 70° Rhombic Inserts for Machining Stainless and Low Carbon Steel



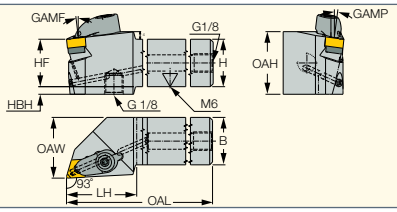


Designation	Dimensions L	IC	S	RE	Tough ↔ Hard IC830	IC6025	IC6015	IC806	IC807	Recommended Machining Data a_p (inch)	f (IPR)
XNMG 331-M3M	.399	.375	.187	.0157	●	●	●	●	●	.016-.157	.0047-.0157
XNMG 332-M3M	.399	.375	.187	.0315	●	●	●	●	●	.020-.177	.0059-.0197
XNMG 431-M3M	.532	.500	.187	.0157	●	●	●	●	●	.020-.197	.0059-.0197
XNMG 432-M3M	.532	.500	.187	.0315	●	●	●	●	●	.020-.197	.0059-.0197

ISOTURN

DXJNR/L-X-JHP-MC

Rigid Clamp Tools with Channels for High-Pressure Coolant Carrying 70° Rhombic Inserts



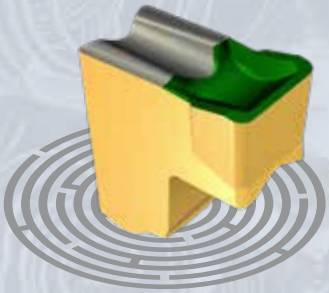
Designation	H	HF	HBH	LH	OAW	OAH	B	OAL	GAMP	GAMF	Insert
DXJNL 12-3-JHP-MC	.750	.750	.354	1.575	1.000	1.299	.750	4.331	6.0	6.0	XNMG 3
DXJNR 12-3-JHP-MC	.750	.750	.354	1.575	1.000	1.299	.750	4.331	6.0	6.0	XNMG 3
DXJNL 16-3-JHP-MC	1.000	1.000	.157	1.575	1.250	1.299	1.000	4.921	6.0	6.0	XNMG 3
DXJNR 16-3-JHP-MC	1.000	1.000	.157	1.575	1.250	1.299	1.000	4.921	6.0	6.0	XNMG 3
DXJNL 12-4-JHP-MC	.750	.750	.354	1.575	1.000	1.299	.750	4.331	6.0	6.0	XNMG 4
DXJNR 12-4-JHP-MC	.750	.750	.354	1.575	1.000	1.299	.750	4.331	6.0	6.0	XNMG 4
DXJNL 16-4-JHP-MC	1.000	1.000	.157	1.575	1.250	1.299	1.000	4.921	6.0	6.0	XNMG 4
DXJNR 16-4-JHP-MC	1.000	1.000	.157	1.575	1.250	1.299	1.000	4.921	6.0	6.0	XNMG 4
DXJNL 20-4-JHP-MC	1.250	1.250	.000	1.575	1.500	1.417	1.250	5.512	6.0	6.0	XNMG 4
DXJNR 20-4-JHP-MC	1.250	1.250	.000	1.575	1.500	1.417	1.250	5.512	6.0	6.0	XNMG 4

High Feed Parting, No Vibrations!

LOGIQFGRIP
HIGH FEED GRIP HOLDER

Revolutionary Quad Blade and Unique Holder **Enables Deeper Parting with High Feed Rates.** Guaranteed Vibration - Free Parting, High Part Straightness, and Improved Surface Finish Lead to Material Savings.
A 6.30" Bar Diameter Can be Cut with a .118" Insert.

300% Increased Productivity



TANGGRIP
PARTING LINE

New Insert Designed for High Feed Parting

A 6.30" Bar Diameter
Can be Cut with a .118" Insert

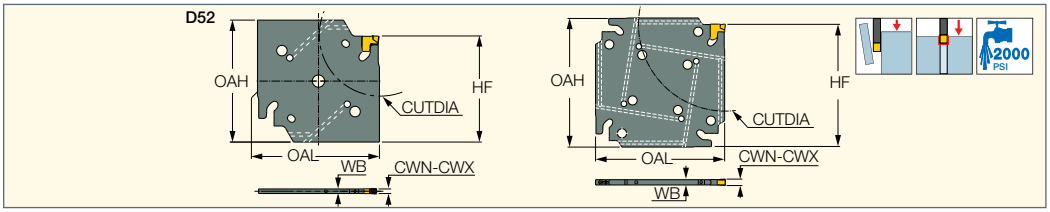
D82
VIDEO

D160
VIDEO

TANG F GRIP HIGH FEED PARTING

TGAQ-JHP

Parting and Grooving Square Adapters with Internal Coolant Holes Carrying TANG-GRIP Tangentially Clamped Inserts



Designation	OAL	OAH	CWN[1]	CWX[2]	WB	HF	CUTDIA[3]	MIID[4]	CSP[5]
TGAQ D52-2-2Z-JHP	1.968	1.968	.071	.098	.065	1.713	2.047	TAG 2	1
TGAQ D52-3-2Z-JHP	1.968	1.968	.110	.138	.098	1.713	2.047	TAG 3	1
TGAQ D52-4-2Z-JHP	1.968	1.968	.146	.177	.134	1.713	2.047	TAG 4	1
TGAQ D82-2-4Z-JHP	2.402	2.402	.071	.098	.065	2.283	3.228	TAG 2	1
TGAQ D82-3-4Z-JHP	2.402	2.402	.110	.138	.098	2.283	3.228	TAG 3	1
TGAQ D82-4-4Z-JHP	2.402	2.402	.146	.177	.134	2.283	3.228	TAG 4	1
TGAQ D120-3-4Z-JHP	3.563	3.563	.110	.138	.098	3.307	4.724	TAG 3	1
TGAQ D120-4-4Z-JHP	3.563	3.563	.146	.177	.134	3.307	4.724	TAG 4	1
TGAQ D120-5-4Z-JHP	3.563	3.563	.185	.217	.157	3.307	4.724	TAG 5	1
TGAQ D160-3-4Z-JHP	3.937	3.937	.110	.138	.098	3.819	6.299	TAG 3	1
TGAQ D160-4-4Z-JHP	3.937	3.937	.146	.177	.134	3.819	6.299	TAG 4	1
TGAQ D160-5-4Z-JHP	3.937	3.937	.185	.217	.157	3.819	6.299	TAG 5	1

- Suitable for all TANG-GRIP inserts

(1) Minimum cutting width

(2) Maximum cutting width

(3) Maximum diameter for parting

(4) Master insert identification

(5) 0 - Without coolant supply, 1 - With coolant supply

Flow Rate vs. Pressure

Designation	1000 PSI Flow Rate (GPM)	1450 PSI Flow Rate (GPM)	2000 PSI Flow Rate (GPM)
TGAQ D.../-2.../-3...-JHP	1.1-1.9	1.3-2.1	1.6-2.4
TGAQ D.../-4.../-5...-JHP	1.6-1.9	1.9-2.1	2.1-2.4

Spare Parts

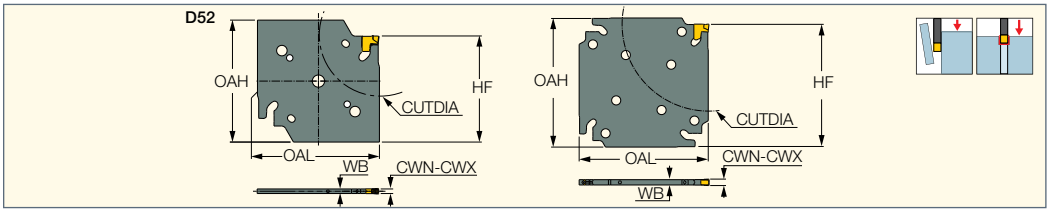
Designation			
TGAQ D52-2-2Z-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 2*
TGAQ D52-3-2Z-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 3-4-SH*
TGAQ D52-4-2Z-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 3-4-SH*
TGAQ D82-2-4Z-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 2*
TGAQ D82-3-4Z-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 3-4-SH*
TGAQ D82-4-4Z-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 3-4-SH*
TGAQ D120-3-4Z-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 3-4-SH*
TGAQ D120-4-4Z-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 3-4-SH*
TGAQ D120-5-4Z-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 5-7*
TGAQ D160-3-4Z-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 3-4-SH*
TGAQ D160-4-4Z-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 3-4-SH*
TGAQ D160-5-4Z-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	ETG 5-7*

* Optional, should be ordered separately

TANG-F-GRIP HIGH FEED PARTING

TGAQ

Parting and Grooving Square Adapters Carrying TANG-GRIP Tangentially Clamped Inserts



Designation	OAL	OAH	CWN[1]	CWX[2]	WB	HF	CUTDIA[3]	MIID[4]	CSP[5]
TGAQ D52-2-2Z	1.968	1.968	.071	.098	.065	1.713	2.047	TAG 2	0
TGAQ D52-3-2Z	1.968	1.968	.110	.138	.098	1.713	2.047	TAG 3	0
TGAQ D52-4-2Z	1.968	1.968	.146	.177	.134	1.713	2.047	TAG 4	0
TGAQ D82-2-4Z	2.402	2.402	.071	.098	.065	2.283	3.228	TAG 2	0
TGAQ D82-3-4Z	2.402	2.402	.110	.138	.098	2.283	3.228	TAG 3	0
TGAQ D82-4-4Z	2.402	2.402	.146	.177	.134	2.283	3.228	TAG 4	0
TGAQ D120-3-4Z	3.563	3.563	.110	.138	.098	3.307	4.724	TAG 3	0
TGAQ D120-4-4Z	3.563	3.563	.146	.177	.134	3.307	4.724	TAG 4	0
TGAQ D120-5-4Z	3.563	3.563	.185	.217	.157	3.307	4.724	TAG 5	0
TGAQ D160-3-4Z	3.937	3.937	.110	.138	.098	3.819	6.299	TAG 3	0
TGAQ D160-4-4Z	3.937	3.937	.146	.177	.134	3.819	6.299	TAG 4	0
TGAQ D160-5-4Z	3.937	3.937	.185	.217	.157	3.819	6.299	TAG 5	0

- Suitable for all TANG-GRIP inserts

[1] Minimum cutting width

[2] Maximum cutting width

[3] Maximum diameter for parting

[4] Master insert identification

[5] 0 - Without coolant supply, 1 - With coolant supply

Spare Parts

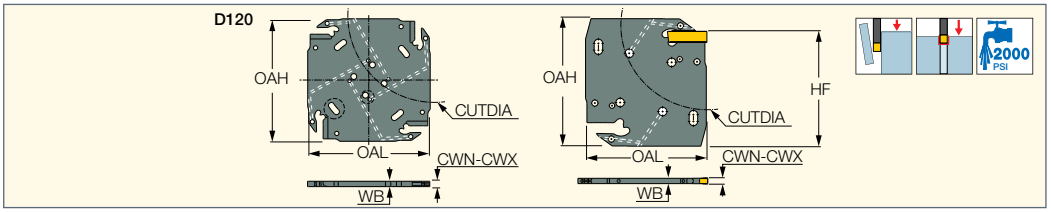
Designation		
TGAQ D52-2-2Z	SR ISO 14580 M4X10	ETG 2*
TGAQ D52-3-2Z	SR ISO 14580 M4X10	ETG 3-4-SH*
TGAQ D52-4-2Z	SR ISO 14580 M4X10	ETG 3-4-SH*
TGAQ D82-2-4Z	SR ISO 14580 M4X10	ETG 2*
TGAQ D82-3-4Z	SR ISO 14580 M4X10	ETG 3-4-SH*
TGAQ D82-4-4Z	SR ISO 14580 M4X10	ETG 3-4-SH*
TGAQ D120-3-4Z	SR ISO 14580 M4X10	ETG 3-4-SH*
TGAQ D120-4-4Z	SR ISO 14580 M4X10	ETG 3-4-SH*
TGAQ D120-5-4Z	SR ISO 14580 M4X10	ETG 5-7*
TGAQ D160-3-4Z	SR ISO 14580 M4X10	ETG 3-4-SH*
TGAQ D160-4-4Z	SR ISO 14580 M4X10	ETG 3-4-SH*
TGAQ D160-5-4Z	SR ISO 14580 M4X10	ETG 5-7*

* Optional, should be ordered separately

DO-FGRIP TWISTED 2-SIDED

DGAQ-JHP

Parting and Grooving Square Adapters with Internal Coolant Holes Carrying DO-GRIP Inserts



Designation	OAL	OAH	CWN[1]	CWX[2]	WB	HF	CUTDIA[3]	MIID[4]	CSP[5]
DGAQ D52-2-2Z-JHP	1.968	1.968	.075	.098	.068	1.713	2.047	DGN 2	1
DGAQ D52-3-2Z-JHP	1.968	1.968	.118	.125	.098	1.713	2.047	DGN 3	1
DGAQ D52-4-2Z-JHP	1.968	1.968	.157	.157	.126	1.713	2.047	DGN 4	1
DGAQ D82-3-2Z-JHP	2.535	2.535	.118	.125	.098	2.283	3.228	DGN 3	1
DGAQ D82-4-2Z-JHP	2.535	2.535	.157	.157	.126	2.283	3.228	DGN 4	1
DGAQ D82-5-2Z-JHP	2.535	2.535	.197	.197	.157	2.283	3.228	DGN 5	1
DGAQ D120-4-4Z-JHP	3.563	3.563	.157	.157	.126	3.307	4.724	DGN 4	1
DGAQ D120-5-4Z-JHP	3.563	3.563	.197	.197	.157	3.307	4.724	DGN 5	1

- When using .079 and .118" double-sided inserts, the depth of cut is limited up to .75". For larger depth, use a DGNM type single-ended insert.

(1) Minimum cutting width

(2) Maximum cutting width

(3) Maximum diameter for parting

(4) Master insert identification

(5) 0 - Without coolant supply, 1 - With coolant supply

Flow Rate vs. Pressure

Designation	1000 PSI Flow Rate (GPM)	1450 PSI Flow Rate (GPM)	2000 PSI Flow Rate (GPM)
DGAQ D.../-2.../-3...-JHP	1.1-1.9	1.3-2.1	1.6-2.4
DGAQ D.../-4.../-5...-JHP	1.6-1.9	1.9-2.1	2.1-2.4

Spare Parts

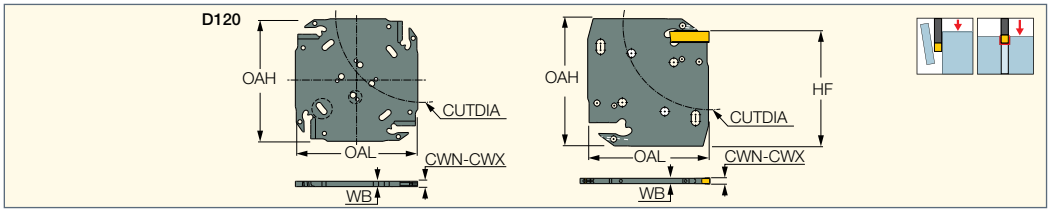
Designation			
DGAQ-JHP	SR M4X9-SEAL-JHP	JHP COPPER SEAL 1/8"	EDG 33A*

* Optional, should be ordered separately

DOFGRIP TWISTED 2-SIDED

DGAQ

Parting and Grooving
Square Adapters Carrying
DO-GRIP Inserts



Designation	OAL	OAH	CWN[1]	CWX[2]	WB	HF	CUTDIA[3]	MIID[4]	CSP[5]
DGAQ D52-2-2Z	1.968	1.968	.075	.098	.068	1.713	2.047	DGN 2	0
DGAQ D52-3-2Z	1.968	1.968	.118	.125	.098	1.713	2.047	DGN 3	0
DGAQ D52-4-2Z	1.968	1.968	.157	.157	.126	1.713	2.047	DGN 4	0
DGAQ D82-3-2Z	2.535	2.535	.118	.125	.098	2.283	3.228	DGN 3	0
DGAQ D82-4-2Z	2.535	2.535	.157	.157	.126	2.283	3.228	DGN 4	0
DGAQ D82-5-2Z	2.535	2.535	.197	.197	.157	2.283	3.228	DGN 5	0
DGAQ D120-4-4Z	3.563	3.563	.157	.157	.126	3.307	4.724	DGN 4	0
DGAQ D120-5-4Z	3.563	3.563	.197	.197	.157	3.307	4.724	DGN 5	0

- When using .079 and .118" double-sided inserts, the depth of cut is limited up to .75". For larger depth, use a DGNM type single-ended insert.

[1] Minimum cutting width
[2] Maximum cutting width
[3] Maximum diameter for parting
[4] Master insert identification
[5] 0 - Without coolant supply, 1 - With coolant supply

Spare Parts

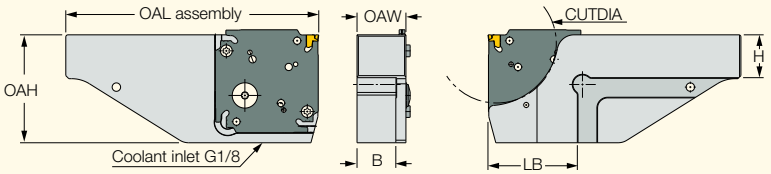
Designation		
DGAQ	SR ISO 14580 M4X10	EDG 33A*

* Optional, should be ordered separately

LOGIQ F GRIP
HIGH FEED GRIP HOLDER

TGTBQ-JHP

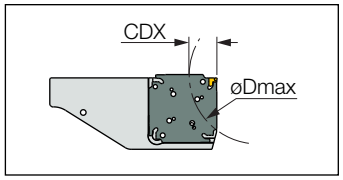
Tool Blocks for Square TANG-F-GRIP and DO-F-GRIP Parting and Grooving Adapters for High-Pressure Coolant



Designation	OAH	H	B	OAW	OAL	LB	CUTDIA
TGTBQ 19L-D52-JHP	1.970	.750	.772	1.008	4.803	1.339	2.047
TGTBQ 19R-D52-JHP	1.970	.750	.772	1.008	4.803	1.339	2.047
TGTBQ 25.4L-D52-JHP	1.970	1.000	1.024	1.260	5.197	1.339	2.047
TGTBQ 25.4R-D52-JHP	1.970	1.000	1.024	1.260	5.197	1.339	2.047
TGTBQ 19L-D82-JHP	2.520	.750	.772	1.008	5.512	2.087	3.228
TGTBQ 19R-D82-JHP	2.520	.750	.772	1.008	5.512	2.087	3.228
TGTBQ 25.4L-D82-JHP	2.520	1.000	1.024	1.260	5.906	2.087	3.228
TGTBQ 25.4R-D82-JHP	2.520	1.000	1.024	1.260	5.906	2.087	3.228
TGTBQ 31.8L-D82-JHP	2.520	1.250	1.280	1.516	5.925	2.106	3.228
TGTBQ 31.8R-D82-JHP	2.520	1.250	1.280	1.516	5.925	2.106	3.228
TGTBQ 25.4L-D120-JHP	3.740	1.000	1.024	1.260	6.496	2.638	4.724
TGTBQ 25.4R-D120-JHP	3.740	1.000	1.024	1.260	6.496	2.638	4.724
TGTBQ 31.8L-D120-JHP	3.740	1.250	1.280	1.516	6.496	2.638	4.724
TGTBQ 31.8R-D120-JHP	3.740	1.250	1.280	1.516	6.496	2.638	4.724
TGTBQ 25.4L-D160-JHP	4.210	1.000	1.024	1.260	7.500	3.642	6.299
TGTBQ 25.4R-D160-JHP	4.210	1.000	1.024	1.260	7.500	3.642	6.299
TGTBQ 31.8L-D160-JHP	4.210	1.250	1.280	1.516	7.500	3.642	6.299
TGTBQ 31.8R-D160-JHP	4.210	1.250	1.280	1.516	7.500	3.642	6.299
TGTBQ 38.1L-D160-JHP	4.210	1.500	1.520	1.756	7.500	3.642	6.299
TGTBQ 38.1R-D160-JHP	4.210	1.500	1.520	1.756	7.500	3.642	6.299

Table determining depth of cut for grooving as function of workpiece diameter.

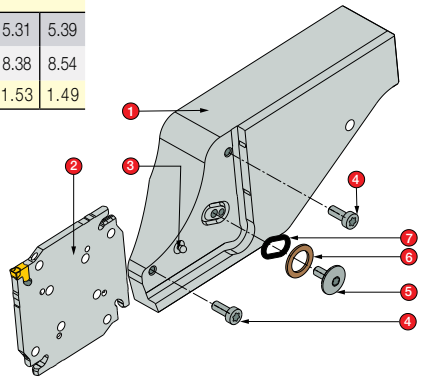
Designation	øDmax																	
TGTBQ...D52-JHP	2.08	2.12	2.16	2.20	2.24	2.32	2.40	2.51	2.63	2.79	2.95	3.18	3.46	3.77	4.21	4.80	5.55	6.65
TGTBQ...D82-JHP	4.21	4.33	4.48	4.68	4.88	5.11	5.39	5.70	6.06	6.49	7.00	7.63	8.38	9.33	10.51	12.12	14.29	17.44
TGTBQ...D120-JHP	7.95	8.26	8.62	9.01	9.44	9.96	10.51	11.14	11.88	12.75	13.74	14.96	16.41	18.18	20.39	23.30	27.12	32.55
TGTBQ...D160-JHP	13.58	14.21	14.84	15.59	16.45	17.36	18.42	19.64	20.62	22.67	24.56	26.85	29.64	33.07	37.44	43.14	50.94	62.32
CDX	.82	.78	.74	.70	.66	.62	.58	.54	.50	.46	.42	.38	.35	.31	.27	.23	.19	.15



Designation	øDmax															
TGTBQ...D82-JHP	3.26	3.26	3.30	3.30	3.34	3.38	3.42	3.46	3.50	3.58	3.62	3.70	3.77	3.85	3.97	4.05
TGTBQ...D120-JHP	5.47	5.55	5.63	5.71	5.82	5.90	6.02	6.14	6.30	6.45	6.61	6.77	6.96	7.20	7.40	7.67
TGTBQ...D160-JHP	8.66	8.85	9.01	9.21	9.40	9.64	9.88	10.11	10.39	10.66	10.98	11.33	11.73	12.12	12.59	13.07
CDX	1.45	1.41	1.37	1.33	1.29	1.26	1.22	1.18	1.14	1.10	1.06	1.02	.98	.94	.90	.86

Designation	øDmax																	
TGTBQ...D120-JHP	4.76	4.80	4.84	4.84	4.88	4.92	4.92	4.96	5.00	5.03	5.07	5.11	5.15	5.19	5.27	5.31	5.39	
TGTBQ...D160-JHP	6.73	6.96	7.12	7.20	7.24	7.32	7.40	7.48	7.59	7.67	7.79	7.87	7.99	8.11	8.23	8.38	8.54	
CDX	2.20-2.36	2.08-2.16	2.04	2.00	1.96	1.92	1.88	1.85	1.81	1.77	1.73	1.69	1.65	1.61	1.57	1.53	1.49	

1. **Block:** TGTBQ...D...
2. **Blade:** T/DGAQ...
3. **Locating Pin:** Side thrust Pin .118”
4. **Screw:** SR M4x10 ISO 14580
5. **Screw:** SR M4x9-Seal-JHP
6. **Seal washer:** CSW 1/8’’
7. **O-ring:** O-ring 10x2 NBR



Spare Parts

Designation							
TGTBQ-JHP	SR M4X9-SEAL-JHP	SIDE THRUST PIN 3mm	JHP COPPER SEAL 1/8"	SR ISO 14580 M4X10	SW6-SD	BLD T20/S7	O-RING 10X2 NBR

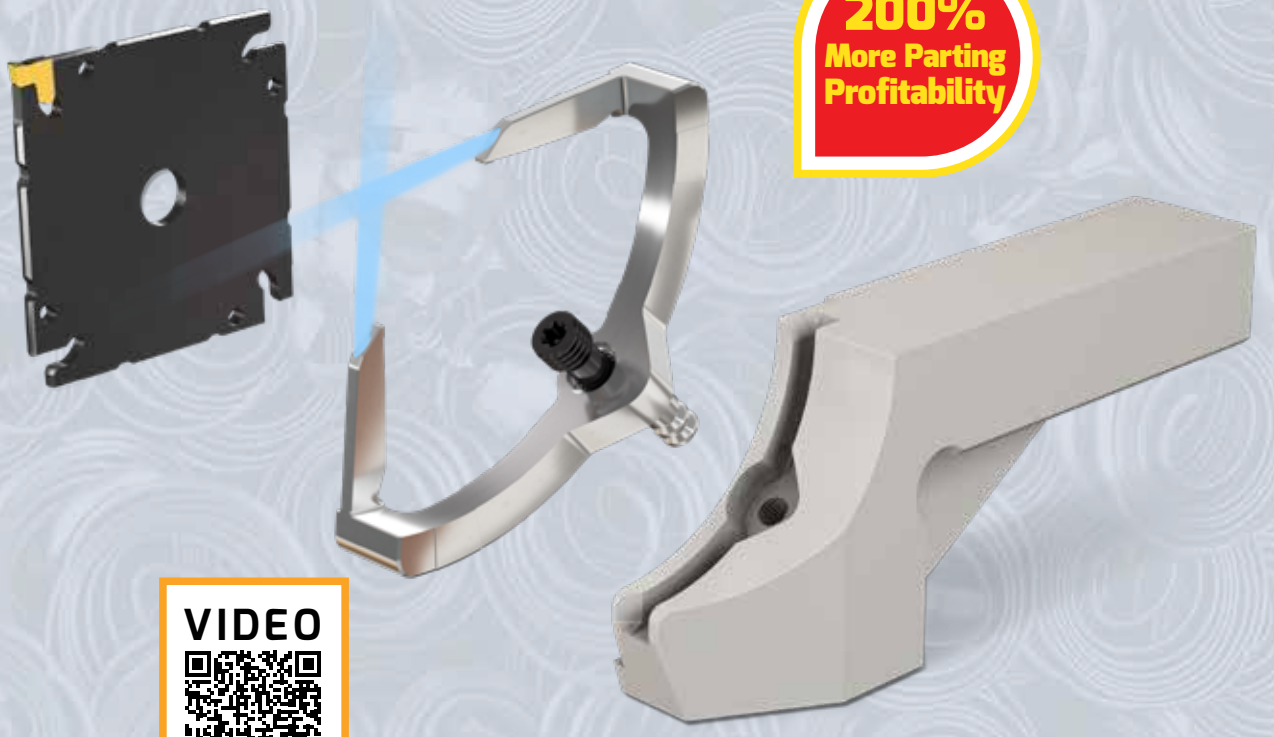
Innovative Clamping with Pinpointed Coolant

JETCROWN
LOGIQ JET COOLANT

Quick Clamping Crown
A Unique Method for Clamping a Square-Shaped Blade with **Direct Pinpointed Coolant**.
Improves Insert Life Time.
No Setup Time
Fast Blade Indexing.

Top and Bottom
Highly Efficient
Pinpointed Coolant

200%
More Parting Profitability



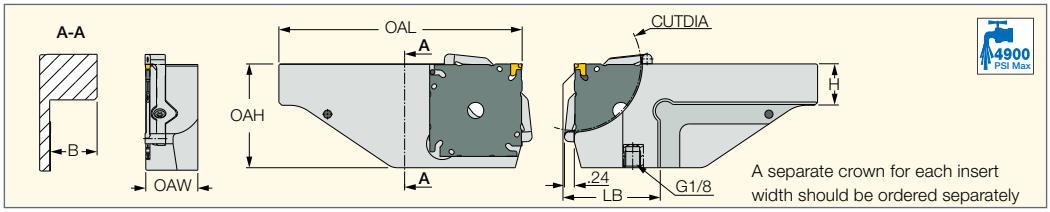
VIDEO

LOGIQ F GRIP HIGH FEED GRIP HOLDER

JETCROWN LOGIQ JET COOLANT

TGTBQ-ECD-JHP (JET-CROWN)

Tool Blocks for Square TANG-F-GRIP (TGAQ-ECD) Parting and Grooving Adapters for High-Pressure Coolant



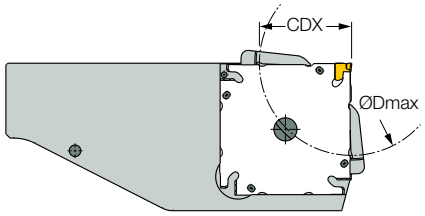
Designation	H	B	OAH	OAW	OAL	LB	CUTDIA
TGTBQ 19L-D65-ECD-JHP	.750	.771	2.165	1.007	5.078	1.653	2.559
TGTBQ 19R-D65-ECD-JHP	.750	.771	2.165	1.007	5.078	1.653	2.559
TGTBQ 19L-D82-ECD-JHP	.750	.771	2.519	1.007	5.511	2.086	3.220
TGTBQ 19R-D82-ECD-JHP	.750	.771	2.519	1.007	5.511	2.086	3.220
TGTBQ 25.4L-D65-ECD-JHP	1.000	1.023	2.165	1.259	5.472	1.653	2.559
TGTBQ 25.4R-D65-ECD-JHP	1.000	1.023	2.165	1.259	5.472	1.653	2.559
TGTBQ 25.4L-D82-ECD-JHP	1.000	1.023	2.519	1.259	5.905	2.086	3.220
TGTBQ 25.4R-D82-ECD-JHP	1.000	1.023	2.519	1.259	5.905	2.086	3.220

- A separate crown for each insert width should be ordered separately.

Depth of cut as function of workpiece diameter

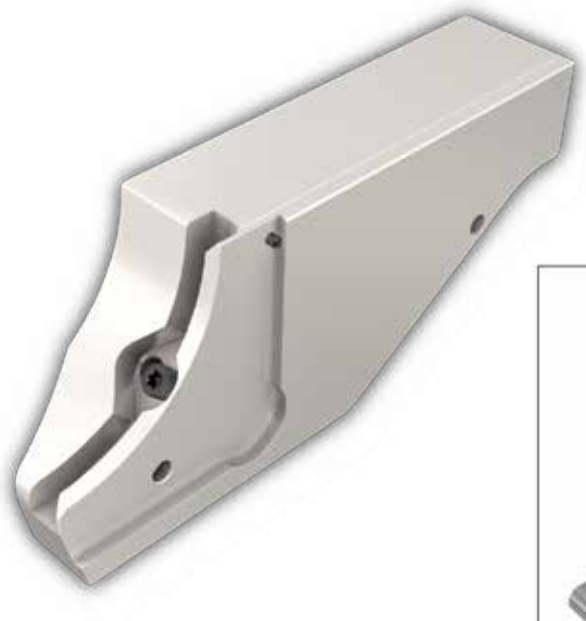
Designation	Dmax																			
TGTBQ ..R/L-D65-ECD	3.86	3.74	3.54	3.43	3.31	3.19	3.07	2.99	2.91	2.87	2.83	2.76	2.72	2.68	2.64	2.60	2.56			
CDX	.31	.35	.39	.43	.47	.51	.55	.59	.63	.67	.71	.75	.79-.83	.87	.91-.94	.98-1.30	1.28			
TGTBQ ..R/L-D82-ECD	4.64	4.56	4.40	4.25	4.13	4.01	3.89	3.81	3.74	3.66	3.58	3.54	3.50	3.46	3.42	3.38	3.34	3.30	3.26	3.22
CDX	.43	.47	.51	.55	.59	.63	.66	.70	.74	.78	.82	.86	.90	.94	.98	1.02	1.06	1.10	1.22	1.61

The tool cannot be used for grooving applications when the workpiece diameter is larger than 4.64".



Spare Parts

Designation			
TGTBQ-ECD-JHP (JET-CROWN)	SR M7-R-L	BLD T20/S7	SW6-SD

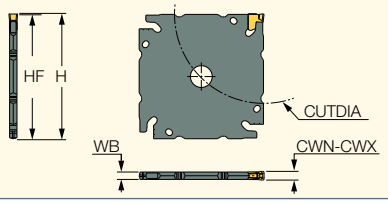


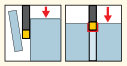
TANG F GRIP HIGH FEED PARTING

JETCROWN LOGIQ JET COOLANT

TGAQ-ECD (JET-CROWN)

Parting and Grooving Square Adapters Compatible with TANG-GRIP Inserts (Single-Ended)





A separate crown for each insert width should be ordered separately

Designation	CWN[1]	CWX[2]	WB	H	HF[3]	CUTDIA	MIID[4]
TGAQ D65-2-4Z-ECD	.071	.098	.065	1.929	1.917	2.559	TAG N2
TGAQ D65-3-4Z-ECD	.110	.138	.098	1.929	1.917	2.559	TAG N3
TGAQ D82-2-4Z-ECD	.071	.098	.065	2.283	2.272	3.228	TAG N2
TGAQ D82-3-4Z-ECD	.110	.138	.098	2.283	2.272	3.228	TAG N3
TGAQ D82-4-4Z-ECD	.146	.177	.134	2.283	2.272	3.228	TAG N4

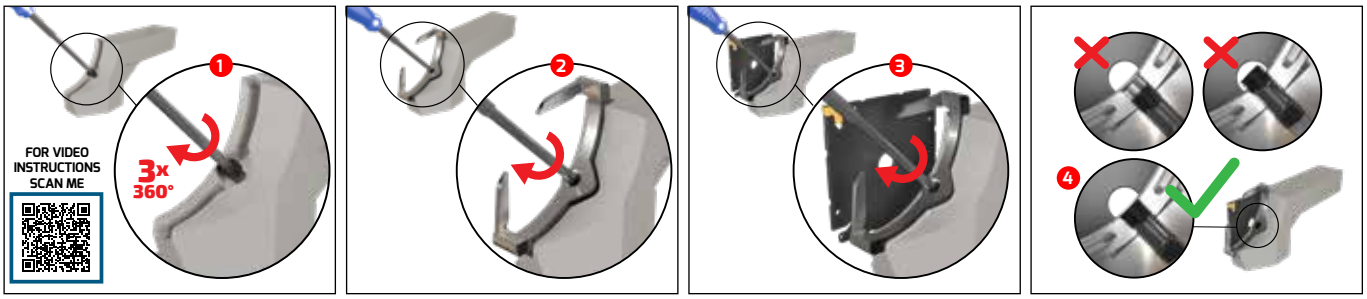
- Suitable for all TANG-GRIP inserts

[1] Minimum cutting width

[2] Maximum cutting width

[3] Related to insert

[4] Master insert identification



Spare Parts

Designation		
TGAQ D65-2-4Z-ECD	ECD D65-2-TG*	ETG 2*
TGAQ D65-3-4Z-ECD	ECD D65-3-TG*	ETG 3-4-SH*
TGAQ D82-2-4Z-ECD	ECD D82-2-TG*	ETG 2*
TGAQ D82-3-4Z-ECD	ECD D82-3-TG*	ETG 3-4-SH*
TGAQ D82-4-4Z-ECD	ECD D82-4-TG*	ETG 3-4-SH*

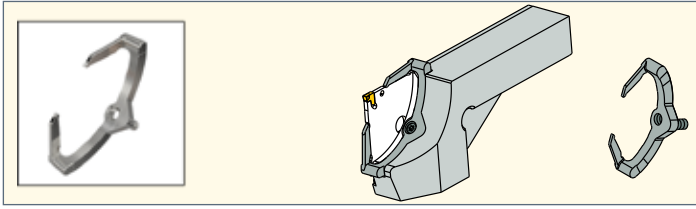
* Optional, should be ordered separately

Accessories

JETCROWN LOGIQ JET COOLANT

CROWN (ECD)

Crown Clamping Mechanism with a Single Screw for Fast Clamping and Indexing, Features Two Effective Coolant Holes



Designation	CW[1]	CUTDIA[2]
ECD D65-2-TG	.079	2.559
ECD D65-3-TG	.118	2.559
ECD D82-2-TG	.079	3.228
ECD D82-3-TG	.118	3.228
ECD D82-4-TG	.157	3.228

[1] Related insert cutting width

[2] Maximum parting diameter


TGAQ D82-3-42

Multi-Task Holder

LOGIQ F GRIP
HIGH FEED Y-AXIS

New Intermediate Size Holder for **Y-Axis Parting on Multi-Tasking Machines** Enables Parting at High Feed Rates. **Vibration Free!**

Vibration Free!

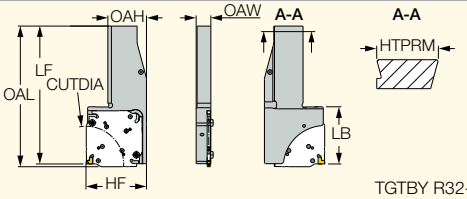
Same Holder and Blade
for Y-and X-Axis Parting

VIDEO

LOGIQ F GRIP HIGH FEED Y-AXIS

TGTBY-JHP

Y-Axis Intermediate Prismatic Holders for Square JHP Adapters on Multi-Task Machines for Parting and Grooving



TGTBY R32-D82R-JHP with TGAQ Shown

Designation	OAH	HF	OAW	LF	LB	CUTDIA	OAL(1)	OAL_2(2)	HTPRM
TGTBY R/L32-D82R-JHP	2.591	2.591	.630	5.906	2.441	3.228	6.024	6.157	1.260
TGTBY R/L32-D82L-JHP	2.591	2.591	.630	5.906	2.441	3.228	6.024	6.157	1.260

• Can be used also for X-axis (multi-task machines) - location pin should be removed • The tool types shown are currently unavailable in the USA, Canada, China, Japan and Korea.

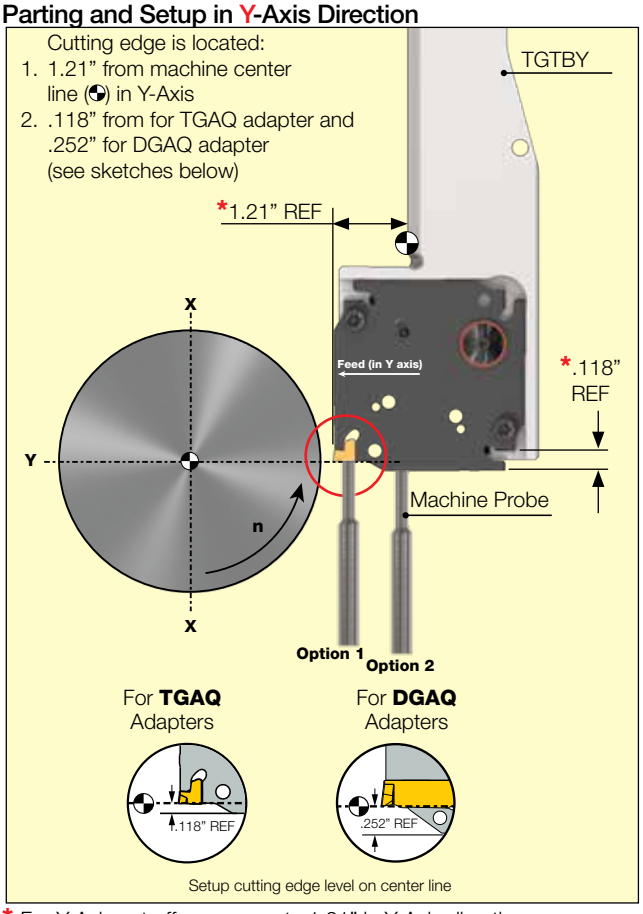
(1) Overall length with TGAQ adapter

(2) Overall length with DGAQ adapter

Y-Axis Tool Setup on Multi-Task Machines

Parting and Setup in Y-Axis Direction

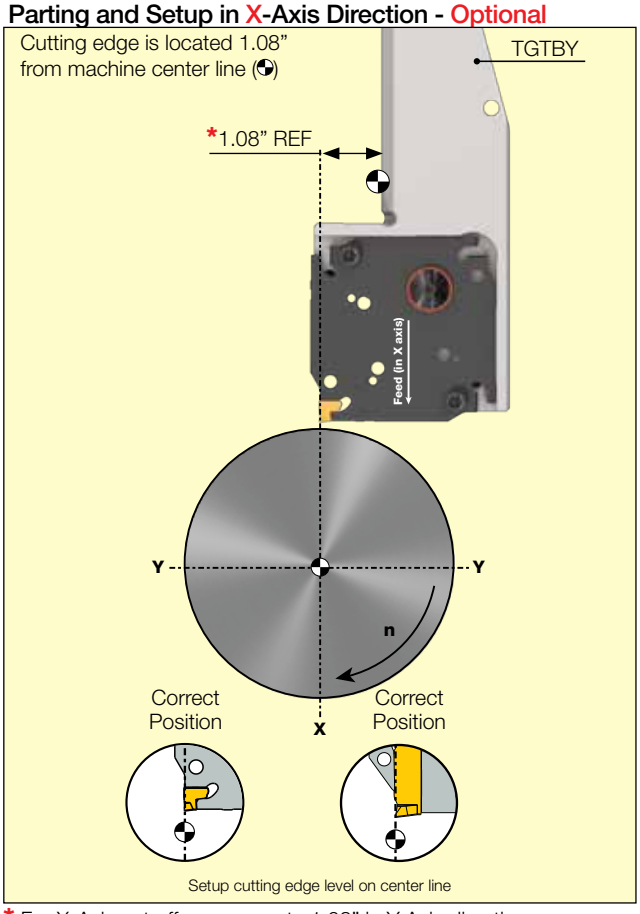
Cutting edge is located:
1. 1.21" from machine center line (⊕) in Y-Axis
2. .118" from for TGAQ adapter and .252" for DGAQ adapter (see sketches below)



Setup cutting edge level on center line

Parting and Setup in X-Axis Direction - Optional

Cutting edge is located 1.08" from machine center line (⊕)

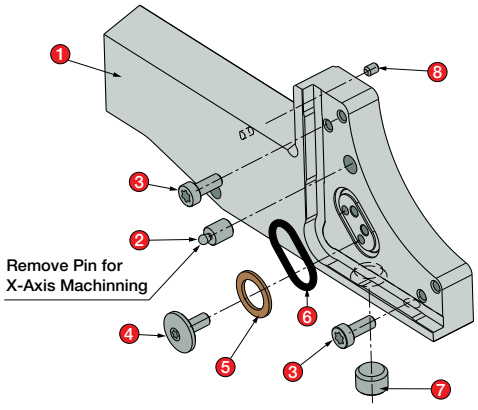


Setup cutting edge level on center line

* For Y-Axis cut off, compensate 1.21" in Y Axis direction and compensate .118" for TGAQ adapters or .252" for DGAQ adapters in X-Axis direction.

Set the cutting edge on the center line:
Option 1 - Gauge the cutting edge - this is preferable due to better accuracy
Option 2 - Gauge the blade and compensate .118 / .252"

* For X-Axis cut off, compensate 1.08" in Y-Axis direction. Location pin should be removed.



1. **Block:** TGTBY
2. **Locating pin:** Side thrust Pin .118"
3. **Clamping screw :** SR M4x10 ISO 14580
4. **Clamping & sealing screw :** SR M4x9-Seal-JHP
5. **Seal washer:** CSW 1/8"
6. **O-ring:** O-ring 10x2 NBR
7. **Lower sealing plug :** Plug G1/8-6.5 TL360
8. **Upper sealing screw :** SR M3x4-DIN913

Spare Parts

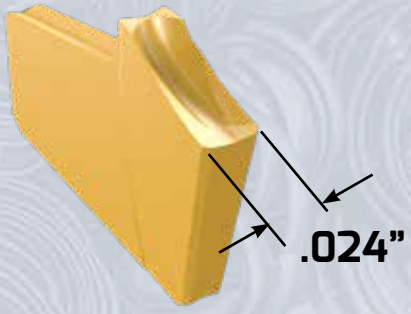
Designation									
TGTBY-JHP	SR ISO 14580 M4X10	SR M4X9-SEAL-JHP	OR 16X2 NBR	JHP COPPER SEAL 1/8"	BLD T20/S7	SW6-SD	PLG G1/8 TL360	HW 5.0	SIDE THRUST PIN 3mm

Narrow Parting for Cost Savings!

SWISSGRIP
NARROW WIDTHS

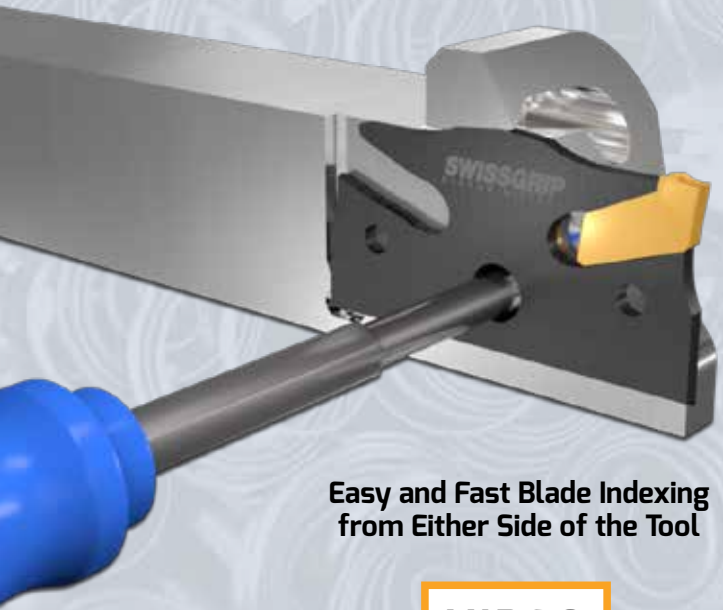
Innovative Tool Holder with a **2 Pocket Blade** for Parting and Grooving. Narrow Widths of **.024-.047".** Fits Swiss-Type Machines. Easy and Fast Blade Indexing with **No Setup Time.**

High Cost Savings No Setup Time



- .024 and .031" Insert Widths for .39" Part Diameter.
- .039 and .047" Insert Widths for .63" Part Diameter.

Increments of .0078"



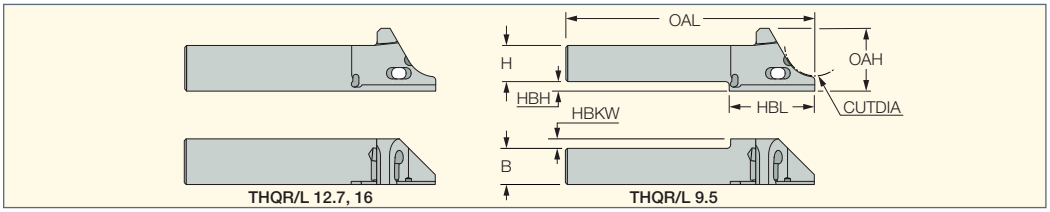
Easy and Fast Blade Indexing from Either Side of the Tool

VIDEO

SWISSGRIP NARROW WIDTHS

THQR/L

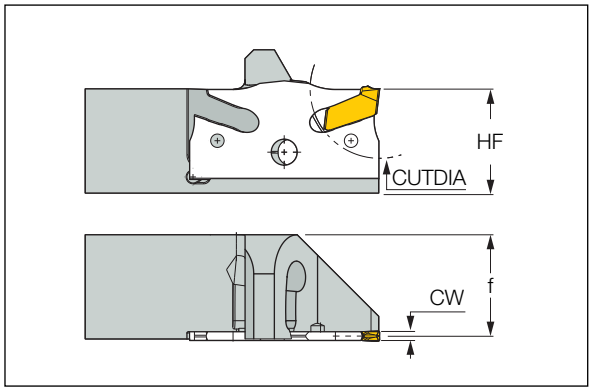
Parting and Grooving Holder for a SELF-GRIP Mini Blades (SGAQ), Suitable for Swiss-Type Machines



Designation	H	OAL	HF	OAH	HBL	HBH	CUTDIA	HBKW	B
THQL 9.5-D16	.375	3.937	.374	.650	.890	.100	.630	.4720	.374
THQR 9.5-D16	.375	3.937	.374	.650	.890	.100	.630	.4720	.374
THQR/L 12.7-D16	.500	3.937	.500	.677	-	-	.630	-	.500
THQR/L 16-D16	.630	3.937	.630	.807	-	-	.630	-	.630

Designation	CW	CUTDIA	f
THQL/R 9.5-D16 + SGAQ 0.6	.024	.394	.381
THQL/R 9.5-D16 + SGAQ 0.8	.031	.394	.381
THQL/R 12.7-D16+SGAQ 0.6	.024	.394	.460
THQL/R 12.7-D16+SGAQ 0.8	.031	.394	.460
THQL/R 16-D16 + SGAQ 0.6	.024	.394	.617
THQL/R 16-D16 + SGAQ 0.8	.031	.394	.617

Designation	CW	CUTDIA	f
THQL/R 9.5-D16 + SGAQ 1.0	.039	.629	.378
THQL/R 9.5-D16 + SGAQ 1.2	.047	.629	.381
THQL/R 12.7-D16+SGAQ 1.0	.039	.629	.457
THQL/R 12.7-D16+SGAQ 1.2	.047	.629	.460
THQL/R 16-D16 + SGAQ 1.0	.039	.629	.614
THQL/R 16-D16 + SGAQ 1.2	.047	.629	.617



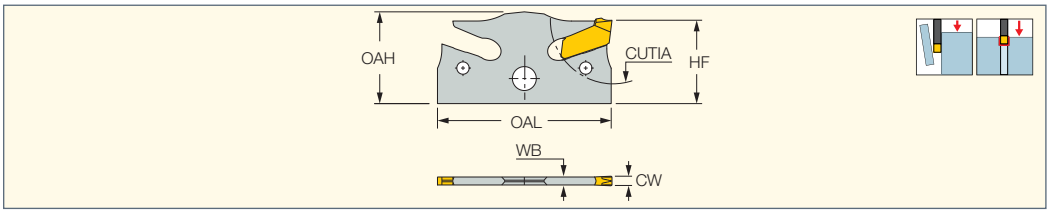
Spare Parts

Designation	
THQR/L	ESG-SWISS 0.6-1.2

SWISSGRIP NARROW WIDTHS

SGAQ

SELF-GRIP Mini Blades for Parting and Grooving, Suitable for Swiss-Type Machines



Designation	OAH	OAL	CUTDIA	WB	CW	MIID[1]	
SGAQ D10-0.6	.453	.858	.394	.020	.024	GFT 0.6J-0.1	ESG-SLM*
SGAQ D10-0.8	.453	.858	.394	.027	.031	GFT 0.8J-0.1	ESG-SLM*
SGAQ D16-1.0	.453	.858	.630	.033	.039	GFT 1.0J-0.1	ESG-SLM*
SGAQ D16-1.2	.453	.858	.630	.039	.047	GFT 1.2J-0.14	ESG-SLM*

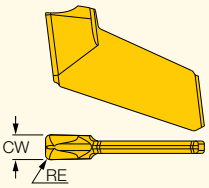
(1) Master insert identification

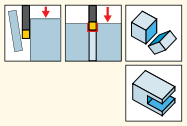
* Optional, should be ordered separately

SLIMGRIP
NARROW INSERTS

GFT-J

Thin Parting, Grooving and Slitting Single-Ended Inserts for Soft Materials





Designation	Dimensions CW	RE	Tough ↔ Hard IC1028	IC1008	Recommended Machining Data f groove (IPR)
GFT 0.6J-0.1	.024	.0039	●	●	.0010-.0020
GFT 0.8J-0.1	.031	.0039	●	●	.0012-.0027
GFT 1.0J-0.1	.039	.0039	●	●	.0012-.0035
GFT 1.2J-0.14	.047	.0055	●	●	.0012-.0039

NEOLOGIQ DRILL

MACHINING INTELLIGENTLY

LOGIQ 3 CHAM
THREE FLUTE CHAMDRILL

SOLIDDRILL
SOLID CARBIDE

Member IMC Group

ISCAR

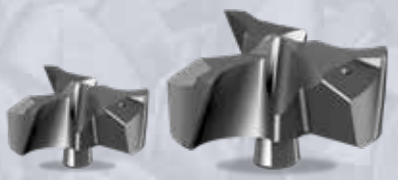
High Productivity Drilling

LOGIQ 3 CHAM
THREE FLUTE CHAMDRILL

3 Effective Cutting Edges, Self-Centering Drill and Flat Heads for Fast and Accurate Drilling. Excellent Hole Surface and Chip Evacuation.
Dia. Range of .472-1.020”

For Better Roundness and Concentricity

Self-Centering for High Surface Quality



Flat Heads for Flat Bottom Holes

VIDEO

VIDEO

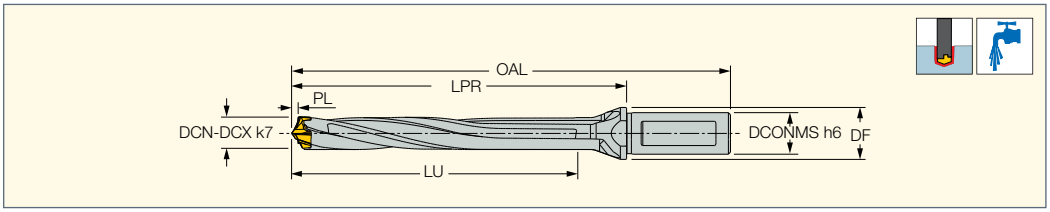
up to 300% Faster

1.5XD 3XD 5XD 8XD

LOGIQ 3CHAM THREE FLUTE CHAMDRILL

D3N A-8D

Exchangeable Head 3 Flute Drills with Coolant Holes and One Flat Shank. Drilling Depth 8xD



Designation	DCN(1)	DCX(2)	DCONMS	DF	LU	LPR	PL	OAL	SSC(3)	
D3N 0472-378-063A-8D	.472	.488	.625	.787	3.8890	4.764	.10700	6.650	12	K D3N 12-13.99
D3N 0492-394-063A-8D	.492	.508	.625	.787	4.0470	4.951	.10700	6.837	12	K D3N 12-13.99
D3N 0512-409-063A-8D	.512	.528	.625	.787	4.2120	5.164	.11500	7.050	13	K D3N 12-13.99
D3N 0531-425-063A-8D	.531	.547	.625	.787	4.3700	5.352	.11500	7.237	13	K D3N 12-13.99
D3N 0551-441-063A-8D	.551	.567	.625	.787	4.5350	5.558	.12200	7.444	14	K D3N 14-15.99
D3N 0571-457-063A-8D	.571	.587	.625	.787	4.6920	5.746	.12200	7.631	14	K D3N 14-15.99
D3N 0591-472-075A-8D	.591	.626	.750	.984	4.8650	5.956	.13700	7.920	15	K D3N 14-15.99
D3N 0630-504-075A-8D	.630	.665	.750	.984	5.1790	6.353	.13500	8.317	16	K D3N 16-17.99
D3N 0669-535-075A-8D	.669	.705	.750	.984	5.4970	6.746	.13900	8.709	17	K D3N 16-17.99
D3N 0709-567-100A-8D	.709	.744	1.000	1.260	5.8270	7.146	.15400	9.345	18	K D3N 18-19.99
D3N 0748-598-100A-8D	.748	.784	1.000	1.260	6.1500	7.542	.16100	9.741	19	K D3N 18-19.99
D3N 0787-630-100A-8D	.787	.823	1.000	1.260	6.4740	7.929	.17000	10.128	20	K D3N 20-21.99
D3N 0827-661-100A-8D	.827	.862	1.000	1.260	6.7980	8.325	.17900	10.524	21	K D3N 20-21.99
D3N 0866-693-100A-8D	.866	.902	1.000	1.260	7.1190	8.732	.18500	10.930	22	K D3N 22-23.99
D3N 0906-724-125A-8D	.906	.941	1.250	1.654	7.4430	9.121	.19300	11.476	23	K D3N 22-23.99
D3N 0945-756-125A-8D	.945	.980	1.250	1.654	7.7700	9.517	.20500	11.872	24	K D3N 24-25.99
D3N 0984-787-125A-8D	.984	1.020	1.250	1.654	8.0890	9.918	.20200	12.272	25	K D3N 24-25.99

- Do not mount smaller drilling heads other than the specified range of the drill body

(1) Cutting diameter minimum

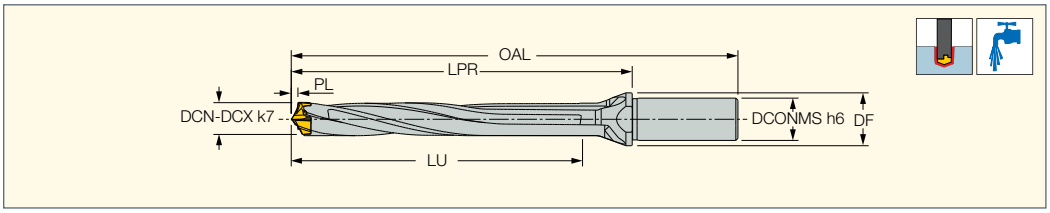
(2) Cutting diameter maximum

(3) Seat size code

LOGIQ 3CHAM THREE FLUTE CHAMDRILL

D3N R-8D

Exchangeable Head 3 Flute Drills with Coolant Holes and Round Shank. Drilling Depth 8xD



Designation	DCN(1)	DCX(2)	DCONMS	DF	LU	LPR	PL	OAL	SSC(3)	
D3N 0472-378-063R-8D	.472	.488	.625	.787	3.8890	4.764	.10700	6.650	12	K D3N 12-13.99
D3N 0492-394-063R-8D	.492	.508	.625	.787	4.0470	4.951	.10700	6.837	12	K D3N 12-13.99
D3N 0512-409-063R-8D	.512	.528	.625	.787	4.2120	5.164	.11500	7.050	13	K D3N 12-13.99
D3N 0531-425-063R-8D	.531	.547	.625	.787	4.3700	5.352	.11500	7.237	13	K D3N 12-13.99
D3N 0551-441-063R-8D	.551	.567	.625	.787	4.5350	5.558	.12200	7.444	14	K D3N 14-15.99
D3N 0571-457-063R-8D	.571	.587	.625	.787	4.6920	5.746	.12200	7.631	14	K D3N 14-15.99
D3N 0591-472-075R-8D	.591	.626	.750	.984	4.8650	5.956	.13700	7.920	15	K D3N 14-15.99
D3N 0630-504-075R-8D	.630	.665	.750	.984	5.1790	6.353	.13500	8.317	16	K D3N 16-17.99
D3N 0669-535-075R-8D	.669	.705	.750	.984	5.4970	6.746	.13900	8.709	17	K D3N 16-17.99
D3N 0709-567-100R-8D	.709	.744	1.000	1.260	5.8270	7.146	.15400	9.345	18	K D3N 18-19.99
D3N 0748-598-100R-8D	.748	.784	1.000	1.260	6.1500	7.542	.16100	9.741	19	K D3N 18-19.99
D3N 0787-630-100R-8D	.787	.823	1.000	1.260	6.4740	7.929	.17000	10.128	20	K D3N 20-21.99
D3N 0827-661-100R-8D	.827	.862	1.000	1.260	6.7980	8.325	.17900	10.524	21	K D3N 20-21.99
D3N 0866-693-100R-8D	.866	.902	1.000	1.260	7.1190	8.732	.18500	10.930	22	K D3N 22-23.99
D3N 0906-724-125R-8D	.906	.941	1.250	1.654	7.4430	9.121	.19300	11.476	23	K D3N 22-23.99
D3N 0945-756-125R-8D	.945	.980	1.250	1.654	7.7700	9.517	.20500	11.872	24	K D3N 24-25.99
D3N 0984-787-125R-8D	.984	1.020	1.250	1.654	8.0890	9.918	.20200	12.272	25	K D3N 24-25.99

- Do not mount smaller drilling heads other than the specified range of the drill body

(1) Cutting diameter minimum

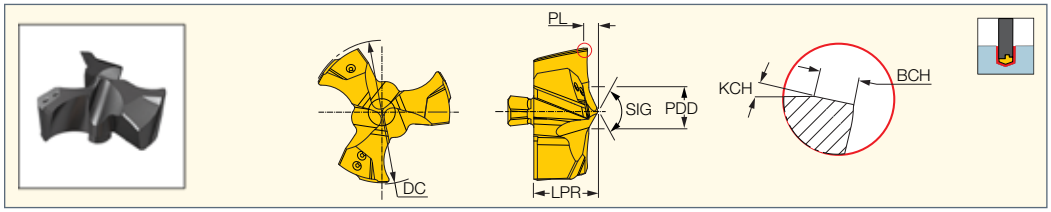
(2) Cutting diameter maximum

(3) Seat size code

LOGIQ 3 CHAM
THREE FLUTE CHAMDRILL

F3P

Exchangeable 3 Flute Flat Drilling Heads for Machining Carbon and Alloy Steel (ISO P) and Cast Iron (ISO K)

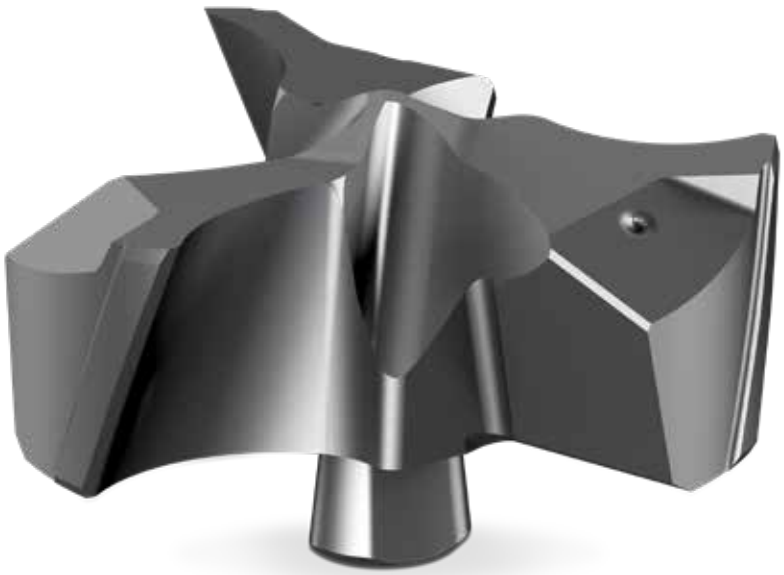


Designation	Dimensions								IC908
	DC	LPR[1]	PL	PDD	SIG	BCH	KCH	SSC[2]	
F3P 0472-IQ	.472	.193	.03110	.117	133	.016	15.00	12	•
F3P 0492-IQ	.492	.193	.03110	.117	133	.016	15.00	12	•
F3P 0512-IQ	.512	.212	.03897	.139	130	.016	15.00	13	•
F3P 0531-IQ	.531	.212	.03897	.139	130	.016	15.00	13	•
F3P 0551-IQ	.551	.253	.04370	.164	124	.016	15.00	14	•
F3P 0571-IQ	.571	.253	.04370	.164	124	.016	15.00	14	•
F3P 0591-IQ	.591	.265	.04685	.150	121	.016	15.00	15	•
F3P 0610-IQ	.610	.265	.04685	.150	121	.016	15.00	15	•
F3P 0630-IQ	.630	.277	.04291	.156	121	.016	15.00	16	•
F3P 0650-IQ	.650	.277	.04291	.156	121	.016	15.00	16	•
F3P 0669-IQ	.669	.303	.04566	.161	121	.016	15.00	17	•
F3P 0689-IQ	.689	.303	.04566	.161	121	.016	15.00	17	•
F3P 0709-IQ	.709	.316	.04842	.231	131	.016	15.00	18	•
F3P 0728-IQ	.728	.316	.04842	.231	131	.016	15.00	18	•
F3P 0748-IQ	.748	.319	.05000	.244	131	.016	15.00	19	•
F3P 0768-IQ	.768	.319	.05000	.244	131	.016	15.00	19	•
F3P 0787-IQ	.787	.338	.05275	.257	132	.016	15.00	20	•
F3P 0807-IQ	.807	.338	.05275	.257	132	.016	15.00	20	•
F3P 0827-IQ	.827	.355	.05551	.272	132	.016	15.00	21	•
F3P 0846-IQ	.846	.355	.05551	.272	132	.016	15.00	21	•
F3P 0866-IQ	.866	.393	.06614	.283	132	.016	15.00	22	•
F3P 0886-IQ	.886	.393	.06614	.283	132	.016	15.00	22	•
F3P 0906-IQ	.906	.400	.06889	.302	132	.016	15.00	23	•
F3P 0925-IQ	.925	.400	.06889	.302	132	.016	15.00	23	•
F3P 0945-IQ	.945	.417	.07165	.307	132	.016	15.00	24	•
F3P 0965-IQ	.965	.417	.07165	.307	132	.016	15.00	24	•
F3P 0984-IQ	.984	.426	.06535	.319	131	.016	15.00	25	•
F3P 1004-IQ	1.004	.426	.06535	.319	131	.016	15.00	25	•

• For nearly flat bottom hole applications

[1] LPR tolerance ±.002"

[2] Seat size code



Flat Heads for Flat Bottom Holes

Extra Long Deep Drilling

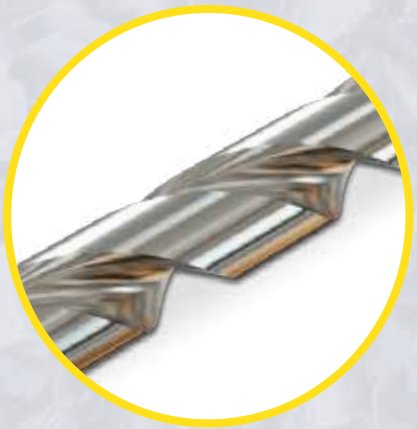
SOLIDDRILL
SOLID CARBIDE

Extra Long 16, 20, 30, 40, 50xD
Solid Drills Designed to Function Under Tough Deep Drilling Conditions.

Spiral Channels with Internal Coolant for **Efficient Lubrication**

Extra Long

Polished Flute Specially Treated Surface for **Good Chip Evacuation**

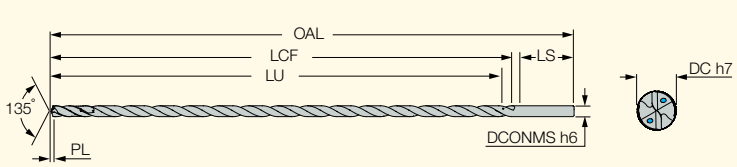


VIDEO

SOLIDDRILL

SCD-SXC16

Solid Carbide Drills with Internal Coolant Channels, Drilling Depth 16xD



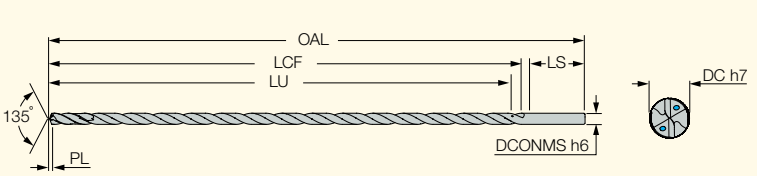
Designation	Dimensions								IC908
	DC	DCONMS	OAL	LU	LCF	LS	PL	ULDR[1]	
SCD0125-0217-0236SXC16	.125	.236	3.940	2.1654	2.36	1.42	.02062	16.0	●
SCD0141-0272-0236SXC16	.141	.236	4.530	2.7165	2.95	1.42	.02320	16.0	●
SCD0156-0272-0236SXC16	.156	.236	4.530	2.7165	2.95	1.42	.02578	16.0	●
SCD0172-0327-0236SXC16	.172	.236	5.120	3.2677	3.54	1.42	.02835	16.0	●
SCD0188-0323-0236SXC16	.188	.236	5.120	3.2283	3.54	1.42	.03093	16.0	●
SCD0203-0394-0236SXC16	.203	.236	5.910	3.9370	4.25	1.42	.03351	16.0	●
SCD0204-0394-0236SXC16	.204	.236	5.910	3.9370	4.25	1.42	.03366	16.0	●
SCD0219-0390-0236SXC16	.219	.236	5.910	3.8976	4.25	1.42	.03609	16.0	●
SCD0234-0390-0236SXC16	.234	.236	5.910	3.8976	4.25	1.42	.03867	16.0	●
SCD0250-0453-0315SXC16	.250	.315	6.500	4.5275	4.92	1.42	.04125	16.0	●
SCD0266-0449-0315SXC16	.266	.315	6.500	4.4882	4.92	1.42	.04382	16.0	●
SCD0281-0508-0315SXC16	.281	.315	7.090	5.0787	5.51	1.42	.04640	16.0	●
SCD0297-0504-0315SXC16	.297	.315	7.090	5.0394	5.51	1.42	.04898	16.0	●
SCD0313-0504-0315SXC16	.313	.315	7.090	5.0394	5.51	1.42	.05156	16.0	●
SCD0328-0579-0394SXC16	.328	.394	8.070	5.7874	6.30	1.58	.05414	16.0	●
SCD0344-0575-0394SXC16	.344	.394	8.070	5.7480	6.30	1.58	.05671	16.0	●
SCD0359-0654-0394SXC16	.359	.394	8.860	6.5354	7.09	1.58	.05929	16.0	●
SCD0375-0650-0394SXC16	.375	.394	8.860	6.4961	7.09	1.58	.06187	16.0	●
SCD0391-0650-0394SXC16	.391	.394	8.860	6.4961	7.09	1.58	.06445	16.0	●
SCD0406-0685-0472SXC16	.406	.472	9.450	6.8504	7.48	1.77	.06703	16.0	●
SCD0422-0681-0472SXC16	.422	.472	9.450	6.8110	7.48	1.77	.06960	16.0	●
SCD0438-0780-0472SXC16	.438	.472	10.430	7.7953	8.46	1.77	.07218	16.0	●
SCD0453-0776-0472SXC16	.453	.472	10.430	7.7559	8.46	1.77	.07476	16.0	●
SCD0469-0776-0472SXC16	.469	.472	10.430	7.7559	8.46	1.77	.07734	16.0	●
SCD0484-0831-0551SXC16	.484	.551	11.020	8.3071	9.05	1.77	.07992	16.0	●
SCD0500-0827-0551SXC16	.500	.551	11.020	8.2677	9.05	1.77	.08250	16.0	●
SCD0531-0882-0551SXC16	.531	.551	11.610	8.8189	9.65	1.77	.08765	16.0	●
SCD0563-0917-0630SXC16	.563	.630	12.010	9.1732	10.04	1.89	.09281	16.0	●
SCD0625-0988-0630SXC16	.625	.630	12.800	9.8819	10.83	1.89	.10312	16.0	●
SCD0750-1185-0787SXC16	.750	.787	14.960	11.8504	12.99	1.97	.12375	16.0	●

[1] Usable length diameter ratio

SOLIDDRILL

SCD-SXC20

Solid Carbide Drills with Internal Coolant Channels, Drilling Depth 20xD



Designation	Dimensions								IC908
	DC	DCONMS	OAL	LU	LCF	LS	PL	ULDR	
SCD0125-0295-0236SXC20	.125	.236	4.720	2.9528	3.15	1.42	.02062	20.0	●
SCD0141-0331-0236SXC20	.141	.236	5.120	3.3071	3.54	1.42	.02320	20.0	●
SCD0156-0331-0236SXC20	.156	.236	5.120	3.3071	3.54	1.42	.02578	20.0	●
SCD0172-0406-0236SXC20	.172	.236	6.300	4.0551	4.33	1.42	.02835	20.0	●
SCD0188-0441-0236SXC20	.188	.236	6.300	4.4094	4.72	1.42	.03093	20.0	●
SCD0203-0520-0236SXC20	.203	.236	7.280	5.1969	5.51	1.42	.03351	20.0	●
SCD0204-0520-0236SXC20	.204	.236	7.280	5.1969	5.51	1.42	.03366	20.0	●
SCD0219-0516-0236SXC20	.219	.236	7.280	5.1575	5.51	1.42	.03609	20.0	●
SCD0234-0516-0236SXC20	.234	.236	7.280	5.1575	5.51	1.42	.03867	20.0	●
SCD0250-0591-0315SXC20	.250	.315	8.270	5.9055	6.30	1.42	.04125	20.0	●
SCD0266-0587-0315SXC20	.266	.315	8.270	5.8661	6.30	1.42	.04382	20.0	●
SCD0281-0665-0315SXC20	.281	.315	9.060	6.6535	7.09	1.42	.04640	20.0	●
SCD0297-0661-0315SXC20	.297	.315	9.060	6.6142	7.09	1.42	.04898	20.0	●
SCD0313-0661-0315SXC20	.313	.315	9.060	6.6142	7.09	1.42	.05156	20.0	●
SCD0328-0717-0394SXC20	.328	.394	10.240	7.1654	7.68	1.58	.05414	20.0	●
SCD0344-0850-0394SXC20	.344	.394	11.420	8.5039	9.05	1.58	.05671	20.0	●
SCD0359-0850-0394SXC20	.359	.394	11.420	8.5039	9.05	1.58	.05929	20.0	●
SCD0375-0846-0394SXC20	.375	.394	11.420	8.4646	9.05	1.58	.06187	20.0	●
SCD0391-0846-0394SXC20	.391	.394	11.420	8.4646	9.05	1.58	.06445	20.0	●
SCD0406-0992-0472SXC20	.406	.472	12.400	9.9213	10.55	1.77	.06703	20.0	●
SCD0422-0988-0472SXC20	.422	.472	12.400	9.8819	10.55	1.77	.06960	20.0	●
SCD0438-0988-0472SXC20	.438	.472	12.400	9.8819	10.55	1.77	.07218	20.0	●
SCD0453-0984-0472SXC20	.453	.472	12.400	9.8425	10.55	1.77	.07476	20.0	●
SCD0469-0984-0472SXC20	.469	.472	12.400	9.8425	10.55	1.77	.07734	20.0	●
SCD0484-1028-0551SXC20	.484	.551	12.800	10.2756	11.02	1.77	.07992	20.0	●
SCD0500-1024-0551SXC20	.500	.551	12.800	10.2362	11.02	1.77	.08250	20.0	●
SCD0531-1118-0551SXC20	.531	.551	13.980	11.1811	12.01	1.77	.08765	20.0	●
SCD0563-1173-0630SXC20	.563	.630	14.570	11.7323	12.60	1.89	.09281	20.0	●
SCD0625-1283-0630SXC20	.625	.630	15.750	12.8346	13.78	1.89	.10312	20.0	●

16xD, 20xD

ISO	Material		Condition	Tensile Strength [ksi]	Hardness HB	Material No.	Cutting Speed V_c (SFM)	Cutting Diameter Feed (IPR) Ø.125"-.197"	Ø.200"-.315"	Ø.319"-.391"	Ø.393"-.625"	Ø.630"-.787"
P	Non-alloy steel and cast steel, free cutting steel	< 0.25 %C	Annealed	61	125	1	230-300	.0035-.0045	.0047-.0066	.0055-.0086	.0063-.011	.007-.013
		>= 0.25 %C	Annealed	94	190	2						
		< 0.55 %C	Quenched and tempered	123	250	3						
		>= 0.55 %C	Annealed	109	220	4						
		>= 0.55 %C	Quenched and tempered	145	300	5						
	Low alloy steel and cast steel (less than 5% of alloying elements)		Annealed	87	200	6						
			Quenched and tempered	135	275	7						
				145	300	8						
				174	350	9						
	High alloyed steel, cast steel, and tool steel		Annealed	99	200	10	230-280					
			Quenched and tempered	160	325	11						
	Stainless steel and cast steel		Ferritic/martensitic.	99	200	12	190-230	.0023-.0035	.0031-.0055	.0039-.007	.0047-.0086	.0051-.0102
			Martensitic	119	240	13						
M	Stainless steel and cast steel		Austenitic	87	180	14	180-220	.00157-.00315	.00236-.00472	.0031-.0063	.0047-.0078	.0055-.0094
K	Grey cast iron (GG)		Ferritic/pearlitic		180	15	260-330	.0055-.0087	.0063-.0095	.007-.011	.0078-.0137	.0098-.0177
			Pearlitic		260	16						
	Cast iron nodular (GGG)		Ferritic		160	17						
			Pearlitic		250	18						
	Malleable cast iron		Ferritic		130	19						
			Pearlitic		230	20						
S	High temp. alloys	Fe based	Annealed		200	31	110-150	.0015-.00314	.0023-.0047	.0031-.0063	.0047-.0078	.0055-.0094
			Cured		280	32						
		Ni or Co based	Annealed		250	33	100-130	.0015-.00314	.0023-.0047	.0031-.0063	.0047-.0078	.0055-.0094
			Cured		350	34						
			Cast		320	35						
	Titanium Ti alloys		Pure	58	110	36	110-150	.0015-.00314	.0023-.0047	.0031-.0063	.0047-.0078	.0055-.0094
			Alpha+beta alloys cured	152	310	37						

TIPS & TRICKS for DEEP HOLE DRILLING

Using a G73 peck cycle helps Chip evacuation in deep hole drilling & materials which have a poor chip formation

16xD - 50xD must utilize a Pilot hole drill

40xD - 50xD can utilize a 20xD intermediary drill if deemed necessary

TIR & tool alignment with material are the most important factors in deep hole Drilling

Use high pressure coolant when deep hole drilling

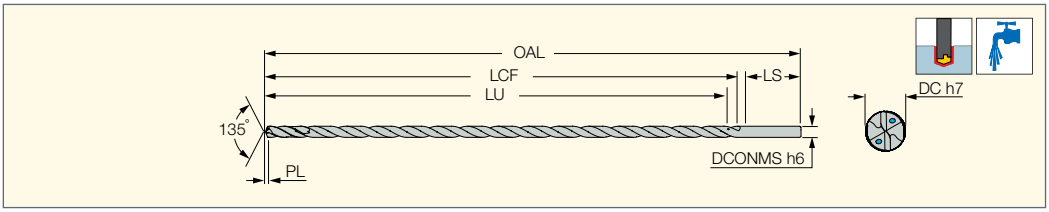
Slow the feedrate to 50% when breaking through the material
In through holes, the tool exit should not exceed .078"-.118".

Spiral Channels with Internal Coolant for Efficient Lubrication

SOLIDDRILL

SCD-SXC30

Solid Carbide Drills with Internal Coolant Channels, Drilling Depth 30xD



Designation	Dimensions DC	DCONMS	OAL	LU	LCF	LS	PL	ULDR(1)	IC908
SCD0125-0382-0236SXC30	.125	.236	5.906	3.8190	4.13	1.58	.02100	30.0	●
SCD0141-0500-0236SXC30	.141	.236	7.283	5.0000	5.32	1.77	.02300	30.0	●
SCD0156-0500-0236SXC30	.156	.236	7.283	5.0000	5.32	1.77	.02600	30.0	●
SCD0172-0618-0236SXC30	.172	.236	8.465	6.1810	6.50	1.77	.02800	30.0	●
SCD0188-0618-0236SXC30	.188	.236	8.465	6.1810	6.50	1.77	.03100	30.0	●
SCD0203-0677-0236SXC30	.203	.236	9.055	6.7720	7.09	1.77	.03400	30.0	●
SCD0204-0677-0236SXC30	.204	.236	9.055	6.7720	7.09	1.77	.03400	30.0	●
SCD0219-0677-0236SXC30	.219	.236	9.055	6.7720	7.09	1.77	.03600	30.0	●
SCD0234-0677-0236SXC30	.234	.236	9.055	6.7720	7.09	1.77	.03900	30.0	●
SCD0250-0815-0315SXC30	.250	.315	11.024	8.1500	8.47	2.36	.04100	30.0	●
SCD0266-0874-0315SXC30	.266	.315	11.024	8.7400	9.06	1.77	.04400	30.0	●
SCD0281-0874-0315SXC30	.281	.315	11.024	8.7400	9.06	1.77	.04600	30.0	●
SCD0297-1012-0315SXC30	.297	.315	12.402	10.1180	10.43	1.77	.04900	30.0	●
SCD0313-1012-0315SXC30	.313	.315	12.402	10.1180	10.43	1.77	.05200	30.0	●
SCD0328-1130-0394SXC30	.328	.394	13.780	11.2990	11.61	1.97	.05400	30.0	●
SCD0344-1268-0394SXC30	.344	.394	14.961	12.6770	12.99	1.77	.05700	30.0	●
SCD0359-1268-0394SXC30	.359	.394	14.961	12.6770	12.99	1.77	.05900	30.0	●
SCD0375-1268-0394SXC30	.375	.394	14.961	12.6770	12.99	1.77	.06200	30.0	●
SCD0391-1268-0394SXC30	.391	.394	14.961	12.6770	12.99	1.77	.06400	30.0	●

(1) Usable length diameter ratio

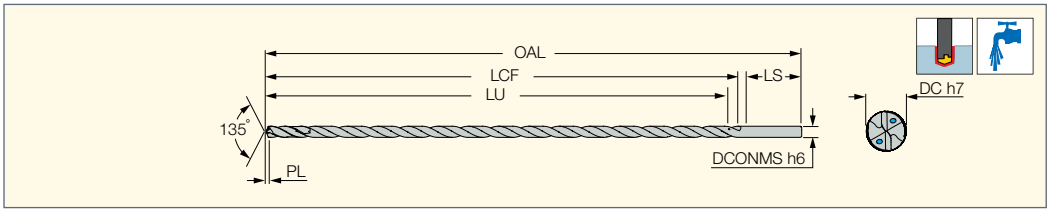
Recommended Machining Conditions for SCD-SXC30 Solid Carbide Drills

ISO	Material		Condition	Tensile Strength ksi	Hardness HB	Material No.	Cutting Speed V_c [SFM]	Cutting Diameter F [IPR] .125-.196	.196-.314	.314-.390
P	Non-alloy steel and cast steel, free cutting steel	< 0.25 %C	Annealed	61	125	1	213-230	.003-.004	.004-.006	.007-.008
		>= 0.25 %C	Annealed	94	190	2				
		< 0.55 %C	Quenched and tempered	123	250	3				
		>= 0.55 %C	Annealed	109	220	4				
		>= 0.55 %C	Quenched and tempered	145	300	5				
	Low alloy steel and cast steel (less than 5% of alloying elements)		Annealed	87	200	6				
			Quenched and tempered	135	275	7				
				145	300	8				
				174	350	9				
	High alloyed steel, cast steel, and tool steel		Annealed	99	200	10	196-213			
			Quenched and tempered	160	325	11				
	Stainless steel and cast steel		Ferritic/martensitic.	99	200	12	147-164	.002-.003	.004-.005	.005-.007
			Martensitic	119	240	13				
M	Stainless steel and cast steel		Austenitic	87	180	14	131-147	.002-.003	.004-.005	.005-.007
K	Grey cast iron (GG)		Ferritic/pearlitic		180	15	246-278	.007-.008	.008-.011	.001-.015
			Pearlitic		260	16				
	Cast iron nodular (GGG)		Ferritic		160	17				
			Pearlitic		250	18				
	Malleable cast iron		Ferritic		130	19				
			Pearlitic		230	20				
S	High temp. alloys	Fe based	Annealed		200	31	147-164	.002-.003	.004-.005	.005-.007
			Cured		280	32				
		Ni or Co based	Annealed		250	33	131-147	.002-.003	.003-.004	.004-.005
			Cured		350	34				
			Cast		320	35				
	Titanium Ti alloys		Pure	58	110	36	147-164	.002-.003	.003-.005	.005-.006
			Alpha+beta alloys cured	152	310	37				

SOLIDDRILL

SCD-SXC40

Solid Carbide Drills with Internal Coolant Channels, Drilling Depth 40xD



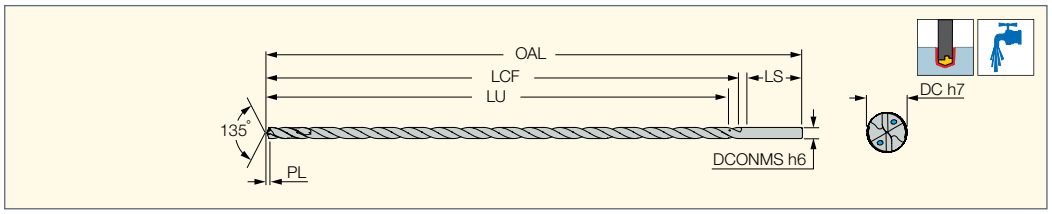
Designation	Dimensions								IC908
	DC	DCONMS	OAL	LU	LCF	LS	PL	ULDR[1]	
SCD0125-0520-0236SXC40	.125	.236	7.480	5.1970	5.51	1.77	.02100	40.0	●
SCD0141-0677-0236SXC40	.141	.236	9.055	6.7720	7.09	1.77	.02300	40.0	●
SCD0156-0677-0236SXC40	.156	.236	9.055	6.7720	7.09	1.77	.02600	40.0	●
SCD0172-0835-0236SXC40	.172	.236	10.630	8.3460	8.66	1.77	.02800	40.0	●
SCD0188-0835-0236SXC40	.188	.236	10.630	8.3460	8.66	1.77	.03100	40.0	●
SCD0203-0913-0236SXC40	.203	.236	11.417	9.1340	9.45	1.77	.03400	40.0	●
SCD0204-0913-0236SXC40	.204	.236	11.417	9.1340	9.45	1.77	.03400	40.0	●
SCD0219-0913-0236SXC40	.219	.236	11.417	9.1340	9.45	1.77	.03600	40.0	●
SCD0234-0913-0236SXC40	.234	.236	11.417	9.1340	9.45	1.77	.03900	40.0	●
SCD0250-1110-0315SXC40	.250	.315	13.386	11.1020	11.42	1.77	.04100	40.0	●
SCD0266-1228-0315SXC40	.266	.315	14.567	12.2830	12.60	1.77	.04400	40.0	●
SCD0281-1228-0315SXC40	.281	.315	14.567	12.2830	12.60	1.77	.04600	40.0	●
SCD0297-1347-0315SXC40	.297	.315	15.748	13.4650	13.78	1.77	.04900	40.0	●
SCD0313-1347-0315SXC40	.313	.315	15.748	13.4650	13.78	1.77	.05200	40.0	●

(1) Usable length diameter ratio

SOLIDDRILL

SCD-SXC50

Solid Carbide Drills with Internal Coolant Channels, Drilling Depth 50xD



Designation	Dimensions								IC908
	DC	DCONMS	OAL	LU	LCF	LS	PL	ULDR[1]	
SCD0172-1051-0236SXC50	.172	.236	12.598	10.5120	10.83	1.58	.02800	50.0	●
SCD0188-1051-0236SXC50	.188	.236	12.598	10.5120	10.83	1.58	.03100	50.0	●
SCD0203-1189-0236SXC50	.203	.236	14.173	11.8900	12.21	1.77	.03400	50.0	●
SCD0204-1189-0236SXC50	.204	.236	14.173	11.8900	12.21	1.77	.03400	50.0	●
SCD0219-1189-0236SXC50	.219	.236	14.173	11.8900	12.21	1.77	.03600	50.0	●
SCD0234-1189-0236SXC50	.234	.236	14.173	11.8900	12.21	1.77	.03900	50.0	●
SCD0250-1307-0315SXC50	.250	.315	15.157	13.0710	13.39	1.58	.04100	50.0	●

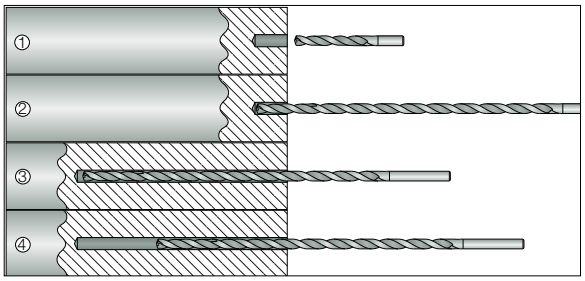
(1) Usable length diameter ratio

Recommended Machining Conditions for SCD-SXC40 & SCD-SXC50 Solid Carbide Drills

ISO	Material		Condition	Tensile Strength ksi	Hardness HB	Material No.	Cutting Speed V_c [SFM]	Cutting Diameter F [IPR]				
								.125-.157	.161-.196	.2-.236	.24-.275	.28-.314
P	Non-alloy steel and cast steel, free cutting steel	< 0.25 %C	Annealed	61	125	1	180-213	.0017-.0018	.0022-.0024	.0026-.0030	.0032-.0036	.0036-.0046
		>= 0.25 %C	Annealed	94	190	2						
		< 0.55 %C	Quenched and tempered	123	250	3						
		>= 0.55 %C	Annealed	109	220	4						
		>= 0.55 %C	Quenched and tempered	145	300	5						
	Low alloy steel and cast steel (less than 5% of alloying elements)		Annealed	87	200	6	147-180	.009-.0016	.0012-.0022	.0016-.0026	.0020-.0032	.0025-.0040
			Quenched and tempered	135	275	7						
				145	300	8						
				174	350	9						
	High alloyed steel, cast steel,and tool steel		Annealed	99	200	10	114-147	.0007-.0009	.0011-.0013	.0015-.0017	.0019-.0021	.0023-.0027
			Quenched and tempered	160	325	11						
	Stainless steel and cast steel		Ferritic/ martensitic.	99	200	12	98-14	.0007-.0009	.0011-.0013	.0015-.0017	.0020-.0021	.0023-.0027
			Martensitic	119	240	13						
M	Stainless steel and cast steel		Austenitic	87	180	14	82-98	.0007-.0009	.0011-.0013	.0015-.0017	.0020-.0021	.0023-.0027
K	Grey cast iron (GG)		Ferritic/pearlitic		180	15	169-229	.0013-.0027	.0019-.0038	.0023-.0047	.0029-.0059	.0033-.0077
			Pearlitic		260	16						
	Cast iron nodular (GGG)		Ferritic		160	17	180-196					
			Pearlitic		250	18						
	Malleable cast iron		Ferritic		130	19	164-180					
			Pearlitic		230	20						
S	High temp. alloys	Fe based	Annealed		200	31	98-114	.0007-.0009	.0011-.0013	.0015-.0017	.0020-.0021	.0024-.0027
			Cured		280	32						
		Ni or Co based	Annealed		250	33	82-98	.0006-.0007	.0010-.0011	.0014-.0015	.0018-.0019	.0023-.0026
			Cured		350	34						
			Cast		320	35						
	Titanium Ti alloys		Pure	58	110	36	98-114	.0007-.0008	.0011-.0012	.0014-.0016	.0018-.0020	.0024-.0027
			Alpha+beta alloys cured	152	310	37						

Recommended Drilling Procedure for Deep Hole Drilling

1 Drill a pilot hole 1-2xD deep with a short drill. The pilot drill should be .001″-.002″ larger than the long drill and its point angle should also be larger (over 135°).
2 Enter the pre-hole using low feed and rotate at low speed (50-100 RPM) until it engages the material.
3 Activate the coolant system and increase rotation speed to the recommended cutting parameter, maintain for 2-3 seconds, then continue at recommended drilling feed. No pecking is required.
4 After having reached the required depth, reduce speed to 50-100 RPM before retracting from the hole.



- 40xD & 50xD must utilize a 20xD intermediary drill along with pilot drill.
- In through holes, the tool exit should not exceed .078"- 118"

NEOLOGIQ MILL

MACHINING INTELLIGENTLY

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S90° LINE

LOGIQ4FEED
HIGH FEED MILLING

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Unique Exact 90° Shouldering

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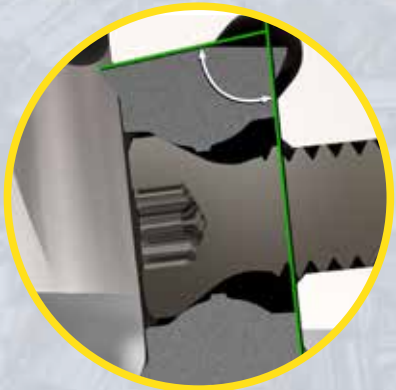
A New Milling Line for Square Shoulder and Face Milling.
A Unique Exact 90° Profile with 8 Cutting Edges in Combination with a **Dovetail Clamping Method** Enables Higher Cutting Conditions and Assures Better Productivity.

Unique **Exact 90°** Profile with **8 Cutting** Edges

High Productivity and Cost Effectiveness



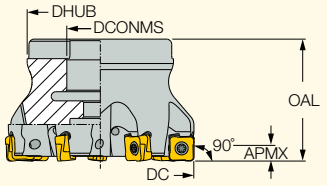
Dovetail Insert **Pocket** Locks the Insert Firmly in the Tool

VIDEO

NEODO S90° LINE

S890 FSZ-R08

Face Mills Carrying Square Double-Sided Inserts with 8 Cutting Edges



Designation	DC	APMX	OAL	CICT[1]	DHUB	DCONMS	Arbor	MIID[2]	Lbs
S890 FSZ D1.5-05-0.75-R08	1.500	.2000	1.500	5	1.440	.750	A	S890 SZMU 0804...	.46
S890 FSZ D1.5-06-0.75-R08	1.500	.2000	1.500	6	1.440	.750	A	S890 SZMU 0804...	.53
S890 FSZ D2.0-06-0.75-R08	2.000	.2000	1.500	6	1.850	.750	A	S890 SZMU 0804...	.86
S890 FSZ D2.0-08-0.75-R08	2.000	.2000	1.500	8	1.850	.750	A	S890 SZMU 0804...	.86
S890 FSZ D2.5-07-1.00-R08	2.500	.2000	1.750	7	2.250	1.000	A	S890 SZMU 0804...	1.76
S890 FSZ D2.5-10-1.00-R08	2.500	.2000	1.750	10	2.250	1.000	A	S890 SZMU 0804...	2.13
S890 FSZ D3.0-08-1.00-R08	3.000	.2000	1.750	8	2.250	1.000	B	S890 SZMU 0804...	1.74
S890 FSZ D3.0-12-1.00-R08	3.000	.2000	1.750	12	2.250	1.000	B	S890 SZMU 0804...	1.75
S890 FSZ D4.0-10-1.50-R08	4.000	.2000	2.000	10	3.230	1.500	B	S890 SZMU 0804...	3.44
S890 FSZ D4.0-14-1.50-R08	4.000	.2000	2.000	14	3.230	1.500	B	S890 SZMU 0804...	3.46
S890 FSZ D5.0-12-1.50-R08	5.000	.2000	2.000	12	3.800	1.500	B	S890 SZMU 0804...	4.63
S890 FSZ D5.0-18-1.50-R08	5.000	.2000	2.000	18	3.800	1.500	B	S890 SZMU 0804...	5.27

(1) Number of inserts

(2) Master insert identification

Spare Parts

Designation			
S890 FSZ D1.5-05-0.75-R08	SR M3X0.5-L7.4 IP9[a]	IP-9/151[b]	SR UNF 3/8X1 B18.3
S890 FSZ D1.5-06-0.75-R08	SR M3X0.5-L7.4 IP9[a]	IP-9/151[b]	SR UNF 3/8X1 B18.3
S890 FSZ D2.0-06-0.75-R08	SR M3X0.5-L7.4 IP9[a]	IP-9/151[b]	SR UNF 3/8X1 B18.3
S890 FSZ D2.0-08-0.75-R08	SR M3X0.5-L7.4 IP9[a]	IP-9/151[b]	SR UNF 3/8X1 B18.3
S890 FSZ D2.5-07-1.00-R08	SR M3X0.5-L7.4 IP9[a]	IP-9/151[b]	SR UNF 1/2X20X1 B18.3
S890 FSZ D2.5-10-1.00-R08	SR M3X0.5-L7.4 IP9[a]	IP-9/151[b]	SR UNF 1/2X20X1 B18.3
S890 FSZ D3.0-08-1.00-R08	SR M3X0.5-L7.4 IP9[a]	IP-9/151[b]	
S890 FSZ D3.0-12-1.00-R08	SR M3X0.5-L7.4 IP9[a]	IP-9/151[b]	
S890 FSZ D4.0-10-1.50-R08	SR M3X0.5-L7.4 IP9[a]	IP-9/151[b]	
S890 FSZ D4.0-14-1.50-R08	SR M3X0.5-L7.4 IP9[a]	IP-9/151[b]	
S890 FSZ D5.0-12-1.50-R08	SR M3X0.5-L7.4 IP9[a]	IP-9/151[b]	
S890 FSZ D5.0-18-1.50-R08	SR M3X0.5-L7.4 IP9[a]	IP-9/151[b]	

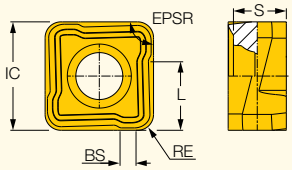
(a) Recommended tightening torque: 17.7 lbf*in

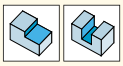
(b) For limiting torque, use optional 7007382 BLD 4 IP09-17.7LBF.IN blade & 7007320 HSD 4-17.7LBF.IN handle.

NEODO
S90° LINE

S890 SZMU-0804PN

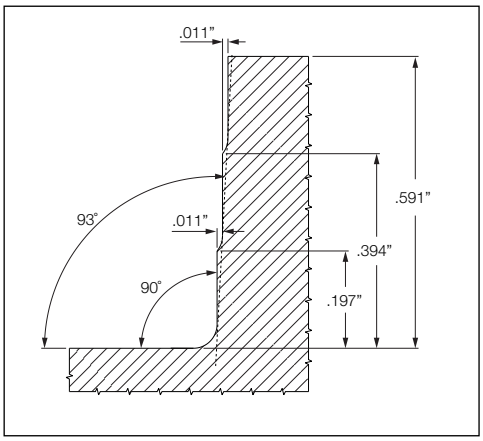
Double-Sided Square Inserts
with 8 Cutting Edges





Designation	Dimensions							Tough ↔ Hard						Recommended Machining Data
	IC	S	L	APMX	BS	RE	EPSR	IC845	IC830	IC5400	IC808	IC810	IC5100	f_z (inch/t)
S890 SZMU 080408PNTR	.323	.157	.205	.1969	.063	.0315	88.4					●		.0047-.0098
S890 SZMU 080412PNTR	.323	.157	.205	.1969	.047	.0472	88.4					●	●	.0047-.0098
S890 SZMU 080408PNRMM	.323	.157	.205	.1969	.063	.0315	88.4		●		●			.0031-.0098
S890 SZMU 080412PNRMM	.323	.157	.205	.1969	.047	.0472	88.4	●	●	●	●			.0031-.0098

When stepdown milling is performed by use of passes, the depth of cut per pass should not exceed the depth of cut as recommended in the ISCAR catalog.



Generated profile for a depth of cut in stepdown milling


S890 FSZ D050-06-22-R08

High Feed Milling

LOGIQ4FEED
HIGH FEED MILLING

Unique Twisted High Positive **4 Cutting Edged** Insert. A Range of Tools from .5" Endmills up to 5.0" Facemills. This New Line of Tools Enables Machining at Very High Feeds for **High Productivity.**

Size 08 mm
Dia. Tool Range: 2.0-5.0"
for Facemills

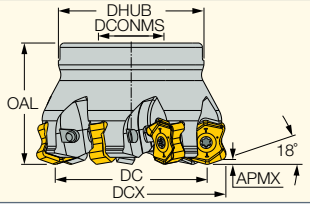
Size 04 mm
Dia. Tool Range:
.5-1.25" Endmills
1.5-2.0" Facemills

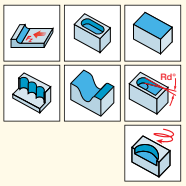
VIDEO

LOGIQ4FEED HIGH FEED MILLING

FFX4 FD-08

Face Mills Carrying "Bone Shaped" Inserts with 4 Cutting Edges for Fast Feed Milling





Designation	DCX(1)	DC	CICT(2)	APMX	AE	OAL	DHUB	DCONMS	Arbor	Rd°	MDN(3)	MDX(4)	Rg(5)	MIID(6)	Lbs
FFX4 FD2.00-4-0.75-08	2.000	1.386	4	.0780	.307	1.750	1.850	.750	A	3.2	3.386	3.961	.157	FFX4 XNMU 080620T	1.32
FFX4 FD2.50-5-1.00-08	2.500	1.886	5	.0780	.307	1.750	2.252	1.000	A	2.2	4.386	4.961	.157	FFX4 XNMU 080620T	1.50
FFX4 FD3.00-6-1.00-08	3.000	2.386	6	.0780	.307	2.000	2.252	1.000	A	1.7	5.386	5.961	.157	FFX4 XNMU 080620T	1.98
FFX4 FD4.00-8-1.50-08	4.000	3.386	8	.0780	.307	2.000	3.228	1.500	B	1.0	7.386	7.961	.157	FFX4 XNMU 080620T	2.87
FFX4 FD5.00-10-1.50-08	5.000	4.386	10	.0780	.307	2.000	3.780	1.500	B	.9	9.386	9.961	.157	FFX4 XNMU 080620T	5.51

- To generate a straight surface without cusps, the width of cut must not exceed DC

(1) Cutting diameter maximum
(2) Number of inserts
(3) Machinable diameter minimum for interpolation
(4) Machinable diameter maximum for interpolation
(5) Radius for programming
(6) Master insert identification

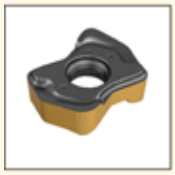
Spare Parts

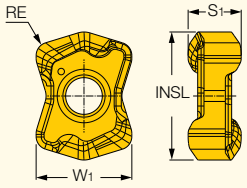
Designation				
FFX4 FD2.00-4-0.75-08	SR M5-14 IP20	SR UNF 3/8X1 B18.3	SW6-T	BLD IP20/S7
FFX4 FD2.50-5-1.00-08	SR M5-14 IP20	SR UNF 1/2X20X1 B18.3	SW6-T	BLD IP20/S7
FFX4 FD3.00-6-1.00-08	SR M5-14 IP20	SR UNF 1/2X1¼ B18.3	SW6-T	BLD IP20/S7
FFX4 FD4.00-8-1.50-08	SR M5-14 IP20		SW6-T	BLD IP20/S7
FFX4 FD5.00-10-1.50-08	SR M5-14 IP20		SW6-T	BLD IP20/S7

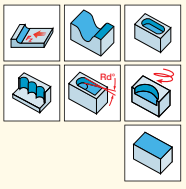
LOGIQ4FEED HIGH FEED MILLING

FFX4 XNMU-08

"Bone Shaped" Inserts with 4 Cutting Edges for Fast Feed Milling







Designation	Dimensions				Tough ↔ Hard			
	INSL	S1	RE	W1	IC882	IC830	IC808	IC810
FFX4 XNMU 080620HP	.705	.307	.0787	.614	●	●	●	
FFX4 XNMU 080620T	.705	.307	.0787	.614		●	●	●

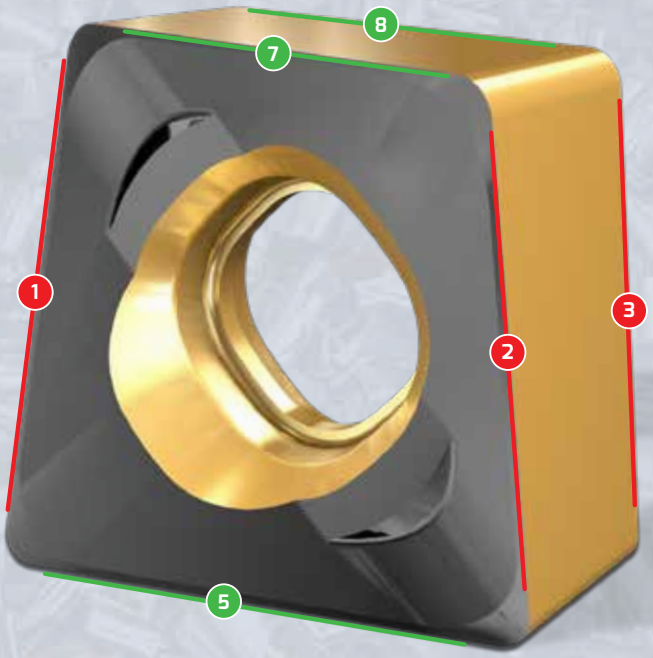
- For side plunging, the initial cutting feed is .004 inch/t
- T-for steel, ferritic and martensitic stainless steel, cast iron and hardened steel
- HP-for austenitic stainless steel and high temperature alloys

Efficient Slot Milling

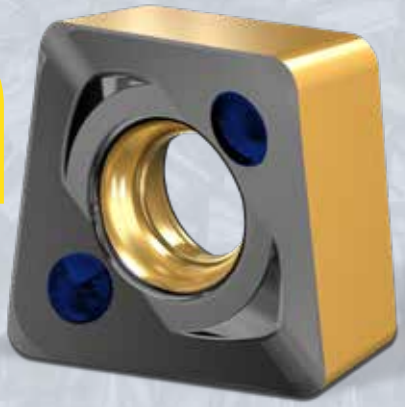
HELISLOT
HELICAL SLOTTING LINE

Unique Twisted High Positive Double-Sided Insert with 4 Right - and 4 Left Hand Cutting Edges. Slotting Width Range of .39-1.00”

Helical Edge for Easy and Soft Cut



NEW



XNMU 09
Slot Width Range:
.39-.55"
Dia. Tool Range: 1.25-6"

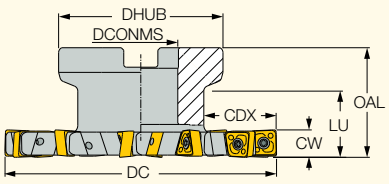
XNMU 13
Slot Width Range:
.56-1.00"
Dia. Tool Range: 1.46-8"

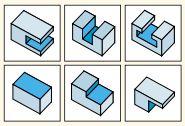
VIDEO

HELISLOT

FDN-XN09

Full Slot Flange Type Slotting Cutters Carrying XNMU 0904 Square Inserts with 4 Right- and 4 Left-Hand Cutting Edges





Designation	DC	CW	CICT(1)	ZEFP	CDX	DHUB	DCONMS	LU	OAL	Arbor	Lbs
FDN D3.0-0.39-06-XN09	3.000	.390	8	8	.875	1.850	.750	1.0600	1.575	A	.96
FDN D3.0-0.50-06-XN09	3.000	.500	8	4	.875	1.850	.750	1.0600	1.575	A	1.28
FDN D4.0-0.39-08-XN09	4.000	.390	12	12	1.060	2.250	1.000	1.1800	1.750	B	1.49
FDN D4.0-0.50-08-XN09	4.000	.500	12	6	1.060	2.250	1.000	1.1800	1.750	B	1.81
FDN D5.0-0.39-10-XN09	5.000	.390	14	14	1.375	2.560	1.250	1.5000	2.000	B	1.98
FDN D5.0-0.50-10-XN09	5.000	.500	14	7	1.375	2.560	1.250	1.5000	2.000	B	2.71
FDN D6.0-0.39-12-XN09	6.000	.390	16	16	1.650	3.150	1.500	1.9000	2.500	B	3.92
FDN D6.0-0.50-12-XN09	6.000	.500	16	8	1.650	3.150	1.500	1.9000	2.500	B	3.97

(1) Number of inserts

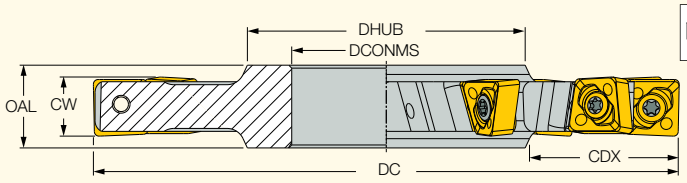
Spare Parts

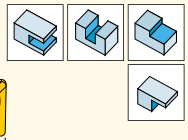
Designation		
FDN-XN09	SR 10508600	T-9/51

HELISLOT

SDN-XN09

Full Slot Disk Type Slotting Cutters Carrying XNMU 0904 Square Inserts with 4 Right- and 4 Left-Hand Cutting Edges





Designation	DC	CW	CICT(1)	ZEFP	CDX	DHUB	DCONMS	OAL	Lbs
SDN D3.0-0.39-08-XN09	3.000	.390	8	8	.700	1.500	1.000	.500	1.21
SDN D4.0-0.39-08-XN09	4.000	.390	12	12	1.000	1.750	1.000	.500	2.21
SDN D5.0-0.50-10-XN09	5.000	.500	14	7	1.400	2.000	1.250	.625	3.86
SDN D6.0-0.50-12-XN09	6.000	.500	16	8	1.750	2.250	1.500	.687	5.73

(1) Number of inserts

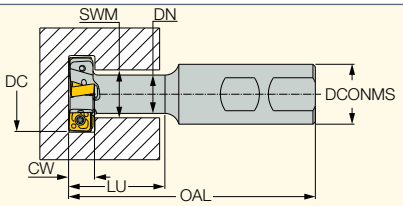
Spare Parts

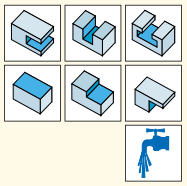
Designation		
SDN-XN09	SR 10508600	T-9/51

HELISLOT

ETS-XN09

T-SLOT Endmills Carrying XNMU 0904 Square Inserts with 4 Right- and 4 Left-Hand Cutting Edges





Designation	DC	CICT[1]	ZEFP	DN	SWM	CW	LU	OAL	DCONMS	Shank	Lbs
ETS D1.25-0.39-W0.62-XN09	1.250	4	2	.590	.688	.390	1.2500	3.250	.625	W	.28
ETS D1.25-0.48-W0.75-XN09	1.250	4	2	.630	.688	.476	1.5000	3.750	.750	W	.88

[1] Number of inserts

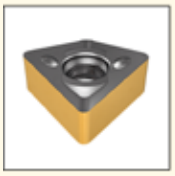
Spare Parts

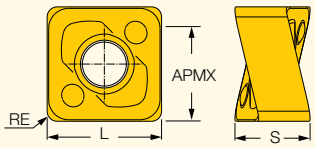
Designation		
ETS-XN09	SR 10508600	T-9/51

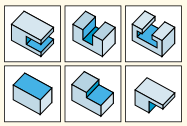
HELISLOT

XNMU 0904PN

Square Inserts with 4 Right- and 4 Left-Hand Cutting Edges







Designation	Dimensions APMX	L	S	RE	Tough ↔ Hard IC830	IC5400	IC808	Recommended Machining Data f_z (inch/t)
XNMU 090408-PNTN	.3228	.358	.234	.0315	●	●	●	.0020-.0059

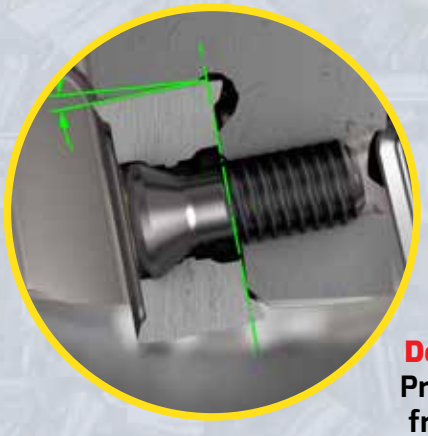
High Feed & Moderate Milling

NEOFEED
HIGH FEED LINE

Unique Insert with
8 Cutting Edges Performs at
Fast Feed and Moderate Rates
for Different Milling Applications.

FFQ8 SZMU 12
Dia. Range for Facemill 2.0-4.0"

Suits All Your Face Milling Needs



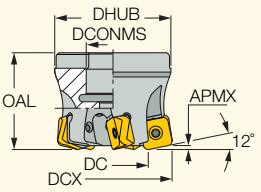
Dovetail Clamping
Protects the Insert from Disengaging

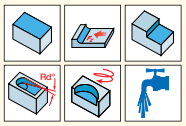
VIDEO

NEOFEED
HIGH FEED LINE

FFQ8-12

Fast Feed Face Mills Carrying Double-Sided Inserts with 8 Cutting Edges





Designation	DC	DCX(1)	APMX	CICT(2)	OAL	DHUB	DCONMS	Arbor	RMPX°(3)	MDN(4)	MDX(5)	MIID(6)	Lbs
FFQ8 D2.00-05-0.75-12	1.236	2.000	.0600	5	1.625	1.850	.750	A	.3	3.236	3.960	FFQ8 SZMU 120520	1.61
FFQ8 D2.50-06-1.00-12	1.736	2.500	.0600	6	1.750	2.250	1.000	A	.2	4.236	4.960	FFQ8 SZMU 120520	1.94
FFQ8 D3.00-07-1.00-12	2.236	3.000	.0600	7	1.750	2.250	1.000	A	.2	5.236	5.960	FFQ8 SZMU 120520	3.64
FFQ8 D4.00-08-1.50-12	3.236	4.000	.0600	8	2.000	3.230	1.500	B	.1	7.236	7.960	FFQ8 SZMU 120520	6.17

• Radius for programming .142" • To generate a straight surface without cusps, the width of cut most not exceed DC • For slot milling or machining with high tool overhang, the maximum depth of cut should be reduced by 30%

(1) Cutting diameter maximum
(2) Number of inserts
(3) Maximum ramping angle
(4) Machinable diameter minimum for interpolation
(5) Machinable diameter maximum for interpolation
(6) Master insert identification

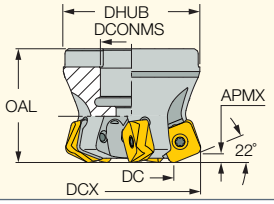
Spare Parts

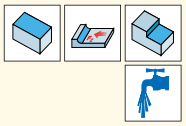
Designation				
FFQ8 D2.00-05-0.75-12	SR M4X0.7-L11.5 IP15	BLD IP15/S7	SW6-T-SH	SR UNF 3/8X1 B18.3
FFQ8 D2.50-06-1.00-12	SR M4X0.7-L11.5 IP15	BLD IP15/S7	SW6-T-SH	SR UNF 1/2X20X1 B18.3
FFQ8 D3.00-07-1.00-12	SR M4X0.7-L11.5 IP15	BLD IP15/S7	SW6-T-SH	SR UNF 1/2X20X1 B18.3
FFQ8 D4.00-08-1.50-12	SR M4X0.7-L11.5 IP15	BLD IP15/M7	SW6-T-SH	

NEOFEED
HIGH FEED LINE

MFQ8-12

Moderate Feed Face Mills Carrying Double-Sided Inserts with 8 Cutting Edges





Designation	DC	DCX(1)	APMX	CICT(2)	OAL	DHUB	DCONMS	Arbor	MIID(3)	Lbs
MFQ8 D2.00-05-0.75-12	1.276	2.000	.1180	5	1.500	1.850	.750	A	FFQ8 SZMU 120520	1.48
MFQ8 D2.50-06-1.00-12	1.776	2.500	.1180	6	1.750	2.250	1.000	A	FFQ8 SZMU 120520	2.43
MFQ8 D3.00-07-1.00-12	2.276	3.000	.1180	7	1.750	2.250	1.000	A	FFQ8 SZMU 120520	3.38
MFQ8 D4.00-08-1.50-12	3.276	4.000	.1180	8	2.000	3.230	1.500	B	FFQ8 SZMU 120520	4.41

• Radius for programming .197" • To generate a straight surface without cusps, the width of cut most not exceed DC • For slot milling or machining with high tool overhang, the maximum depth of cut should be reduced by 30%

(1) Cutting diameter maximum
(2) Number of inserts
(3) Master insert identification

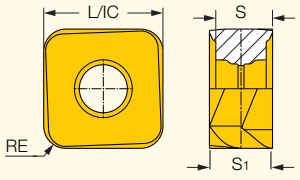
Spare Parts

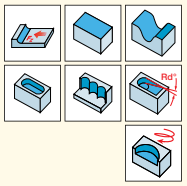
Designation				
MFQ8 D2.00-05-0.75-12	SR M4X0.7-L11.5 IP15	BLD IP15/S7	SW6-T-SH	SR UNF 3/8X1 B18.3
MFQ8 D2.50-06-1.00-12	SR M4X0.7-L11.5 IP15	BLD IP15/S7	SW6-T-SH	SR UNF 1/2X20X1 B18.3
MFQ8 D3.00-07-1.00-12	SR M4X0.7-L11.5 IP15	BLD IP15/S7	SW6-T-SH	SR UNF 1/2X20X1 B18.3
MFQ8 D4.00-08-1.50-12	SR M4X0.7-L11.5 IP15	BLD IP15/M7	SW6-T-SH	

NEOFEED
HIGH FEED LINE

FFQ8 SZMU

Double-Sided Square
Inserts with 8 Cutting Edges
for High Feed Milling





Designation	Dimensions L	S	S1	RE	Tough ↔ Hard IC882	IC830	IC808	IC810
FFQ8 SZMU 120520HP	.472	.230	.256	.0787	•	•	•	
FFQ8 SZMU 120520T	.472	.230	.256	.0787		•	•	•

• For side plunging, the initial cutting feed is 0.1 mm/t • T- for steel, ferritic and martensitic stainless steel, cast iron and hardened steel • HP - for austenitic stainless steel and high temperature alloys

FF
Fast Feed

MF
Moderate Feed

One Insert for both
Fast Feed and Moderate Feed Milling

Ø1.25" Cost Effective Indexable Milling Heads

MULTI-MASTER
INDEXABLE HEADS

New 1.25" MULTI-MASTER Head for Roughing, Semi-Finishing & Finishing with Ramp Down Capabilities for **Cost Savings and High Productivity.**

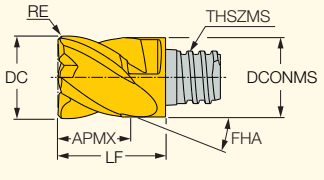
40,000 Indexable Solid Carbide Endmill Options

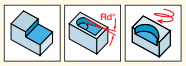
VIDEO

MULTI-MASTER
INDEXABLE SOLID CARBIDE LINE

MM ECK-CF

Five and Six-Flute Heads with 35°/38° Helix Featuring Different Corner Radii For Machining Titanium Alloys





Designation	Dimensions DC	RE	NOF(1)	APMX	THSZMS	DCONMS	LF	RMPX°(2)	IC908	Recommended Machining Data f_z (inch/t)
MM ECK125H1.5R060-5T21	1.250	.0600	5	1.5000	T21	1.181	2.165	1.5	•	.0020-.0070
MM ECK125H1.5R120-5T21	1.250	.1200	5	1.5000	T21	1.181	2.165	1.3	•	.0020-.0070
MM ECK125H1.5R250-5T21	1.250	.2500	5	1.5000	T21	1.181	2.165	.7	•	.0020-.0070
MM ECK125H1.5R375-5T21	1.250	.3750	5	1.5000	T21	1.181	2.165	.5	•	.0020-.0070

- Do not apply lubricant to the threaded connection.

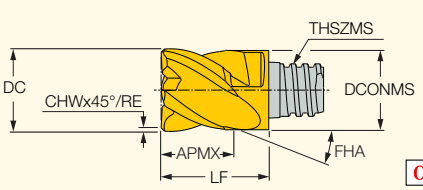
(1) Number of flutes

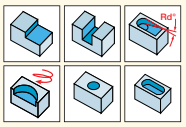
(2) Maximum ramping angle

MULTI-MASTER
INDEXABLE SOLID CARBIDE LINE
CHATTERFREE
MULTI-MASTER LINE

MM EC-CF

Interchangeable Solid Carbide Endmill Heads for CHATTERFREE Roughing and Finishing Operations





Designation	Dimensions DC	RE	NOF(1)	APMX	THSZMS	DCONMS	LF	FHA	CHW	KCH	IC908	Recommended Machining Data f_z (inch/t)
MM EC125E1.5R04CF-4T21	1.250	.0400	4	1.500	T21	1.181	2.165	38.0	-	-	•	.0023-.0070

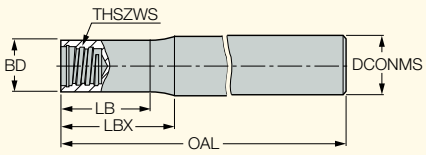
- Do not apply lubricant to the threaded connection.

(1) Number of flutes

MULTI-MASTER

MM S-A (stepped shanks)

Stepped Cylindrical Shanks Carrying Interchangeable Milling Heads



Designation	THSZWS	DCONMS	BD	LB	LBX	OAL	Shank(1)	Shank m.(2)	CSP(3)	RPMX(4)	Lbs
MM S-A-L4/1.2-C1.25-T21	T21	1.250	1.181	1.200	1.32	4.000	C	S	0	12690	1.23
MM S-A-L5/2.5-C1.25-T21-C	T21	1.250	1.181	2.500	2.63	5.000	C	C	0	12690	2.56
MM S-A-L5.3/25-C125T21-C	T21	1.250	1.181	2.500	2.63	5.300	C	C	0	12690	2.76
MM S-A-L6.0/1.5-C1.25-T21	T21	1.250	1.181	1.500	1.63	6.000	C	S	0	12690	1.89
MM S-A-L7/4.0-C1.25-T21-C	T21	1.250	1.181	4.000	4.13	7.000	C	C	0	12690	3.75
MM S-A-L9/5.0-C1.25-T21-C	T21	1.250	1.181	5.000	5.13	9.000	C	C	0	12690	5.45
MM S-A-L11/8-C1.25-T21-C	T21	1.250	1.181	8.000	8.13	11.000	C	C	0	12690	6.09

- Do not apply lubricant to the threaded connection.

(1) C-Cylindrical

(2) S-steel, C-carbide

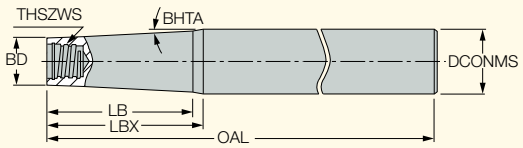
(3) 0 - Without coolant supply

(4) The maximum RPM must be calculated. Divide the listed max. RPM by the number of flutes (on the milling head) being used.

MULTI-MASTER

MM S-B (85° conical shanks)

Shanks Carrying Interchangeable Milling Heads



Designation	THSZWS	DCONMS	BD	BHTA	Shank[1]	LB	LBX	OAL	Shank m.[2]	RPMX[3]	Lbs
MM S-B-L6.0/18-C1.50T21	T21	1.500	1.181	5.00	C	-	1.82	6.000	S	21840	2.78

- Do not apply lubricant to the threaded connection.

[1] C-Cylindrical

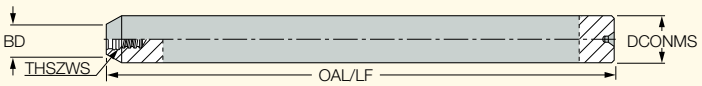
[2] S-steel

[3] The maximum RPM must be calculated. Divide the listed max. RPM by the number of flutes (on the milling head) being used.

MULTI-MASTER

MM S-A (straight shanks)

Shanks Carrying Interchangeable Milling Heads



Designation	THSZWS	DCONMS	BD	OAL	Shank[1]	Shank m.[2]	RPMX[3]	Lbs
MM S-A-L4.0-C1.50T21	T21	1.500	1.181	4.000	C	S	60000	1.90

- Do not apply lubricant to the threaded connection.

[1] C-Cylindrical,

[2] S-steel

[3] The maximum RPM must be calculated. Divide the listed max. RPM by the number of flutes (on the milling head) being used.

75% Less Milling Passes with Barrel Heads

MULTI-MASTER
INDEXABLE HEADS

New Barrel Shaped MULTI-MASTER Head for **Accurate Finishing** Optimizes Valuable Machining Time.

Barrel Shaped Head
Saves **up to 75% Passes**

Extremely Fast Milling

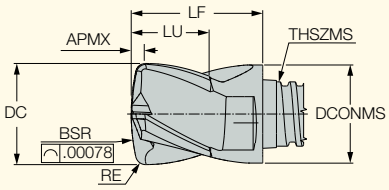
Range: Ø.312 → Ø.5

VIDEO

MULTI-MASTER
INDEXABLE SOLID CARBIDE LINE
NEOBARREL
PROFILE MILLING

MM ELB

Interchangeable Lens-Shaped (Barrel) Solid Carbide Heads for 3D Profiling



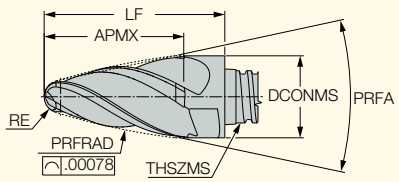
Designation	Dimensions									IC908
	DC	BSR	RE	LU	APMX	THSZMS	DCONMS	NOF(1)	LF	
MM ELB312R625A19-4T05	.312	.6250	.0200	.1900	.0351	T05	.312	4	.394	●
MM ELB375R750A27-4T06	.375	.7500	.0390	.2700	.0548	T06	.375	4	.512	●
MM ELB500R1.0A35-4T08	.500	1.0000	.0390	.3500	.0626	T08	.500	4	.650	●

(1) Number of flutes

MULTI-MASTER
INDEXABLE SOLID CARBIDE LINE
NEOBARREL
PROFILE MILLING

MM EOB

Interchangeable Oval-Shaped (Barrel) Solid Carbide Heads for 3D Profiling



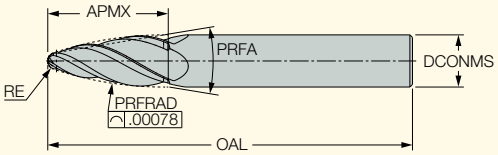
Designation	Dimensions								IC908
	PRFRAD	RE	APMX	PRFA	THSZMS	NOF(1)	DCONMS	LF	
MM EOB312R060R315A53-4T05	3.150	.0600	.5300	24.00	T05	4	.312	.709	●
MM EOB375R123R295A62-4T06	2.950	.1230	.6000	16.00	T06	4	.375	.866	●
MM EOB500R157R750A82-4T08	7.500	.1570	.8200	16.00	T08	4	.500	1.063	●

(1) Number of flutes

SOLIDMILL
PREMIUM LINE
NEOBARREL
PROFILE MILLING

SC EOB

Solid Carbide Oval-Shaped (Barrel) Endmills for 3D Profiling



Designation	Dimensions								IC902
	PRFRAD	RE	APMX	PRFA	DCONMS	NOF(1)	OAL	Shank(2)	
EOBI-R.06R3.5A87/7-4C312	3.500	.0600	.8700	13.60	.312	4	2.500	C	●
EOBI-R.08R3.38A92/7-4C375	3.375	.0800	.9100	14.68	.375	4	3.000	C	●
EOBI-R.08R3.12A1.1/10-4C5	3.125	.0800	1.1000	19.54	.500	4	3.000	C	●

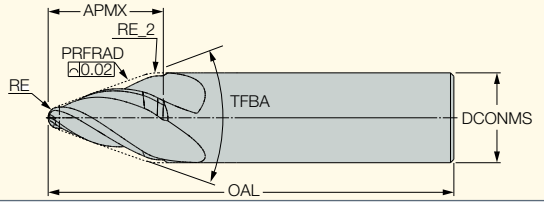
(1) Number of flutes
(2) C-Cylindrical

SOLIDMILL PREMIUM LINE

NEOBARREL PROFILE MILLING

SC ETB

Solid Carbide Tapered-Shaped (Barrel) Endmills for 3D Profiling



Designation	Dimensions									IC902
	PRFRAD	RE_2	RE	APMX	TFBA	DCONMS	NOF[1]	OAL	Shank[2]	
ETBI-R.06R10A35/20-4C312	10.000	.1500	.0600	.3750	40.00	.312	4	2.500	C	●
ETBI-R.08R10A40/20-4C375	10.000	.1900	.1200	.4300	40.00	.375	4	3.000	C	●
ETBI-R.123R10A50/20-4C500	10.000	.2500	.1228	.5500	40.00	.500	4	3.000	C	●

[1] Number of flutes

[2] C-Cylindrical

Barrel Shaped Head
Saves up to 75% Passes

NEOLOGIQ HOLD

MACHINING INTELLIGENTLY

NEOCOLLET

INTEGRAL COLLET

Member IMC Group

ISCAR

Highly Rigid and Accurate Collet

NEOCOLLET
INTEGRAL COLLET

New Rigid Collet for
SD Exchangeable
Solid Carbide Head.

Available for
ER16, 20, 25, 32, 40 Collet Chucks
with a Variety of Extension Sizes

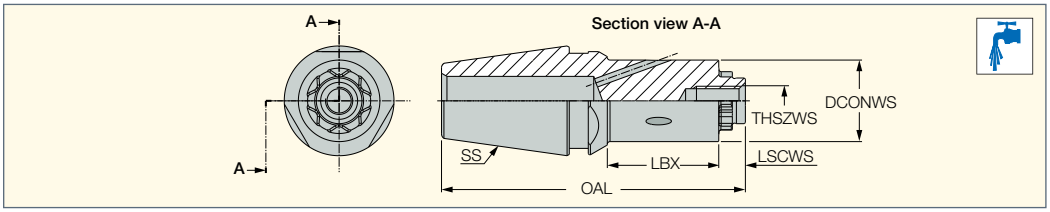
Through-Tool Coolant
Directed to Cutter Edges

VIDEO

NEOCOLLET
INTEGRAL COLLET

SD-S-A-ER-SP

Thermal Shrink Chucks with an Integral ER Collet



Designation	SS	LBX	DCONWS	THSZWS	LSCWS	OAL	Lbs
SD-S-A-H05-ER16-SP11-C	ER16	.197	.4331	M4X0.5	.1516	1.431	.07
SD-S-A-H20-ER16-SP11-C	ER16	.787	.4331	M4X0.5	.1516	2.022	.09
SD-S-A-H05-ER20-SP11-C	ER20	.197	.4331	M4X0.5	.1516	1.569	.11
SD-S-A-H05-ER20-SP13-C	ER20	.197	.5118	M4X0.5	.1713	1.589	.11
SD-S-A-H05-ER20-SP15-C	ER20	.197	.5906	M5X0.5	.1929	1.610	.11
SD-S-A-H20-ER20-SP11-C	ER20	.787	.4331	M4X0.5	.1516	2.159	.13
SD-S-A-H20-ER20-SP13-C	ER20	.787	.5118	M4X0.5	.1713	2.179	.17
SD-S-A-H20-ER20-SP15-C	ER20	.787	.5906	M5X0.5	.1929	2.201	.17
SD-S-A-H05-ER25-SP11-C	ER25	.197	.4331	M4X0.5	.1516	1.687	.19
SD-S-A-H05-ER25-SP13-C	ER25	.197	.5118	M4X0.5	.1713	1.707	.19
SD-S-A-H05-ER25-SP15-C	ER25	.197	.5906	M5X0.5	.1929	1.728	.19
SD-S-A-H05-ER25-SP17-C	ER25	.197	.6693	M6X0.5	.2362	1.772	.20
SD-S-A-H05-ER25-SP19-C	ER25	.197	.7480	M6X0.5	.3346	1.870	.20
SD-S-A-H20-ER25-SP11-C	ER25	.787	.4331	M4X0.5	.1516	2.278	.21
SD-S-A-H20-ER25-SP13-C	ER25	.787	.5118	M4X0.5	.1713	2.297	.22
SD-S-A-H20-ER25-SP15-C	ER25	.787	.5906	M5X0.5	.1929	2.319	.24
SD-S-A-H20-ER25-SP17-C	ER25	.787	.6693	M6X0.5	.2362	2.362	.26
SD-S-A-H20-ER25-SP19-C	ER25	.787	.7480	M6X0.5	.3346	2.461	.28
SD-S-A-H05-ER32-SP13-C	ER32	.197	.5118	M4X0.5	.1713	1.943	.31
SD-S-A-H05-ER32-SP15-C	ER32	.197	.5906	M5X0.5	.1929	1.965	.32
SD-S-A-H05-ER32-SP17-C	ER32	.197	.6693	M6X0.5	.2362	2.008	.33
SD-S-A-H05-ER32-SP19-C	ER32	.197	.7480	M6X0.5	.3346	2.106	.33
SD-S-A-H20-ER32-SP13-C	ER32	.787	.5118	M4X0.5	.1713	2.533	.34
SD-S-A-H20-ER32-SP15-C	ER32	.787	.5906	M5X0.5	.1929	2.555	.35
SD-S-A-H20-ER32-SP17-C	ER32	.787	.6693	M6X0.5	.2362	2.598	.37
SD-S-A-H20-ER32-SP19-C	ER32	.787	.7480	M6X0.5	.3346	2.697	.40
SD-S-A-H05-ER40-SP17-C	ER40	.197	.6693	M6X0.5	.2362	2.244	.57
SD-S-A-H05-ER40-SP19-C	ER40	.197	.7480	M6X0.5	.3346	2.331	.60
SD-S-A-H20-ER40-SP17-C	ER40	.787	.6693	M6X0.5	.2362	2.835	.63
SD-S-A-H20-ER40-SP19-C	ER40	.787	.7480	M6X0.5	.3346	2.933	.65

Through-Tool Coolant Directed to Cutter Edges

Spare Parts

Designation			
SD-S-A-H05-ER16-SP11-C	SR M4X0.5-SP11 HG	SW6-T-SH	BLD T15/S7
SD-S-A-H20-ER16-SP11-C	SR M4X0.5-SP11 HG	SW6-T-SH	BLD T15/S7
SD-S-A-H05-ER20-SP11-C	SR M4X0.5-SP11 HG	SW6-T-SH	BLD T15/S7
SD-S-A-H05-ER20-SP13-C	SR M4X0.5-SP13-IP15-HG	SW6-T-SH	BLD IP15/S7
SD-S-A-H05-ER20-SP15-C	SR M5X0.5-SP15-IP20-HG	SW6-T-SH	BLD IP20/S7
SD-S-A-H20-ER20-SP11-C	SR M4X0.5-SP11 HG	SW6-T-SH	BLD T15/S7
SD-S-A-H20-ER20-SP13-C	SR M4X0.5-SP13-IP15-HG	SW6-T-SH	BLD IP15/S7
SD-S-A-H20-ER20-SP15-C	SR M5X0.5-SP15-IP20-HG	SW6-T-SH	BLD IP20/S7
SD-S-A-H05-ER25-SP11-C	SR M4X0.5-SP11 HG	SW6-T-SH	BLD T15/S7
SD-S-A-H05-ER25-SP13-C	SR M4X0.5-SP13-IP15-HG	SW6-T-SH	BLD IP15/S7
SD-S-A-H05-ER25-SP15-C	SR M5X0.5-SP15-IP20-HG	SW6-T-SH	BLD IP20/S7
SD-S-A-H05-ER25-SP17-C	SR M6X0.5-SP17-IP20-HG	SW6-T-SH	BLD IP20/S7
SD-S-A-H05-ER25-SP19-C	SR M6X0.5-SP17-IP20-HG[a]	SW6-T-SH	BLD IP20/S7
SD-S-A-H20-ER25-SP11-C	SR M4X0.5-SP11 HG	SW6-T-SH	BLD T15/S7
SD-S-A-H20-ER25-SP13-C	SR M4X0.5-SP13-IP15-HG	SW6-T-SH	BLD IP15/S7
SD-S-A-H20-ER25-SP15-C	SR M5X0.5-SP15-IP20-HG	SW6-T-SH	BLD IP20/S7
SD-S-A-H20-ER25-SP17-C	SR M6X0.5-SP17-IP20-HG	SW6-T-SH	BLD IP20/S7
SD-S-A-H20-ER25-SP19-C	SR M6X0.5-SP17-IP20-HG[a]	SW6-T-SH	BLD IP20/S7
SD-S-A-H05-ER32-SP13-C	SR M4X0.5-SP13-IP15-HG	SW6-T-SH	BLD IP15/S7
SD-S-A-H05-ER32-SP15-C	SR M5X0.5-SP15-IP20-HG	SW6-T-SH	BLD IP20/S7
SD-S-A-H05-ER32-SP17-C	SR M6X0.5-SP17-IP20-HG	SW6-T-SH	BLD IP20/S7
SD-S-A-H05-ER32-SP19-C	SR M6X0.5-SP17-IP20-HG[a]	SW6-T-SH	BLD IP20/S7
SD-S-A-H20-ER32-SP13-C	SR M4X0.5-SP13-IP15-HG	SW6-T-SH	BLD IP15/S7
SD-S-A-H20-ER32-SP15-C	SR M5X0.5-SP15-IP20-HG	SW6-T-SH	BLD IP20/S7
SD-S-A-H20-ER32-SP17-C	SR M6X0.5-SP17-IP20-HG	SW6-T-SH	BLD IP20/S7
SD-S-A-H20-ER32-SP19-C	SR M6X0.5-SP17-IP20-HG[a]	SW6-T-SH	BLD IP20/S7
SD-S-A-H05-ER40-SP17-C	SR M6X0.5-SP17-IP20-HG	SW6-T-SH	BLD IP20/S7
SD-S-A-H05-ER40-SP19-C	SR M6X0.5-SP17-IP20-HG[a]	SW6-T-SH	BLD IP20/S7
SD-S-A-H20-ER40-SP17-C	SR M6X0.5-SP17-IP20-HG	SW6-T-SH	BLD IP20/S7
SD-S-A-H20-ER40-SP19-C	SR M6X0.5-SP17-IP20-HG[a]	SW6-T-SH	BLD IP20/S7

[a] Recommended tightening torque:88 lbf*in

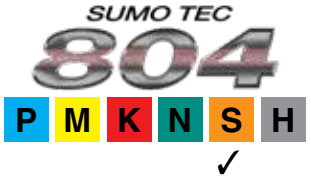
NEOLOGIQ GRADES

MACHINING INTELLIGENTLY

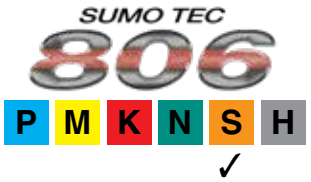
Member IMC Group

ISCAR

Turning Grades

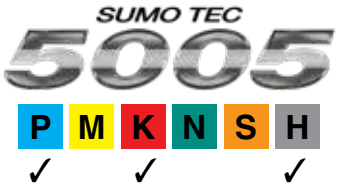


A very hard submicron grain size substrate with PVD coating and a special SUMOTEC surface treatment. Suitable for semi-finishing and finishing operations under stable conditions on high temperature alloys and Titanium alloys moderate to relatively high cutting speeds. Features high wear resistance and plastic deformation durability.

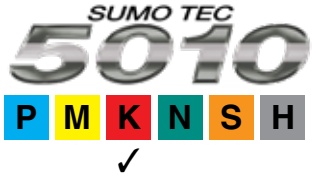


A hard submicron grain size substrate with PVD coating and a special SUMOTEC surface treatment. Excellent for machining high temperature alloys and Titanium alloys, at moderate to relatively high cutting speeds. Features high wear resistance and plastic deformation durability.

A hard submicron grain size substrate with PVD coating and a special SUMOTEC surface treatment. Suitable for machining steels, alloy steels, austenitic stainless steel, high temperature alloys and hard steels at moderate to relatively high cutting speeds under stable conditions. Features high wear resistance and plastic deformation durability.



A very hard substrate with MTCVD coating with a special SUMOTEC surface treatment. Suitable for machining gray and nodular cast iron at high cutting speeds under stable conditions.

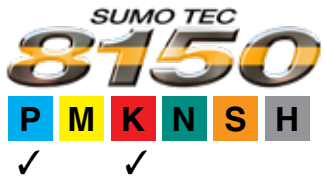


A hard substrate with MTCVD coating with a special SUMOTEC surface treatment. Recommended for machining gray and nodular cast iron at moderate to high cutting speeds, provides very good resistance to chipping.

Turning Grades

A hard substrate with cobalt enriched outer layer and MTCVD coating and a special SUMOTEC surface treatment. Suitable for finishing and medium turning of stainless steel at high cutting speeds. Features long tool life and high wear resistance.

A very tough substrate with MTCVD coating with a special SUMOTEC surface treatment. Recommended for machining stainless steel at moderate cutting speeds and medium to high feeds. Features very high toughness with excellent results in heavy machining operations, unstable conditions, and interrupted cut.



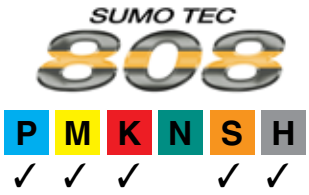
A hard substrate with a cobalt enriched layer, MTCVD coating with a special SUMOTEC surface treatment. Recommended for high speed machining of steels, alloy steels and martensitic stainless steel with moderate feeds under stable conditions. Features excellent thermal stability, resistance to wear and plastic deformation durability.

A tough substrate with a cobalt enriched layer and MTCVD coating with a special SUMOTEC surface treatment. Recommended for general use machining of steels, alloy steels and martensitic stainless steel in a wide range of conditions.
Features high toughness and good wear resistance.

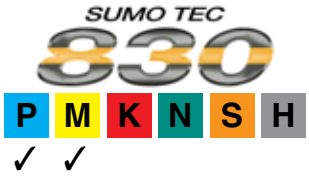
A very tough substrate with cobalt enriched layer and MTCVD coating and a special SUMOTEC surface treatment. Suitable for machining steels and alloy steels at low to medium cutting speeds and medium to high feeds. Features very high toughness with excellent results in heavy machining, unstable conditions, and interrupted cuts.

Parting Grades

A hard submicron grain size substrate with PVD coating and a special SUMOTEC surface treatment. Suitable for machining steels, alloy steels, austenitic stainless steel, high temperature alloys and hard steels at moderate to relatively high cutting speeds under stable conditions. Features high wear resistance and plastic deformation durability.



A tough submicron grain size substrate with PVD coating and a special SUMOTEC surface treatment. Recommended for general use for a large variety of applications and materials such as steels, alloy steels, austenitic stainless steel and high temperature alloys at moderate cutting speeds and feeds. Features high wear resistance and chipping durability.



A tough substrate with PVD coating and a special SUMOTEC surface treatment. Suitable for machining steel and stainless steel at low to medium cutting speeds and moderate to high feeds. The grade features high toughness and recommended for interrupted cuts and machining under unstable conditions. May be used on high temperature alloys at low cutting speeds.

A tough submicron grain size substrate with PVD coating. Recommended for general use on a wide range of applications and materials such as steels, alloy steels, austenitic stainless steel and high temperature alloys at moderate cutting speeds and low to medium feeds. The grade features improved toughness and wear resistance which extends tool life.

A tough substrate with PVD coating, suitable for machining steel and stainless steel at low to medium cutting speeds and moderate to high feeds. Recommended for interrupted cuts and machining under unstable conditions. The grade features improved toughness and wear resistance which extends tool life.

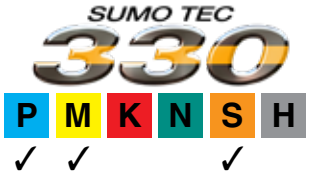
Drilling Grades

A tough submicron grain size substrate with PVD coating, recommended for general use in a large variety of operations and materials such as steels, alloy steels, austenitic stainless steel and high temperature alloys at moderate cutting speeds. Features high wear resistance and chipping durability.

A tough substrate with SUMOTEC CVD coating. Recommended for high speed drilling of steel. Provides excellent tool life.

A submicron grain size substrate with SUMOTEC MTCVD coating. Features excellent chipping and wear resistance. Recommended for high speed drilling of cast iron and steel, to be used for the peripheral insert on DR drills.

Milling Grades



A tough PVD coated grade with SUMOTEC surface treatment. Used for milling a wide range of workpiece materials, at low to medium cutting speeds and for unstable machining conditions.

A SUMOTEC PVD coated grade. Optimal choice for milling nodular cast iron at medium to high cutting speeds.

Milling Grades

SUMO TEC 830

P	M	K	N	S	H
✓	✓			✓	

A tough substrate with PVD coating and a special SUMOTEC surface treatment. Suitable for machining steel and stainless steel at low to medium cutting speeds and moderate to high feeds. The grade features high toughness and recommended for interrupted cuts and machining under unstable conditions. May be used on high temperature alloys at low cutting speeds.

840

P	M	K	N	S	H
	✓			✓	

A PVD coated tough grade followed by a special surface treatment. Suitable for milling austenitic stainless steel and high temperature alloys. Recommended for interrupted cuts and heavy operations.

SUMO TEC 845

P	M	K	N	S	H
✓					

A PVD coated tough grade followed by a special SUMOTEC surface treatment. Designed for milling alloyed steel, especially when used for interrupted cuts and heavy operations.

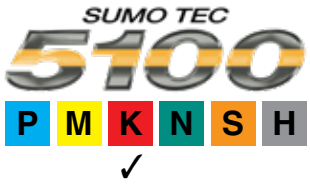
882

P	M	K	N	S	H
	✓			✓	

A grade with a tough substrate, a with PVD coating and a special surface treatment. Designed for machining austenitic stainless steel, Titanium and high temperature alloys, particularly under hard cutting conditions.

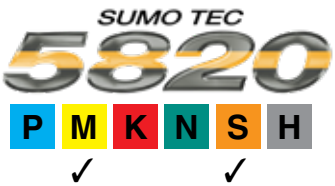
Milling Grades

A tough submicron grain size substrate with PVD coating, recommended for general use in a large variety of operations and materials such as steels, alloy steels, austenitic stainless steel and high temperature alloys at moderate cutting speeds.
Features high wear resistance and chipping durability.

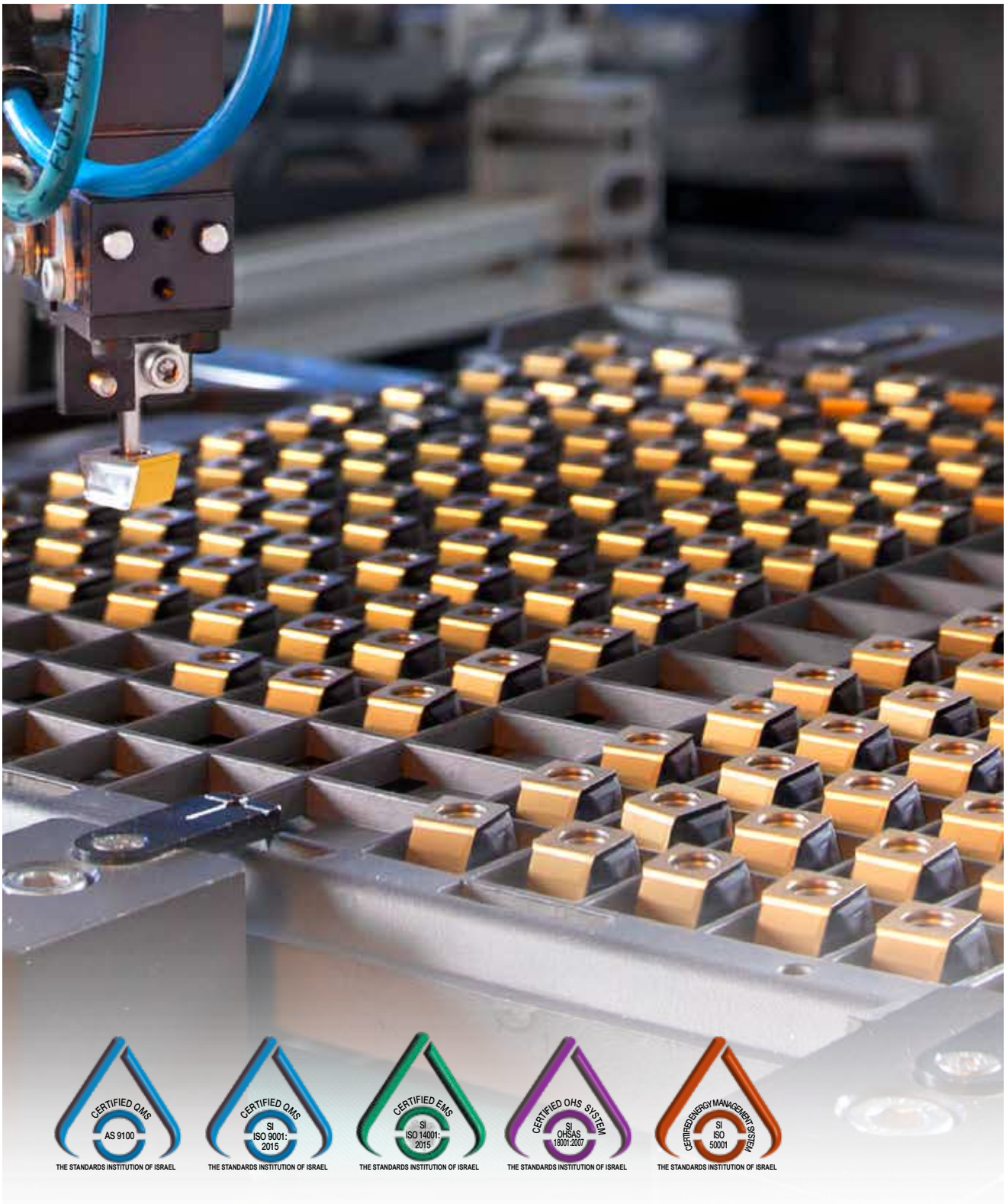


A CVD multi-layer coating with SUMOTEC post coating surface treatment. Recommended for milling grey cast iron at high cutting speeds, and provides extended tool life.

A tough substrate with MTCVD coating. Recommended for milling steel at high cutting speed and for parting stainless steel.



A tough substrate, with a MTCVD coating and special SUMOTEC post coating surface treatment. Designed for machining austenitic stainless steel, Titanium and high temperature alloys.



Quality Standard

ISCAR has been certified by the prestigious Standards Institution, as being in full compliance to ensure delivery of the finest quality goods. Quality control facilities include the metallurgical laboratory, raw metal testing, an online testing procedure and a machining center for tool performance testing and final product inspection. Only the finest products are packaged for entry into ISCAR's inventory.

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